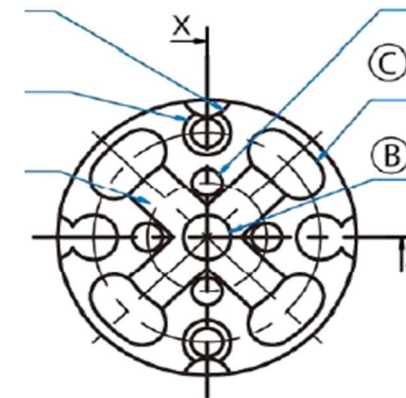


EM20-S6000 ϕ 4.0mm End mill Application (SUS303)

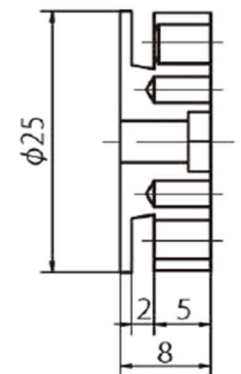
Motor Spindle EM20-S6000/E3000
 Machine Hasegawa CNC H30
 Tools NS TOOL ϕ 4.0 MUGEN-COATING 2-Flute Sharp Edge Short End Mill MSES230P ϕ 4.0
 Work stainless(SUS303)
 Cutting ϕ 4.0 $\times$ Depth 4.0 $\times$ In four locations, Groove cutting
 Coolant Non-water-soluble cutting oil
 Cutting Condition



	NS TOOL	NAKANISHI
Cutting Speed [m/min]	50 -70	314
Spindle Speed [min ⁻¹]	4,800	25,000
Drill Feed C-axis Feed [mm/min]	70	10 400
Feed Rate [mm/tooth]	0.013	0.008
Depth of cut Ap $\times$ Ae[mm]	2 $\times$ 4	0.2 $\times$ 4 <u>$\times$ 20 times</u>
Processing time[sec]	—	90



4- Φ 4.0 End mill



Cross Section X-X