

# HFTNB SKD61

## Finishing of Wall & Flat Surface

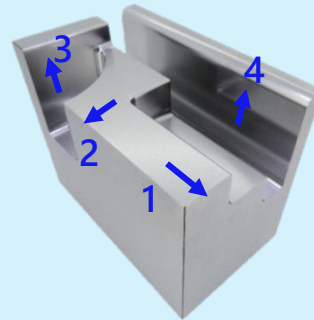


Work size: 30 x 50 x 40 mm  
Taper angle of wall: 0.5°

Tool for Finishing : **3-flute Taper Neck Ball**  
**HFTNB R1 x L20 x 0.4°**

Work material : SKD61 (48±1HRC)

Coolant : Air Blow



Measuring point	Surface roughness Ra (μm)
①	0.353
②	0.480
③	0.200
④	0.168

**Fine surface roughness!**

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)	Allowance (mm)	Cycle Time
1	Roughing	2-flute Long Neck Ball	HSLB R3 x L20	13,000	3,500	0.6	0.6	0.05	0:25:33
2	Semi-finishing	2-flute Long Neck Ball	HSLB R1.5 x L20	14,500	1,360	0.18	0.1	0.02	0:49:48
3	Finishing	<b>3-flute Taper Neck Ball</b>	<b>HFTNB R1 x L20 x 0.4°</b>	4,650	940	0.05	0.05	0	2:29:29
Total									3:44:50