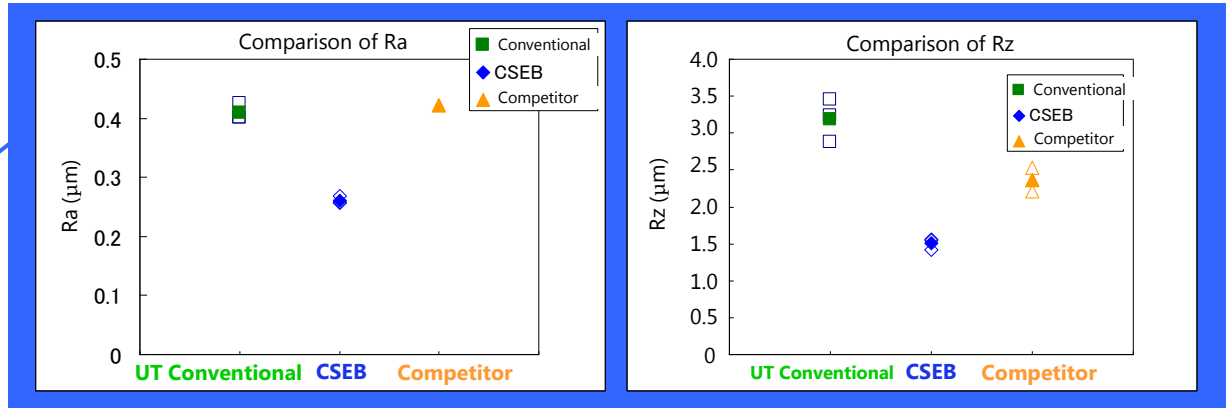
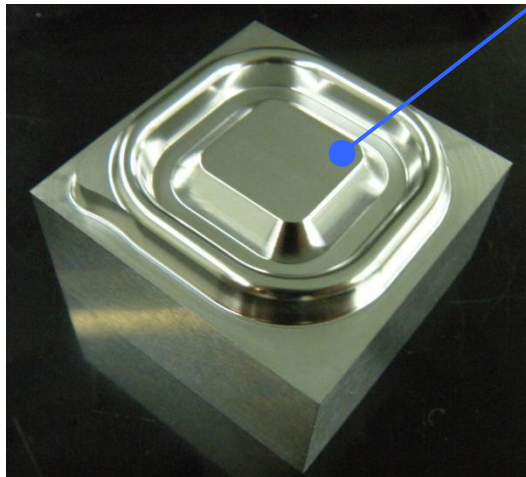


# CSEB HPM38 Plastic Mold Milling

**UTCOAT**  
for low hardness material

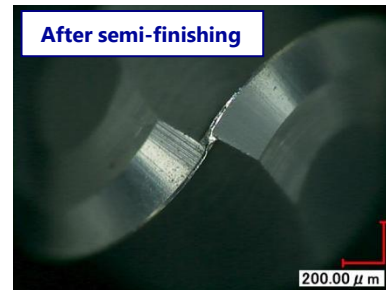
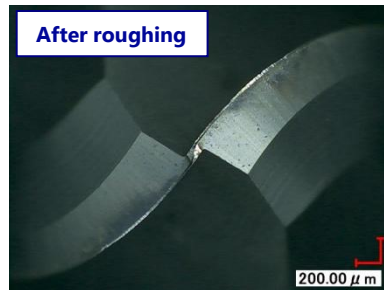
Work material : HPM38 (53HRC)  
Work size : 50 x 50 x 30mm



CSEB φ4 (R2) x LOC 6

CSEB φ2 (R1) x LOC 3

CSEB φ1 (R0.5) x LOC 1.5



No.	Process	Tool geometry	Series / Size	Spindle Speed (min <sup>-1</sup> )	Feed Rate (mm/min)	a <sub>p</sub> (mm)	a <sub>e</sub> (mm)	Overhang length (mm)	Milling time	Coolant
1	Roughing	2-flute ball	CSEB R2 x 6	11,000	2000	0.34	1	15	0:31:21	Air blow
2	Semi-finishing	2-flute ball	CSEB R1 x 3	16,000	1300	0.17	0.5	13	0:03:10	Air blow
3	Semi-finishing	2-flute ball	CSEB R1 x 3	16,000	1300	0.1	0.1	13	0:16:47	Air blow
4	Semi-finishing	2-flute ball	CSEB R1 x 3	16,000	1300	0.01	0.1	13	0:37:00	Oil mist
5	Finishing	2-flute ball	CSEB R0.5 x 1.5	22,000	1300	0.04	0.18	12	0:05:06	Oil mist
6	Finishing	2-flute ball	CSEB R0.5 x 1.5	22,000	700	0.05	0.05	12	0:59:36	Oil mist
7	Finishing	2-flute ball	CSEB R0.5 x 1.5	22,000	700	0.01	0.05	12	0:30:43	Oil mist