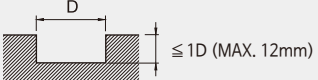
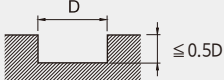
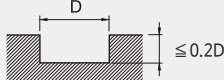


4LSUC Cutting Condition

• RPM : rev./min • Feed : mm/min

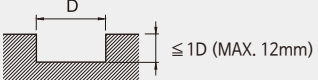


피삭재 Material	합금강/ 공구강 Alloy Steels / Tools Steel				스테인레스강/ 티탄합금 Stainless Steels / Titanium Alloy Steels				고경도강 Hardened Steels			
	SKD61 / NAK				SUS304 / SUS 316 / Ti6A				Inconel 718			
외경 Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
ø 1	10,000	400	1	1	9,600	310	0.5	1	3,200	80	0.2	1
ø 2	10,000	400	2	2	9,600	310	1	2	3,200	80	0.4	2
ø 3	6,900	410	3	3	7,400	380	1.5	3	2,700	110	0.6	3
ø 4	5,600	490	4	4	5,600	400	2	4	2,000	120	0.8	4
ø 5	4,500	630	5	5	4,500	410	2.5	5	1,600	130	1	5
ø 6	3,700	740	6	6	3,700	440	3	6	1,300	160	1.2	6
ø 7	3,200	700	7	7	3,200	410	3.5	7	1,100	140	1.4	7
ø 8	2,800	670	8	8	2,800	390	4	8	1,000	130	1.6	8
ø 10	2,200	530	10	10	2,200	350	5	10	800	130	2	10
ø 11	2,000	530	11	11	2,000	320	5.5	11	720	120	2.2	11
ø 12	1,900	530	12	12	1,900	300	6	12	660	110	2.4	12
ø 16	1,400	390	16	16	1,400	280	8	16	500	80	3.2	16
ø 20	1,100	350	20	20	1,100	260	10	20	400	60	4	20

절입량 Depth of Cut			
---------------------	---	--	---

7SUC Cutting Condition

• RPM : rev./min • Feed : mm/min

피삭재 Material	합금강/ 공구강 Alloy Steels / Tools Steel				스테인레스강/ 티탄합금 Stainless Steels / Titanium Alloy Steels				고경도강 Hardened Steels			
	SKD61 / NAK				SUS304 / SUS 316 / Ti6A				Inconel 718			
외경 Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
ø 6	4,070	925	6	6	4,070	550	3	6	1,430	200	1.2	6
ø 8	3,080	838	8	8	3,080	488	4	8	1,100	163	1.6	8
ø 10	2,420	663	10	10	2,420	438	5	10	880	163	2	10
ø 12	2,090	663	12	12	2,090	375	6	12	726	138	2.4	12
ø 16	1,540	488	16	16	1,540	350	8	16	550	100	3.2	16
ø 20	1,210	438	20	20	1,210	325	10	20	440	75	4	20

절입량 Depth of Cut			
---------------------	---	--	---

- 유효장 길이가 긴 경우, RPM과 FEED를 동일 비율로 낮춰주세요.
- 가공 진입시 가능한 피삭재 밖에서 진입 하십시오.
- 절삭 조건이 없는 직경 및 유효장은 비슷한 직경 및 유효장에 비례하여 UP&DOWN 하여 설정 하십시오.
- 상기 절삭조건은 참고 수치이므로 실 가공시 가공 형상, 가공 목적, 적용 기계에 따라 조건변경 요망 합니다.
- 조건표가 기계의 최대 스피들 속도를 초과하거나 버 및 적열 현상이 발생할 때 스피들 속도와 이송속도를 비례하여 조정 하십시오.
- 에어브로, 절삭유, 오일 미스트 클린트를 추천하며, 칩을 잘 제거하고 가공시 발열과 발화에 주의 하십시오
- If the effective length is long, reduce the RPM and feed in the same proportion.
- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- If the diameter or effective length of your tool are not on the table, adjust it compared similarity value on the table.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine, or found red heat on the material, adjust RPM and feed in the same proportion.
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.