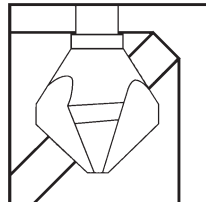


Material	Speed (m/min)	ø10	ø20	ø30	Speed (m/min)	ø10	ø20	ø30	Speed (m/min)	ø10	ø20	ø30
Steels ≤500 N/mm <sup>2</sup>	35-45	Feed* 275	138	90	35-45	Feed* 275	138	90	17-22	Feed* 210	100	75
		RPM 1250	625	430		RPM 1250	625	420		RPM 620	310	210
Steels ≤500 - 800 N/mm <sup>2</sup>	20-30	Feed* 136	68	45	20-30	Feed* 136	68	45	10-15	Feed* 150	76	50
		RPM 800	400	260		RPM 800	400	260		RPM 480	240	160
Steels 800 - 1000 N/mm <sup>2</sup>	15-20	Feed* 68	34	23	15-20	Feed* 68	34	23	8-12	Feed* 100	50	36
		RPM 520	260	180		RPM 520	260	180		RPM 380	190	130
Stainless Steel 1000 - 1300 N/mm <sup>2</sup>	12-15	Feed* 45	25	17	12-15	Feed* 45	25	17	6-8	Feed* 32	16	11
		RPM 380	200	140		RPM 380	200	140		RPM 320	160	110
Stainless Steel Inconel - Nimonic									4-6	Feed* 15	8	5
										RPM 180	90	65
Cast Iron					20-40	Feed* 150	130	100	15-25	Feed* 80	60	50
						RPM 1200	550	430		RPM 630	320	210
Aluminium	50-60	Feed* 400	200	150	0-60	Feed* 400	200	150	35-45	Feed* 375	190	130
		RPM 1600	800	600		RPM 1600	800	600		RPM 1250	625	430
Brass - Bronze					30-40	Feed* 300	150	90	20-30	Feed* 240	120	80
						RPM 1200	600	370		RPM 800	400	260
Copper	20-30	Feed* 200	100	65	20-30	Feed* 200	100	65				
		RPM 800	400	260		RPM 800	400	260				
Laminates					50-100	Feed* 1600	800	250	35-70	Feed* 720	360	240
						RPM 3200	1600	1000		RPM 1600	800	530
Plastics	50-100	Feed* 1600	800	250	500	Feed* 1600	800	250	35-70	Feed* 720	360	240
		RPM 3200	1600	1000		RPM 3200	1600	1000		RPM 1600	800	530

## Longitudinal Chamfers Contouring



Material	Speed (m/min)	ø10	ø20	ø30
Steels ≤500 N/mm <sup>2</sup>	17-22	Feed* 210	100	75
		RPM 620	310	210
Steels 500 - 800 N/mm <sup>2</sup>	10-15	Feed* 150	76	50
		RPM 480	240	160
Steels 800 - 1000 N/mm <sup>2</sup>	8-12	Feed* 100	50	36
		RPM 380	190	130
Stainless Steels 1000 - 1300 N/mm <sup>2</sup>	6-8	Feed* 32	16	11
		RPM 320	160	110
Stainless Steels Inconel - Nimonic	4-6	Feed* 15	8	5
		RPM 180	90	65
Cast Iron	15-25	Feed* 80	60	50
		RPM 630	320	210
Aluminium	25-30	Feed* 255	127	85
		RPM 850	420	280
Bronze / Bronze	15-20	Feed* 137	56	45
		RPM 550	225	180
Copper	10-15	Feed* 95	50	35
		RPM 380	190	130

\*Feed: mm/min