

NORMAL SPEED

RPM = rev./min. Vc = m/min.
FEED = mm/min. Fz = mm/tooth

MATERIAL	P											
	NON-ALLOYED STEELS ALLOY STEELS				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS	~HRc30				HRc30~HRc50				HRc50~HRc55			
STRENGTH	~1000N/mm ²				1000 ~ 1750N/mm ²				1750 ~ 2080N/mm ²			
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
6.0	5670	2040	105	0.060	3960	1395	75	0.059	1610	215	30	0.022
8.0	4280	2040	110	0.079	3000	1395	75	0.078	1180	215	30	0.030
10.0	3430	2040	110	0.099	2370	1395	75	0.098	1020	215	30	0.035
12.0	2900	1715	110	0.099	2040	1185	75	0.097	860	185	30	0.036
16.0	2140	1285	110	0.100	1510	900	75	0.099	650	135	35	0.035
20.0	1710	1030	105	0.075	1180	705	75	0.075	510	110	30	0.027

1.5D
0.1D

1.5D
0.05D

1.0D
0.05D

HIGH SPEED

MATERIAL	P				P			
	NON-ALLOYED STEELS ALLOY STEELS				ALLOY STEELS HEAT RESISTANT STEELS			
HARDNESS	~ HRC50				HRC50 ~ HRC55			
STRENGTH	~1750N/mm ²				1750 ~ 2080N/mm ²			
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
6.0	17140	6210	325	0.060	8570	3110	160	0.060
8.0	12850	6210	325	0.081	6430	3110	160	0.081
10.0	10180	6110	320	0.100	5140	3110	160	0.101
12.0	8570	5140	325	0.100	4280	2570	160	0.100
16.0	6430	3855	325	0.100	3220	1930	160	0.100
20.0	5140	3110	325	0.076	2570	1500	160	0.073

1.5D

0.05D

1.0D

0.05D