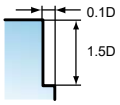
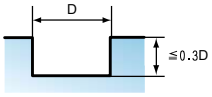
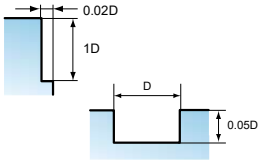
產品規格表 P270
Specification page

• RTAS 2 Flutes Standard Cutting Conditions 標準切削

Work material 被削材	Carbon Steels, Alloy Steels S50C,SCM,鑄鐵FC250等 AiSi 1049, Cast iron 炭素鋼，合金鋼~HRC30			Alloy Steels, Tool Steels 調質鋼SKD61, NAK等 Prehardened steels, AiSi H13 合金鋼、工具鋼、預硬鋼 HRC30~45			Austenitic stainless steels SUS304, SUS316等 AiSi 304, AiSi 316 沃斯田鐵系列不鏽鋼			Hardened steels SKD61, SKD11, NAK, STAVAX等 AiSi H13 熱處理鋼 (HRC45~50)		
Cutting Speed 切削速度	50~100m/min			50~70m/min			30~60m/min			20~40m/min		
Diameter 直徑(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	
		Side Milling 側面	Slotting 溝		Side Milling 側面	Slotting 溝		Side Milling 側面	Slotting 溝		Side Milling 側面	Slotting 溝
8	4000	450	360	2400	240	190	1600	220	130	1200	65	50
10	3200	390	310	1900	190	150	1300	190	110	1000	65	50
12	2700	330	260	1600	160	130	1000	150	90	800	65	50
Depth of cut (D:直徑Dia) 切削量基準	 											

產品規格表 P270
Specification page

• RTAS 2 Flutes High-Speed Milling Conditions 高速標準切削

Work material 被削材	Carbon Steels, Alloy Steels S50C,SCM,鑄鐵FC250等 AiSi 1049, Castiron 炭素鋼，合金鋼~HRC30		Alloy Steels, Tool Steels 調質鋼SKD61, NAK等 Prehardened steels, AiSi H13 合金鋼、工具鋼、預硬鋼 HRC30~45		Hardened steels SKD61, SKD11, NAK, STAVAX等 AiSi H13 熱處理鋼 HRC45~55	
Cutting Speed 切削速度	250m/min		150m/min		100m/min	
Diameter 直徑(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
8	9900	1290	6000	750	4000	220
10	7900	1100	4800	650	3200	200
12	6600	1000	4000	560	2600	200
(mm) Ap Milling Amount 軸方向切削量	Ap=0.05D		Ap=0.03D		Ap=0.02D	

▲ Caution

1.Please use SI coating tools for work materials of 50~60HRC.
2.In cutting Austenitic stainless steels, the use of non-water-soluble cutting fluid is especially effective.
3.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.
4.When drilling, please set the feed rate at 1/3 or below of the above value.

▲ 注意事項

1.切削50~60HRC以上之材料時，請使用SI鍍膜之刀具。
2.切削沃斯田鐵系列不鏽鋼時，請使用非水溶性切削油效果較好。
3.機械設備或工作的夾持剛性不足、出現震動時，請以相同比例按上表降低迴轉數及進給速度。
4.縱向進給時，進給速度請設定為上表1/3以下。

Unit/單位: mm