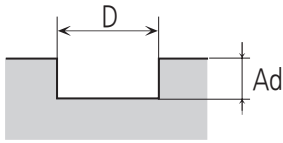


1ALE

Milling Condition

피삭재	아크릴, 알루미늄		합금강, 주철	
Workpiece	Acrylic, Aluminium		Alloy Steels, Cast Iron	
Outside Diameter	Speed (min ⁻¹)	Feed (mm/min)	Speed (min ⁻¹)	Feed (mm/min)
1.0	30,000~35,000	1,500~2,000	25,000~30,000	1,500~2,000
2.0	28,000~32,000	1,800~2,300	20,000~25,000	1,300~1,800
3.0	22,000~26,000	2,200~2,500	16,000~20,000	1,500~2,000
4.0	18,000~22,000	2,200~2,500	13,000~18,000	1,500~2,000
6.0	12,000~15,000	2,200~2,500	8,000~12,000	1,500~2,000
8.0	8,000~12,000	2,300~2,700	6,000~9,000	1,800~2,200
10.0	7,000~9,000	2,300~2,700	5,000~8,000	1,800~2,200
12.0	6,000~8,500	2,300~2,700	4,000~7,000	1,800~2,200

Depth of Cut	 <p style="text-align: center;">$Ad = 0.25D$</p>
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! 경고 Warning

1. 강성을 지닌 정밀한 장비와 홀더를 사용하십시오.
 2. 절삭유 사용을 추천합니다.
1. Use a rigid precise machine and holder.
 2. Recommend water soluble fluids.