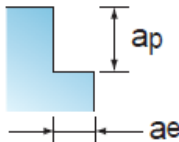


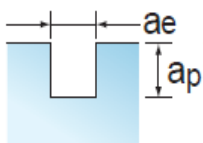
# 切削条件

**SPEEDTIGER 3枚刃 アルミ用45°(AET)**

## 側面加工条件

| 被削材        | COPPER,COPPER ALLOY<br>銅,銅合金   |                  | Aluminum alloy expanding material<br>A7075 Aluminum alloy casting<Sil 13%<br>アルミ合金 |                  |
|------------|--|------------------|--|------------------|
| 最大切削速度(V)  | 140m/min   |                  | 380m/min   |                  |
| 刃径<br>(mm) | 回転数<br>(min <sup>-1</sup> )  | 送り速度<br>(mm/min) | 回転数<br>(min <sup>-1</sup> )  | 送り速度<br>(mm/min) |
| 3          | 14,770   | 3,160            | 39,910   | 9,580            |
| 4          | 11,080   | 2,370            | 29,940   | 7,180            |
| 5          | 8,860  | 1,900            | 23,950   | 5,750            |
| 6          | 7,380  | 1,580            | 19,960   | 4,790            |
| 8          | 5,550  | 1,190            | 15,000   | 3,600            |
| 10         | 4,430  | 940              | 11,980   | 2,870            |
| 12         | 3,690  | 790              | 9,980  | 2,390            |
| 16         | 2,770  | 590              | 7,490  | 1,800            |
| 20         | 2,220  | 470              | 5,980  | 1,440            |
| 基準加工深さ     |  <p>AP=2.0D<br/>AE=0.5D</p> |                  |  |                  |

## 溝加工条件

| 被削材        | COPPER,COPPER ALLOY<br>銅,銅合金   |                  | Aluminum alloy expanding material<br>A7075 Aluminum alloy casting<Sil 13%<br>アルミ合金 |                  |
|------------|--|------------------|--|------------------|
| 最大切削速度(V)  | 90m/min  |                  | 310m/min   |                  |
| 刃径<br>(mm) | 回転数<br>(min <sup>-1</sup> )  | 送り速度<br>(mm/min) | 回転数<br>(min <sup>-1</sup> )  | 送り速度<br>(mm/min) |
| 3          | 9,740  | 1,040            | 32,910   | 3,950            |
| 4          | 7,300  | 780              | 24,680   | 2,960            |
| 5          | 5,850  | 620              | 19,750   | 2,370            |
| 6          | 4,870  | 520              | 16,450   | 1,970            |
| 8          | 3,660  | 390              | 12,340   | 1,480            |
| 10         | 2,960  | 320              | 9,870  | 1,180            |
| 12         | 2,440  | 260              | 8,230  | 990              |
| 16         | 1,820  | 190              | 6,170  | 740              |
| 20         | 1,460  | 150              | 4,940  | 590              |
| 基準加工深さ     |  <p>AP=1.5D<br/>AE=1.0D</p> |                  |  |                  |