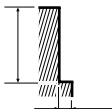


- X600 Series 14354T / 14454T / 11453T / 11454T
- X600 Series 11453TL / 14454TL / 11453TE / 11454TE
- X600L Series 14453T / 11454T

加工材質 WORKING MATERIAL	硬化鋼 HARDENED STEELS																									
硬度 HARDNESS	~40HRC		40~45HRC		45~55HRC		55~60HRC																			
外徑 DIAMETER	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED	R.P.M	FEED																		
1	20000	800	20000	800	20000	800	20000	560																		
2	20000	1600	20000	1600	16000	1250	12000	670																		
3	15000	1800	13500	1600	10500	1250	7950	670																		
4	11000	1800	9950	1600	7950	1250	5950	670																		
5	8900	1800	7950	1600	6350	1250	4800	670																		
6	7450	2650	6650	2400	5300	1900	4000	1000																		
8	5550	2650	4950	2400	4000	1900	3000	1000																		
10	4450	2650	4000	2400	3200	1900	2400	1000																		
12	3700	2650	3300	2400	2650	1900	2000	1000																		
14	3100	2500	2800	2250	2250	1800	1700	1000																		
15	2850	2400	2600	2200	2100	1750	1550	950																		
16	2700	2400	2400	2100	1950	1700	1450	930																		
18	2400	2250	2200	2000	1750	1600	1300	895																		
20	2200	2150	1950	1900	1550	1500	1150	845																		
切削深度 DEPTH OF CUT					<table><tr><td>ap</td><td>ae</td></tr><tr><td>Dc<Ø1.5</td><td>1.5D 0.02D</td></tr><tr><td>Ø1.5<Dc<Ø2.5</td><td>1.5D 0.05D</td></tr><tr><td>Ø1.5<Dc</td><td>1.5D 0.1D</td></tr></table>		ap	ae	Dc<Ø1.5	1.5D 0.02D	Ø1.5<Dc<Ø2.5	1.5D 0.05D	Ø1.5<Dc	1.5D 0.1D	<table><tr><td>ap</td><td>ae</td></tr><tr><td>1.5D</td><td>0.05D</td></tr></table> ae Max=1mm 以下		ap	ae	1.5D	0.05D	<table><tr><td>ap</td><td>ae</td></tr><tr><td>1D</td><td>0.02D</td></tr></table> ae Max=0.5mm 以下		ap	ae	1D	0.02D
					ap	ae																				
Dc<Ø1.5	1.5D 0.02D																									
Ø1.5<Dc<Ø2.5	1.5D 0.05D																									
Ø1.5<Dc	1.5D 0.1D																									
ap	ae																									
1.5D	0.05D																									
ap	ae																									
1D	0.02D																									