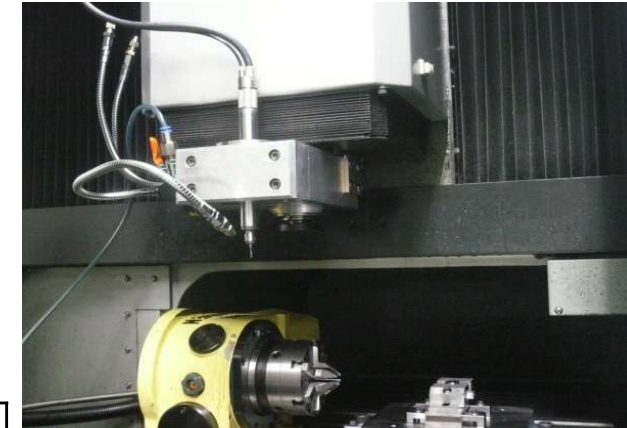


EM20-S6000 ϕ 1.5mm End mill Application (S50C)

Motor Spindle EMS-3060K/E3000
 Machine Sodick MC (MC430L)
 Tools NS TOOL ϕ 1.5mm 2-Flute MUGEN-COATING Carbide end mill MSE230 ϕ 1.5
 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	94
Spindle Speed [min ⁻¹]	13,800	20,000
Feed [mm/min]	210	100
Feed Rate [mm/tooth]	0.008	0.025
Depth of cut $A_p \times A_e$ [mm]	2.25×0.1	0.3×1.35
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
 85%