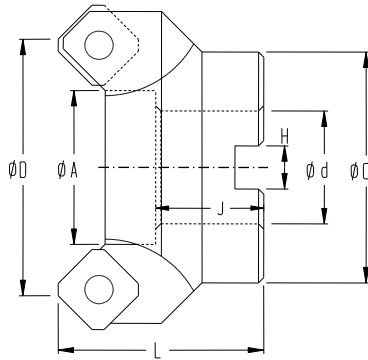




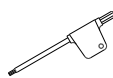
45° 面銑刀

FACE MILLING CUTTER (45 °)



規格 SPECIFICATION	φD	φd	J	L	H	φA	φC	刃數 NO.OF INSERT
FMC50SE12D22	50	22	21	40	8.4	30	45	4
FMC63SE12D25.4	63	25.4	25	45	10.4	37	50	5
FMC80SE12D31.75	80	31.75	30	50	13	46	65	6
FMC100SE12D31.75	100	31.75	30	50	13	66	80	6

部品 PARTS

規格 SPECIFICATION	刀片規格 INSERTS	刀片螺絲 INSERT SCREW	板手 WRENCH
			
FMC50SE12D22	SEKT1204AFER	IS501170	T20
FMC63SE12D25.4			
FMC80SE12D31.75			
FMC100SE12D31.75			

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	0.20 - 0.45	3.0 - 6.0	220 - 260	0.15 - 0.30	1.0 - 3.0	220 - 300	0.15 - 0.17	0.2 - 1.0
Alloyed steels 合金鋼	70 - 110	0.20 - 0.35	3.0 - 6.0	100 - 150	0.15 - 0.25	1.0 - 3.0	100 - 195	0.15 - 0.17	0.2 - 1.0
Stainless steels 不鏽鋼	120 - 140	0.15 - 0.30	3.0 - 6.0	140 - 180	0.15 - 0.25	1.0 - 3.0	180 - 230	0.15 - 0.17	0.2 - 1.0
Cast Irons 鑄鐵	140 - 280	0.15 - 0.30	3.0 - 6.0	180 - 300	0.10 - 0.22	1.0 - 3.0	200 - 350	0.05 - 0.15	0.2 - 1.0
Non-ferric metal 鋁、銅、鎂等非鐵金屬	275 - 450	0.15 - 0.30	3.0 - 6.0	400 - 750	0.10 - 0.22	1.0 - 3.0	700 - 1000	0.05 - 0.15	0.2 - 1.0