

SBS

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SUBT

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JSB

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MIB

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ACB

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SLB

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SUMIB

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SULBT

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SPEED TIGER

切削條件表

### • SBS,JSB,ACB,SUMIB, SUBT,MIB,SLB,SULBT 2 Flutes Standard Cutting Conditions 切削條件表

Work Material 被削材	Carbon Steels S50C 碳素鋼		Alloy Steels Prehardened Steels SCM SKD SUS HPM NAK 合金鋼, 調質鋼		Hardened Steels SKD61(~50HRC) 調質鋼		Aluminum 鋁		Copper 銅	
	150m/min		120~150m/min		80~100m/min		150~m/min		100~150m/min	
Cutting Speed 切削速度										
R	Speed (min <sup>-1</sup> ) 迴轉數	Feed Rate (mm/min) 進給速度	Speed (min <sup>-1</sup> ) 迴轉數	Feed Rate (mm/min) 進給速度	Speed (min <sup>-1</sup> ) 迴轉數	Feed Rate (mm/min) 進給速度	Speed (min <sup>-1</sup> ) 迴轉數	Feed Rate (mm/min) 進給速度	Speed (min <sup>-1</sup> ) 迴轉數	Feed Rate (mm/min) 進給速度
D0.15R	40,000	400	40,000	360	40,000	330	40,000	440	40,000	400
D0.2R	40,000	500	40,000	480	40,000	500	40,000	480	40,000	480
D0.25R	40,000	620	40,000	610	40,000	620	40,000	540	40,000	540
D0.3R	40,000	750	40,000	750	40,000	750	40,000	600	40,000	600
D0.4R	40,000	960	40,000	1,000	36,000	900	40,000	800	40,000	800
D0.5R	40,000	1,200	38,000	1,200	29,000	900	40,000	1,000	40,000	830
D0.75R	30,000	1,270	25,500	1,100	19,000	700	40,000	1,360	30,000	1,160
D1R	24,000	1,160	19,000	800	14,300	600	40,000	2,000	24,000	1,200
D1.25R	19,000	1,000	15,300	670	11,500	510	38,000	2,400	19,000	1,200
D1.5R	16,000	930	13,000	600	9,600	460	32,000	2,400	16,000	1,200
D1.75R	13,700	930	11,400	580	8,200	450	27,300	2,400	13,600	1,200
D2R	12,000	930	10,000	570	7,200	450	24,000	2,400	12,000	1,200
D2.5R	9,600	930	8,000	560	5,700	450	19,000	2,400	9,600	1,200
D3R	8,000	930	6,400	540	4,800	450	16,000	2,400	8,000	1,200
D4R	6,000	900	4,800	540	3,600	450	12,000	2,400	6,000	1,200
D5R	4,800	900	3,800	540	2,900	450	9,600	2,300	4,800	1,150
D6R	4,000	900	3,200	540	2,400	450	8,000	2,100	4,000	1,050
D7R	3,400	900	2,750	540	2,050	450	6,800	2,000	3,400	1,000
D8R	3,000	900	2,400	540	1,800	450	6,000	2,000	3,000	1,000
D10R	2,400	900	1,900	520	1,450	450	4,800	2,000	2,400	1,000
D12.5R	1,900	720	1,520	450	1,160	420	3,840	1,900	1,920	940

Depth of cut  
(R:球頭半徑)  
切削量基準

0.1XR (~45HRC)	~0.08XR (~50HRC)
(R0.1~0.5=0.2XR)	0.3XR
~0.16XR R ≤ 0.3 (~45HRC)	~0.25XR R ≤ 3 (~45HRC)
~0.17XR R ≥ 4 (~45HRC)	~0.05XR (~50HRC)

1. When slotting, reduce the feed by 60% from above values.
2. Length of overhang is 4 times dia, as standard. When it is longer than 4 times dia, follow figures of above table.
3. Use Oil-mist coolant or Air blow.
4. Adjust both spindle speed and feed according to milling conditions and machine rigidity.

1. 溝加工時之進給速度，請設定為上述值之60%。
2. 刀具夾持突出量以4D為基準，超出上述場合時，請將切削條件作適度之調整。
3. 請使用油霧(Oil-mist)冷卻或吹氣方式(Air blow)進行切削。
4. 主軸迴轉速及床台進給速度，請以相同比例作適度調整。