

影響刀具操作的因素 Factors for End Mill Operation

因素 Factor	說明& 建議 Instruction and Advice
機器的剛性 Rigidity of Machine	<ol style="list-style-type: none">1. 使用對的機器 Use a right machine.2. 根據機器的剛性去調整適合的切削數據 Adjust cutting conditions according to the rigidity of machine.
銑刀和筒夾的偏擺值 Collet Chuck and Run out of End Mill	<ol style="list-style-type: none">1. 使用適合且準確的夾頭 Use a right and precise collet chuck.2. 刀的偏擺值降到最低 minimize the run out of end mill.
工作夾頭 Work Clamp	<ol style="list-style-type: none">1. 需夾緊工件 Work piece must be firmly clamped.
切削液和排屑 Cutting Fluid and Chips	<ol style="list-style-type: none">1. 足夠的切削液 Give a sufficient cutting fluid.2. 建議在大量切削時要用水基性的切削液 Recommend water-base cutting fluid for heavy cutting.3. 有些銑刀適用於乾式切削 Some end mills apply dry cutting only.4. 在乾式切削時用吹風的方式 Use air blow for dry cutting.5. 移除加工區的切屑 Remove chips from working area.
選刀 Selection of End Mill	<ol style="list-style-type: none">1. 根據加工材質和大小選擇最適合的刀 Select most suitable end mills according to work material and dimension.2. 參考前面的索引表 Refer to the index table on front page.
切削數據 Cutting Conditions	<ol style="list-style-type: none">1. 參考切削數據表 Refer to recommend milling condition table.2. 根據工件、機器剛性和夾具去做數據的調整 It is necessary to adjust conditions according to the machine rigidity and clamping condition of work piece.
刀具伸長量 Overhang of End Mill from tool holder	<ol style="list-style-type: none">1. 刀柄夾持盡量越多好, 刀具露出的部份盡可能少一點 Overhang of end mill must be as short as possible from tool holder.2. 當刀柄夾持無法太深時, 那就要放慢切削的速度 In case overhang cannot be shorten, relieve cutting condition.