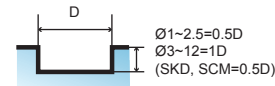
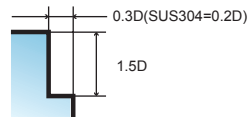




● **SUPE 3 Flutes Standard Cutting Conditions** 切削條件表

Work Material 被削材	Carbon Steels S50C 碳素鋼				Alloy Tool Steels, SCM, SKD 合金工具鋼				Stainless Steels, Titanium Alloys SUS304, SUS316等 不銹鋼, 鈦合金				Prehardened Steels, HPM, NAK 調質鋼(~40HRC)			
Cutting Speed 切削速度	~100m/min				~50m/min				~35m/min				~56m/min			
Diameter 直徑(mm)	Speed (min ⁻¹) 迴轉數	Feed Rate (mm/min) 進給速度			Speed (min ⁻¹) 迴轉數	Feed Rate (mm/min) 進給速度			Speed (min ⁻¹) 迴轉數	Feed Rate (mm/min) 進給速度			Speed (min ⁻¹) 迴轉數	Feed Rate (mm/min) 進給速度		
		Side Milling 側面	Slotting 溝 鑽	Drilling 鑽		Side Milling 側面	Slotting 溝 鑽	Drilling 鑽		Side Milling 側面	Slotting 溝 鑽	Drilling 鑽		Side Milling 側面	Slotting 溝 鑽	Drilling 鑽
1	15,000	400	200	70	15,000	210	100	40	10,000	200	70	-	15,000	200	100	50
1.5	13,000	500	250	70	13,000	270	120	40	7,000	250	70	-	13,000	250	130	50
2	11,000	600	300	100	8,000	350	140	50	5,000	250	70	-	10,000	300	150	70
2.5	10,000	700	400	100	7,000	450	160	60	4,000	250	70	-	8,000	350	170	90
3	9,600	800	550	200	4,200	550	200	100	3,600	250	100	-	5,800	400	250	100
4	7,200	900	650	210	3,200	500	250	120	2,800	250	100	-	4,400	400	250	110
5	5,700	1,000	700	260	2,500	450	250	120	2,200	300	120	-	3,500	500	300	120
6	4,800	1,200	720	300	2,000	400	300	150	1,800	300	120	-	3,000	600	330	130
8	3,600	1,000	760	300	1,600	400	300	120	1,400	300	120	-	2,200	600	330	100
10	3,000	900	800	300	1,300	350	200	100	1,100	300	100	-	1,700	400	200	80
12	2,600	850	740	280	1,100	340	180	80	900	270	100	-	1,500	340	180	70

Depth of cut
(D:直徑Dia)
切削量基準



1. Use a rigid and precise machine and holder.
 2. Please adjust the speed and feed when the cutting depth is large or when machines with low rigidity are used.
 3. Air blow is recommended.
 4. Non-water cutting fluid is recommended for cutting stainless steels.
1. 請使用剛性及精準度較佳之機械及夾頭。
 2. 當切削量過大或機械剛性不足時，請降低迴轉速及進給速度。
 3. 請使用吹氣方式進行切削。
 4. 切削不銹鋼時，請使用非水溶性切削油。