

MSB345

切削参数参考表 Recommended Milling Conditions

加工材料 Work Material	碳素钢 Carbon Steels S50C				合金钢・调质钢 Alloy Steels・Prehardened Steels SKD・HPM・NAK				淬火钢 Hardened Steels STAVAX・SKD61 (~52HRC)			
	切深量 Depth of Cut		进给速度 Feed	主轴转速 Spindle Speed	切深量 Depth of Cut		进给速度 Feed	主轴转速 Spindle Speed	切深量 Depth of Cut		进给速度 Feed	主轴转速 Spindle Speed
	a _p mm	a _e mm	mm/min	min ⁻¹	a _p mm	a _e mm	mm/min	min ⁻¹	a _p mm	a _e mm	mm/min	min ⁻¹
0.5	0.1	0.3	4,000	40,000	0.1	0.3	3,500	40,000	0.1	0.3	2,500	30,000
1	0.2	0.6	4,500	30,000	0.2	0.6	4,000	30,000	0.2	0.6	3,000	20,000
1.5	0.3	1	4,500	24,000	0.3	1	4,000	24,000	0.2	1	3,000	18,000
2	0.4	1.5	4,500	20,000	0.4	1.5	4,000	20,000	0.3	1.5	3,000	15,000
2.5	0.5	1.7	4,500	16,000	0.5	1.7	4,000	16,000	0.3	2	3,000	12,000
3	0.6	2	4,500	10,000	0.6	2	4,000	10,000	0.4	2	3,000	9,000
4	0.8	2.5	4,500	8,000	0.8	2.5	4,000	8,000	0.5	2	3,000	7,000
5	1.2	3	4,500	6,500	1.2	3	4,000	6,500	0.7	2.5	3,000	5,500
6	1.5	4	4,500	5,000	1.5	4	4,000	5,000	1	3	3,000	4,000
备 注 Notes	※切深量的a _p 表示轴向切入量，a _e 表示步距。 ※请以相同的比率调整主轴转速和进给速度。 ※加工参数会因切深量和机床刚性的状况而有所不同。请每次调整后在使用。 ※刀具伸出量请以4-5D为标准，伸出量超出该标准时请调整切削参数。 ※Depth of Cut, a _p =Axial Depth of Cut / a _e =Radial Depth of Cut. ※Adjust both spindle speed and feed at the same rate. ※Adjust milling conditions according to the volume of depth of cut and rigidity of machine. ※Length of overhang is 4 to 5 times Dia. as standard. When it is longer than 4 to 5 times Dia., adjust the conditions listed above.											

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