DCMB

切削参数参考表 Recommended Milling Conditions

加工材料 Work Material		硬质合金 Cemented Carbide			
(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	
		min^{-1}	mm/min	a_p mm	a_p mm
R0.1	–	30,000	100	0.004	0.004
	0.5	30,000	30	0.002	0.003
R0.2	–	30,000	150	0.008	0.03
	1	30,000	100	0.006	0.025
R0.3	–	30,000	200	0.01	0.05
	1.5	30,000	200	0.01	0.05
R0.5	–	30,000	300	0.02	0.10
	2.5	30,000	300	0.02	0.10
R0.75	–	30,000	300	0.03	0.15
	3.8	30,000	300	0.03	0.15
R1	–	20,000	300	0.04	0.15
	5	20,000	300	0.04	0.15

备 注 Notes

※请按照切削参数表设定切削参数，否则可能会导致刀具折断、崩损或涂层剥离。
※尽量将刀具的偏摆量抑制到最小，以免引起刀具的崩损、折断而影响加工精度。
※建议加工前要充分考虑主轴的伸缩量和机床的特性。
※请充分考虑减轻切削负载，设定高精度的刀路轨迹。（进刀方式和公差的设定等）
※Follow the recommended milling conditions to prevent tool breakage and coating peeling.
※Minimal tool runout is required to avoid the tool breakage and to increase the work accuracy.
※Recommend to assess the machine characters, such as expansion of the spindle and others before using the tool.
※Accurate tool path for approach method, tolerance setting and etc. is required to reduce the cutting load.