

HIGH SPEED STEEL WITH COBALT SLITTING SAWS- Small Diameter- Fine Teeth(90/120T)



63

[➡ 搭配鋸片柄 P.200](#)
[➡ 切削條件表 P.567](#)
[➡ 技術資料 P.639](#)

SLITTING SAW ARBORS- Right Hand Thread

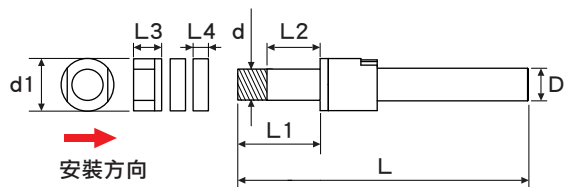
[illegible]

Table 62

鎢鋼鋸片 切削條件表

SOLID CARBIDE SLITTING SAWS- CUTTING CONDITION TABLE

加工材質 Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels	不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys	高溫合金 High-Temp Alloys
工件料號 Material Code	S35C,S45C,S50C	SCM,SKT,SKD	SUS304	FC,FCD	Al 5052 / 6061 / 7075	Ti-6Al-4V
硬度 Hardness	HRC<30	HRC30~45	—	HRC<30	—	HRC<30
切削速度 Vc	70~140m/min	50~80m/min	50~80m/min	70~140m/min	150~200m/min	30~70m/min
外徑 Diameter	每刃進給量 fz (mm)	每刃進給量 fz (mm)	每刃進給量 fz (mm)	每刃進給量 fz (mm)	每刃進給量 fz (mm)	每刃進給量 fz (mm)
10~30mm	0.002~0.004	0.001~0.004	0.001~0.004	0.002~0.004	0.001~0.004	0.001~0.004
30~50mm	0.003~0.007	0.002~0.005	0.002~0.005	0.003~0.007	0.002~0.005	0.002~0.005
50~80mm	0.004~0.008	0.002~0.008	0.002~0.008	0.004~0.010	0.002~0.008	0.002~0.008
80~125mm	0.004~0.012	0.003~0.012	0.003~0.012	0.004~0.010	0.003~0.012	0.003~0.012
125~200mm	0.004~0.012	0.003~0.012	0.003~0.012	0.004~0.010	0.003~0.012	0.003~0.012
備註 Remarks						

※ 切削公式 Cutting Formula : $S(\text{主軸轉速}) = Vc(\text{切削速度}) \times 1000 / D(\text{外徑}) / \pi (3.14)$ $F(\text{進給速度}) = fz(\text{每刃進給量}) \times Z(\text{刃數}) \times S(\text{主軸轉速})$

Table 63

高速鋼 / 高鈷鋼鋸片 切削條件表

SOLID HSS & HSS-Co SLITTING SAWS- CUTTING CONDITION TABLE

加工材質 Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels	不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys	高溫合金 High-Temp Alloys
工件料號 Material Code	S35C,S45C,S50C	SCM,SKT,SKD	SUS304	FC,FCD	Al 5052 / 6061 / 7075	Ti-6Al-4V
硬度 Hardness	HRC<30	HRC30~45	—	HRC<30	—	HRC<30
切削速度 Vc	50m/min	30m/min	40m/min	50m/min	100m/min	30m/min
外徑 Diameter	每刃進給量 fz (mm)	每刃進給量 fz (mm)	每刃進給量 fz (mm)	每刃進給量 fz (mm)	每刃進給量 fz (mm)	每刃進給量 fz (mm)
10~30mm	0.002~0.004	0.001~0.004	0.001~0.004	0.002~0.004	0.001~0.004	0.001~0.004
30~50mm	0.003~0.007	0.002~0.005	0.002~0.005	0.003~0.007	0.002~0.005	0.002~0.005
50~80mm	0.004~0.008	0.002~0.008	0.002~0.008	0.004~0.010	0.002~0.008	0.002~0.008
80~125mm	0.004~0.012	0.003~0.012	0.003~0.012	0.004~0.010	0.003~0.012	0.003~0.012
125~200mm	0.004~0.012	0.003~0.012	0.003~0.012	0.004~0.010	0.003~0.012	0.003~0.012
備註 Remarks						

※ 切削公式 Cutting Formula : $S(\text{主軸轉速}) = Vc(\text{切削速度}) \times 1000 / D(\text{外徑}) / \pi (3.14)$ $F(\text{進給速度}) = fz(\text{每刃進給量}) \times Z(\text{刃數}) \times S(\text{主軸轉速})$

1. 當加工聲音尖銳時，請調降主軸轉速(S) (10~40%)。When the sound is piercing, please lower the spindle speed(S) (10~40%).
2. 當機台震動太大時，請調降進給速度(F) (10~40%)。When the machine is vibrating, please decrease the feed rate(F) (10~40%).
3. 當主軸負載太大時，請調降進給速度(F) (10~40%)。When the spindle load is high, please decrease the feed rate(F) (10~40%).
4. 以上數據為建議值，適當的條件仍需視機台狀況，夾治具品質，潤滑冷卻系統...等而改變。

These are recommended values which depend on the condition of the machine, fixture, lubricating & cooling systems... etc. They may have to be adapted.