

400⁺ 切削條件表 **P357**
Cutting Condition

Square Type - 4 flutes

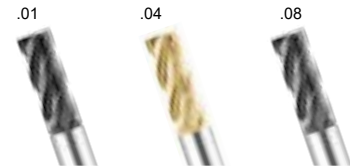
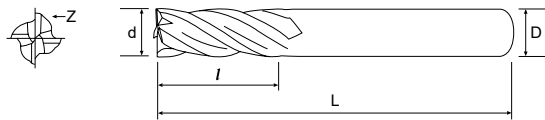
■ 4刃立銑刀

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	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	ZrN-S	nACRo
1	3	50	4	4	P-UET0104	.01	.04	.08
1.5	4	50	4	4	P-UET0154	.01	.04	.08
2	6	50	4	4	P-UET0204	.01	.04	.08
2.5	8	50	4	4	P-UET0254	.01	.04	.08
3	8	50	4	4	P-UET0304	.01	.04	.08
3.5	8	50	4	4	P-UET0354	.01	.04	.08
4	11	50	4	4	P-UET0404	.01	.04	.08
4.5	13	50	6	4	P-UET0454	.01	.04	.08
5	13	50	6	4	P-UET0504	.01	.04	.08
5.5	13	50	6	4	P-UET0554	.01	.04	.08
6	16	50	6	4	P-UET0604	.01	.04	.08
6.5	16	60	8	4	P-UET0654	.01	.04	.08
7	17	60	8	4	P-UET0704	.01	.04	.08
8	21	60	8	4	P-UET0804	.01	.04	.08
8	26	75	8	4	P-UET0814	.01	.04	.08
8.5	26	75	10	4	P-UET0854	.01	.04	.08
9	26	75	10	4	P-UET0904	.01	.04	.08
9.5	26	75	10	4	P-UET0954	.01	.04	.08
10	30	75	10	4	P-UET1004	.01	.04	.08
11	30	75	12	4	P-UET1104	.01	.04	.08
12	32	75	12	4	P-UET1204	.01	.04	.08
13	33	75	14	4	P-UET1304	.01	.04	.08
14	35	75	14	4	P-UET1404	.01	.04	.08
16	46	100	16	4	P-UET1604	.01	.04	.08
20	46	100	20	4	P-UET2004	.01	.04	.08
25	50	100	25	4	P-UET2504	.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	High-hardened 高硬度鋼					Stainless steel 不銹鋼	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	◎	◎	◎	◎	○		○					
ZrN-S	◎	◎	◎	○	○				○			
nACRo	◎	◎	◎	◎	○		◎		○	○		

Unit/單位: mm