

切削参数参考表

Recommended Milling Conditions

加工材料 Work Material		硬质合金 Cemented Carbide			
(R)球头半径 Radius	颈长 Under Neck Length	主轴转速 Spindle Speed	进给速度 Feed	切深量 Depth of Cut	
		min ⁻¹	mm/min	ap mm	ae mm
R0.1	—	30,000	100	0.004	0.004
	0.5	30,000	30	0.002	0.003
R0.2	—	30,000	150	0.008	0.03
	1	30,000	100	0.006	0.025
R0.3	—	30,000	200	0.01	0.05
	1.5	30,000	200	0.01	0.05
R0.5	—	30,000	300	0.02	0.10
	2.5	30,000	300	0.02	0.10
R0.75	—	30,000	300	0.03	0.15
	3.8	30,000	300	0.03	0.15
R1	—	20,000	300	0.04	0.15
	5	20,000	300	0.04	0.15
备注 Notes		※1 请按照切削参数表设定切削参数，否则可能会导致刀具折断、崩损或涂层剥离。 ※2 尽量将刀具的偏摆量抑制到最小，以免因刀具崩损或折断而影响加工精度。 ※3 建议加工前充分考虑主轴的伸缩量和机床的特性。 ※4 请充分考虑减轻切削负载，设定高精度的刀路轨迹。（进刀方式和公差の設定等） ※1 Follow the recommended milling conditions to prevent tool breakage and coating peeling. ※2 Minimal tool runout is required to avoid the tool breakage and to increase the work accuracy. ※3 Recommend to assess the machine characters, such as expansion of the spindle and others before using the tool. ※4 Accurate tool path for approach method, tolerance setting and etc. is required to reduce the cutting load.			

全刃长
Full Cutting Length

长颈
Long Neck

涂层
Coating

球头
Ball

0 硬脆材
Hard Brittle
Material

硬脆材加工
Hard Brittle
Material Milling