

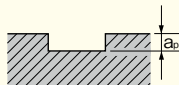
**WXLコート2刃 1.5D刃長タイプ WXL-1.5D-DE**  
溝切削

**WXL Coating Two Flute Short 1.5D Flute Length Type**  
SLOTTING

被削材 WORK MATERIAL	銅・銅合金 COPPER · COPPER ALLOY		一般構造用鋼・炭素鋼 MILD STEELS · CARBON STEELS FC250 · SS400 · S55C ~32HRC		調質鋼・プリハードン鋼・ステンレス鋼 HARDENED STEELS · PREHARDENED STEELS · STAINLESS STEELS SKT · SKD61 · NAK55 · NAK80 · HPM1 · DH				
	呼び MILL DIA (mm)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	33~41HRC		42~50HRC	
						回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)
0.1	50,000	120	40,000	80	40,000	75	40,000	38	
0.2	50,000	170	40,000	110	40,000	90	40,000	45	
0.3	50,000	210	40,000	140	40,000	100	40,000	70	
0.4	50,000	230	40,000	150	40,000	110	34,500	75	
0.5	50,000	250	38,500	150	31,000	110	27,500	75	
0.6	50,000	280	33,500	150	24,500	110	21,000	75	
0.7	50,000	310	30,000	150	21,500	110	18,500	75	
0.8	50,000	360	27,000	150	19,500	110	17,000	80	
0.9	50,000	400	23,500	150	17,000	110	15,000	80	
1	50,000	430	22,000	150	15,500	110	13,500	80	
1.1	50,000	420	20,000	150	14,000	110	12,500	80	
1.2	50,000	420	18,500	150	13,500	110	11,500	80	
1.3	47,000	410	17,500	150	12,500	110	11,000	80	
1.4	44,000	410	16,000	150	11,500	110	10,000	80	
1.5	40,000	400	15,500	150	11,000	110	9,900	80	
1.6	39,000	400	15,000	150	10,500	110	9,400	80	
1.7	36,500	400	14,000	150	9,900	110	8,800	80	
1.8	34,500	400	13,500	160	9,400	110	8,500	80	
1.9	32,500	400	12,500	160	8,800	110	7,900	85	
2	30,000	380	12,000	160	8,700	110	7,900	90	
2.1	29,000	410	11,500	170	8,300	110	7,400	90	
2.2	28,000	410	11,000	170	8,200	110	7,200	90	
2.3	27,500	410	11,000	180	8,000	110	7,000	90	
2.4	26,000	430	10,500	180	7,900	110	6,900	90	
2.5	24,500	430	10,500	200	7,600	110	6,600	90	
2.6	23,500	470	9,800	200	7,400	125	6,300	90	
2.7	23,000	470	9,500	200	7,100	125	6,100	90	
2.8	22,000	470	9,100	210	6,900	125	5,800	95	
2.9	21,500	470	8,800	210	6,700	125	5,700	95	
3	21,000	540	8,900	230	6,800	130	5,700	100	
3.1	20,000	550	8,700	240	6,700	130	5,600	100	
3.2	19,500	560	8,400	240	6,500	145	5,400	105	
3.3	19,000	560	8,100	250	6,300	145	5,200	105	
3.4	18,000	560	7,900	250	6,100	145	5,100	105	
3.5	18,000	560	7,800	250	6,000	155	5,000	105	
3.6	17,500	580	7,600	270	5,900	155	4,900	110	
3.7	16,500	580	7,400	270	5,700	155	4,700	110	
3.8	16,000	590	7,300	280	5,700	155	4,600	110	
3.9	15,500	590	7,100	280	5,500	160	4,500	110	
4	15,500	600	7,000	280	5,500	160	4,500	115	
4.1	15,500	640	6,900	290	5,400	160	4,400	115	
4.2	15,000	640	6,800	290	5,300	160	4,400	115	
4.3	14,000	640	6,700	310	5,200	160	4,300	115	
4.4	14,000	670	6,600	320	5,100	170	4,200	125	
4.5	14,000	670	6,600	320	5,100	170	4,200	125	
4.6	13,500	700	6,500	330	4,900	170	4,100	125	
4.7	13,500	700	6,500	350	4,900	170	4,100	125	
4.8	13,500	710	6,400	350	4,800	170	4,100	125	
4.9	13,500	710	6,300	360	4,700	170	4,000	125	
5	12,500	720	6,200	370	4,600	170	3,900	130	
5.1	12,500	720	6,100	370	4,500	170	3,900	130	
5.2	12,000	720	6,000	370	4,400	170	3,800	130	
5.3	12,000	720	5,900	370	4,400	170	3,800	130	
5.4	11,500	720	5,800	370	4,300	170	3,600	130	
5.5	11,500	720	5,700	370	4,200	170	3,500	130	
5.6	11,500	720	5,600	370	4,100	170	3,500	130	
5.7	11,000	720	5,500	370	4,000	170	3,400	130	
5.8	11,000	710	5,400	370	3,900	170	3,300	130	
5.9	10,500	710	5,300	370	3,800	170	3,300	130	
6	10,000	710	5,200	370	3,800	170	3,200	130	

