

	Carbon Steels Alloy Steels (≤ HRC35)				Pre-Hardened Steels (HRC35-45)				Hardened Steels (HRC46-55)			
D(mm)	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm
1	21000	336	2.00	0.10	22000	320	2.00	0.05	18000	250	1.50	0.05
1.5	18000	378	3.00	0.1	20000	360	3.00	0.1	15000	300	2.25	0.1
2	15000	420	4.00	0.15	16000	400	4.00	0.10	12500	350	3.00	0.05
2.5	12000	462	5.00	0.15	11000	440	5.0	0.10	10000	400	4.00	5.00
3	9600	504	6.00	0.2	8800	480	6.0	0.1	8000	450	4.50	0.1
4	7800	630	8.00	0.20	7100	600	8.0	0.10	6500	550	6.00	0.05
5	7200	735	10.0	0.2	6600	700	10.00	0.1	6000	580	7.50	0.1
6	6000	1050	12.0	0.20	5000	1000	12.00	0.10	5000	600	8.00	0.10
8	5400	1575	16.0	3.0	4400	1500	16.00	0.2	4500	600	12.00	0.1
10	4800	2100	20.0	0.3	3300	2000	20.0	0.2	4000	550	15.00	0.1
12	4200	2625	24.0	0.3	5500	2500	24.0	0.2	3500	500	18.0	0.1
14	3600	2100	28.0	0.3	3800	2000	28.0	0.2	3000	500	21.0	0.1
16	3300	2100	32.0	0.3	3000	2000	32.0	0.2	2800	450	24.0	0.1
20	3000	2100	40.0	0	2700	2000	40.0	0	2500	400	30.0	0