

S220 鎢鋼平銑刀- 強力小柄/標準型- 4刃

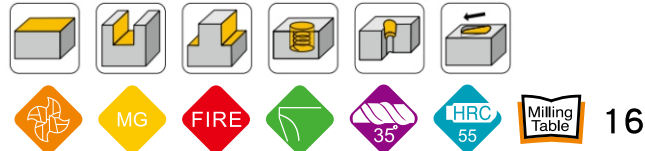
S220 MICRO GRAIN CARBIDE END MILLS- Square Type- Power Cutting- 4F

・ CESHM4

・ CESH4

d(刃徑)	Tolerance(公差)
$\phi < 3$	0 ~ -0.02
$3 \leq \phi \leq 10$	-0.01 ~ -0.03
$10 < \phi$	-0.01 ~ -0.04

超精銑 Bright Finishing	○
精銑 Finishing	◎
中銑 Semi Finishing	◎
粗銑 Roughing	○



刃徑 d	刃長 L1	全長 L	柄徑 D	刃數 F	白刀訂購編號 Uncoated Order No.	鍍膜訂購編號 Coated Order No.
2.0	5	50	4	4	CESHM40200	CESHM40200F
3.0	8	50	4	4	CESHM40300	CESHM40300F
4.0	10	50	4	4	CESHM40400	CESHM40400F
3.0	8	50	6	4	CESH40300	CESH40300F
4.0	10	50	6	4	CESH40400	CESH40400F
5.0	13	50	6	4	CESH40500	CESH40500F
6.0	15	50	6	4	CESH40600	CESH40600F
8.0	20	60	8	4	CESH40800	CESH40800F
10.0	25	75	10	4	CESH41000	CESH41000F
12.0	30	75	12	4	CESH41200	CESH41200F
16.0	35	100	16	4	CESH41600	CESH41600F

Table 16 鎢鋼平銑刀- 強力型- 4刃(鍍膜) 切削條件表

SOLID CARBIDE END MILLS- CUTTING CONDITION TABLE

加工材質 Material	不銹鋼 Stainless Steels		鈦合金 Titanium Alloys		鈦合金 Titanium Alloys		鋁合金 Aluminum Alloys	
工件料號 Material Code	SUS304		TiAl5Sn2(DIN)		TiAl6V4(DIN)		Al 5052 / 6061 / 7075	
硬度 Hardness	—		HRC $\approx$ 30		HRC>30		—	
切削速度 Vc	54m/min		60m/min		40m/min		120m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
2mm	8,600	515	9,550	450	6,370	300	19,110	180
3mm	5,760	345	6,370	300	4,250	200	12,740	230
4mm	4,320	345	4,780	225	3,180	150	9,550	170
5mm	3,420	345	3,820	180	2,550	120	7,640	230
6mm	2,880	345	3,180	150	2,120	100	6,370	190
8mm	2,160	345	2,390	180	1,590	125	4,780	200
10mm	1,710	360	1,910	205	1,270	140	3,820	230
12mm	1,440	360	1,590	230	1,060	155	3,180	190
16mm	1,200	420	1,190	210	790	145	2,390	230
切削量 Cutting Amount (mm)	Ap=0.6D Ae $\leq$ 0.1D		Ap=0.6D Ae $\leq$ 0.1D		Ap=0.6D Ae $\leq$ 0.1D		Ap=0.6D Ae $\leq$ 0.1D	