

600⁺ 切削條件表 **P345**
Cutting Condition

Roughing Type - 4 flutes

■ 4粗銑立銑刀

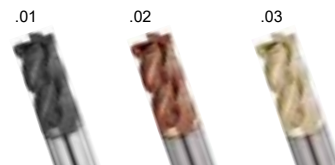
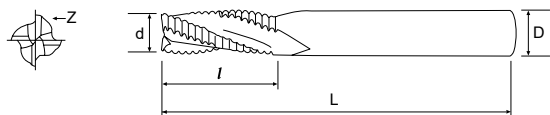
600 PLUS

HRC ▶ 45

25°

a
b > a

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm

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	TISIN	ZrN-A
4	8	50	6	4	P-XTA0404	.01	.02	.03
5	13	50	6	4	P-XTA0504	.01	.02	.03
6	16	50	6	4	P-XTA0604	.01	.02	.03
7	16	60	8	4	P-XTA0704	.01	.02	.03
8	19	60	8	4	P-XTA0804	.01	.02	.03
9	25	75	10	4	P-XTA0904	.01	.02	.03
10	25	75	10	4	P-XTA1004	.01	.02	.03
11	30	75	12	4	P-XTA1104	.01	.02	.03
12	30	75	12	4	P-XTA1204	.01	.02	.03
16	35	100	16	4	P-XTA1604	.01	.02	.03
20	45	100	20	4	P-XTA2004	.01	.02	.03

HRC ▶ 40

HRC ▶ 45

HRC ▶ 50

HRC ▶ 55

HRC ▶ 60

HRC ▶ 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	◎	◎	○					○				
TISIN	○	◎	○	○								
ZrN-A	◎	◎	○					○				

Unit/單位: mm

600⁺ 切削條件表 **P346**
Cutting Condition

Taper Square Type - 2 flutes

■ 2刃斜度立銑刀

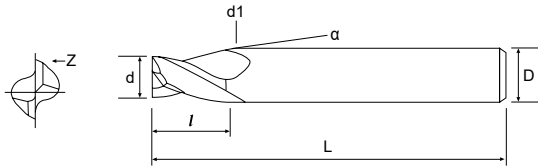
600 PLUS

HRC 55

35°

a/b
b>a

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm

Dimension 規格							Purchase Code 採購代碼			
Diameter	Flute Length	Full Length	Shank Diameter	α	d1	Flutes	MODE	Coating 塗層		
d 刃徑	l 刃長	L 全長	D 柄徑		大徑	Z 刃數	型號	ALTBN	TISIN	ZrN-A
0.5	2	50	4	30°	0.53	2	P-TTA005005	.01	.02	.03
0.5	2	50	4	1°	0.57	2	P-TTA005010	.01	.02	.03
0.5	2	50	4	1°30'	0.6	2	P-TTA005015	.01	.02	.03
0.5	2	50	4	2°	0.64	2	P-TTA005020	.01	.02	.03
0.5	2	50	4	2°30'	0.67	2	P-TTA005025	.01	.02	.03
0.5	2	50	4	3°	0.71	2	P-TTA005030	.01	.02	.03
0.5	2	50	4	5°	0.85	2	P-TTA005050	.01	.02	.03
0.5	2	50	4	7°	0.99	2	P-TTA005070	.01	.02	.03
0.5	2	50	4	10°	1.21	2	P-TTA005100	.01	.02	.03
1	4	50	4	30°	1.07	2	P-TTA010005	.01	.02	.03
1	4	50	4	1°	1.14	2	P-TTA010010	.01	.02	.03
1	4	50	4	1°30'	1.21	2	P-TTA010015	.01	.02	.03
1	4	50	4	2°	1.28	2	P-TTA010020	.01	.02	.03
1	4	50	4	2°30'	1.35	2	P-TTA010025	.01	.02	.03
1	4	50	4	3°	1.42	2	P-TTA010030	.01	.02	.03
1	4	50	4	5°	1.7	2	P-TTA010050	.01	.02	.03
1	4	50	4	7°	1.98	2	P-TTA010070	.01	.02	.03
1	4	50	4	10°	2.41	2	P-TTA010100	.01	.02	.03
1.5	5	50	4	30°	1.59	2	P-TTA015005	.01	.02	.03
1.5	5	50	4	1°	1.67	2	P-TTA015010	.01	.02	.03
1.5	5	50	4	1°30'	1.76	2	P-TTA015015	.01	.02	.03
1.5	5	50	4	2°	1.85	2	P-TTA015020	.01	.02	.03

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	High-hardened 高硬度鋼					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
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
ALTBN	○	◎	○	○			○					
TISIN	○	◎	◎	○								
ZrN-A	○	◎	○	○			○	○				

