

1) 侧面铣削 标准型2刃、4刃 Side Milling Standard 2/4Flutes

| | | | | | | | | | | | | |
|---------------------------|--|---|------------|--------------------------------|--|------------|---|---|---|--|------------------------------------|--|
| 加工形态 Shape of cut | | | | | | | $Ae \leq 0.1D (D \leq \Phi 3)$ $Ae \leq 0.2D (D > \Phi 3)$ $Ap \leq 1.5D$ | | | | $Ae \leq 0.05D$ $AP \leq 1.00D$ | |
| 加工材料 Work material | 碳素钢、铸铁 Carbon steel, Castiron AISI 1049, SCM, FC250 ($\sim 30\text{HRC}$) | | | | 合金钢、模具钢、预硬钢 Alloy steel, Die steel, Pre-hardened steel AISI H13, NAK ($< 45\text{HRC}$) | | | | 淬火钢 Hardened steel AISI H13 ($< 52\text{HRC}$) | | | |
| 直径 $\Phi D(\text{mm})$ | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | | | |
| | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | | |
| 1 | 24000 | 480 | 720 | 16000 | 320 | 480 | 12000 | 96 | 144 | | | |
| 2 | 12000 | 480 | 720 | 8000 | 320 | 480 | 6400 | 96 | 144 | | | |
| 3 | 8000 | 480 | 720 | 5600 | 320 | 480 | 4000 | 96 | 144 | | | |
| 4 | 6000 | 480 | 720 | 4160 | 320 | 480 | 3200 | 96 | 144 | | | |
| 5 | 4800 | 480 | 720 | 3360 | 320 | 480 | 2560 | 96 | 144 | | | |
| 6 | 4000 | 480 | 720 | 2800 | 320 | 480 | 2160 | 96 | 144 | | | |
| 8 | 3200 | 416 | 624 | 2240 | 280 | 416 | 1600 | 88 | 128 | | | |
| 10 | 2560 | 360 | 544 | 1760 | 240 | 360 | 1280 | 80 | 112 | | | |
| 12 | 2160 | 328 | 496 | 1520 | 216 | 328 | 1040 | 80 | 96 | | | |
| 16 | 1600 | 288 | 440 | 1120 | 184 | 280 | 800 | 104 | 136 | | | |
| 20 | 1280 | 256 | 392 | 880 | 176 | 272 | 640 | 88 | 112 | | | |

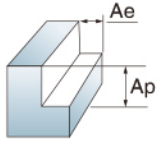
2) 沟槽铣削 标准型2刃、4刃 Slotting Standard 2/4Flutes

| | | | | | | | | | | | | |
|---------------------------|--|---|------------|--------------------------------|--|------------|--|---|---|--|---|--|
| 加工形态 Shape of cut | | | | | | | $Ae = D (D \leq \Phi 3)$ $Ae \leq 0.1D (D > \Phi 2)$ $Ap \leq 0.2D (D > \Phi 2)$ | | | | $Ae = D$ $AP \leq 0.05D (\Phi 0.5 \leq D \leq \Phi 2)$ $AP \leq 0.10D (D > \Phi 2)$ | |
| 加工材料 Work material | 碳素钢、铸铁 Carbon steel, Castiron AISI 1049, SCM, FC250 ($\sim 30\text{HRC}$) | | | | 合金钢、模具钢、预硬钢 Alloy steel, Die steel, Pre-hardened steel AISI H13, NAK ($< 45\text{HRC}$) | | | | 淬火钢 Hardened steel AISI H13 ($< 52\text{HRC}$) | | | |
| 直径 $\Phi D(\text{mm})$ | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | | | |
| | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | | |
| 1 | 24000 | 384 | 576 | 16000 | 256 | 384 | 12000 | 77 | 116 | | | |
| 2 | 12000 | 384 | 576 | 8000 | 256 | 384 | 6400 | 77 | 116 | | | |
| 3 | 8000 | 384 | 576 | 5600 | 256 | 384 | 4000 | 77 | 116 | | | |
| 4 | 6000 | 384 | 576 | 4160 | 256 | 384 | 3200 | 77 | 116 | | | |
| 5 | 4800 | 384 | 576 | 3360 | 256 | 384 | 2560 | 77 | 116 | | | |
| 6 | 4000 | 384 | 576 | 2800 | 256 | 384 | 2160 | 77 | 116 | | | |
| 8 | 3200 | 333 | 500 | 2240 | 224 | 333 | 1600 | 71 | 103 | | | |
| 10 | 2560 | 288 | 436 | 1760 | 192 | 288 | 1280 | 64 | 90 | | | |
| 12 | 2160 | 363 | 397 | 1520 | 173 | 263 | 1040 | 64 | 77 | | | |
| 16 | 1600 | 231 | 352 | 1120 | 148 | 224 | 800 | 84 | 109 | | | |
| 20 | 1280 | 205 | 314 | 880 | 141 | 218 | 640 | 71 | 90 | | | |

