



# MXH230P

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 <sup>-1</sup>	mm/min	min <sup>-1</sup>	mm/min	min <sup>-1</sup>	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	34,500	130	32,000	130	17,000	40	
0.7	30,500	130	28,000	130	15,000	40	
0.8	26,000	140	24,000	140	13,000	45	
0.9	22,000	140	20,000	140	11,000	45	
1	19,100	150	18,000	150	9,500	50	
1.1	17,500	150	16,000	150	8,700	50	
1.2	16,300	150	15,000	150	8,100	50	
1.3	15,100	150	14,000	150	7,500	50	
1.4	13,900	150	13,000	150	7,000	50	
1.5	12,700	150	12,000	150	6,200	50	
1.6	12,000	150	11,500	150	6,000	50	
1.7	11,300	160	10,900	160	5,500	50	
1.8	10,600	160	10,200	160	5,300	50	
1.9	9,900	170	9,500	170	5,000	55	
2	9,500	170	9,100	170	4,800	55	
2.1	9,100	170	8,700	170	4,500	55	
2.2	8,700	170	8,300	170	4,300	55	
2.3	8,300	170	7,900	170	4,100	55	
2.4	7,900	180	7,500	180	4,000	60	
2.5	7,600	180	7,200	180	3,800	60	
2.6	7,400	180	7,000	180	3,700	60	
2.7	7,200	180	6,800	180	3,600	60	
2.8	7,000	180	6,500	180	3,500	60	
2.9	6,700	190	6,200	190	3,300	60	
3	6,400	190	6,000	190	3,200	65	
3.5	5,500	190	5,100	190	2,700	65	
4	4,800	190	4,400	190	2,400	65	
4.5	4,200	210	3,800	210	2,100	70	
5	3,800	230	3,400	230	1,900	75	
5.5	3,500	240	3,100	240	1,700	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  $a_e$ $\phi 0.1 \sim 0.9 = 0.05D$ $\phi 1 \sim 2.9 = 0.07D$ $\phi 3 \sim 0.15D$			侧面 Side Milling  $a_e$ $\phi 0.1 \sim 0.9 = 0.01D$ $\phi 1 \sim 2.9 = 0.015D$ $\phi 3 \sim 6 = 0.03D$			
	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  
Cube Boron Nitride

PCD·单晶  
Diamond

涂层  
Coating

无涂层  
Non-Coating

球头铣刀  
Ball

长颈球头  
Long Neck Ball

圆鼻铣刀  
Radius

长颈圆鼻  
Long Neck Radius

锥形铣刀  
Taper

锥形球头  
Taper Ball

锥形圆鼻  
Taper Radius

钻头  
Drilling

螺纹铣刀  
Thread Milling

倒角刀  
Chamfering