

SPEED & FEED RECOMENDATIONS

Diameter ϕ mm	RPM	Feed mm/rev
5.0 - 11.0	2100 - 1000	0.2 - 0.3
12.0 - 24.0	1500 - 750	0.4 - 0.6
25.0 - 37.0	1000 - 400	0.7 - 1.0
38.0 - 49.0	700 - 300	1.5 - 1.8
50.0 - 64.0	500 - 200	2.0 - 2.3
65.0 - 89.0	400 - 150	2.5 - 2.8
90.0 - 149.0	300 - 100	3.3 - 3.8
150.0 - 200.0	200 - 50	4.0 - 5.3

STOCK ALLOWANCE / SURFACE FINISH

	DIAMETER ϕ mm	BURNISHING ALLOWANCE mm	SURFACE FINISH	
			MACHINED $\mu\text{m Ra}$	BURNISHED $\mu\text{m Ra}$
High ductile material	3 - 12	0.010	2.0	0.2
		0.017	3.1	0.2
	13 - 25	0.017	1.5	0.2
		0.040	3.1	0.2
	26 - 50	0.025	1.5	0.2
		0.050	3.1	0.2
	51 - 200	0.040	1.5	0.2
		0.075	5.0	0.2
Low ductile material	3 - 12	0.010	2.0	0.4
		0.017	2.5	0.4
	13 - 25	0.017	2.2	0.4
		0.025	3.1	0.4
	26 - 50	0.025	3.1	0.4
		0.040	4.5	0.4
	51 - 200	0.040	3.0	0.4
		0.050	5.0	0.6