切込深さ  
DEPTH OF CUT

$D_c < \phi 1$	0.1D
$\phi 1 \leq D_c < \phi 3$	0.3D
$\phi 3 \leq D_c$	0.5D



1. 機械、ホルダは剛性の高いものをご使用下さい。
2. ビビリが発生する時は、回転速度、送り速度を同じ割合で下げてください。
3. 切削油剤は、被削材に適したもので発煙性の少ないものを選んで下さい。
4. 上表の値はあくまでも目安です。実際の加工における切削条件は上表を参考に状況に応じて設定下さい。

1. Use a rigid and precise machine and holder.
2. When chattering occurs, reduce the speed and feed simultaneously.
3. Use a suitable cutting fluid with high smoke retardant properties.
4. Refer to the table above to set the milling conditions in accordance with the actual situation.

# 超硬エンドミル切削条件基準表

RECOMMENDED MILLING CONDITIONS FOR CARBIDE END MILLS

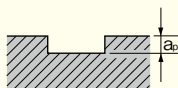
## WXLコート2刃 2D刃長タイプ WXL-2D-DE 溝切削

## WXL Coating Two Flute Short 2D Flute Length Type SLOTTING

被削材 WORK MATERIAL	銅・銅合金 COPPER · COPPER ALLOY			一般構造用鋼・炭素鋼 MILD STEELS · CARBON STEELS FC250 · S5400 · S55C ~32HRC		調質鋼・プリハードン鋼・ステンレス鋼 HARDENED STEELS · PREHARDENED STEELS · STAINLESS STEELS SKT · SKD61 · NAK55 · NAK80 · HPM1 · DH			
	呼び MILL DIA (mm)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	33~41HRC		42~50HRC	
						回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)
0.1	50,000	100	32,000	70	32,000	60	32,000	30	
0.2	50,000	140	32,000	90	32,000	75	32,000	35	
0.3	50,000	170	32,000	110	32,000	80	32,000	40	
0.4	50,000	190	32,000	120	32,000	85	27,500	45	
0.5	50,000	200	31,000	120	25,000	90	22,000	50	
0.6	50,000	230	27,000	120	19,500	90	17,000	55	
0.7	50,000	250	24,000	120	17,000	90	15,000	60	
0.8	50,000	290	21,500	120	15,500	90	13,500	65	
0.9	49,000	320	19,000	120	13,500	90	12,000	65	
1	47,500	350	17,500	120	12,500	90	11,000	65	
1.1	43,000	340	16,000	120	11,500	90	9,900	65	
1.2	40,500	340	15,000	120	10,500	90	9,300	65	
1.3	38,000	330	14,000	120	9,900	90	8,700	65	
1.4	35,000	330	13,000	120	9,200	90	8,100	65	
1.5	32,000	320	12,500	120	8,900	90	7,900	65	
1.6	31,000	320	12,000	120	8,500	90	7,500	65	
1.7	29,000	320	11,000	120	7,900	90	7,000	65	
1.8	28,000	320	10,500	130	7,500	90	6,800	68	
1.9	26,000	320	10,000	130	7,100	90	6,300	68	
2	24,000	310	9,700	130	7,000	90	6,300	70	
2.1	23,000	330	9,300	140	6,600	90	5,900	70	
2.2	22,500	330	9,000	140	6,500	90	5,700	70	
2.3	22,000	330	8,800	150	6,400	90	5,600	70	
2.4	20,500	350	8,600	150	6,300	90	5,500	70	
2.5	20,000	350	8,200	160	6,100	90	5,300	70	
2.6	19,000	380	7,900	160	5,900	100	5,000	70	
