

**200<sup>+</sup>** 切削條件表 **P393**  
Cutting Condition

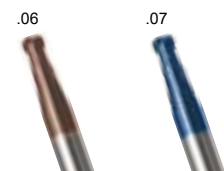
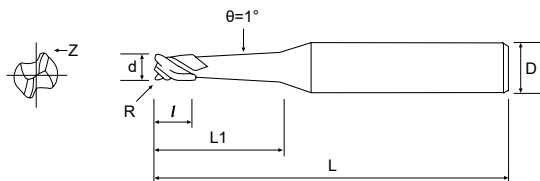
## Pencil Neck Type - Corner Radius - 2 flutes

## ■ 2刃斜頸圓鼻立銑刀

200  
PLUSHRC  
65

- Super Ultra Fine Micro Grain Carbide

- WC=91 Co=9 HRA=93.2 Rupture=4000N/mm<sup>2</sup> Grain Size=0.2μm



| Dimension 規格 |               |              |                  |             |                |        | Purchase Code 採購代碼 |            |        |
|--------------|---------------|--------------|------------------|-------------|----------------|--------|--------------------|------------|--------|
| Diameter     | Corner Radius | Flute Length | Efficient Length | Full Length | Shank Diameter | Flutes | MODE               | Coating 塗層 |        |
| d 刃徑         | R 角           | 刃長           | L1 有效長           | L 全長        | D 柄徑           | Z 刃數   | 型號                 | TISIN+     | P-nACO |
| 1            | 0.2           | 1            | 3                | 50          | 4              | 2      | P-SFUCRS010022     | .06        | .07    |
| 1.5          | 0.2           | 1.5          | 4.5              | 50          | 4              | 2      | P-SFUCRS015022     | .06        | .07    |
| 1.5          | 0.3           | 1.5          | 4.5              | 50          | 4              | 2      | P-SFUCRS015032     | .06        | .07    |
| 2            | 0.2           | 2            | 6                | 50          | 4              | 2      | P-SFUCRS020022     | .06        | .07    |
| 2            | 0.3           | 2            | 6                | 50          | 4              | 2      | P-SFUCRS020032     | .06        | .07    |
| 2            | 0.5           | 2            | 6                | 50          | 4              | 2      | P-SFUCRS020052     | .06        | .07    |
| 3            | 0.2           | 3            | 9                | 50          | 6              | 2      | P-SFUCRS030022     | .06        | .07    |
| 3            | 0.3           | 3            | 9                | 50          | 6              | 2      | P-SFUCRS030032     | .06        | .07    |
| 3            | 0.5           | 3            | 9                | 50          | 6              | 2      | P-SFUCRS030052     | .06        | .07    |
| 3            | 1             | 3            | 9                | 50          | 6              | 2      | P-SFUCRS030102     | .06        | .07    |
| 4            | 0.2           | 4            | 12               | 50          | 6              | 2      | P-SFUCRS040022     | .06        | .07    |
| 4            | 0.3           | 4            | 12               | 50          | 6              | 2      | P-SFUCRS040032     | .06        | .07    |
| 4            | 0.5           | 4            | 12               | 50          | 6              | 2      | P-SFUCRS040052     | .06        | .07    |
| 4            | 1             | 4            | 12               | 50          | 6              | 2      | P-SFUCRS040102     | .06        | .07    |
| 5            | 0.3           | 5            | 15               | 50          | 6              | 2      | P-SFUCRS050032     | .06        | .07    |
| 5            | 0.5           | 5            | 15               | 50          | 6              | 2      | P-SFUCRS050052     | .06        | .07    |
| 5            | 1             | 5            | 15               | 50          | 6              | 2      | P-SFUCRS050102     | .06        | .07    |
| 6            | 0.2           | 6            | 18               | 50          | 6              | 2      | P-SFUCRS060022     | .06        | .07    |

Application 適用材質：

★ Perfect 最推薦

◎ Excellent 適合

○ Good 佳

| Coating<br>塗層 | Carbon steel,<br>Alloy steel<br>炭素鋼, 合金鋼 | Pre-hardened steel<br>預硬鋼 | High-hardened 高硬度鋼 |        |        |        | Stainless steel<br>不鏽鋼 | Titanium alloy<br>鈦合金 | Nickel/Inconel<br>alloy<br>鎳基合金 | Copper alloy<br>銅合金, 銅 | Aluminum alloy<br>鋁合金 |
|---------------|------------------------------------------|---------------------------|--------------------|--------|--------|--------|------------------------|-----------------------|---------------------------------|------------------------|-----------------------|
|               |                                          | ~45HRC                    | ~50HRC             | ~55HRC | ~60HRC | ~65HRC |                        |                       |                                 |                        |                       |
| TiSiN+        | ○                                        | ○                         | ○                  | ◎      | ◎      | ◎      |                        |                       |                                 |                        |                       |
| P-nAlCo       | ○                                        | ○                         | ○                  | ◎      | ◎      | ★      |                        |                       |                                 |                        |                       |

