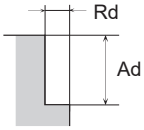
TECHNICAL DATA
MICRO GRAIN

CAE3000 (Milling Condition)

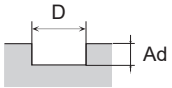
WARINING

Danger of fire by spark incidence or heat caused by tool breakage can happen during processing.
Confirm fire prevention countermeasure beforehand necessarily before use.

■ SIDE Milling Condition

Work Material	ALUMINIUM ALLOY		COPPER ALLOY	
Outside Diameter	SPEED (min^{-1})	FEED (mm/min)	SPEED (min^{-1})	FEED (mm/min)
3.0	21,000	1,100	8,000	325
4.0	15,500	1,250	6,000	365
5.0	12,500	1,280	4,800	385
6.0	10,500	1,400	4,000	400
8.0	7,900	1,500	3,000	460
10.0	6,300	1,700	2,400	475
12.0	5,300	1,800	2,000	510
16.0	3,900	1,800	1,500	510
DEPTH OF CUT			Ad=1.0D Rd=0.1D	

■ SLOT Milling Condition

Work Material	ALUMINIUM ALLOY		COPPER ALLOY	
Outside Diameter	SPEED (min^{-1})	FEED (mm/min)	SPEED (min^{-1})	FEED (mm/min)
3.0	21,000	770	8,000	325
4.0	15,500	810	6,000	375
5.0	12,500	860	4,800	385
6.0	10,500	950	4,000	400
8.0	7,900	1,000	3,000	460
10.0	6,300	1,130	2,400	475
12.0	5,300	1,180	2,000	510
16.0	3,900	1,180	1,500	510
DEPTH OF CUT			Ad=0.5D	

1. Use a rigid and precise machine and holder.
2. Use a water soluble cutting fluid.