



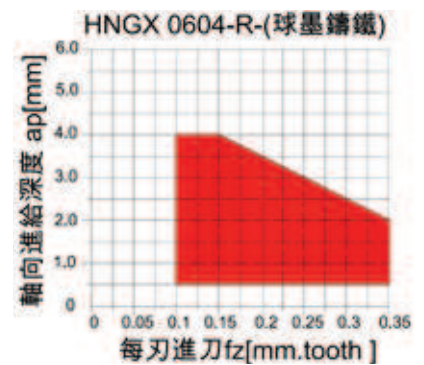
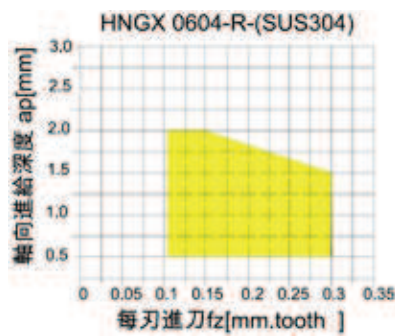
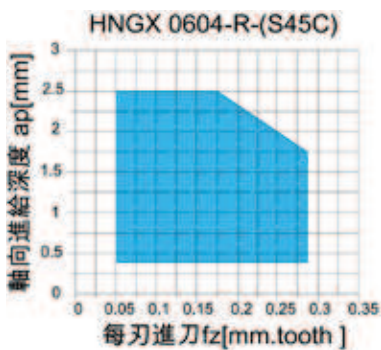
● **HN Cutting Condition**
 切削條件表

HNGX

Item Code 規格碼	Cutting Condition 切削條件參數		ISO Standard for Carbide Tools (Application Range) ISO 碳化物切削刀具標準 (適用切削材料範圍)		
			P	M	K
HNGX0604-R-4225	每刃進給(Fz)	[mm/tooth]	0.05 ~ 0.27	0.1 ~ 0.3	0.1~0.35
	軸向進刀量(Ap)	[mm]	0.5~2.5	0.5~ 2.0	0.5 ~ 4
	切削速度(Vc)	[m/min]	200 ~250	60 ~ 100	135 ~ 182
HNGX0906-R-4225	每刃進給(Fz)	[mm/tooth]	0.1~ 0.3	0.1 ~ 0.27	0.3 ~ 0.5
	軸向進刀量(Ap)	[mm]	1.0 ~ 5.0	1.0 ~ 2.7	0.05 ~ 0.3
	切削速度(Vc)	[m/min]	160 ~230	60 ~ 90	168 ~ 224
HNGX0604-R-3225	每刃進給(Fz)	[mm/tooth]	0.1 ~ 0.27	0.1 ~ 0.3	0.1~0.35
	軸向進刀量(Ap)	[mm]	0.5~2.5	0.5~ 2.0	0.5 ~ 4
	切削速度(Vc)	[m/min]	200 ~250	60 ~ 100	135 ~ 182
HNGX0906-R-3225	每刃進給(Fz)	[mm/tooth]	0.1~ 0.3	0.1 ~ 0.27	0.3 ~ 0.5
	軸向進刀量(Ap)	[mm]	1.0 ~ 5.0	1.0 ~ 2.7	0.05 ~ 0.3
	切削速度(Vc)	[m/min]	160 ~230	60 ~ 90	168 ~ 224

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Nodular Cast Iron/Ductile Iron



Nodular Cast Iron/Ductile Iron

