

400⁺ 切削條件表 **P373**
Cutting Condition

Corner Radius Type- Long Neck - 4 flutes

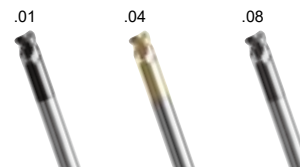
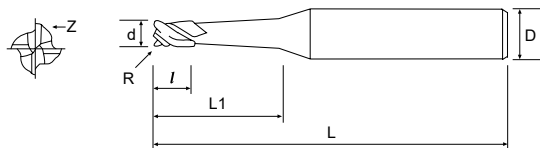
■ 4刃長頸圓鼻立銑刀

400
PLUSHRC
▶ 60A
B
A≠B

R

R

● 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	Efficient Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	Z 刃長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	ALTIBN	ZrN-S	nACRo
6	0.3	7	16	75	6	4	P-UCR06034	.01	.04	.08
6	0.5	7	16	75	6	4	P-UCR06054	.01	.04	.08
6	1	7	16	75	6	4	P-UCR06104	.01	.04	.08
8	0.3	9	20	100	8	4	P-UCR08034	.01	.04	.08
8	0.5	9	20	100	8	4	P-UCR08054	.01	.04	.08
8	1	9	20	100	8	4	P-UCR08104	.01	.04	.08
10	0.5	10	25	100	10	4	P-UCR10054	.01	.04	.08
10	1	10	25	100	10	4	P-UCR10104	.01	.04	.08
10	1.5	10	25	100	10	4	P-UCR10154	.01	.04	.08
10	2	10	25	100	10	4	P-UCR10204	.01	.04	.08
12	0.5	12	30	100	12	4	P-UCR12054	.01	.04	.08
12	1	12	30	100	12	4	P-UCR12104	.01	.04	.08
12	1.5	12	30	100	12	4	P-UCR12154	.01	.04	.08
12	2	12	30	100	12	4	P-UCR12204	.01	.04	.08

HRC
▶ 40HRC
▶ 45HRC
▶ 50HRC
▶ 55HRC
▶ 60HRC
▶ 65

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 ~45HRC	High-hardened 高硬度鋼 ~50HRC ~55HRC ~60HRC ~65HRC					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
ALTIBN	◎	◎	◎	◎	○			○				
ZrN-S	◎	◎	◎	○	○				○			
nACRo	◎	◎	◎	◎	○			◎	○	○		

Unit/單位: mm