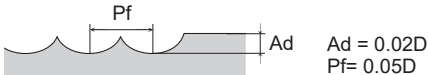




APB2000 (High Speed Milling Condition)



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	CARBON STEELS S50C		PREHARDENED STEELS NAK		HARDENED STEELS SKD61, STAVAX	
Hardness (HRc)	~HRc30		HRc30 ~ 45		HRc45 ~ 55	
Radius of Ball Nose	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)
R0.5	34,000	2,000	32,000	1,600	30,000	1,500
R0.75	32,000	2,500	30,000	2,050	28,000	1,900
R1.0	30,000	2,700	28,000	2,250	25,000	2,000
R1.5	27,000	3,200	25,000	2,500	22,000	2,200
R2.0	24,000	3,300	20,000	2,700	18,300	2,450
R3.0	16,000	3,500	13,500	2,650	12,200	2,450
R4.0	12,000	3,100	10,000	2,500	9,200	2,450
R5.0	9,500	2,850	8,000	2,300	7,350	2,150
R6.0	8,000	2,800	6,700	2,250	6,100	2,100
DEPTH OF CUT						

1. Use a rigid and precise machine and holder.
2. Recommend air blow or MQL(Oil Mist)
When using cutting fluids, use cutting fluid with smoke retardant.