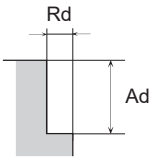


HPE4000 (High Speed Milling Condition)



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	PREHARDENED STEELS NAK		HARDENED STEELS SKD61, STAVAX		HARDENED STEELS SKD11	
Hardness (HRC)	HRC30 ~ 45		HRC45 ~ 55		HRC55 ~ 65	
Outside Diameter	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)	SPEED (min ⁻¹)	FEED (mm/min)
1.0	35,000	1150	23,000	540	14,500	180
2.0	30,000	1300	15,500	630	12,700	380
3.0	18,500	1300	10,500	630	8,500	380
4.0	16,500	1620	11,500	1000	6,500	410
5.0	14,500	1620	10,000	1170	6,000	410
6.0	12,500	1700	8,500	1170	4,700	410
8.0	10,000	1620	6,500	1080	3,500	360
10.0	7,500	1440	5,500	1000	3,000	360
12.0	7,000	1440	4,500	900	2,800	360
DEPTH OF CUT	 Ad=1.0D Rd=0.03D					

1. Use a rigid and precise machine and holder.
2. Recommend air blow or MQL(Oil Mist)