

切削参数参考表 Recommended Milling Conditions

加工材料 Work Material	石墨 Graphite							铝合金压铸件 Aluminum Alloy Die Casting						
	侧面 Side Milling				沟槽 Slotting			侧面 Side Milling				沟槽 Slotting		
	主轴转速 Spindle Speed	进给速度 Feed	切深量 Depth of Cut		主轴转速 Spindle Speed	进给速度 Feed	切深量 Depth of Cut	主轴转速 Spindle Speed	进给速度 Feed	切深量 Depth of Cut		主轴转速 Spindle Speed	进给速度 Feed	切深量 Depth of Cut
刃径 Dia.	min ⁻¹	mm/min	ap mm	ap mm	min ⁻¹	mm/min	ap mm	min ⁻¹	mm/min	ap mm	ap mm	min ⁻¹	mm/min	ap mm
0.5	30,000	1,000	1.5	0.03	30,000	800	0.05	20,000	600	1.5	0.01	20,000	500	0.03
1	30,000	1,200	3	0.05	30,000	1,000	0.1	20,000	1,000	3	0.02	20,000	800	0.1
1.5	25,000	1,500	4.5	0.07	25,000	1,200	0.2	20,000	1,000	4.5	0.05	20,000	800	0.2
2	25,000	2,000	6	0.1	25,000	1,500	0.3	20,000	1,500	6	0.07	20,000	1,200	0.3
3	20,000	2,500	9	0.1	20,000	1,500	0.4	20,000	1,500	9	0.07	20,000	1,200	0.4
4	18,000	2,500	12	0.2	18,000	2,000	0.5	18,000	2,000	12	0.15	18,000	1,500	0.5
5	14,000	3,000	15	0.2	14,000	2,000	0.7	14,000	2,500	15	0.15	14,000	2,000	0.7
6	12,000	3,000	18	0.3	12,000	2,000	1	12,000	2,500	18	0.2	12,000	2,000	1
备 注 Notes	※加工石墨时，请使用石墨专用的加工机床。 此外，进行加工或者操作时为了防止粉尘飞扬或者被吸入身体，请使用吸尘器和防尘口罩。 ※石墨加工建议采用干式切削。 ※如果刀具发生崩刃，或者需要高精度加工时，请降低进给速度。 ※发生振刀时，请以相同的比率降低主轴转速和进给速度。 此外，主轴转速过低时，也以相同的比率降低。													
	※Graphite should be machined by the machining center designed for graphite machining.													
	When handling with graphite material, dust collector and respirator are recommended to protect against graphite dust.													
	※Air blow cooling is recommended for the machining of graphite.													
	※Slow down the feed for high accurate machining to avoid breakage of work piece.													
	※Adjust both spindle speed and feed at the same rate when chattering.													

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