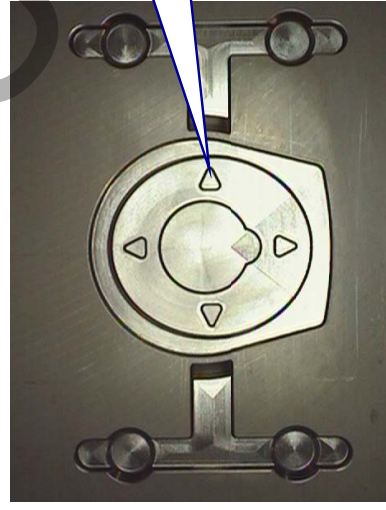


Milling Example: Direct milling SKD11(HRC59)



△ポタン部4点高さ精度 : ±2.0μm
 〃
 上面粗度 : Ry1.0μm

Work size : 40 × 60 × 30 (mm)

◎Machine
 Roku-Roku Industry
 MEGAⅢ - 400
 ◎Holder
 MST corporation
 Shrinkage fit Holder
 ◎Coolant
 Semi-Dry
 ◎Milling Hours
 3h 2min

With New **HARD MAX Coating Series** HLB

Tool	Speed (min-1)	Feed (mm/mm)	Milling Amount Rd	Milling Amount Ad	Cups Height (mm)	Procedure
HLB R1 x 4	25,000	1,500	0.2	0.1	0.03	Roughing offset
HLB R0.5 x 3	25,000	1,000	0.1	0.05	0.03	Semi-Roughing cutting rest
HLB R0.3 x 3	36,000	500	0.02	0.02	0	Semi-Roughing(Center) 3D offset
HLB R0.3 x 3	36,000	500	0.05	0.05	0	Finishing (R&L) Scan Line +offset
HLB R0.2 x 3	36,000	300	0.02	0.02	0	Finishing (Center) cutting rest

