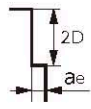
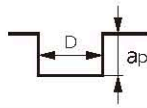
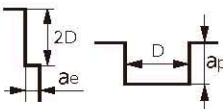
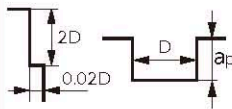


MXH230

切削参数参考表 Recommended Milling Conditions

加工材料 Work Material	不锈钢 Stainless Steels SUS304			钛合金 Titanium Alloy Ti-6AL-4V			超耐热合金 Heat Resistance Alloy Inconel®718			淬火钢 Hardened Steels SKD61 (~52HRC)		
	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	
		mm/min			mm/min			mm/min			mm/min	
		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
刃径 Dia.	min ⁻¹	mm/min		min ⁻¹	mm/min		min ⁻¹	mm/min		min ⁻¹	mm/min	
0.1	50,000	30	15	48,000	30	15	25,000	10	10	50,000	—	15
0.2	50,000	50	25	48,000	50	25	25,000	15	10	47,700	—	20
0.3	50,000	90	35	48,000	90	35	25,000	30	15	31,800	—	20
0.4	47,700	130	50	45,000	130	50	23,000	40	20	23,900	50	25
0.5	38,200	130	50	37,000	130	50	19,000	40	20	19,100	60	30
0.6	34,500	130	50	32,000	130	50	17,000	40	20	16,000	60	30
0.7	30,500	130	50	28,000	130	50	15,000	40	20	13,700	60	30
0.8	26,000	140	50	24,000	140	50	13,000	45	20	12,000	60	30
0.9	22,000	140	55	20,000	140	55	11,000	45	25	10,700	60	30
1	19,100	150	55	18,000	150	55	9,500	50	25	9,500	75	40
1.1	17,500	150	55	16,000	150	55	8,700	50	25	8,700	75	40
1.2	16,300	150	55	15,000	150	55	8,100	50	25	8,000	75	40
1.3	15,100	150	55	14,000	150	55	7,500	50	25	7,400	75	40
1.4	13,900	150	55	13,000	150	55	7,000	50	25	6,900	75	40
1.5	12,700	150	55	12,000	150	55	6,200	50	25	6,400	75	40
1.6	12,000	150	55	11,500	150	55	6,000	50	25	6,000	75	40
1.7	11,300	160	55	10,900	160	55	5,500	50	25	5,700	75	40
1.8	10,600	160	55	10,200	160	55	5,300	50	25	5,300	75	40
1.9	9,900	170	60	9,500	170	60	5,000	55	30	5,000	75	40
2	9,500	170	60	9,100	170	60	4,800	55	30	4,800	75	40
2.1	9,100	170	60	8,700	170	60	4,500	55	30	4,600	75	40
2.2	8,700	170	60	8,300	170	60	4,300	55	30	4,400	75	40
2.3	8,300	170	60	7,900	170	60	4,100	55	30	4,200	75	40
2.4	7,900	180	65	7,500	180	65	4,000	60	30	4,000	75	40
2.5	7,600	180	65	7,200	180	65	3,800	60	30	3,800	75	40
2.6	7,400	180	65	7,000	180	65	3,700	60	30	3,700	75	40
2.7	7,200	180	65	6,800	180	65	3,600	60	30	3,600	75	40
2.8	7,000	180	65	6,500	180	65	3,500	60	30	3,500	75	40
2.9	6,700	190	70	6,200	190	70	3,300	60	30	3,300	75	40
3	6,400	190	70	6,000	190	70	3,200	65	35	3,200	80	40
3.5	5,500	190	70	5,100	190	70	2,700	65	35	2,700	85	45
4	4,800	190	70	4,400	190	70	2,400	65	35	2,400	95	50
4.5	4,200	210	75	3,800	210	75	2,100	70	35	2,100	95	50
5	3,800	230	75	3,400	230	75	1,900	75	40	1,900	95	50
5.5	3,500	240	80	3,100	240	80	1,700	75	40	1,700	95	50
6	3,200	260	85	2,800	260	85	1,600	80	40	1,600	100	50
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 		
	a_e $\phi 0.1 \sim 0.9 = 0.05D$ $\phi 1 \sim 2.9 = 0.07D$ $\phi 3 \sim 6 = 0.15D$			a_p $\phi 0.1 \sim 0.4 = 0.05D$ $\phi 0.5 \sim 1.4 = 0.15D$ $\phi 1.5 \sim 3.5 = 0.5D$ $\phi 4 \sim 6 = 0.75D$			a_e $\phi 0.1 \sim 0.9 = 0.01D$ $\phi 1 \sim 2.9 = 0.015D$ $\phi 3 \sim 6 = 0.03D$			a_p $\phi 0.1 \sim 0.4 = 0.02D$ $\phi 0.5 \sim 1.4 = 0.07D$ $\phi 1.5 \sim 3.5 = 0.2D$ $\phi 4 \sim 6 = 0.3D$		
备注 Notes	<p>※ 请根据机床刚性和工件的夹持状态等调整切削参数。 ※ 请使用发烟性低的切削油。 ※ 请使用刚性较大的铣刀刀柄和机床。 ※ 使用切削油进行加工时，根据排屑和发烟的状况调整切削参数。 ※ Adjust milling condition conforming to machine rigidity and clamping condition. ※ Use cutting fluid with smoke retardant. ※ Use rigid and precise machine and chuck holder. ※ Adjust milling condition with caution for chip evacuation and smoke generation when milling with water-insoluble cutting fluid.</p>											

PCD : 涂层 Coating	PCD : 非涂层 Non-Coating	涂层 Coating	无涂层 Non-Coating	涂层 Coating	无涂层 Non-Coating	涂层 Coating	无涂层 Non-Coating	涂层 Coating	无涂层 Non-Coating	涂层 Coating	无涂层 Non-Coating	涂层 Coating	无涂层 Non-Coating
CBN铣刀 Cubic Boron Nitride	钻石铣刀 Diamond	平底铣刀 Square	长颈平底 铣刀 Long Neck Square	球头铣刀 Ball	长颈球头 铣刀 Long Neck Ball	圆鼻铣刀 Radius	长颈圆鼻 铣刀 Long Neck Radius	锥形铣刀 Taper	锥形球头 铣刀 Taper Ball	锥形圆鼻 铣刀 Taper Radius	钻头 Drilling	螺纹铣刀 Thread milling	倒角刀 Chamfering