


List of recommended milling conditions for **VBH-2T**
VBI-2T

Work Material	HRC30-50		HRC50-55		HRC55-62	
Velocity	V=380m/min		V=300m/min		V=150m/min	
RADIUS	SPEED (mm ⁻¹)	FEED (mm/mim)	SPEED (mm ⁻¹)	FEED (mm/mim)	SPEED (mm ⁻¹)	FEED (mm/mim)
R1	15000	1000	15000	875	15000	750
R1.5	15000	1500	15000	1200	12000	660
R2	15000	1500	15000	1250	10000	600
R2.5	15000	1500	15000	1300	9000	580
R3	15000	1500	15000	1300	8000	550
R4	15000	1500	12000	1000	6000	420
R5	12500	1250	9500	800	4800	340
R6	10000	1000	8000	700	4000	280
D : Diameter 	$XY=0.2D$ $Z=0.05D$					