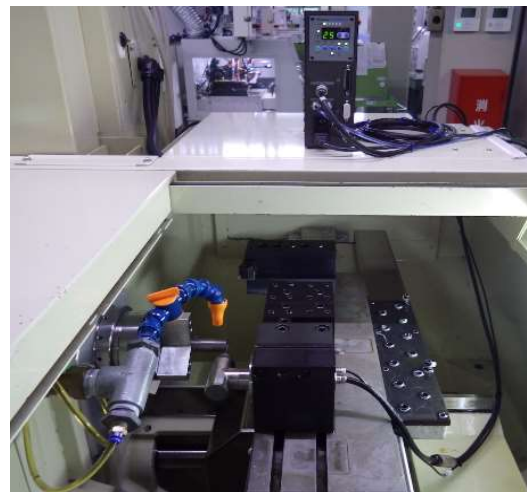
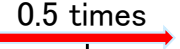
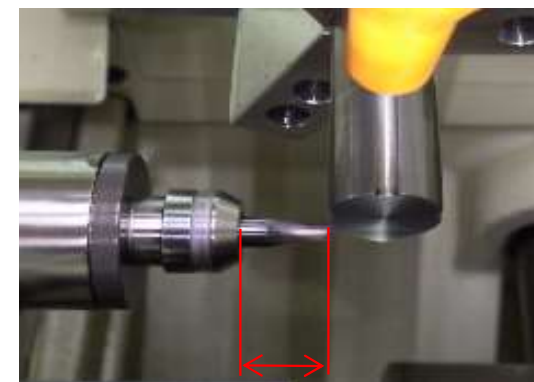


EMA-3020K ϕ 5.0mm End mill Application (S45C)

Motor Spindle EMA-3020K/E3000
Machine Washino G07
Tools NS TOOL ϕ 5.0 MUGEN-COATING 2-Flute LEAD25 End mill MX225 ϕ 5.0
Work Carbon steel (S45C) ϕ 20
Cutting Groove cutting
Coolant Non-water-soluble cutting oil
Cutting Condition



	NS TOOL	NAKANISHI
Cutting Speed[m/min]	50-80	262
Spindle Speed[min^{-1}]	4,100	16,700
Feed [mm/min]	330	160
	0.5 times 	
Feed Rate [mm/tooth]	0.04	0.05
Depth of cut $A_p \times A_e$ [mm]	5×1	1×5
E3000 Controller load meter	—	2 load meter lighting (Continuous duty operation)

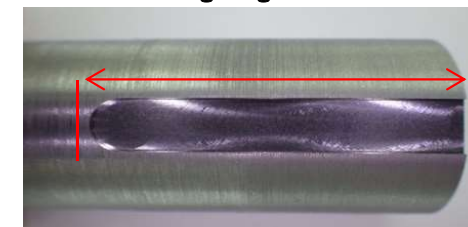


Overhang : 15mm

Processing length 30mm



Wear status at the
cutting edge



Groove processing by
 ϕ 5 end mill