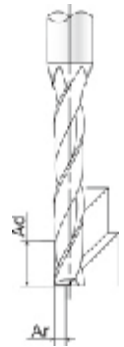


KMSEA-4

切削条件参考
Referential Cutting Conditions



| 刃 径 Flute Diameter | 切込み巾 Cutting Width | 切込み深さ Cutting Depth |
|----------------------------------|-----------------------|------------------------|
| | Ar | Ad |
| $D < \varphi 0.8$ | 0.05D | 0.4D |
| $\varphi 0.8 \leq D < \varphi 1$ | 0.1D | 0.4D |
| $\varphi 1 \leq D$ | 0.1D | 0.8D |

| 被削材 Workpiece | 炭素鋼・一般構造用鋼 Carbon Steel・ General Structural Steel S55C・SS材 | | 合金鋼・工具鋼 Alloy Steel・Tool Steel SCM・SKT・SKS・SKD | | プリハードン鋼 Pre-Harden Steel HPM-1・NAK55・SKT | | 鋳 鉄 Cast iron FC・FCD | |
|------------------|--|--|--|--|--|--|----------------------------|--|
| | 刃 径 Flute Diameter mm | 回転数 Revolution min ⁻¹ | 送り速度 Feed mm/min | 回転数 Revolution min ⁻¹ | 送り速度 Feed mm/min | 回転数 Revolution min ⁻¹ | 送り速度 Feed mm/min | 回転数 Revolution min ⁻¹ |
| 0.5~0.7 | 26,000 | 160 | 20,000 | 170 | 16,500 | 135 | 26,000 | 160 |
| 0.8~0.9 | 22,000 | 170 | 16,500 | 170 | 14,000 | 135 | 22,000 | 170 |
| 1 ~1.1 | 18,400 | 180 | 13,700 | 170 | 11,800 | 135 | 18,400 | 180 |
| 1.2~1.3 | 16,200 | 200 | 12,100 | 170 | 10,400 | 135 | 16,200 | 200 |
| 1.4~1.5 | 14,000 | 210 | 10,500 | 170 | 8,900 | 135 | 14,000 | 210 |
| 1.6~1.7 | 13,000 | 220 | 9,800 | 170 | 8,300 | 135 | 13,000 | 220 |
| 1.8~1.9 | 12,000 | 220 | 9,100 | 170 | 7,600 | 135 | 12,000 | 220 |
| 2 ~2.1 | 11,000 | 240 | 8,400 | 180 | 7,000 | 135 | 11,000 | 240 |
| 2.2~2.3 | 10,000 | 240 | 7,900 | 180 | 6,600 | 135 | 10,000 | 240 |
| 2.4~2.5 | 9,000 | 250 | 7,400 | 200 | 6,200 | 150 | 9,000 | 250 |
| 2.6~2.7 | 8,000 | 250 | 6,900 | 200 | 5,800 | 150 | 8,000 | 250 |
| 2.8~3.0 | 7,400 | 270 | 6,350 | 210 | 5,300 | 160 | 7,400 | 270 |
| 備 考 Remarks | ・回転数と送り速度は同じ割合で調整して下さい。・Adjust Revolution and Feed Speed at the same rate. ・切削油を使用して下さい。・Use Cutting Oil. | | | | | | | |

超硬
エンドミル

Carbide
Endmill