

400⁺ 切削條件表 P366-367
Cutting Condition

Ball Nose Type - Long Neck - 2 flutes

2刃深溝長頸球型立銑刀

400
PLUS

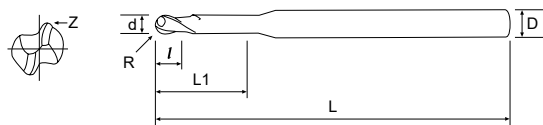
HRC
60

A
B
A+B

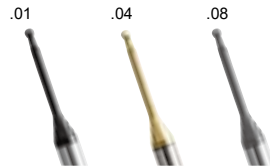
1/2

● Ultra Fine Micro Grain Carbide

● WC=87 Co=12 HRA=92.1 Rupture=3800N/mm² Grain Size=0.4μm



.01 .04 .08



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
135

HRC
140

HRC
145

HRC
150

Dimension 規格

Purchase Code 採購代碼

Diameter	Radius	Flute Length	Efficient Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	刀長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	ALTIBN	ZrN-S	nACRo
0.5	0.25	0.75	2	50	4	2	P-ULNBT05022	.01	.04	.08
0.5	0.25	0.75	4	50	4	2	P-ULNBT05042	.01	.04	.08
0.5	0.25	0.75	6	50	4	2	P-ULNBT05062	.01	.04	.08
0.6	0.3	0.9	2	50	4	2	P-ULNBT06022	.01	.04	.08
0.6	0.3	0.9	4	50	4	2	P-ULNBT06042	.01	.04	.08
0.6	0.3	0.9	6	50	4	2	P-ULNBT06062	.01	.04	.08
0.8	0.4	1.2	4	50	4	2	P-ULNBT08042	.01	.04	.08
0.8	0.4	1.2	6	50	4	2	P-ULNBT08062	.01	.04	.08
0.8	0.4	1.2	8	50	4	2	P-ULNBT08082	.01	.04	.08
1	0.5	1.5	6	50	4	2	P-ULNBT10062	.01	.04	.08
1	0.5	1.5	8	50	4	2	P-ULNBT10082	.01	.04	.08
1	0.5	1.5	10	50	4	2	P-ULNBT10102	.01	.04	.08
1	0.5	1.5	12	50	4	2	P-ULNBT10122	.01	.04	.08
1.5	0.75	2.3	6	50	4	2	P-ULNBT15062	.01	.04	.08
1.5	0.75	2.3	8	50	4	2	P-ULNBT15082	.01	.04	.08
1.5	0.75	2.3	10	50	4	2	P-ULNBT15102	.01	.04	.08
1.5	0.75	2.3	12	50	4	2	P-ULNBT15122	.01	.04	.08
1.5	0.75	2.3	14	50	4	2	P-ULNBT15142	.01	.04	.08
1.5	0.75	2.3	16	50	4	2	P-ULNBT15162	.01	.04	.08
1.5	0.75	2.3	18	50	4	2	P-ULNBT15182	.01	.04	.08
1.5	0.75	2.3	20	50	4	2	P-ULNBT15202	.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

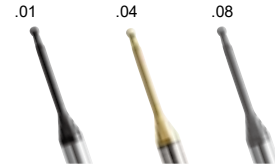
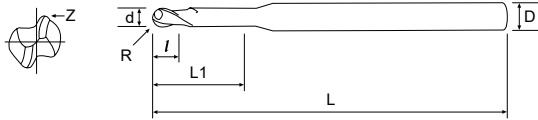
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條件表 **P366-367**
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400
PLUSHRC
▶ 60A
B
A≠B

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Diameter	Radius	Flute Length	Efficient Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	刀長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	ALTIBN	ZrN-S	nACRo
2	1	3	8	50	4	2	P-ULNBT20082	.01	.04	.08
2	1	3	10	50	4	2	P-ULNBT20102	.01	.04	.08
2	1	3	12	50	4	2	P-ULNBT20122	.01	.04	.08
2	1	3	14	50	4	2	P-ULNBT20142	.01	.04	.08
2	1	3	16	50	4	2	P-ULNBT20162	.01	.04	.08
2	1	3	18	50	4	2	P-ULNBT20182	.01	.04	.08
2	1	3	20	50	4	2	P-ULNBT20202	.01	.04	.08
2.5	1.25	4	8	50	4	2	P-ULNBT25082	.01	.04	.08
2.5	1.25	4	12	50	4	2	P-ULNBT25122	.01	.04	.08
2.5	1.25	4	16	50	4	2	P-ULNBT25162	.01	.04	.08
2.5	1.25	4	20	50	4	2	P-ULNBT25202	.01	.04	.08
3	1.5	4.5	10	50	6	2	P-ULNBT30102	.01	.04	.08
3	1.5	4.5	12	50	6	2	P-ULNBT30122	.01	.04	.08
3	1.5	4.5	16	60	6	2	P-ULNBT30162	.01	.04	.08
3	1.5	4.5	20	60	6	2	P-ULNBT30202	.01	.04	.08
3	1.5	4.5	25	75	6	2	P-ULNBT30252	.01	.04	.08
4	2	6	12	50	6	2	P-ULNBT40122	.01	.04	.08
4	2	6	16	60	6	2	P-ULNBT40162	.01	.04	.08
4	2	6	20	75	6	2	P-ULNBT40202	.01	.04	.08
4	2	6	25	75	6	2	P-ULNBT40252	.01	.04	.08
4	2	6	30	75	6	2	P-ULNBT40302	.01	.04	.08

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		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
ALTIBN	◎	◎	◎	◎	○		○					
ZrN-S	◎	◎	◎	○	○				○			
nACRo	◎	◎	◎	◎	○		◎		○	○		

Unit/單位: mm