

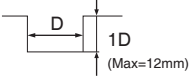
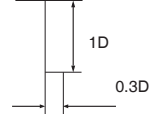
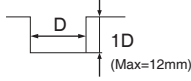
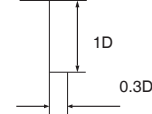
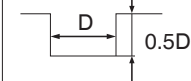
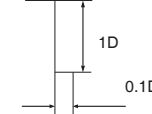
SUE442, SURE442, SUC442, SUR442, SUWC342, SUWC442, SURWC442 절삭조건

SUE442, SURE442, SUC442, SUR442, SUWC342, SUWC442, SURWC442 Cutting Conditions

범용가공 | General milling

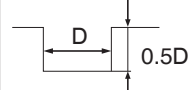
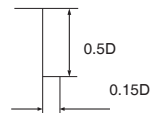
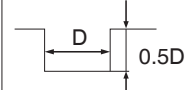
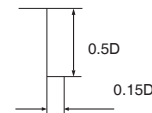
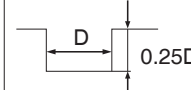
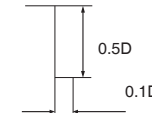
날장 2.5D
Length of cut 2.5D

유효장 3D
Effective Length 3D

피삭재 Work Material	탄소강, 합금강 Carbon Steel, Alloy Steel ~30HRC				SUS 합금 Stainless Steel SUS304				티타늄 합금 Titanium Alloy			
외경 Dia	홈가공 Slotting		측면가공 Side Milling		홈가공 Slotting		측면가공 Side Milling		홈가공 Slotting		측면가공 Side Milling	
	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)
1	20,000	250	20,000	440	17,500	130	19,000	300	11,200	60	12,700	150
1.5	19,000	380	20,000	670	11,700	140	12,700	310	7,500	60	8,500	160
2	14,250	420	15,900	800	8,800	160	9,500	320	5,600	70	6,400	160
3	9,500	500	10,600	850	5,800	180	6,400	330	3,800	80	4,200	170
4	7,120	580	8,000	900	4,400	210	4,800	340	2,800	90	3,200	180
5	5,700	630	6,400	950	3,500	240	3,800	360	2,200	100	2,500	190
6	4,800	700	5,300	950	2,950	260	3,200	380	1,900	110	2,100	190
8	3,600	720	4,000	950	2,200	260	2,400	380	1,400	110	1,600	190
10	2,900	720	3,200	950	1,800	270	1,900	380	1,100	110	1,300	190
12	2,400	670	2,700	860	1,500	240	1,600	350	900	100	1,100	180
16	1,800	590	2,000	790	1,100	200	1,200	320	700	90	800	150
절입량 Depth of Cut (mm)	홈 Slotting 		측면 Side Milling 		홈 Slotting 		측면 Side Milling 		홈 Slotting 		측면 Side Milling 	

범용가공 | General milling

유효장 5D
Effective Length 5D

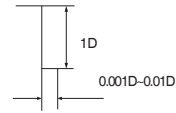
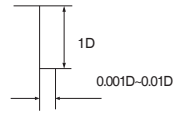
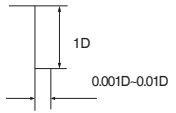
피삭재 Work Material	탄소강, 합금강 Carbon Steel, Alloy Steel ~30HRC				SUS 합금 Stainless Steel SUS304				티타늄 합금 Titanium Alloy			
외경 Dia	홈가공 Slotting		측면가공 Side Milling		홈가공 Slotting		측면가공 Side Milling		홈가공 Slotting		측면가공 Side Milling	
	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)
1	20,000	230	20,000	430	14,300	100	15,900	210	9,500	50	12,700	150
1.5	17,000	330	19,000	630	9,500	110	10,600	220	6,400	50	8,500	160
2	12,700	380	14,300	700	7,200	130	8,000	240	4,800	60	6,400	160
3	8,500	450	9,500	740	4,800	140	5,300	260	3,200	70	4,200	170
4	6,400	500	7,200	790	3,600	160	4,000	270	2,400	80	3,200	180
5	5,100	570	5,700	810	2,900	190	2,700	280	1,900	90	2,500	190
6	4,200	630	4,800	840	2,400	200	2,000	300	1,600	100	2,100	190
8	3,200	640	3,600	840	1,800	200	1,900	300	1,200	100	1,600	190
10	2,500	630	2,900	850	1,400	200	1,600	300	1,000	100	1,300	190
12	2,100	570	2,400	760	1,200	190	1,300	260	800	90	1,100	180
16	1,600	510	1,800	700	900	160	1,000	250	600	80	800	150
절입량 Depth of Cut (mm)	홈 Slotting 		측면 Side Milling 		홈 Slotting 		측면 Side Milling 		홈 Slotting 		측면 Side Milling 	

