

List of recommended milling conditions for MNE

| Work Material | | S50C.NAK.HPM.SUS | | | | |
|---------------|------------------|---------------------------|---------------|---------------------------|---------------|---------------------------|
| DIAMETER | EFFECTIVE LENGTH | Standard | | High Speed | | SPEED (mm ⁻¹) |
| | | SPEED (mm ⁻¹) | FEED (mm/mim) | SPEED (mm ⁻¹) | FEED (mm/mim) | |
| 1 | 6L | 16000 | 400 | 24000 | 2000 | 0.06 |
| 1 | 8L | 16000 | 400 | 24000 | 2000 | 0.04 |
| 1 | 10L | 16000 | 400 | 24000 | 2000 | 0.03 |
| 1 | 12L | 16000 | 400 | 24000 | 2000 | 0.02 |
| 1.5 | 8L | 12000 | 400 | 16000 | 1400 | 0.12 |
| 1.5 | 10L | 12000 | 400 | 16000 | 1400 | 0.08 |
| 1.5 | 12L | 12000 | 400 | 16000 | 1400 | 0.05 |
| 1.5 | 16L | 12000 | 400 | 16000 | 1400 | 0.02 |
| 2 | 10L | 8000 | 400 | 12000 | 1000 | 0.20 |
| 2 | 12L | 8000 | 400 | 12000 | 1000 | 0.15 |
| 2 | 16L | 8000 | 400 | 8000 | 700 | 0.08 |
| 2 | 20 | 8000 | 400 | 8000 | 650 | 0.04 |
| 2.5 | 10L | 6600 | 450 | 10000 | 800 | 0.25 |
| 2.5 | 12L | 6600 | 450 | 8000 | 600 | 0.20 |
| 2.5 | 16L | 6600 | 450 | 5000 | 400 | 0.15 |
| 2.5 | 20L | 6600 | 450 | 4000 | 400 | 0.10 |
| 3 | 10L | 5600 | 450 | 8000 | 680 | 0.30 |
| 3 | 12L | 5600 | 450 | 8000 | 680 | 0.30 |
| 3 | 16L | 5600 | 450 | 5500 | 450 | 0.25 |
| 3 | 20L | 5600 | 450 | 4000 | 350 | 0.25 |
| 3 | 25L | 5600 | 450 | 3200 | 260 | 0.20 |