

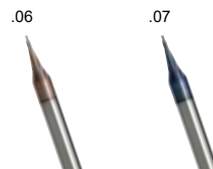
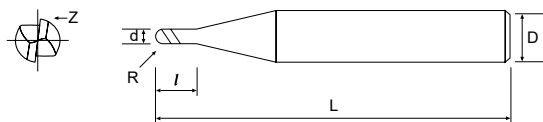
200⁺ 切削條件表 **P387**
Cutting Condition

Miniature Ball Nose Type - 2 flutes

■ 2刃微小徑球型立銑刀

200
PLUSHRC
60

● Super Ultra Fine Micro Grain Carbide

● WC=91 Co=9 HRA=93.2 Rupture=4000N/mm² Grain Size=0.2μmHRC
40HRC
45HRC
50HRC
55HRC
60HRC
65

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	L 刃長	L 全長	D 柄徑	Z 刃數	型號	TiSiN+	P-nACO
0.3	0.15	0.6	38	3	2	P-SFUMIB0033	.06	.07
0.4	0.2	0.8	38	3	2	P-SFUMIB0043	.06	.07
0.5	0.25	1	38	3	2	P-SFUMIB0053	.06	.07
0.6	0.3	1.2	38	3	2	P-SFUMIB0063	.06	.07
0.7	0.35	1.4	38	3	2	P-SFUMIB0073	.06	.07
0.8	0.4	1.6	38	3	2	P-SFUMIB0083	.06	.07
1	0.5	2	38	3	2	P-SFUMIB0103	.06	.07
1.2	0.6	2.5	38	3	2	P-SFUMIB0123	.06	.07
1.4	0.7	3	38	3	2	P-SFUMIB0143	.06	.07
1.5	0.75	3	38	3	2	P-SFUMIB0153	.06	.07
1.6	0.8	3.5	38	3	2	P-SFUMIB0163	.06	.07
1.8	0.9	4	38	3	2	P-SFUMIB0183	.06	.07
2	1	4	38	3	2	P-SFUMIB0203	.06	.07
2.2	1.1	4.5	38	3	2	P-SFUMIB0223	.06	.07
2.4	1.2	5	38	3	2	P-SFUMIB0243	.06	.07
2.5	1.25	5	38	3	2	P-SFUMIB0253	.06	.07
3	1.5	6	38	3	2	P-SFUMIB0303	.06	.07

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					
TiSiN+	○	○	○	◎	◎	◎					
P-nAlCo	○	○	○	◎	◎	★					

Unit/單位: mm

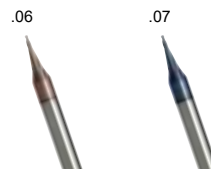
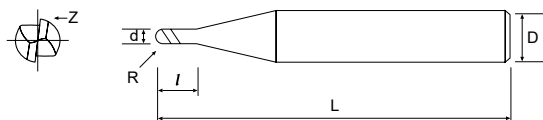
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Dimension 規格						Purchase Code 採購代碼		
Diameter	Radius	Flute Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層	
d 刃徑	R 值	刀長	L 全長	D 柄徑	Z 刃數	型號	TISIN+	P-nACo
0.3	0.15	0.6	50	4	2	P-SFUMIB0034	.06	.07
0.4	0.2	0.8	50	4	2	P-SFUMIB0044	.06	.07
0.5	0.25	1	50	4	2	P-SFUMIB0054	.06	.07
0.6	0.3	1.2	50	4	2	P-SFUMIB0064	.06	.07
0.7	0.35	1.4	50	4	2	P-SFUMIB0074	.06	.07
0.8	0.4	1.6	50	4	2	P-SFUMIB0084	.06	.07
1	0.5	2	50	4	2	P-SFUMIB0104	.06	.07
1.2	0.6	2.5	50	4	2	P-SFUMIB0124	.06	.07
1.4	0.7	3	50	4	2	P-SFUMIB0144	.06	.07
1.5	0.75	3	50	4	2	P-SFUMIB0154	.06	.07
1.6	0.8	3.5	50	4	2	P-SFUMIB0164	.06	.07
1.8	0.9	4	50	4	2	P-SFUMIB0184	.06	.07
2	1	4	50	4	2	P-SFUMIB0204	.06	.07
2.2	1.1	4.5	50	4	2	P-SFUMIB0224	.06	.07
2.4	1.2	5	50	4	2	P-SFUMIB0244	.06	.07
2.5	1.25	5	50	4	2	P-SFUMIB0254	.06	.07
3	1.5	6	50	4	2	P-SFUMIB0304	.06	.07

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		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
TiSiN+	○	○	○	◎	◎	◎					
P-nAlCo	○	○	○	◎	◎	★					

Unit/單位: mm