

DHB.DIB^{2T}

切削條件表 MILLING CONDITIONS

| 被切削材 Work Material | | 合金工具鋼 / 碳工具鋼 : Alloy Tool Steels / Carbon Tool Steels P20 / P5 / SK3 / SKD61 / SKD11 : 1.2311 / 1.1545 / 1.2379 / 1.2344 : H13 / D2 (HRc23~32) | | | | | |
|--------------------|----------------------------------|---|---------------------------------------|--------------------------|------------------------------|------------------------------|----------------------|
| 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 |
| DHB0202 | 40 | 100 | 15000~16000 | 900~1200 | 0.03~0.05 | 0.06~0.1 | 3D 銑 (3D milling) |
| DHB0252 | 40 | 125 | 15000~16000 | 1000~1300 | 0.03~0.05 | 0.06~0.1 | 3D 銑 (3D milling) |
| DHB0302 | 40 | 130 | 13000~14000 | 1000~1300 | 0.04~0.05 | 0.08~0.1 | 3D 銑 (3D milling) |
| DHB0402 | 40 | 150 | 11500~12500 | 1000~1300 | 0.04~0.08 | 0.12~0.16 | 3D 銑 (3D milling) |
| DHB0502 | 40 | 175 | 10000~11000 | 1100~1400 | 0.04~0.08 | 0.12~0.16 | 3D 銑 (3D milling) |
| DHB0602 | 40 | 160 | 7800~8300 | 1300~1700 | 0.1~0.15 | 0.24~0.3 | 3D 銑 (3D milling) |
| DHB0602 | 40 | 175 | 8800~9300 | 1400~1800 | 0.05~0.09 | 0.14~0.18 | 3D 銑 (3D milling) |
| DHB0802 | 40 | 235 | 8700~9200 | 1300~1700 | 0.12~0.2 | 0.32~0.4 | 3D 銑 (3D milling) |
| DHB0802 | 40 | 265 | 9500~10500 | 1400~1800 | 0.05~0.1 | 0.16~0.2 | 3D 銑 (3D milling) |
| DIB0202 | 50 | 150 | 11500~12000 | 700~1000 | 0.04~0.06 | 0.08~0.12 | 3D 銑 (3D milling) |
| DIB0302 | 50 | 150 | 11500~12000 | 800~1100 | 0.04~0.06 | 0.08~0.12 | 3D 銑 (3D milling) |
| DIB0402 | 50 | 150 | 11500~12000 | 900~1200 | 0.04~0.06 | 0.08~0.12 | 3D 銑 (3D milling) |
| DIB0602 | 50 | 230 | 11000~12000 | 900~1200 | 0.06~0.08 | 0.12~0.16 | 3D 銑 (3D milling) |
| DIB0802 | 50 | 185 | 6700~7300 | 900~1200 | 0.15~0.2 | 0.3~0.4 | 3D 銑 (3D milling) |
| DIB0802 | 50 | 225 | 8300~8800 | 1000~1400 | 0.06~0.1 | 0.16~0.2 | 3D 銑 (3D milling) |
| DIB1002 | 60 | 290 | 8700~9200 | 1000~1400 | 0.09~0.14 | 0.18~0.28 | 3D 銑 (3D milling) |
| DIB1202 | 60 | 325 | 8200~8600 | 900~1200 | 0.2~0.25 | 0.4~0.5 | 3D 銑 (3D milling) |
| DIB1202 | 60 | 325 | 8200~8600 | 1000~1400 | 0.1~0.15 | 0.2~0.3 | 3D 銑 (3D milling) |