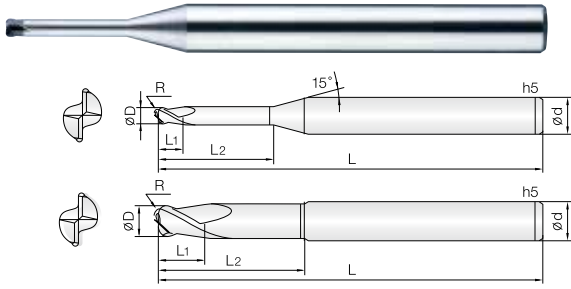


2CCBN CBN, 2 Flutes High Speed Rib Corner Radius End Mills

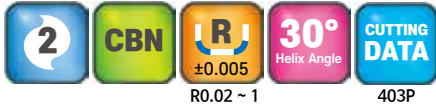
2날 CBN 고속가공용 리브 코너 레디우스 엔드밀



- 고정도강(HRc50~72)의 고정밀(±5μm) 정삭 가공용 엔드밀
- 고품량의 PCBN 소재를 적용하여 장시간 가공이 가능합니다.
- 날부인선의 조도가 뛰어나 경면가공에 적합 합니다.
- 다양한 유효장을 적용함으로써 최상의 작업이 가능합니다.
- 오일미스트 사용을 권장하며, RPM 2만~5만 범위의 고속가공을 추천합니다.
- C.B.N (Cubic Boron Nitride)

• PCBN Endmills for precise finishing (±5μm) of hardened steel (HRc50~72)

- Long tool life by high content PCBN.
- Excellent surface finish.
- Various flute length for optimum performance.
- Recommend high speed (20,000~50,000RPM) with oil-mist.
- C.B.N (Cubic Boron Nitride)



