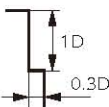
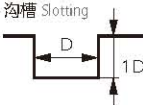


ALZ345 · ALZ345-DLC

切削参数参考表 Recommended Milling Conditions

技术资料

K-024

加工材料 Work Material	铝合金 Aluminum 1070				铝合金 Aluminum Alloy 2017·5052·7075				铸铝 Aluminum Cast AC8C			
切削速度 Cutting Speed	310m/min				350m/min				230m/min			
刃 径 Dia.	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		
		钻孔 Drilling	沟槽 Slotting	侧面 Side Milling		钻孔 Drilling	沟槽 Slotting	侧面 Side Milling		钻孔 Drilling	沟槽 Slotting	侧面 Side Milling
	min ⁻¹	mm/min			min ⁻¹	mm/min			min ⁻¹	mm/min		
1	20,000	200	600	1,100	20,000	200	600	1,100	20,000	150	600	1,100
2	20,000	300	900	1,500	20,000	300	900	1,500	20,000	250	900	1,500
3	20,000	300	1,200	2,000	20,000	300	1,400	2,200	20,000	250	1,200	2,200
4	20,000	300	1,400	2,200	20,000	400	1,800	2,500	18,300	200	1,400	2,300
5	19,700	300	1,500	2,500	20,000	400	2,200	3,100	14,600	150	1,400	2,100
6	16,500	300	1,600	2,500	18,600	400	2,500	3,500	12,200	150	1,400	2,100
7	14,100	200	1,600	2,500	15,900	400	2,500	3,500	10,500	140	1,400	2,100
8	12,300	200	1,700	2,500	13,900	400	2,600	3,500	9,200	120	1,400	2,200
9	11,000	200	1,700	2,500	12,400	300	2,600	3,500	8,100	120	1,400	2,200
10	9,900	100	1,700	2,500	11,100	300	2,600	3,800	7,300	80	1,400	2,200
11	9,000	100	1,800	2,600	10,100	300	2,600	4,100	6,700	80	1,400	2,200
12	8,200	100	1,900	2,700	9,300	300	2,600	4,100	6,100	60	1,500	2,200
切深量 Depth of Cut (D : 刃径 Dia.)	侧面 Side Milling  沟槽 Slotting 											
备 注 Notes	※请以相同的比率调整主轴转速和进给速度。 (主轴转速使用20,000转以上时, 请进行相同的调整。) ※请使用刚性好、精度高的机床和夹具。 ※因工件、机械或铣刀刀柄而导致出现振动或异响时, 请变更切削参数。 ※进行插铣加工时如果切屑容易堵塞, 则请进行分级式铣削。 ※建议使用水溶性切削方式。 ※Adjust both spindle speed and feed at the same rate. (When using spindle speed 20,000 or more, the same adjustment is required.) ※Use a rigid and precise machine and chuck holder. ※Adjust milling conditions when vibration and abnormal sounds occur by the conditions of the machine, chuck holder and work clamping. ※When tending to have chip packing during drilling, step milling is recommended. ※Water soluble cutting fluid is recommended.											

CBN 铣刀
Cubic Boron Nitride

钻石 铣刀
Diamond

PCD · 单晶
PCD-Monocrystal

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Coating

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钻头
Drilling

螺纹铣刀
Thread milling

倒角刀
Chamfering