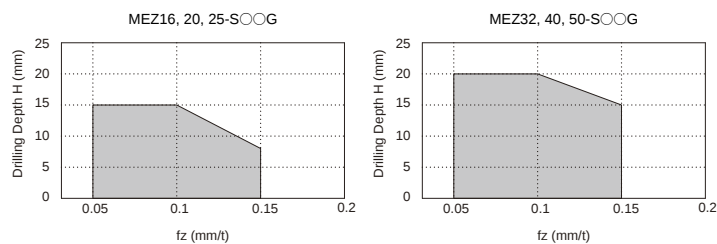
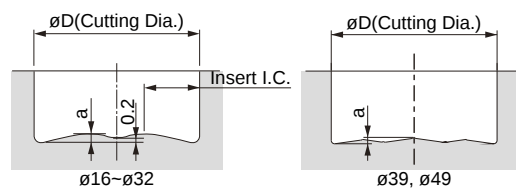


■ Drilling Depth (Standard / Long Head / Long Shank)



Shape of drilled hole (ø16~ø49)

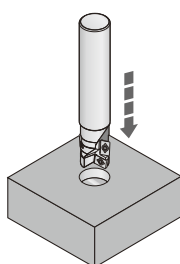


Cutting Dia.	ø16	ø20	ø25	ø32	ø39	ø49
a (mm)	0.30	0.33	0.38	0.45	0.68	0.74

◆ How to use the Silver Drill Mill (MEZ-G) and Drill Mill (MEZ) effectively

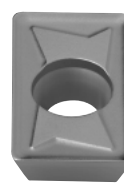
Drilling

- Step feeding is recommended for good chip control (Depth approx. 1mm).
- Drill depth should be under 0.5D. (D: Drilling Dia.)
- Use compressed air during drilling.
- PR660 is recommended for heavy drilling.



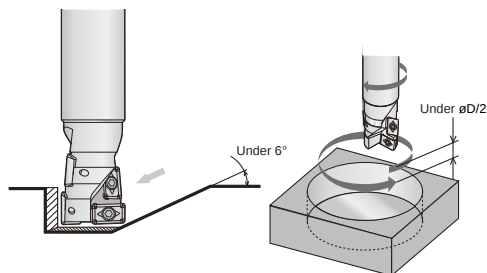
Endmilling

- Tough edge insert is recommended for high load endmilling. (High feed rate, large ap)
- Use a low cutting force insert to prevent chattering.

N(D / E)MT...ER-DH
(Tough Edge)N(D / E)MT...ER-D
(Low Cutting Force)

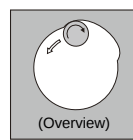
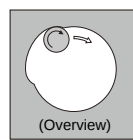
Ramping• Helical Milling

- Ramping angle is recommended to be under 6°.
- Plunge depth per revolution when helical milling should be under 1/2D. Use compressed air when drilling.
- Use compressed air during drilling.



Others

- Down-Cut milling is recommended for the improvement of tool life and surface finish.
- Compressed air is recommended.



Whitish Surface
Chattering may occur
Rapid Wear



Better Surface
Less Chattering
Longer Life



◆ Recommended Cutting Conditions

Workpiece Material	fz (mm/t)		Recommended Insert Grade (Cutting Speed Vc : m/min)											
			Cermet			PVD Coated Carbide							Carbide	
	Drilling	Shouldering Slotting	TN60	TN100M	TC60	PR630	PR730	PR830			PR660	PR905	PW30	KW10
Stainless Steel	0.05~0.12	0.05~0.15		☆ 120~200		☆ 120~200	☆ 120~200				★ 100~180			
Carbon Steel	0.05~0.2	0.05~0.2		★ 120~200		☆ 120~200	★ 120~200				☆ 100~180			
Alloy Steel	0.05~0.2	0.05~0.2		★ 100~180		☆ 100~180	★ 100~180				☆ 80~150			
Mold Steel	0.05~0.12	0.05~0.15		★ 100~180		☆ 80~150	★ 80~150				☆ 60~130			
Cast Iron	0.05~0.2	0.05~0.2										★ 100~180		☆ 80~150
Non-ferrous Metals	0.05~0.2	0.05~0.2												★ 100~300

- Drilling conditions should be calculated as one flute line. Step feed (0.5-0.1mm) is recommended.
- Coolant is recommended when drilling stainless steel / cast iron.
- PR660 is recommended for heavy drilling.

★ : 1st Recommendation ☆ : 2nd Recommendation

M



Milling