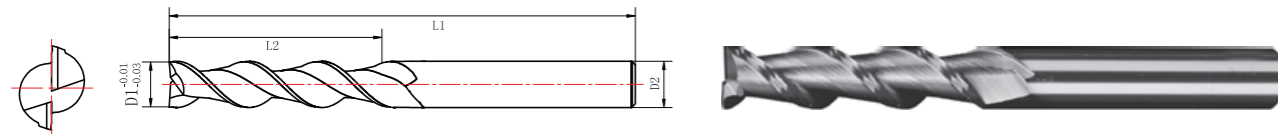


铝合金用二齿加长型 Two Flute Long Length for Aluminum



类型与规格

Type & Specifications

| 产品编码 Code No. | 刃数 Z No. | 螺旋角 Helix angle | 刃径 D1 | 柄径 D2 | 刃长 L2 | 总长 L1 |
|------------------|-------------|--------------------|----------|----------|----------|----------|
| L1182204020 | 2 | 45° | 2.0 | 4.0 | 8 | 60 |
| L1182205020 | 2 | 45° | 2.0 | 6.0 | 8 | 60 |
| L1182206020 | 2 | 45° | 2.5 | 4.0 | 10 | 60 |
| L1182207020 | 2 | 45° | 2.5 | 6.0 | 10 | 60 |
| L1182208020 | 2 | 45° | 3.0 | 4.0 | 12 | 60 |
| L1182209020 | 2 | 45° | 3.0 | 6.0 | 12 | 60 |
| L1182210020 | 2 | 45° | 3.5 | 4.0 | 12 | 60 |
| L1182211020 | 2 | 45° | 3.5 | 6.0 | 12 | 60 |
| L1182212020 | 2 | 45° | 4.0 | 4.0 | 15 | 60 |
| L1182213020 | 2 | 45° | 4.0 | 6.0 | 15 | 60 |
| L1182214020 | 2 | 45° | 5.0 | 6.0 | 25 | 75 |
| L1182215020 | 2 | 45° | 6.0 | 6.0 | 25 | 75 |
| L1182216020 | 2 | 45° | 8.0 | 8.0 | 30 | 75 |
| L1182217020 | 2 | 45° | 10.0 | 10.0 | 40 | 100 |
| L1182218020 | 2 | 45° | 12.0 | 12.0 | 45 | 100 |
| L1182219020 | 2 | 45° | 14.0 | 14.0 | 45 | 100 |
| L1182220020 | 2 | 45° | 16.0 | 16.0 | 60 | 150 |
| L1182221020 | 2 | 45° | 18.0 | 18.0 | 60 | 150 |
| L1182222020 | 2 | 45° | 20.0 | 20.0 | 60 | 150 |
| L1182223020 | 2 | 45° | 25.0 | 25.0 | 70 | 150 |

被加工材质

Materials

| P | | M | K | N | | | S | H | | | | |
|-----|-----|----------|-----|----|-----|-----|------|------|-----|----------|----------|----------|
| 普碳钢 | 合金钢 | 调制钢 | 不锈钢 | 铸铁 | 铝合金 | 铜合金 | 复合材料 | 高温合金 | 钛合金 | 淬硬钢 | | |
| | | HRC30-43 | | | | | | | | HRC45-53 | HRC53-58 | HRC58-63 |
| | | | | | ◎ | ◎ | | | | | | |

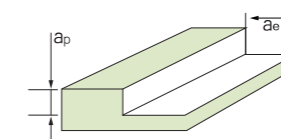
◎=最适合 ○=适合

推荐切削条件 Suggested Conditions

侧铣 Side Milling

| 产品编码 Code No. | 被加工材料 Work Material | 铝合金 Aluminum Alloy | |
|------------------|------------------------|-------------------------|--------------|
| | 刃径 Dia(mm) | 转速 min ⁻¹ | 进给 mm/min |
| L1182204020 | 2.0 | 25460 | 300 |
| L1182205020 | 2.0 | 25460 | 300 |
| L1182206020 | 2.5 | 20370 | 400 |
| L1182207020 | 2.5 | 20370 | 400 |
| L1182208020 | 3.0 | 16980 | 500 |
| L1182209020 | 3.0 | 16980 | 500 |
| L1182210020 | 3.5 | 14550 | 500 |
| L1182211020 | 3.5 | 14550 | 500 |
| L1182212020 | 4.0 | 12730 | 510 |
| L1182213020 | 4.0 | 12730 | 510 |
| L1182214020 | 5.0 | 10190 | 560 |
| L1182215020 | 6.0 | 8490 | 590 |
| L1182216020 | 8.0 | 6370 | 600 |
| L1182217020 | 10.0 | 5090 | 620 |
| L1182218020 | 12.0 | 4240 | 660 |
| L1182219020 | 14.0 | 3640 | 700 |
| L1182220020 | 16.0 | 3180 | 730 |
| L1182221020 | 18.0 | 2830 | 730 |
| L1182222020 | 20.0 | 2550 | 730 |
| L1182223020 | 25.0 | 2040 | 760 |
| ap(切深) | | ap=1.5D | |
| ae(切宽) | | ae=0.1D | |

加工示意图
Illustration



- ◎ 请使用刚性好、精度高的设备和夹具；
- ◎ 请使用顺铣，如发生振颤，请降低使用条件；
- ◎ 请选用适用于工件材料的切削液；