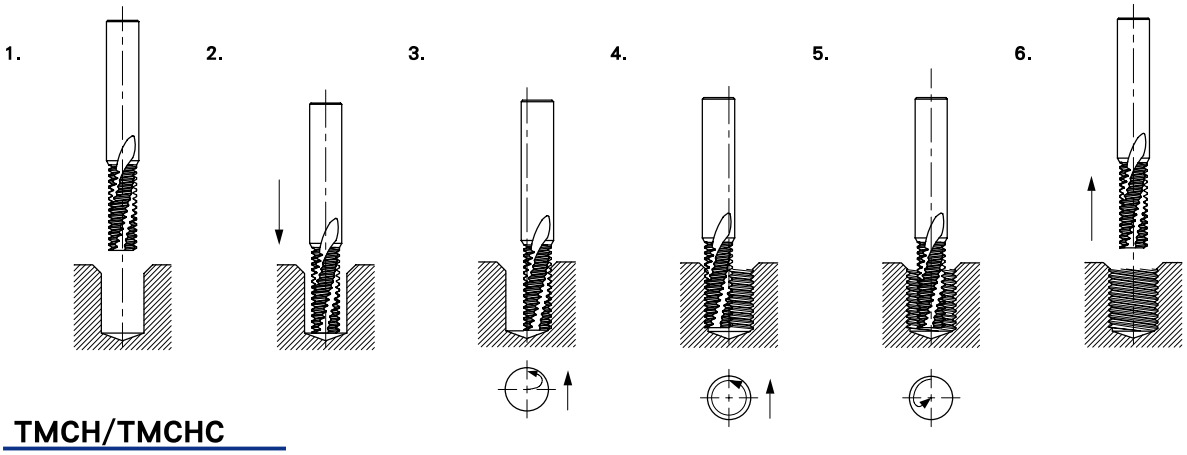
## TM/TMC/TMEL/TMCEL/TMCH/TMCHC
## TM/TMC/TMEL/TMCEL/TMCH/TMCHC 切削條件

