



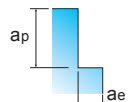
FHPC

產品規格表 **P216**
Specification page


CR-FHPC

產品規格表 **P217**
Specification page

● FHPC & CR-FHPC 4 Flutes Side Milling 側面切削條件表

| Working material 被切削材 | Mild steels Carbon steels, Cast iron SS400, S55c, FC250 (~750N/mm ²) 一般構造用鋼、碳素鋼、鑄鐵 | | Alloy steels, Tool steels, SCM, SKT, SKS, SKD (~30HRC) 合金鋼、工具鋼 | | Hardened steels, Prehardened steels, (Free-cutting) SKT, SKD, NAK65, HPM1 調質鋼 (30~38HRC) | | Hardened steels, Stainless steels SUS304, SKD 調質鋼 (38~45HRC) | | Hardened steels, Titanium alloys, Heat resistant alloys steels, 調質鋼 (45~55HRC) | | Hardened steels, 調質鋼 (55~60HRC) | | | | | | | | | | | | | |
|--------------------------|---|--------------------------|---|--------------------------|--|--------------------------|---|--------------------------|---|--------------------------|---|--------------------------|-------|-------|------|------|--|--|--|--|-------|-------|----|-------|
| | 100 m/min | | 78 m/min | | 66 m/min | | 62 m/min | | 60 m/min | | 30 m/min | | | | | | | | | | | | | |
| Cutting Speed 切削速度 | 100 m/min | | 78 m/min | | 66 m/min | | 62 m/min | | 60 m/min | | 30 m/min | | | | | | | | | | | | | |
| Mill DIA.(mm) 直徑 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | | | | | | | | | | | | |
| 6 | 4240 | 1250 | 3320 | 945 | 2800 | 700 | 2640 | 660 | 2560 | 545 | 1280 | 190 | | | | | | | | | | | | |
| 8 | 3200 | 1250 | 2480 | 895 | 2120 | 660 | 1960 | 640 | 1920 | 555 | 960 | 175 | | | | | | | | | | | | |
| 10 | 2560 | 1100 | 2000 | 855 | 1680 | 605 | 1560 | 590 | 1520 | 525 | 764 | 160 | | | | | | | | | | | | |
| 12 | 2120 | 1100 | 1640 | 850 | 1400 | 565 | 1320 | 535 | 1280 | 475 | 636 | 160 | | | | | | | | | | | | |
| 16 | 1600 | 955 | 1240 | 745 | 1040 | 500 | 1000 | 445 | 960 | 400 | 476 | 160 | | | | | | | | | | | | |
| 20 | 1280 | 765 | 1000 | 595 | 840 | 455 | 788 | 395 | 764 | 355 | 380 | 160 | | | | | | | | | | | | |
| Depth of cut 加工深度 |  <table border="1"> <tr> <td>a_p</td> <td>a_e</td> </tr> <tr> <td>1.5D</td> <td>0.2D</td> </tr> </table> | | | | | | a_p | a_e | 1.5D | 0.2D | <table border="1"> <tr> <td>a_p</td> <td>a_e</td> </tr> <tr> <td>1.5D</td> <td>0.1D</td> </tr> </table> | | a_p | a_e | 1.5D | 0.1D | <table border="1"> <tr> <td>a_p</td> <td>a_e</td> </tr> <tr> <td>1D</td> <td>0.05D</td> </tr> </table> | | | | a_p | a_e | 1D | 0.05D |
| a_p | a_e | | | | | | | | | | | | | | | | | | | | | | | |
| 1.5D | 0.2D | | | | | | | | | | | | | | | | | | | | | | | |
| a_p | a_e | | | | | | | | | | | | | | | | | | | | | | | |
| 1.5D | 0.1D | | | | | | | | | | | | | | | | | | | | | | | |
| a_p | a_e | | | | | | | | | | | | | | | | | | | | | | | |
| 1D | 0.05D | | | | | | | | | | | | | | | | | | | | | | | |

● FHPC & CR-FHPC 4 Flutes Slotting 溝切削條件表

| Working material 被切削材 | Mild steels Carbon steels, Cast iron SS400, S55c, FC250 (~750N/mm ²) 一般構造用鋼、碳素鋼、鑄鐵 | | Alloy steels, Tool steels, SCM, SKT, SKS, SKD (~30HRC) 合金鋼、工具鋼 | | Hardened steels, Prehardened steels, (Free-cutting) SKT, SKD, NAK65, HPM1 調質鋼 (30~38HRC) | | Hardened steels, Stainless steels SUS304, SKD 調質鋼 (38~45HRC) | | Hardened steels, Titanium alloys, Heat resistant alloys steels, 調質鋼 (45~55HRC) | | Hardened steels, 調質鋼 (55~60HRC) | |
|--------------------------|--|--------------------------|---|--------------------------|--|--------------------------|---|--------------------------|---|--------------------------|------------------------------------|--------------------------|
| | 100 m/min | | 78 m/min | | 66 m/min | | 62 m/min | | 60 m/min | | 30 m/min | |
| Cutting Speed 切削速度 | 100 m/min | | 78 m/min | | 66 m/min | | 62 m/min | | 60 m/min | | 30 m/min | |
| Mill DIA.(mm) 直徑 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 | Speed(mm ¹) 迴轉速度 | Speed(mm/ min) 送速度 |
| 6 | 3400 | 715 | 2560 | 560 | 2320 | 500 | 2200 | 495 | 1800 | 400 | 840 | 125 |
| 8 | 2560 | 660 | 1920 | 550 | 1760 | 545 | 1640 | 515 | 1320 | 415 | 636 | 125 |
| 10 | 2040 | 610 | 1520 | 535 | 1400 | 475 | 1320 | 470 | 1080 | 380 | 508 | 115 |
| 12 | 1680 | 610 | 1280 | 475 | 1160 | 450 | 1120 | 440 | 880 | 355 | 424 | 115 |
| 16 | 1280 | 610 | 960 | 430 | 880 | 370 | 840 | 370 | 668 | 300 | 320 | 88 |
| 20 | 1000 | 510 | 764 | 380 | 700 | 350 | 664 | 330 | 536 | 265 | 256 | 89 |
| Depth of cut 加工深度 |  $a_p = 0.5D$ | | | | | | $a_p = 0.05D$ | | | | | |