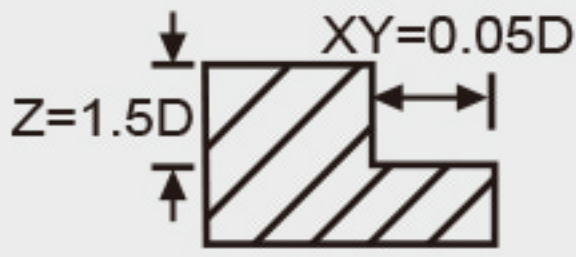
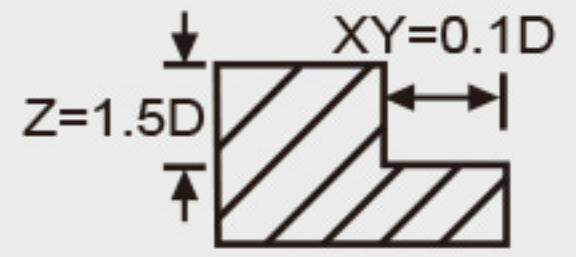
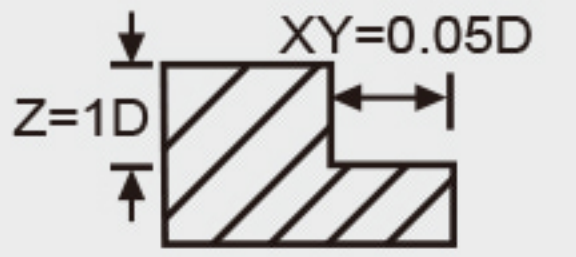
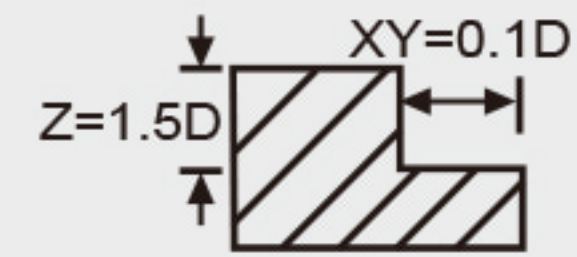


List of recommended milling conditions for BEA-4T

Work Material	Carbon Steels S45C.S50C HB150-250		Alloy Steels SCM.SUS(HPM) HBC20-35		Prehardened Steels NAK(HPM) HRC40		Hardened Steels SKD61 HBC50	
	SPEED (mm ⁻¹)	FEED (mm/mlm)	SPEED (mm ⁻¹)	FEED (mm/mlm)	SPEED (mm ⁻¹)	FEED (mm/mlm)	SPEED (mm ⁻¹)	FEED (mm/mlm)
1	21000	400	18000	210	16000	160	9800	110
2	14000	400	9600	250	8000	180	4800	110
3	9500	450	6400	250	5300	200	3200	120
4	7200	550	4800	320	4000	200	2400	120
5	5700	700	3800	350	3200	220	1900	160
6	4800	700	3200	380	2650	220	1600	180
8	3600	600	2400	380	2000	220	1200	180
10	2900	600	1900	380	1600	220	950	180
12	2400	430	1600	300	1300	200	800	150

Side Milling below $\varnothing 3$	Side Milling up to $\varnothing 4$	Side Milling
		

Work Material	Alloy Steels SCM.SUS(HPM) HRC20-35		Prehardened Steels NAK80(HPM) HRC35-45		Hardened Steels SKD61 HBC45-55	
	SPEED (mm ⁻¹)	FEED (mm/mlm)	SPEED (mm ⁻¹)	FEED (mm/mlm)	SPEED (mm ⁻¹)	FEED (mm/mlm)
Velocity	V=170m/min		V=110m/min		V=80m/min	
DIAMETER	SPEED (mm ⁻¹)	FEED (mm/mlm)	SPEED (mm ⁻¹)	FEED (mm/mlm)	SPEED (mm ⁻¹)	FEED (mm/mlm)
3	18000	720	11500	465	8500	340
4	13500	810	8800	525	6400	380
5	10800	650	7000	420	5100	300
6	9000	720	5800	465	4250	340
8	6800	675	4400	440	3200	320
10	5400	755	3500	490	2550	355
12	4500	720	2900	465	2100	340
16	3400	745	2200	480	1600	350

D : Diameter	
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