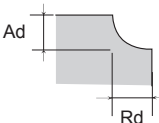




APRE4000R (High Speed Milling Condition)



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	
Outside Diameter	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)
3	21,000	3,200	19,100	2,900	17,000	2,300
4	16,000	3,200	14,300	2,850	12,800	2,350
6	10,500	4,250	9,500	3,800	8,500	3,050
8	8,000	3,500	7,200	3,200	6,400	2,500
10	6,400	3,050	5,750	2,750	5,100	2,250
12	5,300	2,750	4,800	2,500	4,250	2,050
DEPTH OF CUT	 Ad=0.01D~0.02D Rd=0.20D~0.40D					

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