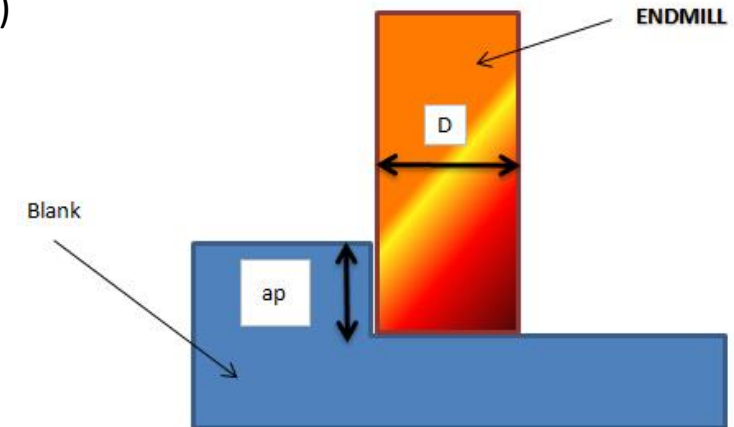


# Endmill

- Model :  $\alpha$ -D21MiA5
- Coolant : Synthetic soluble type
- Coolant pump :  
460W  
96 L/min  
6.5m(60Hz)
- Material : S50C  
(Carbon steel for machine structural use)
- Tool :  
Square Endmill non-coated 2 flutes  
Diameter 5mm Length 15mm



- Processing  
Repeat grooving of the upper surface of the blank.
- Condition  
Spindle Speed : 2860min<sup>-1</sup>  
Feed : 129mm/min  
Depth : 2.5mm (ap)  
Width : 5mm (D)



- Case of Wavy Nozzle use (Two Wavy Nozzle are used)  
Mode : SWEEP  
Swing Angle : 1 Count  
Nozzle Speed : 30 Count
- Case of fixed nozzle  
Two 1/2 inch Round nozzle are used.

# Endmill

Machining

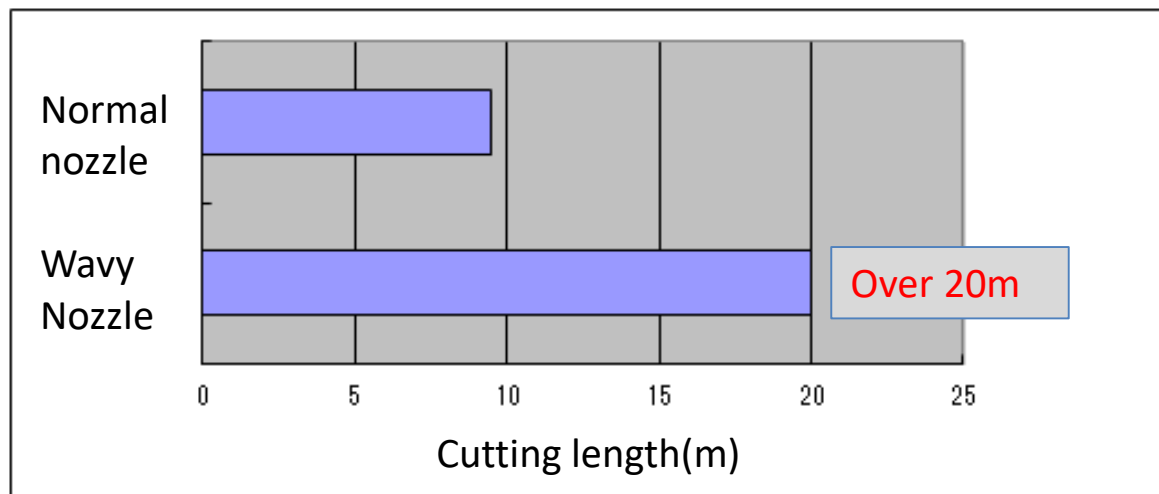


Normal coolant nozzle



Wavy Nozzle

## Cutting length until tool breakage



Normal nozzle : 9.5m  
Wavy Nozzle : Over 20m

**Longer tool life**  
**by using Wavy Nozzle**