

產品規格表 **P82-83**
Specification page

● P-UMIE 2 Flutes Cutting Condition 標準切削

Working material hardness 被切削材硬度	HRC30~ 50		HRC50~ 55	
	Rotational speed 轉速	Feeding speed 進給	Rotational speed 轉速	Feeding speed 進給
Diameter D	RPM 轉/分	mm/min. mm/分	RPM 轉/分	mm/min. mm/分
D0.2	25000	144	22500	130
D0.3	25000	171	22500	154
D0.4	25000	189	22500	170
D0.5	25000	216	22500	194
D0.6	25000	216	22500	194
D0.7	23000	252	20700	227
D0.8	21500	270	19350	243
D0.9	20000	324	18000	292



Attention : In order to get better cutting surface and lengthen the life-time of the end mill, please use high accuracy, high rigidity and dynamic equilibrium of holder.

請特別注意：為了得到較佳之切削表面及延長刀具壽命，請務必使用高精度、高剛性、動平衡佳之刀把夾治具。

1. Before using the end mill, please examine the end mill to lean towards and put, when the precision of the leaning towards of end mill exceeds 0.01mm, please cut after correcting.
2. It is better that end mill stretches out shorter from chuck, when the end mill stretches out longer, please adjust the rotational speed, feeding speed or cutting amount.
3. Unusual vibrations or sound happen when cutting, please adjust and lower the rotational speed of the main shaft one by one, feeding speed and cutting amount until improving the situation, or change the high-quality end mill.
4. It is the best way to cool steel material by spraying or air in order to make **nBS** efficiently; we commend to adopt non-water cutting liquid to cool the stainless steel, titanium alloy or heat-resisting alloy.
5. Cutting will be influenced by work piece, machine and software; the above-mentioned data are only for reference, please improve feeding speed by 30%~50% up after cutting situation steadily.

1. 使用本刀具前請測刀具偏擺，刀具之偏擺精度超過0.01mm時，請改正後再進行切削。
2. 刀具伸出夾頭之長度越短越好，刀具之伸出量若伸出較長時，請自行調降轉速、進給速度或切削量。
3. 在切削中如果產生異常之震動或聲音時，請逐一調降主軸轉速，進給速度與切削量至情況改善為止，或更換高品質刀把。
4. 鋼料冷卻以噴霧式或噴氣式為最佳選用方式，以使**nBS**發揮最佳效果，不鏽鋼鈦合金或耐熱合金建議採用非水溶性切削液。
5. 切削方式依工件、機器、軟件之影響，以上之數據僅供參考，待切削狀況穩定後再將進給速度往上提高 30%-50%。