

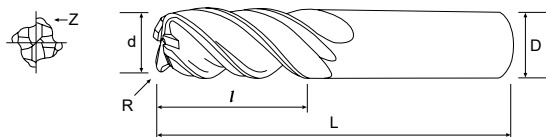
400⁺ 切削條件表 P374-379
Cutting Condition

Corner Radius Type - 4 flutes

■ 4刃不等圓鼻立銑刀

400
PLUSHRC
55

Ultra Fine Micro Grain Carbide

WC=87 Co=12 HRA=92.1 Rupture=3800N/mm² Grain Size=0.4μmHRC
40HRC
45HRC
50HRC
55HRC
60HRC
65

Dimension 規格						Purchase Code 採購代碼			
Diameter	Corner Radius	Flute Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刀徑	R 角	Z 刃長	L 全長	D 柄徑	Z 刃數	型號	ALTIBN	ZrN-S	nACRo
3	0.1	7	50	6	4	PVR0300104	.01	.04	.08
3	0.3	7	50	6	4	PVR0300304	.01	.04	.08
3	0.5	7	50	6	4	PVR0300504	.01	.04	.08
4	0.1	9	50	6	4	PVR0400104	.01	.04	.08
4	0.3	9	50	6	4	PVR0400304	.01	.04	.08
4	0.5	9	50	6	4	PVR0400504	.01	.04	.08
4	1	9	50	6	4	PVR0401004	.01	.04	.08
5	0.5	11	50	6	4	PVR0500504	.01	.04	.08
6	0.1	13	50	6	4	PVR0600104	.01	.04	.08
6	0.3	13	50	6	4	PVR0600304	.01	.04	.08
6	0.5	13	50	6	4	PVR0600504	.01	.04	.08
6	1	13	50	6	4	PVR0601004	.01	.04	.08
8	0.1	17	60	8	4	PVR0800104	.01	.04	.08
8	0.5	17	60	8	4	PVR0800504	.01	.04	.08
8	1	17	60	8	4	PVR0801004	.01	.04	.08
8	2	17	60	8	4	PVR0802004	.01	.04	.08
10	0.1	22	75	10	4	PVR1000104	.01	.04	.08
10	0.5	22	75	10	4	PVR1000504	.01	.04	.08
10	1	22	75	10	4	PVR1001004	.01	.04	.08
10	2	22	75	10	4	PVR1002004	.01	.04	.08
12	0.1	26	75	12	4	PVR1200104	.01	.04	.08
12	0.5	26	75	12	4	PVR1200504	.01	.04	.08
12	1	26	75	12	4	PVR1201004	.01	.04	.08
12	2	26	75	12	4	PVR1202004	.01	.04	.08
16	0.5	35	100	16	4	PVR1600504	.01	.04	.08
16	1	35	100	16	4	PVR1601004	.01	.04	.08
16	2	35	100	16	4	PVR1602004	.01	.04	.08
16	3	35	100	16	4	PVR1603004	.01	.04	.08
20	1	40	100	20	4	PVR2001004	.01	.04	.08
20	1.5	40	100	20	4	PVR2001504	.01	.04	.08
20	2	40	100	20	4	PVR2002004	.01	.04	.08
20	2.5	40	100	20	4	PVR2002504	.01	.04	.08
20	3	40	100	20	4	PVR2003004	.01	.04	.08
25	1	50	120	25	4	PVR2501004	.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