

400⁺

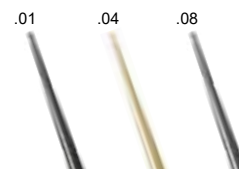
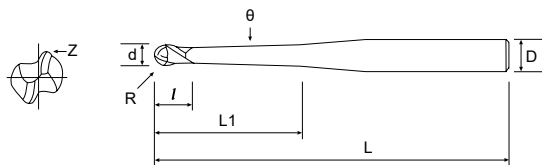
切削條件表 P368
Cutting Condition

Pencil Neck Ball Nose Type - 2 flutes

■ 2刃深溝斜頸球型立銑刀

400
PLUSHRC
60

● 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	Radius	Flute Length	Efficient Length	Full Length	Shank Diameter	Bevel	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	Z 刃長	L1 有效長	L 全長	D 柄徑	θ 斜度	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
1	0.5	2	20	75	6	1.5°	2	P-UPBT101520	.01	.04	.08
1.5	0.75	3	20	75	6	1.5°	2	P-UPBT151520	.01	.04	.08
2	1	4	25	75	6	1°	2	P-UPBT201025	.01	.04	.08
2.5	1.25	5	25	75	6	1°	2	P-UPBT251025	.01	.04	.08
3	1.5	6	30	75	6	1°	2	P-UPBT301030	.01	.04	.08
4	2	7	35	75	6	1°	2	P-UPBT401035	.01	.04	.08
4	2	7	45	150	8	2.5°	2	P-UPBT402545	.01	.04	.08
5	2.5	9	50	150	10	2.5°	2	P-UPBT502550	.01	.04	.08
6	3	10	38	150	10	3°	2	P-UPBT603038	.01	.04	.08
8	4	13	38	150	12	3°	2	P-UPBT803038	.01	.04	.08
10	5	16	42	150	16	4°	2	P-UPBT904042	.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					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
		~50HRC	~55HRC	~60HRC	~65HRC							
ALTiBN	◎	◎	◎	◎	○			○				
ZrN-S	◎	◎	◎	○	○				○			
nACRo	◎	◎	◎	◎	○			◎	○	○		

Unit/單位: mm