

400⁺ 切削條件表 **P365**
Cutting Condition

Ball Nose Type - Long Shank - 2 flutes

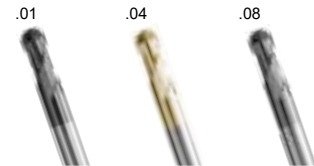
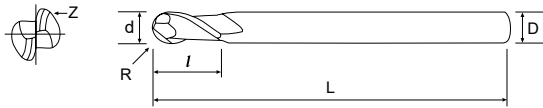
■ 2刃長柄球型立銑刀

400 PLUS

HRC 60

A
B
A≠B

● 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	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	Z 刃長	L 全長	D 柄徑	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
1	0.5	2	75	6	2	P-ULBTS0102	.01	.04	.08
1.5	0.75	3	75	6	2	P-ULBTS0152	.01	.04	.08
2	1	4	75	6	2	P-ULBTS0202	.01	.04	.08
2.5	1.25	5	75	6	2	P-ULBTS0252	.01	.04	.08
3	1.5	6	75	6	2	P-ULBTS0302	.01	.04	.08
3.5	1.75	7	75	6	2	P-ULBTS0352	.01	.04	.08
4	2	8	75	6	2	P-ULBTS0402	.01	.04	.08
4.5	2.25	9	75	6	2	P-ULBTS0452	.01	.04	.08
5	2.5	10	75	6	2	P-ULBTS0502	.01	.04	.08
5.5	2.75	11	75	6	2	P-ULBTS0552	.01	.04	.08
6	3	12	75	6	2	P-ULBTS0602	.01	.04	.08
7	3.5	14	75	8	2	P-ULBTS0702	.01	.04	.08
8	4	16	100	8	2	P-ULBTS0802	.01	.04	.08
9	4.5	18	100	10	2	P-ULBTS0902	.01	.04	.08
10	5	20	100	10	2	P-ULBTS1002	.01	.04	.08
12	6	24	100	12	2	P-ULBTS1202	.01	.04	.08
14	7	28	100	14	2	P-ULBTS1402	.01	.04	.08
16	8	32	150	16	2	P-ULBTS1602	.01	.04	.08
6	3	12	100	6	2	P-ULBTM0602	.01	.04	.08
8	4	16	150	8	2	P-ULBTM0802	.01	.04	.08
10	5	20	150	10	2	P-ULBTM1002	.01	.04	.08
12	6	24	150	12	2	P-ULBTM1202	.01	.04	.08
16	8	32	200	16	2	P-ULBTM1602	.01	.04	.08
6	3	12	150	6	2	P-ULBTL0602	.01	.04	.08
20	10	40	200	20	2	P-ULBTL2002	.01	.04	.08
25	12.5	45	200	25	2	P-ULBTL2502	.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