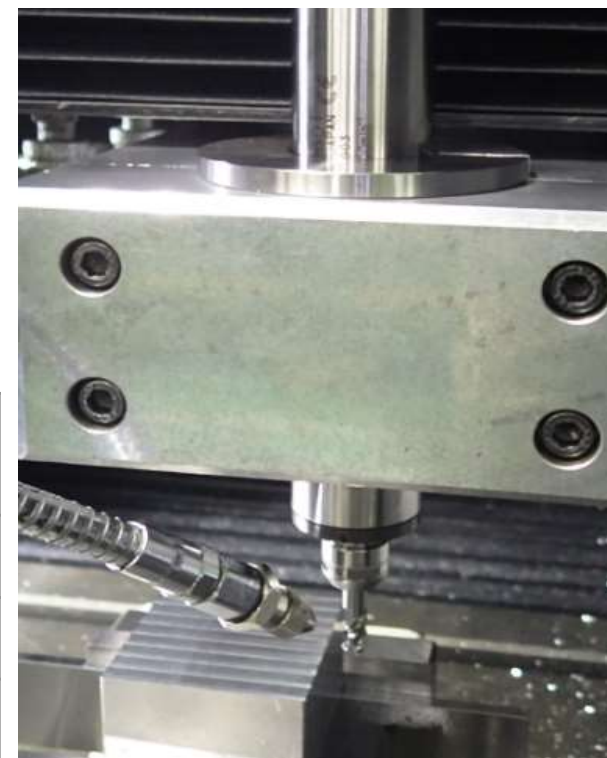


EMR-3008K ϕ 3.0mm End mill Application (S50C)

Motor Spindle EMR-3008K/E3000
 Machine Sodick MC (MC430L)
 Tools NS TOOL ϕ 3mm 2-Flute MUGEN-COATING
 Carbide end mill MSE230 ϕ 3.0
 Work Carbon steel S50C
 Cutting Side milling, Down cut
 Coolant Non-water-soluble cutting oil
 Cutting Condition



	NS TOOL	NAKANISHI
Cutting Speed [m/min]	50—80	75
Spindle Speed [min ⁻¹]	6,900	8,000
Feed [mm/min]	280	480
Feed Rate [mm/tooth]	0.02	0.03
Depth of cut $A_p \times A_e$ [mm]	4.5×0.3	0.6×2.7
E3000 Controller load meter	—	1 load meter lighting (continuous duty operation)
Surface Roughness R_y [μ m] Right Angle Direction /Processing Direction	—	4.2899 /1.8901

**Processing
Efficiency**
2.1times