

CZS Circular pocket milling example

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

Work material : Raw SKD11 (16HRC)

Pocket size : $\phi 20 \times$ Depth 10 mm

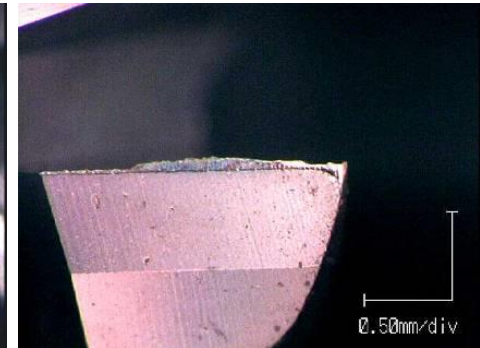
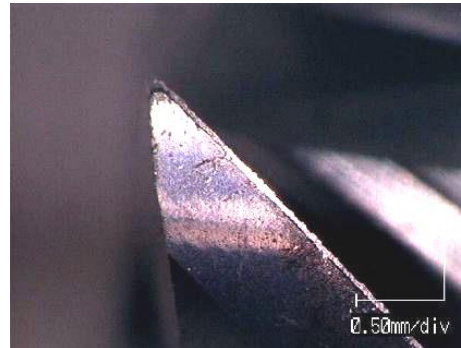
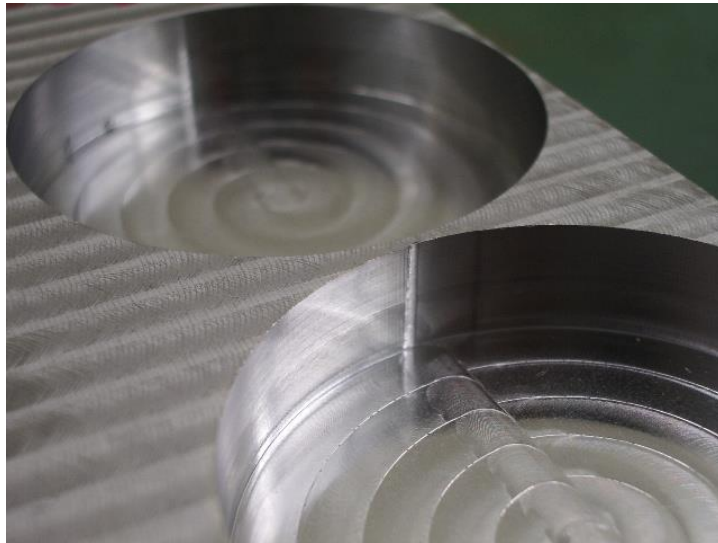
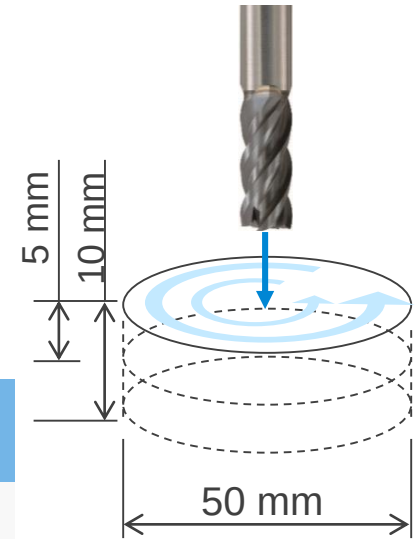
No. of pocket : 2 pockets

Coolant : Air blow

a_p
5 mm x 2 times

Milling condition

Spindle Speed (min^{-1})	Z-Feed Rate (mm/min)	XY-Feed Rate (mm/min)	a_p (mm)	a_e (mm)	Cycle Time
4,800	110	500	5	4.5	4.9 min



**After 2 circular pockets milling,
The tool was still available !**