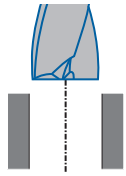
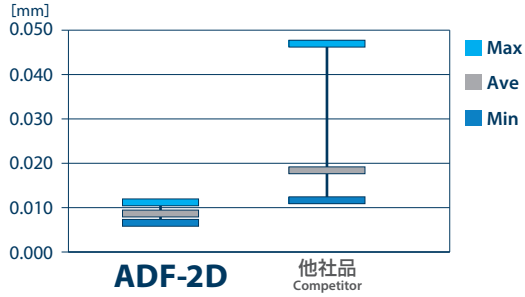
油穴なし
Non Oil Hole

平面の加工 Flat Surface



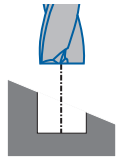
使用工具 Tool	ADF-2D φ10
加工面 Machined Surface	平面 Flat Surface
被削材 Work Material	S50C
切削速度 Cutting Speed	75m/min (2,387min^{-1})
送り速度 Feed	430mm/min (0.18mm/rev)
穴深さ Depth of Hole	20mm (通り) (Through)
切削油剤 Coolant	水溶性切削油剤 Water-Soluble
使用機械 Machine	横形マシニングセンタ (BT40) Horizontal Machining Center

■穴拡大代 Oversize



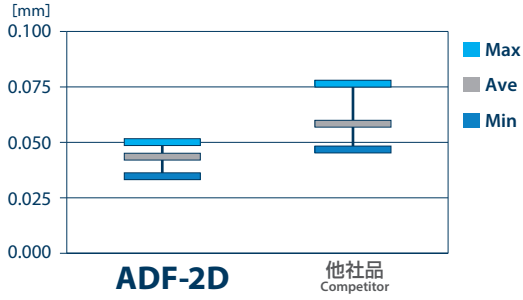
油穴なし
Non Oil Hole

傾斜面の加工 Inclined Surface



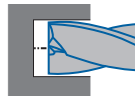
使用工具 Tool	ADF-2D φ10
加工面 Machined Surface	傾斜面 (30°) Inclined Surface
被削材 Work Material	SCM440(30HRC)
切削速度 Cutting Speed	60m/min (1,910min^{-1})
送り速度 Feed	191mm/min (0.1mm/rev)
穴深さ Depth of Hole	20mm (止り) (Blind)
切削油剤 Coolant	水溶性切削油剤 Water-Soluble
使用機械 Machine	横形マシニングセンタ (BT40) Horizontal Machining Center

■穴位置ずれ量 Shift length in hole position

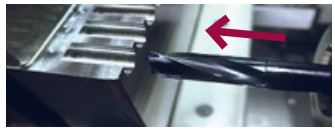


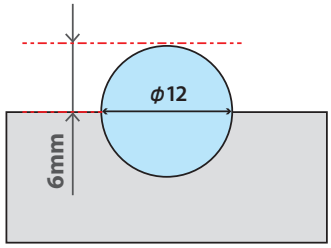
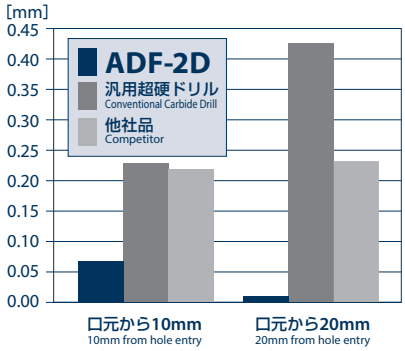
油穴なし
Non Oil Hole

半割れ穴の加工 Half-Hole



使用工具 Tool	ADF-2D φ12
加工面 Machined Surface	平面 Flat Surface
被削材 Work Material	S50C
切削速度 Cutting Speed	37m/min (982min^{-1})
送り速度 Feed	157mm/min (0.16mm/rev)
穴深さ Depth of Hole	24mm (止り) (Blind)
切削油剤 Coolant	水溶性切削油剤 Water-Soluble
使用機械 Machine	横形マシニングセンタ (BT40) Horizontal Machining Center





■倒れ量(口元から1mmの値を基準として)
Fallen amount (based on the value of 1 mm from hole entry)