切削條件表 P468
Cutting Condition

Carbide Edge Reamer

■ 刃部鎢鋼頭鉸刀

● Micro Grain Carbide

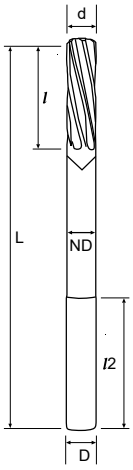
● WC=90 Co=10 HV30=1571 Rupture=3750N/mm^2 Grain Size=0.6μm



MODE	Diameter	Flute Length	Neck Diameter	Shank Length	Full Length	Shank Diameter	Flutes
型號	直徑d	l 刃長	ND頸部直徑	l2 柄長	L全長	D 柄徑	Z 刃數
REC085	8.5	33	7.0	42	117	8	6
REC090	9.0	36	8.0	42	125	10	6
REC095	9.5	36	8.0	42	125	10	6
REC100	10.0	38	9.0	42	135	10	6
REC105	10.5	38	9.0	45	133	10	6
REC110	11.0	41	9.0	50	142	10	6
REC115	11.5	41	9.0	50	142	10	6
REC120	12.0	44	9.0	50	151	12	6
REC125	12.5	44	9.0	50	151	12	6
REC130	13.0	44	11.0	50	151	12	6
REC135	13.5	47	11.0	58	160	12	8
REC140	14.0	47	11.0	58	160	12	8
REC145	14.5	50	11.0	58	162	12	8
REC150	15.0	50	11.0	58	162	12	8
REC155	15.5	52	11.0	58	170	12	8
REC160	16.0	52	11.0	58	170	12	8

Helix Angle ：Tolerance for outer diameter Application：Mold steel and nonmetal material
Main character：Specialized in ream process of mold, could reach prefect tolerance for outer diameter, the helix angle more larger, the surface more smooth.





螺 旋 角：7° ~ 12°　　公　差：H7
適用材質：模具鋼鐵材料及非鐵金屬材質切削用。特別在製造模具時鉸孔作業，可達到非常好的孔徑公差，螺旋角越大，孔的加工面越光滑。

Application 適用材質：

★ Perfect 最推薦　◎ Excellent 適合　○ Good 佳

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	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC			
○	○	○	○	○	○	○	○	○

Unit/單位: mm