

DB 4T

切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS400 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRC22)					
冷卻方式 Coolant Type		乾式切削 Dry coolant					
型號 Type NO.	刀具伸長量 Extension Length(mm)	切削速度 Cutting Speed(m/min)	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
DB0104	10	60	18000~20000	800~1200	0.06~0.08	0.12~0.16	3D 銑 (3D milling)
DB0104	10	60	18000~20000	1100~1500	0.02~0.04	0.04~0.08	3D 銑 (3D milling)
DB0154	10	90	18000~20000	800~1200	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0154	10	90	18000~20000	1100~1500	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0204	12	120	18000~20000	800~1200	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0204	12	120	18000~20000	1100~1500	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0304	13	150	16000~17000	800~1200	0.1~0.12	0.2~0.24	3D 銑 (3D milling)
DB0304	13	150	16000~17000	1100~1500	0.05~0.07	0.1~0.14	3D 銑 (3D milling)
DB0404	15	190	15000~16000	800~1200	0.11~0.13	0.22~0.26	3D 銑 (3D milling)
DB0404	15	190	15000~16000	1200~1600	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0504	18	220	14000~15000	800~1200	0.13~0.16	0.26~0.32	3D 銑 (3D milling)
DB0504	18	220	14000~15000	1200~1600	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0604	20	245	13000~14000	1100~1500	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB0604	20	245	13000~14000	1400~1800	0.07~0.11	0.14~0.22	3D 銑 (3D milling)
DB0804	25	305	12000~13000	1100~1500	0.18~0.23	0.36~0.46	3D 銑 (3D milling)
DB0804	25	305	12000~13000	1500~1900	0.08~0.13	0.16~0.26	3D 銑 (3D milling)
DB1004	35	285	8700~9200	1100~1500	0.23~0.28	0.46~0.56	3D 銑 (3D milling)
DB1004	35	285	8700~9200	1500~1900	0.1~0.15	0.2~0.3	3D 銑 (3D milling)
DB1204	40	265	7000~8000	1100~1500	0.27~0.32	0.54~0.64	3D 銑 (3D milling)
DB1204	40	265	7000~8000	1500~1900	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB1604	50	255	5000~6000	900~1200	0.35~0.4	0.7~0.8	3D 銑 (3D milling)
DB1604	50	255	5000~6000	1200~1600	0.18~0.23	0.36~0.46	3D 銑 (3D milling)

DB 4T

切削條件表 MILLING CONDITIONS

被切削材 Work Material		調質鋼 / 預硬鋼 : Prehardened Steels NAK80 : 1.2083 : AISI420 : M310 (Hrc 36~45)					
冷卻方式 Coolant Type		乾式切削 Dry coolant					
型號 Type NO.	刀具伸長量 Extension Length(mm)	切削速度 Cutting Speed(m/min)	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
DB0104	10	50	16000~17000	400~700	0.06~0.08	0.12~0.16	3D 銑 (3D milling)
DB0104	10	50	16000~17000	700~1000	0.02~0.04	0.04~0.08	3D 銑 (3D milling)
DB0154	10	80	16000~17000	400~700	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0154	10	80	16000~17000	700~1000	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0204	12	100	15000~16000	400~700	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0204	12	100	15000~16000	700~1000	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0304	13	135	14000~15000	400~700	0.09~0.11	0.18~0.22	3D 銑 (3D milling)
DB0304	13	135	14000~15000	700~1000	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DB0404	15	170	13000~14000	500~800	0.11~0.13	0.22~0.26	3D 銑 (3D milling)
DB0404	15	170	13000~14000	1000~1400	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0504	18	195	12000~13000	600~900	0.11~0.13	0.22~0.26	3D 銑 (3D milling)
DB0504	18	195	12000~13000	1000~1400	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0604	20	215	11000~12000	700~1000	0.15~0.18	0.3~0.36	3D 銑 (3D milling)
DB0604	20	215	11000~12000	1100~1500	0.07~0.11	0.14~0.22	3D 銑 (3D milling)
DB0804	25	240	9000~10000	900~1200	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB0804	25	240	9000~10000	1200~1600	0.08~0.12	0.16~0.24	3D 銑 (3D milling)
DB1004	35	235	7000~8000	900~1200	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DB1004	35	235	7000~8000	1200~1600	0.1~0.15	0.2~0.3	3D 銑 (3D milling)
DB1204	40	190	5000~6000	800~1100	0.27~0.32	0.54~0.64	3D 銑 (3D milling)
DB1204	40	190	5000~6000	1200~1600	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB1604	50	255	4500~5500	600~900	0.3~0.35	0.6~0.7	3D 銑 (3D milling)
DB1604	50	255	4500~5500	1000~1300	0.15~0.23	0.36~0.46	3D 銑 (3D milling)