

WORK MATERIAL	Aluminium Alloy Casting Aluminium Die Casting			Wrought Aluminium Alloy		
	DIAMETER	RPM(MIN ⁻¹)	Speed(m/min)	Feed(mm/rev)	RPM(MIN ⁻¹)	Speed(m/min)
Ø3.0 ~ Ø6.0	8,000~15,000	80~150	0.2~0.5	8,000~15,000	80~150	0.15~0.3
~ Ø10.0	6,000~10,500	100~200	0.3~1.0	6,000~10,500	100~200	0.2~0.4
~ Ø14.0	4,500~5,800	150~250	0.3~1.0	4,500~5,800	150~250	0.2~0.4
~ Ø20.0	3,200~4,600	150~200	0.3~1.0	3,200~4,600	150~200	0.2~0.4