

Milling Guideline (<0.5mm DOC)

	Workpiece Material		Hardness approx.	Grade	V		f		Edge P rep.	V		f					
					m/min		mm/rev			m/min		mm/rev					
Ferrous	Soft cast iron	Gray cast iron	<HB200	SB95	600	-	2000	0.10	-	0.15	chamfer/Hone	1969	-	6562	0.004	-	0.006
				SB90	500	-	1500	0.10	-	0.15	chamfer/Hone	1640	-	4921	0.004	-	0.006
		Ductile cast iron	>HB200	SB95	100	-	500	0.10	-	0.15	chamfer/Hone	328	-	1640	0.004	-	0.006
				SB90	100	-	500	0.10	-	0.15	chamfer/Hone	328	-	1640	0.004	-	0.006
	Hard cast iron	white/chill Alloyed cast iron (Ni hard)	HRC 59	SB95	90	-	200	0.10	-	0.15	chamfer/Hone	295	-	656	0.004	-	0.006
	Hardened steels	Hardened steel	>HRC 45	SB95	100	-	200	0.10	-	0.15	chamfer/Hone	328	-	656	0.004	-	0.006
				SB60	100	-	200	0.10	-	0.15	chamfer/Hone	328	-	656	0.004	-	0.006
	P/M parts(Metals)	Ferrous sintered parts	HRC 35	SB95	150	-	300	0.10	-	0.15	chamfer/Hone	492	-	984	0.004	-	0.006
Hard facing alloy	Ni based	HRC 36	SB95	100	-	250	0.10	-	0.30	chamfer/Hone	328	-	820	0.004	-	0.012	

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					m/min		mm/rev			m/min		mm/rev					
Ferrous	Soft cast iron	Gray cast iron	<HB200	SB95	500	-	1200	0.20	-	0.40	chamfer/Hone	1640	-	3937	0.008	-	0.016
				SB90	500	-	1000	0.20	-	0.50	chamfer/Hone	1640	-	3281	0.008	-	0.020
		Ductile cast iron	>HB200	SB95	100	-	500	0.10	-	0.20	chamfer/Hone	328	-	1640	0.004	-	0.008
				SB90	100	-	500	0.10	-	0.20	chamfer/Hone	328	-	1640	0.004	-	0.008
	Hard cast iron	white/chill Alloyed cast iron (Ni hard)	HRC 59	SB95	70	-	150	0.10	-	0.20	chamfer/Hone	230	-	492	0.004	-	0.008
	Hardened steels	Hardened steel	>HRC 45	SB95	70	-	150	0.10	-	0.40	chamfer/Hone	230	-	492	0.004	-	0.016
				SB60	70	-	150	0.10	-	0.20	chamfer/Hone	230	-	492	0.004	-	0.008
	P/M parts(Metals)	Ferrous sintered parts	HRC 35	SB95	100	-	150	0.10	-	0.30	chamfer/Hone	328	-	492	0.004	-	0.012
Hard facing alloy	Ni based	HRC 36	SB95	50	-	200	0.10	-	0.20	chamfer/Hone	164	-	656	0.004	-	0.008	