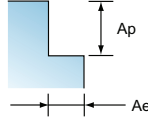
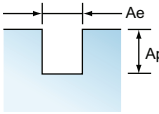


產品規格表 **P181**
Specification page

• CMF Series Side Milling 側銑切削

Work Material 被削材	Aluminum alloy expanding material A7075 Aluminum alloy casting< Si1 13% 鋁合金		Copper 銅	
Diameter 直徑 (mm)	Speed 迴轉速 (min^{-1})	Feed Rate 進給速度 (mm/min)	Speed 迴轉速 (min^{-1})	Feed Rate 進給速度 (mm/min)
2.5	30000	1733	11000	533
3	25000	1933	9250	667
4	18750	2200	6950	867
5	15000	2467	5550	1067
6	12500	2767	4650	1333
8	9400	2100	3500	1013
10	7500	1667	2800	800
12	6250	1400	2300	667
16	4700	1033	1750	507
20	3750	833	1400	400
Depth of cut 切削基準量 (D=直徑Dia)	*Side milling (側銑)  Ap=2.0D Ae=0.05D			
Vc 線速度	235.5		87.92	
Z 刃數	3		3	
Fz	0.11		0.1	

• CMF Series Slotting 溝銑切削

Work Material 被削材	Aluminum alloy expanding material A7075 Aluminum alloy casting< Si1 13% 鋁合金		Copper 銅	
Diameter 直徑 (mm)	Speed 迴轉速 (min^{-1})	Feed Rate 進給速度 (mm/min)	Speed 迴轉速 (min^{-1})	Feed Rate 進給速度 (mm/min)
2.5	20000	1000	118000	567
3	18000	1200	9840	660
4	15000	1533	7440	733
5	13000	1867	5920	800
6	12000	2667	4960	900
8	10000	2027	3680	700
10	8000	14933	2960	567
12	6660	1333	2480	467
16	5000	867	1840	333
20	4000	667	1520	267
Depth of cut 切削基準量 (D=直徑Dia)	*Slotting (溝銑)  Ap=1.5D Ae=1D			
Vc 線速度	251.2		92.944	
Z 刃數	3		3	
Fz	0.1		0.14	