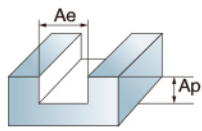
使用中的注意事项

1. 请使用精度高、刚性好的设备和夹具。
 2. 如果加工设备或工具的夹持刚性不足而出现震动或杂音时，请适度降低转速或进给速度。
 3. 纵向进给时，进给速度请设定为上表1/3以下。
 4. 切削不锈钢时，请用湿式加工；切削奥氏体不锈钢时，使用非水溶性切削液效果好。
1. Use rigid and precise machine and tool holder. 2. If chattering and noise occur due to the rigidity of machine or the work material installation is very low, please reduce the revolution and the feed rate proportionately.
3. In drilling, please set the feed rate at 1/3 or below.
4. When cutting stainless steel, please use fluid; when cutting Austenitic stainless steel, non-water-soluble cutting fluid is very effective.

1) 侧面铣削 加长型2刃、4刃 Side Milling Extra Long 2/4Flutes

| | | | | | | | | | | | | |
|---------------------------|--|---------------------------|------------|--|---------------------------|------------|---|---------------------------|------------|-------------------------------------|---------------------------|------------|
| 加工形态 Shape of cut |  | | | | | | $Ae \leq 0.1D (D \leq \Phi 3)$ $Ae \leq 0.2D (D > \Phi 3)$ $Ap \leq 1.5D$ | | | $Ae \leq 0.05D$ $AP \leq 1.00D$ | | |
| 加工材料 Work material | 碳素钢、铸铁 Carbon steel, Castiron AISI 1049, SCM, FC250 ($\sim 30\text{HRC}$) | | | 合金钢、模具钢、预硬钢 Alloy steel, Die steel, Pre-hardened steel AISI H13, NAK ($< 45\text{HRC}$) | | | 淬火钢 Hardened steel AISI H13 ($< 52\text{HRC}$) | | | | | |
| 直径 $\Phi D(\text{mm})$ | 转速 $\text{Rev}(\text{min}^{-1})$ | 切削速度Cutting speed(mm/min) | | 转速 $\text{Rev}(\text{min}^{-1})$ | 切削速度Cutting speed(mm/min) | | 转速 $\text{Rev}(\text{min}^{-1})$ | 切削速度Cutting speed(mm/min) | | 转速 $\text{Rev}(\text{min}^{-1})$ | 切削速度Cutting speed(mm/min) | |
| | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes |
| 1 | 15000 | 300 | 450 | 10000 | 200 | 300 | 7500 | 60 | 90 | | | |
| 2 | 7500 | 300 | 450 | 5000 | 200 | 300 | 4000 | 60 | 90 | | | |
| 3 | 5000 | 300 | 450 | 3500 | 200 | 300 | 2500 | 60 | 90 | | | |
| 4 | 3750 | 300 | 450 | 2600 | 200 | 300 | 2000 | 60 | 90 | | | |
| 5 | 3000 | 300 | 450 | 2100 | 200 | 300 | 1600 | 60 | 90 | | | |
| 6 | 2500 | 300 | 450 | 1750 | 200 | 300 | 1350 | 60 | 90 | | | |
| 8 | 2000 | 260 | 390 | 1400 | 175 | 260 | 1000 | 55 | 80 | | | |
| 10 | 1600 | 225 | 340 | 1100 | 150 | 225 | 800 | 50 | 70 | | | |
| 12 | 1350 | 205 | 310 | 950 | 135 | 205 | 650 | 50 | 60 | | | |
| 16 | 1000 | 180 | 275 | 700 | 115 | 175 | 500 | 65 | 85 | | | |
| 20 | 800 | 160 | 245 | 550 | 110 | 170 | 400 | 55 | 70 | | | |

