| Work Material | | S50C.PX-5.SKD11.HPM-1.NAK55 HRC30-40 | | | S50C.PX-5.SKD11.HPM-1.NAK55 HRC30-40 | | | | | NAK80 HRC40 | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | Standard | | | High Speed | | | | | | | |
| Radius | Effective Length | Speed ($mm^{-1}$) | Feed (mm/mim) | Cutting Depth (mm/per time) | Speed ($mm^{-1}$) | Feed (mm/mim) | Long Neck Milling (mm/per time) | Feed (mm/mim) | 3d Milling Cutting Depth | Speed ($mm^{-1}$) | Feed (mm/mim) | Cutting Depth (mm/per time) |
| R0.5 | 6L | 30000 | 800 | 0.05 | 28000-30000 | 300-800 | 0.01-0.05 | 800-1200 | 0.1-0.3 | 20000 | 1000 | 0.05 |
| | 8L | | 800 | 0.04 | | | | | | | 1000 | 0.04 |
| | 10L | | 800 | 0.02 | | | | | | | 1000 | 0.02 |
| | 12L | | 800 | 0.02 | | | | | | | 1000 | 0.02 |
| R0.75 | 8L | 24000 | 1000 | 0.1 | 9500-30000 | 300-800 | 0.01-0.15 | 800-1500 | 0.1-0.3 | 16000 | 2000 | 0.1 |
| | 10L | | 1000 | 0.08 | | | | | | | 2000 | 0.08 |
| | 12L | | 1000 | 0.06 | | | | | | | 2000 | 0.06 |
| | 16L | | 800 | 0.04 | | | | | | | 1600 | 0.04 |
| | 20L | | 800 | 0.02 | | | | | | | 1600 | 0.02 |
| R1 | 8L | 20000 | 1200 | 0.12 | 6400-30000 | 300-800 | 0.01-0.3 | 800-2000 | 0.1-0.5 | 12000 | 2500 | 0.2 |
| | 10L | | 1200 | 0.12 | | | | | | | 2500 | 0.2 |
| | 12L | | 1200 | 0.1 | | | | | | | 2500 | 0.16 |
| | 16L | | 1000 | 0.06 | | | | | | | 2000 | 0.1 |
| | 20L | | 1000 | 0.06 | | | | | | | 2000 | 0.1 |
| R1.5 | 10L | 13000 | 1500 | 0.2 | 4200-20000 | 300-800 | 0.01-0.3 | 800-2000 | 0.1-0.5 | 10000 | 2500 | 0.25 |
| | 12L | | 1500 | 0.2 | | | | | | | 2500 | 0.25 |
| | 16L | | 1500 | 0.16 | | | | | | | 2500 | 0.2 |
| | 20L | | 1200 | 0.16 | | | | | | | 2000 | 0.18 |
| | 25L | | 1200 | 0.1 | | | | | | | 2000 | 0.15 |
| R2 | 12L | 9000 | 1200 | 0.2 | 3200-15000 | 300-800 | 0.01-0.3 | 800-1500 | 0.1-0.5 | 8000 | 1600 | 0.3 |
| | 16L | | 1200 | 0.2 | | | | | | | 1600 | 0.3 |
| | 20L | | 1200 | 0.2 | | | | | | | 1600 | 0.3 |
| | 25L | | 1200 | 0.16 | | | | | | | 1600 | 0.2 |
| | 30L | | 1200 | 0.16 | | | | | | | 1600 | 0.2 |