2.7	18,000	390	7,600	160	5,700	100	4,900	70	
2.8	17,500	390	7,300	170	5,500	100	4,700	75	
2.9	17,000	380	7,100	170	5,300	100	4,500	75	
3	16,000	400	6,900	170	5,300	100	4,400	75	
3.1	15,500	410	6,700	180	5,100	100	4,300	75	
3.2	15,000	420	6,500	180	5,000	110	4,200	80	
3.3	14,500	420	6,300	190	4,800	110	4,000	80	
3.4	14,000	420	6,100	190	4,600	110	3,900	80	
3.5	14,000	420	6,000	190	4,600	120	3,800	80	
3.6	13,500	430	5,900	200	4,500	120	3,700	85	
3.7	12,500	430	5,700	200	4,400	120	3,600	85	
3.8	12,500	440	5,600	210	4,400	120	3,600	85	
3.9	12,000	440	5,500	210	4,200	125	3,500	85	
4	12,000	450	5,400	210	4,200	125	3,500	90	
4.1	11,500	480	5,300	220	4,100	125	3,400	90	
4.2	11,500	480	5,300	220	4,100	125	3,300	90	
4.3	11,000	480	5,200	230	4,000	125	3,300	90	
4.4	11,000	500	5,100	240	3,900	130	3,200	95	
4.5	10,500	500	5,100	240	3,900	130	3,200	95	
4.6	10,500	520	5,000	250	3,800	130	3,200	95	
4.7	10,500	520	5,000	260	3,800	130	3,100	95	
4.8	10,500	530	4,900	260	3,700	130	3,100	95	
4.9	10,000	530	4,900	270	3,600	130	3,100	95	
5	9,500	540	4,800	270	3,500	130	3,000	100	
5.1	9,500	540	4,700	270	3,500	130	3,000	100	
5.2	9,300	540	4,600	270	3,400	130	2,900	100	
5.3	9,200	540	4,600	270	3,400	130	2,900	100	
5.4	9,000	540	4,500	270	3,300	130	2,800	100	
5.5	8,800	540	4,400	270	3,200	130	2,700	100	
5.6	8,700	540	4,300	270	3,100	130	2,600	100	
5.7	8,500	540	4,200	270	3,100	130	2,600	100	
5.8	8,400	530	4,200	270	3,000	130	2,600	100	
5.9	8,200	530	4,100	270	2,900	130	2,500	100	
6	7,900	530	4,000	270	2,900	130	2,500	100	
6.5	7,500	530	3,700	270	2,700	130	2,300	100	
7	6,900	530	3,400	270	2,500	130	2,100	100	
7.5	6,400	530	3,200	270	2,300	130	2,000	100	
8	5,900	520	3,000	260	2,200	125	1,900	100	
8.5	5,600	520	2,800	260	2,000	125	1,700	100	
9	5,300	510	2,600	260	1,900	125	1,500	100	
9.5	5,100	510	2,500	260	1,800	125	1,400	95	
10	4,700	500	2,400	250	1,700	125	1,500	95	
11	4,400	500	2,200	250	1,600	125	1,100	95	
12	4,000	510	2,000	250	1,400	125	1,200	95	
16	3,000	400	1,500	200	1,100	115	800	80	
18	2,700	360	1,300	180	900	100	700	70	
20	2,400	300	1,200	150	800	90	600	60	

切込深さ  
DEPTH OF CUT

Dc < φ1	0.1D
φ1 ≤ Dc < φ3	0.3D
φ3 ≤ Dc	0.5D



1. 機械、ホルダは剛性のある精度の高いものをご使用下さい。
2. ビビリが発生する時は、回転速度、送り速度を同じ割合で下げてご使用下さい。
3. 切削油剤は、被削材に適したもので発煙性の少ないものを選定して下さい。
4. 上表の値はあくまでも目安です。実際の加工における切削条件は上表を参考に状況に応じて設定下さい。

