

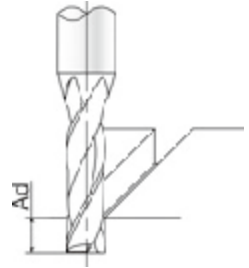


# KSET-2

## 切削条件参考

Referential Cutting Conditions

刃 径 Flute Diameter	切込み深さ Cutting Depth
	Ad
$D < \phi 0.2$	0.05D
$\phi 0.2 \leq D < \phi 1.0$	0.1D
$\phi 1.0 \leq D$	0.3D



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	
	刃 径 Flute Diameter mm	回転数 Revolution min <sup>-1</sup>	送り速度 Feed mm/min	回転数 Revolution min <sup>-1</sup>	送り速度 Feed mm/min	回転数 Revolution min <sup>-1</sup>
0.1	32,000	20	32,000	20	32,000	15
0.2	32,000	30	32,000	30	32,000	25
0.3	32,000	35	32,000	35	31,500	25
0.4	32,000	60	31,500	50	24,000	45
0.5	31,500	80	25,500	60	19,000	45
0.6	26,500	100	21,000	60	16,000	45
0.7	22,700	100	18,000	60	13,500	45
0.8	20,000	100	16,000	75	12,000	50
0.9	18,000	100	14,100	75	10,600	50
1	16,000	100	12,700	95	9,500	50
1.1	14,500	100	11,500	95	8,600	55
1.2	13,200	100	10,500	95	7,900	55
1.3	12,200	100	9,800	95	7,300	55
1.4	11,300	100	9,000	95	6,800	55
1.5	10,500	100	8,500	95	6,300	55
1.6	10,000	100	8,000	100	5,900	55
1.7	9,300	100	7,500	100	5,600	55
1.8	8,800	100	7,000	105	5,300	55
1.9	8,400	100	6,700	105	5,000	55
2	8,000	135	6,300	110	4,700	55
2.1	7,500	135	6,000	110	4,500	55
2.2	7,200	140	5,800	115	4,300	55
2.3	6,900	145	5,500	115	4,100	55
2.4	6,600	145	5,300	120	3,900	55
2.5	6,300	150	5,100	120	3,800	55
2.6	6,100	155	4,900	120	3,600	55
2.7	5,900	160	4,700	125	3,500	55
2.8	5,700	160	4,500	125	3,400	55
2.9	5,500	165	4,400	125	3,300	55
3	5,300	170	4,200	125	3,200	55
3.5	4,500	170	3,600	125	2,700	55
4	4,000	170	3,200	125	2,300	60

# KSET-2

## 切削条件参考

### Referential Cutting Conditions

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	
刃 径 Flute Diameter mm	回転数 Revolution min <sup>-1</sup>	送り速度 Feed mm/min	回転数 Revolution min <sup>-1</sup>	送り速度 Feed mm/min	回転数 Revolution min <sup>-1</sup>	送り速度 Feed mm/min
4.5	3,500	170	2,800	125	2,100	60
5	3,200	170	2,500	125	1,900	60
5.5	2,900	170	2,300	125	1,700	60
6	2,600	170	2,100	125	1,600	60
備 考 Remarks	<ul style="list-style-type: none"> <li>・ 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.</li> <li>・ 切削油を使用して下さい。 ・ Use Cutting Oil.</li> </ul>					