R0.02 ~ 1

403P

D Size	D Tolerance
ø0.2 ~ 6	+0 -0.01mm

단위 : mm

Order Number	날경 D × R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Shank Dia d	비고	Order Number	날경 D × R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Shank Dia d	비고
2CCBN 002 0002 002	0.2 X R0.02	0.2	-	48	4		2CCBN 008 002 060	0.8 X R0.2	0.6	6	48	4	
2CCBN 002 0002 004	0.2 X R0.02	0.4	-	48	4		2CCBN 010 0002 007	1 X R0.02	0.7	-	48	4	
2CCBN 002 0005 002	0.2 X R0.05	0.2	-	48	4		2CCBN 010 0002 015	1 X R0.02	0.7	1.5	48	4	
2CCBN 002 0005 004	0.2 X R0.05	0.4	-	48	4		2CCBN 010 0002 025	1 X R0.02	0.7	2.5	48	4	
2CCBN 003 0002 003	0.3 X R0.02	0.3	-	48	4		2CCBN 010 0002 040	1 X R0.02	0.7	4	48	4	
2CCBN 003 0002 005	0.3 X R0.02	0.5	-	48	4		2CCBN 010 0002 060	1 X R0.02	0.7	6	48	4	
2CCBN 003 0005 003	0.3 X R0.05	0.3	-	48	4		2CCBN 010 0002 080	1 X R0.02	0.7	8	48	4	
2CCBN 003 0005 005	0.3 X R0.05	0.5	-	48	4		2CCBN 010 0002 100	1 X R0.02	0.7	10	48	4	
2CCBN 004 0002 003	0.4 X R0.02	0.3	-	48	4		2CCBN 010 0005 007	1 X R0.05	0.7	-	48	4	
2CCBN 004 0002 015	0.4 X R0.02	0.3	1.5	48	4		2CCBN 010 0005 015	1 X R0.05	0.7	1.5	48	4	
2CCBN 004 0002 020	0.4 X R0.02	0.3	2	48	4		2CCBN 010 0005 025	1 X R0.05	0.7	2.5	48	4	
2CCBN 004 0005 003	0.4 X R0.05	0.3	-	48	4		2CCBN 010 0005 040	1 X R0.05	0.7	4	48	4	
2CCBN 004 0005 015	0.4 X R0.05	0.3	1.5	48	4		2CCBN 010 0005 060	1 X R0.05	0.7	6	48	4	
2CCBN 004 0005 020	0.4 X R0.05	0.3	2	48	4		2CCBN 010 0005 080	1 X R0.05	0.7	8	48	4	
2CCBN 004 001 003	0.4 X R0.1	0.3	-	48	4		2CCBN 010 0005 100	1 X R0.05	0.7	10	48	4	
2CCBN 004 001 015	0.4 X R0.1	0.3	1.5	48	4		2CCBN 010 001 007	1 X R0.1	0.7	-	48	4	
2CCBN 004 001 020	0.4 X R0.1	0.3	2	48	4		2CCBN 010 001 015	1 X R0.1	0.7	1.5	48	4	
2CCBN 005 0005 004	0.5 X R0.05	0.4	-	48	4		2CCBN 010 001 025	1 X R0.1	0.7	2.5	48	4	
2CCBN 005 0005 015	0.5 X R0.05	0.4	1.5	48	4		2CCBN 010 001 040	1 X R0.1	0.7	4	48	4	
2CCBN 005 0005 020	0.5 X R0.05	0.4	2	48	4		2CCBN 010 001 060	1 X R0.1	0.7	6	48	4	
2CCBN 005 0005 030	0.5 X R0.05	0.4	3	48	4		2CCBN 010 001 080	1 X R0.1	0.7	8	48	4	
2CCBN 005 0005 040	0.5 X R0.05	0.4	4	48	4		2CCBN 010 001 100	1 X R0.1	0.7	10	48	4	
2CCBN 005 0005 050	0.5 X R0.05	0.4	5	48	4		2CCBN 010 002 007	1 X R0.2	0.7	-	48	4	
2CCBN 005 001 004	0.5 X R0.1	0.4	-	48	4		2CCBN 010 002 015	1 X R0.2	0.7	1.5	48	4	
2CCBN 005 001 015	0.5 X R0.1	0.4	1.5	48	4		2CCBN 010 002 025	1 X R0.2	0.7	2.5	48	4	
2CCBN 005 001 020	0.5 X R0.1	0.4	2	48	4		2CCBN 010 002 040	1 X R0.2	0.7	4	48	4	
2CCBN 005 001 030	0.5 X R0.1	0.4	3	48	4		2CCBN 010 002 060	1 X R0.2	0.7	6	48	4	
2CCBN 005 001 040	0.5 X R0.1	0.4	4	48	4		2CCBN 010 002 080	1 X R0.2	0.7	8	48	4	
2CCBN 005 001 050	0.5 X R0.1	0.4	5	48	4		2CCBN 010 002 100	1 X R0.2	0.7	10	48	4	
2CCBN 006 0005 005	0.6 X R0.05	0.5	-	48	4		2CCBN 010 003 007	1 X R0.3	0.7	-	48	4	
2CCBN 006 0005 020	0.6 X R0.05	0.5	2	48	4		2CCBN 010 003 015	1 X R0.3	0.7	1.5	48	4	
2CCBN 006 0005 030	0.6 X R0.05	0.5	3	48	4		2CCBN 010 003 025	1 X R0.3	0.7	2.5	48	4	
2CCBN 006 0005 040	0.6 X R0.05	0.5	4	48	4		2CCBN 010 003 040	1 X R0.3	0.7	4	48	4	
2CCBN 006 0005 060	0.6 X R0.05	0.5	6	48	4		2CCBN 010 003 060	1 X R0.3	0.7	6	48	4	
2CCBN 006 001 005	0.6 X R0.1	0.5	-	48	4		2CCBN 010 003 080	1 X R0.3	0.7	8	48	4	
2CCBN 006 001 020	0.6 X R0.1	0.5	2	48	4		2CCBN 010 003 100	1 X R0.3	0.7	10	48	4	
2CCBN 006 001 030	0.6 X R0.1	0.5	3	48	4		2CCBN 012 001 007	1.2 X R0.1	0.7	-	48	4	
2CCBN 006 001 040	0.6 X R0.1	0.5	4	48	4		2CCBN 012 001 015	1.2 X R0.1	0.7	1.5	48	4	
2CCBN 006 001 060	0.6 X R0.1	0.5	6	48	4		2CCBN 012 001 030	1.2 X R0.1	0.7	3	48	4	
2CCBN 007 001 005	0.7 X R0.1	0.5	-	48	4		2CCBN 012 001 040	1.2 X R0.1	0.7	4	48	4	
2CCBN 007 001 025	0.7 X R0.1	0.5	2.5	48	4		2CCBN 012 001 060	1.2 X R0.1	0.7	6	48	4	
2CCBN 007 001 040	0.7 X R0.1	0.5	4	48	4		2CCBN 012 001 080	1.2 X R0.1	0.7	8	48	4	
2CCBN 007 001 060	0.7 X R0.1	0.5	6	48	4		2CCBN 012 001 100	1.2 X R0.1	0.7	10	48	4	
2CCBN 008 001 006	0.8 X R0.1	0.6	-	48	4		2CCBN 012 002 007	1.2 X R0.2	0.7	-	48	4	
2CCBN 008 001 025	0.8 X R0.1	0.6	2.5	48	4		2CCBN 012 002 015	1.2 X R0.2	0.7	1.5	48	4	
2CCBN 008 001 040	0.8 X R0.1	0.6	4	48	4		2CCBN 012 002 030	1.2 X R0.2	0.7	3	48	4	
2CCBN 008 001 060	0.8 X R0.1	0.6	6	48	4		2CCBN 012 002 040	1.2 X R0.2	0.7	4	48	4	
2CCBN 008 002 006	0.8 X R0.2	0.6	-	48	4		2CCBN 012 002 060	1.2 X R0.2	0.7	6	48	4	
2CCBN 008 002 025	0.8 X R0.2	0.6	2.5	48	4		2CCBN 012 002 080	1.2 X R0.2	0.7	8	48	4	
2CCBN 008 002 040	0.8 X R0.2	0.6	4	48	4		2CCBN 012 002 100	1.2 X R0.2	0.7	10	48	4	

