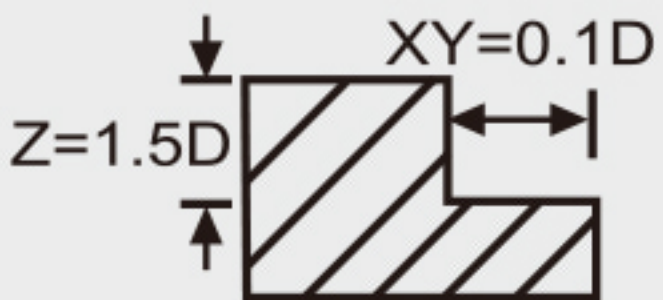


List of recommended milling conditions for **AEA-4T** **VEA-4T**

Work Material	HRC20-30		HRC30-48		HRC48-58		HRC58-62	
Velocity	V=170m/min		V=110m/min		V=80m/min		V=50m/min	
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)
2	26500	850	17500	560	12800	410	8000	250
3	18000	720	11500	465	8500	340	3200	130
4	13500	810	8800	525	6350	380	2400	145
5	11000	650	7000	420	5100	305	1900	115
6	9000	720	5800	465	4250	340	1600	130
8	6800	675	4400	440	3200	320	1200	120
10	5400	755	3500	490	2500	355	1000	140
12	4500	720	2900	465	2100	340	800	130
16	3400	745	2200	480	1600	350	600	130
20	2700	745	1750	480	1280	350	320	130
D : Diameter	Side Milling 						Side Milling 