Titanium (Ti-6Al-4V) Milling example

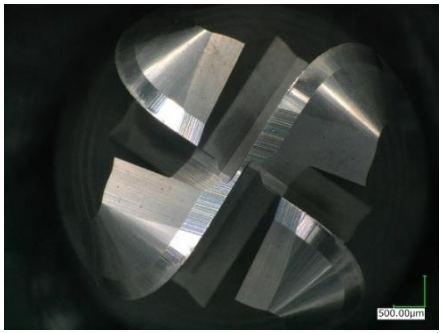
Tool : CRRS 4060-15-18 (ϕ6 x CR1.5 x 18)
Work material : Ti-6Al-4V
Pocket size : 98 x 30 x 4 mm
Coolant : Water soluble

～ Milling condition ～

Spindle Speed (min^{-1})	Feed Rate (mm/min)	a_p (mm)	a_e (mm)	Cycle Time (min)
7,150	4,010	0.06	1.08	70

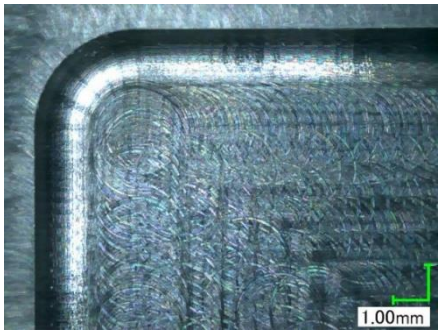
There were no problems such as chattering vibration. No burrs or chattering was seen on the work.
There is no chipping on the rake face and the peripheral relief face, and the tool wear was normal.

Bottom edge

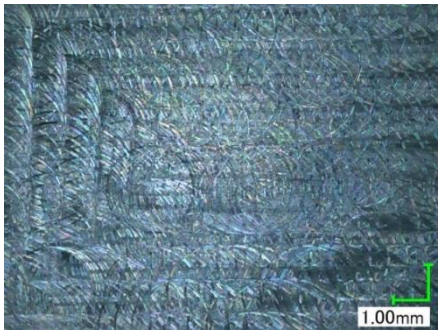


Work surface(Whole)

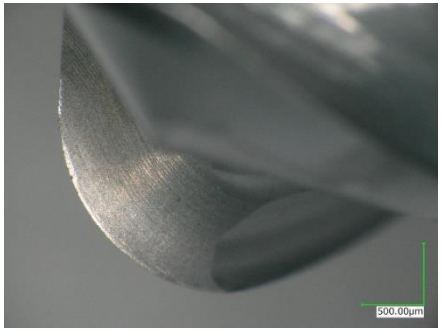
Work surface A



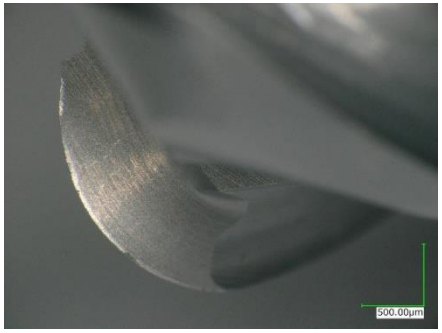
Work surface B



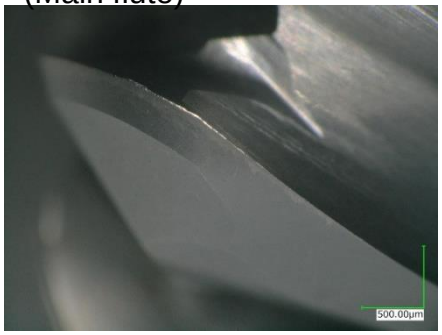
Rake face (Main flute)



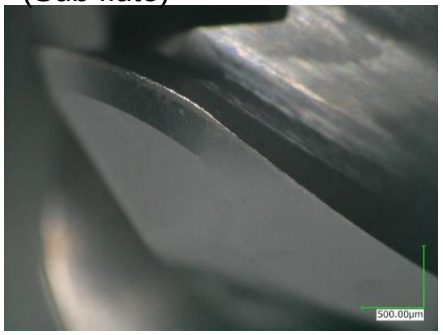
Rake face (Sub flute)