2) 沟槽铣削 加长型2刃、4刃 Slotting Extra Long 2/4Flutes

| | | | | | | | | | | | | |
|---------------------------|--|---------------------------|------------|--|---------------------------|------------|--|---------------------------|------------|---|---------------------------|------------|
| 加工形态 Shape of cut |  | | | | | | $Ae = D (D \leq \Phi 3)$ $Ae \leq 0.1D (D > \Phi 2)$ $Ap \leq 0.2D (D > \Phi 2)$ | | | $Ae = D$ $AP \leq 0.05D (\Phi 0.5 \leq D \leq \Phi 2)$ $AP \leq 0.10D (D > \Phi 2)$ | | |
| 加工材料 Work material | 碳素钢、铸铁 Carbon steel, Castiron AISI 1049, SCM, FC250 ($\sim 30\text{HRC}$) | | | 合金钢、模具钢、预硬钢 Alloy steel, Die steel, Pre-hardened steel AISI H13, NAK ($< 45\text{HRC}$) | | | 淬火钢 Hardened steel AISI H13 ($< 52\text{HRC}$) | | | | | |
| 直径 $\Phi D(\text{mm})$ | 转速 $\text{Rev}(\text{min}^{-1})$ | 切削速度Cutting speed(mm/min) | | 转速 $\text{Rev}(\text{min}^{-1})$ | 切削速度Cutting speed(mm/min) | | 转速 $\text{Rev}(\text{min}^{-1})$ | 切削速度Cutting speed(mm/min) | | 转速 $\text{Rev}(\text{min}^{-1})$ | 切削速度Cutting speed(mm/min) | |
| | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes |
| 1 | 15000 | 240 | 360 | 10000 | 160 | 240 | 7500 | 48 | 72 | | | |
| 2 | 7500 | 240 | 360 | 5000 | 160 | 240 | 4000 | 48 | 72 | | | |
| 3 | 5000 | 240 | 360 | 3500 | 160 | 240 | 2500 | 48 | 72 | | | |
| 4 | 3750 | 240 | 360 | 2600 | 160 | 240 | 2000 | 48 | 72 | | | |
| 5 | 3000 | 240 | 360 | 2100 | 160 | 240 | 1600 | 48 | 72 | | | |
| 6 | 2500 | 240 | 360 | 1750 | 160 | 240 | 1350 | 48 | 72 | | | |
| 8 | 2000 | 208 | 312 | 1400 | 140 | 208 | 1000 | 44 | 64 | | | |
| 10 | 1600 | 180 | 272 | 1100 | 120 | 180 | 800 | 40 | 56 | | | |
| 12 | 1350 | 164 | 248 | 950 | 108 | 164 | 650 | 40 | 48 | | | |
| 16 | 1000 | 144 | 220 | 700 | 92 | 140 | 500 | 52 | 68 | | | |
| 20 | 800 | 128 | 196 | 550 | 88 | 136 | 400 | 44 | 56 | | | |

使用中的注意事项

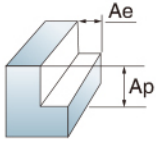
1. 请使用精度高、刚性好的设备和夹具。
2. 如果加工设备或工具的夹持刚性不足而出现震动或杂音时，请适度降低转速或进给速度。
3. 纵向进给时，进给速度请设定为上表1/3以下。
4. 切削不锈钢时，请用湿式加工；切削奥氏体不锈钢时，使用非水溶性切削液效果好。

1. Use rigid and precise machine and tool holder. 2. If chattering and noise occur due to the rigidity of machine or the work material installation is very low, please reduce the revolution and the feed rate proportionately.

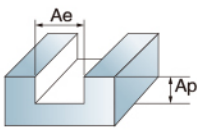
3. In drilling, please set the feed rate at 1/3 or below.

4. When cutting stainless steel, please use fluid; when cutting Austenitic stainless steel, non-water-soluble cutting fluid is very effective.