產 品 規格表 P170-173
Specification page

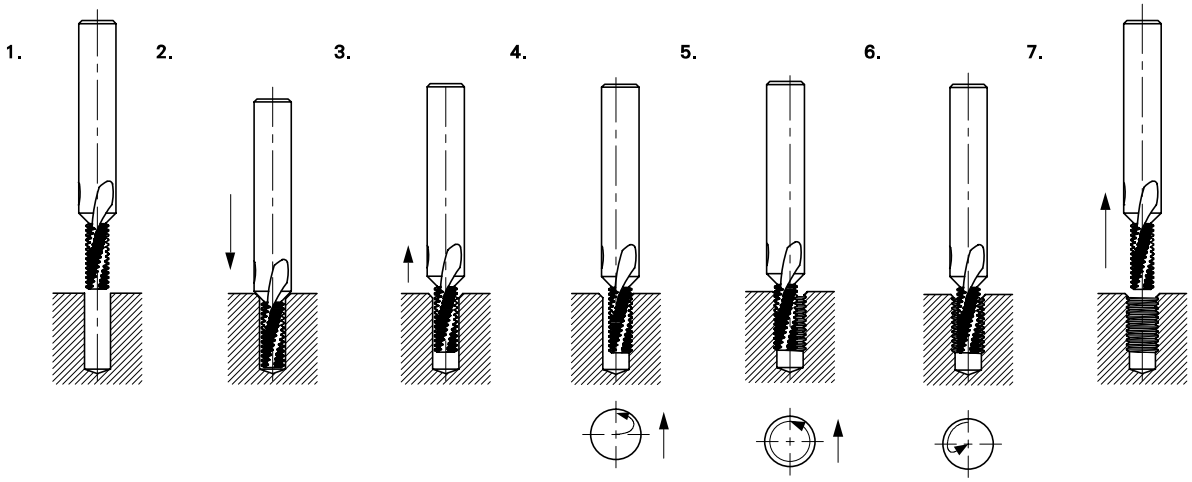
| Work Material 被削材 | SS400. AISI 1050. SCM等 一般構造鋼.碳素鋼. NON-ALLOYED STEELS ALLOY STEELS TOOL STEELS | | AISI H13. AISI D2等 合金鋼.工具鋼 調質鋼 ALLOY STEELS HEAT RESISTANT STEELS | | AISI 304 AISI 316等 沃斯田鐵、麻田 散鐵系 系列不銹鋼 STAINLESS STEELS | | 鑄鐵、球狀石墨鑄鐵 可延展性鑄鐵 FC250 等 CAST IRON | | 鋁鎂合金 鋁及鋁合金 | | 特殊合金、 鈦及鈦合金 TITANUM ALLOYS | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| HARDNESS 硬度 | ~30HRC | | 30~45HRC | | ~40HRC | | ≧240HB | | | | | |
| STRENGTH 抗拉強度 | ~1000 N/mm² | | 1000~1500 N/mm² | | ~950N/mm² | | | | | | 1300N/mm² | |
| Vc | 50~220 | | 30~100 | | 50~140 | | 60~140 | | 80~280 | | 15~80 | |
| Diameter 直徑(mm) | fz (mm/z) | | fz (mm/z) | | fz (mm/z) | | fz (mm/z) | | fz (mm/z) | | fz (mm/z) | |
| 2 | 0.025 | 0.020 | 0.020 | 0.025 | 0.025 | 0.015 | 0.012 | 0.011 | 0.015 | 0.011 | 0.009 | 0.005 |
| 3 | 0.035 | 0.025 | 0.025 | 0.035 | 0.035 | 0.015 | 0.016 | 0.014 | 0.020 | 0.014 | 0.012 | 0.006 |
| 4 | 0.040 | 0.030 | 0.030 | 0.040 | 0.040 | 0.020 | 0.020 | 0.018 | 0.025 | 0.018 | 0.015 | 0.008 |
| 6 | 0.055 | 0.035 | 0.035 | 0.055 | 0.055 | 0.025 | 0.024 | 0.021 | 0.030 | 0.021 | 0.018 | 0.009 |
| 8 | 0.065 | 0.040 | 0.040 | 0.065 | 0.065 | 0.025 | 0.028 | 0.025 | 0.035 | 0.025 | 0.021 | 0.011 |
| 10 | 0.080 | 0.045 | 0.045 | 0.080 | 0.080 | 0.030 | 0.032 | 0.028 | 0.040 | 0.028 | 0.024 | 0.012 |
| 12 | 0.090 | 0.050 | 0.050 | 0.090 | 0.090 | 0.030 | 0.043 | 0.039 | 0.054 | 0.038 | 0.034 | 0.021 |
| 16 | 0.110 | 0.060 | 0.060 | 0.110 | 0.110 | 0.040 | 0.048 | 0.043 | 0.060 | 0.043 | 0.038 | 0.023 |
| 20 | 0.140 | 0.070 | 0.070 | 0.140 | 0.140 | 0.040 | 0.058 | 0.052 | 0.072 | 0.051 | 0.046 | 0.028 |
| 14 | 0.067 | 0.056 | 0.060 | 0.039 | 0.056 | 0.038 | 0.067 | 0.060 | 0.084 | 0.060 | 0.053 | 0.032 |
| 16 | 0.077 | 0.064 | 0.069 | 0.045 | 0.064 | 0.043 | 0.077 | 0.069 | 0.096 | 0.068 | 0.061 | 0.037 |
| 20 | 0.096 | 0.080 | 0.086 | 0.056 | 0.080 | 0.054 | 0.096 | 0.086 | 0.120 | 0.085 | 0.076 | 0.046 |

## 切削示範 Cutting Demonstration

### TM/TMC/TMEL/TMCEL




### TMCH/TMCHC




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