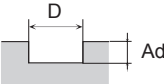
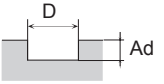




APE2000 (Milling Condition)



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)
1.0	29,000	520	19,000	260	12,000	120
1.5	20,000	530	13,000	270	8,500	120
2.0	16,000	530	10,000	270	6,500	120
3.0	11,000	580	6,500	290	4,500	140
4.0	8,800	560	5,500	270	3,500	130
6.0	6,500	540	3,700	250	2,500	130
8.0	4,800	540	2,800	250	2,000	130
10.0	3,800	540	2,300	250	1,500	130
12.0	3,200	540	1,900	250	1,300	130
DEPTH OF CUT	 Ad=0.15D (D ≤ Ø3) Ad=0.20D (D > Ø3)				 Ad=0.10D (D ≤ Ø6) Ad=0.15D (D > Ø6)	

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