1) 侧面铣削 标准型2刃、4刃 Side Milling Standard 2/4Flutes

| | | | | | | | | | | | | |
|-----------------------|---|---------------------------|------------|--|---------------------------|------------|--|---------------------------|------------|---|---------------------------|------------|
| 加工形态 Shape of cut |  | | | | | | | | | | | |
| | $Ae \leq 0.1D (D \leq \Phi 3)$ $Ae \leq 0.2D (D > \Phi 3)$ $Ap \leq 1.5D$ | | | | | | | | | | | |
| 加工材料 Work material | 铝合金, 铜 Aluminum Alloy, cuprum | | | 碳素钢、铸铁 Carbon steel, Castiron AISI 1049, SCM, FC250 ($\bar{30}$ HRC) | | | 合金钢、模具钢 Alloy steel, Die steel (< 35 HRC) | | | 不锈钢 Stainless steel AISI 1304, AISI1316 | | |
| 直径 ΦD (mm) | 转速 Rev(min ⁻¹) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min ⁻¹) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min ⁻¹) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min ⁻¹) | 切削速度Cutting speed(mm/min) | |
| | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes |
| 1 | 30400 | 240 | 480 | 16000 | 96 | 192 | 9600 | 56 | 112 | 8000 | 48 | 96 |
| 2 | 17600 | 352 | 640 | 8800 | 144 | 216 | 5760 | 88 | 136 | 4800 | 75 | 112 |
| 3 | 13600 | 384 | 696 | 6800 | 160 | 240 | 4240 | 104 | 160 | 3520 | 88 | 136 |
| 4 | 11200 | 584 | 880 | 5760 | 288 | 432 | 3520 | 176 | 264 | 2960 | 144 | 216 |
| 5 | 9600 | 688 | 1040 | 4800 | 304 | 456 | 2880 | 184 | 280 | 2400 | 152 | 232 |
| 6 | 8800 | 792 | 1200 | 4240 | 336 | 504 | 2560 | 192 | 288 | 2160 | 168 | 256 |
| 8 | 6400 | 800 | 1200 | 3200 | 360 | 544 | 1920 | 192 | 288 | 1600 | 176 | 264 |
| 10 | 5120 | 720 | 1080 | 2560 | 312 | 472 | 1520 | 152 | 232 | 1280 | 152 | 232 |
| 12 | 4240 | 592 | 880 | 2160 | 264 | 400 | 1280 | 128 | 192 | 1040 | 120 | 184 |
| 16 | 3200 | 448 | 672 | 1600 | 192 | 288 | 960 | 96 | 144 | 800 | 96 | 144 |
| 20 | 2560 | 360 | 544 | 1280 | 160 | 240 | 800 | 80 | 120 | 640 | 76 | 112 |

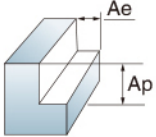
2) 沟槽铣削 标准型2刃、4刃 Slotting Standard 2/4Flutes

| | | | | | | | | | | | | |
|-----------------------|---|---------------------------|------------|--|---------------------------|------------|--|---------------------------|------------|---|---------------------------|------------|
| 加工形态 Shape of cut |  | | | | | | | | | | | |
| | 2刃 $Ae=D$ $Ap \leq 0.1D (D < \Phi 2)$ $Ap \leq 0.3D (\Phi 2 \leq D \leq \Phi 3)$ $Ap \leq 0.5D (D > \Phi 3)$ | | | | | | | | | | | |
| 加工材料 Work material | 铝合金, 铜 Aluminum Alloy, cuprum | | | 碳素钢、铸铁 Carbon steel, Castiron AISI 1049, SCM, FC250 ($\bar{30}$ HRC) | | | 合金钢、模具钢 Alloy steel, Die steel (< 35 HRC) | | | 不锈钢 Stainless steel AISI 1304, AISI1316 | | |
| 直径 ΦD (mm) | 转速 Rev(min ⁻¹) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min ⁻¹) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min ⁻¹) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min ⁻¹) | 切削速度Cutting speed(mm/min) | |
| | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes |
| 1 | 30400 | 240 | 384 | 16000 | 96 | 154 | 9600 | 56 | 90 | 8000 | 48 | 77 |
| 2 | 17600 | 352 | 512 | 8800 | 144 | 173 | 5760 | 88 | 109 | 4800 | 72 | 90 |
| 3 | 13600 | 384 | 560 | 6800 | 160 | 192 | 4240 | 104 | 128 | 3520 | 88 | 109 |
| 4 | 11200 | 464 | 704 | 5760 | 232 | 346 | 3520 | 144 | 212 | 2400 | 88 | 173 |
| 5 | 9600 | 552 | 832 | 4800 | 240 | 365 | 2880 | 144 | 224 | 1920 | 88 | 186 |
| 6 | 8800 | 632 | 960 | 4240 | 272 | 404 | 2560 | 152 | 231 | 1760 | 104 | 205 |
| 8 | 6400 | 640 | 960 | 3200 | 288 | 436 | 1920 | 152 | 231 | 1280 | 104 | 212 |
| 10 | 5120 | 576 | 864 | 2560 | 248 | 378 | 1520 | 120 | 186 | 1040 | 88 | 186 |
| 12 | 3200 | 472 | 704 | 2160 | 208 | 320 | 1280 | 104 | 154 | 800 | 72 | 148 |
| 16 | 2560 | 360 | 538 | 1600 | 152 | 231 | 960 | 80 | 116 | 640 | 56 | 116 |
| 20 | 2000 | 288 | 736 | 1280 | 128 | 192 | 800 | 64 | 96 | 512 | 48 | 90 |

