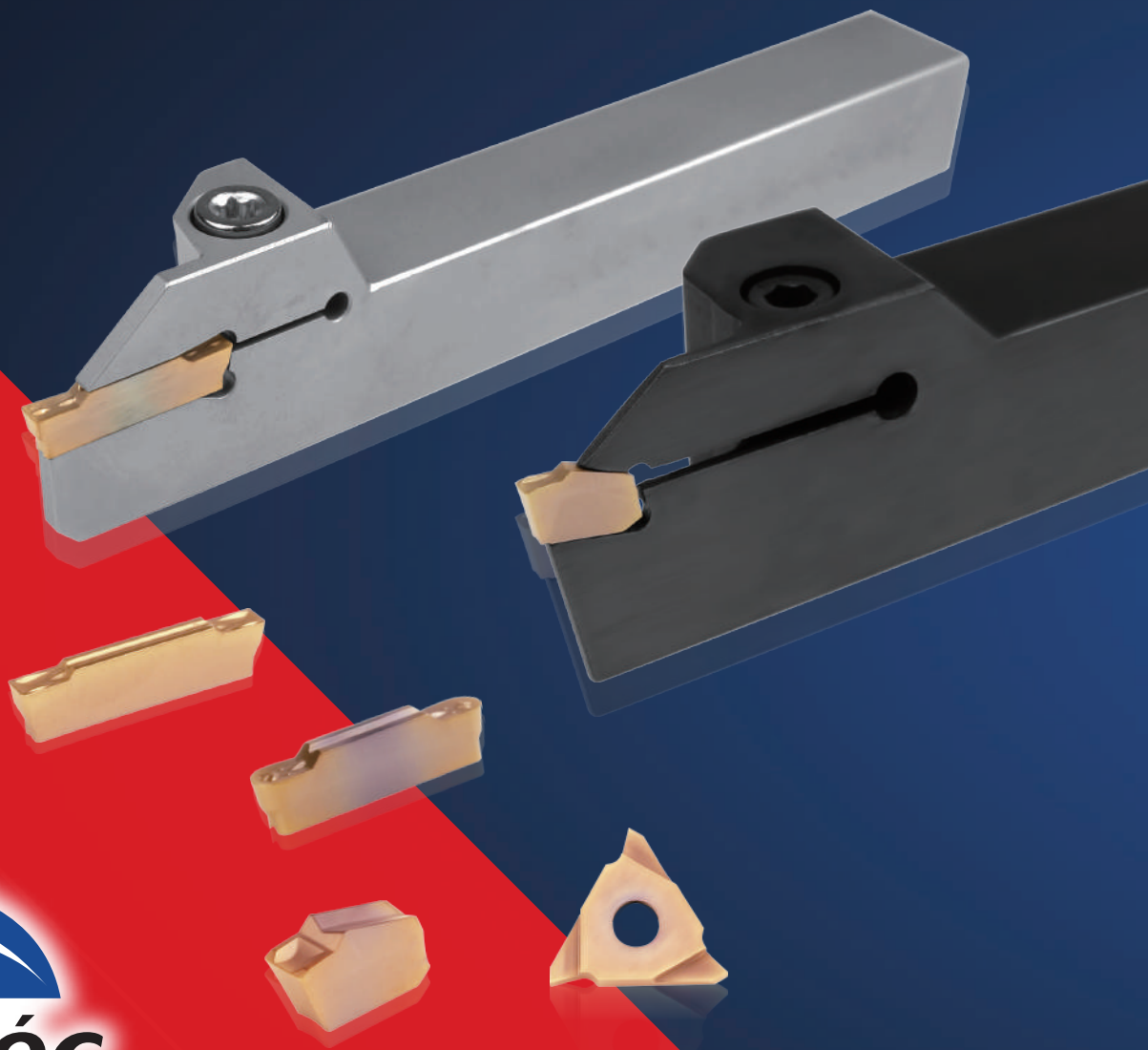


鎢鋼切槽/切斷車刀片系列
**CARBIDE GROOVING
/ PARTING INSERT
SERIES**



西門德克

鎢鋼切槽 / 切斷 車刀片 Carbide Grooving / Parting Inserts	<p>NEW</p> <p>切槽寬度 P.215 2.0~4.0W</p>	<p>NEW</p> <p>切槽寬度 P.216 2.0~3.0W</p>	<p>切槽寬度 P.216 2.2~4.1W</p>	<p>NEW</p> <p>切槽寬度 P.217 0.33~2.5W</p>
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鎢鋼圓槽車刀片 Carbide Radius Inserts	<p>NEW</p> <p>R 角尺寸 P.215 1.0~2.0R</p>	<p>NEW</p> <p>R 角尺寸 P.218 0.25~0.75R</p>
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外徑切槽 / 切斷 車刀桿 External Grooving / Parting Toolholders	<p>外徑切斷切槽 Parting Grooving:</p> <p>四角柄尺寸 P.220 16~25D</p>	<p>外徑切斷切槽 Parting Grooving:</p> <p>四角柄尺寸 P.221 12~32D</p>	<p>外徑切斷加工 External Parting:</p> <p>全長尺寸 P.222 110~150L</p>	<p>P.222</p>
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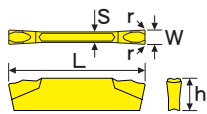
<p>外徑切斷切槽 Parting Grooving:</p> <p>四角柄尺寸 P.223 16~25D</p>	<p>外徑切槽加工 External Grooving:</p> <p>四角柄尺寸 P.224 10~25D</p>	<p>外徑切槽加工 External Grooving:</p> <p>四角柄尺寸 P.224 16~20D</p>	<p>NEW</p> <p>四角柄尺寸 P.225 10~25D</p>	切削條件表 【切槽 & 切斷】 Grooving & Parting Condition Table P.226
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切削方式 CUTTING MODE