Unit/單位: mm

**200<sup>+</sup>** 切削條件表 **P393**  
Cutting Condition

## Pencil Neck Type – Corner Radius - 2 flutes

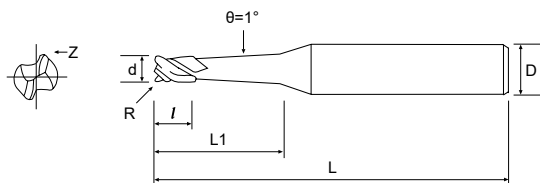
## ■ 2刃斜頸圓鼻立銑刀

200  
PLUSHRC  
65

R

A  
B  
A≠BL1 L2 L3 L4  
L1≠L2≠L3≠L4

● Super Ultra Fine Micro Grain Carbide

● WC=91 Co=9 HRA=93.2 Rupture=4000N/mm<sup>2</sup> Grain Size=0.2μm

.06

.07

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

Dimension 規格

Purchase Code 採購代碼

| Diameter | Corner Radius | Flute Length | Efficient Length | Full Length | Shank Diameter | Flutes | MODE           | Coating 塗層 |        |
|----------|---------------|--------------|------------------|-------------|----------------|--------|----------------|------------|--------|
| d 刃徑     | R 角           | 刀長           | L1 有效長           | L 全長        | D 柄徑           | Z 刃數   | 型號             | TiSiN+     | P-nACO |
| 6        | 0.3           | 6            | 18               | 50          | 6              | 2      | P-SFUCRS060032 | .06        | .07    |
| 6        | 0.5           | 6            | 18               | 50          | 6              | 2      | P-SFUCRS060052 | .06        | .07    |
| 6        | 1             | 6            | 18               | 50          | 6              | 2      | P-SFUCRS060102 | .06        | .07    |
| 6        | 2             | 6            | 18               | 50          | 6              | 2      | P-SFUCRS060202 | .06        | .07    |
| 8        | 0.3           | 8            | 20               | 60          | 8              | 2      | P-SFUCRS080032 | .06        | .07    |
| 8        | 0.5           | 8            | 20               | 60          | 8              | 2      | P-SFUCRS080052 | .06        | .07    |
| 8        | 1             | 8            | 20               | 60          | 8              | 2      | P-SFUCRS080102 | .06        | .07    |
| 8        | 2             | 8            | 20               | 60          | 8              | 2      | P-SFUCRS080202 | .06        | .07    |
| 10       | 0.5           | 10           | 25               | 75          | 10             | 2      | P-SFUCRS100052 | .06        | .07    |
| 10       | 1             | 10           | 25               | 75          | 10             | 2      | P-SFUCRS100102 | .06        | .07    |
| 10       | 1.5           | 10           | 25               | 75          | 10             | 2      | P-SFUCRS100152 | .06        | .07    |
| 10       | 2             | 10           | 25               | 75          | 10             | 2      | P-SFUCRS100202 | .06        | .07    |
| 10       | 3             | 10           | 25               | 75          | 10             | 2      | P-SFUCRS100302 | .06        | .07    |
| 12       | 0.5           | 12           | 30               | 75          | 12             | 2      | P-SFUCRS120052 | .06        | .07    |
| 12       | 1             | 12           | 30               | 75          | 12             | 2      | P-SFUCRS120102 | .06        | .07    |
| 12       | 1.5           | 12           | 30               | 75          | 12             | 2      | P-SFUCRS120152 | .06        | .07    |
| 12       | 2             | 12           | 30               | 75          | 12             | 2      | P-SFUCRS120202 | .06        | .07    |
| 12       | 3             | 12           | 30               | 75          | 12             | 2      | P-SFUCRS120302 | .06        | .07    |

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| Coating<br>塗層 | Carbon steel,<br>Alloy steel<br>炭素鋼, 合金鋼 | Pre-harden steel<br>預硬鋼 | High-hardened 高硬度鋼 |        |        |        | Stainless steel<br>不鏽鋼 | Titanium alloy<br>鈦合金 | Nickel/Inconel<br>alloy<br>鎳基合金 | Copper alloy<br>銅合金, 銅 | Aluminum alloy<br>鋁合金 |
|---------------|------------------------------------------|-------------------------|--------------------|--------|--------|--------|------------------------|-----------------------|---------------------------------|------------------------|-----------------------|
|               |                                          | ~45HRC                  | ~50HRC             | ~55HRC | ~60HRC | ~65HRC |                        |                       |                                 |                        |                       |
| TiSiN+        | ○                                        | ○                       | ○                  | ◎      | ◎      | ◎      |                        |                       |                                 |                        |                       |
| P-nACo        | ○                                        | ○                       | ○                  | ◎      | ◎      | ★      |                        |                       |                                 |                        |                       |

Unit/單位: mm