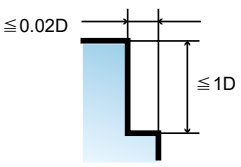
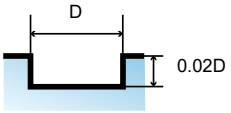
DE 2 刃溝銑

WORK MATERIAL 被切削材 	COPPER, COPPER ALLOY 銅、鋁合金		MILD STEELS, CARBON STEELS, SS400、S55C、FC250、NAK55 一般構造用鋼、碳素鋼		HARDENED STEELS, PREHARDENED STEELS, STAINLESS STEELS SKT、SKD61、NAK80、HPM1、DH 調質鋼、預硬鋼、不鏽鋼			
			~32HRC		33~41HRC		42~50HRC	
MILL DIA. (mm) 直徑	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速
1	47,500	280	17,500	96	12,500	72	11,000	52
1.5	32,000	256	12,500	96	8,900	72	7,900	52
2	24,000	248	9,700	104	7,000	72	6,300	56
2.5	20,000	280	8,200	128	6,100	72	5,300	56
3	16,000	320	6,900	136	5,300	80	4,400	60
3.5	14,000	336	6,000	152	4,600	96	3,800	64
4	12,000	360	5,400	168	4,200	100	3,500	72
4.5	10,500	400	5,100	192	3,900	104	3,200	76
5	9,500	432	4,800	216	3,500	104	3,000	80
5.5	8,800	432	4,400	216	3,200	104	2,700	80
6	7,900	424	4,000	216	2,900	104	2,500	80
6.5	7,500	424	3,700	216	2,700	104	2,300	80
7	6,900	424	3,400	216	2,500	104	2,100	80
7.5	6,400	424	3,200	216	2,300	104	2,000	80
8	5,900	416	3,000	208	2,200	100	1,900	80
8.5	5,600	416	2,800	208	2,000	100	1,700	80
9	5,300	408	2,600	208	1,900	100	1,500	80
9.5	5,100	408	2,500	208	1,800	100	1,400	76
10	4,700	400	2,400	200	1,700	100	1,500	76
11	4,400	400	2,200	200	1,600	100	1,100	76
12	4,000	408	2,000	200	1,400	100	1,200	76
16	3,000	320	1,500	160	1,100	92	800	64
18	2,700	288	1,300	144	900	80	700	56
20	2,400	240	1,200	120	800	72	600	48
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DE
產品規格表 P42-44
Specification page

DE 4 刃側銑

WORK MATERIAL 被切削材 	MILD STEELS, CARBON STEELS, CAST IRON SS400、S55C、FC250 (~750N/mm²) 一般構造用鋼、碳素鋼、鑄鐵		ALLOY STEELS, TOOL STEELS SCM、SKT、SKS、SKD (~30HRC) 合金鋼、工具鋼		HARDENED STEELS, PREHARDENED STEELS SKT、SKD、NAK55、HPM1 (30~38HRC) 調質鋼、預硬鋼		STAINLESS STEELS, HARDENED STEELS SUS304、SKD (38~45HRC)不鏽鋼、調質鋼		HARDENED STEELS, TITANIUM ALLOY STEELS (45~55HRC) 調質鋼、鈦合金		HEAT RESISTANT ALLOY STEELS INCONEL 耐熱合金鋼、高鎳合金	
MILL DIA. (mm) 直徑	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速
3	12,500	880	9,550	672	8,100	500	7,650	492	7,400	436	3,800	176
4	9,750	960	7,550	788	6,400	544	6,050	568	5,850	504	3,000	192
5	7,950	1,040	6,150	840	5,250	580	4,950	620	4,800	536	2,450	196
6	6,750	1,280	5,250	960	4,450	712	4,200	668	4,050	556	2,100	200
8	5,050	1,240	3,950	880	3,350	652	3,150	648	3,050	540	1,600	180
10	4,100	1,160	3,200	840	2,700	580	2,550	572	2,450	508	1,250	172
12	3,400	1,120	2,650	800	2,250	576	2,100	540	2,050	484	1,050	168
16	2,550	960	2,000	752	1,700	508	1,600	444	1,550	404	765	168
20	2,050	788	1,600	604	1,350	472	1,250	412	1,250	368	635	160
25	1,650	704	1,250	540	1,100	428	1,000	388	990	316	510	148

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DE 4 刃溝銑

WORK MATERIAL 被切削材 	MILD STEELS, CARBON STEELS, CAST IRON SS400、S55C、FC250 (~750N/mm²) 一般構造用鋼、碳素鋼、鑄鐵		ALLOY STEELS, TOOL STEELS SCM、SKT、SKS、SKD(~30HRC) 合金鋼、工具鋼		HARDENED STEELS, PREHARDENED STEELS SKT、SKD、NAK55、HPM1(30~38HRC) 調質鋼、預硬鋼		STAINLESS STEELS, HARDENED STEELS SUS304、SKD (38~45HRC)不鏽鋼、調質鋼		HARDENED STEELS, TITANIUM ALLOY STEELS (45~55HRC) 調質鋼、鈦合金		HEAT RESISTANT ALLOY STEELS INCONEL 耐熱合金鋼、高鎳合金	
MILL DIA. (mm) 直徑	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速	SPEED (min^{-1}) 迴轉速	FEED (mm/min) 進給速
3	10,500	584	8,550	544	7,850	416	7,450	368	7,200	352	2,500	100
4	7,750	584	6,400	620	5,900	416	5,550	412	5,400	396	1,900	108
5	6,200	588	5,100	604	4,700	436	4,450	436	4,300	428	1,500	116
6	5,150	592	4,250	508	3,950	460	3,700	456	3,600	436	1,250	116
8	3,850	480	3,200	440	2,950	440	2,800	420	2,700	408	945	124
10	3,100	464	2,550	432	2,350	384	2,250	380	2,150	364	760	116
12	2,600	448	2,150	380	1,950	368	1,850	352	1,800	348	630	116
16	1,950	444	1,600	344	1,500	296	1,400	296	1,350	292	475	88
20	1,550	380	1,300	304	1,200	284	1,100	264	1,100	264	380	88
25	1,250	360	1,000	292	945	252	890	228	865	188	300	84

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