


List of recommended milling conditions for MBMT MBM

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)
R0.15	32000	450	32000	400	32000	200	25000	140
R0.2	32000	460	32000	410	32000	200	25000	135
R0.25	32000	480	32000	550	32000	230	25000	150
R0.3	32000	530	32000	550	32000	250	25000	160
R0.35	32000	580	32000	580	30000	250	24000	160
R0.4	32000	610	32000	620	28000	280	23500	210
R0.5	32000	750	32000	620	22000	280	19000	210
R0.6	30000	750	30000	620	18500	280	15500	210
R0.7	27000	750	22000	620	15500	280	13500	210
R0.75	25000	750	21000	620	14200	280	12000	210
R0.8	23500	750	19000	620	13500	280	11500	210
R0.9	21000	750	18000	620	12000	280	10500	210
R1.0	19000	750	16000	620	11000	280	9500	210
D : Diameter	$XY=0.05D$ $Z=0.2D$ 				$XY=0.05D$ $Z=0.1D$ 