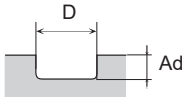




HPRE4000R (High Speed Milling Condition)



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 ~ 60		
Outside Diameter	Depth of Cut Ad(mm)	SPEED (min ⁻¹)	FEED (mm/min)	Depth of Cut Ad(mm)	SPEED (min ⁻¹)	FEED (mm/min)
2	0.050	18,000	2,200	0.030	14,000	1,700
3	0.100	16,000	2,700	0.080	12,800	1,800
4	0.100	14,000	3,000	0.080	10,000	2,000
6	0.100	13,000	4,700	0.080	10,400	3,500
8	0.150	9,000	4,200	0.130	7,200	3,200
10	0.150	6,000	3,300	0.130	4,800	2,500
12	0.150	5,000	3,100	0.130	4,000	2,400
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.)