Epoch Deep Radius Evolution

エポックディープラジアスエボリューション

■ 標準切削条件表 Recommended cutting conditions EPDRE-ATH

高能率切削条件 High efficiency cuttiing condition

高精度切削条件 High accuracy cuttiing condition

高精度切削条件はA139 ページを参照してください。
Please refer to P.A139 about high accuracy cutting conditions

被削材 Work				1 銅 Copper		2 炭素鋼・合金鋼 Carbon Steels, Alloy Steels (180～250HB)		3 ステンレス鋼・工具鋼 Stainless Steels, Tool Steels (25～35HRC)		4 プリハードン鋼 Pre-hardened Steels (35～45HRC)		5 焼き入れ鋼 Hardened Steels (45～55HRC)		6 焼き入れ鋼 Hardened Steels (55～65HRC)	
切り込み比率 Ratio to standard depth of cut				120%		100%		90%		80%		65%		60%	
外径 Mill Dia. (mm)	r (mm)	首下長 Under neck Length (mm)	ap (mm)	回転数 n min⁻¹	送り速度 vf mm/min	回転数 n min⁻¹	送り速度 vf mm/min	回転数 n min⁻¹	送り速度 vf mm/min	回転数 n min⁻¹	送り速度 vf mm/min	回転数 n min⁻¹	送り速度 vf mm/min	回転数 n min⁻¹	送り速度 vf mm/min
0.2	0.02	0.5	0.016	50,000	922	50,000	922	45,000	829	42,500	705	37,500	553	35,000	452
		1	0.011	50,000	922	50,000	922	45,000	829	42,500	705	37,500	553	35,000	452
		2	0.007	50,000	809	42,000	774	40,500	746	38,250	635	33,750	498	31,500	406
	0.05	0.5	0.02	50,000	922	50,000	922	45,000	829	42,500	705	37,500	553	35,000	452
		1	0.014	50,000	922	50,000	922	45,000	829	42,500	705	37,500	553	35,000	452
		1.5	0.008	50,000	809	47,000	866	42,750	788	40,375	670	35,625	525	33,250	429
		2	0.008	50,000	809	42,000	774	40,500	746	38,250	635	33,750	498	31,500	406
0.3	0.02	1	0.016	50,000	1,208	48,000	1,161	43,200	1,045	40,800	733	36,000	547	33,600	441
		2	0.011	45,000	998	38,880	860	34,992	774	33,048	594	29,160	443	27,216	357
		3	0.007	42,750	881	36,936	760	33,242	684	31,396	525	27,702	392	25,855	316
	0.05	1	0.021	50,000	1,208	48,000	1,161	43,200	1,045	40,800	733	36,000	547	33,600	441
		1.5	0.016	47,500	1,147	45,600	1,103	41,040	993	38,760	697	34,200	520	31,920	419
		2	0.012	45,000	998	38,880	860	34,992	774	33,048	594	29,160	443	27,216	357
		2.5	0.01	45,000	998	38,880	860	34,992	774	33,048	594	29,160	443	27,216	357
		3	0.008	42,750	881	36,936	760	33,242	684	31,396	525	27,702	392	25,855	316
0.4	0.02	1	0.016	46,080	1,239	38,300	1,032	34,560	929	32,256	793	28,800	620	26,726	508
		2	0.013	46,080	1,115	38,300	929	34,560	836	32,256	714	28,800	557	26,726	457
		3	0.01	35,250	780	29,325	649	26,437	585	24,675	499	22,031	390	20,445	320
		4	0.007	29,029	642	24,150	535	21,772	481	20,320	411	18,143	321	16,837	263
	0.05	1	0.025	46,080	1,239	38,300	1,032	34,560	929	32,256	793	28,800	620	26,726	508
		1.5	0.02	46,080	1,239	38,300	1,032	34,560	929	32,256	793	28,800	620	26,726	508
		2	0.016	46,080	1,115	38,300	929	34,560	836	32,256	714	28,800	557	26,726	457
		2.5	0.015	43,200	1,062	36,000	885	32,400	796	30,600	677	27,000	531	25,200	434
		3	0.014	35,250	780	29,325	649	26,437	585	24,675	499	22,031	390	20,445	320
		3.5	0.012	33,048	731	27,540	609	24,786	548	23,409	467	20,655	365	19,278	299
		4	0.008	29,029	642	24,150	535	21,772	481	20,320	411	18,143	321	16,837	263
	0.1	1	0.033	46,080	1,239	38,300	1,032	34,560	929	32,256	793	28,800	620	26,726	508
		2	0.028	46,080	1,115	38,300	929	34,560	836	32,256	714	28,800	557	26,726	457
		3	0.016	35,250	780	29,325	649	26,437	585	24,675	499	22,031	390	20,445	320
		4	0.01	29,029	642	24,150	535	21,772	481	20,320	411	18,143	321	16,837	263
0.5	0.02	1	0.016	46,080	1,239	38,300	1,032	34,560	929	32,256	793	28,800	620	26,726	508
		2	0.013	46,080	1,239	38,300	1,032	34,560	929	32,256	793	28,800	620	26,726	508
