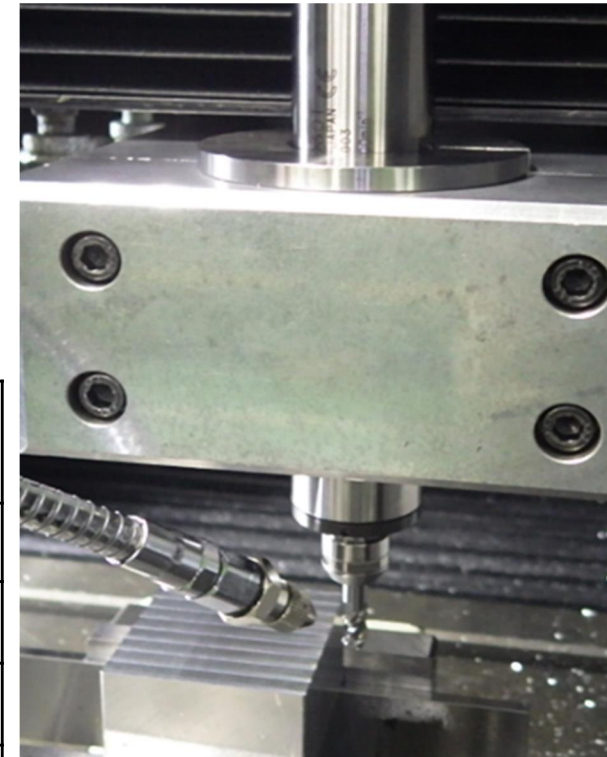


EMR-3008K ϕ 2.5mm End mill Application (SUS304)

Motor Spindle EMR-3008K/E3000
 Machine Sodick MC (MC430L)
 Tools NS TOOL ϕ 2.5mm 2-Flute MUGEN-COATING Carbide end mill MSE230 ϕ 2.5
 Work Stainless steel SUS304
 Cutting Side milling, Down cut
 Coolant Non-water-soluble cutting oil
 Cutting Condition

	NS TOOL	NAKANISHI
Cutting Speed [m/min]	50—70	63
Spindle Speed [min ⁻¹]	7,600	8,000
Feed [mm/min]	180	240
Feed Rate [mm/tooth]	0.012	0.015
Depth of cut $A_p \times A_e$ [mm]	3.75×0.175	0.5×2.25
E3000 Controller load meter	—	1 load meter lighting (continuous duty operation)
Surface Roughness R_y [μ m] Right Angle Direction /Processing Direction	—	6.7537 /2.7469



Processing
 Efficiency
 2.3times