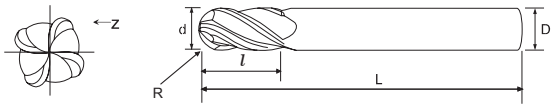
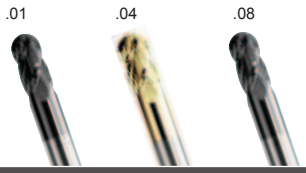
400+ 切削條件表 P364 Cutting Condition

Ball Nose Type - 4 flutes

■ 4刃球型立銑刀

- Ultra Fine Micro Grain Carbide
- WC=87 Co=12 HRA=92.1 Rupture=3800N/mm² Grain Size=0.4μm





Dimension 規格						Purchase Code 採購代碼			
Diameter	Radius	Flute Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	l 刃長	L 全長	D 柄徑	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
1	0.5	2	50	4	4	P-UBT0104	.01	.04	.08
2	1	4	50	4	4	P-UBT0204	.01	.04	.08
2.5	1.25	5	50	4	4	P-UBT0254	.01	.04	.08
3	1.5	6	50	4	4	P-UBT0304	.01	.04	.08
4	2	8	50	4	4	P-UBT0404	.01	.04	.08
4.5	2.25	9	50	6	4	P-UBT0454	.01	.04	.08
5	2.5	10	50	6	4	P-UBT0504	.01	.04	.08
6	3	12	50	6	4	P-UBT0604	.01	.04	.08
7	3.5	14	60	8	4	P-UBT0704	.01	.04	.08
8	4	16	60	8	4	P-UBT0804	.01	.04	.08
8	4	16	75	8	4	P-UBT0814	.01	.04	.08
10	5	20	75	10	4	P-UBT1004	.01	.04	.08
12	6	24	75	12	4	P-UBT1204	.01	.04	.08
14	7	28	100	14	4	P-UBT1404	.01	.04	.08
16	8	32	100	16	4	P-UBT1604	.01	.04	.08
20	10	40	150	20	4	P-UBT2004	.01	.04	.08
25	12.5	50	150	25	4	P-UBT2504	.01	.04	.08

Long Shank - 長柄

Dimension 規格						Purchase Code 採購代碼			
Diameter	Radius	Flute Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	l 刃長	L 全長	D 柄徑	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
6	3	12	75	6	4	P-ULBT0604	.01	.04	.08
8	4	16	100	8	4	P-ULBT0804	.01	.04	.08
10	5	20	100	10	4	P-ULBT1004	.01	.04	.08
12	6	24	100	12	4	P-ULBT1204	.01	.04	.08
16	8	32	150	16	4	P-ULBT1604	.01	.04	.08

R ±0.003 High precision radius accuracy request is available
高精度R值可訂製

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-harden 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					
ALTiBN	◎	◎	◎	◎	○		○				
ZrN-S	◎	◎	◎	○	○			○			
nACRo	◎	◎	◎	◎	○		◎	○	○		

Unit/單位: mm