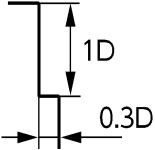
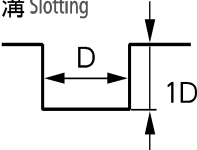


ALZ345

切削条件参考表 Recommended Milling Conditions

被削材 Work Material		アルミニウム Aluminium A1070				アルミニウム合金 Aluminium Alloy A2017・A5052・A7075				鋳造アルミニウム Aluminium Cast AC8C			
切削速度 Cutting Speed		310m/min				350m/min				230m/min			
外 径 Dia.	首下長 Under Neck Length	回転数 Spindle Speed	送り速度 Feed			回転数 Spindle Speed	送り速度 Feed			回転数 Spindle Speed	送り速度 Feed		
			突込み Plunging	溝 Slotting	側面 Side Milling		突込み Plunging	溝 Slotting	側面 Side Milling		突込み Plunging	溝 Slotting	側面 Side Milling
		min-1	mm/min			min-1	mm/min			min-1	mm/min		
1	3	20 000	200	600	1 100	20 000	200	600	1 100	20 000	150	600	1 100
	5	16 000	160	500	900	16 000	160	500	900	16 000	120	500	900
2	6	20 000	300	900	1 500	20 000	300	900	1 500	20 000	250	900	1 500
	10	16 000	240	800	1 200	16 000	240	800	1 200	16 000	200	800	1 200
3	9	20 000	300	1 200	2 000	20 000	300	1 400	2 200	20 000	250	1 200	2 200
	15	16 000	240	1 000	1 600	16 000	240	1 200	1 800	16 000	200	1 000	1 800
4	12	20 000	300	1 400	2 200	20 000	400	1 800	2 500	18 300	200	1 400	2 300
	20	16 000	240	1 200	1 800	16 000	320	1 500	2 000	14 600	160	1 200	1 900
5	15	19 700	300	1 500	2 500	20 000	400	2 200	3 100	14 600	150	1 400	2 100
	25	15 700	240	1 200	2 000	16 000	320	1 800	2 500	11 700	120	1 200	1 700
6	—	16 500	300	1 600	2 500	18 600	400	2 500	3 500	12 200	150	1 400	2 100
	18	16 500	300	1 600	2 500	18 600	400	2 500	3 500	12 200	150	1 400	2 100
	30	13 200	240	1 300	2 000	14 800	320	2 000	2 800	9 700	120	1 200	1 700
7	21	14 100	200	1 600	2 500	15 900	400	2 500	3 500	10 500	140	1 400	2 100
8	—	12 300	200	1 700	2 500	13 900	400	2 600	3 500	9 200	120	1 400	2 200
	24	12 300	200	1 700	2 500	13 900	400	2 600	3 500	9 200	120	1 400	2 200
	40	9 800	160	1 400	2 000	11 100	320	2 100	2 800	7 300	100	1 200	1 800
9	27	11 000	200	1 700	2 500	12 400	300	2 600	3 500	8 100	120	1 400	2 200
10	—	9 900	100	1 700	2 500	11 100	300	2 600	3 800	7 300	80	1 400	2 200
	30	9 900	100	1 700	2 500	11 100	300	2 600	3 800	7 300	80	1 400	2 200
	50	7 900	80	1 400	2 000	8 800	240	2 100	3 000	5 800	70	1 200	1 800
11	33	9 000	100	1 800	2 600	10 100	300	2 600	4 100	6 700	80	1 400	2 200
12	—	8 200	100	1 900	2 700	9 300	300	2 600	4 100	6 100	60	1 500	2 200
	36	8 200	100	1 900	2 700	9 300	300	2 600	4 100	6 100	60	1 500	2 200
	60	6 500	80	1 500	2 200	7 400	240	2 100	3 200	4 800	50	1 200	1 800

<p>切込み量 Depth of Cut</p> <p>(D:外径 Dia.)</p>	<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p>側面 Side Milling</p>  </div> <div style="text-align: center;"> <p>溝 Slotting</p>  </div> </div>
<p>備考 Notes</p>	<p>※1 Adjust both spindle speed and feed at the same rate. (When using spindle speed 20,000 or more, the same adjustment is required.)</p> <p>※2 TYPE A : Recommended milling conditions for standard type are at overhang 3D. Adjust spindle speed and feed rate at 80% for overhang 5D, and 50% for 7D.</p> <p>※3 Use a rigid and precise machine and chuck holder.</p> <p>※4 Adjust milling conditions when vibration and abnormal sounds occur by the conditions of the machine, chuck holder and work clamping.</p> <p>※5 When tending to have chip packing during plunging, step milling is recommended.</p> <p>※6 Water-soluble fluid is recommended.</p>