DCRB230

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			
(R)球头半径 Radius	有效长 Effective Length	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	
		min^{-1}	mm/min	ap mm	ap mm	min^{-1}	mm/min	ap mm	ap mm
0.2	1	40,000	1,500	0.08	0.1	20,000	800	0.05	0.08
	2	40,000	1,200	0.05	0.1	20,000	600	0.02	0.05
	4	30,000	1,000	0.05	0.1	20,000	200	0.01	0.02
	6	30,000	800	0.03	0.1	20,000	120	0.01	0.01
0.3	3	30,000	1,500	0.1	0.2	20,000	1,000	0.05	0.1
	6	30,000	1,200	0.08	0.2	20,000	600	0.03	0.05
	9	25,000	1,000	0.07	0.15	18,000	400	0.01	0.02
	12	20,000	800	0.05	0.1	15,000	200	0.01	0.01
0.5	4	30,000	2,500	0.2	0.3	20,000	2,000	0.2	0.3
	6	25,000	2,000	0.15	0.3	20,000	1,500	0.1	0.3
	10	20,000	1,800	0.1	0.3	15,000	800	0.05	0.1
	16	18,000	1,200	0.08	0.2	12,000	500	0.03	0.08
	20	15,000	1,000	0.07	0.2	8,000	300	0.02	0.05
1	6	20,000	3,000	0.5	0.6	20,000	2,000	0.3	0.6
	10	20,000	2,500	0.3	0.6	20,000	1,500	0.3	0.6
	16	18,000	2,000	0.2	0.6	15,000	1,200	0.2	0.5
	20	15,000	1,500	0.2	0.5	10,000	1,000	0.1	0.2
	30	12,000	1,000	0.2	0.5	8,000	500	0.05	0.1
1.5	20	20,000	2,500	0.5	1	15,000	1,500	0.5	1
	40	12,000	1,400	0.3	0.7	7,000	600	0.1	0.3
2	15	20,000	3,000	0.5	1.5	16,000	2,000	0.5	1.5
	30	15,000	2,500	0.5	1.5	12,000	1,500	0.5	1.2
	40	12,000	2,000	0.3	1	8,000	1,000	0.2	0.7
3	30	16,000	3,000	0.6	2	12,000	2,000	0.6	2
	60	8,000	2,000	0.4	2	7,000	1,000	0.3	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.
※Reduce the feed for high accurate machining and to avoid breakage of work piece.
※Adjust both spindle speed and feed at the same rate when chattering.