



## 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	300m/min		220m/min		330m/min		240m/min		250m/min		160m/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 <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min
1	20,000	400	20,000	300	20,000	400	20,000	300	20,000	400	20,000	300
1.5	20,000	500	20,000	400	20,000	500	20,000	400	20,000	500	20,000	400
2	20,000	600	20,000	400	20,000	600	20,000	400	20,000	600	20,000	400
2.5	20,000	700	20,000	500	20,000	700	20,000	500	20,000	700	20,000	500
3	20,000	900	20,000	600	20,000	900	20,000	600	20,000	900	17,000	500
4	20,000	1,000	17,500	700	20,000	1,000	19,000	750	20,000	1,000	13,000	500
5	19,000	1,000	14,000	700	20,000	1,200	15,500	750	16,000	1,000	10,000	500
6	16,000	1,100	11,500	700	17,500	1,400	12,500	750	13,500	1,000	8,500	500
7	13,500	1,100	10,000	750	15,000	1,500	11,000	800	11,500	1,100	7,300	500
8	12,000	1,100	8,800	750	13,000	1,600	9,600	800	9,900	1,200	6,400	500
9	11,000	1,100	7,800	750	11,700	1,600	8,500	800	8,800	1,200	5,700	500
10	9,600	1,100	7,000	800	10,500	1,700	7,600	850	8,000	1,300	5,100	550
11	8,700	1,100	6,400	800	9,600	1,700	6,900	850	7,200	1,300	4,600	550
12	8,000	1,200	5,800	800	8,800	1,700	6,400	900	6,600	1,300	4,200	600
切深量 Depth of Cut  (D:外径 Dia.)	<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p>侧面 Side Milling</p> </div> <div style="text-align: center;"> <p>沟槽 Slotting</p> </div> </div>											
备 注 Notes	<p>※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。)</p> <p>※2 请使用刚性好、精度高的机床和夹具。</p> <p>※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。</p> <p>※4 建议使用水溶性切削方式。</p> <p>※1 Adjust both spindle speed and feed at the same rate. (When using spindle speed 20,000 or more, the same adjustment is required.)</p> <p>※2 Use a rigid and precise machine and chuck holder.</p> <p>※3 Adjust milling conditions when vibration and abnormal sounds occur by the conditions of the machine, chuck holder and work clamping.</p> <p>※4 Water-soluble fluid is recommended.</p>											

N 铝合金  
Aluminium Alloy



N 铜合金  
Copper



O 树脂  
Resin

