

**600<sup>+</sup>** 切削條件表 **P339**  
Cutting Condition

## Square Type - Long Flute - 4 flutes

### 4刃長刃立銑刀

**600 PLUS**

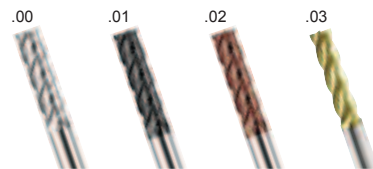
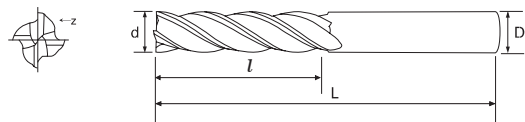
**HRC > 45**

**35°**

$a > b$

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm<sup>2</sup> Grain Size=0.6μm



HRC > 40

HRC > 45

HRC > 50

HRC > 55

HRC > 60

HRC > 65

HRC > 70

HRC > 75

HRC > 80

HRC > 85

HRC > 90

HRC > 95

HRC > 100

HRC > 105

HRC > 110

HRC > 115

HRC > 120

HRC > 125

HRC > 130

HRC > 135

HRC > 140

HRC > 145

HRC > 150

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	TISIN	ZrN-A	
1	6	50	4	4	P-LET0104	.00	.01	.02	.03
1.5	9	50	4	4	P-LET0154	.00	.01	.02	.03
2	12	50	4	4	P-LET0204	.00	.01	.02	.03
2.5	12	50	4	4	P-LET0254	.00	.01	.02	.03
3	15	60	6	4	P-LET0304	.00	.01	.02	.03
3.5	15	60	6	4	P-LET0354	.00	.01	.02	.03
4	20	75	6	4	P-LET0404	.00	.01	.02	.03
4.5	20	75	6	4	P-LET0454	.00	.01	.02	.03
5	25	75	6	4	P-LET0504	.00	.01	.02	.03
5.5	25	75	6	4	P-LET0554	.00	.01	.02	.03
6	30	75	6	4	P-LET0604	.00	.01	.02	.03
7	30	100	8	4	P-LET0704	.00	.01	.02	.03
8	40	100	8	4	P-LET0804	.00	.01	.02	.03
9	40	100	10	4	P-LET0904	.00	.01	.02	.03
10	40	100	10	4	P-LET1004	.00	.01	.02	.03
11	40	100	12	4	P-LET1104	.00	.01	.02	.03
12	50	100	12	4	P-LET1204	.00	.01	.02	.03
14	50	150	16	4	P-LET1404	.00	.01	.02	.03
16	60	150	16	4	P-LET1604	.00	.01	.02	.03
20	90	200	20	4	P-LET2004	.00	.01	.02	.03

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-harden 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					
	○	○								○	○
ALTIBN	◎	◎	○	○			○				
TISIN	○	○	○	○							
ZrN-A	◎	◎	○	○			◎	○	○		

Unit/單位: mm