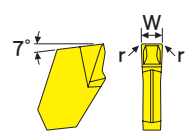
車刀片系列 Inserts		切槽寬度 W Groove Width	切槽加工 Grooving	切斷加工 Parting	橫向加工 Plunge Turning	斜向加工 Ramping	仿形加工 Copy
	MGMN	2.0~4.0W	○	○	○	○	X
	MRMN (圓槽型)	2.0~4.0W (1.0~2.0R)	○	X	○	X	○
	GMM	2.0~3.0W	○	○	○	○	X
	TGTN	2.2~4.1W	○	○	X	X	X
	TGF	0.33~2.5W	○	X	X	X	X
	TGF (圓槽型)	0.5~1.5W (0.25~0.75R)	○	X	X	X	X

加工材質	鋼材 Alloy Steels		●	●	✱						刀片 2D 圖 Drawing	刀桿 頁數 Tool Page	
	不銹鋼 Stainless Steels		●	●	✱								
鑄鐵 Cast Iron		●	●	✱									
鋁合金 Aluminum Alloys		-	-	-									
高溫合金 High Temp Alloys		⊙	●	✱									
調質鋼 Hardened Steels		⊙	●	-									
<ul style="list-style-type: none"> ● 第一推薦 / ○ 第二推薦：連續加工 Continuous Cutting ● 第一推薦 / ⊙ 第二推薦：一般加工 General Cutting ✱ 第一推薦 / ✱ 第二推薦：斷續加工 Interrupted Cutting - 不推薦 NO Recommend <p>F：精加工 Finishing S：半精加工 Semi Finishing M：中加工 Medium R：粗加工 Roughing</p>													
刀片 Insert	訂購編號 Order No.	材質碼 Grade				尺寸 Dimension (mm)					刀片 2D 圖 Drawing	刀桿 頁數 Tool Page	
		C/6032	C/6133	C/6143		W	r	L	h	S			
 NEW	MGMN200-SG	●	●	●		2.0	0.2	16	3.5	1.60		220	
F S M R													
 NEW	MGMN300-MG	●	●	●		3.0	0.4	21	4.8	2.35			
F S M R													
 NEW	MGMN400-MG	●	●	●		4.0	0.4	21	4.8	3.30			
F S M R													
 NEW	MRMN200-MG	●	●	●		2.0	1.0	16	3.5	1.60		220	
F S M R													
 NEW	MRMN300-MG	●	●	●		3.0	1.5	21	4.8	2.35			
F S M R													
 NEW	MRMN400-MG	●	●	●		4.0	2.0	21	4.8	3.30			
F S M R													

▶ 切削條件表 Cutting Condition Table → Page : P.226

加工材質	P	鋼材 Alloy Steels	●	●	✱					<ul style="list-style-type: none"> ● 第一推薦 / ○ 第二推薦：連續加工 Continuous Cutting ● 第一推薦 / ⊙ 第二推薦：一般加工 General Cutting ✱ 第一推薦 / ⊛ 第二推薦：斷續加工 Interrupted Cutting — 不推薦 NO Recommend 		
	M	不銹鋼 Stainless Steels	●	●	✱							
K	鑄鐵 Cast Iron	●	●	✱								
N	鋁合金 Aluminum Alloys	—	—	—					F：精加工 Finishing S：半精加工 Semi Finishing M：中加工 Medium R：粗加工 Roughing			
S	高溫合金 High Temp Alloys	⊙	●	✱								
H	調質鋼 Hardened Steels	⊙	●	—								
刀片 Insert	訂購編號 Order No.	材質碼 Grade				尺寸 Dimension (mm)					刀片 2D 圖 Drawing	刀桿頁數 Tool Page
		CM6032	CM6133	CM6143		W	r	L	h	S		
	GMM2020-MR	●	●	●		2.0	0.20	20	4.3	1.5		221
	GMM2520-MR	●	●			2.5	0.20	20	4.3	1.9		
	GMM3020-MR	●	●			3.0	0.25	20	4.3	2.3		
F	S	M	R									

