

RSES230

切削参数参考表 Recommended Milling Conditions

加工材料 Work Material				ABS · MC尼龙 · PTFE ABS · MC nylon · PTFE						聚碳酸酯 · POM · PEEK Polycarbonate · POM · PEEK						亚克力 · 电木 Acrylic · Bakelite					
外径 Dia.	刃长 Length of Cut	颈长 Under neck Length	L(颈长)/D(外径) L/D	主轴转速 Spindle Speed			进给速度 Feed			切深量 Depth of Cut			主轴转速 Spindle Speed			进给速度 Feed			切深量 Depth of Cut		
				侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting
0.8	1.2	-	1.5	20,000	2,640	1,320	1.2	0.16	0.8	20,000	2,200	1,100	1.2	0.16	0.8	20,000	1,760	880	1.2	0.16	0.8
		4	5	19,000	2,130	1,060	1.2	0.08	0.4	19,000	1,770	880	1.2	0.08	0.4	19,000	1,420	710	1.2	0.08	0.4
		6	7.5	17,300	1,750	870	1.2	0.047	0.23	17,300	1,460	730	1.2	0.047	0.23	17,300	1,160	580	1.2	0.047	0.23
		8	10	14,000	1,010	500	1.2	0.02	0.096	14,000	840	420	1.2	0.02	0.096	14,000	670	330	1.2	0.02	0.096
		10	12.5	13,400	880	440	1.2	0.016	0.08	13,400	730	360	1.2	0.016	0.08	13,400	580	290	1.2	0.016	0.08
		12	15	12,700	750	370	1.2	0.013	0.064	12,700	620	310	1.2	0.013	0.064	12,700	500	250	1.2	0.013	0.064
		14	17.5	12,300	640	320	1.2	0.01	0.048	12,300	540	270	1.2	0.01	0.048	12,300	430	210	1.2	0.01	0.048
0.9	1.35	-	1.5	18,500	2,660	1,330	1.35	0.18	0.9	18,500	2,220	1,110	1.35	0.18	0.9	18,500	1,770	880	1.35	0.18	0.9
		6	6.7	16,500	1,890	940	1.35	0.065	0.32	16,500	1,570	780	1.35	0.065	0.32	16,500	1,260	630	1.35	0.065	0.32
		8	8.9	13,500	1,280	640	1.35	0.035	0.17	13,500	1,070	530	1.35	0.035	0.17	13,500	850	420	1.35	0.035	0.17
1	1.5	-	1.5	17,000	2,650	1,320	1.5	0.2	1	17,000	2,210	1,100	1.5	0.2	1	17,000	1,760	880	1.5	0.2	1
		4	4	16,500	2,390	1,190	1.5	0.15	0.75	16,500	1,990	990	1.5	0.15	0.75	16,500	1,590	790	1.5	0.15	0.75
		6	6	15,500	1,980	990	1.5	0.084	0.41	15,500	1,650	820	1.5	0.084	0.41	15,500	1,320	660	1.5	0.084	0.41
		8	8	14,400	1,690	840	1.5	0.05	0.25	14,400	1,400	700	1.5	0.05	0.25	14,400	1,120	560	1.5	0.05	0.25
		10	10	13,000	1,110	550	1.5	0.024	0.12	13,000	920	460	1.5	0.024	0.12	13,000	740	370	1.5	0.024	0.12
		12	12	12,400	980	490	1.5	0.021	0.1	12,400	820	410	1.5	0.021	0.1	12,400	650	320	1.5	0.021	0.1
		14	14	12,000	870	430	1.5	0.018	0.088	12,000	730	360	1.5	0.018	0.088	12,000	580	290	1.5	0.018	0.088