		3	0.01	37,325	1,000	31,104	839	27,994	750	26,438	634	23,328	473	21,773	381
		4	0.008	33,178	889	27,648	746	24,883	666	23,501	563	20,736	420	19,354	339
		6	0.006	25,805	666	21,504	555	19,354	499	18,278	320	16,128	282	15,053	222
	0.05	1	0.03	46,080	1,239	38,300	1,032	34,560	929	32,256	793	28,800	620	26,726	508
		2	0.023	46,080	1,239	38,300	1,032	34,560	929	32,256	793	28,800	620	26,726	508
		3	0.017	37,325	1,000	31,104	839	27,994	750	26,438	634	23,328	473	21,773	381
		4	0.017	33,178	889	27,648	746	24,883	666	23,501	563	20,736	420	19,354	339
		5	0.011	29,030	778	24,192	653	21,773	583	20,563	493	18,144	368	16,934	297
		6	0.008	25,805	666	21,504	555	19,354	499	18,278	320	16,128	282	15,053	222
	0.1	1	0.035	46,080	1,239	38,300	1,032	34,560	929	32,256	793	28,800	620	26,726	508
		2	0.03	46,080	1,239	38,300	1,032	34,560	929	32,256	793	28,800	620	26,726	508
		3	0.02	37,325	1,000	31,104	839	27,994	750	26,438	634	23,328	473	21,773	381
		4	0.02	33,178	889	27,648	746	24,883	666	23,501	563	20,736	420	19,354	339
		5	0.013	29,030	778	24,192	653	21,773	583	20,563	493	18,144	368	16,934	297
		6	0.013	25,805	666	21,504	555	19,354	499	18,278	320	16,128	282	15,053	222
0.6	0.02	2	0.016	46,080	1,751	38,300	1,455	34,560	1,313	32,256	991	28,800	774	26,726	635
		4	0.013	37,325	1,376	31,104	1,147	27,994	1,032	26,438	792	23,328	591	21,773	477
		6	0.01	29,030	1,070	24,192	892	21,773	803	20,563	616	18,144	460	16,934	371
	0.05	2	0.028	46,080	1,751	38,300	1,455	34,560	1,313	32,256	991	28,800	774	26,726	635
		4	0.019	37,325	1,376	31,104	1,147	27,994	1,032	26,438	792	23,328	591	21,773	477
		6	0.012	29,030	1,070	24,192	892	21,773	803	20,563	616	18,144	460	16,934	371
		8	0.01	27,579	1,017	22,982	847	20,684	763	19,535	585	17,237	437	16,088	352
		10	0.007	24,676	814	20,563	678	18,507	610	17,479	489	15,422	355	14,394	287
	0.1	2	0.035	46,080	1,751	38,300	1,455	34,560	1,313	32,256	991	28,800	774	26,726	635
		4	0.024	37,325	1,376	31,104	1,147	27,994	1,032	26,438	792	23,328	591	21,773	477
		6	0.015	29,030	1,070	24,192	892	21,773	803	20,563	616	18,144	460	16,934	371
		8	0.013	27,579	1,017	22,982	847	20,684	763	19,535	585	17,237	437	16,088	352
		10	0.009	24,676	814	20,563	678	18,507	610	17,479	489	15,422	355	14,394	287
0.7	0.05	2	0.035	45,960	1,751	38,300	1,455	34,470	1,313	32,555	991	28,725	774	26,810	635
		4	0.024	37,325	1,376	31,104	1,147	27,994	1,032	26,438	792	23,328	591	21,773	477
		6	0.015	29,030	1,070	24,192	892	21,773	803	20,563	616	18,144	460	16,934	371
	0.1	2	0.042	45,960	1,751	38,300	1,455	34,470	1,313	32,555	991	28,725	774	26,810	635
		4	0.029	37,325	1,376	31,104	1,147	27,994	1,032	26,438	792	23,328	591	21,773	477
		6	0.018	29,030	1,070	24,192	892	21,773	803	20,563	616	18,144	460	16,934	371
0.8	0.02	2	0.016	48,000	2,211	40,000	1,843	36,000	1,658	34,000	1,410	30,000	1,106	28,000	903
		4	0.016	48,000	1,769	40,000	1,475	36,000	1,327	34,000	1,128	30,000	885	28,000	723
		6	0.013	36,720	1,218	30,600	1,015	27,540	914	26,010	863	22,950	677	21,420	553
	0.05	2	0.038	48,000	2,211	40,000	1,843	36,000	1,658	34,000	1,410	30,000	1,106	28,000	903
		4	0.026	48,000	1,769	40,000	1,475	36,000	1,327	34,000	1,128	30,000	885	28,000	723
		6	0.015	36,720	1,218	30,600	1,015	27,540	914	26,010	863	22,950	677	21,420	553
		8	0.012	29,376	906	24,480	755	22,032	680	20,808	642	18,360	504	17,136	411
		12	0.01	26,438	759	22,032	632	19,829	569	18,727	537	16,524	421	15,422	344

