

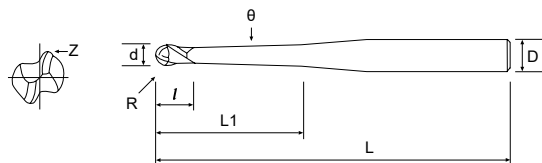
400⁺ 切削條件表 **P368**
Cutting Condition

Pencil Neck Ball Nose Type - Long Neck - 2 flutes

■ 2刃深溝長斜頸球型立銑刀

400
PLUSHRC
▶ 60A
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	Radius	Flute Length	Efficient Length	Full Length	Shank Diameter	Bevel	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	刀長	L1 有效長	L 全長	D 柄徑	θ 斜度	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
2	1	3	60	100	6	0.5°	2	P-ULPBT200560	.01	.04	.08
2	1	3	60	100	6	1°	2	P-ULPBT201060	.01	.04	.08
2	1	3	60	100	6	1.5°	2	P-ULPBT201560	.01	.04	.08
2	1	3	57	100	6	2°	2	P-ULPBT202057	.01	.04	.08
3	1.5	4	60	100	6	0.5°	2	P-ULPBT300560	.01	.04	.08
3	1.5	4	60	100	6	1°	2	P-ULPBT301060	.01	.04	.08
3	1.5	4	57	100	6	1.5°	2	P-ULPBT301557	.01	.04	.08
3	1.5	4	43	100	6	2°	2	P-ULPBT302043	.01	.04	.08
4	2	5	60	100	6	0.5°	2	P-ULPBT400560	.01	.04	.08
4	2	5	57	100	6	1°	2	P-ULPBT401057	.01	.04	.08
4	2	5	38	100	6	1.5°	2	P-ULPBT401538	.01	.04	.08
4	2	5	29	100	6	2°	2	P-ULPBT402029	.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
			~50HRC	~55HRC	~60HRC	~65HRC					
ALTiBN	◎	◎	◎	◎	○		○				
ZrN-S	◎	◎	◎	○	○			○			
nACRo	◎	◎	◎	◎	○		◎	○	○		

Unit/單位: mm