▶ 切削條件表 Cutting Condition Table → Page : P.226

加工材質	P	鋼材 Alloy Steels	●	●	✱					<ul style="list-style-type: none"> ● 第一推薦 / ○ 第二推薦：連續加工 Continuous Cutting ● 第一推薦 / ⊙ 第二推薦：一般加工 General Cutting ✱ 第一推薦 / ⊛ 第二推薦：斷續加工 Interrupted Cutting — 不推薦 NO Recommend 		
	M	不銹鋼 Stainless Steels	●	●	✱							
K	鑄鐵 Cast Iron	●	●	✱								
N	鋁合金 Aluminum Alloys	—	—	—					F：精加工 Finishing S：半精加工 Semi Finishing M：中加工 Medium R：粗加工 Roughing			
S	高溫合金 High Temp Alloys	⊙	●	✱								
H	調質鋼 Hardened Steels	⊙	●	—								
刀片 Insert	訂購編號 Order No.	材質碼 Grade				尺寸 Dimension (mm)					刀片 2D 圖 Drawing	刀桿頁數 Tool Page
		CM6032	CM6133	CM6143		W	r	L	h	S		
	TGTN0220	●	●	●		2.2	0.20	—	—	—		222 223
	TGTN0310	●	●	●		3.1	0.20	—	—	—		
	TGTN0410	●	●	●		4.1	0.25	—	—	—		
F	S	M	R									

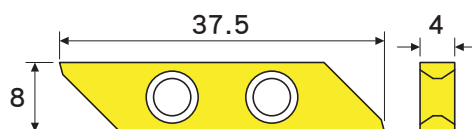
▶ 切削條件表 Cutting Condition Table → Page : P.226

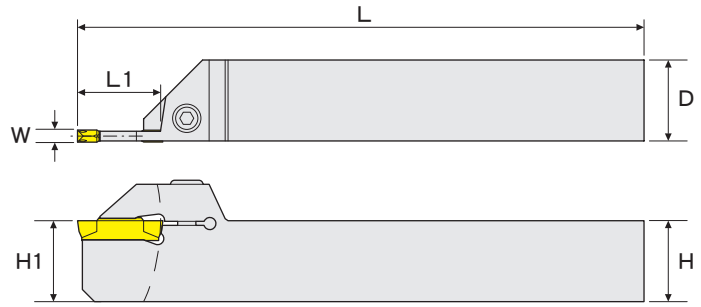
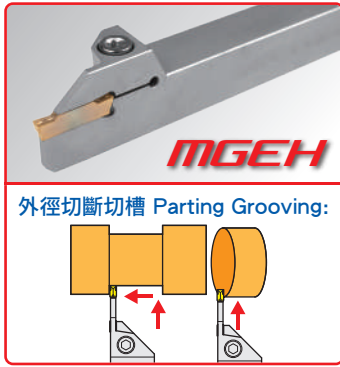
加工材質	P	鋼材 Alloy Steels	●	-									<ul style="list-style-type: none"> ● 第一推薦 / ○ 第二推薦：連續加工 Continuous Cutting ● 第一推薦 / ⊙ 第二推薦：一般加工 General Cutting ✱ 第一推薦 / ⊗ 第二推薦：斷續加工 Interrupted Cutting - 不推薦 NO Recommend 			
	M	不銹鋼 Stainless Steels	●	-												
K	鑄鐵 Cast Iron	●	-													
N	鋁合金 Aluminum Alloys	○	●													
S	高溫合金 High Temp Alloys	●	-													
H	調質鋼 Hardened Steels	●	-													
刀片 Insert	訂購編號 Order No.	材質碼 Grade			尺寸 Dimension (mm)						切深 Depth Of Cut		刀桿頁數 Tool Page			
		CM5515	CM10		W	h	r	S	d	d1	外徑切槽最大切深 O.D. (Max)	內徑切槽最大切深 I.D. (Max)				
	TGF32R033	●			0.33	1.0	0.05	3.18	9.52	4.4	0.8	0.5	224			
	TGF32L033	●			0.33	1.0	0.05	3.18	9.52	4.4	0.8	0.5				
	TGF32R050	●			0.50	1.4	0.05	3.18	9.52	4.4	1.2	0.8				
	TGF32L050	●			0.50	1.4	0.05	3.18	9.52	4.4	1.2	0.8				
	TGF32R075	●			0.75	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L075	●			0.75	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R095	●			0.95	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L095	●			0.95	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R100	●			1.00	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L100	●			1.00	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R110	●			1.10	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L110	●			1.10	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R125	●			1.25	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L125	●			1.25	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R135	●			1.35	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L135	●			1.35	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R145	●			1.45	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L145	●			1.45	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R150	●			1.50	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L150	●			1.50	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R165	●			1.65	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L165	●			1.65	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R175	●			1.75	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L175	●			1.75	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R180	●			1.80	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L180	●			1.80	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32R185	●			1.85	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
	TGF32L185	●			1.85	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
TGF32R200	●			2.00	2.5	0.10	3.18	9.52	4.4	2.0	1.5					
TGF32L200	●			2.00	2.5	0.10	3.18	9.52	4.4	2.0	1.5					
	NEW TGF32R250	●			2.50	2.5	0.10	3.18	9.52	4.4	2.0	1.5				
F	S	M	R	TGF32L250	●				2.50	2.5	0.10	3.18	9.52	4.4	2.0	1.5