被削材 Work				1		2		3		4		5		6	
				銅 Copper		炭素鋼・合金鋼 Carbon Steels, Alloy Steels (180～250HB)		ステンレス鋼・工具鋼 Stainless Steels, Tool Steels (25～35HRC)		プリハードン鋼 Pre-hardened Steels (35～45HRC)		焼き入れ鋼 Hardened Steels (45～55HRC)		焼き入れ鋼 Hardened Steels (55～65HRC)	
切り込み比率 Ratio to standard depth of cut				120%		100%		90%		80%		65%		60%	
外径 Mill Dia. (mm)	r (mm)	首下長 Under neck Length (mm)	ap (mm)	回転数 n min⁻¹	送り速度 vf mm/min	回転数 n min⁻¹	送り速度 vf mm/min	回転数 n min⁻¹	送り速度 vf mm/min	回転数 n min⁻¹	送り速度 vf mm/min	回転数 n min⁻¹	送り速度 vf mm/min	回転数 n min⁻¹	送り速度 vf mm/min
0.8	0.1	2	0.047	48,000	2,211	40,000	1,843	36,000	1,658	34,000	1,410	30,000	1,106	28,000	903
		4	0.032	48,000	1,769	40,000	1,475	36,000	1,327	34,000	1,128	30,000	885	28,000	723
		6	0.019	36,720	1,218	30,600	1,015	27,540	914	26,010	863	22,950	677	21,420	553
		8	0.015	29,376	906	24,480	755	22,032	680	20,808	642	18,360	504	17,136	411
		12	0.012	26,438	759	22,032	632	19,829	569	18,727	537	16,524	421	15,422	344
	0.2	2	0.081	48,000	2,211	40,000	1,843	36,000	1,658	34,000	1,410	30,000	1,106	28,000	903
		4	0.056	48,000	1,769	40,000	1,475	36,000	1,327	34,000	1,128	30,000	885	28,000	723
		6	0.032	36,720	1,218	30,600	1,015	27,540	914	26,010	863	22,950	677	21,420	553
		8	0.018	29,376	906	24,480	755	22,032	680	20,808	642	18,360	504	17,136	411
		12	0.015	26,438	759	22,032	632	19,829	569	18,727	537	16,524	421	15,422	344
1	0.02	2	0.016	47,770	2,866	39,490	2,369	35,668	2,140	33,439	1,805	29,617	1,421	27,707	1,163
		4	0.013	43,200	2,588	36,000	2,157	32,400	1,941	30,600	1,650	27,000	1,294	25,200	1,057
		6	0.01	34,992	1,887	29,160	1,572	29,299	1,757	24,786	1,336	21,870	1,048	20,412	856
		8	0.008	31,104	1,677	25,920	1,397	26,244	1,415	22,032	1,188	19,440	932	18,144	761
		10	0.006	27,216	1,467	22,680	1,223	23,328	1,258	19,278	1,039	17,010	815	15,876	666
		12	0.005	24,192	1,159	20,160	966	20,412	1,100	17,136	719	15,120	634	14,112	507
	0.05	2	0.046	47,770	2,866	39,490	2,369	35,668	2,140	33,439	1,805	29,617	1,421	27,707	1,163
		3	0.035	47,770	2,866	39,490	2,369	35,668	2,140	33,439	1,805	29,617	1,421	27,707	1,163
		4	0.027	43,200	2,588	36,000	2,157	32,400	1,941	30,600	1,650	27,000	1,294	25,200	1,057
		5	0.021	39,808	2,388	31,847	1,910	29,299	1,757	27,707	1,496	24,522	1,177	22,929	963
		6	0.017	34,992	1,887	29,160	1,572	26,244	1,415	24,786	1,336	21,870	1,048	20,412	856
		8	0.016	31,104	1,677	25,920	1,397	23,328	1,258	22,032	1,188	19,440	932	18,144	761
		10	0.011	27,216	1,467	22,680	1,223	20,412	1,100	19,278	1,039	17,010	815	15,876	666
		12	0.01	24,192	1,159	20,160	966	18,144	870	17,136	719	15,120	634	14,112	507
		16	0.006	24,192	1,014	20,160	845	18,144	761	17,136	667	15,120	543	14,112	423
		20	0.004	18,144	761	15,120	634	13,608	571	12,852	500	11,340	408	10,584	317
	0.1	2	0.065	47,770	2,866	39,490	2,369	35,668	2,140	33,439	1,805	29,617	1,421	27,707	1,163
		3	0.05	47,770	2,866	39,490	2,369	35,668	2,140	33,439	1,805	29,617	1,421	27,707	1,163
		4	0.038	43,200	2,588	36,000	2,157	32,400	1,941	30,600	1,650	27,000	1,294	25,200	1,057
		5	0.03	39,808	2,388	31,847	1,910	29,299	1,757	27,707	1,496	24,522	1,177	22,929	963
		6	0.024	34,992	1,887	29,160	1,572	26,244	1,415	24,786	1,336	21,870	1,048	20,412	856
		8	0.024	31,104	1,677	25,920	1,397	23,328	1,258	22,032	1,188	19,440	932	18,144	761
		10	0.015	27,216	1,467	22,680	1,223	20,412	1,100	19,278	1,039	17,010	815	15,876	666
