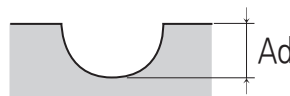


High Speed Milling Condition

피삭재	프리하든강			고경도강(열처리강)					
Workpiece	Preharden Steel NAK, STAVAX			Hardened Steels SKD			Hardened Steels SKD 11		
HRC	HRC ~ 55			HRC 55 ~ 60			HRC 60 ~ 65		
Radius of Ball Nose	Depth of Cut Ad(mm)	Speed (min ⁻¹)	Feed (mm/min)	Depth of Cut Ad(mm)	Speed (min ⁻¹)	Feed (mm/min)	Depth of Cut Ad(mm)	Speed (min ⁻¹)	Feed (mm/min)
R0.05	0.003	60,000	150	0.002	60,000	100	0.001	52,500	30
R0.1	0.004	60,000	180	0.003	60,000	120	0.002	45,000	60
R0.15	0.005	45,000	310	0.004	43,500	180	0.003	32,500	90
R0.2	0.006	37,500	420	0.005	35,000	240	0.004	26,250	120
R0.25	0.007	33,000	530	0.006	30,000	300	0.005	22,500	150
R0.3	0.008	27,000	1,200	0.007	26,500	800	0.006	20,000	400
R0.4	0.100	24,000	1,600	0.009	23,500	1,000	0.008	17,500	500
R0.5	0.100	21,000	2,000	0.100	21,000	1,750	0.100	16,000	875
R0.75	0.150	17,000	2,000	0.100	18,000	1,750	0.100	14,500	875
R1.0	0.200	14,000	2,000	0.200	15,000	1,750	0.150	11,250	875
R1.25	0.200	12,250	1,100	0.200	12,250	1,800	0.150	9,200	900
R1.5	0.200	10,500	2,150	0.200	10,700	1,850	0.150	8,050	925
R2.0	0.250	9,000	2,200	0.200	9,200	1,900	0.150	6,900	950
R2.5	0.250	7,800	2,300	0.200	7,900	2,000	0.150	5,900	1,000
R3.0	0.300	6,500	2,500	0.250	6,800	2,100	0.150	5,100	1,050
R4.0	0.400	5,200	2,500	0.300	5,700	2,200	0.200	5,300	1,100
R5.0	0.500	4,300	2,200	0.400	4,500	1,900	0.300	3,400	950
R6.0	0.600	3,600	2,000	0.500	3,750	1,750	0.400	2,800	875
R6.5	0.600	3,600	1,750	0.500	3,150	1,500	0.400	2,350	750
R7.0	0.700	3,000	1,750	0.600	2,850	1,350	0.450	2,150	700
R8.0	0.700	2,500	1,500	0.600	2,300	1,200	0.450	1,800	650
R10.0	0.800	2,500	1,300	0.700	2,300	1,200	0.500	1,800	650

Depth of Cut



⚠ 경고 Warning

- 경밀하고 강성이 있는 홀더와 장비를 사용해주시시오.
- 절입량의 Ad는 축방향 절입량을 표시합니다.
- 강재 가공 시 Air Blow나 Oil Mist 사용을 추천합니다.
- 회전수와 테이블 이송은 같은 비율로 조정해주시시오.
- 상기 조건표는 참고 자료이니 실제 가공 시 가공 형상, 기계 용량, 작업환경에 따라 조건을 조정해서 가공하시기 바랍니다.

- Use a rigid precise machine and holder.
- Ad(mm) : Axial Depth of Cut.
- For milling steels, air blow or MQL(Oil Mist) are recommended.
- Adjust both Spindle speed and Feedrate by the same proportion.
- The above condition are only reference. In actual machining conditions adjust these parameters according to the milling shape, machine capability and the operation environment.