

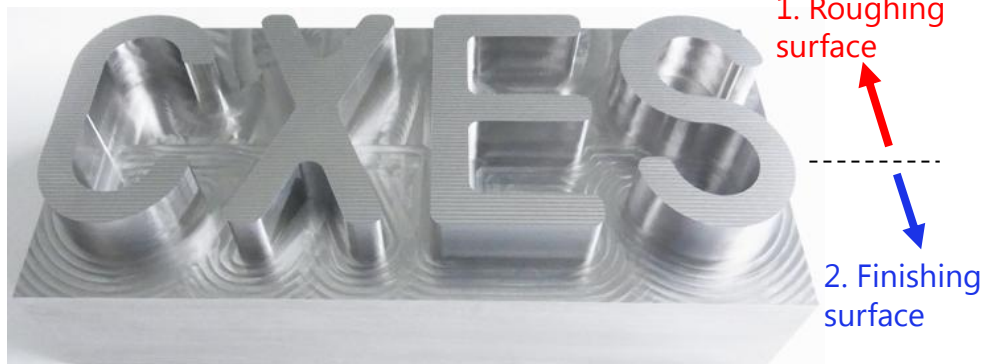
# CXES SUS304 Relief Milling



Tool: 4-flute square CXES 4060-1500 ( $\phi 6 \times 15$ ) 1 pc. each for **roughing** & **finishing**

**x 1.5 higher side milling efficiency compared to CZS!**

Work material : SUS304  
Coolant : Water-soluble (Through spindle)  
Overhang length : 20.0 mm



Process	1. Roughing	2. Finishing
Spindle Speed ( $\text{min}^{-1}$ )	4,500	4,500
Feed Rate ( $\text{mm}/\text{min}$ )	810	400
$a_p$ (mm)	15	15
$a_e$ (mm)	0.6	2.5 (Standing wall stock 0.1)
Cycle time	1:11:29	0:18:43

**Tool appearance after Roughing process**

**Axial cutting edge**

**Radial cutting edge**

Main flute

Sub flute

Main flute

Sub flute

