

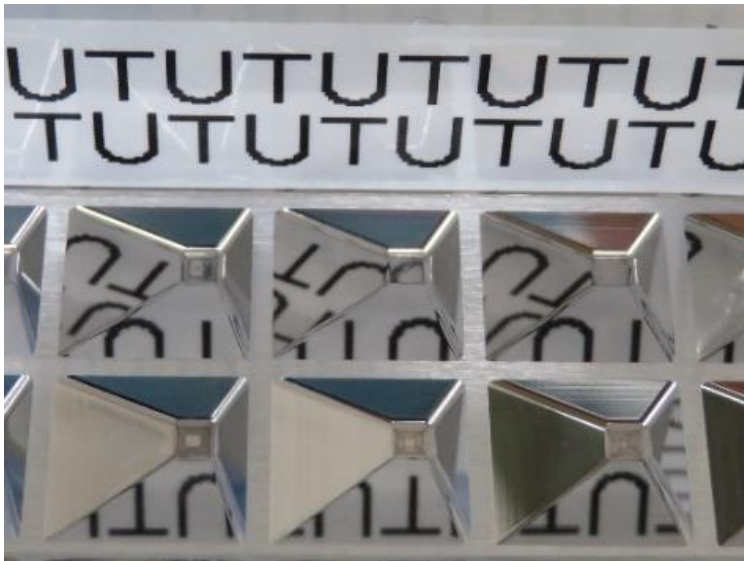
CBN-PLB Inclined surface finishing milling example

Tool : CBN-PLB R0.5 x EL2.5
Work material : ELMAX (60HRC)
Size : 9 x 9 x 1.5 mm
Coolant : Oil mist
Cycle time : 1 hour 30 min / pocket

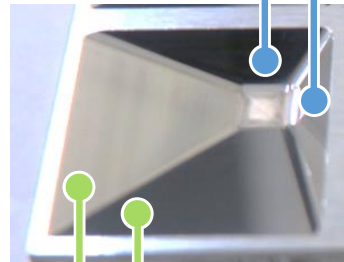
Milling condition

Spindle Speed (min ⁻¹)	Feed Rate (mm/min)	Pick feed (mm)	Allowance (mm)
30,000	375	0.005	0.003

Reflection of the surface finishing



45° inclined surface



15° inclined surface



Surface roughness Ra

0.018 μm

0.014 μm