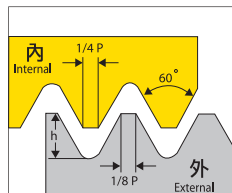


鎢鋼多功能螺旋鑽銑牙刀(鑽孔-螺紋-倒角)- 內螺紋用(ISO規格)

CARBIDE MULTIPURPOSE THREAD MILLS- DRILL-THREAD-CHAMFER- Helix Flute- Internal(ISO Metric)

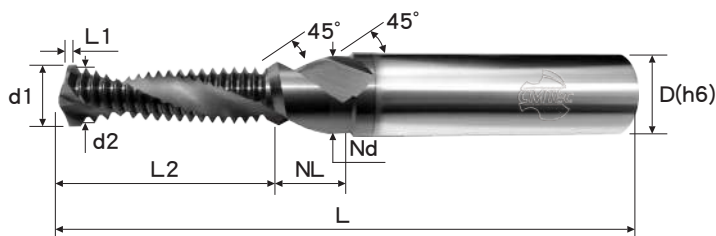
· CSHI200000-000A



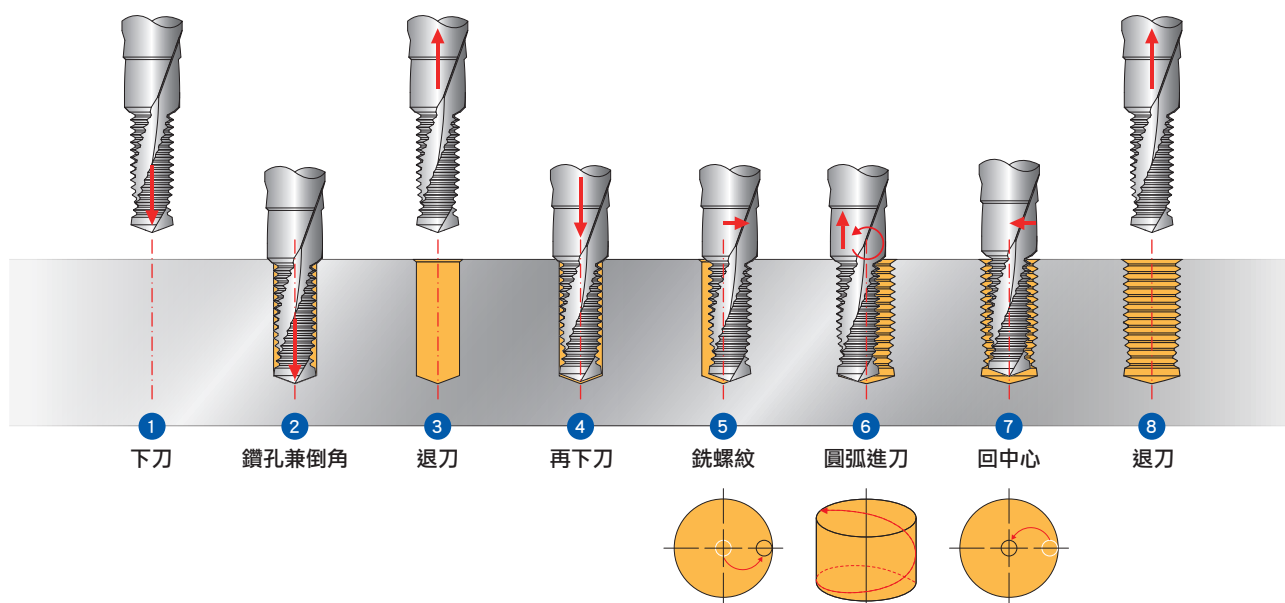
公差 Tolerance class
6g / 6H



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螺紋 Thread	螺距 Pitch	d1	d2	L1	L2	Nd	NL	L	D	h (mm)	牙數 Teeth	刃數 Flute	鍍膜訂購編號 Coated Order No.
粗牙M													
M6	1.00	5.0	4.85	1.0	14.5	6.6	9.5	60	8	0.58	11	2	CSHI205008-100A
M8	1.25	6.8	6.45	1.3	18.2	9.0	16.8	75	10	0.72	11	2	CSHI206810-125A
M10	1.50	8.5	8.08	1.5	23.4	11.0	11.6	80	12	0.87	12	2	CSHI208512-150A
M12	1.75	10.3	9.74	1.5	27.1	13.5	17.9	90	14	1.01	12	2	CSHI210314-175A



→ 切削條件表
Cutting Condition P.565

Table 60

鎢鋼多功能螺旋鑽銑牙刀(鍍膜) 切削條件表

SOLID CARBIDE THREAD MILLS- THREADING CONDITION TABLE

材料種類 Material Group	加工材質 Material		布式硬度 HB	抗拉強度 Strength (N-mm)	切削速度 Vc (m/min)	每轉進給量 f (mm/rev)		每刃進給量 fz (mm)	
						≤6mm	≤12mm	≤6mm	≤12mm
K	灰鑄鐵 Grey Cast Iron	灰鑄鐵 Grey Cast Iron	≤150	≤500	55~85	0.07~0.105	0.105~0.154	0.014~0.035	0.035~0.07
		灰鑄鐵(熱處理) Grey Cast Iron (Heat Treated)	150~300	500~1000	55~85	0.07~0.105	0.105~0.154	0.014~0.035	0.035~0.07
N	銅 Copper	短屑、黃銅、青銅 Short Chips、Brass、Bronze	≤200	≤700	—	0.07~0.21	0.042~0.07	0.021~0.042	0.042~0.07
	鋁 / 鎂 Aluminium / Magnesium	鋁、鎂(非合金) Aluminium、Magnesium Non Alloy	≤100	≤350	70~280	0.07~0.175	0.175~0.21	0.021~0.042	0.042~0.07
		鋁鑄造合金 Aluminium、Cast AlloyS (矽 Si<10%)	≤180	≤600	70~280	0.07~0.175	0.175~0.21	0.021~0.042	0.042~0.07
		鋁鑄造合金 Aluminium、Cast Alloy (矽 Si≥10%)	≤180	≤600	70~280	0.07~0.175	0.175~0.21	0.021~0.042	0.042~0.07
X	塑膠 Plastic	熱塑性塑膠 Thermoplastics	—	—	40~80	0.07~0.175	0.175~0.21	0.021~0.042	0.042~0.07
		熱固性塑膠 Thermosetting Plastic	—	—	40~70	0.07~0.175	0.175~0.21	0.021~0.042	0.042~0.07
		纖維增強塑膠 Fiber Reinforce Plastic	—	—	40~55	0.07~0.105	0.105~0.154	0.014~0.035	0.035~0.07
備註 Remarks		※ f(鑽孔)=每轉進給量(mm/rev.) ※ fz(銑削)=每刃進給量(mm)							

※ 切削公式 Cutting Formula : $S(\text{主軸轉速}) = Vc(\text{切削速度}) \times 1000 / D(\text{外徑}) / \pi (3.14)$ $F(\text{進給速度}) = fz(\text{每刃進給量}) \times Z(\text{刃數}) \times S(\text{主軸轉速})$

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.