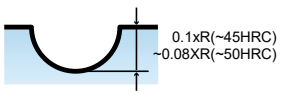
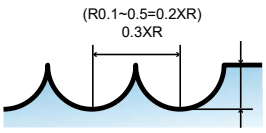
產品規格表 P269
Specification page

● SBS 4 Flutes Standard Cutting Conditons 標準切削

WORK MATERIAL 被切削材	Carbon Steels S50C 碳素鋼		Alloy Steels Prehardened Steels SCM SKD 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}) 迴轉速	Feed Rate (mm/min) 進給速度	SPEED (min^{-1}) 迴轉速	Feed Rate (mm/min) 進給速度	SPEED (min^{-1}) 迴轉速	Feed Rate (mm/min) 進給速度	SPEED (min^{-1}) 迴轉速	Feed Rate (mm/min) 進給速度	SPEED (min^{-1}) 迴轉速	Feed Rate (mm/min) 進給速度
D0.15R	40,000	800	40,000	720	40,000	660	40,000	880	40,000	800
D0.2R	40,000	1,000	40,000	960	40,000	1,000	40,000	960	40,000	960
D0.25R	40,000	1,240	40,000	1,220	40,000	1,240	40,000	1,080	40,000	1,080
D0.3R	40,000	1,500	40,000	1,500	40,000	1,500	40,000	1,200	40,000	1,200
D0.4R	40,000	1,920	40,000	2,000	36,000	1,800	40,000	1,600	40,000	1,600
D0.5R	40,000	2,400	38,000	2,400	29,000	1,800	40,000	2,000	40,000	1,660
D0.75R	30,000	2,540	25,500	2,200	19,000	1,400	40,000	2,720	30,000	2,320
D1R	24,000	2,320	19,000	1,600	14,300	1,200	40,000	4,000	24,000	2,400
D1.25R	19,000	2,000	15,300	1,340	11,500	1,020	38,000	4,800	19,000	2,400
D1.5R	16,000	1,860	13,000	1,200	9,600	920	32,000	4,800	16,000	2,400
D1.75R	13,700	1,860	11,400	1,160	8,200	900	27,300	4,800	13,600	2,400
D2R	12,000	1,860	10,000	1,140	7,200	900	24,000	4,800	12,000	2,400
D2.5R	9,600	1,860	8,000	1,120	5,700	900	19,000	4,800	9,600	2,400
D3R	8,000	1,860	6,400	1,080	4,800	900	16,000	4,800	8,000	2,400
D4R	6,000	1,800	4,800	1,080	3,600	900	12,000	4,800	6,000	2,400
D5R	4,800	1,800	3,800	1,080	2,900	900	9,600	4,600	4,800	2,300
D6R	4,000	1,800	3,200	1,080	2,400	900	8,000	4,200	4,000	2,100
D7R	3,400	1,800	2,750	1,080	2,050	900	6,800	4,000	3,400	2,000
D8R	3,000	1,800	2,400	1,080	1,800	900	6,000	4,000	3,000	2,000
D10R	2,400	1,800	1,900	1,040	1,450	900	4,800	4,000	2,400	2,000
D12.5R	1,900	1,440	1,520	900	1,160	420	3,840	3,800	1,920	940

DEPTH OF CUT 加工深度





Unit/單位: mm