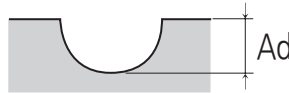


2RSB

High Speed Milling Condition

피삭재		프리하든강			고경도강(열처리강)					
Workpiece	Prehardened 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	0.002	60,000	150	0.002	60,000	150	0.001	52,500	30	
R0.1	0.003	60,000	180	0.002	60,000	180	0.002	45,000	60	
R0.15	0.006	60,000	350	0.004	45,000	310	0.003	32,500	90	
R0.2	0.010	50,000	500	0.007	37,500	420	0.005	26,250	120	
R0.25	0.015	44,000	650	0.010	33,000	550	0.007	22,500	150	
R0.3	0.030	40,000	1,100	0.020	30,000	1,200	0.010	20,000	400	
R0.4	0.060	35,000	1,600	0.040	27,000	1,600	0.020	17,500	500	
R0.5	0.020	30,000	1,750	0.100	24,000	2,000	0.050	16,000	870	
R0.6	0.025	30,000	2,000	0.120	21,000	2,000	0.050	14,500	870	
R0.75	0.025	30,000	2,450	0.150	17,000	2,000	0.060	11,250	900	
R1.0	0.300	28,000	2,900	0.150	14,000	2,100	0.080	9,200	930	
R1.5	0.400	24,500	2,950	0.200	12,250	2,150	0.100	8,050	950	
R2.0	0.500	21,000	3,000	0.250	10,500	2,200	0.120	6,900	1,000	
R2.5	0.500	18,000	3,200	0.250	9,000	2,300	0.150	5,900	1,050	
R3.0	0.600	15,600	3,500	0.300	7,800	2,500	0.150	5,000	1,100	
R4.0	0.700	13,000	3,000	0.400	6,500	2,500	0.200	4,300	950	
R5.0	0.800	9,500	2,500	0.500	5,200	2,200	0.250	3,400	875	
R6.0	0.900	7,500	2,000	0.600	4,300	2,000	0.300	2,800	750	

Depth of Cut



⚠ 경고 Warning

1. 경밀하고 강성이 있는 홀더와 장비를 사용해주십시오.
 2. 절입량의 Ad는 축방향 절입량을 표시합니다.
 3. 강재 가공 시 Air Blow나 Oil Mist 사용을 추천합니다.
 4. 회전수와 테이블 이송은 같은 비율로 조정해주십시오.
 5. 상기 조건표는 참고 자료이니 실제 가공 시 가공 형상, 기계 용량, 작업환경에 따라 조건을 조정해서 가공하시기 바랍니다.
1. Use a rigid precise machine and holder.
 2. Ad(mm) : Axial Depth of Cut.
 3. For milling steels, air blow or MQL(Oil Mist) are recommended.
 4. Adjust both Spindle speed and Feedrate by the same proportion.
 5. The above condition are only reference. In actual machining conditions adjust these parameters according to the milling shape, machine capability and the operation environment.