


List of recommended milling conditions for BBA

Work Material	Carbon Steels S45C.S50C HB150-250		Alloy Steels SCM.P20.PDS5.PDS3.SKD11 HRC20-35		Prehardened Steels NAK80 HRC35-45		Hardened Steels SKD61 HBC45-55	
Velocity	V=100m/min		V=80m/min		V=70m/min		V=40m/min	
RADIUS	SPEED (mm ⁻¹)	FEED (mm/mim)	SPEED (mm ⁻¹)	FEED (mm/mim)	SPEED (mm ⁻¹)	FEED (mm/mim)	SPEED (mm ⁻¹)	FEED (mm/mim)
R1	16000	400-1000	12700	300-800	11000	200-400	6400	80-250
R1.5	10600	400-1000	8500	300-800	7430	200-400	4250	80-250
R2	8000	400-1000	6400	300-800	5650	200-400	3200	80-250
R3	5300	400-1000	4200	300-800	3750	200-400	2100	80-250
R4	4000	400-1000	3200	300-800	2800	200-400	1600	80-250
R5	3200	400-1000	2500	300-800	2250	200-400	1200	80-250
R6	2700	400-1000	2100	300-800	1900	200-400	1000	80-250
D : Diameter 	XY=0.2D Z=0.1-0.3D				XY=0.2D (Z) HRC45 below 0.1-0.3D HRC50 below 0.05-0.02D			