단위 : mm

Order Number	날경 D×R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Dia d	비고	Order Number	날경 D×R	날장 Length of cut L1	유효장 Effective Length L2	전장 Overall Length L	샙크 Dia d	비고
2CCBN 012 003 007	1.2 X R0.3	0.7	-	48	4		2CCBN 020 002 080	2 X R0.2	0.9	8	50	4	
2CCBN 012 003 015	1.2 X R0.3	0.7	1.5	48	4		2CCBN 020 002 100	2 X R0.2	0.9	10	50	4	
2CCBN 012 003 030	1.2 X R0.3	0.7	3	48	4		2CCBN 020 003 009	2 X R0.3	0.9	-	50	4	
2CCBN 012 003 040	1.2 X R0.3	0.7	4	48	4		2CCBN 020 003 020	2 X R0.3	0.9	2	50	4	
2CCBN 012 003 060	1.2 X R0.3	0.7	6	48	4		2CCBN 020 003 030	2 X R0.3	0.9	3	50	4	
2CCBN 012 003 080	1.2 X R0.3	0.7	8	48	4		2CCBN 020 003 060	2 X R0.3	0.9	6	50	4	
2CCBN 012 003 100	1.2 X R0.3	0.7	10	48	4		2CCBN 020 003 080	2 X R0.3	0.9	8	50	4	
2CCBN 015 0002 008	1.5 X R0.02	0.8	-	48	4		2CCBN 020 003 100	2 X R0.3	0.9	10	50	4	
2CCBN 015 0002 015	1.5 X R0.02	0.8	1.5	48	4		2CCBN 020 005 009	2 X R0.5	0.9	-	50	4	
2CCBN 015 0002 030	1.5 X R0.02	0.8	3	48	4		2CCBN 020 005 020	2 X R0.5	0.9	2	50	4	
2CCBN 015 0002 040	1.5 X R0.02	0.8	4	48	4		2CCBN 020 005 030	2 X R0.5	0.9	3	50	4	
2CCBN 015 0002 060	1.5 X R0.02	0.8	6	48	4		2CCBN 020 005 060	2 X R0.5	0.9	6	50	4	
2CCBN 015 0002 080	1.5 X R0.02	0.8	8	48	4		2CCBN 020 005 080	2 X R0.5	0.9	8	50	4	
2CCBN 015 0002 100	1.5 X R0.02	0.8	10	48	4		2CCBN 020 005 100	2 X R0.5	0.9	10	50	4	
2CCBN 015 0005 008	1.5 X R0.05	0.8	-	48	4		2CCBN 025 001 012	2.5 X R0.1	1.2	-	66	6	
2CCBN 015 0005 015	1.5 X R0.05	0.8	1.5	48	4		2CCBN 025 001 030	2.5 X R0.1	1.2	3	66	6	
2CCBN 015 0005 030	1.5 X R0.05	0.8	3	48	4		2CCBN 025 001 060	2.5 X R0.1	1.2	6	66	6	
2CCBN 015 0005 040	1.5 X R0.05	0.8	4	48	4		2CCBN 025 001 100	2.5 X R0.1	1.2	10	66	6	
2CCBN 015 0005 060	1.5 X R0.05	0.8	6	48	4		2CCBN 025 002 012	2.5 X R0.2	1.2	-	66	6	
2CCBN 015 0005 080	1.5 X R0.05	0.8	8	48	4		2CCBN 025 002 030	2.5 X R0.2	1.2	3	66	6	
2CCBN 015 0005 100	1.5 X R0.05	0.8	10	48	4		2CCBN 025 002 060	2.5 X R0.2	1.2	6	66	6	
2CCBN 015 001 008	1.5 X R0.1	0.8	-	48	4		2CCBN 025 002 100	2.5 X R0.2	1.2	10	66	6	
2CCBN 015 001 015	1.5 X R0.1	0.8	1.5	48	4		2CCBN 025 003 012	2.5 X R0.3	1.2	-	66	6	
2CCBN 015 001 030	1.5 X R0.1	0.8	3	48	4		2CCBN 025 003 030	2.5 X R0.3	1.2	3	66	6	
2CCBN 015 001 040	1.5 X R0.1	0.8	4	48	4		2CCBN 025 003 060	2.5 X R0.3	1.2	6	66	6	
2CCBN 015 001 060	1.5 X R0.1	0.8	6	48	4		2CCBN 025 003 100	2.5 X R0.3	1.2	10	66	6	
2CCBN 015 001 080	1.5 X R0.1	0.8	8	48	4		2CCBN 030 001 012	3 X R0.1	1.2	-	66	6	
2CCBN 015 001 100	1.5 X R0.1	0.8	10	48	4		2CCBN 030 001 030	3 X R0.1	1.2	3	66	6	
2CCBN 015 002 008	1.5 X R0.2	0.8	-	48	4		2CCBN 030 001 060	3 X R0.1	1.2	6	66	6	
2CCBN 015 002 015	1.5 X R0.2	0.8	1.5	48	4		2CCBN 030 001 100	3 X R0.1	1.2	10	66	6	
