

**400<sup>+</sup>** 切削條件表 P374-379  
Cutting Condition

Square Type - 4 flutes

# 4刃不等立銑刀

400  
PLUS

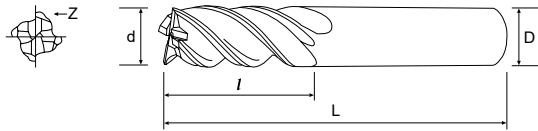
HRC  
55

A  
B  
A≠B

1/2

Ultra Fine Micro Grain Carbide

WC=87 Co=12 HRA=92.1 Rupture=3800N/mm<sup>2</sup> 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  
140

HRC  
150

HRC  
160

HRC  
170

HRC  
180

| 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-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