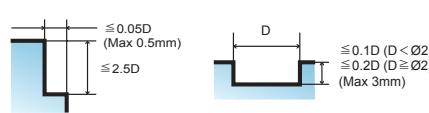
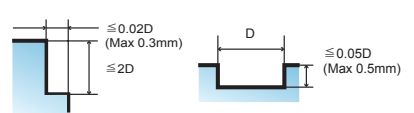


• SFULET,ULET,SULET 2 Flutes Standard Cutting Conditions 切削條件表

Work Material 被削材	Carbon Steels, Alloy Steels S50C, SCM, 鑄鐵FC250等 AISI 1049, Cast iron 碳素鋼, 合金鋼(~30HRC)			Alloy Steels, Tool Steels 調質鋼, SKD61, NAK等 Prehardened steels, AISI H13 合金鋼, 工具鋼(30~45HRC)			Austenitic stainless steels SUS304, SUS316等 AISI 304, AISI 316 沃斯田鐵系列不銹鋼			Hardened steels SKD61, SKD11, NAK, STAVAX等 AISI H13 熱處理鋼(45~50HRC)		
Cutting Speed 切削速度	30~50m/min			30~40m/min			20~30m/min			15~25m/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		Side Milling 側面	Slotting 溝		Side Milling 側面	Slotting 溝		Side Milling 側面	Slotting 溝
1	13,000	60	60	9,500	45	45	8,000	35	35	6,400	25	25
1.5	8,500	60	60	6,400	45	45	5,300	35	35	4,200	25	25
2	6,400	60	60	4,800	45	45	4,000	35	35	3,200	25	25
2.5	5,100	60	60	3,800	45	45	3,200	40	40	2,500	25	25
3	4,200	65	60	3,400	55	45	2,600	40	40	2,100	25	25
4	3,400	80	60	2,700	65	45	2,100	50		1,700	35	25
							1,600		30			
5	2,900	100	60	2,300	80	45	1,800	60		1,500	40	25
							1,350		30			
6	2,500	120	60	2,000	100	50	1,500	75		1,300	50	25
							1,100		30			
8	1,900	130	60	1,500	100	50	1,200	80		1,000	50	25
							900		30			
10	1,600	130	60	1,300	100	50	950	75		800	50	25
							710		30			
12	1,300	120	60	1,100	100	50	800	75		670	50	25
							600		30			
16	1,000	80	40	820	65	30	600	45		500	30	15
							450		20			
20	800	65	30	650	50	25	480	40		400	25	13
							360		15			
25	650	50	25	520	40	20	380	30		320	20	10
							280		12			

Depth of cut
(D:直徑Dia)
切削量基準





1. Please use SI coating tools for work materials of 50~60HRC.
2. In cutting Austenitic stainless steels, the use of non-water-soluble cutting fluid is especially effective.
3. If the rigidity of the machine or the work material installation is very low, or chattering is generated, please reduce the revolution and the feed rate proportionately.
4. When drilling, please set the feed rate at 1/3 or below of the above value.

1. 切削50~60 HRC 以上之材料時，請使用SI鍍膜之刀具。
2. 切削沃斯田鐵系列不銹鋼時，請使用非水溶性切削油效果較好。
3. 機械設備或工件的夾持剛性不足、出現震動時，請以相同比例按上表降低迴轉數及進給速度。
4. 縱向進給時，進給速度請設定為上表之1/3以下。