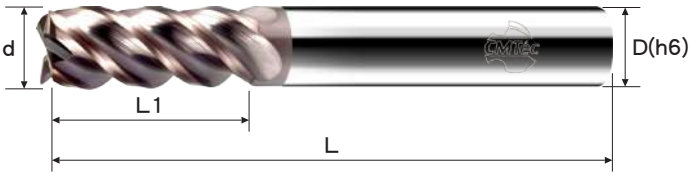
M520 極細鎢鋼不銹鋼用平銑刀- 高導型- 4刃

M520 ULTRA CARBIDE END MILLS FOR STAINLESS- High Helix- 4F

· MEMHM4□□□□F
· MEMH4□□□□F



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	◎

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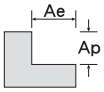
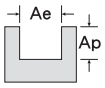
切 削 實 例 CUT EXAMPLES

刃徑 d	刃長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
1.0	3	50	4	4	MEMHM40100F
2.0	5	50	4	4	MEMHM40200F
3.0	8	50	4	4	MEMHM40300F
4.0	10	50	4	4	MEMHM40400F
2.0	5	50	6	4	MEMH40200F
3.0	8	50	6	4	MEMH40300F
4.0	10	50	6	4	MEMH40400F
5.0	13	50	6	4	MEMH40500F
6.0	15	50	6	4	MEMH40600F
7.0	18	60	8	4	MEMH40700F
8.0	20	60	8	4	MEMH40800F
10.0	25	75	10	4	MEMH41000F
12.0	30	75	12	4	MEMH41200F
14.0	30	75	14	4	MEMH4140014F
15.0	35	100	16	4	MEMH41500F
16.0	35	100	16	4	MEMH41600F
18.0	40	100	20	4	MEMH41800F
20.0	45	100	20	4	MEMH42000F
25.0	45	100	25	4	MEMH42500F

➡ 切削條件表 Cutting Condition P.574
➡ 技術資料 Technical Data P.622

Table 75 M520 極細鎢鋼不銹鋼用高導型銑刀- 4刃(鍍膜) 切削條件表

SOLID CARBIDE END MILLS- CUTTING CONDITION TABLE

加工材質 Material	不銹鋼 Stainless Steels			
工件料號 Material Code	SUS304			
硬度 Hardness	—			
切削速度 Vc	70m/min			
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
1mm	22,290	300~1,000	22,290	100~200
2mm	11,146	300~1,000	11,146	100~200
3mm	7,430	300~1,000	7,430	100~200
4mm	5,570	300~1,000	5,570	100~200
5mm	4,460	500~1,000	4,460	200~300
6mm	3,720	500~1,200	3,720	200~300
7mm	3,190	500~1,200	3,190	300~400
8mm	2,790	500~1,100	2,790	300~400
10mm	2,230	500~1,100	2,230	300~400
12mm	1,860	600~800	1,860	250~300
14mm	1,590	600~800	1,590	250~300
15mm	1,490	400~600	1,490	250~300
16mm	1,390	400~600	1,390	250~300
18mm	1,240	300~500	1,240	100~250
20mm	1,120	300~500	1,120	100~250
25mm	890	300~500	890	100~250
切削量 Cutting Amount (mm)	Ap≦0.5D Ae=0.1~0.5D 		Ap≦0.5D 	

※ 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.