2CCBN 015 002 030	1.5 X R0.2	0.8	3	48	4		2CCBN 030 001 160	3 X R0.1	1.2	16	66	6	
2CCBN 015 002 040	1.5 X R0.2	0.8	4	48	4		2CCBN 030 001 200	3 X R0.1	1.2	20	66	6	
2CCBN 015 002 060	1.5 X R0.2	0.8	6	48	4		2CCBN 030 002 012	3 X R0.2	1.2	-	66	6	
2CCBN 015 002 080	1.5 X R0.2	0.8	8	48	4		2CCBN 030 002 030	3 X R0.2	1.2	3	66	6	
2CCBN 015 002 100	1.5 X R0.2	0.8	10	48	4		2CCBN 030 002 060	3 X R0.2	1.2	6	66	6	
2CCBN 015 003 008	1.5 X R0.3	0.8	-	48	4		2CCBN 030 002 100	3 X R0.2	1.2	10	66	6	
2CCBN 015 003 015	1.5 X R0.3	0.8	1.5	48	4		2CCBN 030 002 160	3 X R0.2	1.2	16	66	6	
2CCBN 015 003 030	1.5 X R0.3	0.8	3	48	4		2CCBN 030 002 200	3 X R0.2	1.2	20	66	6	
2CCBN 015 003 040	1.5 X R0.3	0.8	4	48	4		2CCBN 030 003 012	3 X R0.3	1.2	-	66	6	
2CCBN 015 003 060	1.5 X R0.3	0.8	6	48	4		2CCBN 030 003 030	3 X R0.3	1.2	3	66	6	
2CCBN 015 003 080	1.5 X R0.3	0.8	8	48	4		2CCBN 030 003 060	3 X R0.3	1.2	6	66	6	
2CCBN 015 003 100	1.5 X R0.3	0.8	10	48	4		2CCBN 030 003 100	3 X R0.3	1.2	10	66	6	
2CCBN 020 0002 009	2 X R0.02	0.9	-	50	4		2CCBN 030 003 160	3 X R0.3	1.2	16	66	6	
2CCBN 020 0002 020	2 X R0.02	0.9	2	50	4		2CCBN 030 003 200	3 X R0.3	1.2	20	66	6	
2CCBN 020 0002 030	2 X R0.02	0.9	3	50	4		2CCBN 030 005 012	3 X R0.5	1.2	-	66	6	
2CCBN 020 0002 060	2 X R0.02	0.9	6	50	4		2CCBN 030 005 030	3 X R0.5	1.2	3	66	6	
2CCBN 020 0002 080	2 X R0.02	0.9	8	50	4		2CCBN 030 005 060	3 X R0.5	1.2	6	66	6	
2CCBN 020 0002 100	2 X R0.02	0.9	10	50	4		2CCBN 030 005 100	3 X R0.5	1.2	10	66	6	
2CCBN 020 0005 009	2 X R0.05	0.9	-	50	4		2CCBN 030 005 160	3 X R0.5	1.2	16	66	6	
2CCBN 020 0005 020	2 X R0.05	0.9	2	50	4		2CCBN 030 005 200	3 X R0.5	1.2	20	66	6	
2CCBN 020 0005 030	2 X R0.05	0.9	3	50	4		2CCBN 030 010 012	3 X R1	1.2	-	66	6	
2CCBN 020 0005 060	2 X R0.05	0.9	6	50	4		2CCBN 030 010 030	3 X R1	1.2	3	66	6	
2CCBN 020 0005 080	2 X R0.05	0.9	8	50	4		2CCBN 030 010 060	3 X R1	1.2	6	66	6	
2CCBN 020 0005 100	2 X R0.05	0.9	10	50	4		2CCBN 030 010 100	3 X R1	1.2	10	66	6	
2CCBN 020 001 009	2 X R0.1	0.9	-	50	4		2CCBN 030 010 160	3 X R1	1.2	16	66	6	
2CCBN 020 001 020	2 X R0.1	0.9	2	50	4		2CCBN 030 010 200	3 X R1	1.2	20	66	6	
2CCBN 020 001 030	2 X R0.1	0.9	3	50	4		2CCBN 040 001 015	4 X R0.1	1.5	-	66	6	
2CCBN 020 001 060	2 X R0.1	0.9	6	50	4		2CCBN 040 001 030	4 X R0.1	1.5	3	66	6	
2CCBN 020 001 080	2 X R0.1	0.9	8	50	4		2CCBN 040 001 060	4 X R0.1	1.5	6	66	6	
2CCBN 020 001 100	2 X R0.1	0.9	10	50	4		2CCBN 040 001 100	4 X R0.1	1.5	10	66	6	
2CCBN 020 002 009	2 X R0.2	0.9	-	50	4		2CCBN 040 001 160	4 X R0.1	1.5	16	66	6	
2CCBN 020 002 020	2 X R0.2	0.9	2	50	4		2CCBN 040 002 015	4 X R0.2	1.5	-	66	6	
2CCBN 020 002 030	2 X R0.2	0.9	3	50	4		2CCBN 040 002 030	4 X R0.2	1.5	3	66	6	
2CCBN 020 002 060	2 X R0.2	0.9	6	50	4		2CCBN 040 002 060	4 X R0.2	1.5	6	66	6	

