

EcoCut Mini (ECM)

切削条件基準表

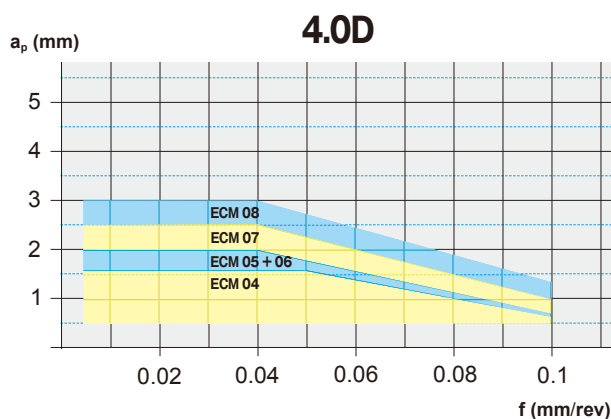
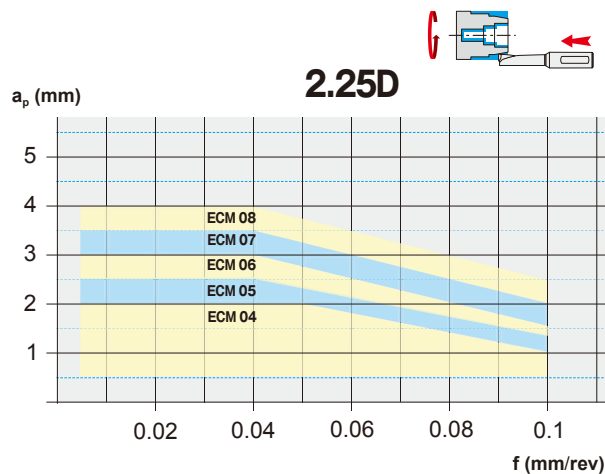
■ EcoCut Mini ドリル加工

被削材		ドリル加工 (旋削加工) 切削速度 Vc (m/min)	ドリル加工 送り量 f (mm/rev)					
			EcoCut Mini 2.25D			EcoCut Mini 4.0D		
			φ 4, 5, 6	φ 7	φ 8	φ 4, 5, 6	φ 7	φ 8
P	軟鋼、低炭素鋼 (SS400, S10C)	80 (40~120)	0.02 (0.005~0.03)	0.025 (0.005~0.035)	0.03 (0.005~0.04)	0.015 (0.005~0.02)	0.02 (0.005~0.025)	0.025 (0.005~0.03)
	炭素鋼、合金鋼 (S50C, SCM440)	80 (40~120)	0.02 (0.005~0.03)	0.025 (0.005~0.035)	0.03 (0.005~0.04)	0.015 (0.005~0.02)	0.02 (0.005~0.025)	0.025 (0.005~0.03)
	ダイス鋼 (SKD11, SKD61)	60 (30~100)	0.02 (0.005~0.03)	0.025 (0.005~0.035)	0.03 (0.005~0.04)	0.015 (0.005~0.02)	0.02 (0.005~0.025)	0.025 (0.005~0.03)
M	ステンレス鋼 (SUS304, SUS420)	60 (30~100)	0.02 (0.005~0.03)	0.025 (0.005~0.035)	0.03 (0.005~0.04)	0.015 (0.005~0.02)	0.02 (0.005~0.025)	0.025 (0.005~0.03)
K	鋳鉄 (FC250)	80 (40~120)	0.02 (0.005~0.03)	0.025 (0.005~0.035)	0.03 (0.005~0.04)	0.015 (0.005~0.02)	0.02 (0.005~0.025)	0.025 (0.005~0.03)
	ダクタイル鋳鉄 (FCD400)	80 (40~120)	0.02 (0.005~0.03)	0.025 (0.005~0.035)	0.03 (0.005~0.04)	0.015 (0.005~0.02)	0.02 (0.005~0.025)	0.025 (0.005~0.03)
N	アルミニウム合金	120 (80~200)	0.02 (0.005~0.03)	0.025 (0.005~0.035)	0.03 (0.005~0.04)	0.015 (0.005~0.02)	0.02 (0.005~0.025)	0.025 (0.005~0.03)
S	耐熱合金 (Inconel 718)	20 (10~30)	0.02 (0.005~0.03)	0.025 (0.005~0.035)	0.03 (0.005~0.04)	0.015 (0.005~0.02)	0.02 (0.005~0.025)	0.025 (0.005~0.03)
	チタン合金 (Ti-6Al-4V)	40 (30~50)	0.02 (0.005~0.03)	0.025 (0.005~0.035)	0.03 (0.005~0.04)	0.015 (0.005~0.02)	0.02 (0.005~0.025)	0.025 (0.005~0.03)

■ EcoCut Mini 旋削加工

旋削時の切削速度は上記表をご参照下さい。

内径／外径旋削の切込み／送り条件



端面旋削の切込み／送り条件

