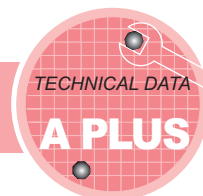
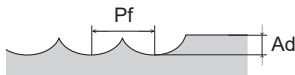


KPBL2000 (High Speed Milling Condition)



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

WARNING

Work Material	COPPER ALLOYS		
Radius of Ball Nose	Depth of Cut Ad(mm)	SPEED (min ⁻¹)	FEED (mm/min)
R0.5	0.050~0.200	20,000~40,000	800~3,000
R0.75	0.100~0.300	18,000~30,000	1,200~3,000
R1.0	0.100~0.400	12,000~20,000	1,200~3,000
R1.5	0.200~0.500	16,000~20,000	1,800~4,000
R2.0	0.300~0.500	16,000~20,000	2,100~4,000
R3.0	0.300~0.600	13,300~20,000	1,600~4,000
R4.0	0.300~0.800	10,000~16,000	1,400~3,200
R5.0	0.300~1.000	8,000~12,800	1,280~3,000
R6.0	0.300~1.200	6,600~10,000	1,190~2,660
DEPTH OF CUT	 $Pf \leq 0.6D$		

1. Use a rigid and precise machine and holder.
2. Recommend water soluble fluids.