



切削條件表 **P391**
Cutting Condition

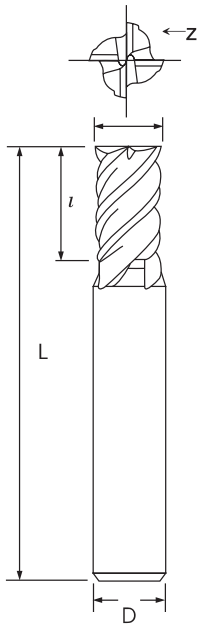
FHP - FHPS 4 Flutes • Short (Heavy-duty operation type)



■ 4刃重切削立銑刀

● Ultra Micro Grain Carbide

● WC=87 Co=12 HRA=92.1 Rupture=3800N/mm² Grain Size=0.4μm



UMG - FHPS					
Mode	Diameter	Flute Length	Full Length	Shank Diameter	Flutes
型號	d 直徑	l 刃長	L 全長	D 柄徑	Z 刃數
FHPS020	2	3	50	6	4
FHPS021	2.1	3.2	50	6	4
FHPS022	2.2	3.3	50	6	4
FHPS023	2.3	3.5	50	6	4
FHPS024	2.4	3.6	50	6	4
FHPS025	2.5	3.8	50	6	4
FHPS026	2.6	3.9	50	6	4
FHPS027	2.7	4.1	50	6	4
FHPS028	2.8	4.2	50	6	4
FHPS029	2.9	4.4	50	6	4
FHPS030	3	4.5	50	6	4
FHPS031	3.1	4.7	50	6	4
FHPS032	3.2	4.8	50	6	4
FHPS033	3.3	5	50	6	4
FHPS034	3.4	5.1	50	6	4
FHPS035	3.5	5.3	50	6	4
FHPS036	3.6	5.4	50	6	4
FHPS037	3.7	5.6	50	6	4
FHPS038	3.8	5.7	50	6	4
FHPS039	3.9	5.9	50	6	4
FHPS040	4	6	50	6	4
FHPS041	4.1	6.2	50	6	4
FHPS042	4.2	6.3	50	6	4
FHPS043	4.3	6.5	50	6	4
FHPS044	4.4	6.6	50	6	4
FHPS045	4.5	6.8	50	6	4
FHPS046	4.6	6.9	50	6	4
FHPS047	4.7	7.1	50	6	4
FHPS048	4.8	7.2	50	6	4
FHPS049	4.9	7.4	50	6	4
FHPS050	5	7.5	50	6	4
FHPS051	5.1	7.7	50	6	4
FHPS052	5.2	7.8	50	6	4
FHPS053	5.3	8	50	6	4
FHPS054	5.4	8.1	50	6	4
FHPS055	5.5	8.3	50	6	4



Application 適用材質：

◎ Recommend 最適合 ○ Suitable 適合 X Not Recommend 不建議

carbon steel, Alloy steel 炭素鋼,合金鋼	Pre-hardened steel 預硬鋼					Stainless steel 不銹鋼	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC			
◎	◎	◎	○	○				

