

ALB225·ALB225-DLC

切削参数参考表 Recommended Milling Conditions

技术资料 K-026

加工材料 Work Material			铝合金 A2017·A5052·A7075							
			一般切削参数 General Milling Conditions				高速切削参数 High Speed Milling Conditions			
			L/D ≥ 10				L/D < 10			
刀具伸出量 Tool Overhang			主轴转速 Spindle Speed min ⁻¹	进给速度 Feed mm/min	切深量 Depth of cut		主轴转速 Spindle Speed min ⁻¹	进给速度 Feed mm/min	切深量 Depth of cut	
(R)球头半径 Radius	刃长 Length of Cut	有效长 Effective Length			ap mm	ae mm			ap mm	ae mm
0.3	0.45	3	20,000	1,000	0.1	0.2	40,000	2,000	0.1	0.2
0.4	0.6	4	20,000	1,000	0.1	0.2	40,000	2,000	0.1	0.2
0.5	2	—	20,000	2,000	0.3	0.3	40,000	4,000	0.3	0.3
	0.75	5	20,000	1,500	0.3	0.3	30,000	3,000	0.3	0.3
0.75	0.75	10	10,000	1,000	0.2	0.2	20,000	2,000	0.2	0.2
	3	—	20,000	2,000	0.3	0.5	40,000	4,000	0.3	0.5
1	1.1	7.5	16,000	1,600	0.3	0.5	30,000	3,000	0.3	0.5
	1.1	15	10,000	1,000	0.2	0.3	20,000	2,000	0.2	0.3
1.5	4	—	20,000	2,000	0.5	0.5	30,000	4,000	0.5	0.5
	1.5	10	15,000	1,500	0.3	0.5	20,000	3,000	0.3	0.5
2	1.5	20	12,000	1,200	0.2	0.5	15,000	2,000	0.2	0.5
	6	—	18,000	2,000	0.6	1	25,000	4,000	0.6	1
2.5	2.5	15	15,000	1,600	0.6	1	20,000	3,000	0.6	1
	2.5	30	12,000	1,200	0.3	1	15,000	2,000	0.3	1
3	8	—	14,000	2,000	0.5	1.5	20,000	4,000	0.5	1.5
	3	20	12,000	1,500	0.5	1.5	16,000	3,000	0.5	1.5
4	3	40	8,000	1,000	0.3	1.5	12,000	2,000	0.3	1.5
	10	—	12,000	3,000	0.8	1.8	20,000	5,000	0.8	1.8
5	3.5	25	8,000	2,000	0.8	1.8	15,000	3,000	0.8	1.8
	3.5	50	5,000	1,500	0.5	1.8	10,000	2,000	0.5	1.8
6	12	—	12,000	3,000	1	2	20,000	5,000	1	2
	6	30	8,000	2,000	1	2	15,000	4,000	1	2
7	6	60	5,000	1,200	0.6	2	10,000	2,000	0.6	2
	4	16	10,000	2,000	1	2	15,000	3,000	1	2
8	5	20	8,000	2,000	2	3	12,000	3,000	2	3
	6	24	6,000	2,000	3	4	10,000	3,000	3	4
备 注 Notes			※ 切深量的ap表示轴向切入量，ae表示步距。 ※ 请以相同的比率调整主轴转速和进给速度。 (机床主轴转速使用20,000转以上时，请进行相同的调整。) ※ 请使用刚性良好、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。 ※ 建议使用水溶性切削方式。 ※ Depth of Cut: ap=Axial Depth of Cut / ae=Radial Depth of Cut. ※ 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 according to the rigidity of the machine and the chuck holder, or work clamping condition. ※ Water soluble cutting fluid is recommended.							

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