▶ 切削條件表 Cutting Condition Table → Page : P.226

加工材質	鋼材 Alloy Steels		●	●						● 第一推薦 / ○ 第二推薦：連續加工 Continuous Cutting ● 第一推薦 / ○ 第二推薦：一般加工 General Cutting ✱ 第一推薦 / ✱ 第二推薦：斷續加工 Interrupted Cutting — 不推薦 NO Recommend			
	不銹鋼 Stainless Steels		●	●									
鑄鐵 Cast Iron		●	●										
鋁合金 Aluminum Alloys		○	○										
高溫合金 High Temp Alloys		●	●										
調質鋼 Hardened Steels		●	●										
		F：精加工 Finishing S：半精加工 Semi Finishing M：中加工 Medium R：粗加工 Roughing											
刀片 Insert	訂購編號 Order No.	材質碼 Grade					尺寸 Dimension (mm)					刀片 2D 圖 Drawing	刀桿頁數 Tool Page
		CM5515	CM6015				W	R	L2	K	Pitch		
	SAKBR20005	●					2.0	—	5.0	35	—	後掃車刀片 Back Turning 	225
	SAKBR20015	●					2.0	0.10	5.0	35	—		
	SAKBR20025	●					2.0	0.20	5.0	35	—		
	SAKBR30015	●					3.0	0.10	5.0	35	—		
F S M R	SAKBR30025	●					3.0	0.20	5.0	35	—		
	SAKCR15018	●					1.5	0.10	8.5	15	—	切斷車刀片 Parting Off 	225
	SAKCR20019	●					2.0	0.10	9.0	15	—		
	SAKCR25019	●					2.5	0.10	9.0	15	—		
F S M R	SAKCR30019	●					3.0	0.10	9.0	15	—		
	SAKGR10013	●					1.0	0.10	3.0	—	—	切槽車刀片 Grooving 	225
	SAKGR15013	●					1.5	0.10	3.0	—	—		
	SAKGR15025	●					1.5	0.20	5.0	—	—		
	SAKGR15027	●					1.5	0.20	7.0	—	—		
	SAKGR20015	●					2.0	0.10	5.0	—	—		
	SAKGR20025	●					2.0	0.20	5.0	—	—		
	SAKGR20027	●					2.0	0.20	7.0	—	—		
	SAKGR20029	●					2.0	0.20	9.0	—	—		
	SAKGR25015	●					2.5	0.10	5.0	—	—		
	SAKGR25025	●					2.5	0.20	5.0	—	—		
	SAKGR25029	●					2.5	0.20	9.0	—	—		
	SAKGR30015	●					3.0	0.10	5.0	—	—		
	SAKGR30019	●					3.0	0.10	9.0	—	—		
	SAKGR30025	●					3.0	0.20	5.0	—	—		
SAKGR30027	●					3.0	0.20	7.0	—	—			
F S M R	SAKGR30029	●					3.0	0.20	9.0	—	—		
	SAKPR10053	●					1.0	0.50	3.0	—	—	圓槽車刀片 Radius 	225
	SAKPR15075	●					1.5	0.75	5.0	—	—		
	SAKPR20105	●					2.0	1.00	5.0	—	—		
	SAKPR25125	●					2.5	1.25	5.0	—	—		
F S M R	SAKPR30158	●					3.0	1.50	8.0	—	—		
	SAKTR20655	●					2.0	0.05	6.0	55	0.05-2	螺紋車刀片 Threading 	225
	SAKTR30655	●					3.0	0.10	6.0	55	0.10-3		
	SAKTR20660	●					2.0	0.05	6.0	60	0.05-2		
F S M R	SAKTR30660	●					3.0	0.10	6.0	60	0.10-3		

▶ 切削條件表 Cutting Condition Table → Page : P.226





右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)	尺寸 Dimension (mm)						搭配刀片 Insert	Screw 	Wrench
	H1 / H	F	L1	L	D	W			
MGEH ^R _L -1616K-2T-16T	16	16.25	16	125	16	2.0	MGMN200.. MRMN200..	HTMT520	ETL25
MGEH ^R _L -2020K-2T-20T	20	20.25	20	125	20	2.0		HTMT525	ETL25
MGEH ^R _L -2525M-2T-20T	25	25.25	20	150	25	2.0		HTMT525	ETL25
MGEH ^R _L -1616K-3T-20T	16	16.30	20	125	16	3.0	MGMN300.. MRMN300..	HTMT520	ETL25
MGEH ^R _L -2020K-3T-20T	20	20.30	20	125	20	3.0		HTMT525	ETL25
MGEHR-2525M-3T-20T	25	25.30	20	150	25	3.0		HTMT525	ETL25
MGEHR-2525M-4T-20T	25	25.35	20	150	25	4.0	MGMN400.. MRMN400..	HTMT525	ETL25

