

2HSPB							Cutting Condition					
Material	Non-Alloy Steels SCM/HPM		Alloy Steels NAK80/KP4M		Stainless Steels SUS304/SUS316		Hardened Steels STAVAX/SKD11		Heat-treated Steels / Hardened Steels SKD11/ SKD61/ YXR7/ R7 / SKH51		Heat-treated Steels / Hardened Steels SKD11/ SKD61/ YXR7/ R7 / SKH51	
Hardness	30 ~ 40HRC		40 ~ 45HRC		-		45 ~ 55HRC		55 ~ 60HRC		60 ~ 70HRC	
Radius	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
R 0.5	25,600	680	25600	680	25,600	680	25600	680	25,600	610	25600	610
R 0.75	22,000	850	22000	850	22,000	850	22000	850	22,000	750	22000	750
R 1	19,200	1080	19200	1080	19,200	1080	19200	1080	19,200	960	17600	960
R 2	12,400	1440	11200	1240	10,800	1160	10000	1080	10,000	920	8800	920
R 3	8,400	1480	7600	1360	7,200	1280	6800	1200	6,800	1040	5900	1040
R 4	6,400	1120	5700	1000	5,500	960	5100	880	5,100	790	4400	790
R 5	5,100	880	4600	800	4,400	784	4000	720	4,000	640	3600	640
R 6	4,800	840	3800	670	3,640	640	3400	600	3,400	540	3000	540

- The values of ap and ae on the table are for roughing or semi-roughing. If you need a great surface roughness, apply 50% of the value.
- Use the table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine or found red heat on the material, adjust RPM and feed in the same proportion.