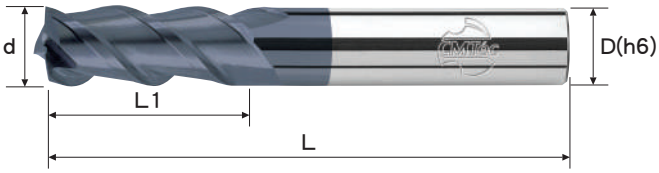
S220 鎢鋼平銑刀- 高導標準型- 3刃

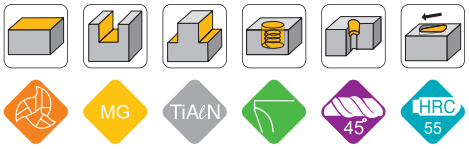
S220 MICRO GRAIN CARBIDE END MILLS- Square Type- High Helix- 3F

· CEH30000A



刃徑 d	公差 Tolerance
Φ<3	0 ~ -0.02
3≦Φ≦10	-0.01 ~ -0.03
10<Φ	-0.01 ~ -0.04

超精銑 Bright Finishing	○
精銑 Finishing	◎
中銑 Semi Finishing	◎
粗銑 Roughing	○



09

刃徑 d	刃長 L1	全長 L	柄徑 D	刃數 F	白刀訂購編號 Uncoated Order No.	鍍膜訂購編號 Coated Order No.
3.0	8	50	6	3	CEH30300	CEH30300A
4.0	10	50	6	3	CEH30400	CEH30400A
5.0	13	50	6	3	CEH30500	CEH30500A
6.0	15	50	6	3	CEH30600	CEH30600A
8.0	20	60	8	3	CEH30800	CEH30800A
10.0	25	75	10	3	CEH31000	CEH31000A
12.0	30	75	12	3	CEH31200	CEH31200A
16.0	35	100	16	3	CEH31600	CEH31600A
20.0	40	100	20	3	CEH32000	CEH32000A

切削條件表 Cutting Condition P.539
技術資料 Technical Data P.622

Table 09 S220 鎢鋼高導型銑刀- 3刃(鍍膜) 切削條件表

SOLID CARBIDE END MILLS- CUTTING CONDITION TABLE

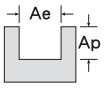
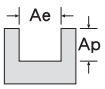
加工材質 Material	合金鋼 Alloy Steels		調質鋼 Hardened Steels		調質鋼 Hardened Steels	
工件料號 Material Code	SCM,SKT,SKD		SKT,SKD		SKT,SKD	
硬度 Hardness	HRC30~45		HRC45~55		HRC55~63	
切削速度 Vc	27m/min		18m/min		16m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
3mm	2,880	75	1,890	75	1,710	70
4mm	2,160	80	1,440	80	1,300	75
5mm	1,710	80	1,170	80	1,040	70
6mm	1,440	155	990	110	860	90
8mm	1,080	155	720	110	650	90
10mm	860	155	580	90	520	75
12mm	720	155	480	80	430	65
14mm	600	130	450	75	410	60
16mm	540	120	360	75	320	55
18mm	480	100	350	60	310	50
20mm	430	95	290	65	270	45
切削量 Cutting Amount (mm)	Ap=0.1D					

Table 10 M520 極細鎢鋼銑刀- 6刃(鍍膜) 切削條件表

SOLID CARBIDE END MILLS- CUTTING CONDITION TABLE

加工材質 Material	合金鋼 Alloy Steels		調質鋼 Hardened Steels		調質鋼 Hardened Steels	
工件料號 Material Code	SCM,SKT,SKD		SKT,SKD		SKT,SKD	
硬度 Hardness	HRC30~45		HRC45~55		HRC55~63	
切削速度 Vc	27m/min		18m/min		16m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
3mm	2,880	75	1,890	75	1,710	70
4mm	2,160	80	1,440	80	1,300	75
5mm	1,710	80	1,170	80	1,040	70
6mm	1,440	155	990	110	860	90
8mm	1,080	155	720	110	650	90
10mm	860	155	580	90	520	75
12mm	720	155	480	80	430	65
14mm	600	130	450	75	410	60
16mm	540	120	360	75	320	55
18mm	480	100	350	60	310	50
20mm	430	95	290	65	270	45
切削量 Cutting Amount (mm)	Ap=0.1D					

※ 切削公式 Cutting Formula：S(主軸轉速) = Vc(切削速度) × 1000 / D(外徑) / π(3.14)　　F(進給速度) = fz(每刃進給量) × Z(刃數) × S(主軸轉速)

1. 當加工聲音尖銳時，請調降主軸轉速(S) (10~40%)。 When the sound is piercing, please lower the spindle speed(S) (10~40%).
2. 當機台震動太大時，請調降進給速度(F) (10~40%)。 When the machine is vibrating, please decrease the feed rate(F) (10~40%).
3. 當主軸負載太大時，請調降進給速度(F) (10~40%)。 When the spindle load is high, please decrease the feed rate(F) (10~40%).
4. 以上數據為建議值，適當的條件仍需視機台狀況，夾治具品質，潤滑冷卻系統…等而改變。
   These are recommended values which depend on the condition of the machine, fixture, lubricating & cooling systems... etc. They may have to be adapted.