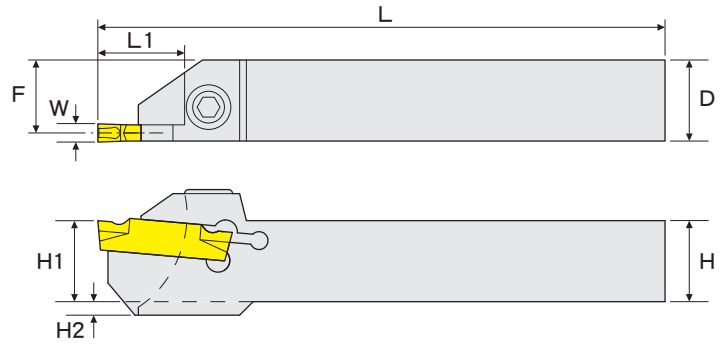
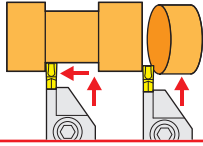
▶ 搭配刀片 Insert → Page : P.215

▶ 切削條件表 Turning Condition Table → Page : P.226



KGM

外徑切斷切槽 Parting Grooving:

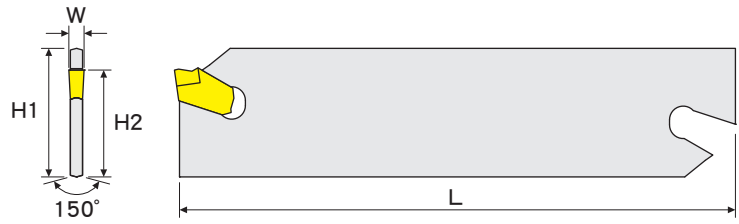


右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)	尺寸 Dimension (mm)					W (mm)		搭配刀片 Insert	Screw 	Wrench
	H1 / H	F	L1	L	D	Min	Max			
KGM ^R / _L -1212K-1.5-L10	12	11.4	10	125	12	1.5	2.0	GMM2020..	HTM416	PL30
KGM ^R / _L -1616K-1.5-L10	16	15.4	10	125	16	1.5	2.0		HTMT520	ETL25
KGM ^R / _L -2020K-1.5-L10	20	19.4	10	125	20	1.5	2.0		HTMT525	ETL25
KGM ^R / _L -2525M-1.5-L10	25	24.4	10	150	25	1.5	2.0		HTMT525	ETL25
KGM ^R / _L -1212K-2T-L10	12	11.1	10	125	12	2.0	3.0	GMM2020.. GMM2520.. GMM3020..	HTM416	PL30
KGM ^R / _L -1616K-2T-L10	16	15.1	10	125	16	2.0	3.0		HTMT520	ETL25
KGM ^R / _L -2020K-2T-L10	20	19.1	10	125	20	2.0	3.0		HTMT525	ETL25
KGM ^R / _L -2525M-2T-L10	25	24.1	10	150	25	2.0	3.0		HTMT525	ETL25
KGM ^R / _L -1212K-2T-L13	12	11.1	13	125	12	2.0	3.0		HTM420	PL30
KGM ^R / _L -1616K-2T-L13	16	15.1	13	125	16	2.0	3.0		HTMT520	ETL25
KGM ^R / _L -2020K-2T-L13	20	19.1	13	125	20	2.0	3.0		HTMT525	ETL25
KGM ^R / _L -2525M-2T-L13	25	24.1	13	150	25	2.0	3.0		HTMT525	ETL25
KGM ^R / _L -1212K-2T-L17	12	11.1	17	125	12	2.0	3.0		HTM420	PL30
KGM ^R / _L -1616K-2T-L17	16	15.1	17	125	16	2.0	3.0		HTMT520	ETL25
KGM ^R / _L -2020K-2T-L17	20	19.1	17	125	20	2.0	3.0		HTMT525	ETL25
KGM ^R / _L -2525M-2T-L17	25	24.1	17	150	25	2.0	3.0		HTMT525	ETL25
KGM ^R / _L -1616K-3T-L16	16	14.8	16	125	16	3.0	4.0		HTMT520	ETL25
KGM ^R / _L -2020K-3T-L16	20	18.8	16	125	20	3.0	4.0		HTMT525	ETL25
KGM ^R / _L -2525M-3T-L16	25	23.8	16	150	25	3.0	4.0		HTMT525	ETL25
KGM ^R / _L -1616K-3T-L20	16	14.8	20	125	16	3.0	4.0		HTMT525	ETL25
KGM ^R / _L -2020K-3T-L20	20	18.8	20	125	20	3.0	4.0	HTMT525	ETL25	
KGM ^R / _L -2525M-3T-L20	25	23.8	20	150	25	3.0	4.0	HTMT525	ETL25	
KGMR-3232P-3T-L20	32	30.8	20	170	32	3.0	4.0	HTMT525	ETL25	

