CEL
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SULNT
產 品 規格表 P202-203
Specification page

• CEL,SULNT 2 Flutes Standard Cutting Conditions 標準切削

Work Material 被削材		Carbon Steels, Alloy Steels Prehardened Steels S50C, SCM, SKD, SUS, HPM, NAK 碳素鋼・合金鋼・調質鋼		Aluminum 鋁		Copper 銅		Plastics 塑膠	
Cutting Speed 切削速度		30~80m/min		100~200m/min		50~150m/min		50~80m/min	
Diameter (mm) 直徑	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
0.2	0.002~0.01	47,800~	200~400	50,000~	200~400	50,000~	200~400	50,000~	200~400
0.3	0.002~0.02	31,800~	200~600	50,000~	200~600	50,000~	300~600	50,000~	200~600
0.4	0.002~0.02	23,900~	200~800	50,000~	200~800	39,800~	300~800	39,800~	200~800
0.5	0.001~0.04	19,100~	200~1,000	50,000~	200~1,000	31,800~	300~1,000	31,800~	200~1,000
1	0.002~0.05	9,600~25,500	300~1,300	31,800~	300~2,600	15,900~47,800	450~1,950	15,900~25,500	300~1,300
1.5	0.002~0.1	6,400~17,000	250~900	21,200~42,500	250~1,800	10,600~31,800	375~1,350	10,600~17,000	250~900
2	0.003~0.2	4,800~12,700	250~700	15,900~31,800	250~1,400	8,000~23,900	375~1,050	8,000~12,700	250~700
2.5	0.01~0.4	3,800~10,200	200~500	12,700~25,500	200~1,000	6,400~19,100	300~750	6,400~10,200	200~500
3	0.012~0.6	3,200~8,500	200~500	10,600~21,200	200~1,000	5,300~15,900	300~750	5,300~8,500	200~500

1. Adjust depth of cut according to effective length.
2. When under 20 (effective length / diameter), refer to the conditions listed above.
3. Use cutting fluid with retardant.
4. Recommend reciprocating cutting.

1. 請參考刀具之有效長，來調整切削量及回轉數，床台進給速度。
2. 上述條件為 L1(有效長)/ D(刀徑) ≦ 20 為基準，超出上述場合時；請大幅調整切削條件。
3. 請使用不容易冒煙之切削油劑。
4. 請使用往復方式進行切削。

Unit/單位: mm