1. Use a rigid and precise machine and holder.
2. When chattering occurs, reduce the speed and feed simultaneously.
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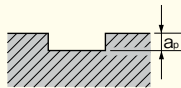
WXLコート2刃 3D刃長タイプ WXL-3D-DE  
溝切削

WXL Coating Two Flute Short 3D Flute Length Type  
SLOTTING

被削材 WORK MATERIAL	銅・銅合金 COPPER・COPPER ALLOY		一般構造用鋼・炭素鋼 MILD STEEL S・CARBON STEELS FC250・SS400・S55C ~32HRC		調質鋼・プリハードン鋼・ステンレス鋼 HARDENED STEELS・PREHARDENED STEELS・STAINLESS STEELS SKT・SKD61・NAK55・NAK80・HPM1・DH				
	呼び MILL DIA. (mm)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	33~41HRC		42~50HRC	
						回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)
0.1	50,000	100	32,000	70	32,000	60	32,000	30	
0.2	50,000	140	32,000	90	32,000	75	32,000	35	
0.3	50,000	170	32,000	110	32,000	80	32,000	55	
0.4	50,000	190	32,000	120	32,000	90	27,500	60	
0.5	50,000	200	31,000	120	25,000	90	22,000	60	
0.6	50,000	230	27,000	120	19,500	90	17,000	60	
0.7	50,000	250	24,000	120	17,000	90	15,000	60	
0.8	50,000	290	21,500	120	15,500	90	13,500	65	
0.9	49,000	320	19,000	120	13,500	90	12,000	65	
1	47,500	350	17,500	120	12,500	90	11,000	65	
1.1	43,000	340	16,000	120	11,500	90	9,900	65	
1.2	40,500	340	15,000	120	10,500	90	9,300	65	
1.3	38,000	330	14,000	120	9,900	90	8,700	65	
1.4	35,000	330	13,000	120	9,200	90	8,100	65	
1.5	32,000	320	12,500	120	8,900	90	7,900	65	
1.6	31,000	320	12,000	120	8,500	90	7,500	65	
1.7	29,000	320	11,000	120	7,900	90	7,000	65	
1.8	28,000	320	10,500	130	7,500	90	6,800	68	
1.9	26,000	320	10,000	130	7,100	90	6,300	68	
2	24,000	310	9,700	130	7,000	90	6,300	70	
2.1	23,000	330	9,300	140	6,600	90	5,900	70	
2.2	22,500	330	9,000	140	6,500	90	5,700	70	
2.3	22,000	330	8,800	150	6,400	90	5,600	70	
2.4	20,500	350	8,600	150	6,300	90	5,500	70	
2.5	20,000	350	8,200	160	6,100	90	5,300	70	
2.6	19,000	380	7,900	160	5,900	100	5,000	70	
2.7	18,000	380	7,600	160	5,700	100	4,900	70	
2.8	17,500	380	7,300	170	5,500	100	4,700	75	
2.9	17,000	380	7,100	170	5,300	100	4,500	75	
3	16,000	400	6,900	170	5,300	100	4,400	75	
3.1	15,500	410	6,700	180	5,100	100	4,300	75	
3.2	15,000	420	6,500	180	5,000	110	4,200	80	
3.3	14,500	420	6,300	190	4,800	110	4,000	80	
3.4	14,000	420	6,100	190	4,600	110	3,900	80	
3.5	14,000	420	6,000	190	4,600	120	3,800	80	
3.6	13,500	430	5,900	200	4,500	120	3,700	85	
3.7	12,500	430	5,700	200	4,400	120	3,600	85	
3.8	12,500	440	5,600	210	4,400	120	3,600	85	
3.9	12,000	440	5,500	210	4,200	125	3,500	85	
4	12,000	450	5,400	210	4,200	125	3,500	90	
4.1	11,500	480	5,300	220	4,100	125	3,400	90	
4.2	11,500	480	5,300	220	4,100	125	3,300	90	
4.3	11,000	480	5,200	230	4,000	125	3,300	90	
4.4	11,000	500	5,100	240	3,900	130	3,200	95	
4.5	10,500	500	5,100	240	3,900	130	3,200	95	
4.6	10,500	520	5,000	250	3,800	130	3,200	95	
4.7	10,500	520	5,000	260	3,800	130	3,100	95	
4.8	10,500	530	4,900	260	3,700	130	3,100	95	
4.9	10,000	530	4,900	270	3,600	130	3,100	95	
5	9,500	540	4,800	270	3,500	130	3,000	100	
5.1	9,500	540	4,700	270	3,500	130	3,000	100	
5.2	9,300	540	4,600	270	3,400	130	2,900	100	
5.3	9,200	540	4,600	270	3,400	130	2,900	100	
5.4	9,000	540	4,500	270	3,300	130	2,800	100	
5.5	8,800	540	4,400	270	3,200	130	2,700	100	
5.6	8,700	540	4,300	270	3,100	130	2,600	100	
5.7	8,500	540	4,200	270	3,100	130	2,600	100	
5.8	8,400	530	4,200	270	3,000	130	2,600	100	
5.9	8,200	530	4,100	270	2,900	130	2,500	100	
6	7,900	530	4,000	270	2,900	130	2,500	100	
6.5	7,500	530	3,700	270	2,700	130	2,300	100	
7	6,900	530	3,400	270	2,500	130	2,100	100	
7.5	6,400	530	3,200	270	2,300	130	2,000	100	
8	5,900	520	3,000	260	2,200	125	1,900	100	
8.5	5,600	520	2,800	260	2,000	125	1,700	100	
9	5,300	510	2,600	260	1,900	125	1,500	100	
9.5	5,100	510	2,500	260	1,800	125	1,400	95	
10	4,700	500	2,400	250	1,700	125	1,500	95	
11	4,400	500	2,200	250	1,600	125	1,100	95	
12	4,000	510	2,000	250	1,400	125	1,200	95	
16	3,000	400	1,500	200	1,100	115	800	80	
18	2,700	360	1,300	180	900	100	700	70	
20	2,400	300	1,200	150	800	90	600	60	

