



HPRM (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 SKD,STAVAX		
Hardness (HRc)	HRc30 ~ 45			HRc45 ~ 55		
Outside Diameter	Depth of Cut Ad(mm)	SPEED (min ⁻¹)	FEED (mm/min)	Depth of Cut Ad(mm)	SPEED (min ⁻¹)	FEED (mm/min)
1.0	0.014~0.030	14,500~20,000	650~1,100	0.010~0.030	11,000~15,500	430~720
1.5	0.030~0.050	11,000~13,000	700~1,000	0.020~0.040	8,000~11,500	500~720
2.0	0.020~0.040	7,200~8,700	630~840	0.015~0.030	5,400~7,200	400~650
3.0	0.050~0.070	5,000~6,300	720~1,100	0.030~0.050	4,000~5,000	520~730
4.0	0.050~0.080	3,600~4,500	720~1,000	0.040~0.060	2,700~3,200	470~640
DEPTH OF CUT						

1. Use a rigid and precise machine and holder.
2. For milling steels, air blow or MQL(Oil Mist) are recommended. When using cutting fluids, use cutting fluid with smoke retardant.
(For milling copper, water soluble fluids are recommended.)