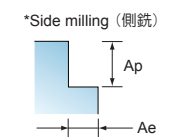
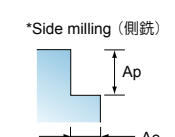
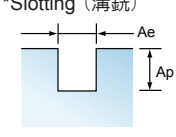
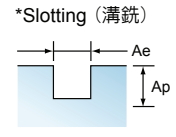


產品規格表 **P235**  
Specification page

| ● KKM Side Milling 側面切削            |   |                                      |   |                                      |  |                                      |  |                                      |                                 |                                      |                               |
|------------------------------------|---|--------------------------------------|---|--------------------------------------|--|--------------------------------------|--|--------------------------------------|---------------------------------|--------------------------------------|-------------------------------|
| Work Material<br>被削材               | Mild seteels Carbon steels,<br>Cast iron<br>SS400.S55c.FC250<br>(-750N/mm2)<br>一般構造鋼.碳素鋼.鑄鐵   |                                      | Alloy Steels.Tool Steels.<br>SCM.SKT.SKS.SKD<br>~HRC30合金鋼.工具鋼 |                                      | Hardened steels.<br>Prehardened steels.<br>(Free-cutting)<br>SKT.SKD.NAK55.HPM1<br>調質鋼HRC30~38 |                                      | Hardened steels.<br>Titanium alloys.<br>Heat resistant alloys<br>steels.<br>調質鋼HRC45~55  |                                      | Hardened steels.<br>調質鋼HRC55~60 |                                      |                               |
|                                    | Diameter<br>直徑<br>(mm)  | Speed<br>迴轉速<br>(min <sup>-1</sup> ) | Feed Rate<br>進給速度<br>(mm/min)                                 | Speed<br>迴轉速<br>(min <sup>-1</sup> ) | Feed Rate<br>進給速度<br>(mm/min)  | Speed<br>迴轉速<br>(min <sup>-1</sup> ) | Feed Rate<br>進給速度<br>(mm/min)  | Speed<br>迴轉速<br>(min <sup>-1</sup> ) | Feed Rate<br>進給速度<br>(mm/min)   | Speed<br>迴轉速<br>(min <sup>-1</sup> ) | Feed Rate<br>進給速度<br>(mm/min) |
| 6                                  | 6760  | 1280                                 | 5250  | 960                                  | 4450   | 712                                  | 4050   | 556                                  | 2100                            | 200                                  |                               |
| 8                                  | 5050  | 1240                                 | 3950  | 880                                  | 3350   | 652                                  | 3050   | 540                                  | 1600                            | 180                                  |                               |
| 10                                 | 4100  | 1160                                 | 3200  | 840                                  | 2700   | 580                                  | 2450   | 508                                  | 1250                            | 172                                  |                               |
| 12                                 | 3400  | 1120                                 | 2650  | 800                                  | 2250   | 576                                  | 2050   | 484                                  | 1050                            | 168                                  |                               |
| 16                                 | 2550  | 960                                  | 2000  | 752                                  | 1700   | 508                                  | 1550   | 404                                  | 765                             | 168                                  |                               |
| 20                                 | 2050  | 788                                  | 1600  | 604                                  | 1350   | 472                                  | 1250   | 368                                  | 635                             | 160                                  |                               |
| 25                                 | 1650  | 704                                  | 1250  | 540                                  | 1100   | 428                                  | 990  | 316                                  | 510                             | 148                                  |                               |
| Depth of cut<br>切削基準量<br>(D=直徑Dia) | <p>*Side milling (側銑)</p>  <p>Ae: ≤0.3 D Ap: 1.5 D</p> |                                      |   |                                      |  |                                      | <p>*Side milling (側銑)</p>  <p>Ae: ≤0.15 D Ap: 1.0 D</p> |                                      |                                 |                                      |                               |

| ● KKM Slotting 溝標準切削               |  |                                      |   |                                      |  |                                      |   |                                      |                                 |                                      |                               |
|------------------------------------|--|--------------------------------------|---|--------------------------------------|--|--------------------------------------|---|--------------------------------------|---------------------------------|--------------------------------------|-------------------------------|
| Work Material<br>被削材               | Mild seteels Carbon steels,<br>Cast iron<br>SS400.S55c.FC250<br>(-750N/mm2)<br>一般構造鋼.碳素鋼.鑄鐵                              |                                      | Alloy Steels.Tool Steels.<br>SCM.SKT.SKS.SKD<br>~HRC30合金鋼.工具鋼 |                                      | Hardened steels.<br>Prehardened steels.<br>(Free-cutting)<br>SKT.SKD.NAK55.HPM1<br>調質鋼HRC30~38 |                                      | Hardened steels.<br>Titanium alloys.<br>Heat resistant alloys<br>steels.<br>調質鋼HRC45~55                                       |                                      | Hardened steels.<br>調質鋼HRC55~60 |                                      |                               |
|                                    | Diameter<br>直徑<br>(mm)   | Speed<br>迴轉速<br>(min <sup>-1</sup> ) | Feed Rate<br>進給速度<br>(mm/min)                                 | Speed<br>迴轉速<br>(min <sup>-1</sup> ) | Feed Rate<br>進給速度<br>(mm/min)  | Speed<br>迴轉速<br>(min <sup>-1</sup> ) | Feed Rate<br>進給速度<br>(mm/min)   | Speed<br>迴轉速<br>(min <sup>-1</sup> ) | Feed Rate<br>進給速度<br>(mm/min)   | Speed<br>迴轉速<br>(min <sup>-1</sup> ) | Feed Rate<br>進給速度<br>(mm/min) |
| 6                                  | 5150   | 592                                  | 4250  | 508                                  | 3950   | 460                                  | 3600  | 436                                  | 1250                            | 116                                  |                               |
| 8                                  | 3850   | 480                                  | 3200  | 440                                  | 2950   | 440                                  | 2700  | 408                                  | 945                             | 124                                  |                               |
| 10                                 | 3100   | 464                                  | 2550  | 432                                  | 2350   | 384                                  | 2150  | 364                                  | 760                             | 116                                  |                               |
| 12                                 | 2600   | 448                                  | 2150  | 380                                  | 1950   | 368                                  | 1800  | 348                                  | 630                             | 116                                  |                               |
| 16                                 | 1950   | 444                                  | 1600  | 344                                  | 1500   | 296                                  | 1350  | 292                                  | 475                             | 88                                   |                               |
| 20                                 | 1550   | 380                                  | 1300  | 304                                  | 1200   | 284                                  | 1100  | 264                                  | 380                             | 88                                   |                               |
| 25                                 | 1250   | 360                                  | 1000  | 292                                  | 945  | 252                                  | 865   | 188                                  | 300                             | 84                                   |                               |
| Depth of cut<br>切削基準量<br>(D=直徑Dia) | <p>*Slotting (溝銑)</p>  <p>Ap: ≤1D</p> |                                      |   |                                      |  |                                      | <p>*Slotting (溝銑)</p>  <p>Ap: ≤0.5 D</p> |                                      |                                 |                                      |                               |