

產品規格表 **P56-59**  
Specification page

### ● P-TTA 2 Flutes Standard Cutting Conditions 標準切削

WORK MATERIAL 被切削材	Copper 銅			Carbon Steels, Alloy Steels, S50C, SCM, 鑄鐵FC250等 AISI 1049, Cast iron 碳素鋼, 合金鋼~HRC30			HRC30~45 Alloy Steels, Tool Steels, 調質鋼, SKD61, NAK等 Prehardened steels, AISI H13 合金鋼, 工具鋼			Austenitic stainless steels SUS304, SUS316等 沃斯田鐵系列不鏽鋼			Hardened steels SKD61, SKD11, NAK, STAVAX等 AISI H13 熱處理鋼HRC45~50		
Cutting Speed 切削速度	80~150m/min			50~100m/min			50~70m/min			30~60m/min			20~40m/min		
Shank 柄徑(mm)	SPEED (min <sup>-1</sup> ) 迴轉速	Feed Rate (mm/min) 進給速度		SPEED (min <sup>-1</sup> ) 迴轉速	Feed Rate (mm/min) 進給速度		SPEED (min <sup>-1</sup> ) 迴轉速	Feed Rate (mm/min) 進給速度		SPEED (min <sup>-1</sup> ) 迴轉速	Feed Rate (mm/min) 進給速度		SPEED (min <sup>-1</sup> ) 迴轉速	Feed Rate (mm/min) 進給速度	
		Side Milling 側銑	Slotting 溝銑切 削		Side Milling 側銑	Slotting 溝銑切 削		Side Milling 側銑	Slotting 溝銑切 削		Side Milling 側銑	Slotting 溝銑切 削		Side Milling 側銑	Slotting 溝銑切 削
4	12,000	1,000	330	7,500	600	480	5,200	400	320	3,100	300	180	2,400	75	60
6	8,000	1,000	330	5,000	600	480	3,500	400	320	2,100	300	180	1,600	75	60
8	6,000	1,000	330	4,000	520	410	2,800	350	280	1,600	260	150	1,200	65	50
10	4,800	1,000	330	3,200	450	360	2,200	300	240	1,300	230	130	1,000	65	50
12	4,000	1,000	330	2,700	410	320	1,900	270	210	1,100	210	120	800	65	50
16	3,000	1,000	330	2,000	240	190	1,400	210	160	840	160	100	600	60	45

  

DEPTH OF CUT 加工深度	$\leq 0.1D (D \leq \phi 3)$ $\leq 0.2D (D > \phi 3)$		$\leq 1.5D$	$\leq 0.1D (D < \phi 2)$ $\leq 0.2D (D \geq \phi 2)$		$\leq 0.02D$		$\leq 0.02D (D < \phi 0.5)$ $\leq 0.05D (\phi 0.5 \leq D \leq \phi 2)$ $\leq 0.1D (D > \phi 2)$
	Side Milling 側銑	Slotting 溝銑切 削		Side Milling 側銑	Slotting 溝銑切 削	Side Milling 側銑	Slotting 溝銑切 削	

產品規格表 **P60-61**  
Specification page

### ● P-LTTA 2 Flutes Standard Cutting Conditions 標準切削

WORK MATERIAL 被切削材	Carbon Steels, Alloy Steels, S50C, SCM, 鑄鐵FC250等 AISI 1049, Cast iron 碳素鋼, 合金鋼~HRC30			HRC30~45 Alloy Steels, Tool Steels, 調質鋼, SKD61, NAK等 Prehardened steels, AISI H13 合金鋼, 工具鋼			Austenitic stainless steels SUS304, SUS316等 沃斯田鐵系列不鏽鋼			Hardened steels SKD61, SKD11, NAK, STAVAX等 AISI H13 熱處理鋼HRC45~50		
Cutting Speed 切削速度	30~50m/min			30~40m/min			20~30m/min			15~25m/min		
Shank 柄徑(mm)	SPEED (min <sup>-1</sup> ) 迴轉速	Feed Rate (mm/min) 進給速度		SPEED (min <sup>-1</sup> ) 迴轉速	Feed Rate (mm/min) 進給速度		SPEED (min <sup>-1</sup> ) 迴轉速	Feed Rate (mm/min) 進給速度		SPEED (min <sup>-1</sup> ) 迴轉速	Feed Rate (mm/min) 進給速度	
		Side Milling 側銑	Slotting 溝銑切 削		Side Milling 側銑	Slotting 溝銑切 削		Side Milling 側銑	Slotting 溝銑切 削		Side Milling 側銑	Slotting 溝銑切 削
4	3,400	80	60	2,700	65	45	2,100	50		1,700	35	25
							1,600		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			

  

DEPTH OF CUT 加工深度	$\leq 0.05D$ (Max 0.5mm)		$\leq 2.5D$	$\leq 0.1D (D < \phi 2)$ $\leq 0.2D (D \geq \phi 2)$ (Max 3mm)		$\leq 0.02D$ (Max 0.3mm)		$\leq 0.05D$ (Max 0.5mm)
	Side Milling 側銑	Slotting 溝銑切 削		Side Milling 側銑	Slotting 溝銑切 削	Side Milling 側銑	Slotting 溝銑切 削	

Unit/單位: mm