



鑽頭 · 螺絲攻 · 切削轉速參考表

Reference table of drills, threads, and cutting revolving speed

材質 MATERIALS	塑膠 PLASTIC		青·黃銅 BRONZE·BRASS		合金銅 ALLOY COPPER		鋁 ALUMINUM		鑄鐵 CAST IRON		鐵 IRON		不銹鋼 STAINLESS STEEL	
切削條件 Cutting conditions	V值±5 value V±5		V值±7 value V±7		V值±2 value V±2		V值±10 value V±10		V值±5 value V±5		V值±5 value V±5		V值±2 value V±2	
	34	17	60	30	28	14	50	25	30	15	25	12	8	4
直徑 D.I.A. mm	雙刃 Double Flute		三刃 Triple Flute		雙刃 Double Flute		三刃 Triple Flute		雙刃 Double Flute		三刃 Triple Flute		雙刃 Double Flute	
	R.P.M.		R.P.M.		R.P.M.		R.P.M.		R.P.M.		R.P.M.		R.P.M.	
Ø 2	5415	2705	9555	4780	4460	2230	7960	3980	4780	2390	3980	1910	1275	635
Ø 3	3610	1805	6370	3185	2970	1485	5310	2655	3185	1590	2650	1275	850	425
Ø 4	2705	1355	4780	2390	2230	1115	3980	1990	2390	1195	1990	955	640	320
Ø 5	2165	1085	3820	1910	1785	890	3185	1590	1910	955	1590	765	510	255
Ø 6	1805	900	3185	1590	1485	745	2655	1330	1590	795	1330	640	425	210
Ø 7	1545	775	2730	1365	1275	635	2275	1140	1365	680	1140	545	365	180
Ø 8	1355	680	2390	1195	1115	555	1990	995	1195	600	995	480	320	160
Ø 9	1205	600	2125	1060	990	495	1770	885	1060	530	885	425	285	140
Ø 10	1085	540	1910	955	890	445	1590	800	955	480	800	380	255	125
Ø 11	985	490	1740	870	810	405	1450	725	870	435	725	350	230	115
Ø 12	900	450	1590	795	745	370	1330	665	795	400	665	320	210	105
Ø 13	835	420	1470	735	685	340	1225	610	735	365	610	295	195	100
Ø 14	775	385	1365	680	635	320	1135	570	680	340	570	270	180	90
Ø 15	720	360	1275	640	600	300	1060	530	640	320	530	255	170	85
Ø 16	680	340	1195	600	560	280	995	500	600	300	500	240	160	80
Ø 17	640	320	1125	560	525	260	935	470	560	280	470	225	150	75
Ø 18	600	300	1060	530	495	250	885	440	530	265	440	210	140	70
Ø 19	570	285	1005	500	470	235	835	420	500	250	420	200	135	67
Ø 20	540	270	955	480	445	225	795	400	480	240	400	190	130	65
Ø 25	430	220	765	380	355	180	640	320	380	190	320	155	100	50
Ø 30	360	180	635	320	300	150	530	265	320	160	265	130	85	45
Ø 40	270	135	480	240	225	110	400	200	240	120	200	95	65	30
Ø 50	220	110	380	190	175	90	320	160	190	95	160	75	50	25

備註
NOTE

$$S \text{ 轉速 (running speed)} = \frac{1000 \times V \text{ (切削速度 cutting speed)}}{3.14 \times D \text{ (刀直徑 diameter of cutting tool)}}$$

※加工時視切削情形的切削材料或切削刀具材質再做增減。
 ※Processing is adjustable on the cutting materials as well as the material of the cutting tools according to real cutting conditions.