

EMD83 SERIES 4 FLUTE CORNER RADIUS - SLOTTING
4刃 圆鼻 - 槽铣削

Vc (切削速度) = (m/min.)
fz (每齿进给) = (mm/tooth)
RPM (转速) = (rev./min.)
FEED (进给) = (mm/min.)

ISO	VDI 3323	Material Description 材料描述	Ae(mm) 切削宽度	Ap(mm) 切削深度	Parameter 参数	Diameter (Ø) 直径															
						1.0	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	
P	1-2	Non-alloy steel	1.0D	1.0D	Vc	127	127	128	127	127	127	127	127	127	127	127	127	126	127	126	
					fz	0.002	0.003	0.004	0.005	0.005	0.009	0.013	0.018	0.031	0.048	0.056	0.058	0.063	0.070	0.078	
					RPM	40500	27000	20300	16200	13500	10100	8090	6750	5050	4050	3370	2890	2500	2250	2000	
	6	Low alloy steel	1.0D	1.0D	Vc	127	127	128	127	127	127	127	127	127	127	127	126	127	126		
					fz	0.002	0.003	0.004	0.005	0.005	0.009	0.013	0.018	0.031	0.048	0.056	0.058	0.063	0.070	0.078	
					RPM	40500	27000	20300	16200	13500	10100	8090	6750	5050	4050	3370	2890	2500	2250	2000	
	10	High alloyed steel, and tool steel	1.0D	1.0D	Vc	127	127	128	127	127	127	127	127	127	127	126	127	126			
					fz	0.002	0.003	0.004	0.005	0.005	0.009	0.013	0.018	0.031	0.048	0.056	0.058	0.063	0.070	0.078	
					RPM	40500	27000	20300	16200	13500	10100	8090	6750	5050	4050	3370	2890	2500	2250	2000	
M	12-13	Stainless steel	1.0D	1.0D	Vc	88	87	88	86	88	88	88	89	88	88	89	88	88	88		
					fz	0.001	0.003	0.004	0.004	0.004	0.007	0.010	0.014	0.024	0.038	0.046	0.051	0.053	0.059	0.065	
					RPM	28000	18500	14000	11000	9350	7000	5600	4700	3500	2800	2350	2000	1750	1550	1400	
	14.1	Stainless steel	1.0D	1.0D	Vc	63	61	63	63	63	63	64	63	63	64	63	62	63	62		
					fz	0.003	0.003	0.004	0.004	0.004	0.007	0.010	0.014	0.025	0.039	0.046	0.050	0.053	0.059	0.065	
					RPM	20000	13000	10000	8000	6690	5050	4050	3350	2500	2050	1680	1400	1250	1100	1000	
	K	15	Grey cast iron	1.0D	1.0D	Vc	127	127	128	127	127	127	127	127	127	127	126	127	126		
						fz	0.002	0.003	0.004	0.005	0.005	0.009	0.013	0.018	0.031	0.048	0.056	0.058	0.063	0.070	0.078
						RPM	40500	27000	20300	16200	13500	10100	8090	6750	5050	4050	3370	2890	2500	2250	2000
17		Nodular cast iron	1.0D	1.0D	Vc	127	127	128	127	127	127	127	127	127	127	126	127	126			
					fz	0.002	0.003	0.004	0.005	0.005	0.009	0.013	0.018	0.031	0.048	0.056	0.058	0.063	0.070	0.078	
					RPM	40500	27000	20300	16200	13500	10100	8090	6750	5050	4050	3370	2890	2500	2250	2000	
19-20		Malleable cast iron	1.0D	1.0D	Vc	127	127	128	127	127	127	127	127	127	127	126	127	126			
					fz	0.002	0.003	0.004	0.005	0.005	0.009	0.013	0.018	0.031	0.048	0.056	0.058	0.063	0.070	0.078	
					RPM	40500	27000	20300	16200	13500	10100	8090	6750	5050	4050	3370	2890	2500	2250	2000	
S	37	Titanium Alloys	1.0D	1.0D	Vc	63	61	63	63	63	63	64	63	63	64	63	62	63	62		
					fz	0.003	0.003	0.004	0.004	0.004	0.007	0.010	0.014	0.025	0.039	0.046	0.050	0.053	0.059	0.065	
					RPM	20000	13000	10000	8000	6690	5050	4050	3350	2500	2050	1680	1400	1250	1100	1000	

