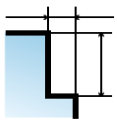
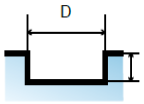
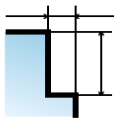
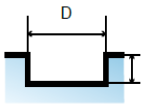
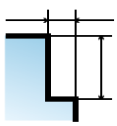
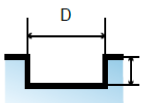
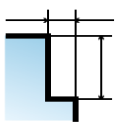
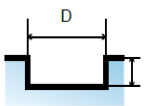
切削条件

SPEEDTIGER ①4枚刃 防振(P-SE/T) ②4枚刃 SIコート(SE/SI) ③4枚刃 防振ハイヘリ(P-PE/T)

側面加工条件

被切削材	MILD STEELS, CARBON STEELS, CAST IRON SS400,S55C,FC250 (～750N/mm²) 一般構造用鋼,炭素 鋼,鋳鉄		ALLOY STEELS, TOOL STEELS SCM,SKT,SKS,SKD (～30HRC) 合金鋼,工具鋼		HARDENED STEELS, PREHARDENED STEELS SKT,SKD,NAK55, HPM1 (30～38HRC) 調質鋼		STAINLESS STEELS, HARDENED STEELS SUS304,SKD (38～45HRC) ステンレス		HARDENED STEELS, TITANIUM ALLOY STEELS (45～55HRC) 調質鋼		HEAT RESISTANT ALLOY STEELS INCONEL 耐熱合金鋼	
刃径 (mm)	回転数 (min^{-1})	送り速度 (mm/min)	回転数 (min^{-1})	送り速度 (mm/min)	回転数 (min^{-1})	送り速度 (mm/min)	回転数 (min^{-1})	送り速度 (mm/min)	回転数 (min^{-1})	送り速度 (mm/min)	回転数 (min^{-1})	送り速度 (mm/min)
3	12,500	880	9,550	672	8,100	500	7,650	492	7,400	436	3,800	176
4	9,750	960	7,550	788	6,400	544	6,050	568	5,850	504	3,000	192
5	7,950	1,040	6,150	840	5,250	580	4,950	620	4,800	536	2,450	196
6	6,750	1,280	5,250	960	4,450	712	4,200	668	4,050	556	2,100	200
8	5,050	1,240	3,950	880	3,350	652	3,150	648	3,050	540	1,600	180
10	4,100	1,160	3,200	840	2,700	580	2,550	572	2,450	508	1,250	172
12	3,400	1,120	2,650	800	2,250	576	2,100	540	2,050	484	1,050	168
16	2,550	960	2,000	752	1,700	508	1,600	444	1,550	404	765	168
20	2,050	788	1,600	604	1,350	472	1,250	412	1,250	368	635	160
基準加工深さ	≦0.1D(D≦φ3) ≦0.2D(D＞Φ3)  ≦1.5D		 ≦0.1D(D＜φ2) ≦0.2D(D≧Φ2)				≦0.1D  ≦1D		 ≦0.05D(D≦φ2) ≦0.1D(D＞Φ2)			

溝加工条件

被切削材	MILD STEELS, CARBON STEELS, CAST IRON SS400,S55C,FC250 (～750N/mm²) 一般構造用鋼,炭素 鋼,鋳鉄		ALLOY STEELS, TOOL STEELS SCM,SKT,SKS,SKD (～30HRC) 合金鋼,工具鋼		HARDENED STEELS, PREHARDENED STEELS SKT,SKD,NAK55, HPM1 (30～38HRC) 調質鋼		STAINLESS STEELS, HARDENED STEELS SUS304,SKD (38～45HRC) ステンレス		HARDENED STEELS, TITANIUM ALLOY STEELS (45～55HRC) 調質鋼		HEAT RESISTANT ALLOY STEELS INCONEL 耐熱合金鋼	
刃径 (mm)	回転数 (min^{-1})	送り速度 (mm/min)	回転数 (min^{-1})	送り速度 (mm/min)	回転数 (min^{-1})	送り速度 (mm/min)	回転数 (min^{-1})	送り速度 (mm/min)	回転数 (min^{-1})	送り速度 (mm/min)	回転数 (min^{-1})	送り速度 (mm/min)
3	10,500	584	8,550	544	7,850	416	7,450	368	7,200	352	2,500	100
4	7,750	584	6,400	620	5,900	416	5,550	412	5,400	396	1,900	108
5	6,200	588	5,100	604	4,700	436	4,450	436	4,300	428	1,500	116
6	5,150	592	4,250	508	3,950	460	3,700	456	3,600	436	1,250	116
8	3,850	480	3,200	440	2,950	440	2,800	420	2,700	408	945	124
10	3,100	464	2,550	432	2,350	384	2,250	380	2,150	364	760	116
12	2,600	448	2,150	380	1,950	368	1,850	352	1,800	348	630	116
16	1,950	444	1,600	344	1,500	296	1,400	296	1,350	292	475	88
20	1,550	380	1,300	304	1,200	284	1,100	264	1,100	264	380	88
基準加工深さ	≦0.1D(D≦φ3) ≦0.2D(D＞Φ3)  ≦1.5D		 ≦0.1D(D＜φ2) ≦0.2D(D≧Φ2)				≦0.1D  ≦1D		 ≦0.05D(D≦φ2) ≦0.1D(D＞Φ2)			