RECOMMENDED MILLING CONDITIONS  
CARBIDE END MILLS  
WXL Coated  
超硬エンドミル  
切削条件

切込深さ DEPTH OF CUT	Dc < φ1	0.1D
	φ1 ≤ Dc < φ3	0.3D
	φ3 ≤ Dc	0.5D



1. 機械、ホルダは剛性のある精度の高いものをご使用下さい。
  2. ピビリが発生する時は、回転速度、送り速度を同じ割合で下げてご使用下さい。
  3. 切削油剤は、被削材に適したもので発煙性の少ないものを選定して下さい。
  4. 上表の値はあくまでも目安です。実際の加工における切削条件は上表を参考に状況に応じて設定下さい。
1. Use a rigid and precise machine and holder.
  2. When chattering occurs, reduce the speed and feed simultaneously.
  3. Use a suitable cutting fluid with high smoke retardant properties.
  4. Refer to the table above to set the milling conditions in accordance with the actual situation.

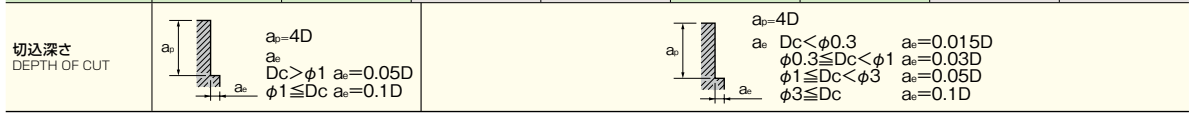
# 超硬エンドミル切削条件基準表

RECOMMENDED MILLING CONDITIONS FOR CARBIDE END MILLS

## WXLコート2刃 4D刃長タイプ WXL-4D-DE 側面切削

## WXL Coating Two Flute Short 4D Flute Length Type SIDE MILLING

被削材 WORK MATERIAL	銅・銅合金 COPPER · COPPER ALLOY		一般構造用鋼・炭素鋼 MILD STEELS · CARBON STEELS FC250 · S45C · S55C ~32HRC		調質鋼・プリハードン鋼・ステンレス鋼 HARDENED STEELS · PREHARDENED STEELS · STAINLESS STEELS SKT · SKD61 · NAK55 · NAK80 · HPM1 · DH				
	呼び MILL DIA (mm)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	33~41HRC		42~50HRC	
						回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)	回転速度 SPEED (min <sup>-1</sup> )	送り速度 FEED (mm/min)
0.2	32,000	90	22,500	30	19,000	30	—	—	
0.3	32,000	110	22,500	40	19,000	35	—	—	
0.4	25,000	110	16,000	45	14,500	35	—	—	
0.5	20,000	120	13,000	45	13,000	40	—	—	
0.6	16,000	120	11,000	45	10,000	40	—	—	
0.7	16,000	120	9,400	45	6,800	40	—	—	
0.8	12,000	120	8,400	45	6,000	40	—	—	
0.9	12,000	120	7,500	45	5,400	40	—	—	
1	9,800	120	5,700	45	5,400	40	—	—	
1.1	9,500	140	5,200	45	5,000	40	—	—	
1.2	8,600	130	4,800	45	4,500	40	—	—	
1.3	8,100	130	4,500	45	4,200	40	—	—	
1.4	7,500	130	4,200	45	3,900	40	—	—	
1.5	7,000	130	3,900	45	3,600	40	—	—	
1.6	6,400	120	3,700	45	3,500	40	—	—	
1.7	6,200	120	3,600	45	3,400	40	—	—	
