

CZS Titanium circular pocket milling example

Tool : **CZS 4050-1300** ($\phi 5 \times 13$)

Work material : Ti-6Al-4V

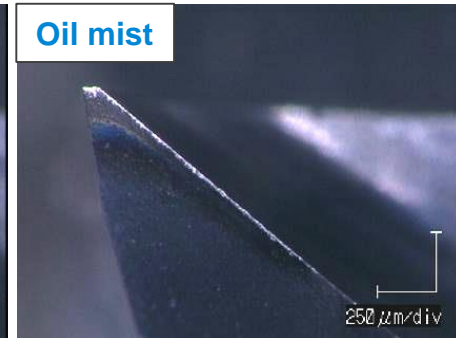
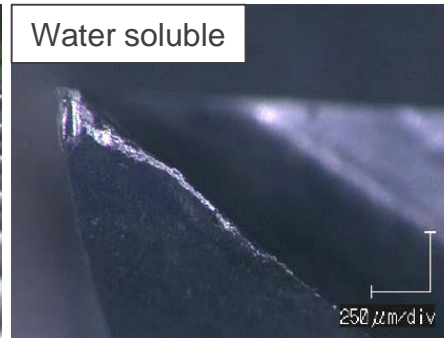
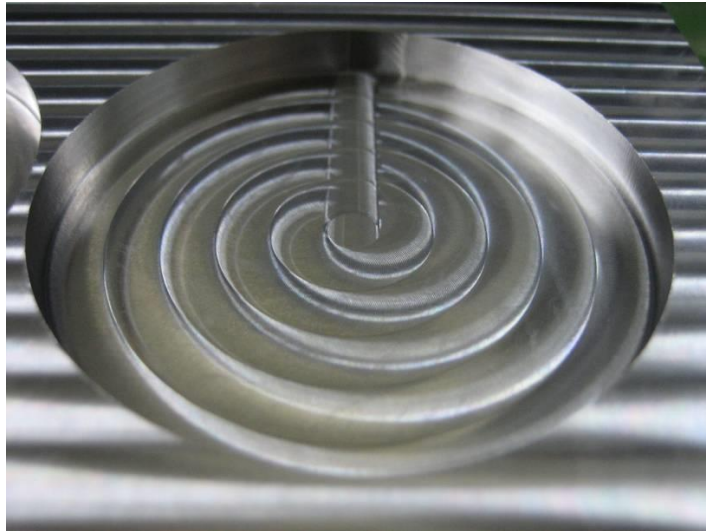
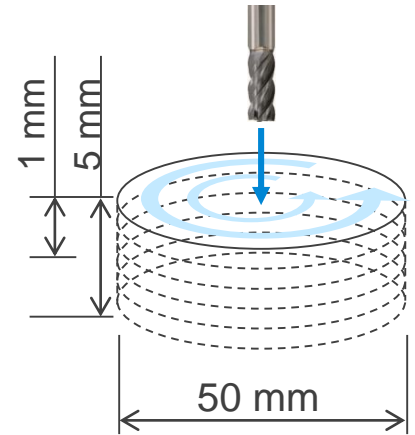
Pocket size : $\phi 50 \times$ Depth 5 mm

Coolant : Water soluble / Oil mist

Milling condition

Spindle Speed (min^{-1})	Z-Feed Rate (mm/min)	XY-Feed Rate (mm/min)	a_p (mm)	a_e (mm)	Cycle Time
2,600	40	400	1	4.5	7 min

a_p
1 mm x 5 times



When using oil mist, the tool wear become smaller than water soluble.