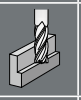
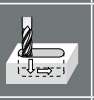
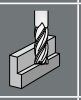
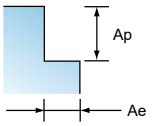
PNVE1T/PVE1TF
產 品 規格表 P189-190
Specification page

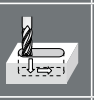
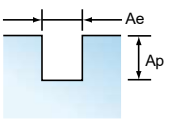
PVR1T
產 品 規格表 P191
Specification page

## PNVE1T/PVE1TF/PVR1T Cutting Condition

| Type | PNVE1T, PVE1TF | | | | | |
|---|---|---|---|---|---|---|
| Side Milling  | TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3 | | | | | |
| Hardness BRINELL | ≦300 | | | | | |
| HRC | ≦31 | | | | | |
| Vc | 60 | | | 50 | | |
| Ae/Ap | Ae=0.65D Ap=1D | | | Ae=0.4D Ap=1.5D | | |
| MILL DIA (Metric) | RPM | Fz | Feed 4 Flutes | RPM | Fz | Feed 4 Flutes |
| 4 | 4,775 | 0.0119 | 227.4 | 3,980 | 0.0119 | 189.5 |
| 5 | 3,820 | 0.0238 | 363.7 | 3,184 | 0.0190 | 242.5 |
| 6 | 3,183 | 0.0318 | 404.3 | 2,653 | 0.0212 | 224.6 |
| 8 | 2,388 | 0.0397 | 378.7 | 1,990 | 0.0248 | 197.3 |
| 10 | 1,910 | 0.0429 | 327.5 | 1,592 | 0.0333 | 212.3 |
| 12 | 1,592 | 0.0635 | 404.3 | 1,327 | 0.0423 | 224.6 |
| 16 | 1,194 | 0.0642 | 306.5 | 995 | 0.0494 | 196.5 |
| 20 | 955 | 0.0714 | 272.9 | 796 | 0.0572 | 182.0 |

| Type | PNVE1T, PVE1TF | | | | | |
|---|---|---|---|---|---|---|
| Slot Milling  | TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3 | | | | | |
| Hardness BRINELL | ≦300 | | | | | |
| HRC | ≦31 | | | | | |
| Vc | 50 | | | 40 | | |
| Ae/Ap | Ae=1D Ap=0.9D | | | Ae=1D Ap=1.25D | | |
| MILL DIA (Metric) | RPM | Fz | Feed) 4 Flutes | RPM | Fz | Feed 4 Flutes |
| 4 | 3,980 | 0.0119 | 189.5 | 3,185 | 0.0079 | 101.1 |
| 5 | 3,184 | 0.0190 | 242.5 | 2,548 | 0.0143 | 145.5 |
| 6 | 2,653 | 0.0265 | 280.8 | 2,123 | 0.0212 | 179.8 |
| 8 | 1,990 | 0.0347 | 276.2 | 1,593 | 0.0248 | 157.9 |
| 10 | 1,592 | 0.0429 | 272.9 | 1,274 | 0.0286 | 145.6 |
| 12 | 1,327 | 0.0529 | 280.8 | 1,062 | 0.0423 | 179.8 |
| 16 | 995 | 0.0593 | 235.8 | 796 | 0.0444 | 141.5 |
| 20 | 796 | 0.0667 | 212.3 | 637 | 0.0524 | 133.5 |

| Type | PVR1T | | |
|---|---|---|---|
| Side Milling  | TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3 | | |
| Hardness BRINELL | ≦300 | | |
| HRC | ≦31 | | |
| Vc | 18 | | |
| Ae/Ap | Ae=0.4D Ap=1.5D | | |
| MILL DIA (Metric) | RPM | Fz | Feed 4 Flutes |
| 4 | 3,980 | 0.0119 | 189.5 |
| 5 | 3,184 | 0.0190 | 242.5 |
| 6 | 2,653 | 0.0212 | 224.6 |
| 8 | 1,990 | 0.0248 | 197.3 |
| 10 | 1,592 | 0.0333 | 212.3 |
| 12 | 1,327 | 0.0423 | 224.6 |
| 16 | 995 | 0.0494 | 196.5 |
| 20 | 796 | 0.0572 | 182.0 |
| Depth of cut |   | | |

| Type | PVR1T | | |
|---|---|---|---|
| Slot Milling  | TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3 | | |
| Hardness BRINELL | ≦300 | | |
| HRC | ≦31 | | |
| Vc | 18 | | |
| Ae/Ap | Ae=1D Ap=1.25D | | |
| MILL DIA (Metric) | RPM | Fz | Feed 4 Flutes |
| 4 | 3,185 | 0.0079 | 101.1 |
| 5 | 2,548 | 0.0143 | 145.5 |
| 6 | 2,123 | 0.0212 | 179.8 |
| 8 | 1,593 | 0.0248 | 157.9 |
| 10 | 1,274 | 0.0286 | 145.6 |
| 12 | 1,062 | 0.0423 | 179.8 |
| 16 | 796 | 0.0444 | 141.5 |
| 20 | 637 | 0.0524 | 133.5 |
| Depth of cut |   | | |

Unit/單位: mm