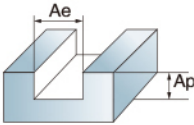
使用中的注意事项

1. 请使用精度高、刚性好的设备和夹具。
 2. 如果加工设备或工具的夹持刚性不足而出现震动或杂音时, 请适度降低转速或进给速度。
 3. 纵向进给时, 进给速度请设定为上表1/3以下。
 4. 切削不锈钢时, 请用湿式加工; 切削奥氏体不锈钢时, 使用非水溶性切削液效果好。
1. Use rigid and precise machine and tool holder. 2. If chattering and noise occur due to the rigidity of machine or the work material installation is very low, please reduce the revolution and the feed rate proportionately.
3. In drilling, please set the feed rate at 1/3 or below.
4. When cutting stainless steel, please use fluid; when cutting Austenitic stainless steel, non-water-soluble cutting fluid is very effective.

1) 侧面铣削 加长型2刃、4刃 Side Milling Extra Long 2/4Flutes

| 加工形态 Shape of cut |  $Ae \leq 0.1D (D \leq \Phi 3)$ $Ae \leq 0.2D (D > \Phi 3)$ $Ap \leq 1.5D$ | | | | | | | | | | | |
|---------------------------|---|---|------------|--|---|------------|---|---|------------|---|---|------------|
| | 铝合金, 铜 Aluminum Alloy, cuprum | | | 碳素钢、铸铁 Carbon steel, Castiron AISI 1049, SCM, FC250 ($\sim 30\text{HRC}$) | | | 合金钢、模具钢 Alloy steel, Die steel ($< 35\text{HRC}$) | | | 不锈钢 Stainless steel AISI 1304, AISI1316 | | |
| 直径 $\Phi D(\text{mm})$ | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | |
| | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes |
| 1 | 19000 | 50 | 300 | 10000 | 60 | 120 | 6000 | 35 | 70 | 5000 | 30 | 60 |
| 2 | 11000 | 220 | 400 | 5500 | 90 | 135 | 3600 | 55 | 85 | 3000 | 45 | 70 |
| 3 | 8500 | 240 | 435 | 4250 | 100 | 150 | 2650 | 65 | 100 | 2200 | 55 | 85 |
| 4 | 7000 | 365 | 550 | 3600 | 180 | 270 | 2200 | 110 | 165 | 1850 | 90 | 135 |
| 5 | 6000 | 430 | 650 | 3000 | 190 | 185 | 1800 | 115 | 175 | 1500 | 95 | 145 |
| 6 | 5500 | 495 | 750 | 2650 | 210 | 315 | 1600 | 120 | 180 | 1350 | 105 | 160 |
| 8 | 4000 | 500 | 750 | 2000 | 225 | 340 | 1200 | 120 | 180 | 1000 | 110 | 165 |
| 10 | 3200 | 450 | 675 | 1600 | 195 | 295 | 950 | 95 | 145 | 800 | 95 | 145 |
| 12 | 2560 | 370 | 550 | 1350 | 165 | 250 | 800 | 80 | 120 | 650 | 75 | 115 |
| 16 | 2000 | 280 | 420 | 1000 | 120 | 180 | 600 | 60 | 90 | 500 | 60 | 90 |
| 20 | 1600 | 225 | 340 | 800 | 100 | 150 | 500 | 50 | 75 | 400 | 48 | 70 |

