

600⁺ 切削條件表 **P334**
Cutting Condition

Square Type - 4 flutes

■ 4刃立銑刀

600 PLUS

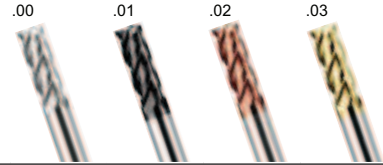
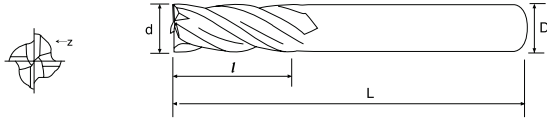
HRC > 45

35°

a/b > a

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



Dimension 規格					Purchase Code 採購代碼				
Diameter	Flute Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層			
d 刃徑	l 刃長	L 全長	D 柄徑	Z 刃數	型號		ALTiBN	TiSiN	ZrN-A
1	3	50	3	4	P-SSE0104	.00	.01	.02	.03
1	3	50	4	4	P-MSE0104	.00	.01	.02	.03
1.5	4	50	3	4	P-SSE0154	.00	.01	.02	.03
1.5	4	50	4	4	P-MSE0154	.00	.01	.02	.03
2	6	50	3	4	P-SSE0204	.00	.01	.02	.03
2	6	50	4	4	P-MSE0204	.00	.01	.02	.03
2.5	8	50	3	4	P-SSE0254	.00	.01	.02	.03
2.5	8	50	4	4	P-MSE0254	.00	.01	.02	.03
3	8	50	3	4	P-SSE0304	.00	.01	.02	.03
3	8	50	4	4	P-MSE0304	.00	.01	.02	.03
3.5	10	50	4	4	P-MSE0354	.00	.01	.02	.03
4	11	50	4	4	P-MSE0404	.00	.01	.02	.03
1	3	50	6	4	P-SE0104	.00	.01	.02	.03
1.5	4	50	6	4	P-SE0154	.00	.01	.02	.03
2	6	50	6	4	P-SE0204	.00	.01	.02	.03
2.5	8	50	6	4	P-SE0254	.00	.01	.02	.03
3	8	50	6	4	P-SE0304	.00	.01	.02	.03
3.5	10	50	6	4	P-SE0354	.00	.01	.02	.03
4	11	50	6	4	P-SE0404	.00	.01	.02	.03
4.5	13	50	6	4	P-SE0454	.00	.01	.02	.03
5	13	50	6	4	P-SE0504	.00	.01	.02	.03

HRC > 40

HRC > 45

HRC > 50

HRC > 55

HRC > 60

HRC > 65

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-harden 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						
	○	○									○	○
ALTiBN	◎	◎	◎	○			○					
TiSiN	○	○	○	◎								
ZrN-A	◎	◎	◎	○			◎	○	○			

Unit/單位: mm

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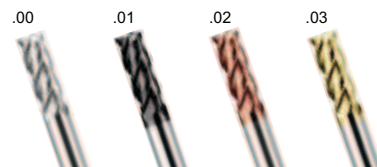
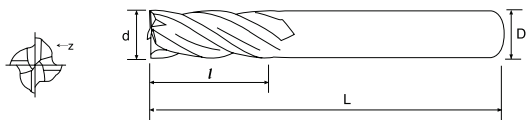
HRC > 45

35°

$a_1 > a_2$
 $b > a$

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



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

Dimension 規格					Purchase Code 採購代碼				
Diameter	Flute Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層			
d 刃徑	l 刃長	L 全長	D 柄徑	Z 刃數	型號		ALTiBN	TiSiN	ZrN-A
5.5	13	50	6	4	P-SE0554	.00	.01	.02	.03
6	16	50	6	4	P-SE0604	.00	.01	.02	.03
6.5	16	60	8	4	P-SE0654	.00	.01	.02	.03
7	16	60	8	4	P-SE0704	.00	.01	.02	.03
7.5	19	60	8	4	P-SE0754	.00	.01	.02	.03
8	20	60	8	4	P-SE0804	.00	.01	.02	.03
8.5	20	75	10	4	P-SE0854	.00	.01	.02	.03
9	20	75	10	4	P-SE0904	.00	.01	.02	.03
9.5	25	75	10	4	P-SE0954	.00	.01	.02	.03
10	30	75	10	4	P-SE1004	.00	.01	.02	.03
10.5	30	75	12	4	P-SE1054	.00	.01	.02	.03
11	30	75	12	4	P-SE1104	.00	.01	.02	.03
11.5	30	75	12	4	P-SE1154	.00	.01	.02	.03
12	32	75	12	4	P-SE1204	.00	.01	.02	.03
14	40	100	16	4	P-SE1404	.00	.01	.02	.03
16	40	100	16	4	P-SE1604	.00	.01	.02	.03
18	45	100	20	4	P-SE1804	.00	.01	.02	.03
20	45	100	20	4	P-SE2004	.00	.01	.02	.03

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-harden 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						
	○	○									○	○
ALTiBN	◎	◎	◎	○			○					
TiSiN	○	○	○	◎								
ZrN-A	◎	◎	◎	○			◎	○	○			

Unit/單位: mm