		12	0.015	24,192	1,159	20,160	966	18,144	870	17,136	719	15,120	634	14,112	507
		16	0.009	24,192	1,014	20,160	845	18,144	761	17,136	667	15,120	543	14,112	423
		20	0.006	18,144	761	15,120	634	13,608	571	12,852	500	11,340	408	10,584	317
	0.2	2	0.11	47,770	2,866	39,490	2,369	35,668	2,140	33,439	1,805	29,617	1,421	27,707	1,163
		3	0.09	47,770	2,866	39,490	2,369	35,668	2,140	33,439	1,805	29,617	1,421	27,707	1,163
		4	0.07	43,200	2,588	36,000	2,157	32,400	1,941	30,600	1,650	27,000	1,294	25,200	1,057
		5	0.05	39,808	2,388	31,847	1,910	29,299	1,757	27,707	1,496	24,522	1,177	22,929	963
		6	0.04	34,992	1,887	29,160	1,572	26,244	1,415	24,786	1,336	21,870	1,048	20,412	856
		8	0.04	31,104	1,677	25,920	1,397	23,328	1,258	22,032	1,188	19,440	932	18,144	761
		10	0.025	27,216	1,467	22,680	1,223	20,412	1,100	19,278	1,039	17,010	815	15,876	666
		12	0.025	24,192	1,159	20,160	966	18,144	870	17,136	719	15,120	634	14,112	507
		16	0.015	24,192	1,014	20,160	845	18,144	761	17,136	667	15,120	543	14,112	423
		20	0.01	18,144	761	15,120	634	13,608	571	12,852	500	11,340	408	10,584	317
	0.3	2	0.11	47,770	2,866	39,490	2,369	35,668	2,140	33,439	1,805	29,617	1,421	27,707	1,163
		3	0.09	47,770	2,866	39,490	2,369	35,668	2,140	33,439	1,805	29,617	1,421	27,707	1,163
		4	0.07	43,200	2,588	36,000	2,157	32,400	1,941	30,600	1,650	27,000	1,294	25,200	1,057
		5	0.05	39,808	2,388	31,847	1,910	29,299	1,757	27,707	1,496	24,522	1,177	22,929	963
		6	0.04	34,992	1,887	29,160	1,572	26,244	1,415	24,786	1,336	21,870	1,048	20,412	856
		8	0.04	31,104	1,677	25,920	1,397	23,328	1,258	22,032	1,188	19,440	932	18,144	761
		10	0.025	27,216	1,467	22,680	1,223	20,412	1,100	19,278	1,039	17,010	815	15,876	666
		12	0.025	24,192	1,159	20,160	966	18,144	870	17,136	719	15,120	634	14,112	507
		16	0.015	24,192	1,014	20,160	845	18,144	761	17,136	667	15,120	543	14,112	423
		20	0.01	18,144	761	15,120	634	13,608	571	12,852	500	11,340	408	10,584	317
1.25	0.1	5	0.03	39,808	2,388	31,847	1,910	29,299	1,757	27,707	1,496	24,522	1,177	22,929	963
		10	0.015	27,216	1,467	25,920	1,397	20,412	1,100	19,278	1,039	17,010	815	15,876	666
		15	0.01	24,192	1,014	20,160	845	18,144	761	17,136	667	15,120	543	14,112	423
		20	0.006	18,144	761	15,120	634	13,608	571	12,852	500	11,340	408	10,584	317
	0.2	5	0.05	39,808	2,388	31,847	1,910	29,299	1,757	27,707	1,496	24,522	1,177	22,929	963
		10	0.025	27,216	1,467	25,920	1,397	20,412	1,100	19,278	1,039	17,010	815	15,876	666
		15	0.016	24,192	1,014	20,160	845	18,144	761	17,136	667	15,120	543	14,112	423
		20	0.01	18,144	761	15,120	634	13,608	571	12,852	500	11,340	408	10,584	317
	0.3	5	0.05	39,808	2,388	31,847	1,910	29,299	1,757	27,707	1,496	24,522	1,177	22,929	963
		10	0.025	27,216	1,467	25,920	1,397	20,412	1,100	19,278	1,039	17,010	815	15,876	666
		15	0.016	24,192	1,014	20,160	845	18,144	761	17,136	667	15,120	543	14,112	423
		20	0.01	18,144	761	15,120	634	13,608	571	12,852	500	11,340	408	10,584	317
1.5	0.1	4	0.042	33,264	2,153	27,700	1,793	24,948	1,614	23,285	1,378	20,790	1,076	19,293	883
		6	0.04	31,847	2,057	26,539	1,714	23,779	1,536	22,505	1,332	19,957	1,033	18,471	845
		8	0.036	30,240	1,956	25,200	1,630	22,680	1,467	21,420	1,268	18,900	979	17,640	807
		12	0.036	24,192	1,565	20,160	1,304	18,144	1,174	17,136	1,014	15,120	783	14,112	646
		15	0.023	18,816	1,082	15,680	902	14,112	812	13,328	671	11,760	592	10,976	473
		20	0.018	18,816	978	15,680	815	14,112	733	13,328	613	11,760	540	10,976	428

