

● S500 - 81302T

加工材質 WORKING MATERIAL	合金鋼/工具鋼 ALLOY STEEL / TOOL STEEL		合金鋼/工具鋼 ALLOY STEEL / TOOL STEEL		合金鋼/工具鋼 ALLOY STEEL / TOOL STEEL		硬質鋼 HARDENED STEEL		不鏽鋼 STAINLESS STEEL		鑄鐵 CAST IRON	
MATERIAL CODE	(45C,S50C,SCM)		(SCM,SKT,SKD)		(SCM,SKT,SKD)		(SKT,SKD)		(SUS304)		FC/FCD	
硬度HARDNESS	HRC < 20		HRC 20~30		HRC 30~40		HRC 45~50		-		-	
切削速度VC	144 M/min		110 M/min		70 M/min		58 M/min		110 M/min		144 M/min	
R徑(R) Radius	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)
0.5R	46000	450	35400	380	22300	290	18600	180	35400	380	46000	450
1.0R	23020	600	17600	490	11200	380	9300	240	17600	490	23020	600
2.0R	11520	720	8780	560	5650	435	4680	290	8780	560	11520	720
3.0R	7700	900	5860	600	3750	450	3120	360	5860	600	7700	900
4.0R	5760	900	4420	600	2800	450	2330	360	4420	600	5760	900
5.0R	4590	900	3520	600	2260	450	1850	360	3520	600	4590	900
6.0R	3830	900	2920	620	1880	470	1550	360	2920	620	3830	900
8.0R	2880	1000	2220	680	1400	520	1160	400	2220	680	2880	1000
10.0R	2300	1000	1780	680	1120	520	930	400	1780	680	2300	1000
切削量 Milling Amount (mm)	Ad=0,05D,Pf=0,1D											