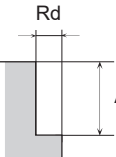
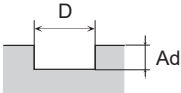


# KPE2000 (High Speed Milling Condition)



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    | Copper                                                                                                                                                  |               |                                                                                                                                         |               |
|------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|-----------------------------------------------------------------------------------------------------------------------------------------|---------------|
| Outside Diameter | SPEED (min <sup>-1</sup> )                                                                                                                              | FEED (mm/min) | SPEED (min <sup>-1</sup> )                                                                                                              | FEED (mm/min) |
| 0.4              | 30,000~40,000                                                                                                                                           | 100           | 30,000~40,000                                                                                                                           | 80            |
| 0.5              | 28,000~35,000                                                                                                                                           | 120           | 28,000~35,000                                                                                                                           | 100           |
| 0.6              | 27,000~33,000                                                                                                                                           | 150           | 23,000~28,000                                                                                                                           | 120           |
| 0.8              | 20,000~25,000                                                                                                                                           | 180           | 18,000~24,000                                                                                                                           | 150           |
| 1                | 15,000~20,000                                                                                                                                           | 180           | 14,000~20,000                                                                                                                           | 150           |
| 1.2              | 14,000~20,000                                                                                                                                           | 200           | 10,000~15,000                                                                                                                           | 150           |
| 1.5              | 14,000~20,000                                                                                                                                           | 250           | 10,000~15,000                                                                                                                           | 150           |
| 2                | 13,000~18,000                                                                                                                                           | 320           | 5,000~10,000                                                                                                                            | 150           |
| 2.5              | 13,000~18,000                                                                                                                                           | 420           | 5,000~10,000                                                                                                                            | 150           |
| 3.0              | 12,000~17,000                                                                                                                                           | 600           | 4,000~8,000                                                                                                                             | 170           |
| 4.0              | 10,000~15,000                                                                                                                                           | 650           | 4,000~8,000                                                                                                                             | 200           |
| 5.0              | 8,000~12,000                                                                                                                                            | 700           | 4,000~8,000                                                                                                                             | 250           |
| 6.0              | 5,000~10,000                                                                                                                                            | 750           | 3,500~7,000                                                                                                                             | 250           |
| 8.0              | 4,000~9,000                                                                                                                                             | 650           | 3,000~6,000                                                                                                                             | 250           |
| 10.0             | 4,000~8,000                                                                                                                                             | 600           | 3,000~6,000                                                                                                                             | 350           |
| 12.0             | 3,000~6,000                                                                                                                                             | 500           | 3,000~6,000                                                                                                                             | 450           |
| DEPTH OF CUT     |  <p>Ad=1.5D, Rd=0.02D (D ≤ Ø1)<br/>Ad=1.5D, Rd=0.10D (D &gt; Ø1)</p> |               |  <p>Ad=0.05D (D ≤ Ø1)<br/>Ad=0.10D (D &gt; Ø1)</p> |               |

11. Use a rigid and precise machine and holder.
12. Recommend water soluble fluids.