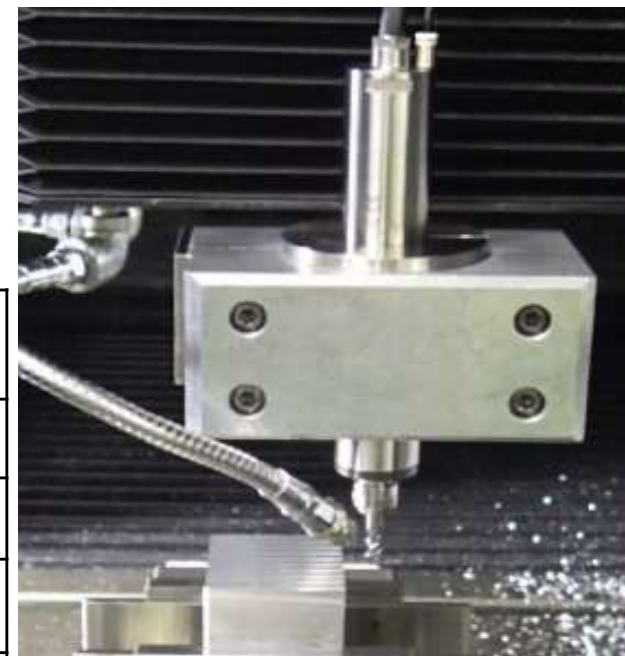


EMR-3008K ϕ 4.0mm End mill Application (A2017)

Motor Spindle	EMR-3008K/E3000
Machine	Sodick MC (MC430L)
Tools	NS TOOL ϕ 4mm 2-Flute MUGEN-COATING Carbide End mill MSE230 ϕ 4.0
Work	Aluminium alloy A2017
Cutting	Side milling, Down cut
Coolant	Non-water-soluble cutting oil
Cutting Condition	

	NS TOOL	NAKANISHI
Cutting Speed [m/min]	100-200	100
Spindle Speed [min ⁻¹]	11,900	8,000
Feed [mm/min]	830	640
Feed Rate [mm/tooth]	0.03	0.04
Depth of cut Ap × Ae[mm]	8 × 0.8	0.8 × 3.6
E3000 Controller load meter	—	1 load meter lighting (Continuous duty operation)
Surface Roughness Ry(μm) Right Angle Direction / Processing Direction		2.9051 /3.4337



**Processing
Efficiency 35%**