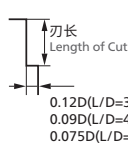


加工材料 Work Material			不锈钢 Stainless Steels SUS304						钛合金 Titanium Alloy Ti-6Al-4V					
外 径 Dia.	颈长 Under Neck Length	L(颈长)/ D(刀径) L/D	侧面 Side Milling		沟槽 Slotting		插铣 Plunging		侧面 Side Milling		沟槽 Slotting		插铣 Plunging	
			主轴转速 Spindle Speed	进给速度 Feed	主轴转速 Spindle Speed	进给速度 Feed	主轴转速 Spindle Speed	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	3	3	17,000	600	14,000	180	14,000	30	15,300	600	12,600	180	12,600	30
	4	4	15,000	450	12,000	150	12,000	20	13,500	450	10,800	150	10,800	20
	5	5	12,000	200	10,000	110	10,000	20	10,800	200	9,000	110	9,000	20
1.5	4.5	3	12,000	650	9,600	200	9,600	30	10,800	650	8,700	200	8,700	30
	6	4	10,300	480	8,500	160	8,500	20	9,300	480	7,700	160	7,700	20
	7.5	5	8,500	250	7,300	120	7,300	20	7,700	250	6,600	120	6,600	20
2	6	3	9,400	780	8,000	210	8,000	30	8,500	780	7,200	210	7,200	30
	8	4	8,000	520	7,200	170	7,200	20	7,200	520	6,500	170	6,500	20
	10	5	7,000	280	6,000	140	6,000	20	6,300	280	5,400	140	5,400	20
2.5	7.5	3	7,700	900	6,800	240	6,800	30	7,000	900	6,100	240	6,100	30
	10	4	6,500	580	6,100	180	6,100	20	5,900	580	5,500	180	5,500	20
	12.5	5	5,800	330	5,200	140	5,200	20	5,200	330	4,700	140	4,700	20
3	9	3	6,500	950	6,200	270	6,200	30	5,900	950	5,600	270	5,600	30
	12	4	5,500	650	5,200	200	5,200	20	5,000	650	4,700	200	4,700	20
	15	5	5,000	350	4,400	150	4,400	20	4,500	350	4,000	150	4,000	20
3.5	10.5	3	6,000	1,000	5,400	300	5,400	30	5,400	1,000	4,900	300	4,900	30
	14	4	5,000	700	4,500	210	4,500	20	4,500	700	4,000	210	4,000	20
	17.5	5	4,500	350	3,800	150	3,800	20	4,100	350	3,400	150	3,400	20
4	12	3	5,800	1,050	4,800	300	4,800	30	5,300	1,050	4,300	300	4,300	30
	16	4	4,600	700	4,000	210	4,000	20	4,200	700	3,600	210	3,600	20
	20	5	4,200	380	3,400	150	3,400	20	6,800	380	3,100	150	3,100	20
4.5	13.5	3	5,600	1,100	4,500	300	4,500	30	5,000	1,100	4,000	300	4,000	30
	18	4	4,400	720	3,600	220	3,600	20	4,000	720	3,200	220	3,200	20
	22.5	5	4,000	380	3,100	150	3,100	20	3,600	380	2,800	150	2,800	20
5	15	3	5,400	1,100	4,100	300	4,100	30	4,900	1,100	3,700	300	3,700	30
	20	4	4,300	720	3,300	220	3,300	20	3,900	720	3,000	220	3,000	20
	25	5	3,900	400	2,800	150	2,800	20	3,500	400	2,500	150	2,500	20
5.5	16.5	3	5,100	1,100	3,900	300	3,900	30	4,600	1,100	3,500	300	3,500	30
	22	4	4,200	750	3,000	220	3,000	20	3,800	750	2,700	220	2,700	20
	27.5	5	3,700	400	2,600	150	2,600	20	3,300	400	2,300	150	2,300	20
6	18	3	4,800	1,100	3,600	300	3,600	30	4,300	1,100	3,200	300	3,200	30
	24	4	4,000	750	2,800	220	2,800	20	3,600	750	2,500	220	2,500	20
	30	5	3,600	400	2,400	150	2,400	20	3,200	400	2,200	150	2,200	20

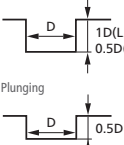
切深量  
Depth of Cut

(D:外径 Dia.)

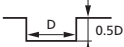
侧面 Side Milling



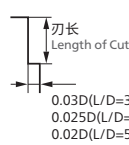
沟槽 Slotting



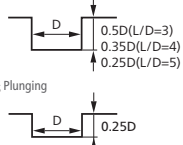
插铣 Plunging



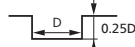
侧面 Side Milling



沟槽 Slotting



插铣 Plunging



备注  
Notes

- ※1 测量刀具长度时请测量子刃。
- ※2 请根据机床刚性和工件的夹持状态等调整切削参数。
- 实际加工时请根据加工形状、目的以及所用的机床等调整切削参数。
- ※3 请以相同的比率调整主轴转速和进给速度。
- ※4 建议使用水溶性切削方式。
- ※5 供应冷却液时请尽量增大流量、加高压力，以排出切屑。
- ※6 插铣时若排屑不佳，请调整轴向切深量和进给速度。
- ※7 排屑不佳可能会导致刀具崩刃和折断，敬请注意。
- ※8 建议使用刚性较大的铣刀刀柄和机床。
- ※9 请尽量缩短刀具的伸出量。
- ※1 Please choose the short end tooth when measure the tool length.
- ※2 Adjust milling condition conforming with machine rigidity and clamping condition.
- Final milling conditions are subject to machining profile, purpose and machine status.
- ※3 Adjust both Spindle Speed and Feed at the same rate.
- ※4 Water-soluble fluid is recommended.
- ※5 Please increasing the coolant flow rate and pressure as much as possible, and supply it sufficiently to the machining point and flute.
- ※6 Please change the Depth of Cut or Feed when chips could not remove smoothly during plunging.
- ※7 Please be noted there would be a possible tool chipping or breakage when the chip removal is insufficient.
- ※8 Use a rigid and precise machine and chuck holder.
- ※9 Overhang of end mill should be as short as possible from spindle nose.

M 不锈钢  
Stainless Steel

S 钛合金  
耐钛合金  
Titanium Alloy  
Heat Resistant Alloy

高效率加工  
High Efficient  
Milling