

List of recommended milling conditions for VRB

Work Material	Carbon Steels.Alloy Steels S45C, FC, FCD, SCM, S50C, SKS...		Alloy Steels.Tool Steels SCr, SNCM, SKD11, SKD61, NAK80...		Hardened Steels SKD11	
HARDNESS	~HRC30		~HRC50		~HRC60	
DIAMETER	SPEED (mm ⁻¹)	FEED (mm/mim)	SPEED (mm ⁻¹)	FEED (mm/mim)	SPEED (mm ⁻¹)	FEED (mm/mim)
2	26000	1600	16500	1000	7500	300
3	19000	1800	12000	1200	5400	360
4	16000	3200	10000	1900	4800	480
5	14000	3300	8000	2000	3800	500
6	12000	3600	7200	2200	3500	650
8	9600	4000	5600	2200	2700	750
10	7000	3400	4400	1700	2100	650
12	6000	2800	3600	1400	1800	600
16	4500	2000	2800	1000	1400	450
DEPTH OF CUT	<p> $H \leq 0.02R$ $P \leq 0.02R$ HRC45 ↓ </p> <p> $H \leq 0.1D$ $W \leq 0.02D$ HRC45 ↑ </p>					