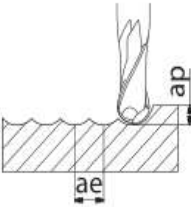


2 Flute ball nose end mill

Processing mode	Material		Dia(mm)	φ2	φ3	φ4	φ5	φ6	φ8	φ10	φ12	φ16
	structural steel		Speed(min ⁻¹)	25900	22800	21300	19700	16000	14000	12800	11800	9500
	cast iron carbon steel		Feed(mm/min)	3910	3570	3290	3070	2890	2660	2540	2500	2470
	tool steel		Speed(min ⁻¹)	23300	20500	19100	17700	15200	12600	11500	10600	8500
	alloy steel		Feed(mm/min)	3100	2880	2670	2490	2330	2110	2010	1980	1970
	stainless steel		Speed(min ⁻¹)	23300	20500	19100	17700	15200	12600	11500	10600	8500
			Feed(mm/min)	3150	2880	2660	2500	2370	2190	2060	1970	1920
	Pre hardened steel	30-38 HRC	Speed(min ⁻¹)	23300	20500	19100	17700	15200	12600	11500	10600	8500
			Feed(mm/min)	3150	2880	2660	2500	2370	2190	2060	1970	1920
		38-45 HRC	Speed(min ⁻¹)	20900	18500	17200	15900	13700	11300	10400	9500	7700
			Feed(mm/min)	2550	2330	2170	2040	1940	1800	1680	1590	1550
		45-55 HRC	Speed(min ⁻¹)	18600	16400	15300	14200	12200	10000	9200	8500	6800
			Feed(mm/min)	2060	1850	1700	1600	1520	1410	1320	1230	1190
	quenched steel	45-55 HRC	Speed(min ⁻¹)	18600	16400	15300	14200	12200	10000	9200	8500	6800
			Feed(mm/min)	2060	1850	1700	1600	1520	1410	1320	1230	1190
		55-60 HRC	Speed(min ⁻¹)	14300	12600	11800	10900	9400	7700	7100	6500	5200
			Feed(mm/min)	1230	1130	1030	980	930	850	800	780	760