CSM Centering

CSM
Specification page
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Work Material	Mild steels, Carbon steels, Cast iron SS400, S55C, FC250 (-750N/mm2)		Alloy Steels, Tool Steels, SCM, SKT, SKS, SKD ~HRC30合		Hardened steels. Prehardened steels. (Free-cutting) SKT.SKD.NAK55.HPM1 HRC30~38		Cast Iron FC250, etc. Carbon Steels ~HRC30		Aluminum alloy expanding material	
Diameter 直徑(mm)	Rotational Speed (min-1)	Feed Rate (mm/min)	Rotational Speed (min-1)	Feed Rate (mm/min)	Rotational Speed (min-1)	Feed Rate (mm/min)	Rotational Speed (min-1)	Feed Rate (mm/min)	Rotational Speed (min-1)	Feed Rate (mm/min)
4	4000	480	2400	270	1200	108	4000	480	6000	900
6	2600	486	1600	252	800	102	2700	486	4000	900
8	2000	450	1200	234	600	99	2000	450	3000	900
10	1600	432	960	201	480	93	1600	432	2400	900

CSM Chamfering

Work Material	Mild steels, Carbon steels, Cast iron SS400, S55C, FC250 (-750N/mm2)		Alloy Steels, Tool Steels, SCM, SKT, SKS, SKD ~HRC30		Hardened steels. Prehardened steels. (Free-cutting) SKT.SKD.NAK55.HPM1 HRC30~38		Cast Iron FC250, etc. Carbon Steels ~HRC30		Aluminum alloy expanding material	
Diameter (mm)	Rotational Speed (min-1)	Feed Rate (mm/min)	Rotational Speed (min-1)	Feed Rate (mm/min)	Rotational Speed (min-1)	Feed Rate (mm/min)	Rotational Speed (min-1)	Feed Rate (mm/min)	Rotational Speed (min-1)	Feed Rate (mm/min)
4	4000	300	2400	150	1200	60	4000	675	6000	600
6	2600	300	1600	150	800	60	2700	675	4000	600
8	2000	300	1200	150	600	60	2000	675	3000	600
10	1600	300	960	150	480	60	1600	675	2400	600