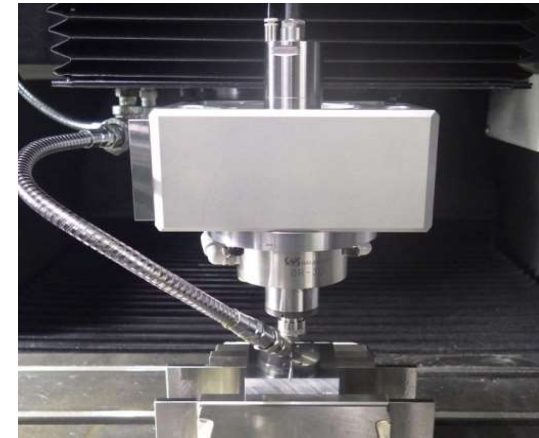


EMS-3060K ϕ 2.0mm End mill Application (S50C)

Motor Spindle EMS-3060K/E3000
 Machine Sodick MC (MC430L)
 Tools NS TOOL ϕ 2mm 2-Flute MUGEN-COATING
 Carbide end mill MSE230 ϕ 2.0
 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	151
Spindle Speed [min ⁻¹]	10,300	24,000
Feed [mm/min]	210	1,200
Feed Rate [mm/tooth]	0.01	0.025
Depth of cut $A_p \times A_e$ [mm]	3×0.14	0.4×1.8
E3000 Controller load meter	—	1 load meter lighting (continuous duty operation)
Surface Roughness R_y [μ m] Right Angle Direction /Processing Direction	—	3.7576 /1.6625



Processing
 Efficiency
 9.8times