



# MXH235P

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	
	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
刃径 Dia.	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min
0.1	50,000	30	40,000	30	25,000	10
0.2	50,000	50	40,000	50	25,000	15
0.3	50,000	90	40,000	90	25,000	30
0.4	43,800	120	35,000	120	22,000	40
0.5	35,000	120	28,000	120	17,000	40
0.6	31,500	120	25,000	120	15,000	40
0.7	28,000	120	22,500	120	14,000	40
0.8	24,500	130	19,600	130	12,000	45
0.9	21,000	130	17,000	130	10,500	45
1	17,500	140	14,000	140	8,700	45
1.1	16,400	140	13,000	140	8,200	45
1.2	15,300	140	12,000	140	7,500	45
1.3	14,100	140	11,000	140	7,000	45
1.4	12,900	140	10,000	140	6,400	45
1.5	11,700	140	9,400	140	5,800	45
1.6	11,200	140	8,900	140	5,500	45
1.7	10,600	140	8,500	140	5,300	45
1.8	10,000	150	8,000	150	5,000	50
1.9	9,400	160	7,500	160	4,700	50
2	8,800	160	7,000	160	4,400	50
2.1	8,500	160	6,800	160	4,200	50
2.2	8,100	160	6,500	160	4,000	50
2.3	7,800	160	6,200	160	3,900	50
2.4	7,400	160	5,900	160	3,700	50
2.5	7,000	170	5,600	170	3,500	55
2.6	6,700	170	5,400	170	3,300	55
2.7	6,400	170	5,100	170	3,200	55
2.8	6,200	170	4,900	170	3,100	55
2.9	6,000	170	4,800	170	3,000	55
3	5,800	170	4,600	170	2,900	55
3.5	5,000	180	4,000	180	2,500	60
4	4,400	180	3,500	180	2,200	60
4.5	3,900	200	3,100	200	1,900	65
5	3,500	210	2,800	210	1,700	70
5.5	3,200	220	2,500	220	1,600	75
6	2,900	230	2,300	230	1,400	75

切深量 Depth of Cut (D: 刃径 Dia.)	侧面 Side Milling	侧面 Side Milling
	 $a_e$ $\phi 0.1 \sim 0.9 = 0.04D$ $\phi 1 \sim 2.9 = 0.05D$ $\phi 3 \sim 6 = 0.1D$	 $a_e$ $\phi 0.1 \sim 0.9 = 0.01D$ $\phi 1 \sim 2.9 = 0.02D$ $\phi 3 \sim 6 = 0.05D$

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.

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