

**JNTA**產品規格表 **P201**
Specification page**SUNTA**產品規格表 **P186**
Specification page**NTA**產品規格表 **P73**
Specification page**• JNTA,SUNTA,NTA 4 Flutes Side Cutting 側面銑削**

Work Material 被削材	SS400, AISI 1050, SCM 鑄鐵, FC250等 結構鋼, 碳素鋼(~30HRC)		AISI H13, AISI D2等 合金鋼, 工具鋼, 調質鋼(30~35HRC)		AISI 304, AISI 316等 沃斯田鐵系列不銹鋼		SKD61等 淬火鋼(45~50HRC)		耐熱合金英高鎳等	
(mm) 外徑	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	Speed (min ⁻¹) 迴轉數	Feed Rate (mm/min) 進給速度
5	7,600	740	4,500	380	3,800	260	3,200	100	2,500	70
6	6,400	750	3,700	390	3,200	290	2,700	110	2,100	75
8	4,800	780	2,800	420	2,400	340	2,000	140	1,600	95
10	3,800	790	2,200	420	1,900	340	1,600	150	1,300	105
12	3,200	790	1,900	420	1,600	320	1,300	150	1,100	110
16	2,400	770	1,400	390	1,200	300	1,000	150	800	110
20	1,900	760	1,100	370	1,000	300	800	140	600	100
Depth of cut 切削深度										

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Specification page**• JNTA,SUNTA,NTA 4 Flutes Slot Cutting 溝加工**

Work Material 被削材	SS400, AISI 1050, SCM 鑄鐵, FC250等 結構鋼, 碳素鋼(~30HRC)		AISI H13, AISI D2等 合金鋼, 工具鋼, 調質鋼(30~35HRC)		AISI 304, AISI 316等 沃斯田鐵系列不銹鋼		SKD61等 淬火鋼(45~50HRC)		耐熱合金英高鎳等	
(mm) 外徑	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	Speed (min ⁻¹) 迴轉數	Feed Rate (mm/min) 進給速度
5	6,400	570	3,800	280	3,200	190	1,900	50	1,300	25
6	5,300	580	3,200	290	2,700	200	1,600	55	1,100	30
8	4,000	600	2,400	320	2,000	220	1,200	70	800	35
10	3,200	600	1,900	310	1,600	220	1,000	70	600	35
12	2,700	600	1,600	310	1,300	210	800	75	500	40
16	2,000	570	1,200	320	1,000	180	600	75	400	45
20	1,600	540	1,000	270	800	160	500	70	300	40
Depth of cut 切削深度										

1. In cutting Austenitic stainless steels, the use of non-water-soluble cutting fluid is especially effective; in cutting heat-resisting alloy, it is more effective to use water-soluble cutting fluid.
2. It can improve the speed and feed to cut non-deep depth.
3. If the installation rigidity of machine tool or working material is very low, or shaking and noise happen, please in accordance with reducing the and feeding proportionally, or reduce the depth of cutting.
4. Suggest to right o'clock cutting when side working.

1. 切削沃斯田鐵系列不銹鋼時，使用水溶性切削油效果較好，切削耐熱合金時，使用非水溶性切削油效果較好。
2. 若切削深度很淺，可提高轉速和進給速度。
3. 若機床設備或工件材料的安裝剛性很低，或出現震顫和噪音，請相應地同比例降低轉速和進給速度，或者請減少切削深度。
4. 建議在側面加工時使用順銑。