

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

MATERIAL	M				K			
	STAINLESS STEELS				CAST IRON			
HARDNESS								
STRENGTH								
DIAMETER	RPM	FEED	Vc	Fz	RPM	FEED	Vc	Fz
2.0	6930	90	45	0.004	12720	185	80	0.005
3.0	5080	120	50	0.008	9810	210	90	0.007
4.0	4270	145	55	0.011	8320	295	105	0.012
5.0	3480	155	55	0.015	6930	310	110	0.015
6.0	3120	175	60	0.019	6120	340	115	0.019
8.0	2310	175	60	0.025	4620	375	115	0.027
10.0	1850	160	60	0.029	3590	330	115	0.031
12.0	1500	130	55	0.029	3010	275	115	0.030
16.0	1170	110	60	0.031	2420	220	120	0.030

(up to Ø3:0.2D)