피삭재 Material		합금강/프리하드강 Alloy Steels / Pre-hardened Steels NAK80 / KP4M				고경도강 Hardened Steels STAVAX / SKD11				열처리 / 고경도강 Heat-treated steels / Hardened Steels YXR7 / SKH51			
경도 Hardness		40 ~ 45HRc				45 ~ 55HRc				55 ~ 62HRc			
외경 Outside Diameter	유효장 Effective Length	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
∅ 0.4	0.3	50,000	890	0.010	0.010	50,000	520	0.005	0.006	50,000	450	0.005	0.005
"	1	50,000	730	0.010	0.010	50,000	500	0.005	0.005	50,000	430	0.005	0.005
"	2	50,000	390	0.005	0.005	50,000	250	0.003	0.003	50,000	220	0.002	0.003
∅ 0.5	0.4	50,000	990	0.010	0.020	50,000	850	0.005	0.010	50,000	770	0.005	0.010
"	1	50,000	900	0.010	0.015	50,000	590	0.005	0.010	50,000	550	0.005	0.010
"	3	50,000	630	0.010	0.015	50,000	560	0.005	0.010	50,000	530	0.005	0.010
∅ 0.8	0.6	50,000	1,610	0.020	0.020	50,000	1,320	0.015	0.015	50,000	1,140	0.010	0.010
"	2	50,000	1,520	0.020	0.020	50,000	1,230	0.010	0.010	50,000	1,120	0.010	0.010
"	4	40,000	910	0.015	0.020	40,000	740	0.010	0.010	40,000	650	0.010	0.010
"	6	30,000	460	0.015	0.015	30,000	410	0.010	0.010	30,000	290	0.005	0.005
∅ 1	0.7	50,000	1,820	0.020	0.030	50,000	1,380	0.020	0.020	50,000	1,290	0.010	0.020
"	2	40,000	1,470	0.015	0.020	40,000	1,010	0.015	0.015	40,000	910	0.010	0.010
"	4	30,000	1,080	0.015	0.015	30,000	660	0.010	0.015	30,000	630	0.010	0.010
"	8	24,000	680	0.010	0.010	24,000	460	0.005	0.010	24,000	360	0.005	0.005
∅ 1.5	0.8	40,000	1,790	0.030	0.040	40,000	1,150	0.020	0.030	40,000	1,190	0.020	0.020
"	2	30,000	1,470	0.030	0.030	30,000	1,160	0.020	0.030	30,000	930	0.020	0.020
"	4	30,000	1,190	0.030	0.030	30,000	950	0.015	0.020	30,000	810	0.010	0.015
"	8	24,000	550	0.015	0.015	24,000	430	0.010	0.015	24,000	370	0.010	0.010
∅ 2	2	40,000	1,610	0.040	0.040	40,000	1,340	0.030	0.030	40,000	1,150	0.020	0.030
"	4	30,000	1,400	0.030	0.030	30,000	1,120	0.025	0.025	30,000	960	0.020	0.020
"	8	30,000	1,190	0.030	0.030	30,000	950	0.020	0.030	30,000	810	0.010	0.010
∅ 2.5	1.2	40,000	2,317	0.050	0.050	40,000	1,850	0.040	0.040	40,000	1,580	0.030	0.040
"	4	40,000	1,620	0.030	0.040	40,000	1,300	0.030	0.030	40,000	1,210	0.020	0.030
"	10	24,000	850	0.020	0.030	24,000	680	0.010	0.030	24,000	280	0.010	0.020
∅ 3	6	40,000	1,470	0.030	0.030	40,000	1,180	0.020	0.030	40,000	1,010	0.020	0.030
"	10	21,000	1,190	0.020	0.030	21,000	950	0.020	0.020	21,000	810	0.010	0.020
"	16	16,000	770	0.020	0.030	16,000	620	0.010	0.020	16,000	530	0.010	0.010
∅ 4	6	40,000	1,510	0.030	0.040	40,000	1,180	0.030	0.030	40,000	1,100	0.020	0.030
"	10	21,000	1,140	0.020	0.030	21,000	900	0.020	0.020	21,000	780	0.010	0.020
"	16	16,000	740	0.010	0.020	16,000	590	0.010	0.020	16,000	500	0.010	0.010
∅ 6		16,000~ 50,000	740~ 3,000	0.050	0.060	13,000~ 50,000	590~ 2,000	0.050	0.060	11,000~ 50,000	390~ 1,500	0.050	0.060

