

Mold industry



HM series ball end milling cutter

Application

Machine type:DMG

Tool type:D10R5

Workpiece mat:SKD11

Workpiece hardness:HRC56-HRC60

Chuck:BT40- Shrink chuck

Coolant type:Emulsion

Spindle speed:2000 r/min

Feed rate:150mm/min

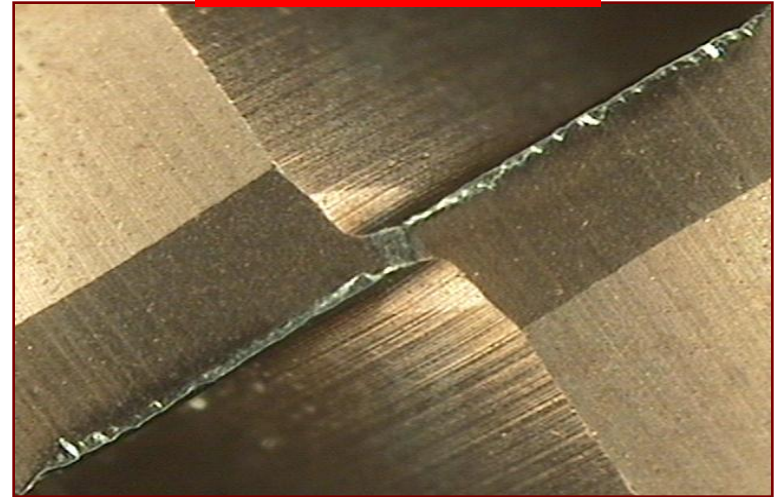


Processing contrast case:

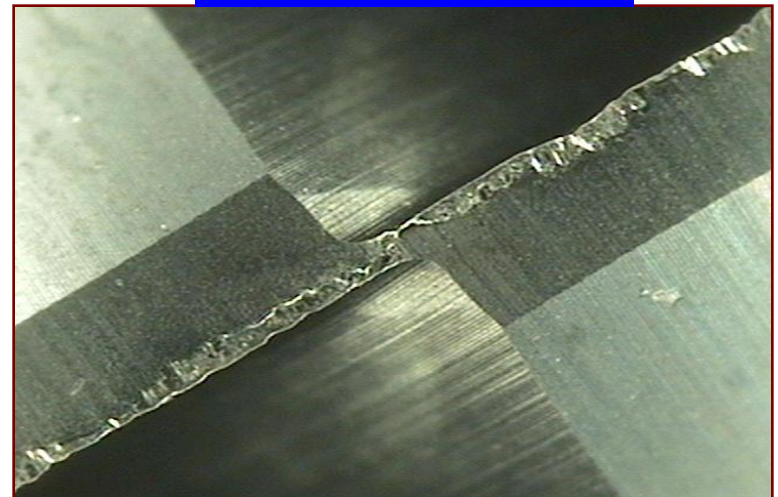
RA processing 8PCS, the tool has no obvious wear and tear, Ra1.6, can continue to process

OSK machining 20PCS, the tool R corner and the bottom edge of the obvious wear, Ra>3.2, but the side edge intact, stop processing

OSK



RA



KHM series round nose milling cutter

Application

Machine type:HASS

Tool type:D10R0.5

Workpiece mat:SKD11

Workpiece hardness:HRC60

Chuck:BT40- Shrink chuck

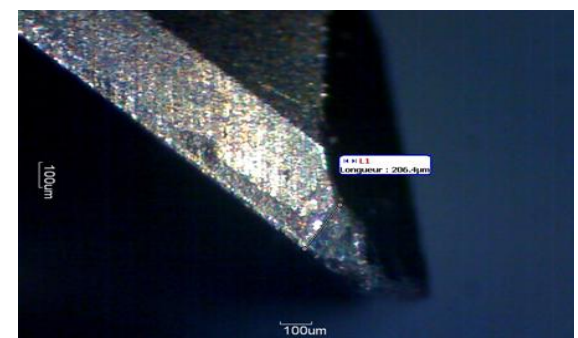
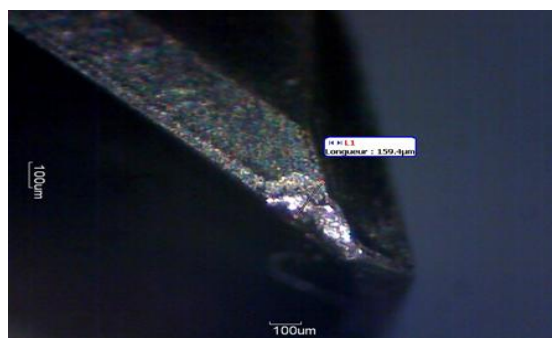
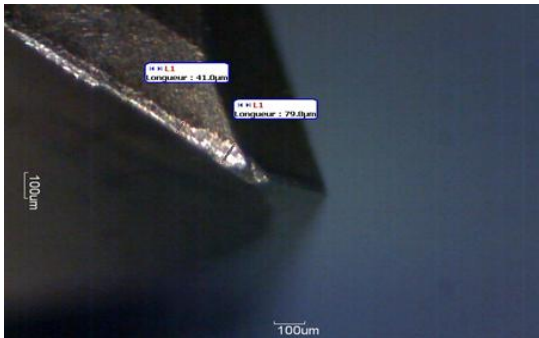
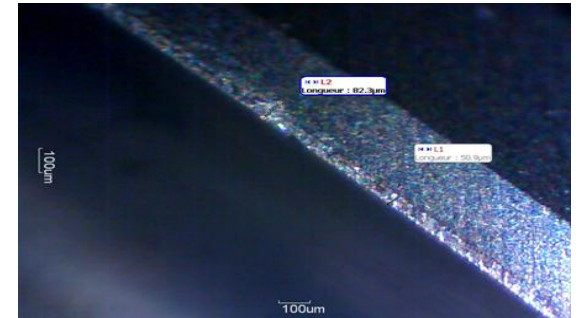
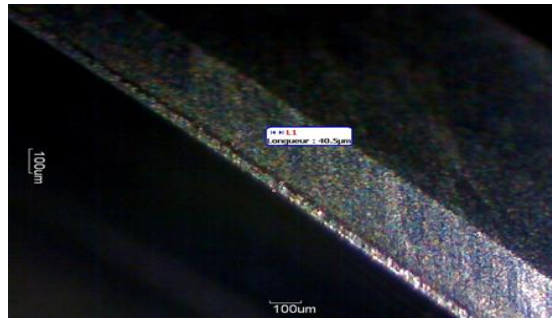
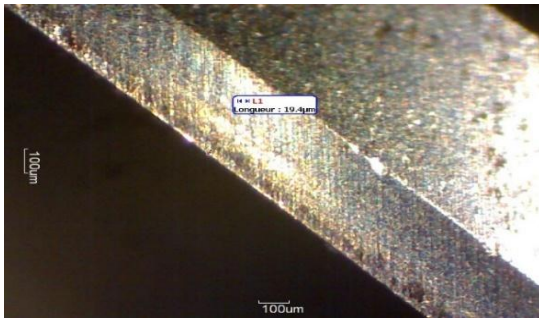
Coolant type:Emulsion

Spindle speed:2000 r/min

Feed rate:200mm/min



Processing result: After processing 5H, tool condition contrast



OSK

VA

NA

The End

Thank You Very Much