



切削参数参考表

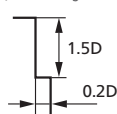
Recommended Milling Conditions

加工材料 Work Material	铝 Aluminium A1070				铝合金 Aluminium Alloy A2017 · A5052 · A7075				铸铝 Aluminium Cast AC8C			
切削速度 Cutting Speed	340m/min		270m/min		380m/min		300m/min		280m/min		200m/min	
外 径 Dia.	侧面 Side Milling		沟槽 Slotting		侧面 Side Milling		沟槽 Slotting		侧面 Side Milling		沟槽 Slotting	
	主轴转速 Spindle Speed	进给速度 Feed	主轴转速 Spindle Speed	进给速度 Feed	主轴转速 Spindle Speed	进给速度 Feed	主轴转速 Spindle Speed	进给速度 Feed	主轴转速 Spindle Speed	进给速度 Feed	主轴转速 Spindle Speed	进给速度 Feed
	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min
0.5	20,000	400	20,000	200	20,000	400	20,000	300	20,000	400	20,000	300
1	20,000	700	20,000	400	20,000	700	20,000	400	20,000	700	20,000	400
1.5	20,000	800	20,000	500	20,000	800	20,000	500	20,000	800	20,000	500
2	20,000	1,000	20,000	600	20,000	1,000	20,000	600	20,000	1,000	20,000	600
2.5	20,000	1,200	20,000	700	20,000	1,200	20,000	700	20,000	1,200	20,000	700
3	20,000	1,300	20,000	800	20,000	1,500	20,000	900	20,000	1,500	20,000	800
4	20,000	1,500	20,000	900	20,000	1,700	20,000	1,100	20,000	1,700	15,900	800
5	20,000	1,700	17,200	900	20,000	2,000	19,100	1,300	17,800	1,700	12,700	800
6	18,000	1,800	14,300	900	20,000	2,200	15,900	1,300	14,900	1,700	10,600	800
7	15,500	1,800	12,300	900	17,300	2,300	13,600	1,300	12,700	1,700	9,100	800
8	13,500	1,800	10,700	1,000	15,100	2,400	11,900	1,300	11,100	1,800	8,000	800
9	12,000	1,800	9,600	1,000	13,400	2,400	10,600	1,300	9,900	1,800	7,100	800
10	10,800	1,800	8,600	1,000	12,100	2,400	9,600	1,300	8,900	1,800	6,400	800
11	9,800	1,900	7,800	1,000	11,000	2,500	8,700	1,300	8,100	1,800	5,800	800
12	9,000	2,000	7,200	1,100	10,100	2,500	8,000	1,400	7,400	1,800	5,300	900

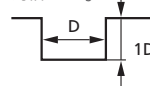
切深量
Depth of Cut

(D:外径 Dia.)

侧面 Side Milling



沟槽 Slotting



备注
Notes

- ※1 请以相同的比率调整主轴转速和进给速度。
(主轴转速使用20,000转以上时, 请进行相同的调整。)
- ※2 请使用刚性好、精度高的机床和夹具。
- ※3 因工件、机床或铣刀刀柄而导致出现振动或异响时, 请变更切削参数。
- ※4 建议使用水溶性切削方式。
- ※ 1 Adjust both the spindle speed and feed at the same rate.
(When using spindle speed 20,000 or more, the same adjustment is required.)
- ※ 2 Use a rigid and precise machine and chuck holder.
- ※ 3 Adjust milling conditions when vibration and abnormal sounds occur according to the rigidity of the machine and the chuck holder, or work clamping condition.
- ※ 4 Water-soluble fluid is recommended.

N 铝合金
Aluminium Alloy



N 铜合金
Copper



O 树脂
Resin