절입량
Depth of Cut

• Ap : Axial Depth
• Ae : Radial Depth

- HRC68 이상 고경도강 가공 시 같은 직경의 같은 비율로 20% DOWN 시켜주십시오.
- 유효장이 긴 경우에는 회전수와 이송속도를 최대30% 이하로 줄이십시오.
- 4날 사용시 Feed 20% 증가, 절입량을 5% 감소하여 사용 하십시오.
- 측면 절삭시 코너R 부분과 각도 내용을 참고하여 절삭 하시기 바랍니다.
- 곡면 절삭시 날경의 코너R 보다 낮은 이동 PITCH를 설정 하십시오.
- 곡면 절삭시 안정적인 속도 내에서 피드를 최대 30%까지 UP 해주십시오.
- 상기 절삭조건은 참고 수치이므로 실 가공시에는가공형상, 가공 목적, 적용 기계 등에 따라 조건을 조정 하십시오.
- 절삭조건이 없는 유효장은 비슷한 유효장에 비례하여 사용 하십시오.
- 길이가 긴 엔드밀의 경우 떨림, 이상음이 발생할 경우에는 상기표의 회전속도와 이송속도를 같은 비율로 내려서 사용해 주십시오.
- In case machining Hardened steel HRC upper 68, reduce 20% of cutting parameter on the table.
- In case of long effective length, reduce the RPM and feed by 30% or less.
- For using 4 flutes, reduce the feed by 20% and the depth of cut by 5%.
- For side milling, refer to the corner R section and the angle.
- For curved milling, set up a pitch below than corner radius of the tool diameter.
- For curved milling, raise the feed upto 30% at a stable speed.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If there is no effective length of your endmill on the table, use a similar type of effective length and apply the same proportion.
- In case of long length endmill shaking or abnormal sound, lower the rotation speed and feed speed of the table above by the same ratio.