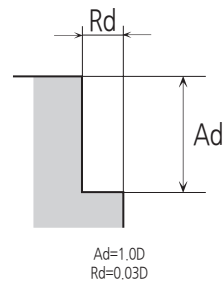
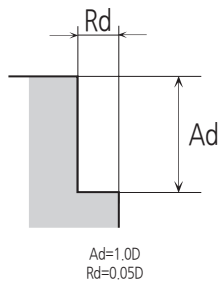


6HPE

High Speed Milling Condition

피삭재	프리하든강		고경도강(열처리강)					
Workpiece	Preharden Steel NAK, CENA 1		Hardened Steels SKD 61, STAVAX		Hardened Steels SKD 11, SKD 61		Hardened Steels ASP	
HRC	HRC 30 ~ 45		HRC 45 ~ 55		HRC 55 ~ 65		HRC 65 ~ 70	
Outside Diameter	Speed (min ⁻¹)	Feed (mm/min)	Speed (min ⁻¹)	Feed (mm/min)	Speed (min ⁻¹)	Feed (mm/min)	Speed (min ⁻¹)	Feed (mm/min)
6.0	13,000	4,400	11,000	3,300	8,000	2,200	5,300	1,300
8.0	10,000	4,500	8,000	3,200	6,000	2,200	4,000	1,300
10.0	8,000	4,300	6,400	3,050	4,800	2,100	3,200	1,250
12.0	6,600	4,000	5,300	2,800	4,000	1,900	2,700	1,170
16.0	5,000	3,800	4,000	2,650	3,000	1,800	2,000	1,100
20.0	4,000	3,600	3,200	2,530	2,400	1,730	1,600	1,050

Depth of Cut



! 경고 Warning

1. 경밀하고 강성이 있는 홀더와 장비를 사용하십시오.
2. 절입량의 Ad는 축방향 절입량을 표시합니다.
3. 강재 가공 시 Air Blow나 Oil Mist 사용을 추천합니다.
4. 회전수와 테이블 이송은 같은 비율로 조정하십시오.
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.