

# EMM 4000系列切削參數

The Cutting Data For EMM 4000 Series

被加工材質  
Material

鋼  
Steel

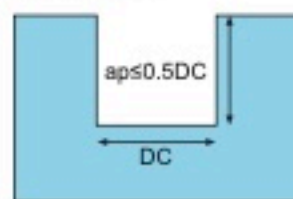
不銹鋼  
Stainless steel

鑄鐵  
Cast Iron

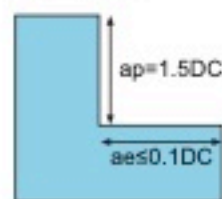
直徑 (mm) Shank		4	6	8	10	12	16	18	20
轉速 n (min)		4800	3100	2300	1900	1600	1200	1240	1060
進給速度 Vf (mm/min)	開槽 Slotted	200	180	180	180	180	200	225	300
	側邊 Side	700	500	580	580	410	300	450	240

## 切削深度 Cutting depth

開槽 Slotted



側邊 Side



$ap$  : 軸向切削深度 Axial depth of cutting

$ae$  : 徑向切削深度 Radial depth of cutting

$DC$  : 刃徑 Diameter of cutting