【注意】ご使用にあたっては、A138ページの表下の項目と注意を参照してください。【Note】Upon usage, please refer to comments and notes below table on page A138.

Epoch Deep Radius Evolution

エポックディープラジアスエボリューション

■ 標準切削条件表 Recommended cutting conditions EPDRE-ATH

高能率切削条件 High efficiency cuttiing condition

高精度切削条件 High accuracy cuttiing condition

高精度切削条件はA139ページを参照してください。
Please refer to P.A139 about high accuracy cutting conditions

被削材 Work material				1 銅 Copper		2 炭素鋼・合金鋼 Carbon Steels, Alloy Steels (180～250HB)		3 ステンレス鋼・工具鋼 Stainless Steels, Tool Steels (25～35HRC)		4 プリハードン鋼 Pre-hardened Steels (35～45HRC)		5 焼入れ鋼 Hardened Steels (45～55HRC)		6 焼入れ鋼 Hardened Steels (55～65HRC)	
切り込み比率 Ratio to standard depth of cut				120%		100%		90%		80%		65%		60%	
外径 Tool Dia. (mm)	コーナ半径r Corner radius (mm)	首下長 Under neck Length (mm)	ap (mm)	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min
1.5	0.2	4	0.07	33,264	2,153	27,700	1,793	24,948	1,614	23,285	1,378	20,790	1,076	19,293	883
		6	0.065	31,847	2,057	26,539	1,714	23,779	1,536	22,505	1,332	19,957	1,033	18,471	845
		8	0.06	30,240	1,956	25,200	1,630	22,680	1,467	21,420	1,268	18,900	979	17,640	807
		12	0.06	24,192	1,565	20,160	1,304	18,144	1,174	17,136	1,014	15,120	783	14,112	646
		15	0.038	18,816	1,082	15,680	902	14,112	812	13,328	671	11,760	592	10,976	473
		20	0.03	18,816	978	15,680	815	14,112	733	13,328	613	11,760	540	10,976	428
	0.3	4	0.07	33,264	2,153	27,700	1,793	24,948	1,614	23,285	1,378	20,790	1,076	19,293	883
		6	0.065	31,847	2,057	26,539	1,714	23,779	1,536	22,505	1,332	19,957	1,033	18,471	845
		8	0.06	30,240	1,956	25,200	1,630	22,680	1,467	21,420	1,268	18,900	979	17,640	807
		12	0.06	24,192	1,565	20,160	1,304	18,144	1,174	17,136	1,014	15,120	783	14,112	646
		15	0.038	18,816	1,082	15,680	902	14,112	812	13,328	671	11,760	592	10,976	473
		20	0.03	18,816	978	15,680	815	14,112	733	13,328	613	11,760	540	10,976	428
	0.5	4	0.085	33,264	2,153	27,700	1,793	24,948	1,614	23,285	1,378	20,790	1,076	19,293	883
		6	0.08	31,847	2,057	26,539	1,714	23,779	1,536	22,505	1,332	19,957	1,033	18,471	845
		8	0.07	30,240	1,956	25,200	1,630	22,680	1,467	21,420	1,268	18,900	979	17,640	807
		12	0.065	24,192	1,565	20,160	1,304	18,144	1,174	17,136	1,014	15,120	783	14,112	646
		15	0.045	18,816	1,082	15,680	902	14,112	812	13,328	671	11,760	592	10,976	473
		20	0.035	18,816	978	15,680	815	14,112	733	13,328	613	11,760	540	10,976	428
1.75	0.1	5	0.04	31,847	2,057	26,539	1,714	23,779	1,536	22,505	1,332	19,957	1,033	18,471	845
		10	0.036	24,192	1,565	20,160	1,304	18,144	1,174	17,136	1,014	15,120	783	14,112	646
		15	0.023	18,816	1,082	15,680	902	14,112	812	13,328	671	11,760	592	10,976	473
		20	0.018	18,816	978	15,680	815	14,112	733	13,328	613	11,760	540	10,976	428
	0.2	5	0.065	31,847	2,057	26,539	1,714	23,779	1,536	22,505	1,332	19,957	1,033	18,471	845
		10	0.06	24,192	1,565	20,160	1,304	18,144	1,174	17,136	1,014	15,120	783	14,112	646
		15	0.038	18,816	1,082	15,680	902	14,112	812	13,328	671	11,760	592	10,976	473
		20	0.03	18,816	978	15,680	815	14,112	733	13,328	613	11,760	540	10,976	428
	0.3	5	0.065	31,847	2,057	26,539	1,714	23,779	1,536	22,505	1,332	19,957	1,033	18,471	845
		10	0.06	24,192	1,565	20,160	1,304	18,144	1,174	17,136	1,014	15,120	783	14,112	646
		15	0.038	18,816	1,082	15,680	902	14,112	812	13,328	671	11,760	592	10,976	473
		20	0.03	18,816	978	15,680	815	14,112	733	13,328	613	11,760	540	10,976	428
2	0.1	4	0.08	28,662	3,221	24,203	2,720	21,815	2,452	20,541	2,308	18,152	1,630	17,038	1,339
		6	0.07	27,720	3,114	23,100	2,595	20,790	2,335	19,635	2,205	17,325	1,557	16,170	1,271
		8	0.055	25,200	2,830	21,000	2,359	18,900	2,123	17,850	2,005	15,750	1,415	14,700	1,156
		12	0.03	20,412	2,063	17,010	1,720	15,309	1,548	14,459	1,462	12,758	1,146	11,907	936
		16	0.03	18,144	1,834	15,120	1,528	13,608	1,376	12,852	1,299	11,340	1,019	10,584	832
		20	0.025	15,876	1,605	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		25	0.015	15,876	1,605	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		30	0.01	15,082	1,525	12,569	1,271	11,312	1,143	10,683	1,080	9,426	761	8,798	621
	0.2	4	0.1	28,662	3,221	24,203	2,720	21,815	2,452	20,541	2,308	18,152	1,630	17,038	1,339
		6	0.08	27,720	3,114	23,100	2,595	20,790	2,335	19,635	2,205	17,325	1,557	16,170	1,271
		8	0.07	25,200	2,830	21,000	2,359	18,900	2,123	17,850	2,005	15,750	1,415	14,700	1,156
		12	0.04	20,412	2,063	17,010	1,720	15,309	1,548	14,459	1,462	12,758	1,146	11,907	936
		16	0.04	18,144	1,834	15,120	1,528	13,608	1,376	12,852	1,299	11,340	1,019	10,584	832
		20	0.035	15,876	1,605	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		25	0.025	15,876	1,605	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		30	0.017	15,082	1,525	12,569	1,271	11,312	1,143	10,683	1,080	9,426	761	8,798	621
	0.3	4	0.13	28,662	3,221	24,203	2,720	21,815	2,452	20,541	2,308	18,152	1,630	17,038	1,339
		6	0.11	27,720	3,114	23,100	2,595	20,790	2,335	19,635	2,205	17,325	1,557	16,170	1,271
		8	0.09	25,200	2,830	21,000	2,359	18,900	2,123	17,850	2,005	15,750	1,415	14,700	1,156
		12	0.06	20,412	2,063	17,010	1,720	15,309	1,548	14,459	1,462	12,758	1,146	11,907	936
		16	0.06	18,144	1,834	15,120	1,528	13,608	1,376	12,852	1,299	11,340	1,019	10,584	832
		20	0.037	15,876	1,605	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		25	0.03	15,876	1,605	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		30	0.021	15,082	1,525	12,569	1,271	11,312	1,143	10,683	1,080	9,426	761	8,798	621
	0.5	6	0.17	27,720	3,114	23,100	2,595	20,790	2,335	19,635	2,205	17,325	1,557	16,170	1,271
		8	0.14	25,200	2,830	21,000	2,359	18,900	2,123	17,850	2,005	15,750	1,415	14,700	1,156
		12	0.08	20,412	2,063	17,010	1,720	15,309	1,548	14,459	1,462	12,758	1,146	11,907	936
		16	0.08	18,144	1,834	15,120	1,528	13,608	1,376	12,852	1,299	11,340	1,019	10,584	832
		20	0.05	15,876	1,605	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		25	0.05	15,876	1,605	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		30	0.03	15,082	1,525	12,569	1,271	11,312	1,143	10,683	1,080	9,426	761	8,798	621
	0.8	6	0.22	27,720	3,114	23,100	2,595	20,790	2,335	19,635	2,205	17,325	1,557	16,170	1,271
		8	0.2	25,200	2,830	21,000	2,359	18,900	2,123	17,850	2,005	15,750	1,415	14,700	1,156
		12	0.13	20,412	2,063	17,010	1,720	15,309	1,548	14,459	1,462	12,758	1,146	11,907	936
		16	0.1	18,144	1,834	15,120	1,528	13,608	1,376	12,852	1,299	11,340	1,019	10,584	832
		20	0.06	15,876	1,605	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		25	0.057	15,876	1,605	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		30	0.045	15,082	1,525	12,569	1,271	11,312	1,143	10,683	1,080	9,426	761	8,798	621

