

產品規格表 **P49-51**
Specification page

● P-LNT 2 Flutes Slotting P-LNT 2刃 溝銑切削													
WORK MATERIAL 被切削材		COPPER, ALUMINUM ALLOY 銅、鋁合金			MILD STEELS, CARBON STEELS, SS400、S55C、FC250、NAK55 一般構造用鋼、碳素鋼			HARDENED STEELS, PREHARDENED STEELS, STAINLESS STEELSSKT、SKD61、NAK80、HPM1、DH 調質鋼、預硬鋼、不銹鋼					
					~32HRC			HRC33~41			HRC42~50		
MILL DIA. (mm) 直徑	Efficient Length 有效長	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	Ap	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	Ap	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	Ap	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	Ap
0.5	2	38,500	480	0.054	32,000	400	0.045	32,000	320	0.038	29,000	240	0.030
	4	33,500	384	0.025	28,000	320	0.021	28,000	256	0.018	25,000	200	0.014
	6	26,500	336	0.007	22,000	280	0.006	22,000	176	0.005	20,000	144	0.004
0.6	2	38,500	576	0.065	32,000	480	0.054	32,000	320	0.045	27,000	240	0.036
	4	33,500	432	0.048	28,000	360	0.040	28,000	240	0.033	25,000	160	0.260
	6	26,500	240	0.022	22,000	200	0.018	22,000	160	0.015	20,000	120	0.012
0.7	4	33,500	432	0.055	28,000	360	0.046	28,000	240	0.039	22,000	240	0.031
	6	33,500	432	0.035	28,000	360	0.029	28,000	160	0.250	22,000	160	0.020
0.8	4	38,500	576	0.064	32,000	480	0.053	32,000	480	0.044	25,000	320	0.035
	6	31,000	432	0.041	26,000	360	0.034	26,000	320	0.028	21,000	240	0.022
	8	26,500	336	0.290	22,000	280	0.024	22,000	240	0.020	18,000	200	0.016
0.9	6	36,000	960	0.071	30,000	800	0.059	28,000	624	0.050	22,000	480	0.040
	8	31,000	768	0.046	26,000	640	0.038	25,000	480	0.032	19,000	320	0.025
	10	24,000	576	0.032	20,000	480	0.027	20,000	400	0.023	16,000	240	0.018
1.0	6	32,500	960	0.084	27,000	800	0.070	26,000	720	0.060	20,000	480	0.040
	8	27,500	768	0.048	23,000	640	0.040	22,000	560	0.040	18,000	320	0.030
	10	23,000	576	0.036	19,000	480	0.030	18,000	400	0.028	15,000	240	0.020
	12	23,000	576	0.024	19,000	480	0.020	18,000	400	0.019	15,000	240	0.010
1.2	16	18,000	288	0.010	15,000	240	0.008	15,000	240	0.007	12,000	160	0.006
	6	27,500	960	0.096	23,000	800	0.080	22,000	720	0.070	18,000	560	0.060
	8	24,000	672	0.084	20,000	560	0.070	19,000	560	0.050	17,000	480	0.050
	10	24,000	672	0.060	20,000	560	0.050	19,000	560	0.040	14,000	320	0.040
1.4	12	20,500	576	0.048	17,000	480	0.040	16,000	400	0.030	14,000	320	0.030
	6	24,000	960	0.156	20,000	800	0.013	19,000	720	0.110	15,000	480	0.090
	10	21,500	768	0.072	18,000	640	0.050	17,000	560	0.040	13,000	320	0.030
	16	18,000	576	0.036	15,000	480	0.030	14,000	400	0.020	11,000	240	0.020
1.5	6	21,500	960	0.168	18,000	800	0.014	18,000	720	0.110	14,000	480	0.090
	8	19,000	768	0.120	16,000	640	0.010	15,000	560	0.080	12,000	320	0.070
	10	19,000	768	0.096	16,000	640	0.080	15,000	560	0.070	12,000	320	0.050
	12	19,000	768	0.072	16,000	640	0.060	15,000	560	0.050	12,000	320	0.040
	14	19,000	768	0.060	16,000	640	0.050	15,000	560	0.045	12,000	320	0.035
	16	17,000	576	0.060	14,000	480	0.050	13,000	400	0.040	10,000	240	0.030
	18	17,000	576	0.036	14,000	480	0.030	13,000	400	0.020	10,000	240	0.020
1.6	20	14,500	400	0.024	12,000	336	0.020	11,000	304	0.015	10,000	240	0.010
	6	20,500	960	0.180	17,000	800	0.150	17,000	720	0.130	13,000	480	0.100
	8	18,000	768	0.168	15,000	640	0.140	15,000	560	0.120	11,000	320	0.100
	10	18,000	768	0.132	15,000	640	0.110	15,000	560	0.090	11,000	320	0.070
	12	18,000	768	0.084	15,000	640	0.070	15,000	560	0.060	11,000	320	0.050
	14	18,000	768	0.072	15,000	640	0.060	15,000	560	0.050	11,000	320	0.040
	16	15,500	576	0.060	13,000	480	0.050	13,000	400	0.040	9,000	240	0.035
1.8	18	15,500	576	0.048	13,000	480	0.040	13,000	400	0.030	9,000	240	0.030
	8	19,000	1,040	0.252	16,000	880	0.210	15,000	800	0.170	12,000	560	0.130
	14	17,000	768	0.096	14,000	640	0.080	14,000	560	0.060	10,000	400	0.050
	20	14,500	576	0.048	12,000	480	0.040	12,000	400	0.040	8,000	320	0.030
	6	18,000	1,040	0.372	15,000	880	0.310	14,000	800	0.260	11,000	560	0.210
2.0	8	18,000	1,040	0.312	15,000	880	0.260	14,000	800	0.220	11,000	560	0.180
	10	15,500	768	0.288	13,000	640	0.240	12,000	560	0.200	9,000	400	0.160
	12	15,500	768	0.156	13,000	640	0.130	12,000	560	0.110	9,000	400	0.090
	14	15,500	768	0.132	13,000	640	0.110	12,000	560	0.090	9,000	400	0.070
	16	15,500	768	0.096	13,000	640	0.080	12,000	560	0.070	9,000	400	0.060
	18	15,500	768	0.084	13,000	640	0.070	12,000	560	0.060	9,000	400	0.050
2.5	20	13,000	576	0.060	11,000	480	0.050	10,000	400	0.050	7,000	320	0.040
	8	14,500	1,040	0.468	12,000	880	0.039	11,000	800	0.330	9,000	560	0.260
	10	14,500	1,040	0.396	12,000	880	0.033	11,000	800	0.280	9,000	560	0.220
	12	14,500	1,040	0.276	12,000	880	0.230	11,000	800	0.190	9,000	560	0.150
	14	12,000	768	0.204	12,000	640	0.170	9,000	560	0.140	7,000	400	0.110
2.5	16	12,000	768	0.144	12,000	640	0.120	9,000	560	0.100	7,000	400	0.080
	20	12,000	768	0.108	12,000	640	0.090	9,000	560	0.090	7,000	400	0.060