▶ 搭配刀片 Insert → Page : P.216

▶ 切削條件表 Turning Condition Table → Page : P.226

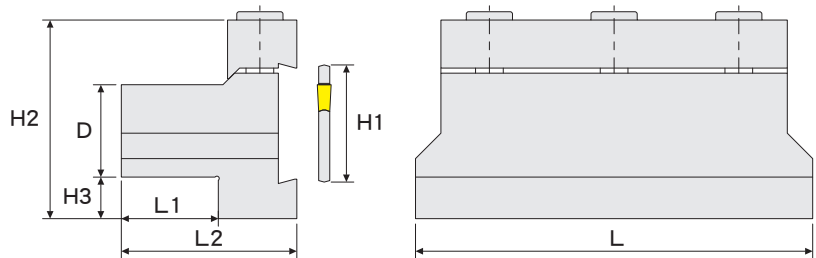


鋼材柄訂購編號 Order No. (Steel Shank)	尺寸 Dimension (mm)				搭配刀片 Insert	切斷板座 Tool Block	Wrench
	H1	H2	L	W			
SGIH26-2	26	21.4	110	2.2	TGTN0220..	SGTBU...-26	ESG-1
SGIH26-3	26	21.4	110	3.1	TGTN0310..		
SGIH26-4	26	21.4	110	4.1	TGTN0410..		
SGIH32-2	32	25.0	150	2.2	TGTN0220..	SGTBU...-32	
SGIH32-3	32	25.0	150	3.1	TGTN0310..		
SGIH32-4	32	25.0	150	4.1	TGTN0410..		

▶ 搭配刀片 Insert → Page : P.216

▶ 切削條件表 Turning Condition Table → Page : P.226

SGTBU



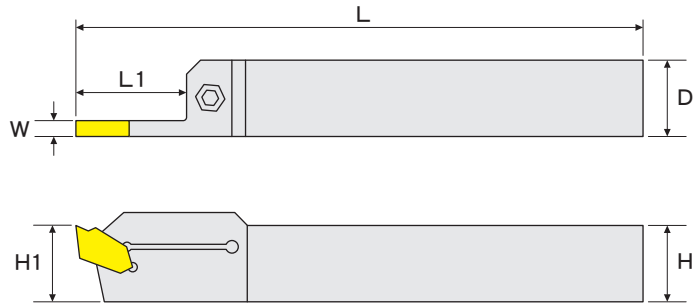
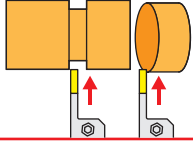
切斷板座 Tool Block

鋼材柄訂購編號 Order No. (Steel Shank)	尺寸 Dimension (mm)							搭配刀板 Blade	Screw 	Wrench
	H1	H2	H3	L1	L2	L	D			
SGTBU20-26	26	43	9	21	38	86	20	SGIH26-..	HTM630	PL50
SGTBU25-26	26	43	4	23	40	86	25			
SGTBU20-32	32	50	13	21	40	110	20	SGIH32-..		
SGTBU25-32	32	50	8	23	42	110	25			



SGTH

外徑切斷切槽 Parting Grooving:

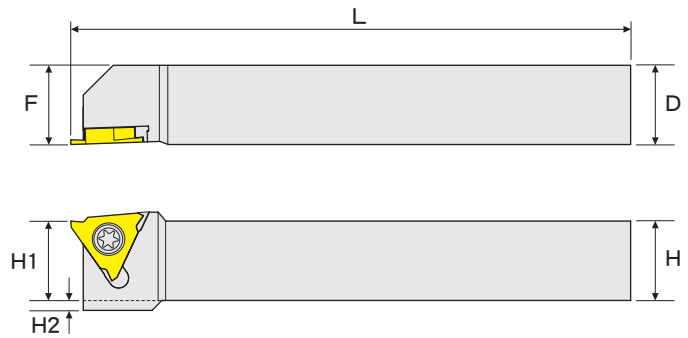


右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)	尺寸 Dimension (mm)					搭配刀片 Insert	Screw 	Wrench
	H1 / H	L1	L	D	W			
SGTHR1616-2	16	16	110	16	2	TGTN0220..	HTM521	PL40
SGTHR2020-2	20	18	125	20	2			
SGTHR2020-3	20	20	125	20	3	TGTN0310..	HTM625	PL50
SGTHR2525-3	25	25	150	25	3			
SGTHR2525-4	25	30	150	25	4	TGTN0410..	HTM625	PL50

▶ 搭配刀片 Insert → Page : P.216

▶ 切削條件表 Turning Condition Table → Page : P.226

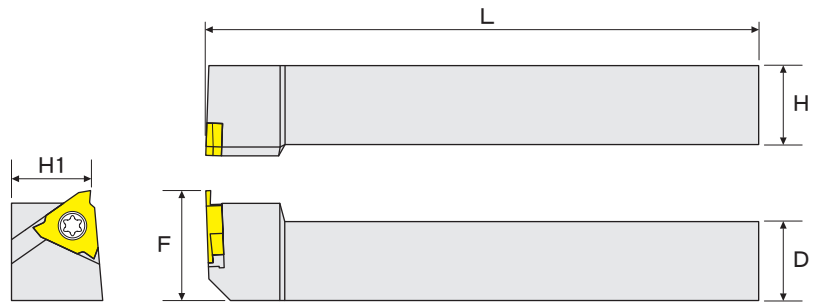
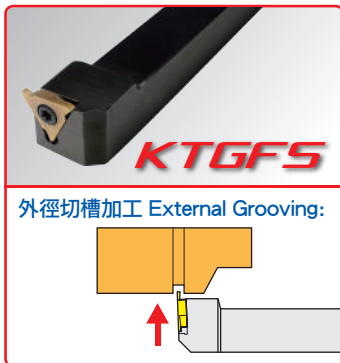


