

Processed material	Aluminum alloy		Silicon aluminum alloy Si≤10%	
Diameter(mm)	Rotating speed(min	Feed rate (mm/min)	Rotating speed(min	Feed rate (mm/min)
1	40000	800	40000	600
2	40000	1200	32000	900
3	26500	1800	21000	1300
4	20000	2000	16000	1500
5	16000	1750	13000	1300
6	13000	1500	10600	1200
8	10000	1650	8000	1300
10	8000	1900	6500	1500
12	6600	1950	6300	1550
14	5700	2000	4600	1600
16	5000	2000	4000	1600
18	4400	2000	3500	1600
20	4000	2000	3200	1600