被削材 Work material				1 銅 Copper		2 炭素鋼・合金鋼 Carbon Steels, Alloy Steels (180～250HB)		3 ステンレス鋼・工具鋼 Stainless Steels, Tool Steels (25～35HRC)		4 プリハードン鋼 Pre-hardened Steels (35～45HRC)		5 焼入れ鋼 Hardened Steels (45～55HRC)		6 焼入れ鋼 Hardened Steels (55～65HRC)	
切り込み比率 Ratio to standard depth of cut				120%		100%		90%		80%		65%		60%	
外径 Tool Dia. (mm)	コーナ半径r Corner radius (mm)	首下長 Under neck Length (mm)	ap (mm)	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min
2.5	0.1	10	0.05	20,412	2,293	17,010	1,720	15,309	1,548	14,459	1,462	12,758	1,146	11,907	936
		20	0.03	15,876	1,783	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		30	0.015	15,082	1,525	12,569	1,271	11,312	1,143	10,683	1,080	9,426	761	8,798	621
	0.2	10	0.07	20,412	2,293	17,010	1,720	15,309	1,548	14,459	1,462	12,758	1,146	11,907	936
		20	0.04	15,876	1,783	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		30	0.025	15,082	1,525	12,569	1,271	11,312	1,143	10,683	1,080	9,426	761	8,798	621
	0.3	10	0.09	20,412	2,293	17,010	1,720	15,309	1,548	14,459	1,462	12,758	1,146	11,907	936
		20	0.06	15,876	1,783	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		30	0.03	15,082	1,525	12,569	1,271	11,312	1,143	10,683	1,080	9,426	761	8,798	621
	0.5	10	0.12	20,412	2,293	17,010	1,720	15,309	1,548	14,459	1,462	12,758	1,146	11,907	936
		20	0.08	15,876	1,783	13,230	1,337	11,907	1,204	11,246	1,137	9,923	801	9,261	653
		30	0.05	15,082	1,525	12,569	1,271	11,312	1,143	10,683	1,080	9,426	761	8,798	621
3	0.1	6	0.08	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		8	0.07	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		12	0.05	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		16	0.035	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		18	0.035	16,985	2,384	14,331	2,012	12,738	1,788	12,208	1,714	10,615	1,193	10,084	992
		20	0.035	15,552	2,184	12,960	1,820	11,664	1,638	11,016	1,547	9,720	1,092	9,072	892
		30	0.027	12,096	1,524	10,080	1,270	9,072	1,143	8,568	1,079	7,560	771	7,056	621
		35	0.02	12,096	1,524	10,080	1,270	9,072	1,143	8,568	1,079	7,560	771	7,056	621
	0.2	6	0.1	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		8	0.09	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		12	0.07	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		16	0.05	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		18	0.05	16,985	2,384	14,331	2,012	12,738	1,788	12,208	1,714	10,615	1,193	10,084	992
		20	0.05	15,552	2,184	12,960	1,820	11,664	1,638	11,016	1,547	9,720	1,092	9,072	892
		30	0.04	12,096	1,524	10,080	1,270	9,072	1,143	8,568	1,079	7,560	771	7,056	621
		35	0.035	12,096	1,524	10,080	1,270	9,072	1,143	8,568	1,079	7,560	771	7,056	621
	0.3	6	0.145	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		8	0.13	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		12	0.1	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		16	0.075	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		18	0.075	16,985	2,384	14,331	2,012	12,738	1,788	12,208	1,714	10,615	1,193	10,084	992
		20	0.075	15,552	2,184	12,960	1,820	11,664	1,638	11,016	1,547	9,720	1,092	9,072	892
		30	0.06	12,096	1,524	10,080	1,270	9,072	1,143	8,568	1,079	7,560	771	7,056	621
		35	0.05	12,096	1,524	10,080	1,270	9,072	1,143	8,568	1,079	7,560	771	7,056	621
	0.5	8	0.18	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		12	0.13	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		16	0.1	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		18	0.1	16,985	2,384	14,331	2,012	12,738	1,788	13,600	1,909	10,615	1,193	10,084	992
		20	0.1	15,552	2,184	12,960	1,820	11,664	1,638	11,016	1,547	9,720	1,092	9,072	892
		30	0.08	12,096	1,524	10,080	1,270	9,072	1,143	8,568	1,079	7,560	771	7,056	621
		35	0.065	12,096	1,524	10,080	1,270	9,072	1,143	8,568	1,079	7,560	771	7,056	621
	1	8	0.2	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		12	0.15	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		16	0.12	19,200	2,696	16,000	2,246	14,400	2,022	13,600	1,909	12,000	1,348	11,200	1,101
		18	0.11	16,985	2,384	14,331	2,012	12,738	1,788	13,600	1,909	10,615	1,193	10,084	992
		20	0.11	15,552	2,184	12,960	1,820	11,664	1,638	11,016	1,547	9,720	1,092	9,072	892
		30	0.09	12,096	1,524	10,080	1,270	9,072	1,143	8,568	1,079	7,560	771	7,056	621
		35	0.075	12,096	1,524	10,080	1,270	9,072	1,143	8,568	1,079	7,560	771	7,056	621
4	0.1	8	0.08	16,560	2,880	13,800	2,400	12,420	2,160	11,730	2,040	10,350	1,440	9,660	1,176
		12	0.065	16,560	2,880	13,800	2,400	12,420	2,160	11,730	2,040	10,350	1,440	9,660	1,176
		16	0.06	13,733	2,388	11,445	1,990	10,071	1,751	9,613	1,671	8,240	1,146	7,782	947
		20	0.055	13,733	2,388	11,445	1,990	10,071	1,751	9,613	1,671	8,240	1,146	7,782	947
		30	0.045	10,985	1,719	9,154	1,433	8,239	1,290	7,781	1,218	6,866	860	6,408	702
		35	0.04	10,985	1,719	9,154	1,433	8,239	1,290	7,781	1,218	6,866	860	6,408	702
		45	0.03	8,789	1,100	7,324	917	6,592	825	6,226	780	5,494	554	5,127	446
	0.2	8	0.16	16,560	2,880	13,800	2,400	12,420	2,160	11,730	2,040	10,350	1,440	9,660	1,176
		12	0.14	16,560	2,880	13,800	2,400	12,420	2,160	11,730	2,040	10,350	1,440	9,660	1,176
		16	0.13	13,733	2,388	11,445	1,990	10,071	1,751	9,613	1,671	8,240	1,146	7,782	947
		20	0.11	13,733	2,388	11,445	1,990	10,071	1,751	9,613	1,671	8,240	1,146	7,782	947
		30	0.1	10,985	1,719	9,154	1,433	8,239	1,290	7,781	1,218	6,866	860	6,408	702
		35	0.08	10,985	1,719	9,154	1,433	8,239	1,290	7,781	1,218	6,866	860	6,408	702
		45	0.06	8,789	1,100	7,324	917	6,592	825	6,226	780	5,494	554	5,127	446
	0.3	8	0.24	16,560	2,880	13,800	2,400	12,420	2,160	11,730	2,040	10,350	1,440	9,660	1,176
		12	0.22	16,560	2,880	13,800	2,400	12,420	2,160	11,730	2,040	10,350	1,440	9,660	1,176
		16	0.2	13,733	2,388	11,445	1,990	10,071	1,751	9,613	1,671	8,240	1,146	7,782	947
		20	0.18	13,733	2,388	11,445	1,990	10,071	1,751	9,613	1,671	8,240	1,146	7,782	947
		30	0.16	10,985	1,719	9,154	1,433	8,239	1,290	7,781	1,218	6,866	860	6,408	702
		35	0.14	10,985	1,719	9,154	1,433	8,239	1,290	7,781	1,218	6,866	860	6,408	702
		45	0.12	8,789	1,100	7,324	917	6,592	825	6,226	780	5,494	554	5,127	446

