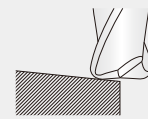
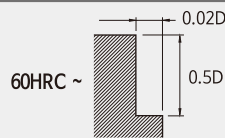
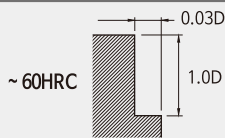


4JJCR / 6JJCR / 4JJTC

- 6JJCR은 RPM 동일, FEED만 최대 50% Up 적용.
- Use the same RPM and raise up the feed up to 50% for 6JJCR.

피삭재 Material		고경도강 Hardened Steels											
경도 Hardness		55 ~ 60HRC				60 ~ 65HRC				65 ~ 68HRC			
외경 Outside Diameter	반경 Corner Radius	RPM	FEED	Ap	Ae	RPM	FEED	Ap	Ae	RPM	FEED	Ap	Ae
				Axial Depth	Radial Depth			Axial Depth	Radial Depth			Axial Depth	Radial Depth
∅ 0.5	R0.1	33,000	365	0.015	0.02	25,000	245	0.007	0.010	20,000	140	0.007	0.010
∅ 0.6	R0.1	30,000	380	0.02	0.10	25,000	250	0.01	0.075	20,000	150	0.01	0.075
∅ 0.7	R0.1	28,000	39	0.03	0.13	21,000	255	0.01	0.080	18,000	150	0.01	0.080
∅ 0.8	R0.1	25,500	400	0.04	0.15	19,000	260	0.02	0.12	16,000	155	0.02	0.12
∅ 1	R0.1	20,500	430	0.08	0.80	16,000	270	0.04	0.06	12,500	175	0.03	0.05
"	R0.3	20,500	430	0.10	0.40	16,000	270	0.05	0.08	12,500	175	0.05	0.06
∅ 1.5	R0.1	18,000	460	0.12	1.30	13,000	300	0.07	0.10	10,500	200	0.05	0.08
"	R0.5	18,000	460	0.15	0.50	13,000	300	0.10	0.12	10,500	200	0.07	0.10
∅ 2	R0.1	14,500	520	0.15	1.80	11,000	320	0.10	0.12	9,500	230	0.10	0.10
"	R0.5	14,500	520	0.18	1.00	11,000	320	0.10	0.14	9,500	230	0.10	0.12
∅ 2.5	R0.1	11,500	520	0.16	2.00	8,500	320	0.10	0.13	7,500	230	0.10	0.10
"	R0.5	11,500	520	0.19	1.50	8,500	320	0.10	0.15	7,500	230	0.10	0.12
∅ 3	R0.1	9,500	520	0.16	2.50	7,500	320	0.12	0.13	6,400	230	0.12	0.10
"	R0.5	9,500	520	0.18	2.00	7,500	320	0.12	0.14	6,400	230	0.12	0.12
"	R1	9,500	520	0.20	1.00	7,500	320	0.12	0.16	6,400	230	0.12	0.13
∅ 4	R0.1	7,200	540	0.20	3.50	5,600	335	0.12	0.16	4,750	240	0.12	0.13
"	R0.5	7,200	540	0.25	3.00	5,600	335	0.12	0.20	4,750	240	0.15	0.16
"	R1	7,200	540	0.25	2.00	5,600	335	0.15	0.20	4,750	240	0.15	0.16
∅ 5	R0.1	6,400	580	0.25	4.50	5,100	370	0.12	0.20	4,450	270	0.12	0.16
"	R0.5	6,400	580	0.28	4.00	5,100	370	0.15	0.22	4,450	270	0.15	0.18
"	R1	6,400	580	0.30	3.00	5,100	370	0.15	0.24	4,450	270	0.15	0.19
∅ 6	R0.1	5,300	560	0.30	5.50	4,200	350	0.20	0.24	3,700	260	0.20	0.19
"	R0.5	5,300	560	0.30	5.00	4,200	350	0.20	0.24	3,700	260	0.20	0.19
"	R1	5,300	560	0.40	4.00	4,200	350	0.25	0.32	3,700	260	0.25	0.26
"	R1.5	5,300	560	0.40	3.00	4,200	350	0.25	0.32	3,700	260	0.25	0.26
∅ 8	R0.5	4,000	520	0.30	7.50	3,200	330	0.20	0.24	2,800	240	0.20	0.19
"	R1	4,000	520	0.30	6.00	3,200	330	0.20	0.24	2,800	240	0.20	0.19
"	R1.5	4,000	520	0.40	5.00	3,200	330	0.25	0.32	2,800	240	0.25	0.26
"	R2	4,000	520	0.50	4.00	3,200	330	0.30	0.40	2,800	240	0.25	0.32
∅ 10	R0.5	3,200	480	0.40	9.50	2,550	310	0.20	0.32	2,200	220	0.20	0.26
"	R1	3,200	480	0.45	9.00	2,550	310	0.25	0.36	2,200	220	0.25	0.29
"	R1.5	3,200	480	0.50	7.00	2,550	310	0.30	0.40	2,200	220	0.30	0.32
"	R2	3,200	480	0.50	6.00	2,550	310	0.30	0.40	2,200	220	0.30	0.32
"	R2.5	3,200	480	0.50	5.00	2,550	310	0.30	0.40	2,200	220	0.30	0.32
∅ 12	R0.5	2,650	480	0.50	11.00	2,100	300	0.35	0.40	1,860	220	0.30	0.32
"	R1	2,650	480	0.70	10.00	2,100	300	0.35	0.56	1,860	220	0.35	0.45
"	R1.5	2,650	480	0.80	9.00	2,100	300	0.40	0.64	1,860	220	0.35	0.51
"	R2	2,650	480	0.80	8.00	2,100	300	0.40	0.64	1,860	220	0.35	0.51
"	R3	2,650	480	0.80	6.00	2,100	300	0.40	0.64	1,860	220	0.35	0.51

절입량
Depth of Cut



경사진면절삭
Inclined Cutting

- 상기 조건표는 홈 절삭 조건표이며, 측면 절삭시 절입기준표를 참고바랍니다.
- HRC55 이하 피삭재(합금강, 공구강) 가공시 같은 파이에 대비 상기 절삭조건외 20% UP 해주십시오.
- 유효장이 긴 경우에는 회전수와 이송속도를 최대 30% 이하로 줄이십시오.
- 곡면 절삭시 날경의 코너R 보다 낮은 이동 PITCH를 설정 하십시오.
- 곡면 절삭시 안정적인 속도 내에서 피드를 최대 30%까지 UP 해주십시오.
- 6날시 회전수는 유지하고, 피드는 안정적인 속도 내에서 최대 50%까지 UP 해주십시오.

- Above the table is a reference for groove milling, and refer to the depth of cut for side milling.
- When milling workpiece, HRC below 55 (Alloy steel, tool steel), Raise up 20% RPM and feed compared to the same diameter.
- In case of long effective length, reduce the RPM and feed by 30% or less.
- For curved milling, use the lower value of pitch than corner radius value of tool diameter.
- For curved milling, raise up the feed up to 30% in stable condition.
- With 6flutes milling, raise up the feed up to 50% in stable condition.

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