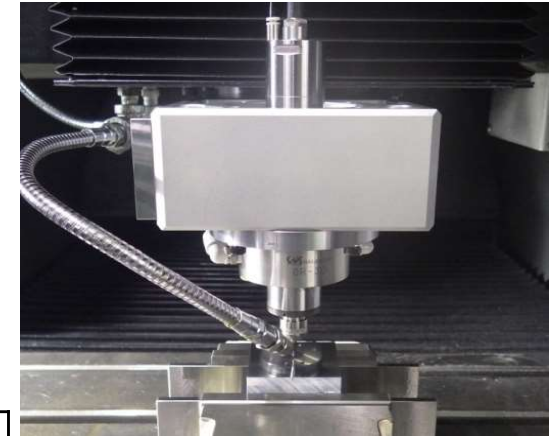


EMS-3060K ϕ 2.0mm End mill Application (SUS304)

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 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	126
Spindle Speed [min ⁻¹]	9,500	20,000
Feed [mm/min]	170	400
Feed Rate [mm/tooth]	0.009	0.01
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	—	1.7638 /1.4065

Processing
 Efficiency
 4times