切削
條件表 **P391**
Cutting Condition

SPEED TIGER

**FHP - FHPS 4 Flutes • Short
(Heavy-duty operation type)**

400
Nano

HRC
▶ 60

45°

nBS

■ 4刃重切削立銑刀

● Ultra Micro Grain Carbide

● WC=87 Co=12 HRA=92.1 Rupture=3800N/mm² Grain Size=0.4μm

功能性
銑刀



UMG - FHPS					
Mode	Diameter	Flute Length	Full Length	Shank Diameter	Flutes
型號	d 直徑	l 刃長	L 全長	D 柄徑	Z 刃數
FHPS056	5.6	8.4	50	6	4
FHPS057	5.7	8.6	50	6	4
FHPS058	5.8	8.7	50	6	4
FHPS059	5.9	8.9	50	6	4
FHPS060	6	9	50	6	4
FHPS061	6.1	9.2	60	8	4
FHPS062	6.2	9.3	60	8	4
FHPS063	6.3	9.5	60	8	4
FHPS064	6.4	9.6	60	8	4
FHPS065	6.5	9.8	60	8	4
FHPS066	6.6	9.9	60	8	4
FHPS067	6.7	10.1	60	8	4
FHPS068	6.8	10.2	60	8	4
FHPS069	6.9	10.4	60	8	4
FHPS070	7	10.5	60	8	4
FHPS071	7.1	10.7	60	8	4
FHPS072	7.2	10.8	60	8	4
FHPS073	7.3	11	60	8	4
FHPS074	7.4	11.1	60	8	4
FHPS075	7.5	11.3	60	8	4
FHPS076	7.6	11.4	60	8	4
FHPS077	7.7	11.6	60	8	4
FHPS078	7.8	11.7	60	8	4
FHPS079	7.9	11.9	60	8	4
FHPS080	8	12	60	8	4
FHPS081	8.1	12.2	75	10	4
FHPS082	8.2	12.3	75	10	4
FHPS083	8.3	12.5	75	10	4
FHPS084	8.4	12.6	75	10	4
FHPS085	8.5	12.8	75	10	4
FHPS086	8.6	12.9	75	10	4
FHPS087	8.7	13.1	75	10	4
FHPS088	8.8	13.2	75	10	4
FHPS089	8.9	13.4	75	10	4
FHPS090	9	13.5	75	10	4
FHPS091	9.1	13.7	75	10	4

HRC
▶ 40

HRC
▶ 45

HRC
▶ 50

HRC
▶ 55

HRC
▶ 60

HRC
▶ 65



Application 適用材質：

◎ Recommend 最適合 ○ Suitable 適合 X Not Recommend 不建議

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	Copper alloy 銅合金, 銅	Aluminum alloy 鋁合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC			
◎	◎	◎	○	○				



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HRC
▶ 60

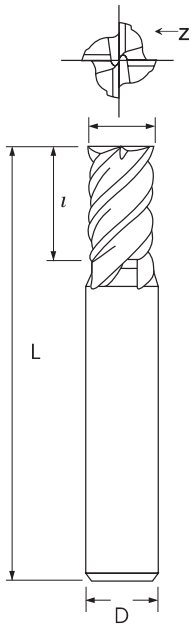
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UMG - FHPS

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型號	d 直徑	l 刃長	L 全長	D 柄徑	Z 刃數
FHPS092	9.2	13.8	75	10	4
FHPS093	9.3	14	75	10	4
FHPS094	9.4	14.1	75	10	4
FHPS095	9.5	14.3	75	10	4
FHPS096	9.6	14.4	75	10	4
FHPS097	9.7	14.6	75	10	4
FHPS098	9.8	14.7	75	10	4
FHPS099	9.9	14.9	75	10	4
FHPS100	10	15	75	10	4
FHPS105	10.5	15.8	100	12	4
FHPS110	11	16.5	100	12	4
FHPS115	11.5	17.3	100	12	4
FHPS120	12	18	100	12	4
FHPS125	12.5	18.8	100	14	4
FHPS130	13	19.5	100	14	4
FHPS135	13.5	20.3	100	14	4
FHPS140	14	21	100	14	4
FHPS145	14.5	21.8	100	16	4
FHPS150	15	22.5	100	16	4
FHPS155	15.5	23.3	100	16	4
FHPS160	16	24	100	16	4
FHPS170	17	25.5	100	20	4
FHPS180	18	27	100	20	4
FHPS190	19	28.5	100	20	4
FHPS200	20	30	100	20	4

HRC
▶ 40

HRC
▶ 45

HRC
▶ 50

HRC
▶ 55

HRC
▶ 60

HRC
▶ 65



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◎ Recommend 最適合 ○ Suitable 適合 X Not Recommend 不建議

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◎	◎	◎	○	○				