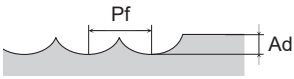
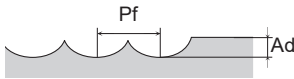




HPB2000 (High Speed Milling Condition)



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

Work Material	PREHARDENED STEELS NAK		HARDENED STEELS SKD61, STAVAX		HARDENED STEELS SKD11	
Hardness (HRc)	HRc30 ~ 45		HRc45 ~ 55		HRc55 ~ 65	
Radius of Ball Nose	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)
R0.2	45,000	2,000	42,000	1,800	40,000	1,500
R0.25	45,000	2,300	42,000	2,000	40,000	1,600
R0.3	42,000	2,500	40,000	2,300	40,000	1,700
R0.4	42,000	2,800	40,000	2,500	40,000	1,800
R0.5	42,000	3,100	40,000	2,700	40,000	1,900
R0.75	40,000	3,800	38,000	2,900	38,000	2,000
R1.0	38,000	4,000	36,000	3,200	32,000	2,100
R1.25	37,000	4,200	35,000	3,300	28,000	2,100
R1.5	36,000	4,400	35,000	3,500	24,000	2,100
R2.0	31,000	4,700	24,500	3,550	17,000	2,300
R2.5	28,000	4,700	28,000	3,600	15,000	2,100
R3.0	21,000	4,900	18,000	3,600	12,500	2,100
R4.0	15,000	4,000	12,000	2,900	7,900	1,800
R5.0	10,000	3,600	8,500	2,500	6,300	1,500
R6.0	8,500	3,400	7,500	2,300	5,300	1,300
DEPTH OF CUT	 Ad = 0.02D P f= 0.05D				 Ad = 0.01D P f= 0.05D	

1. Use a rigid and precise machine and holder.
2. Recommend air blow or MQL(Oil Mist)