

切削条件

SPEEDTIGER 4枚刃 高剛性ラジアス ショート刃ネック付(UCRS)

溝/側面加工条件

| 被削材 | HRC30 | | HRC50 | | HRC60 | |
|--------------|------------------------------|------------------------------------|------------------------------|------------------------------------|------------------------------|------------------------------------|
| | 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) |
| D6.0 x 0.5R | 9,200 | 2,400 | 7,040 | 1,600 | 3,680 | 600 |
| D8.0 x 0.5R | 6,920 | 2,420 | 4,280 | 1,360 | 3,080 | 656 |
| D10.0 x 0.5R | 4,400 | 2,240 | 2,560 | 880 | 1,320 | 464 |
| D12.0 x 0.5R | 3,720 | 2,320 | 1,760 | 760 | 1,040 | 424 |
| D3.0 x 1R | 11,960 | 1,840 | 9,016 | 1,380 | 6,900 | 460 |
| D4.0 x 1R | 11,500 | 1,840 | 8,556 | 966 | 6,256 | 460 |
| D6.0 x 1R | 10,580 | 2,760 | 8,096 | 1,840 | 4,232 | 690 |
| D8.0 x 1R | 7,958 | 3,128 | 4,922 | 1,564 | 3,542 | 754 |
| D10.0 x 1R | 5,060 | 2,560 | 2,944 | 1,012 | 1,518 | 534 |
| D12.0 x 1R | 4,278 | 2,668 | 2,024 | 1,140 | 1,196 | 488 |
| D6.0 x 1.5R | 11,040 | 2,880 | 8,448 | 1,920 | 4,416 | 720 |
| D8.0 x 1.5R | 8,304 | 3,264 | 5,136 | 1,632 | 3,696 | 787 |
| D10.0 x 1.5R | 5,280 | 2,688 | 3,072 | 1,056 | 1,584 | 557 |
| D12.0 x 1.5R | 4,464 | 2,784 | 2,112 | 912 | 1,248 | 509 |
| D6.0 x 2R | 11,960 | 3,120 | 9,152 | 5,080 | 4,784 | 780 |
| D8.0 x 2R | 8,996 | 3,536 | 5,564 | 1,768 | 4,004 | 853 |
| D10.0 x 2R | 5,720 | 2,912 | 3,328 | 1,144 | 1,716 | 603 |
| D12.0 x 2R | 4,836 | 3,016 | 2,288 | 988 | 1,352 | 551 |
| D8.0 x 3R | 9,342 | 3,672 | 5,778 | 1,836 | 4,160 | 886 |
| D10.0 x 3R | 5,940 | 3,024 | 3,456 | 1,188 | 1,782 | 626 |
| D12.0 x 3R | 5,022 | 3,132 | 2,376 | 1,026 | 1,404 | 573 |
| 基準加工 深さ | | | | | | |