CZS Slit milling example
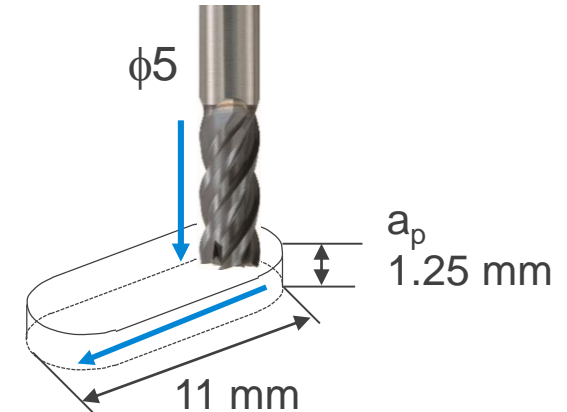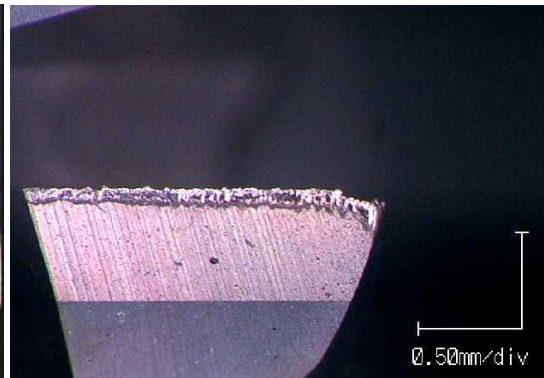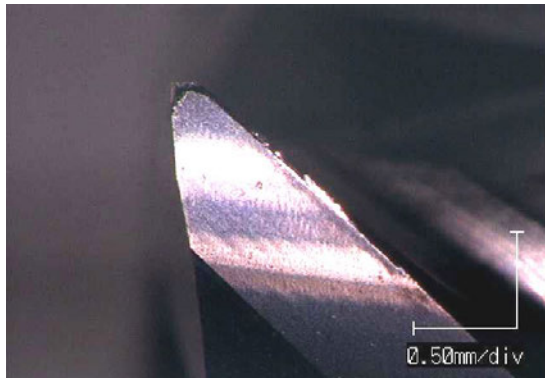
Tool   : **CZS 4050-1300** (ϕ5 x 13)
Work material : SKD11 (60HRC)
Slit size   : Width 6 x Length 11 x Depth 1.25 mm
No. of slit   : 133 slits
Coolant   : Air blow

ϕ5

a_p
1.25 mm

11 mm

Milling condition

Spindle Speed (min^{-1})	Z-Feed Rate (mm/min)	XY-Feed Rate (mm/min)	a_p (mm)	Cycle Time
1,500	30	100	1.25	19 min

〜Tool wear〜

0.50mm/div

0.50mm/div

The tool corner was damaged, because this tool is not designed
for high hardness materials, so this process is difficult.

UNION TOOL CO.