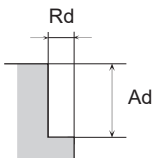
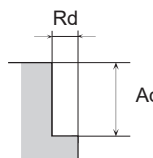




APEL4000 (Milling Condition)



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)
2.0	19,000	750	15,000	650	12,000	350
3.0	15,000	1,000	12,500	800	10,000	500
4.0	11,000	1,100	9,500	850	7,900	600
6.0	7,500	1,100	6,500	850	5,200	600
8.0	5,500	1,000	4,800	750	4,000	500
10.0	4,500	1,000	3,800	750	3,200	500
12.0	3,700	1,000	3,200	750	2,500	500
DEPTH OF CUT						
	Ad=1.0D, Rd=0.02D (D ≤ Ø6) Ad=1.0D, Rd=0.05D (D > Ø6)		Ad=1.0D, Rd=0.01D (D ≤ Ø6) Ad=1.0D, Rd=0.02D (D > Ø6)			

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