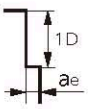
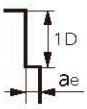
MXH225P

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
0.1	50,000	30	48,000	30	25,000	10
0.2	50,000	50	48,000	50	25,000	15
0.3	50,000	90	48,000	90	25,000	30
0.4	47,700	130	45,000	130	23,000	40
0.5	38,200	130	37,000	130	19,000	40
0.6	34,000	130	33,000	130	17,000	40
0.7	30,000	130	29,000	130	15,000	40
0.8	26,000	140	25,000	140	13,000	45
0.9	22,000	140	21,000	140	11,000	45
1	19,100	150	18,000	150	9,500	50
1.1	17,500	150	16,000	150	8,500	50
1.2	16,000	150	15,000	150	8,000	50
1.3	14,500	150	13,500	150	7,200	50
1.4	13,000	150	12,500	150	6,500	50
1.5	12,700	150	12,000	150	6,200	50
1.6	11,900	150	11,500	150	6,000	50
1.7	11,300	160	10,900	160	5,500	50
1.8	10,700	160	10,300	160	5,200	50
1.9	10,100	170	9,700	170	5,000	55
2	9,500	170	9,100	170	4,800	55
2.5	7,600	180	7,200	180	3,800	60
3	6,400	190	6,000	190	3,200	65
4	4,800	190	4,400	190	2,400	65
5	3,800	230	3,400	230	1,900	75
6	3,200	260	2,800	260	1,600	80
切深量 Depth of Cut (D：刃径 Dia.)	侧面 Side Milling  ae φ0.1～0.9=0.05D φ1～2.5=0.1D φ3～6=0.2D				侧面 Side Milling  ae φ0.1～0.9=0.01D φ1～2.5=0.02D φ3～6=0.04D	
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.					