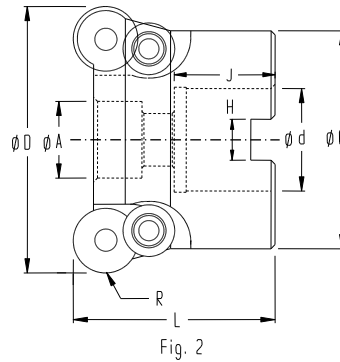
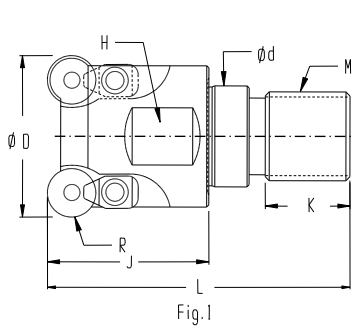


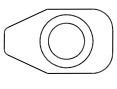
R 角銑刀

ROUND INSERTS MILLING CUTTER



規格 SPECIFICATION	ϕD	R	ϕd	J	L	H	ϕA	ϕC	M	K	刃數 NO.OF INSERT	圖 Fig
RFM40RP12M22	40	6	25	40	75	32	-	-	M22	25	3	#1
RFM40RP12D16	40	6	16	19	36	8.4	13.5	35	-	-		#2
RFM50RP12D22	50	6	22	20	42	8.4	17	45	-	-	4	#2
RFM52RP12D22	52	6	22	20	42	8.4	17	45				
RFM66RD16D25.4	66	8	25.4	25	50	10.15	19	54	-	-	4	#2
RFM80RD16D31.75	80	8	31.75	30	50	13	42	65			5	

部品 PARTS

規格 SPECIFICATION	刀片規格 INSERTS	壓板 CLAMPS		(刀片及壓板) 螺絲 SCREWS	板手 WRENCH
					
RFM40RP12M22	RPMT1204M0	FC1308-3.5	-	IS401155	T15
RFM40RP12D16					
RFM50RP12D22					
RFM52RP12D22	RDMX1604M0	-	CL12836	IS501170	T20
RFM66RD16D25.4					
RFM80RD16D31.75					

建議切削條件一覽表 Recommended Cutting Conditions

工件材質 Workpiece Material	Roughing 粗加工			Semi-Finishing 中加工			Finishing 精加工		
	速度 Speed Vc (m/min)	每刃進給 Feed (mm/tooth)	切削深度 D.O.C (mm)	速度 Speed Vc (m/min)	每刃進給 Feed (mm/tooth)	切削深度 D.O.C (mm)	速度 Speed Vc (m/min)	每刃進給 Feed (mm/tooth)	切削深度 D.O.C (mm)
	Unalloyed steels 一般碳鋼	180 - 220	0.16 - 0.30	3.0 - D/2	220 - 260	0.14 - 0.22	1.0 - 3.0	220 - 300	0.12 - 0.18
Alloyed steels 合金鋼	70 - 110	0.14 - 0.25	3.0 - D/2	100 - 150	0.12 - 0.20	1.0 - 3.0	100 - 195	0.08 - 0.16	0.1 - 1.0
Stainless steels 不鏽鋼	120 - 140	0.10 - 0.18	3.0 - D/2	140 - 180	0.08 - 0.14	1.0 - 3.0	180 - 230	0.08 - 0.12	0.1 - 1.0
Cast Irons 鑄鐵	140 - 280	0.14 - 0.25	3.0 - D/2	180 - 300	0.12 - 0.20	1.0 - 3.0	200 - 350	0.08 - 0.16	0.1 - 1.0
Non-ferrous metal 鋁、銅、鎂等非鐵金屬	275 - 450	0.10 - 0.20	3.0 - D/2	400 - 750	0.08 - 0.20	1.0 - 3.0	700 - 1000	0.08 - 0.15	0.1 - 1.0