

APLS2000R (Milling Condition)



WARNING

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	
Outside Diameter	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)
6	3,800	250	2,700	130	1,600	55
8	2,900	240	2,100	120	1,200	50
10	2,300	230	1,700	100	1,000	50
12	2,000	230	1,400	100	800	45
DEPTH OF CUT						

1. Use a rigid and precise machine and holder.
2. Use cutting fluid with smoke retardant.