Unit/單位: mm

產品規格表 **P49-51**
Specification page

● P-LNT 2 Flutes Slotting P-LNT 2刃 溝銑切削													
WORK MATERIAL 被切削材		COPPER, ALUMINUM ALLOY 銅、鋁合金			MILD STEELS, CARBON STEELS, SS400、S55C、FC250、NAK55 一般構造用鋼、碳素鋼			HARDENED STEELS, PREHARDENED STEELS, STAINLESS STEELSSKT、SKD61、NAK80、HPM1、DH 調質鋼、預硬鋼、不鏽鋼					
MILL DIA. (mm) 直徑	Efficient Length 有效長	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	Ap	~32HRC			HRC33~41			HRC42~50		
					SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	Ap	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	Ap	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	Ap
3.0	8	12,000	1,040	0.432	10,000	880	0.360	10,000	800	0.300	8,000	560	0.240
	10	12,000	1,040	0.348	10,000	880	0.290	10,000	800	0.240	8,000	560	0.190
	12	12,000	1,040	0.324	10,000	880	0.270	10,000	800	0.230	8,000	560	0.180
	16	12,000	768	0.240	10,000	640	0.200	9,000	560	0.170	6,000	400	0.130
	20	12,000	768	0.156	10,000	640	0.130	9,000	560	0.110	6,000	400	0.080
	25	12,000	768	0.132	10,000	640	0.110	9,000	560	0.090	6,000	400	0.070
4.0	12	8,550	1,080	0.456	7,000	880	0.380	7,000	800	0.320	6,000	560	0.260
	16	8,550	1,080	0.432	7,000	880	0.360	7,000	800	0.300	6,000	560	0.240
	20	8,550	776	0.408	7,000	640	0.340	6,000	560	0.280	5,000	400	0.220
	25	8,550	776	0.312	7,000	640	0.260	6,000	560	0.220	5,000	400	0.180
	30	8,550	776	0.228	7,000	640	0.190	6,000	560	0.160	5,000	400	0.130
	35	8,550	776	0.204	7,000	640	0.170	6,000	560	0.140	5,000	400	0.110
DEPTH OF CUT 加工深度													