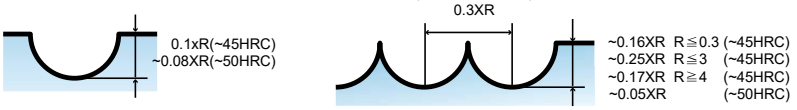
P-MIB 產品規格表 P62 Specification page
P-SLB/P-MLB/P-LLB/P-XLB 產品規格表 P65 Specification page
ACB 產品規格表 P171-172 Specification page
SUMIB 產品規格表 P208 Specification page
SUBT 產品規格表 P209 Specification page
SULBT 產品規格表 P211 Specification page
SBS 產品規格表 P269 Specification page

• P-MIB,P-SLB,P-MLB,P-LLB,P-XLB,ACB,SUMIB,SUBT,SULBT,SBS 2 Flutes Standard Cutting Conditions 標準切削

Work Material 被削材	Carbon Steels S50C 碳素鋼		Alloy Steels Prehardened Steels SCM SKD SUS HPM NAK 合金鋼，調質鋼		Hardened Steels SKD61~HRC50 調質鋼		Aluminum 鋁		Copper 銅	
Cutting Speed 切削速度	150m/min		120~150m/min		80~100m/min		150~m/min		100~150m/min	
R	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	Speed (min^{-1}) 迴轉數	Feed Rate (mm/min) 進給速度
D0.15R	40,000	400	40,000	360	40,000	330	40,000	440	40,000	400
D0.2R	40,000	500	40,000	480	40,000	500	40,000	480	40,000	480
D0.25R	40,000	620	40,000	610	40,000	620	40,000	540	40,000	540
D0.3R	40,000	750	40,000	750	40,000	750	40,000	600	40,000	600
D0.4R	40,000	960	40,000	1,000	36,000	900	40,000	800	40,000	800
D0.5R	40,000	1,200	38,000	1,200	29,000	900	40,000	1,000	40,000	830
D0.75R	30,000	1,270	25,500	1,100	19,000	700	40,000	1,360	30,000	1,160
D1R	24,000	1,160	19,000	800	14,300	600	40,000	2,000	24,000	1,200
D1.25R	19,000	1,000	15,300	670	11,500	510	38,000	2,400	19,000	1,200
D1.5R	16,000	930	13,000	600	9,600	460	32,000	2,400	16,000	1,200
D1.75R	13,700	930	11,400	580	8,200	450	27,300	2,400	13,600	1,200
D2R	12,000	930	10,000	570	7,200	450	24,000	2,400	12,000	1,200
D2.5R	9,600	930	8,000	560	5,700	450	19,000	2,400	9,600	1,200
D3R	8,000	930	6,400	540	4,800	450	16,000	2,400	8,000	1,200
D4R	6,000	900	4,800	540	3,600	450	12,000	2,400	6,000	1,200
D5R	4,800	900	3,800	540	2,900	450	9,600	2,300	4,800	1,150
D6R	4,000	900	3,200	540	2,400	450	8,000	2,100	4,000	1,050
D7R	3,400	900	2,750	540	2,050	450	6,800	2,000	3,400	1,000
D8R	3,000	900	2,400	540	1,800	450	6,000	2,000	3,000	1,000
D10R	2,400	900	1,900	520	1,450	450	4,800	2,000	2,400	1,000
D12.5R	1,900	720	1,520	450	1,160	420	3,840	1,900	1,920	940

Depth of cut (R:球頭半徑) 切削量基準



1. When Slotting, reduce the feed by 60% from above values.
2. Length of overhang is 4 times dia, as standard. When it is longer then 4 times dia, follow figures of above table.
3. Use Oil-mist coolant or Air blow.
4. Adjust both spindle speed and feed according to Milling conditions and machine rigidity.

