

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 5.0 $\times$ In four locations, Groove cutting
 Coolant Non-water-soluble cutting oil
 Cutting Condition



	NS TOOL	NAKANISHI
Cutting Speed [m/min]	50-70	251
Spindle Speed [min ⁻¹]	4,800	20,000
Feed [mm/min]	70	20
Feed Rate [mm/tooth]	0.013	0.0005
Depth of cut Ap $\times$ Ae[mm]	2 $\times$ 4	1 $\times$ 4 <u>$\times$ 5 times</u>
Processing time[sec]	—	12

