

VTA

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 (m/min) Cutting Speed	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
VTA0606	20	130	6700~7200	1300~1500	0.1~0.2	4~6	溝銑 (SLOTTING)
VTA0606	20	130	6700~7200	1000~1300	0.05~0.1	4~6	溝銑 (SLOTTING)
VTA0606	20	85	4000~4500	1000~1200	6~12	0.15~0.25	側銑 (SIDE MILLING)
VTA0606	20	85	4000~4500	800~1000	6~12	0.05~0.12	側銑 (SIDE MILLING)
VTA0806	25	130	4800~5300	1300~1600	0.1~0.2	6~8	溝銑 (SLOTTING)
VTA0806	25	130	4800~5300	1000~1300	0.05~0.1	6~8	溝銑 (SLOTTING)
VTA0806	25	85	3200~3500	1200~1500	8~16	0.2~0.3	側銑 (SIDE MILLING)
VTA0806	25	85	3200~3500	700~900	8~16	0.05~0.15	側銑 (SIDE MILLING)
VTA1006	30	130	4000~4500	1300~1600	0.15~0.25	8~10	溝銑 (SLOTTING)
VTA1006	30	130	4000~4500	1000~1300	0.05~0.15	8~10	溝銑 (SLOTTING)
VTA1006	30	85	2500~3000	1100~1400	10~20	0.2~0.3	側銑 (SIDE MILLING)
VTA1006	30	85	2500~3000	650~850	10~20	0.05~0.15	側銑 (SIDE MILLING)
VTA1206	35	130	3200~3700	1100~1400	0.15~0.25	10~12	溝銑 (SLOTTING)
VTA1206	35	130	3200~3700	900~1200	0.05~0.15	10~12	溝銑 (SLOTTING)
VTA1206	35	85	2000~2500	900~1200	12~24	0.2~0.3	側銑 (SIDE MILLING)
VTA1206	35	85	2000~2500	600~800	12~24	0.05~0.15	側銑 (SIDE MILLING)
VTA1606	50	130	2400~2900	900~1200	0.15~0.25	14~16	溝銑 (SLOTTING)
VTA1606	50	130	2400~2900	700~900	0.05~0.15	14~16	溝銑 (SLOTTING)
VTA1606	50	85	1500~2000	800~1000	16~32	0.2~0.4	側銑 (SIDE MILLING)
VTA1606	50	85	1500~2000	500~700	16~32	0.05~0.2	側銑 (SIDE MILLING)

被切削材 Work Material

調質鋼 / 預硬鋼 : Prehardened Steels
NAK80 : 1.2083 : AISI420 : M310 (HRc36~45)

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 (m/min) Cutting Speed	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
VTA0606	20	130	6700~7200	1300~1500	0.1~0.2	4~6	溝銑 (SLOTTING)
VTA0606	20	130	6700~7200	1000~1300	0.05~0.1	4~6	溝銑 (SLOTTING)
VTA0606	20	85	4000~4500	1000~1200	6~12	0.15~0.25	側銑 (SIDE MILLING)
VTA0606	20	85	4000~4500	800~1000	6~12	0.05~0.12	側銑 (SIDE MILLING)
VTA0806	25	130	4800~5300	1300~1600	0.1~0.2	6~8	溝銑 (SLOTTING)
VTA0806	25	130	4800~5300	1000~1300	0.05~0.1	6~8	溝銑 (SLOTTING)
VTA0806	25	85	3200~3500	1200~1500	8~16	0.2~0.3	側銑 (SIDE MILLING)
VTA0806	25	85	3200~3500	700~900	8~16	0.05~0.15	側銑 (SIDE MILLING)
VTA1006	30	130	4000~4500	1300~1600	0.15~0.25	8~10	溝銑 (SLOTTING)
VTA1006	30	130	4000~4500	1000~1300	0.05~0.15	8~10	溝銑 (SLOTTING)
VTA1006	30	85	2500~3000	1100~1400	10~20	0.2~0.3	側銑 (SIDE MILLING)
VTA1006	30	85	2500~3000	650~850	10~20	0.05~0.15	側銑 (SIDE MILLING)