Unit/單位: mm

600⁺ 切削條件表 **P346**
Cutting Condition

Taper Square Type - 2 flutes

■ 2刃斜度立銑刀

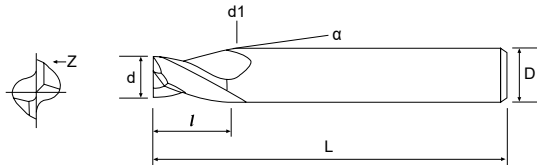
600 PLUS

HRC 55

35°

a/b
b>a

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm

Dimension 規格							Purchase Code 採購代碼			
Diameter	Flute Length	Full Length	Shank Diameter	α	d1	Flutes	MODE	Coating 塗層		
d 刃徑	刀長	L 全長	D 柄徑		大徑	Z 刃數	型號	ALTBN	TISIN	ZrN-A
1.5	5	50	4	2°30"	1.93	2	P-TTA015025	.01	.02	.03
1.5	5	50	4	3°	2.02	2	P-TTA015030	.01	.02	.03
1.5	5	50	4	5°	2.37	2	P-TTA015050	.01	.02	.03
1.5	5	50	4	7°	2.73	2	P-TTA015070	.01	.02	.03
1.5	5	50	4	10°	3.26	2	P-TTA015100	.01	.02	.03
2	6	50	4	30"	2.1	2	P-TTA020005	.01	.02	.03
2	6	50	4	1°	2.21	2	P-TTA020010	.01	.02	.03
2	6	50	4	1°30"	2.31	2	P-TTA020015	.01	.02	.03
2	6	50	4	2°	2.41	2	P-TTA020020	.01	.02	.03
2	6	50	4	2°30"	2.52	2	P-TTA020025	.01	.02	.03
2	6	50	4	3°	2.62	2	P-TTA020030	.01	.02	.03
2	6	50	4	5°	3.05	2	P-TTA020050	.01	.02	.03
2	6	50	4	7°	3.47	2	P-TTA020070	.01	.02	.03
2	6	50	4	10°	4.11	2	P-TTA020100	.01	.02	.03
2.5	8	50	4	30"	2.64	2	P-TTA025005	.01	.02	.03
2.5	8	50	4	1°	2.78	2	P-TTA025010	.01	.02	.03
2.5	8	50	4	1°30"	2.91	2	P-TTA025015	.01	.02	.03
2.5	8	50	4	2°	3.05	2	P-TTA025020	.01	.02	.03
2.5	8	50	4	2°30"	3.2	2	P-TTA025025	.01	.02	.03
2.5	8	50	4	3°	3.33	2	P-TTA025030	.01	.02	.03
2.5	8	50	4	5°	3.9	2	P-TTA025050	.01	.02	.03
2.5	8	50	6	7°	4.46	2	P-TTA025070	.01	.02	.03

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	High-hardened 高硬度鋼					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
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
ALTBN	○	◎	○	○			○					
TISIN	○	◎	◎	○								
ZrN-A	○	◎	○	○			○	○				

Unit/單位: mm

600⁺ 切削條件表 **P346**
Cutting Condition

Taper Square Type - 2 flutes

■ 2刃斜度立銑刀

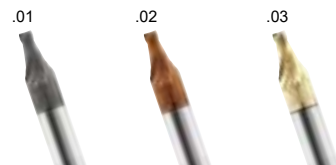
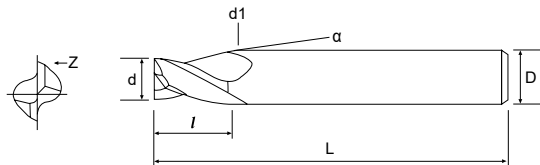
600 PLUS

