



RD - Cutting CONDITION

切削條件表

Work Material 加工材質	Hardness 硬度	Cutting Speed 切削速度	Feed	Feed per Tooth 進給 fz(mm /tooth)				
			進給	Diameter 直徑 ØD (mm)				
		(m/min)	fz(mm/t)	2.5R	3.5R	5R	6R	8R
Carbon Steel 碳素鋼	HB 160~260	140~200	0.15~0.35	0.1~0.5	0.15~1.	0.2~1.	0.5~1.5	0.5~2.
Pre-Hardened Steel 預硬鋼	HB 280~400	100~160	0.1~0.2	0.1~0.5	0.15~0.8	0.2~1.	0.2~1.2	0.3~1.5
Hardened steel 淬火鋼	HRC 40~52	80~120	0.1~0.15	0.07~0.2	0.1~0.6	0.15~0.8	0.15~1.2	0.2~1.2
	HRC 52~63	60~80	0.07~0.15	0.05~0.1	0.05~0.2	0.07~0.5	0.1~0.8	0.15~1.
Stainless Steel 不銹鋼	HB 150~250		0.1~0.15	0.1~0.3	0.1~0.5	0.15~0.8	0.2~1.	0.2~1.2
Gray Cast Iron 灰口鑄鐵	HB 170~300	120~185	0.12~0.3	0.1~0.5	0.15~1.	0.2~1.	0.5~1.5	0.5~2.
Aluminum Alloy 鋁合金(un-coating 無塗層)	HB 90~150	250~400	0.05~0.35		0.15~0.8	0.2~1.	0.5~1.5	0.5~2.
Aluminum Alloy 鋁合金(TB coating 塗層)		300~700	0.05~0.35		0.15~0.8	0.2~1.	0.5~1.5	0.5~2.