右車刀桿圖示 Right-Hand Shown

鋼材柄訂購編號 Order No. (Steel Shank)	尺寸 Dimension (mm)					搭配刀片 Insert	Screw 	Wrench
	H1/H	F	H2	L	D			
KTGF ^R / _L -1010K-16F	10	10	4	125	10	TGF32R.. / TGF32L..	MS4009A	ETF15
KTGFR-1012K-16F	10	12	2	125	12	TGF32R..	MS4011A	
KTGF ^R / _L -1212K-16F	12	12	2	125	12	TGF32R.. TGF32L..		
KTGF ^R / _L -1616K-16F	16	16	—	125	16	TGF32R..		
KTGFR-2020K-16F	20	20	—	125	20	TGF32R..		
KTGF ^R / _L -1616K-16	16	20	—	125	16	TGF32R.. TGF32L..		
KTGF ^R / _L -2020K-16	20	25	—	125	20			
KTGF ^R / _L -2525M-16	25	32	—	150	25			

▶ 搭配刀片 Insert → Page : P.217,218

▶ 切削條件表 Turning Condition Table → Page : P.226



左車刀桿圖示 Left-Hand Shown

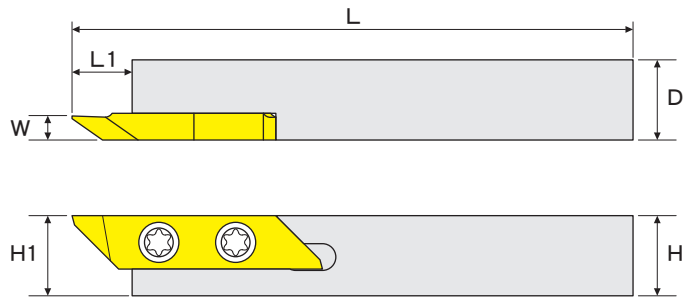
鋼材柄訂購編號 Order No. (Steel Shank)	尺寸 Dimension (mm)				搭配刀片 Insert	Screw 	Wrench
	H1 / H	F	L	D			
KTGFSL-1616K-16	16	22	125	16	TGF32R..	MS4009A	ETF15
KTGFSL-2020K-16	20	26	125	20			

▶ 搭配刀片 Insert → Page : P.217,218

▶ 切削條件表 Turning Condition Table → Page : P.226

CNC 走心式自動車床用刀桿 - SAK 系列

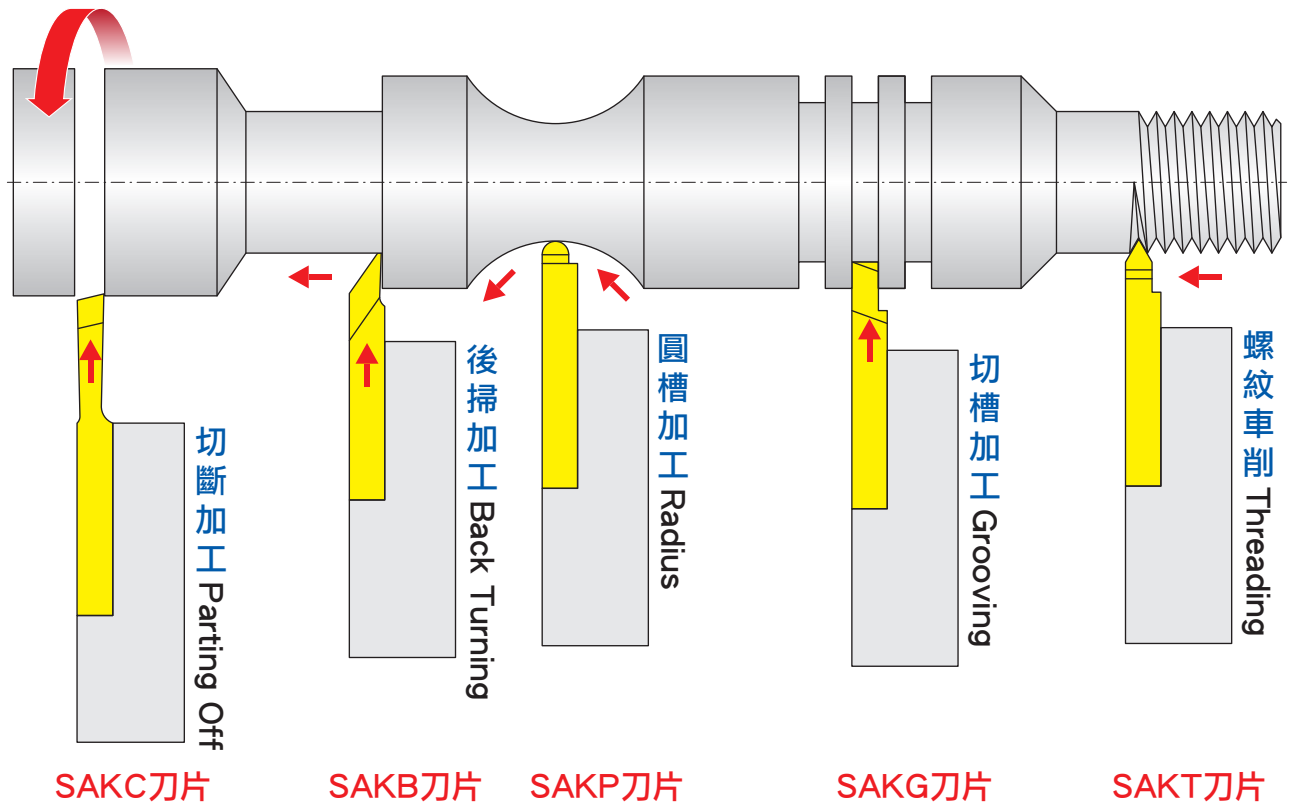
TOOLHOLDERS FOR AUTOMATIC LATHES- SAK SERIES