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調質鋼 / 預硬鋼 : Prehardened Steels
NAK80 : 1.2083 : AISI420 : M310 (HRC36~45)

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 (m/min) Cutting Speed	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
VTA1206	35	130	3200~3700	1100~1400	0.15~0.25	10~12	溝銑 (SLOTTING)
VTA1206	35	130	3200~3700	900~1200	0.05~0.15	10~12	溝銑 (SLOTTING)
VTA1206	35	85	2000~2500	900~1200	12~24	0.2~0.3	側銑 (SIDE MILLING)
VTA1206	35	85	2000~2500	600~800	12~24	0.05~0.15	側銑 (SIDE MILLING)
VTA1606	50	130	2400~2900	900~1200	0.15~0.25	14~16	溝銑 (SLOTTING)
VTA1606	50	130	2400~2900	700~900	0.05~0.15	14~16	溝銑 (SLOTTING)
VTA1606	50	85	1500~2000	800~1000	16~32	0.2~0.4	側銑 (SIDE MILLING)
VTA1606	50	85	1500~2000	500~700	16~32	0.05~0.2	側銑 (SIDE MILLING)

被切削材 Work Material

熱處理鋼 : Hardened Steels
SKD61/ STAVAX / 17-4PH : 1.2083 / 1.2344 / 1.4542 : H13 / 420 (HRC48~54)

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 (m/min) Cutting Speed	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
VTA0606	20	100	5000~5500	1000~1200	0.1~0.2	4~6	溝銑 (SLOTTING)
VTA0606	20	100	5000~5500	800~1000	0.05~0.1	4~6	溝銑 (SLOTTING)
VTA0606	20	75	3800~4300	700~1000	6~12	0.1~0.2	側銑 (SIDE MILLING)
VTA0606	20	75	3800~4300	500~700	6~12	0.05~0.1	側銑 (SIDE MILLING)
VTA0806	25	100	3800~4300	1100~1300	0.1~0.2	6~8	溝銑 (SLOTTING)
VTA0806	25	100	3800~4300	900~1200	0.05~0.1	6~8	溝銑 (SLOTTING)
VTA0806	25	75	2800~3300	800~1100	8~16	0.15~0.25	側銑 (SIDE MILLING)
VTA0806	25	75	2800~3300	500~700	8~16	0.05~0.12	側銑 (SIDE MILLING)
VTA1006	30	100	3000~3500	1000~1300	0.15~0.25	8~10	溝銑 (SLOTTING)
VTA1006	30	100	3000~3500	800~1100	0.05~0.15	8~10	溝銑 (SLOTTING)
VTA1006	30	75	2200~2600	800~1100	10~20	0.2~0.3	側銑 (SIDE MILLING)
VTA1006	30	75	2200~2600	500~700	10~20	0.05~0.15	側銑 (SIDE MILLING)
VTA1206	35	100	2500~3000	800~1100	0.15~0.25	10~12	溝銑 (SLOTTING)
VTA1206	35	100	2500~3000	700~1000	0.05~0.15	10~12	溝銑 (SLOTTING)
VTA1206	35	75	1800~2200	700~900	12~24	0.2~0.3	側銑 (SIDE MILLING)
VTA1206	35	75	1800~2200	450~650	12~24	0.05~0.15	側銑 (SIDE MILLING)
VTA1606	50	100	1800~2300	700~900	0.15~0.25	14~16	溝銑 (SLOTTING)
VTA1606	50	100	1800~2300	600~800	0.05~0.15	14~16	溝銑 (SLOTTING)
VTA1606	50	75	1300~1700	600~800	16~32	0.2~0.4	側銑 (SIDE MILLING)
VTA1606	50	75	1300~1700	300~500	16~32	0.05~0.2	側銑 (SIDE MILLING)