1. 溝加工時之進給速度，請設定為上述值之 60%。
2. 刀具夾持突出量以 4D 為基準，超出上述場合時，請將切削條件作適度之調整。
3. 請使用油霧 (Oil-mist) 冷卻或吹氣方式 (Air blow) 進行切削。
4. 主軸回轉速及床台進給速度，請以相同比例作適度調整。

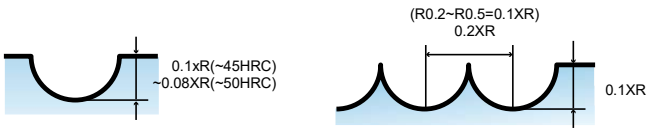
Unit/單位: mm

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P-SLB/P-MLB/P-LLB/P-XLB 產品規格表 P65 Specification page
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SUBT 產品規格表 P209 Specification page
SULBT 產品規格表 P211 Specification page
SBS 產品規格表 P269 Specification page

• P-MIB,P-SLB,P-MLB,P-LLB,P-XLB,ACB,SUMIB,SUBT,SULBT,SBS 2 Flutes HIGH - SPEED Milling Conditions 高速標準切削

Work Material 被削材	Carbon Steels S50C 碳素鋼		Alloy Steels SCM, SKD, SUS 合金鋼		Prehardened Steels HPM, NAK 調質鋼		Hardened Steels SKD61~HRC50 調質鋼	
Cutting Speed 切削速度	250m/min		200m/min		180m/min		100m/min	
R	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
D0.15R	~ 40,000	~ 1,200	~ 40,000	~ 960	~ 40,000	~ 800	~ 40,000	350
D0.2R	~ 40,000	~ 1,200	~ 40,000	~ 960	~ 40,000	~ 800	~ 40,000	480
D0.25R	~ 40,000	~ 1,200	~ 40,000	~ 960	~ 40,000	~ 800	~ 40,000	520
D0.3R	~ 40,000	~ 1,200	~ 40,000	~ 960	~ 40,000	~ 800	~ 40,000	560
D0.4R	~ 40,000	~ 2,400	~ 40,000	~ 2,000	~ 40,000	~ 1,760	40,000	1,000
D0.5R	~ 40,000	~ 2,400	~ 40,000	~ 2,000	~ 40,000	~ 1,760	32,000	1,500
D0.75R	~ 40,000	~ 3,700	~ 40,000	~ 3,000	38,000	2,700	21,300	1,500
D1R	40,000	5,000	32,000	3,200	29,000	2,900	16,000	1,500
D1.25R	32,000	5,000	25,000	3,200	23,000	2,900	12,800	1,500
D1.5R	27,000	5,000	21,000	3,200	19,000	2,900	10,600	1,500
D1.75R	23,000	5,000	18,000	3,200	16,400	2,900	9,100	1,500
D2R	20,000	4,000	16,000	3,200	14,000	2,900	8,000	1,500
D2.5R	16,000	3,500	12,800	2,500	11,500	2,300	6,400	1,300
D3R	13,500	3,000	10,600	2,000	9,500	1,800	5,300	1,200
D4R	10,000	3,000	8,000	2,000	7,200	1,800	4,000	1,200
D5R	8,000	3,000	6,400	2,000	5,700	1,800	3,200	1,200
D6R	6,700	2,500	5,300	1,800	4,800	1,600	2,700	1,200
D8R	5,000	2,000	4,000	1,500	3,600	1,300	2,000	800
D10R	4,000	1,500	3,200	1,200	2,900	1,000	1,600	800
D12.5R	3,200	1,200	2,550	900	2,300	700	1,280	760

Depth of cut 切削量基準 (R:球頭半徑)



1.When Slotting, reduce the feed by 60% from above values.
2.Length of overhang is 4 times dia. as standard. When it is longer then 4 times dia., follow figures of above table.
3. Recommend Oil-mist coolant or Air blow.
4.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.
5.Use a rigid machine and holder.

1. 溝加工時之進給速度，請設定為上述值之 60%。
2. 刀具夾持突出量以 4D 為基準，超出上述場合時，請將切削條件作適度之調整。
3. 請使用油霧 (Oil-mist) 冷卻或吹氣方式 (Air blow) 進行切削。
4. 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。
5. 請使用較具剛性之機械設備及夾頭。

Unit/單位: mm