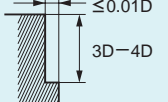
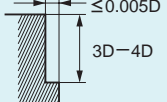


Work material	Alloy steel, Tool steel, Pre-hardened steel AISI H13, AISI W1-10, AISI P21		Hardened steel (45–55HRC) AISI H13		Hardened steel (55–62HRC) AISI D2		Hardened steel (62–70HRC) AISI W1, AISI M2	
	Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)
6	2100	450	1600	330	1300	240	1100	190
8	1600	430	1200	310	1000	230	800	170
10	1300	420	960	290	800	220	640	150
12	1100	380	800	260	660	200	530	140
16	800	310	600	220	500	160	400	120
20	640	270	480	190	400	140	320	110
25	510	230	380	160	320	120	260	90
Depth of cut								

D:Dia.

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.