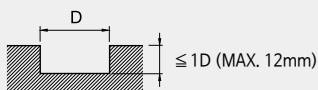
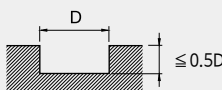



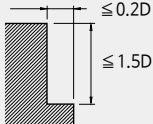
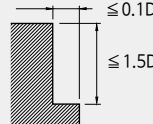
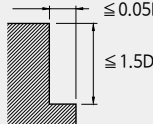
홈절삭 Slotting

피삭재 Material	합금강 / 프리하드강 Alloy Steels / Pre-hardened Steels NAK80 / KP4M				스테인레스강 / 티타늄 합금강 Stainless Steel / Titanium alloy steels SUS304 / SUS316 / Ti6A				내열합금강 Heat Resistance Alloys			
	40 ~ 45Hrc											
외경 Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
ø 2	10,000	400	2	2	9,600	310	1	2	3,200	80	0.4	2
ø 3	6,900	410	3	3	7,400	380	1.5	3	2,700	110	0.6	3
ø 4	5,600	490	4	4	5,600	400	2	4	2,000	120	0.8	4
ø 5	4,500	630	5	5	4,500	410	2.5	5	1,600	130	1	5
ø 6	3,700	740	6	6	3,700	440	3	6	1,300	160	1.2	6
ø 7	3,200	700	7	7	3,200	410	3.5	7	1,100	140	1.4	7
ø 8	2,800	670	8	8	2,800	390	4	8	1,000	130	1.6	8
ø 9	2,500	600	9	9	2,500	350	4.5	9	900	130	1.8	9
ø 10	2,200	530	10	10	2,200	350	5	10	800	130	2	10
ø 11	2,000	530	11	11	2,000	320	5.5	11	720	120	2.2	11
ø 12	1,900	530	12	12	1,900	300	6	12	660	110	2.4	12
ø 16	1,400	390	16	16	1,400	280	8	16	500	80	3.2	16
ø 20	1,100	350	20	20	1,100	260	10	20	400	60	4	20

절입량 Depth of Cut			
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측면절삭 Side Cutting

피삭재 Material	합금강 / 프리하드강 Alloy Steels / Pre-hardened Steels NAK80 / KP4M				스테인레스강 / 티타늄 합금강 Stainless Steel / Titanium alloy steels SUS304 / SUS316 / Ti6A				내열합금강 Heat Resistance Alloys			
	40 ~ 45Hrc											
외경 Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
ø 2	21,000	825	3	0.4	14,000	420	3	0.2	4,800	130	3	0.1
ø 3	15,000	938	4.5	0.6	10,600	638	4.5	0.3	4,200	200	4.5	0.15
ø 4	11,000	1,050	6	0.8	8,000	720	6	0.4	3,200	220	6	0.2
ø 5	9,600	1,425	7.5	1	6,400	750	7.5	0.5	2,500	250	7.5	0.25
ø 6	8,000	1,650	9	1.2	5,300	750	9	0.6	2,100	250	9	0.3
ø 7	6,800	1,425	10.5	1.4	4,500	750	10.5	0.7	1,800	260	10.5	0.35
ø 8	6,000	1,200	12	1.6	4,000	720	12	0.8	1,600	260	12	0.4
ø 9	5,300	1,110	13.5	1.8	3,500	630	13.5	0.9	1,400	220	13.5	0.45
ø 10	4,800	1,080	15	2	3,200	578	15	1	1,300	210	15	0.5
ø 11	4,400	1,013	16.5	2.2	2,900	570	16.5	1.1	1,200	190	16.5	0.55
ø 12	4,000	938	18	2.4	2,700	570	18	1.2	1,100	180	18	0.6
ø 16	3,000	855	24	3.2	2,000	420	24	1.6	800	130	24	0.8
ø 20	2,400	645	30	4	1,600	383	30	2	600	100	30	1

절입량 Depth of Cut			
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- 유효장 길이가 긴 경우, RPM과 FEED를 동일 비율로 낮춰주세요.
- 가공 진입시 가능한 피삭재 밖에서 진입 하십시오.
- 절삭 조건이 없는 직경 및 유효장은 비슷한 직경 및 유효장에 비례하여 UP & DOWN 하여 설정 하십시오.
- 날 끝이 정밀하게 연삭되어 있습니다. 파손을 피하기 위해 가능하면 비접촉 방식으로 측정 하십시오.
- 상기 절삭조건은 참고 수치이므로 실 가공시 가공 형상, 가공 목적, 적용 기계에 따라 조건변경 요망 합니다.
- 조건표가 기계의 최대 스피들 속도를 초과하거나 버 및 적열 현상이 발생할 때 스피들 속도와 이송 속도를 비례하여 조정 하십시오.
- 에어브로, 절삭유, 오일 미스트 쿨런트를 추천하며, 칩을 잘 제거하고 가공시 발열과 발화에 주의하십시오

- If the effective length is long, reduce the RPM and feed in the same proportion.
- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- If the diameter or effective length of your tool are not on the table, adjust it compared similarity value on the table.
- The edge of the flute precisely grinded. If you want to measure the tool, and to avoid damaging on the flutes, use non-contact measuring method.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine, or found red heat on the material, adjust RPM and feed in the same proportion.
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.