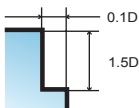
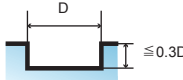
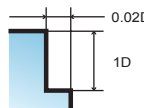
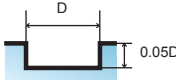


● SURTA 3 Flutes Standard Cutting Conditions 切削條件表

Work Material 被削材	Carbon Steels, Alloy Steels S50C, SCM, 鑄鐵FC250等 AISI 1049, Cast iron 碳素鋼, 合金鋼(~30HRC)		Alloy Steels, Tool Steels 調質鋼, SKD61, NAK等 Prehardened Steels, AISI H13 合金鋼, 工具鋼(30~45HRC)		Austenitic stainless Steels SUS304, SUS316等 AISI 304, AISI 316 沃斯田鐵系列不銹鋼		Hardened Steels SKD61, SKD11, NAK, STAVAX等 AISI H13 熱處理鋼(45~50HRC)					
Cutting Speed 切削速度	50~100m/min		50~70m/min		30~60m/min		20~40m/min					
Diameter 直徑(mm)	Speed (min ⁻¹) 迴轉數	Feed Rate (mm/min) 進給速度		Speed (min ⁻¹) 迴轉數	Feed Rate(mm/min) 進給速度		Speed (min ⁻¹) 迴轉數	Feed Rate (mm/min) 進給速度				
		Side Milling 側面	Slotting 溝		Side Milling 側面	Slotting 溝		Side Milling 側面	Slotting 溝			
2	11,000	180	180	7,200	110	110	6,000	90	90	4,800	45	45
3	8,500	200	160	5,300	130	100	4,400	110	66	3,200	55	44
4	7,200	360	290	4,400	220	180	3,000	180	110	2,400	67	54
5	6,000	380	300	3,600	230	180	2,400	190	110	1,900	70	56
6	5,300	420	340	3,200	240	190	2,200	210	130	1,600	75	60
8	4,000	450	360	2,400	240	190	1,600	220	130	1,200	65	50
10	3,200	390	310	1,900	190	150	1,300	190	110	1,000	65	50
12	2,700	330	260	1,600	160	130	1,000	150	90	800	65	50

切削量基準 Depth of cut (D:直徑Dia)				
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▲ Caution

1. Please use SI coating tools for work materials of 50~60HRC.
2. In cutting Austenitic stainless Steels, the use of non-water-soluble cutting fluid is especially effective.
3. If the rigidity of the machine or the work material installation is very low, or chattering is generated, please reduce the revolution and the feed rate proportionately.
4. When drilling, please set the feed rate at 1/3 or below of the above value.

▲ 注意事項

1. 切削50~60 HRC 以上之材料時，請使用SI鍍膜之刀具。
2. 切削沃斯田鐵系列不銹鋼時，請使用非水溶性切削油效果較好。
3. 機械設備或工件的夾持剛性不足、出現震動時，請以相同比例按上表降低迴轉數及進給速度。
4. 縱向進給時，進給速度請設定為上表之1/3以下。