400+

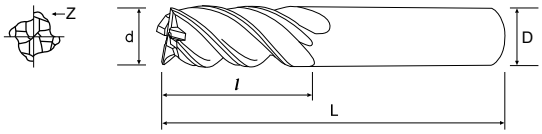
切削條件表 P374-379
Cutting Condition

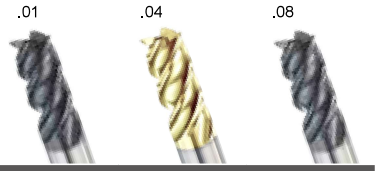
Square Type - 4 flutes

■ 4刃不等立銑刀

Ultra Fine Micro Grain Carbide

WC=87 Co=12 HRA=92.1 Rupture=3800N/mm^2 Grain Size=0.4μm





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	ALTiBN	ZrN-S	nACRo
3	7	50	6	4	PVE0304	.01	.04	.08
4	9	50	6	4	PVE0404	.01	.04	.08
5	11	50	6	4	PVE0504	.01	.04	.08
6	13	50	6	4	PVE0604	.01	.04	.08
8	17	60	8	4	PVE0804	.01	.04	.08
10	22	75	10	4	PVE1004	.01	.04	.08
12	26	75	12	4	PVE1204	.01	.04	.08
14	31	100	16	4	PVE1404	.01	.04	.08
16	35	100	16	4	PVE1604	.01	.04	.08
20	40	100	20	4	PVE2004	.01	.04	.08
25	50	120	25	4	PVE2504	.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-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

400+

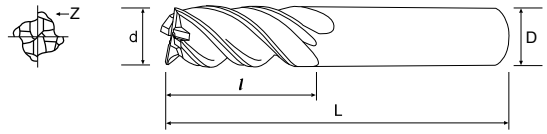
切削條件表 P374-379
Cutting Condition

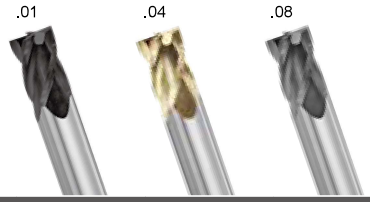
Square Type - Short / Medium / Long Flute

■ 4刃不等立銑刀 – 1倍 / 1.5倍 / 3倍長刃

Ultra Fine Micro Grain Carbide

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





Short Flute (1D) - 1 倍長刃

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	ALTIBN	ZrN-S	nACRo
6	6	50	6	4	PVES0604	.01	.04	.08
8	8	60	8	4	PVES0804	.01	.04	.08
10	10	75	10	4	PVES1004	.01	.04	.08
12	12	75	12	4	PVES1204	.01	.04	.08
16	16	100	16	4	PVES1604	.01	.04	.08
20	20	100	20	4	PVES2004	.01	.04	.08

Medium Flute (1.5D) - 1.5 倍長刃

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	ALTIBN	ZrN-S	nACRo
6	9	50	6	4	PVEM0604	.01	.04	.08
8	12	60	8	4	PVEM0804	.01	.04	.08
10	15	75	10	4	PVEM1004	.01	.04	.08
12	18	75	12	4	PVEM1204	.01	.04	.08
16	24	100	16	4	PVEM1604	.01	.04	.08
20	30	100	20	4	PVEM2004	.01	.04	.08

Long Flute (3D) - 3 倍長刃

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	ALTIBN	ZrN-S	nACRo
6	20	75	6	4	PVEL0604	.01	.04	.08
8	25	75	8	4	PVEL0804	.01	.04	.08
10	30	100	10	4	PVEL1004	.01	.04	.08
12	35	100	12	4	PVEL1204	.01	.04	.08
16	45	120	16	4	PVEL1604	.01	.04	.08
20	50	120	20	4	PVEL2004	.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-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