측면정삭 | Side finishing

날장 2.5D
Length of cut 2.5D

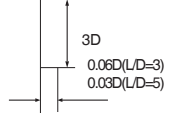
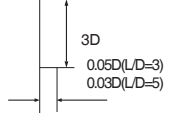
유효장 3D
Effective Length 3D

유효장 5D
Effective Length 5D

피삭재 Work Material	탄소강, 합금강 Carbon Steel, Alloy Steel ~30HRC				SUS 합금 Stainless Steel SUS304				티타늄 합금 Titanium Alloy			
외경 Dia	가공 Slotting		측면가공 Side Milling		홈가공 Slotting		측면가공 Side Milling		홈가공 Slotting		측면가공 Side Milling	
	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)
1			20,000	450			18,000	250			20,000	200
1.5			20,000	660			18,000	390			14,000	230
2			20,000	930			15,800	480			10,500	240
3			15,200	1,100			10,500	500			7,000	260
4			11,400	1,170			7,900	540			5,300	270
5			9,100	1,200			6,300	570			4,200	280
6			7,600	1,200			5,300	570			3,500	280
8			5,700	1,200			3,900	570			2,600	280
10			4,600	1,200			3,200	580			2,100	280
12			3,800	1,100			2,600	500			1,800	260
16			2,800	1,000			2,000	480			1,300	230
절입량 Depth of Cut (mm)			측면 Side Milling 				측면 Side Milling 				측면 Side Milling 	

SUSC542, SURSC542 절삭조건

SUSC542, SURSC542 Cutting Conditions

피삭재 Work Material	탄소강, 합금강 Carbon Steel, Alloy Steel ~30HRC		SUS 합금 Stainless Steel SUS304	
외경 Dia	트로코이달 Trochoidal Milling		트로코이달 Trochoidal Milling	
	Spindle Speed (min ⁻¹)	Feed (mm/min)	Spindle Speed (min ⁻¹)	Feed (mm/min)
6	7,700	3,460	7,700	2,800
8	5,800	2,600	5,800	2,300
10	4,640	2,550	4,640	2,300
12	3,850	2,110	3,850	1,920
16	2,890	1,400	2,890	1,150
절입량 Depth of Cut (mm)	트로코이달 (Trochoidal Milling) 		트로코이달 (Trochoidal Milling) 	

NOTE

- 가능한 고강성, 고정도의 장비와 홀더를 사용해 주십시오
Use the high-rigidity and high accuracy machine and chuck holder as possible.
- 냉각수 유량과 압력을 최대한 증가시켜 가공지점과 인선날에 충분히 공급해 주십시오
Please increasing coolant flow rate and coolant pressure as much as possible, and supply it sufficiently to the machining point and flute
- 수용성 절삭유를 사용해 주십시오
Water soluble cutting fluid is recommended.
- 공구 돌출량은 최대한 짧게 해주십시오
Overhang of end mill should be as short as possible.
- 떨림과 비정상적인 진동이 발생하면 절삭 조건을 조정해 주십시오
If chatter or abnormal vibration occurs, adjust the cutting conditions.