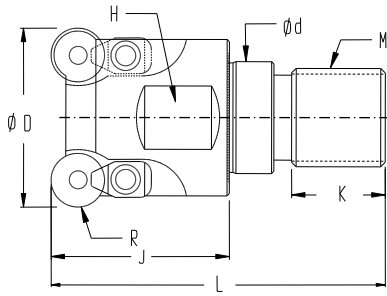


# R 角銑刀

## ROUND INSERTS MILLING CUTTER



規格 SPECIFICATION	φD	R	φd	J	L	H	M	K	刃數 NO.OF INSERT
RFM17R4RD08M08	17	4	8.5	29	50	12	M08	15	2
RFM21R4RD08M10	21	4	10.5	29	50	14	M10	14	2
RFM26R5RD10M12	26	5	14	34	60	19	M12	20	2
RFM26R5RD10M12F	26	5	14	34	60	19	M12	20	3
RFM30R5RD10M12C	30	5	14	34	60	19	M12	20	2
RFM30R5RD10M12FC	30	5	14	34	60	19	M12	20	3
RFM35R5RD10M16C	35	5	22	39	67	24	M16	22	2
RFM35R5RD10M16FC	35	5	22	39	67	24	M16	22	3

## 部品 PARTS

規格 SPECIFICATION	刀片規格 INSERTS	壓板 CLAMPS	(刀片及壓板) 螺絲 SCREWS	扳手 WRENCH
RFM17R4RD08M08	RDHW0802MOTN	-	IS30070	T 09
RFM21R4RD08M10				
RFM26R5RD10M12	RDMT10T3MOTN	-	IS40080	T 15
RFM26R5RD10M12F				
RFM30R5RD10M12C	RDMT10T3MOTN	SC118-70-3.5	IS40080	T 15
RFM30R5RD10M12FC				
RFM35R5RD10M16C	RDMT10T3MOTN	SC118-70-3.5	IS40080	T 15
RFM35R5RD10M16FC				

## 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	0.1 - 1.0
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