HRC 55

35°

a/b
b>a

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm

HRC 40

HRC 45

HRC 50

HRC 55

HRC 60

HRC 65

Dimension 規格

Purchase Code 採購代碼

Diameter	Flute Length	Full Length	Shank Diameter		d1	Flutes	MODE	Coating 塗層		
d 刃徑	L 刃長	L 全長	D 柄徑	α	大徑	Z 刃數	型號	ALTBN	TISIN	ZrN-A
2.5	8	50	6	10°	5.32	2	P-TTA025100	.01	.02	.03
3	10	50	6	30°	3.17	2	P-TTA030005	.01	.02	.03
3	10	50	6	1°	3.35	2	P-TTA030010	.01	.02	.03
3	10	50	6	1°30'	3.52	2	P-TTA030015	.01	.02	.03
3	10	50	6	2°	3.69	2	P-TTA030020	.01	.02	.03
3	10	50	6	2°30'	3.87	2	P-TTA030025	.01	.02	.03
3	10	50	6	3°	4.05	2	P-TTA030030	.01	.02	.03
3	10	50	6	5°	4.75	2	P-TTA030050	.01	.02	.03
3	10	50	6	7°	5.46	2	P-TTA030070	.01	.02	.03
3	10	50	6	10°	6	2	P-TTA030100	.01	.02	.03
4	15	50	6	30°	4.26	2	P-TTA040005	.01	.02	.03
4	15	50	6	1°	4.52	2	P-TTA040010	.01	.02	.03
4	15	50	6	1°30'	4.79	2	P-TTA040015	.01	.02	.03
4	15	50	6	2°	5.04	2	P-TTA040020	.01	.02	.03
4	15	50	6	2°30'	5.31	2	P-TTA040025	.01	.02	.03
4	15	50	6	3°	5.57	2	P-TTA040030	.01	.02	.03
4	15	60	8	5°	6.62	2	P-TTA040050	.01	.02	.03
4	15	60	8	7°	7.68	2	P-TTA040070	.01	.02	.03
5	20	60	6	30°	5.34	2	P-TTA050005	.01	.02	.03
5	20	60	6	1°	5.7	2	P-TTA050010	.01	.02	.03
5	20	60	6	1°30'	6	2	P-TTA050015	.01	.02	.03
5	20	60	8	2°	6.39	2	P-TTA050020	.01	.02	.03
5	20	60	8	2°30'	6.74	2	P-TTA050025	.01	.02	.03

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	High-hardened 高硬度鋼					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
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
ALTBN	○	◎	○	○			○					
TISIN	○	◎	◎	○								
ZrN-A	○	◎	○	○			○	○				

Unit/單位: mm

600⁺ 切削條件表 **P346**
Cutting Condition

Taper Square Type - 2 flutes

■ 2刃斜度立銑刀

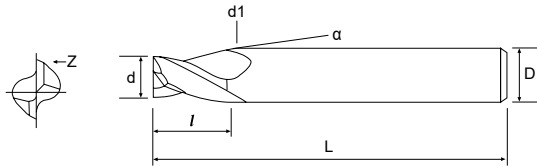
600 PLUS

HRC 55

35°

a/b
b>a

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm

Dimension 規格							Purchase Code 採購代碼			
Diameter	Flute Length	Full Length	Shank Diameter	α	d1	Flutes	MODE	Coating 塗層		
d 刃徑	刀長	L 全長	D 柄徑		大徑	Z 刃數	型號	ALTiBN	TiSiN	ZrN-A
5	20	60	8	3°	7.1	2	P-TTA050030	.01	.02	.03
5	20	75	10	5°	8.5	2	P-TTA050050	.01	.02	.03
5	20	75	10	7°	9.91	2	P-TTA050070	.01	.02	.03
6	20	60	8	30"	6.35	2	P-TTA060005	.01	.02	.03
6	20	60	8	1°	6.7	2	P-TTA060010	.01	.02	.03
6	20	60	8	1°30"	7.05	2	P-TTA060015	.01	.02	.03
6	20	60	8	2°	7.4	2	P-TTA060020	.01	.02	.03
6	20	60	8	2°30"	7.75	2	P-TTA060025	.01	.02	.03
6	19	60	8	3°	7.99	2	P-TTA060030	.01	.02	.03
6	20	75	10	5°	9.5	2	P-TTA060050	.01	.02	.03
8	25	75	10	30"	8.44	2	P-TTA080005	.01	.02	.03
8	25	75	10	1°	8.87	2	P-TTA080010	.01	.02	.03
8	25	75	10	1°30"	9.31	2	P-TTA080015	.01	.02	.03
8	25	75	10	2°	9.74	2	P-TTA080020	.01	.02	.03
8	25	75	12	2°30"	10.18	2	P-TTA080025	.01	.02	.03
8	25	75	12	3°	10.62	2	P-TTA080030	.01	.02	.03
8	22	100	12	5°	11.8	2	P-TTA080050	.01	.02	.03
10	35	100	12	30"	10.61	2	P-TTA100005	.01	.02	.03
10	35	100	12	1°	11.22	2	P-TTA100010	.01	.02	.03
10	35	100	12	1°30"	11.83	2	P-TTA100015	.01	.02	.03
10	35	100	12	2°	11.96	2	P-TTA100020	.01	.02	.03
10	35	100	16	2°30"	13.06	2	P-TTA100025	.01	.02	.03
10	35	100	16	3°	13.67	2	P-TTA100030	.01	.02	.03
10	35	100	16	5°	16.12	2	P-TTA100050	.01	.02	.03

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	High-hardened 高硬度鋼					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
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
ALTiBN	○	◎	○	○			○					
TiSiN	○	◎	◎	○								
ZrN-A	○	◎	○	○			○	○				

Unit/單位: mm