

400⁺ 切削條件表 P374-379
Cutting Condition

Ball Nose Type - 4 flutes

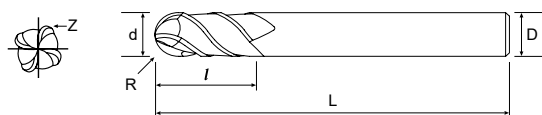
■ 4刃不等球型立銑刀

400 PLUS

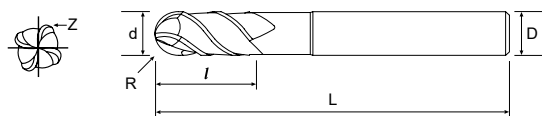
HRC 55

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	l 刃長	L 全長	D 柄徑	Z 刃數	型號	ALTIBN	ZrN-S	nACRo
6	3	6	50	6	4	PVB0604	.01	.04	.08
8	4	8	60	8	4	PVB0804	.01	.04	.08
10	5	10	75	10	4	PVB1004	.01	.04	.08
12	6	12	75	12	4	PVB1204	.01	.04	.08
16	8	16	100	16	4	PVB1604	.01	.04	.08



Long Flute & Neck - 長刃 & 有效

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	l 刃長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	ALTIBN	ZrN-S	nACRo
6	3	9	15	60	6	4	PVBSX0604	.01	.04	.08
8	4	12	20	75	8	4	PVBSX0804	.01	.04	.08
10	5	15	25	80	10	4	PVBSX1004	.01	.04	.08
12	6	18	30	100	12	4	PVBSX1204	.01	.04	.08
16	8	24	40	120	16	4	PVBSX1604	.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