

List of recommended milling conditions for ANB

Work Material		S50C. PX5. SKD11. HPM-1. NAK55				
RADIUS	EFFECTIVE LENGTH	SPEED (mm ⁻¹)	FEED (mm/mim)	LONG NECK MILLING (mm/per time)	FEED (mm/mim)	3D MILLING (mm/per time)
R0.5	6L	12800-30000	300-800	0.01-0.05	800-1200	0.1-0.3
R0.5	8L	12800-30000	300-800	0.01-0.05	800-1200	0.1-0.3
R0.5	10L	12800-30000	300-800	0.01-0.05	800-1200	0.1-0.3
R0.5	12L	12800-30000	300-800	0.01-0.05	800-1200	0.1-0.3
R0.75	8L	8500-30000	300-800	0.02-0.10	800-1200	0.1-0.4
R0.75	12L	8500-30000	300-800	0.02-0.10	800-1200	0.1-0.4
R0.75	16L	8500-30000	300-800	0.02-0.10	800-1200	0.1-0.4
R0.75	20L	8500-30000	300-800	0.02-0.10	800-1200	0.1-0.4
R1	8L	6400-30000	300-800	0.02-0.30	800-2000	0.1-0.4
R1	12L	6400-30000	300-800	0.02-0.30	800-2000	0.1-0.4
R1	16L	6400-30000	300-800	0.02-0.30	800-2000	0.1-0.4
R1	20L	6400-30000	300-800	0.02-0.30	800-2000	0.1-0.4
R1.5	8L	4200-20000	300-800	0.02-0.30	800-2000	0.1-0.4
R1.5	10L	4200-20000	300-800	0.02-0.30	800-2000	0.1-0.4
R1.5	16L	4200-20000	300-800	0.02-0.30	800-2000	0.1-0.4
R1.5	20L	4200-20000	300-800	0.02-0.30	800-2000	0.1-0.4
R1.5	25L	4200-20000	300-800	0.02-0.30	800-2000	0.1-0.4
R2	10L	3200-15000	300-800	0.02-0.30	800-1500	0.1-0.5
R2	15L	3200-15000	300-800	0.02-0.30	800-1500	0.1-0.5
R2	20L	3200-15000	300-800	0.02-0.30	800-1500	0.1-0.5
R2	25L	3200-15000	300-800	0.02-0.30	800-1500	0.1-0.5
R2	30L	3200-15000	300-800	0.02-0.30	800-1500	0.1-0.5