

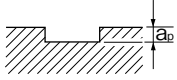
超硬MG 2刃ミニチュア ショート形 MG-EDS-3
溝切削

MG 2 FLUTES SHORT MINIATURE (φ3 SHANK)
SLOTTING

被削材 WORK MATERIAL	鋳鉄 CAST IRON FC, FCD		一般構造用鋼・炭素鋼 MILD STEELS・ CARBON STEELS SS400, S55C (~750N/mm ²)		合金鋼・工具鋼 ALLOY STEELS・ TOOL STEELS SCM, SKT, SKS, SKD (~30HRC)		調質鋼・プリハードン鋼 (快削) HARDENED STEELS・ PREHARDENED STEELS (FREE-CUTTING) SKT, SKD, NAK55, HPM1 (30~38HRC)		調質鋼・プリハードン鋼 (非快削) HARDENED STEELS・ PREHARDENED STEELS (NONFREE-CUTTING) SKT, SKD, NAK80, HPM50 (38~45HRC)		アルミニウム合金 ALUMINUM ALLOYS A7075		銅合金 COPPER ALLOYS C1100	
	呼び MILL DIA. (mm)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)
0.1	31,500	15	31,500	15	31,500	15	31,500	10	—	—	32,000	20	31,500	15
0.2	31,500	30	31,500	30	31,500	25	31,500	20	25,000	15	32,000	40	31,500	30
0.4	31,500	60	31,500	60	27,000	40	22,000	25	17,500	20	32,000	80	31,500	60
0.6	23,500	75	21,000	65	18,000	40	14,500	25	11,500	20	32,000	120	21,000	65
0.8	17,500	80	15,500	70	13,500	40	11,000	25	8,750	20	32,000	160	15,500	70
1	14,000	95	12,500	85	10,500	40	8,900	30	7,000	25	32,000	205	12,500	85
1.2	11,500	95	10,500	85	9,000	40	7,400	30	5,800	25	26,500	200	10,500	85
1.4	10,000	95	9,050	85	7,700	45	6,350	30	5,000	25	22,500	200	9,050	85
1.6	8,950	100	7,950	90	6,750	45	5,550	30	4,350	25	19,500	200	7,950	90
1.8	7,950	105	7,050	95	6,000	55	4,950	30	3,850	25	17,500	200	7,050	95
2	7,150	110	6,350	100	5,400	60	4,450	30	3,500	25	15,500	200	6,350	100
2.2	6,500	110	5,750	100	4,900	65	4,050	30	3,150	25	14,000	245	5,750	100
2.4	5,950	110	5,300	100	4,500	65	3,700	30	2,900	25	13,000	285	5,300	100
2.6	5,500	110	4,850	100	4,150	70	3,400	30	2,650	25	12,000	300	4,850	100
2.8	5,100	110	4,500	100	3,850	75	3,150	30	2,500	25	11,000	300	4,500	100
3	4,750	110	4,200	100	3,600	80	2,950	30	2,300	25	10,500	300	4,200	100

切込深さ
DEPTH
OF CUT

a_p	0.1D
$D_c < \phi 1$	0.1D
$\phi 1 \leq D_c$	0.3D



1. 切削油剤は、鋳切削は油性を使用し、鋳鉄、非鉄金属はエアブローまたは水溶性を使用下さい。

1. Use an oil-based cutting fluid for milling steels. Water soluble oil or dry milling is recommended for cutting cast iron or non-ferrous metals.

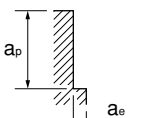
超硬MG 2刃ロング形 MG-EDL
側面切削

MG 2 FLUTES LONG
SIDE MILLING

被削材 WORK MATERIAL	鋳鉄 CAST IRON FC, FCD		一般構造用鋼・炭素鋼 MILD STEELS・ CARBON STEELS SS400, S55C (~750N/mm ²)		合金鋼・工具鋼 ALLOY STEELS・ TOOL STEELS SCM, SKT, SKS, SKD (~30HRC)		調質鋼・プリハードン鋼 (快削) HARDENED STEELS・ PREHARDENED STEELS (FREE CUTTING) SKT, SKD, NAK55, HPM1 (30~38HRC)		調質鋼・プリハードン鋼 (非快削) HARDENED STEELS・ PREHARDENED STEELS (NONFREE-CUTTING) SKT, SKD, NAK80, HPM50 (38~45HRC)		アルミニウム合金 ALUMINUM ALLOYS A7075	
	呼び MILL DIA. (mm)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)	送り速度 FEED (mm/min)	回転速度 SPEED (min ⁻¹)
3	4,750	160	3,350	80	2,850	65	2,300	25	1,900	20	8,450	240
4	3,550	160	2,500	80	2,100	65	1,750	25	1,400	20	6,350	240
5	2,850	165	2,000	80	1,700	65	1,400	25	1,100	20	5,050	240
6	2,350	195	1,650	80	1,400	65	1,150	25	955	20	4,200	240
8	1,750	230	1,250	80	1,050	65	875	25	715	20	3,150	240
10	1,400	230	1,000	80	855	65	700	25	570	20	2,500	240
12	1,150	230	845	80	715	65	580	25	475	20	2,100	240
14	1,000	230	725	80	610	65	500	25	405	20	1,800	240
16	895	235	635	80	535	65	435	25	355	20	1,550	240
18	795	235	565	80	475	65	385	25	315	20	1,400	240
20	715	235	505	80	430	65	350	25	285	20	1,250	240
22	650	235	460	80	390	65	315	25	260	20	1,150	240
24	595	230	420	80	355	65	290	25	235	20	1,050	240
25	570	230	405	80	340	65	280	25	225	20	1,000	240

切込深さ
DEPTH
OF CUT

a_p	a_e
2.5D	0.05D



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