

CNC machines milling cutter, smooth garden knife, you know swallow end k a few, cutter track parameter set standardaa

These CNC numerical control machine milling cutter, sm knife, garden knife, swallow end knife you know a few, sp what you know



Standard of set of parameter of CNC cutter track

Type: Material of average engine work: 35 ace of HRC ? steel, before quenching (S136, H13, 8407)

of of of of of of of of of of of knife diameter

Cutting tool is bulgy quantity

? 30R5 60

? 30R5 120

? 25R5 60

? 25R5 120

φ 25R0.8	60
φ 25R0.8	120
φ 25R0.8	60
φ 25R0.8	120
φ 12	45
φ 10	35
φ 8	30
φ 6	25

of of of of of of of of of of of knife diameter Cutting tool is bulgy quantity

φ 16R8	100
φ 12R6	100
φ 10R5	80
φ 8R4	60

φ 6R3 40

Workpiece material: 738 718H 738H

of of of of of of of of of of of knife diameter Cutting tool is bulgy quantity

φ 30/R5 60

φ 30/R5 120

φ 25/R5 60

φ 25/R5 120

φ 25/R0.8 60

φ 25/R0.8 120

φ 16/R0.8 60

φ 16/R0.8 120

φ 12 45

φ 10 35

φ 8 30

φ 6 30

φ 4 15

of of of of of of of of of of of of knife diameter

Cutting tool is bulgy quantity

? 16/R8

100

? 12/R6

100

? 10/R5

60

? 8/R4

50

? 6/R3

35

? 4/R2

20

Workpiece material: ? Yan?

of of of of of of of of of of of of knife diameter

Cutting tool is bulgy quantity

? 25/R0.8

120

? 19.05

110

? 15.875

80

? 12

60

? 10

50

φ 8	45
φ 6	35
φ 4	20
φ 3	15
φ 2	10
φ 16/R8	100
φ 12/R6	100
φ 10/R5	60
φ 8/R4	50
φ 6/R3	40
φ 4/R2	20
φ 2/R1.5	15
φ 2/R1	10

Type: Material of work of high speed engine: 718 738

of of of of of of of of of of of of knife diameter Cutting tool is bulgy quantity

φ 16	65
φ 12	65

φ 10 60

φ 8 50

φ 6 40

Ball head knife Cutting tool is bulgy quantity

φ 12/R6 65

φ 10/R5 60

φ 8/R4 50

φ 6/R3 40

Workpiece material: 304

Make the same score bottom knife diameter Cutting tool is bulgy quantity

φ 16 70

φ 12 65

φ 10 60

φ 8 50

φ 6 40

? 4 25

3 20

2 10

Ball head knife

Cutting tool is bulgy quantity

? 16/R6 65

? 10/R5	60
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? 8/R4 50

? 6/R3 40

? 4/R2 25

? 3/R1.5 20

? 2/R1	10
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