訂購編號 Order No.	尺寸 Dimensions (mm)					搭配刀片 Insert	Screw 	Wrench
	H / H1	L1	L	D	W			
SAK ^R _L -1010K-374	10	9	125	10	4	SAK..	MS3509A	ETF15
SAK ^R _L -1212K-374	12	9	125	12	4			
SAK ^R _L -1212M-374	12	9	150	12	4			
SAK ^R _L -1616M-374	16	9	150	16	4			
SAK ^R _L -2020K-374	20	9	125	20	4			
SAK ^R _L -2525M-374	25	9	150	25	4			

▶ 搭配刀片 Insert → Page : P.219

▶ 切削條件 Turning Condition Table → Page : P.226



外徑切槽/切斷車刀桿

External Grooving / Parting Toolholders

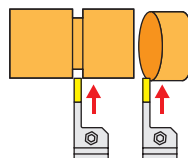
Table

切槽 / 切斷車刀片 切削條件表

CARBIDE GROOVING / PARTING INSERTS- CUTTING CONDITION TABLE

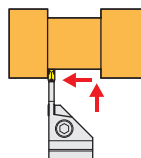
切槽加工 & 切斷加工 GROOVING & PARTING

加工材質 Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels	不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys	高溫合金 High Temp Alloys
工件料號 Material Code	S35C,S45C,S50C	SCM,SKT,SKD	SUS304	FC,FCD	Al 5052 / 6061 / 7075	Ti-6Al-4V
硬度 Hardness	HRC<30	HRC30~40	—	HRC<30	—	HRC<30
切削速度 Vc	50~130m/min	50~130m/min	50~100m/min	50~150m/min	80~200m/min	50~100m/min
每轉進給量 f (mm/rev)	0.03~0.07	0.03~0.07	0.02~0.06	0.03~0.08	0.03~0.10	0.02~0.07
備註 Remarks	※ 建議先採用最低切削速度和每轉進給量參數加工，如加工狀況良好，再慢慢調高參數。 We recommend starting with slow speeds and feeds. If processing goes well, you can raise parameters gradually.					



橫向加工 PLUNGE TURNING

加工材質 Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels	不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys	高溫合金 High Temp Alloys
工件料號 Material Code	S35C,S45C,S50C	SCM,SKT,SKD	SUS304	FC,FCD	Al 5052 / 6061 / 7075	Ti-6Al-4V
硬度 Hardness	HRC<30	HRC30~40	—	HRC<30	—	HRC<30
切削速度 Vc	50~130m/min	50~130m/min	50~100m/min	50~150m/min	80~200m/min	50~100m/min
每轉進給量 f (mm/rev)	0.02~0.07	0.02~0.07	0.02~0.06	0.02~0.08	0.03~0.10	0.02~0.06
備註 Remarks	※ 建議先採用最低切削速度和每轉進給量參數加工，如加工狀況良好，再慢慢調高參數。 We recommend starting with slow speeds and feeds. If processing goes well, you can raise parameters gradually.					



※ 切削公式 / Cutting formula : $S(\text{主軸轉速}) = Vc(\text{切削速度}) \times 1000 / D(\text{外徑}) / \pi(3.14)$ $F(\text{進給速度}) = f(\text{每轉進給量}) \times S(\text{主軸轉速})$

1. 當加工聲音尖銳時，請調降主軸轉速(S) (10~40%)。When the sound is piercing, please lower the spindle speed(S) (10~40%).
2. 當機台震動太大時，請調降進給速度(F) (10~40%)。When the machine is vibrating, please decrease the feed rate(F) (10~40%).
3. 當主軸負載太大時，請調降進給速度(F) (10~40%)。When the spindle load is high, please decrease the feed rate(F) (10~40%).
4. 以上數據為建議值，適當的條件仍需視機台狀況，夾治具品質，潤滑冷卻系統...等而改變。

These are recommended values which depend on the condition of the machine, fixture, lubricating & cooling systems... etc. They may have to be adapted.