【注意】ご使用にあたっては、A138ページの表下の項目と注意を参照してください。【Note】Upon usage, please refer to comments and notes below table on page A138.

Epoch Deep Radius Evolution

エポックディープラジアスエボリューション

■ 標準切削条件表 Recommended cutting conditions EPDRE-ATH

高能率切削条件 High efficiency cuttiing condition

高精度切削条件 High accuracy cuttiing condition

高精度切削条件はA139ページを参照してください。
Please refer to P.A139 about high accuracy cutting conditions

被削材 Work material				1 銅 Copper		2 炭素鋼・合金鋼 Carbon Steels, Alloy Steels (180～250HB)		3 ステンレス鋼・工具鋼 Stainless Steels, Tool Steels (25～35HRC)		4 プリハードン鋼 Pre-hardened Steels (35～45HRC)		5 焼入れ鋼 Hardened Steels (45～55HRC)		6 焼入れ鋼 Hardened Steels (55～65HRC)	
切り込み比率 Ratio to standard depth of cut				120%		100%		90%		80%		65%		60%	
外径 Tool Dia. (mm)	コーナ半径r Corner radius (mm)	首下長 Under neck Length (mm)	ap (mm)	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min	回転数 n min-1	送り速度 vf mm/min
4	0.5	12	0.35	16,560	2,880	13,800	2,400	12,420	2,160	11,730	2,040	10,350	1,440	9,660	1,176
		16	0.25	13,733	2,388	11,445	1,990	10,071	1,751	9,613	1,671	8,240	1,146	7,782	947
		20	0.2	13,733	2,388	11,445	1,990	10,071	1,751	9,613	1,671	8,240	1,146	7,782	947
		30	0.15	10,985	1,719	9,154	1,433	8,239	1,290	7,781	1,218	6,866	860	6,408	702
		35	0.1	10,985	1,719	9,154	1,433	8,239	1,290	7,781	1,218	6,866	860	6,408	702
		45	0.05	8,789	1,100	7,324	917	6,592	825	6,226	780	5,494	554	5,127	446
	1	12	0.4	16,560	2,880	13,800	2,400	12,420	2,160	11,730	2,040	10,350	1,440	9,660	1,176
		16	0.29	13,733	2,388	11,445	1,990	10,071	1,751	9,613	1,671	8,240	1,146	7,782	947
		20	0.23	13,733	2,388	11,445	1,990	10,071	1,751	9,613	1,671	8,240	1,146	7,782	947
		30	0.17	10,985	1,719	9,154	1,433	8,239	1,290	7,781	1,218	6,866	860	6,408	702
		35	0.12	10,985	1,719	9,154	1,433	8,239	1,290	7,781	1,218	6,866	860	6,408	702
		45	0.06	8,789	1,100	7,324	917	6,592	825	6,226	780	5,494	554	5,127	446
5	0.1	20	0.08	13,179	2,865	10,983	2,388	9,884	2,149	9,336	2,029	8,237	1,433	7,688	1,170
		40	0.06	11,868	2,312	9,890	1,926	8,901	1,734	8,407	1,637	7,418	1,156	6,923	944
	0.2	20	0.16	13,179	2,865	10,983	2,388	9,884	2,149	9,336	2,029	8,237	1,433	7,688	1,170
		40	0.13	11,868	2,312	9,890	1,926	8,901	1,734	8,407	1,637	7,418	1,156	6,923	944
	0.3	20	0.24	13,179	2,865	10,983	2,388	9,884	2,149	9,336	2,029	8,237	1,433	7,688	1,170
		40	0.2	11,868	2,312	9,890	1,926	8,901	1,734	8,407	1,637	7,418	1,156	6,923	944
	0.5	20	0.35	13,179	2,865	10,983	2,388	9,884	2,149	9,336	2,029	8,237	1,433	7,688	1,170
		40	0.135	11,868	2,312	9,890	1,926	8,901	1,734	8,407	1,637	7,418	1,156	6,923	944
	1	20	0.4	13,179	2,865	10,983	2,388	9,884	2,149	9,336	2,029	8,237	1,433	7,688	1,170
		40	0.15	11,868	2,312	9,890	1,926	8,901	1,734	8,407	1,637	7,418	1,156	6,923	944
6	0.1	12	0.08	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		18	0.065	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		24	0.06	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		35	0.05	9,881	2,320	8,234	1,933	7,411	1,740	6,999	1,643	6,176	1,160	5,764	947
		55	0.04	7,687	1,805	6,406	1,504	5,765	1,354	5,445	1,278	4,805	902	4,484	737
	0.2	12	0.16	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		18	0.14	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		24	0.13	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		35	0.11	9,881	2,320	8,234	1,933	7,411	1,740	6,999	1,643	6,176	1,160	5,764	947
		55	0.08	7,687	1,805	6,406	1,504	5,765	1,354	5,445	1,278	4,805	902	4,484	737
	0.3	12	0.24	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		18	0.22	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		24	0.2	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		35	0.18	9,881	2,320	8,234	1,933	7,411	1,740	6,999	1,643	6,176	1,160	5,764	947
		55	0.14	7,687	1,805	6,406	1,504	5,765	1,354	5,445	1,278	4,805	902	4,484	737
	0.5	18	0.35	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		24	0.29	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		35	0.24	9,881	2,320	8,234	1,933	7,411	1,740	6,999	1,643	6,176	1,160	5,764	947
		55	0.165	7,687	1,805	6,406	1,504	5,765	1,354	5,445	1,278	4,805	902	4,484	737
	1	18	0.4	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		24	0.35	10,985	2,866	9,154	2,388	8,239	2,149	7,781	2,030	6,866	1,433	6,408	1,170
		35	0.28	9,881	2,320	8,234	1,933	7,411	1,740	6,999	1,643	6,176	1,160	5,764	947
		55	0.2	7,687	1,805	6,406	1,504	5,765	1,354	5,445	1,278	4,805	902	4,484	737

