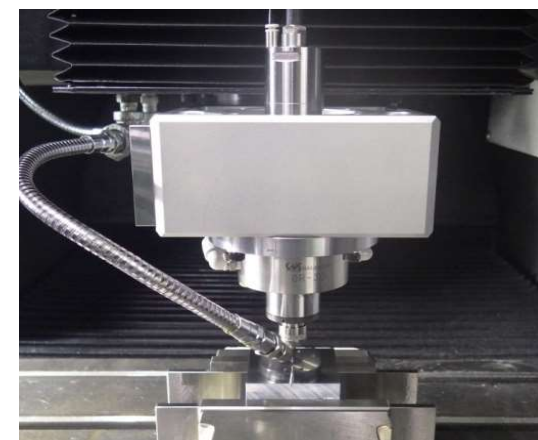


EMS-3060K ϕ 2.5mm End mill Application (A2017)

Motor Spindle EMS-3060K/E3000
 Machine Sodick MC (MC430L)
 Tools NS TOOL ϕ 2.5mm 2-Flute MUGEN-COATING Carbide
 end mill MSE230 ϕ 2.0
 Work Aluminum alloy A2017
 Cutting Side milling, Down cut
 Coolant Non-water-soluble cutting oil
 Cutting Condition



	NS TOOL	NAKANISHI
Cutting Speed [m/min]	100—200	471
Spindle Speed [min ⁻¹]	19,100	60,000
Feed [mm/min]	760	2,400
Feed Rate [mm/tooth]	0.02	0.02
Depth of cut $A_p \times A_e$ [mm]	3.75×0.5	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	—	2.9051 /3.4337

Processing
 Efficiency
 1.9times