

400⁺ 切削條件表 **P364**
Cutting Condition

Ball Nose Type - 2 flutes

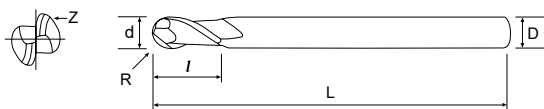
■ 2刃球型立銑刀

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	ALTBN	ZrN-S	nACRo
1	0.5	2	50	4	2	P-UBT0102	.01	.04	.08
1.5	0.75	3	50	4	2	P-UBT0152	.01	.04	.08
2	1	4	50	4	2	P-UBT0202	.01	.04	.08
2.5	1.25	5	50	4	2	P-UBT0252	.01	.04	.08
3	1.5	6	50	4	2	P-UBT0302	.01	.04	.08
3.5	1.75	7	50	4	2	P-UBT0352	.01	.04	.08
4	2	8	50	4	2	P-UBT0402	.01	.04	.08
4.5	2.25	9	50	6	2	P-UBT0452	.01	.04	.08
5	2.5	10	50	6	2	P-UBT0502	.01	.04	.08
5.5	2.75	11	50	6	2	P-UBT0552	.01	.04	.08
6	3	12	50	6	2	P-UBT0602	.01	.04	.08
7	3.5	14	60	8	2	P-UBT0702	.01	.04	.08
8	4	16	60	8	2	P-UBT0802	.01	.04	.08
8	4	16	75	8	2	P-UBT0812	.01	.04	.08
9	4.5	18	75	10	2	P-UBT0902	.01	.04	.08
10	5	20	75	10	2	P-UBT1002	.01	.04	.08
12	6	24	75	12	2	P-UBT1202	.01	.04	.08
14	7	28	75	14	2	P-UBT1402	.01	.04	.08
16	8	32	100	16	2	P-UBT1602	.01	.04	.08
20	10	40	150	20	2	P-UBT2002	.01	.04	.08
25	12.5	45	150	25	2	P-UBT2502	.01	.04	.08

R High precision radius accuracy request is available
±0.003 高精度R值可訂製

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	◎	◎	◎	◎	○			○				
ZrN-S	◎	◎	◎	○	○				○			
nACRo	◎	◎	◎	◎	○			◎	○	○		

Unit/單位: mm