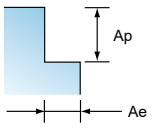
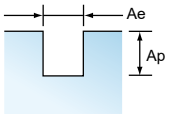
產 品 規格表 P188
Specification page

PVE1T/PLVE1T Cutting Condition

Type	PVE1T		
Side Milling 	TITANIUM ALLOYS(DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3		
Hardness BRINELL	≦300		
HRC	≦31		
Vc	60		
Ae/Ap	Ae=0.4D Ap=1.5D		
MILL DIA (Metric)	RPM	Fz	Feed 4 Flutes
4	4,775	0.0159	303.2
5	3,820	0.0238	363.7
6	3,183	0.0318	404.3
8	2,388	0.0397	378.7
10	1,910	0.0429	327.5
12	1,592	0.0582	370.6
16	1,194	0.0642	306.5
20	955	0.0762	291.1

Type	PVE1T		
Slot Milling 	TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3		
Hardness BRINELL	≦300		
HRC	≦31		
Vc	50		
Ae/Ap	Ae=1D Ap=1.25D		
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	0.0265	280.8
8	1,990	0.0297	236.7
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

Type	PLVE1T		
Side Milling 	TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3		
Hardness BRINELL	≦300		
HRC	≦31		
Vc	60		
Ae/Ap	Ae=0.2D Ap=1.8D		
MILL DIA (Metric)	RPM	Fz	Feed 4 Flutes
4	4775	0.0119	227.4
5	3820	0.0238	363.7
6	3183	0.0265	336.9
8	2388	0.0297	284.0
10	1910	0.0381	291.1
12	1592	0.0476	303.2
16	1194	0.0593	282.9
20	955	0.0667	254.7
Depth of cut			

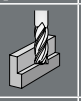
Type	PLVE1T		
Slot Milling 	TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3		
Hardness BRINELL	≦300		
HRC	≦31		
Vc	50		
Ae/Ap	Ae=1D Ap=1.5D		
MILL DIA (Metric)	RPM	Fz	Feed 4 Flutes
4	3980	0.0079	126.4
5	3184	0.0143	181.9
6	2653	0.0212	224.6
8	1990	0.0248	197.3
10	1592	0.0286	182.0
12	1327	0.0370	196.6
16	995	0.0444	176.9
20	796	0.0524	166.8
Depth of cut			

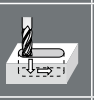
Unit/單位: mm

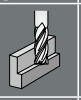
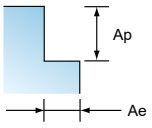
PNVE1T/PVE1TF
產品規格表 P189-190
Specification page

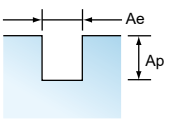
PVR1T
產品規格表 P191
Specification page

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