ACBL 產品規格表 P173 Specification page

SULNBT 產品規格表 P212-213 Specification page

• ACBL,SULNBT 2 Flutes Standard Cutting Conditions 標準切削

Work Material 被削材		Carbon Steels S50C(~225HB) 碳素鋼		Alloy Steels SCM, SK, SUS (225~325HB) 合金鋼		Prehardened Steels Hardened steels NAK.SKD HRC30~45 調質鋼		Hardened steels SKD11.61.SKT HRC40~50 調質鋼	
Cutting Speed 切削速度		50~65m/min		40~55m/min		30~50m/min		30~40m/min	
R	Ad Depth of cut (mm)	Speed (min^{-1}) 迴轉數	Feed Rate (mm/min) 進給速度	Speed (min^{-1}) 迴轉數	Feed Rate (mm/min) 進給速度	Speed (min^{-1}) 迴轉數	Feed Rate (mm/min) 進給速度	Speed (min^{-1}) 迴轉數	Feed Rate (mm/min) 進給速度
D0.25R	0.003~0.01	32,000	640	32,000	640	26,000	300	20,000	240
D0.3R	0.006~0.03	32,000	830	27,000	700	21,000	340	16,000	260
D0.5R	0.005~0.08	19,000	870	16,000	740	13,000	420	10,000	320
D0.75R	0.06~0.12	13,000	940	10,500	760	8,500	440	6,500	340
D1R	0.03~0.21	10,000	1,000	8,000	800	6,000	420	5,000	350
D1.5R	0.03~0.23	6,600	730	5,300	580	4,000	310	3,300	260
D2R	0.01~0.28	5,000	660	4,000	530	3,000	260	2,500	230
Depth of cut (R:球頭半徑) 切削量基準		≦0.1R (R≦1) ≦0.2R (R>1) 							

1. Use a rigid machine and holder.
2. If the rigidity of the machine or the work material installation is very low, or chattering is generated, please reduce the revolution and the feed rate proportionately.
3. Use cutting fluid with retardant.

1. 請使用較具剛性之機械設備及夾頭。
2. 機械設備或工件的夾持剛性不足、出現震動時，請以相同比例按上表降低回轉數及進給速度。
3. 請使用不容易冒煙之切削油劑。

Unit/單位: mm