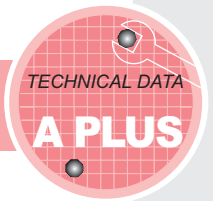
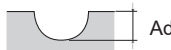


KPRB (High Speed Milling Condition)



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 ALLOYS		
Radius of Ball Nose	Depth of Cut Ad(mm)	SPEED (min ⁻¹)	FEED (mm/min)
R0.05	0.003~0.010	38,000~50,000	50~100
R0.1	0.010~0.020	38,000~50,000	200~500
R0.15	0.010~0.025	38,000~50,000	300~800
R0.2	0.010~0.030	30,000~42,000	300~1,000
R0.25	0.010~0.030	30,000~42,000	500~1,400
R0.3	0.010~0.100	24,000~40,000	350~1,600
R0.4	0.030~0.100	20,000~40,000	450~2,000
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
DEPTH OF CUT			

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