



RECOMMENDED MILLING CONDITIONS

Work material	Carbon STEELS Cast Iron		Alloy steels Mold steels		Pre-hardened steels		Stainless steels Tempered steels		Hardened steels		Hardened steels	
	S50C, FC250		SCM, SKD		30~38HRC		38~45HRC		45~55HRC		55~60HRC	
(mm)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)
BFR6x0.66	5300	1000	4800	780	4200	600	3700	430	3200	320	1600	120
BFR8x0.88	4250	965	3850	770	3350	590	3000	420	2600	310	1300	120
BFR10x0.9	3200	930	2900	760	2500	580	2200	410	1900	300	1000	120
BFR12x1.6	2700	910	2400	730	2100	560	1900	410	1600	300	800	110
BFR12x0.91	2700	820	2400	660	2100	500	1900	370	1600	270	800	100
BFR16x1.77	2000	800	1800	650	1600	510	1400	360	1200	260	600	100
BFR16x1.5	1600	700	1400	550	1300	460	1100	310	1000	240	480	80
Depth of cut	0.1D										0.05D	
Conventional Condition	Adjust milling condition when unusual vibration, different sound occur by cutting.											

Work material	Carbon STEELS Cast Iron		Alloy steels Mold steels		Pre-hardened steels		Stainless steels Tempered steels		Hardened steels		Hardened steels	
	S50C, FC250		SCM, SKD		30~38HRC		38~45HRC		45~55HRC		55~60HRC	
(mm)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)	rpm (mm ⁻¹)	Feed (mm/min)
BFR6x0.66	17000	4100	16000	3800	13000	3100	12000	2300	12000	2000	8000	960
BFR8x0.88	13500	3600	13000	3400	10500	2750	9650	2000	9500	1750	6400	840
BFR10x0.9	10000	3000	10000	3000	8000	2400	7300	1800	7000	1500	4800	720
BFR12x1.6	8500	2000	8000	1900	6600	1600	6100	1200	5800	1000	4000	400
BFR12x0.91	9050	2100	8500	2000	8000	1900	6600	1600	6100	1200	4400	480
BFR16x1.77	6400	1800	6000	1700	5000	1400	4600	1100	4400	900	3000	430
BFR16x1.5	5100	1500	4800	1400	4000	1200	3700	900	3500	700	2400	360
Depth of cut	0.05D										0.02D	
High Speed Cutting Condition	<p>When using low speed machines, use the maximum speed and adjust the feed rate.</p> <p>Adjust milling condition when unusual vibration, different sound occur by cutting.</p>											