Peripheral relief face (Main flute)



Peripheral relief face (Sub flute)



Titanium (Ti-6Al-4V) Milling example

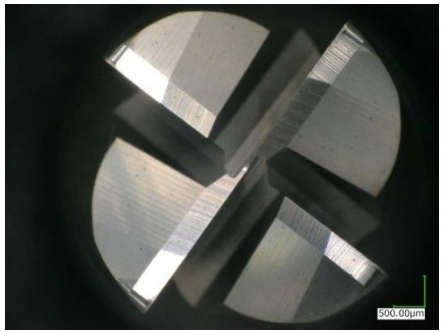
Tool	: CRRS 4060-03-18 (ϕ6 x CR0.3 x 18)
Work material	: Ti-6Al-4V
Pocket size	: 98 x 30 x 4 mm
Coolant	: Water soluble

～ Milling condition ～

Spindle Speed (min^{-1})	Feed Rate (mm/min)	a_p (mm)	a_e (mm)	Cycle Time (min)
7,150	4,010	0.05	1	67

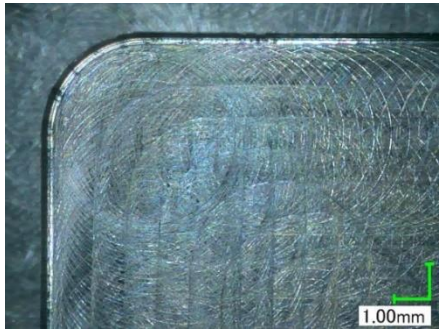
There were no problems such as chattering vibration. No burrs or chattering was seen on the work.
There is no chipping on the rake face and the peripheral relief face, and the tool wear was normal.

Bottom edge

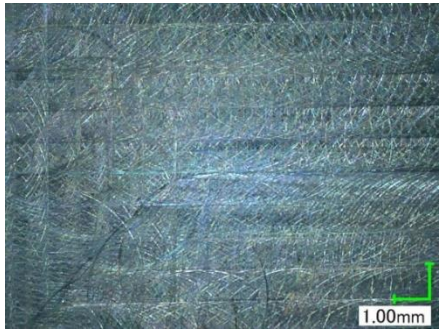


Work surface(Whole)

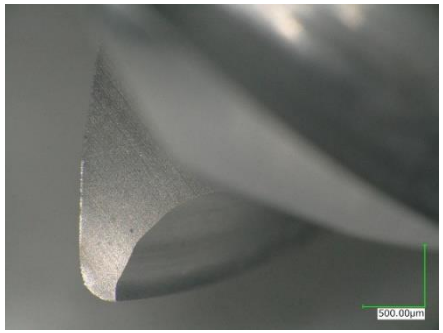
Work surface A



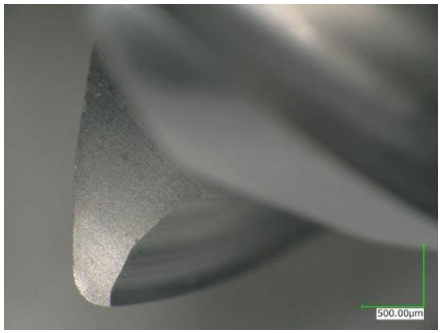
Work surface B



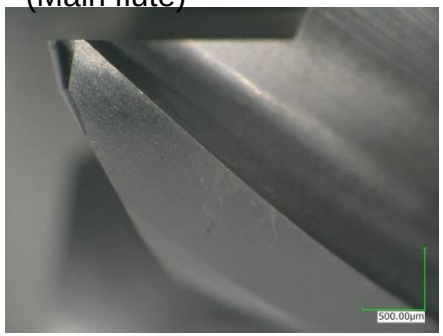
Rake face (Main flute)



Rake face (Sub flute)



Peripheral relief face (Main flute)



Peripheral relief face (Sub flute)