

HPE6000 (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 Hardness (HRC)	PREHARDENED STEELS NAK		HARDENED STEELS SKD61,STAVAX		HARDENED STEELS SKD11,SKD61		HARDENED STEELS ASP	
	HRC30 ~ 45		HRC45 ~ 55		HRC55 ~ 65		HRC65 ~ 70	
Outside Diameter	SPEED (min ⁻¹)	FEED (mm/min ⁻¹)	SPEED (min ⁻¹)	FEED (mm/min ⁻¹)	SPEED (min ⁻¹)	FEED (mm/min ⁻¹)	SPEED (min ⁻¹)	FEED (mm/min ⁻¹)
6.0	13,000	4,400	11,000	3,300	8,000	2,200	5,300	1,300
8.0	10,000	4,500	8,000	3,200	6,000	2,200	4,000	1,300
10.0	8,000	4,300	6,400	3,050	4,800	2,100	3,200	1,250
12.0	6,600	4,000	5,300	2,800	4,000	1,900	2,700	1,170
16.0	5,000	3,800	4,000	2,650	3,000	1,800	2,000	1,100
20.0	4,000	3,600	3,200	2,530	2,400	1,730	1,600	1,050
DEPTH OF CUT								

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