2) 沟槽铣削 加长型2刃、4刃 Slotting Extra Long 2/4Flutes

| 加工形态 Shape of cut |  <div style="display: flex; justify-content: space-around;"> <div> <p>2刃 $Ae=D$</p> <p>$Ap \leq 0.1D (D < \Phi 2)$</p> <p>$Ap \leq 0.3D (\Phi 2 \leq D \leq \Phi 3)$</p> <p>$Ap \leq 0.5D (D > \Phi 3)$</p> </div> <div> <p>4刃 $Ae=D$</p> <p>$Ap \leq 0.3D (D \leq \Phi 3)$</p> <p>$Ap \leq 0.5D (D > \Phi 3)$</p> </div> </div> | | | | | | | | | | | |
|---------------------------|---|---|------------|--|---|------------|---|---|------------|---|---|------------|
| | 铝合金, 铜 Aluminum Alloy, cuprum | | | 碳素钢、铸铁 Carbon steel, Castiron AISI 1049, SCM, FC250 ($\sim 30\text{HRC}$) | | | 合金钢、模具钢 Alloy steel, Die steel ($< 35\text{HRC}$) | | | 不锈钢 Stainless steel AISI 1304, AISI1316 | | |
| 直径 $\Phi D(\text{mm})$ | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | | 转速 Rev(min^{-1}) | 切削速度Cutting speed(mm/min) | |
| | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes | | 2刃 2Flutes | 4刃 4Flutes |
| 1 | 19000 | 150 | 240 | 10000 | 60 | 96 | 6000 | 35 | 56 | 5000 | 30 | 48 |
| 2 | 11000 | 220 | 320 | 5500 | 90 | 108 | 3600 | 55 | 68 | 3000 | 45 | 56 |
| 3 | 8500 | 240 | 350 | 4250 | 100 | 120 | 2650 | 65 | 80 | 2200 | 55 | 68 |
| 4 | 7000 | 290 | 440 | 3600 | 145 | 216 | 2200 | 90 | 132 | 1500 | 55 | 108 |
| 5 | 6000 | 345 | 520 | 3000 | 150 | 228 | 1800 | 90 | 140 | 1200 | 55 | 116 |
| 6 | 5500 | 395 | 600 | 2650 | 170 | 252 | 1600 | 95 | 144 | 1100 | 65 | 128 |
| 8 | 4000 | 400 | 600 | 2000 | 180 | 272 | 1200 | 95 | 144 | 800 | 65 | 132 |
| 10 | 3200 | 360 | 540 | 1600 | 155 | 236 | 950 | 75 | 116 | 650 | 55 | 116 |
| 12 | 2560 | 295 | 440 | 1350 | 130 | 200 | 800 | 65 | 96 | 500 | 45 | 92 |
| 16 | 2000 | 225 | 336 | 1000 | 95 | 144 | 600 | 50 | 72 | 400 | 35 | 72 |
| 20 | 1600 | 180 | 272 | 800 | 80 | 120 | 500 | 40 | 60 | 320 | 30 | 56 |

使用中的注意事项

- 请使用精度高、刚性好的设备和夹具。
- 如果加工设备或工具的夹持刚性不足而出现震动或杂音时, 请适度降低转速或进给速度。
- 纵向进给时, 进给速度请设定为上表1/3以下。
- 切削不锈钢时, 请用湿式加工; 切削奥氏体不锈钢时, 使用非水溶性切削液效果好。

- Use rigid and precise machine and tool holder.
- If chattering and noise occur due to the rigidity of machine or the work material installation is very low, please reduce the revolution and the feed rate proportionately.
- In drilling, please set the feed rate at 1/3 or below.
- When cutting stainless steel, please use fluid; when cutting Austenitic stainless steel, non-water-soluble cutting fluid is very effective.