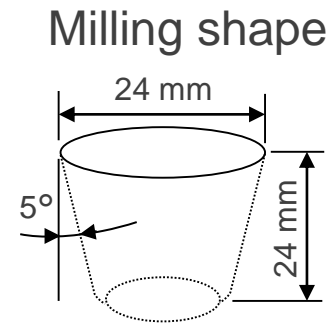


HSB Pocket milling example

Tool : **HSB 2060-0900** (R3 x 9)
Work material : S50C (Annealed)
Coolant : Air blow

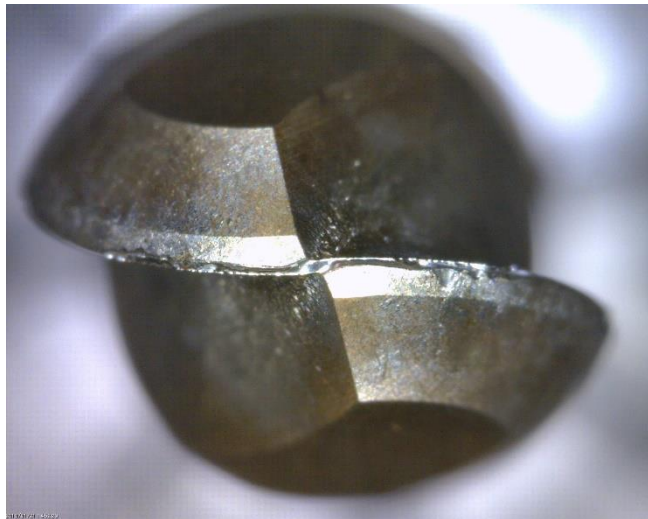
Milling condition

Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	a _p (mm)	a _e (mm)	Cycle Time
13,000	3,500	0.6	1.8	3min / pocket



X 100 pockets

Tool after 100 pockets (5 hours)



S50C(annealed) was milled for about 5 hours under the conditions of HSB hardened steel (~ 55HRC).

- ◆ The tool was worn, but it's still available for the roughing process.
- ◆ HSB has a design for high hardness, but it can be used for roughing of soft steels.