

切削参数参考表  
Recommended Milling Conditions

| 加工材料<br>Work Material | 不锈钢<br>Stainless Steels<br>SUS304                                                                                                                                                                                                                                                                                                                                                                                                                                                                |              |                  | 铝合金<br>Aluminium Alloy<br>A5052 |              |                  |
|-----------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|------------------|---------------------------------|--------------|------------------|
|                       | 主轴转速<br>Spindle Speed                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 进给速度<br>Feed | 分级量<br>Step Feed | 主轴转速<br>Spindle Speed           | 进给速度<br>Feed | 分级量<br>Step Feed |
| 直 径<br>Dia.           | mim <sup>-1</sup>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | mm/min       | μm               | mim <sup>-1</sup>               | mm/min       | μm               |
| 0.01                  | 20,000                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 1            | 0.1              | 20,000                          | 1            | 0.1              |
| 0.03                  | 20,000                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 2            | 0.5              | 20,000                          | 2            | 0.5              |
| 0.05                  | 20,000                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 2            | 1                | 20,000                          | 2            | 1                |
| 0.1                   | 20,000                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 5            | 2                | 25,000                          | 5            | 2                |
| 备 注<br>Notes          | <p>※1 请使用适合加工材料和加工内容的冷却方式。</p> <p>※2 请尽量将主轴转速设为振动较小的转速，并尽量抑制刀具的偏摆量。<br/>(可能的话，请确认所用主轴转速下的动态偏摆精度。)</p> <p>※3 请尽量确保加工面平坦后开始加工。</p> <p>※4 取出或夹持刀具时请务必小心。</p> <p>※1 Use appropriate coolant for work material and machining description.</p> <p>※2 Minimize chucking runout by setting spindle speed at minimum oscillation.<br/>(Recommend to measure actual runout at activated rpm)</p> <p>※3 Set up flat surface before start machining.</p> <p>※4 Take extra care when chucking in and out.</p> |              |                  |                                 |              |                  |



- M 不锈钢  
Stainless Steel
- N 铝合金  
Aluminium Alloy
- N 铜合金  
Copper
- O 树脂  
Resin

