

- Un-Equal pitch reduces the harmonic vibration caused by the equal timing of the cutting tool
- The cutting flutes are not evenly loaded if the pitch is not equal

กัดแล้วไม่สะท้าน ฟัดได้เร็วกว่า

### Helix Angle

Equal Helix Angle



30° 30°

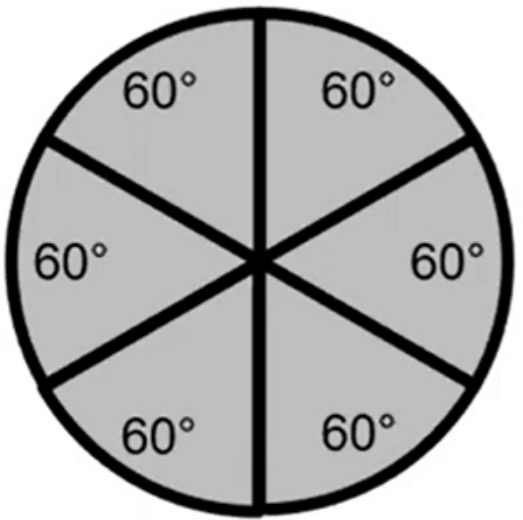
Unequal Helix Angle



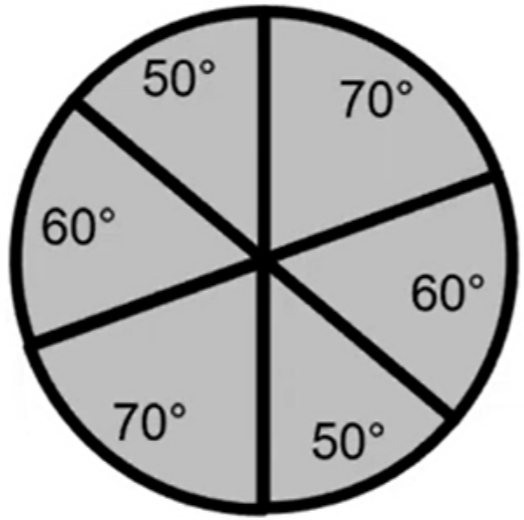
40° 42°



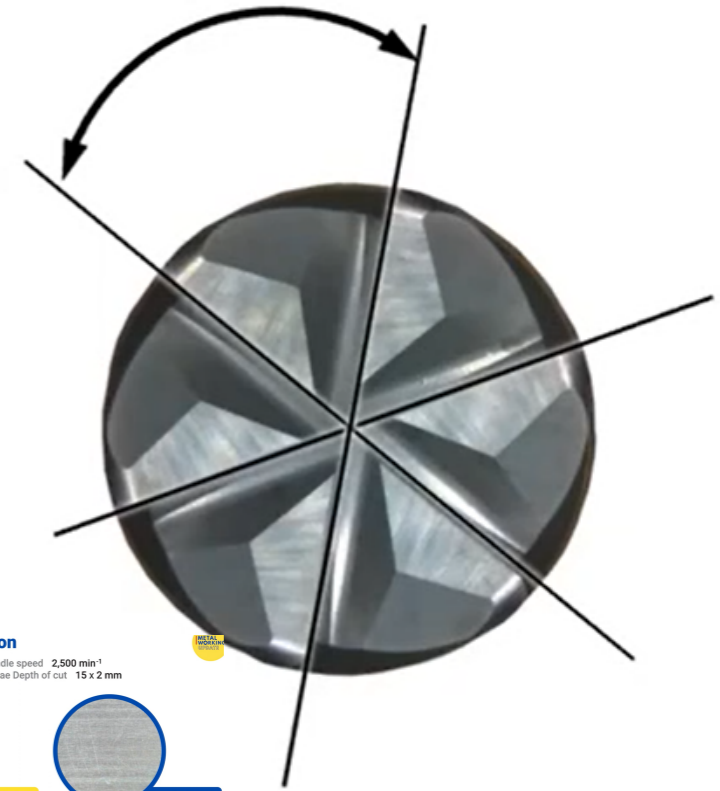
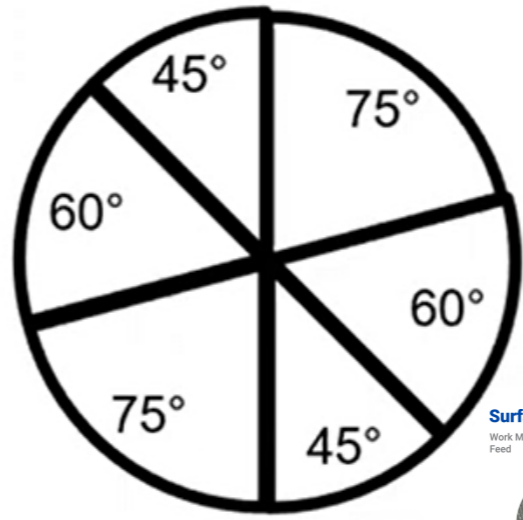
Equal Pitch



Un-Equal Pitch



Strongly Un-Equal Pitch



#### Surface Comparison

Work Material SUS304 | Spindle speed 2,500 min<sup>-1</sup>  
Feed 560 mm/min | ap x ae Depth of cut 15 x 2 mm

