

**200<sup>+</sup>** 切削條件表 **P392**  
Cutting Condition

# Corner Radius Type - Long Neck & Shank - 4 flutes

## 4刃長頸長柄圓鼻立銑刀

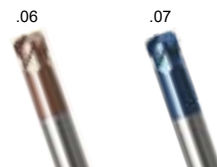
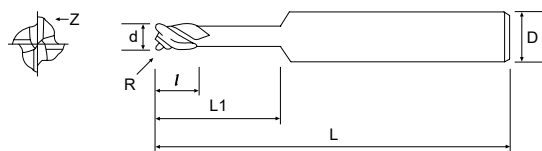
**200**  
PLUS

**HRC**  
65



● Super Ultra Fine Micro Grain Carbide

● WC=91 Co=9 HRA=93.2 Rupture=4000N/mm<sup>2</sup> Grain Size=0.2μm



| Dimension 規格 |               |              |                  |             |                |        | Purchase Code 採購代碼 |            |        |
|--------------|---------------|--------------|------------------|-------------|----------------|--------|--------------------|------------|--------|
| Diameter     | Corner Radius | Flute Length | Efficient Length | Full Length | Shank Diameter | Flutes | MODE               | Coating 塗層 |        |
| d 刃徑         | R 角           | 刃長           | L1 有效長           | L 全長        | D 柄徑           | Z 刃數   | 型號                 | TISIN+     | P-nACO |
| 6            | 0.2           | 9            | 18               | 75          | 6              | 4      | P-SFUCRM060024     | .06        | .07    |
| 6            | 0.3           | 9            | 18               | 75          | 6              | 4      | P-SFUCRM060034     | .06        | .07    |
| 6            | 0.5           | 9            | 18               | 75          | 6              | 4      | P-SFUCRM060054     | .06        | .07    |
| 6            | 1             | 9            | 18               | 75          | 6              | 4      | P-SFUCRM060104     | .06        | .07    |
| 6            | 2             | 9            | 18               | 75          | 6              | 4      | P-SFUCRM060204     | .06        | .07    |
| 8            | 0.3           | 12           | 20               | 100         | 8              | 4      | P-SFUCRM080034     | .06        | .07    |
| 8            | 0.5           | 12           | 20               | 100         | 8              | 4      | P-SFUCRM080054     | .06        | .07    |
| 8            | 1             | 12           | 20               | 100         | 8              | 4      | P-SFUCRM080104     | .06        | .07    |
| 8            | 2             | 12           | 20               | 100         | 8              | 4      | P-SFUCRM080204     | .06        | .07    |
| 10           | 0.5           | 15           | 25               | 100         | 10             | 4      | P-SFUCRM100054     | .06        | .07    |
| 10           | 1             | 15           | 25               | 100         | 10             | 4      | P-SFUCRM100104     | .06        | .07    |
| 10           | 1.5           | 15           | 25               | 100         | 10             | 4      | P-SFUCRM100154     | .06        | .07    |
| 10           | 2             | 15           | 25               | 100         | 10             | 4      | P-SFUCRM100204     | .06        | .07    |
| 10           | 3             | 15           | 25               | 100         | 10             | 4      | P-SFUCRM100304     | .06        | .07    |
| 12           | 0.5           | 18           | 30               | 100         | 12             | 4      | P-SFUCRM120054     | .06        | .07    |
| 12           | 1             | 18           | 30               | 100         | 12             | 4      | P-SFUCRM120104     | .06        | .07    |
| 12           | 1.5           | 18           | 30               | 100         | 12             | 4      | P-SFUCRM120154     | .06        | .07    |
| 12           | 2             | 18           | 30               | 100         | 12             | 4      | P-SFUCRM120204     | .06        | .07    |
| 12           | 3             | 18           | 30               | 100         | 12             | 4      | P-SFUCRM120304     | .06        | .07    |

Application 適用材質：

★ Perfect 最推薦

◎ Excellent 適合

○ Good 佳

| Coating<br>塗層 | Carbon steel,<br>Alloy steel<br>炭素鋼, 合金鋼 | Pre-hardened steel<br>預硬鋼 | High-hardened 高硬度鋼 |        |        |        | Stainless steel<br>不鏽鋼 | Titanium alloy<br>鈦合金 | Nickel/Inconel<br>alloy<br>鎳基合金 | Copper alloy<br>銅合金, 銅 | Aluminum alloy<br>鋁合金 |
|---------------|------------------------------------------|---------------------------|--------------------|--------|--------|--------|------------------------|-----------------------|---------------------------------|------------------------|-----------------------|
|               |                                          | ~45HRC                    | ~50HRC             | ~55HRC | ~60HRC | ~65HRC |                        |                       |                                 |                        |                       |
| TiSiN+        | ○                                        | ○                         | ○                  | ◎      | ◎      | ◎      |                        |                       |                                 |                        |                       |
| P-nAlCo       | ○                                        | ○                         | ○                  | ◎      | ◎      | ★      |                        |                       |                                 |                        |                       |

Unit/單位: mm