

BMS-4040—RGD $\phi 6$ End milling application (A5052)

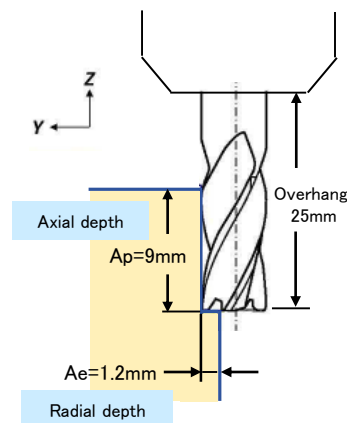
Tool : 2-Flute 6 end mill (NS Tool AL3D-2)

Work : Aluminum alloy A5052 (L100 × W40 × T50)

Machine : Machining center (Sodick MC430L)

Coolant : Oil mist

	NS Tool	Nakanishi
Rotation speed [min^{-1}]	17,500	2.3 times 40,000
Feed [mm/min]	1,400	1.4 times 2,000
Depth $A_p \times A_e$ [mm]	9×1.2	9×1.2

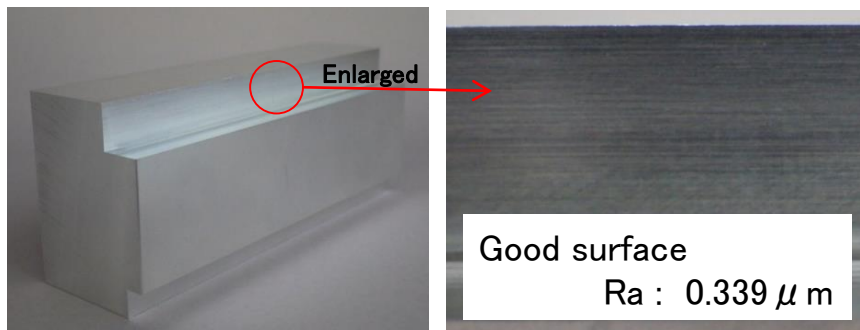


Pic.10 Milling condition

The load meter indicates 3 green LED and 2 yellow LED.

Depth is not changed and the feed during high speed milling is regulated.

The feed become 1.4 times and The milling efficiency is improved by 1.4 times feed.



Pic.11 Finishing surface of high speed milling