		15	15	11,700	820	410	1.5	0.016	0.08	11,700	680	340	1.5	0.016	0.08	11,700	540	270	1.5	0.016	0.08
		18	18	11,300	680	340	1.5	0.012	0.056	11,300	570	280	1.5	0.012	0.056	11,300	450	220	1.5	0.012	0.056
		20	20	11,000	600	300	1.5	0.008	0.04	11,000	500	250	1.5	0.008	0.04	11,000	400	200	1.5	0.008	0.04
1.5	2.25	-	1.5	13,300	2,590	1,290	2.25	0.3	1.5	13,300	2,150	1,070	2.25	0.3	1.5	13,300	1,720	860	2.25	0.3	1.5
		6	4	12,800	2,350	1,170	2.25	0.22	1.1	12,800	1,950	970	2.25	0.22	1.1	12,800	1,560	780	2.25	0.22	1.1
		8	5.3	12,200	2,060	1,030	2.25	0.14	0.7	12,200	1,720	860	2.25	0.14	0.7	12,200	1,370	680	2.25	0.14	0.7
		10	6.7	11,400	1,850	920	2.25	0.1	0.54	11,400	1,540	770	2.25	0.1	0.54	11,400	1,230	610	2.25	0.1	0.54
		12	8	10,600	1,650	820	2.25	0.075	0.37	10,600	1,380	690	2.25	0.075	0.37	10,600	1,100	550	2.25	0.075	0.37
		15	10	9,400	1,150	570	2.25	0.036	0.18	9,400	960	480	2.25	0.036	0.18	9,400	770	380	2.25	0.036	0.18
		18	12	9,000	1,050	520	2.25	0.032	0.15	9,000	870	430	2.25	0.032	0.15	9,000	700	350	2.25	0.032	0.15
		20	13.3	8,700	980	490	2.25	0.028	0.14	8,700	810	400	2.25	0.028	0.14	8,700	650	320	2.25	0.028	0.14
		23	15.3	8,300	880	440	2.25	0.024	0.11	8,300	730	360	2.25	0.024	0.11	8,300	580	290	2.25	0.024	0.11
		25	16.7	8,100	820	410	2.25	0.02	0.1	8,100	680	340	2.25	0.02	0.1	8,100	550	270	2.25	0.02	0.1
2	3	-	1.5	9,900	2,320	1,160	3	0.4	2	9,900	1,930	960	3	0.4	2	9,900	1,550	770	3	0.4	2
		6	3	9,900	2,320	1,160	3	0.4	2	9,900	1,930	960	3	0.4	2	9,900	1,550	770	3	0.4	2
		8	4	9,500	2,140	1,070	3	0.3	1.5	9,500	1,780	890	3	0.3	1.5	9,500	1,420	710	3	0.3	1.5
		10	5	9,100	1,960	980	3	0.2	1	9,100	1,640	820	3	0.2	1	9,100	1,310	650	3	0.2	1
		12	6	8,600	1,800	900	3	0.16	0.83	8,600	1,500	750	3	0.16	0.83	8,600	1,200	600	3	0.16	0.83
		15	7.5	7,700	1,560	780	3	0.11	0.58	7,700	1,300	650	3	0.11	0.58	7,700	1,040	520	3	0.11	0.58
		20	10	6,200	1,050	520	3	0.048	0.24	6,200	870	430	3	0.048	0.24	6,200	700	350	3	0.048	0.24
		24	12	5,900	950	470	3	0.042	0.2	5,900	790	390	3	0.042	0.2	5,900	630	310	3	0.042	0.2
		30	15	5,300	810	400	3	0.032	0.16	5,300	680	340	3	0.032	0.16	5,300	540	270	3	0.032	0.16
		40	20	4,500	620	310	3	0.016	0.08	4,500	510	250	3	0.016	0.08	4,500	410	200	3	0.016	0.08

