

400⁺ 切削條件表 **P360**
Cutting Condition

Square Type - For Hard Material - Multiple Flutes

多刃高硬度用立銑刀

400 PLUS

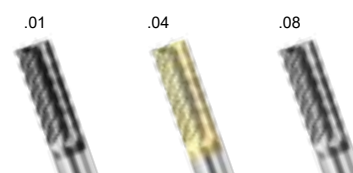
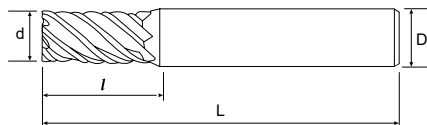
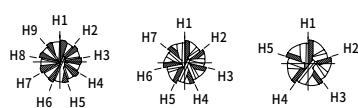
HRC 60

A B A+B

1/2

● Ultra Fine Micro Grain Carbide

● WC=87 Co=12 HRA=92.1 Rupture=3800N/mm² Grain Size=0.4μm



HRC
▶ 40

HRC
▶ 45

HRC
▶ 50

HRC
▶ 55

HRC
▶ 60

HRC
▶ 65

HRC
▶ 70

HRC
▶ 75

HRC
▶ 80

HRC
▶ 85

HRC
▶ 90

HRC
▶ 95

HRC
▶ 100

HRC
▶ 105

HRC
▶ 110

HRC
▶ 115

HRC
▶ 120

HRC
▶ 125

HRC
▶ 130

HRC
▶ 135

HRC
▶ 140

HRC
▶ 145

HRC
▶ 150

HRC
▶ 155

HRC
▶ 160

Dimension 規格					Purchase Code 採購代碼			
Diameter	Flute Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刃徑	L 刃長	L 全長	D 柄徑	Z 刃數	型號	ALTBN	ZrN-S	nACRo
6	16	50	6	5	P-UVT0605	.01	.04	.08
8	20	60	8	7	P-UVT0807	.01	.04	.08
10	30	75	10	7	P-UVT1007	.01	.04	.08
12	32	75	12	7	P-UVT1207	.01	.04	.08
16	40	100	16	9	P-UVT1609	.01	.04	.08
20	45	100	20	9	P-UVT2009	.01	.04	.08
25	45	100	25	9	P-UVT2509	.01	.04	.08

Application 適用材質：

★ Perfect 最推薦

◎ Excellent 適合

○ Good 佳

Coating 塗層	Carbon steel, Alloy steel 炭素鋼, 合金鋼	Pre-hardened steel 預硬鋼	High-hardened 高硬度鋼					Stainless steel 不鏽鋼	Titanium alloy 鈦合金	Nickel/Inconel alloy 鎳基合金	Copper alloy 銅合金, 銅	Aluminum alloy 鋁合金
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
ALTBN	◎	◎	◎	◎	○		○					
ZrN-S	◎	◎	◎	○	○				○			
nACRo	◎	◎	◎	◎	○		◎		○	○		

Unit/單位: mm