※(1)a_pは被削材グループ2での目安を示しています。その他のグループの場合は、上表の切込み比率を目安に調整してください。
※(2)リブ加工や止まり溝など、切りくずがつまりやすい切削の場合、切込み設定は基本切込みに切込み比率をかけて算出した切込み量を、さらにその80%まで小さくして使用してください。
※(3)a_eの設定はa_p×切込み比率×5倍以下を目安に調整してください。仕上げ加工を行う場合、理論カスプハイトを計算し設定してください。
※(4)掘り込み時のアプローチ方法は、ヘリカルか傾斜での加工を推奨いたします。
※(5)L/Dが5以上の場合、
①彫り込み時の傾斜進入角は1°以下を推奨いたします。また、送り速度は条件表の70%以下に調整してください。
②文字彫り加工のような溝切削の際は、送り速度は50%以下・a_pを30%以下を目安に調整してください。また往復切削による加工を推奨いたします。

※(1) a_p is shown as the criteria for Group 2 workpieces. For other groups, adjust the cutting depth according to the cutting depth factors in the above table.
※(2) When performing cutting where cutting chips may cause clogging, such as for rib cutting, blind grooves, etc., cutting depth setting should be set by multiplying a cutting depth factor to calculate the cutting depth amount, and this amount should then be reduced to 80% of the calculated value.
※(3) Adjust by setting a_e to (5 or less)×(a_p)×(cutting depth ratio). When performing finishing cutting, calculate the theoretical cusp height and set accordingly.
※(4) Helical or sloped cutting is recommended for the approach method when engraving.
※(5) When L/D is 5 or greater:
①The recommended slope entrance angle when engraving is 1° or less. In addition, feed rate should be adjusted to 70% or less of the values in the cutting condition table.
②When slotting such engraving letters, adjust feed rate to 50% or less and ap to 30% or less of the values shown. In addition, cutting by reciprocal cutting is recommended.

【切込み設定例】EPDRE2030-6-02-ATHの工具でプリハードン鋼(40HRC)をリブ溝等高線切削する場合、
切込み=0.1(a_p)×0.8(プリハードン鋼グループ4の切込み比率)×0.8(閉鎖域の切削)=0.064mm

Cutting depth setting example: When cutting rib groove contours in pre-hardened steel (40HRC) using an EPDRE2030-6-02-ATH tool:
Cutting depth = 0.1 (a_p) × 0.8 (cutting depth factor for Group 4 pre-hardened steel) × 0.8 (for closed-area cutting) = 0.064mm

【注意】①被削材、加工形状に合わせて、適切なクーラントを使用してください。
②この標準切削条件表は切削条件の目安を示すものです。実際の加工では加工形状、目的、使用機械等により条件を調整してください。
③機械の回転数が足りない場合は、回転数と送り速度を同じ比率で下げてください。

【Note】① Use the appropriate coolant for the work material and machining shape.
② These Recommended Cutting Conditions indicate only the rule of a thumb for the cutting conditions. In actual machining, the condition should be adjusted according to the machining shape, purpose and the machine type.
③ If the rpm of the machine is low, lower the feed rate also to put the rpm and feed rate in the same ratio.