

HGLRS Pocket shape milling example

Tool : HGLRS $\phi 3$ x CR0.3 x EL16
Comp. (Same size)

Material : HAP72 (69HRC)

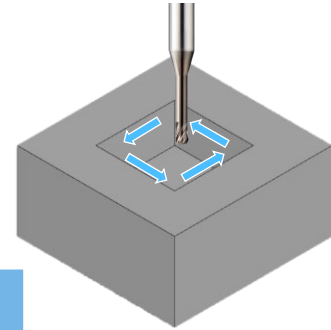
Milling size : 10 x 10 x 5 mm

Coolant : Air blow

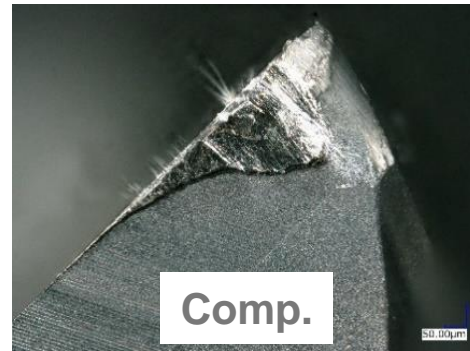
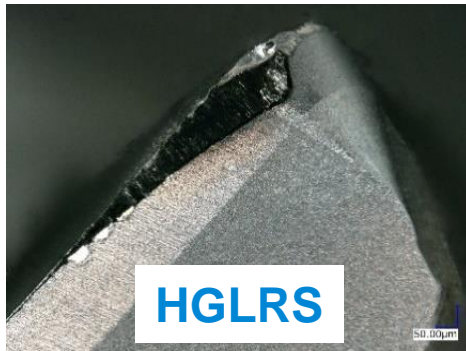
Cycle time : 68 min

~ Milling condition ~

Spindle Speed (min^{-1})	Feed Rate (mm/min)	a_p (mm)	a_e (mm)
7,000	900	0.03	0.6



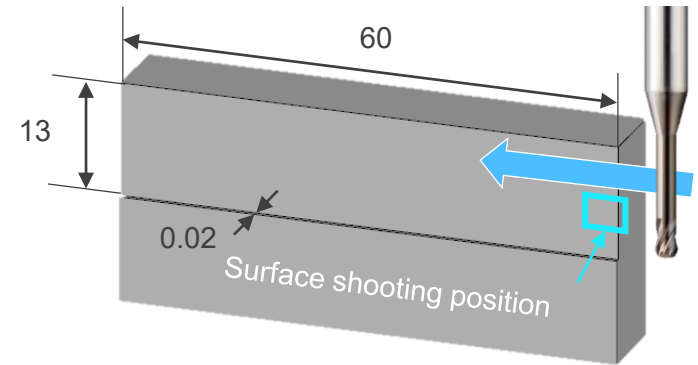
~ Tool after process ~



HGLRS offers high efficiency and long tool life even for next generation ultra hard materials

HGLRS Side wall milling example

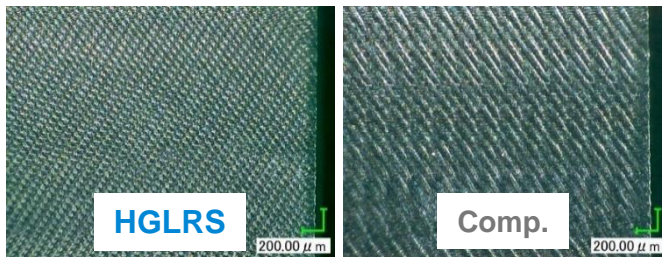
Tool : HGLRS $\phi 3$ x CR0.3 x EL16
 Material : HAP72 (69HRC)
 Milling size : 60 x 0.02 x 13 mm
 Coolant : Air blow
 Cycle Time : 15 min



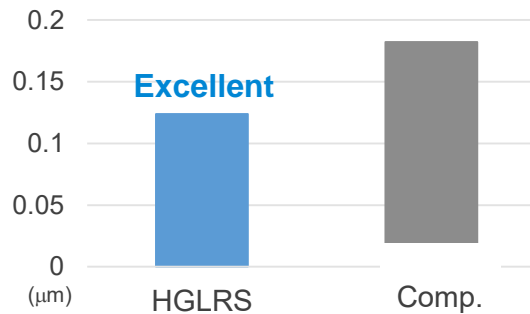
~ Milling condition ~

Spindle Speed (min^{-1})	Feed Rate (mm/min)	a_p (mm)	a_e (mm)
7,000	1,800	0.03	0.02

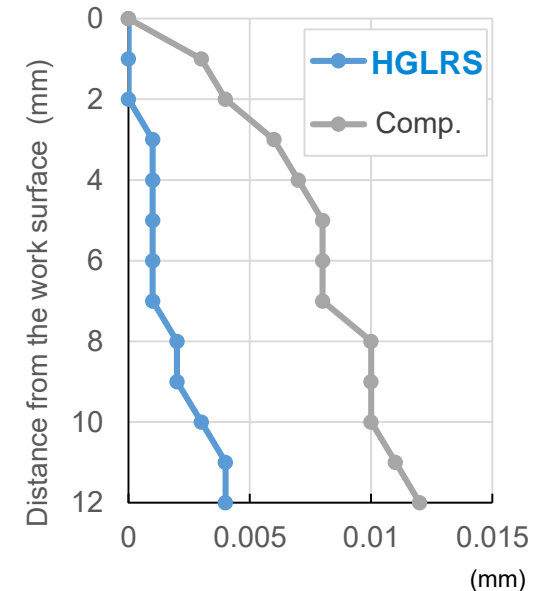
~ Surface condition after milling ~



Surface roughness after milling (Ra)



Deflection of the wall after milling



Smaller dimensional change and better milling accuracy with HGLRS series