- 铝合金 Aluminium Alloy **N**
- 铜合金 Copper **N**
- 树脂 Resin **O**

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Recommended Milling Conditions

加工材料 Work Material				ABS · MC尼龙 · PTFE ABS · MC nylon · PTFE					聚碳酸酯 · POM · PEEK Polycarbonate · POM · PEEK					亚克力 · 电木 Acrylic · Bakelite								
外径 Dia.	刃长 Length of Cut	颈长 Under neck Length	L(颈长)/ D(外径) L/D	主轴转速 Spindle Speed		进给速度 Feed			切深量 Depth of Cut			主轴转速 Spindle Speed		进给速度 Feed			切深量 Depth of Cut					
				侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting	侧面 Side Milling	沟槽 Slotting					
																		mm ⁻¹	mm/min	ap mm	ae mm	ap mm
3	4.5	-	1.5	6,600	2,060	1,030	4.5	0.6	3	6,600	1,710	850	4.5	0.6	3	6,600	1,370	680	4.5	0.6	3	
		10	3.3	6,500	2,010	1,000	4.5	0.55	2.7	6,500	1,670	830	4.5	0.55	2.7	6,500	1,340	670	4.5	0.55	2.7	
		12	4	6,300	1,910	950	4.5	0.45	2.2	6,300	1,590	790	4.5	0.45	2.2	6,300	1,270	630	4.5	0.45	2.2	
		15	5	5,900	1,760	880	4.5	0.3	1.5	5,900	1,460	730	4.5	0.3	1.5	5,900	1,170	580	4.5	0.3	1.5	
		20	6.7	5,200	1,500	750	4.5	0.21	1	5,200	1,250	620	4.5	0.21	1	5,200	1,000	500	4.5	0.21	1	
		24	8	4,600	1,290	640	4.5	0.15	0.75	4,600	1,080	540	4.5	0.15	0.75	4,600	860	430	4.5	0.15	0.75	
		30	10	3,700	920	460	4.5	0.072	0.36	3,700	770	380	4.5	0.072	0.36	3,700	610	300	4.5	0.072	0.36	
4	6	6(d4)	-	1.5	4,900	1,910	950	6	0.8	4	4,900	1,590	790	6	0.8	4	4,900	1,270	630	6	0.8	4
		6(d6)	-	1.5	4,900	1,910	950	6	0.8	4	4,900	1,590	790	6	0.8	4	4,900	1,270	630	6	0.8	4
		10	2.5	4,900	1,910	950	6	0.8	4	4,900	1,590	790	6	0.8	4	4,900	1,270	630	6	0.8	4	
		15	3.8	4,800	1,810	900	6	0.65	3.2	4,800	1,510	750	6	0.65	3.2	4,800	1,200	600	6	0.65	3.2	
		20	5	4,400	1,640	820	6	0.4	2	4,400	1,360	680	6	0.4	2	4,400	1,090	540	6	0.4	2	
		30	7.5	3,600	1,270	630	6	0.23	1.1	3,600	1,060	530	6	0.23	1.1	3,600	850	420	6	0.23	1.1	
		40	10	2,700	850	420	6	0.096	0.48	2,700	710	350	6	0.096	0.48	2,700	570	280	6	0.096	0.48	
5	7.5	-	1.5	3,900	1,820	910	7.5	1	5	3,900	1,510	750	7.5	1	5	3,900	1,210	600	7.5	1	5	
		30	6	3,300	1,410	700	7.5	0.41	2	3,300	1,180	590	7.5	0.41	2	3,300	940	470	7.5	0.41	2	
		40	8	2,700	1,140	570	7.5	0.25	1.2	2,700	950	470	7.5	0.25	1.2	2,700	760	380	7.5	0.25	1.2	
6	9	-	1.5	3,300	1,750	870	9	1.2	6	3,300	1,460	730	9	1.2	6	3,300	1,170	580	9	1.2	6	
		40	6.7	2,600	1,270	630	9	0.43	2.1	2,600	1,060	530	9	0.43	2.1	2,600	850	420	9	0.43	2.1	
		60	10	1,800	780	390	9	0.14	0.72	1,800	650	320	9	0.14	0.72	1,800	520	260	9	0.14	0.72	
		80	13.3	1,600	650	320	9	0.11	0.56	1,600	540	270	9	0.11	0.56	1,600	430	210	9	0.11	0.56	
备注 Notes				<p>※1 本切削参数为粗加工时的参考值。请根据实际的加工形状和所使用机床的刚性等调整切削参数。</p> <p>※2 精加工时，请根据要求精度等调整切削参数。</p> <p>※3 内角等刀具负载增大的部位可能需要调整切削参数。</p> <p>※4 L/D较大的刀具 (L/D≥10) 发生倾斜时，必须降低进给速度或切深量。</p> <p>※5 L/D>20的刀具请根据L/D=20左右的切削参数参考值，充分降低主轴转速、进给速度、切深量，调整切削参数。</p> <p>※6 建议使用吹气冷却方式。</p> <p>※7 加工过程中切屑卡入、缠绕可能会有损加工面品质，因此请注意排屑。</p> <p>※8 请尽量抑制刀具的偏摆量。</p> <p>※9 采用接触方式测量刀具长度时，尤其是φ1以下的尺寸，请注意避免发生崩刃。</p> <p>※10 发生振刀时，请以相同的比率降低主轴转速和进给速度。 此外，主轴转速过低时，也以相同的比率降低。</p> <p>※1 These recommended cutting conditions indicate just reference for roughing. It should be adjusted according to milling shape and machine type.</p> <p>※2 For finishing process, please adjust to the optimized condition to meet the requirement of machining accuracy.</p> <p>※3 Necessary to adjust the cutting condition at the parts overloading against the tools such as inner corner parts.</p> <p>※4 When a tool with L/D 10 times and longer deflects on milling, please reduce Feed or Depth of Cut.</p> <p>※5 For a tool with L/D longer than 20 times, reduce spindle speed, feed rate and depth of cut at sufficient values by referring the cutting conditions of L/D 20 times.</p> <p>※6 Air blow is recommended.</p> <p>※7 Care for chip removal to avoid being stuck or caught during process for better surface quality.</p> <p>※8 Minimize chucking runout.</p> <p>※9 Pay keen attention for tool length measurement with contact-type equipment for the tools under φ1 to avoid cutting edge damage.</p> <p>※10 Reduce both spindle speed and feed at same rate for chattering and also for insufficient spindle speed of a machine.</p>																		

N 铝合金
Aluminium AlloyN 铜合金
CopperO 树脂
Resin树脂加工
Resin Milling