

400⁺ 切削條件表 **P358**
Cutting Condition

Square Type - Long Flute - 2 flutes

■ 2刃長刃立銑刀

400 PLUS

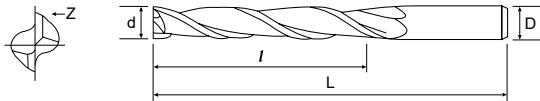
HRC 60

A B A+B

1/2

● 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	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	ALTBN	ZrN-S	nACRo
1	5	50	4	2	P-ULET0102	.01	.04	.08
1.5	6	50	4	2	P-ULET0152	.01	.04	.08
2	8	50	6	2	P-ULET0202	.01	.04	.08
2.5	10	50	6	2	P-ULET0252	.01	.04	.08
3	12	60	6	2	P-ULET0302	.01	.04	.08
3.5	14	60	6	2	P-ULET0352	.01	.04	.08
4	16	60	6	2	P-ULET0402	.01	.04	.08
4.5	16	60	6	2	P-ULET0452	.01	.04	.08
5	20	60	6	2	P-ULET0502	.01	.04	.08
5.5	20	60	6	2	P-ULET0552	.01	.04	.08
6	25	75	6	2	P-ULET0602	.01	.04	.08
7	26	75	8	2	P-ULET0702	.01	.04	.08
8	26	75	8	2	P-ULET0802	.01	.04	.08
8	36	100	8	2	P-ULET0812	.01	.04	.08
10	40	100	10	2	P-ULET1002	.01	.04	.08
11	40	100	12	2	P-ULET1102	.01	.04	.08
12	46	100	12	2	P-ULET1202	.01	.04	.08
14	46	100	14	2	P-ULET1402	.01	.04	.08
15	46	100	16	2	P-ULET1502	.01	.04	.08
16	46	100	16	2	P-ULET1602	.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
ALTBN	◎	◎	◎	◎	○		○				
ZrN-S	◎	◎	◎	○	○			○			
nACRo	◎	◎	◎	◎	○		◎	○	○		

Unit/單位: mm