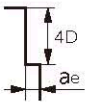
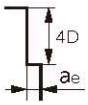
MXH240

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	
刃 径 Dia.	侧面 Side Milling		侧面 Side Milling		侧面 Side Milling	
	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
0.3	21,200	40	20,000	40	10,500	20
0.4	15,900	45	14,000	40	8,000	20
0.5	12,700	45	11,000	40	6,300	20
0.8	9,600	45	8,000	40	4,800	20
1	6,400	50	4,400	50	3,200	25
1.2	4,800	50	3,300	50	2,400	25
1.5	4,200	50	2,900	50	2,100	25
1.8	3,700	55	2,600	50	1,800	25
2	3,200	60	2,200	55	1,600	30
2.5	2,500	60	1,700	55	1,200	30
3	2,100	60	1,600	60	1,000	30
4	1,600	65	1,100	65	800	35
5	1,300	80	900	80	750	40
6	1,100	90	700	90	600	45
切深量 Depth of Cut (D：刃径 Dia.)	侧面 Side Milling  ae ϕ0.3～0.8＝0.03D ϕ1～2.5＝0.04D ϕ3～6＝0.08D				侧面 Side Milling  ae ϕ0.3～0.8＝0.01D ϕ1～2.5＝0.015D ϕ3～6＝0.02D	
备 注 Notes	※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。 ※仅限于侧面切削。 ※Adjust milling condition conforming to machine rigidity and clamping condition. ※Use cutting fluid with smoke retardant. ※Use a rigid and precise machine and chuck holder. ※Available only for side cutting.					