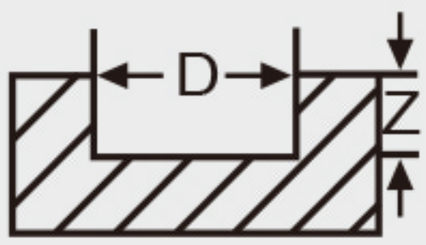
List of recommended milling conditions for BEH-2T/BEI-2T/BEJ-2T

Work Material	Mild Steels, Carbon steels, Cast iron, SS400, S55C, FC250(-750N/mm²)		Alloy Steels, Tool Steels, SCM, SKT, SKS, SKD(-30HRC)		Stainless Steels, Prehardened Steels, SKT,SKD,NAK55 HPM(30-38HRC)		Stainless Steels, Prehardened Steels, SUS304,SKD,NAK80, HPM50(38-45HRC)		Hardened Steels, (45-55HRC) Heat resistant, Alloy steels		Hardened Steels, (55-60HRC)	
DIAMETER	SPEED (mm^{-1})	FEED (mm/mim)	SPEED (mm^{-1})	FEED (mm/mim)	SPEED (mm^{-1})	FEED (mm/mim)	SPEED (mm^{-1})	FEED (mm/mim)	SPEED (mm^{-1})	FEED (mm/mim)	SPEED (mm^{-1})	FEED (mm/mim)
1	19500	130	14500	125	12500	90	11000	65	7000	30	5050	25
1.5	14000	130	10500	125	8900	90	7950	65	5050	40	3550	25
2	11000	135	8400	125	7000	90	6350	70	3950	40	2750	25
2.5	8900	170	7250	135	6000	95	5200	70	3250	40	2300	25
3	7450	200	7200	230	5850	125	5300	100	3200	45	2100	25
3.5	6650	225	6200	230	5000	125	4550	100	2750	45	1800	25
4	6000	235	5400	230	4400	125	4000	100	2400	45	1600	25
4.5	5650	270	4800	230	3900	125	3550	100	2100	45	1400	25
5	5300	315	4350	235	3500	130	3200	100	1900	55	1300	30
5.5	4800	310	3950	235	3250	130	2750	100	1750	55	1150	30
6	4400	310	3600	235	2900	130	2650	100	1600	55	1050	25
8	3300	295	2700	235	2200	125	2000	100	1200	50	795	25
10	2650	280	2150	230	1750	125	1600	95	955	50	635	25
12	2200	280	1800	230	1450	125	1350	95	795	45	530	20
Depth of cut												

	Z
D≦Ø1	0.3D
Ø6<D	0.5D

	Z
D≦Ø1	0.1D
Ø6<D	0.2D

	Z
D≦Ø1	0.05D
Ø6<D	0.1D