

產品規格表 **P63**
Specification page

• P-SSB/P-MSB/P-SB 2 Flutes Regular Milling 標準切削

WORK MATERIAL 被切削材	COPPER, ALUMINUM 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				HRC33~41				HRC42~50			
	R	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	DEPTH OF CUT 加工深度 Ap Pf		SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	DEPTH OF CUT 加工深度 Ap Pf		SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	DEPTH OF CUT 加工深度 Ap Pf		SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	DEPTH OF CUT 加工深度 Ap Pf
R 0.05	40,000	120	0.003	0.005	32,000	60	0.005	0.005	32,000	40	0.005	0.005	32,000	28	0.005	0.005
R 0.1	40,000	240	0.010	0.020	32,000	160	0.010	0.010	32,000	160	0.010	0.010	32,000	160	0.005	0.005
R0.2	40,000	392	0.020	0.080	32,000	328	0.020	0.080	32,000	264	0.040	0.080	32,000	164	0.020	0.040
R0.3	40,000	464	0.030	0.120	32,000	392	0.030	0.120	32,000	336	0.060	0.120	32,000	212	0.030	0.060
R0.4	40,000	528	0.040	0.160	32,000	440	0.040	0.160	31,500	336	0.080	0.160	27,500	232	0.040	0.080
R0.5	32,000	600	0.050	0.200	31,500	496	0.050	0.200	25,000	320	0.100	0.200	22,000	228	0.050	0.100
R1	19,000	600	0.200	0.400	15,500	496	0.200	0.400	12,500	320	0.200	0.400	11,000	232	0.100	0.200
R1.5	12,500	608	0.300	0.600	10,500	504	0.300	0.600	8,450	324	0.300	0.600	7,400	232	0.150	0.300
R2	9,500	608	0.400	0.800	7,950	504	0.400	0.800	6,350	356	0.400	0.800	5,550	296	0.200	0.400
R3	6,300	640	0.600	1.200	5,300	536	0.600	1.200	4,200	372	0.600	1.200	3,700	312	0.300	0.600
R4	4,750	760	0.800	1.600	3,950	632	0.800	1.600	3,150	444	0.800	1.600	2,750	364	0.400	0.800
R5	3,800	712	1.000	2.000	3,150	596	1.000	2.000	2,500	420	1.000	2.000	2,200	344	0.500	1.000
R6	3,170	672	1.200	2.400	2,650	560	1.200	2.400	2,100	392	1.200	2.400	1,850	344	0.600	1.200
R8	2,400	504	1.600	3.200	1,990	420	1.600	3.200	1,580	296	1.600	3.200	1,390	260	0.800	1.600
R10	1,900	400	2.000	4.000	1,590	336	2.000	4.000	1,260	232	2.000	4.000	1,110	208	1.000	2.000

DEPTH OF CUT
加工深度

• P-SSB/P-MSB/P-SB 2 Flutes HIGH-SPEED LIGHT Milling P-SSB/P-MSB/P-SB 2刃 高速切削

WORK MATERIAL 被切削材	COPPER, ALUMINUM 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							
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	R	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	DEPTH OF CUT 加工深度 Ap Pf		SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	DEPTH OF CUT 加工深度 Ap Pf		SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	DEPTH OF CUT 加工深度 Ap Pf		SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	DEPTH OF CUT 加工深度 Ap Pf
R 0.5	50,000	2,680	0.020	0.050	50,000	2,240	0.020	0.050	50,000	2,000	0.020	0.050	47,500	1,800	0.020	0.050
R1	31,500	2,680	0.040	0.100	25,000	2,240	0.040	0.100	24,500	2,000	0.040	0.100	23,500	1,800	0.040	0.100
R1.5	21,000	2,680	0.060	0.150	16,500	2,240	0.060	0.150	16,000	2,000	0.060	0.150	15,500	1,800	0.060	0.150
R2	15,500	3,264	0.080	0.200	15,500	2,720	0.080	0.200	15,000	2,200	0.080	0.200	13,500	1,960	0.080	0.200
R3	10,500	4,128	0.120	0.300	13,500	3,440	0.300	0.600	11,500	2,200	0.300	0.600	9,500	1,800	0.120	0.300
R4	7,900	3,072	0.160	0.400	10,000	2,560	0.400	0.800	8,950	1,680	0.400	0.800	7,150	1,360	0.160	0.400
R5	6,300	2,496	0.200	0.500	8,250	2,080	0.500	1.000	7,150	1,360	0.500	1.000	5,700	1,080	0.200	0.500
R6	5,250	2,064	0.240	0.600	6,850	1,720	0.500	2.400	5,950	1,120	0.500	2.400	4,750	880	0.240	0.600
R8	4,950	1,240	0.320	0.800	4,110	1,032	0.500	3.200	4,460	840	0.500	3.200	3,560	656	0.320	0.800
R10	3,950	992	0.400	1.000	3,290	824	0.500	4.000	3,570	672	0.500	4.000	2,850	528	0.320	1.000

DEPTH OF CUT
加工深度