1.8	5,800	120	3,300	45	3,100	40	—	—	
1.9	5,500	120	3,200	45	3,000	40	—	—	
2	5,200	120	3,000	45	2,800	40	—	—	
2.1	4,800	120	2,900	45	2,800	40	—	—	
2.2	4,600	130	2,700	50	2,600	40	—	—	
2.3	4,500	130	2,700	50	2,600	40	—	—	
2.4	4,400	130	2,600	55	2,500	40	—	—	
2.5	4,100	140	2,500	55	2,500	40	—	—	
2.6	3,900	140	2,400	55	2,400	40	—	—	
2.7	3,700	150	2,300	55	2,300	45	—	—	
2.8	3,600	150	2,200	55	2,200	45	—	—	
2.9	3,500	150	2,100	60	2,100	45	—	—	
3	3,400	150	2,100	60	2,100	50	1,900	30	
3.1	3,200	160	2,000	60	2,000	50	1,800	30	
3.2	3,000	160	2,000	65	2,000	50	1,800	30	
3.3	2,900	160	1,900	65	1,900	55	1,700	30	
3.4	2,800	160	1,800	70	1,800	55	1,700	30	
3.5	2,800	160	1,800	70	1,800	55	1,600	30	
3.6	2,700	160	1,800	70	1,800	60	1,600	30	
3.7	2,700	170	1,700	70	1,700	60	1,500	35	
3.8	2,500	170	1,700	70	1,700	60	1,500	35	
3.9	2,400	170	1,600	75	1,600	60	1,500	35	
4	2,400	170	1,600	75	1,600	65	1,400	35	
4.1	2,400	180	1,600	75	1,600	65	1,400	35	
4.2	2,300	190	1,600	80	1,600	65	1,400	35	
4.3	2,300	190	1,500	80	1,500	65	1,400	35	
4.4	2,100	190	1,500	80	1,500	65	1,400	35	
4.5	2,100	200	1,500	85	1,500	65	1,300	40	
4.6	2,100	200	1,500	85	1,500	65	1,300	40	
4.7	2,100	200	1,500	90	1,500	65	1,300	40	
4.8	2,100	200	1,500	90	1,500	65	1,300	40	
4.9	2,000	210	1,400	90	1,400	65	1,300	40	
5	2,000	210	1,400	95	1,400	65	1,300	40	
5.1	1,900	210	1,400	95	1,400	65	1,200	40	
5.2	1,900	210	1,400	95	1,400	65	1,200	40	
5.3	1,800	210	1,300	95	1,300	65	1,200	40	
5.4	1,800	210	1,300	95	1,300	65	1,200	40	
5.5	1,800	210	1,300	95	1,300	65	1,100	40	
5.6	1,700	210	1,300	95	1,300	65	1,100	40	
5.7	1,700	210	1,300	95	1,300	65	1,100	40	
5.8	1,700	210	1,200	95	1,200	65	1,100	40	
5.9	1,600	210	1,200	95	1,200	65	1,000	40	
6	1,600	210	1,200	95	1,200	65	1,000	40	
8	1,100	200	900	95	900	65	800	40	
10	900	200	700	90	700	65	630	40	
12	800	200	600	90	600	65	525	40	



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