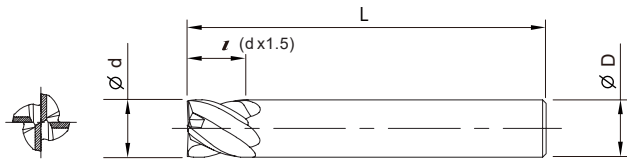


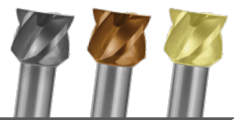
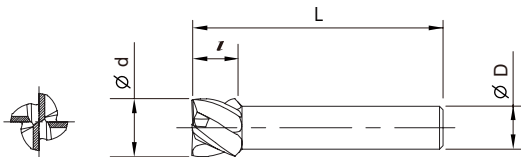
High Efficiency for Turning & Machine Center - 4 Flutes 車銑複合機用高效率立銑刀 - 4刃



切削條件表 **P183**
Cutting Condition



MODE 型號	Diameter d 刃徑	Flute Length l 刃長	Full Length L 全長	Shank Diameter D 柄徑	Flute z 刃數	Coating		
						AlTiBN	TiSiN	ZrN-A
TSUE0504	5	7.5	40	6	4	.01	.02	.03
TSUE0604	6	9	40	6	4	.01	.02	.03
TSUE0704	7	10.5	50	8	4	.01	.02	.03
TSUE0804	8	12	50	8	4	.01	.02	.03
TSUE1004	10	15	50	10	4	.01	.02	.03



MODE 型號	Diameter d 刃徑	Flute Length l 刃長	Full Length L 全長	Shank Diameter D 柄徑	Flute z 刃數	Coating		
						AlTiBN	TiSiN	ZrN-A
TUE0804	8	6	38	6	4	.01	.02	.03
TUE1004	10	6	40	6	4	.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-hardened 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	◎	◎	○	○			★	○	○			

TSUE/TUE

TSEE/TEE

TVE

SUS+/SUSL+

產品規格表 **P22**

產品規格表 **P23**

產品規格表 **P24**

產品規格表 **P53**

Specification page

Specification page

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TSEE&TEE 5 Flutes/TVE 6 Flutes/TSUE&TUE /SUS+/SUSL+ 4 Flutes Side Milling TSEE&TEE 5 刃/TVE 6 刃/TSUE&TUE/SUS+/SUSL+ 4 刃 側銑

Work Material 被削材	SS400, AISI 1050, SCM等 一般構造鋼, 碳素鋼, NON-ALLOYED STEELS ALLOY STEELS TOOL STEELS	AISI H13, AISI D2等 合金鋼, 工具鋼, 調質鋼 ALLOY STEELS HEAT RESISTANT STEELS	AISI 304 AISI 316等 沃斯田鐵、麻田 散鐵系 系列不銹鋼 STAINLESS STEELS	特殊合金、 鈦及鈦合金 TITANIUM ALLOYS
HARDNESS 硬度	~30HRC	30~45HRC	~40HRC	
STRENGTH 抗拉強度	~1000 N/mm ²	1000~1500 N/mm ²	~950N/mm ²	1300N/mm ²
Vc	90~140	70~110	50~100	35~80
Diameter 直徑(mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
3	0.015	0.013	0.013	0.012
4	0.020	0.017	0.018	0.016
5	0.025	0.021	0.022	0.020
6	0.030	0.025	0.026	0.023
7	0.035	0.029	0.031	0.027
8	0.040	0.034	0.035	0.031
9	0.055	0.051	0.051	0.045
10	0.060	0.057	0.057	0.050
12	0.072	0.068	0.068	0.060
14	0.084	0.080	0.080	0.070
16	0.096	0.091	0.091	0.080
20	0.120	0.114	0.114	0.100

$Ae: \leq 0.2D$ $Ap: \leq 1.5 D$

TSUE/TUE /SUS+/SUSL+ Slot Milling TSUE/TUE /SUS+/SUSL+ 槽銑

Work Material 被削材	SS400, AISI 1050, SCM等 一般構造鋼, 碳素鋼, NON-ALLOYED STEELS ALLOY STEELS TOOL STEELS	AISI H13, AISI D2等 合金鋼, 工具鋼, 調質鋼 ALLOY STEELS HEAT RESISTANT STEELS	AISI 304 AISI 316等 沃斯田鐵、麻田 散鐵系 系列不銹鋼 STAINLESS STEELS	特殊合金、 鈦及鈦合金 TITANIUM ALLOYS
HARDNESS 硬度	~30HRC	30~45HRC	~40HRC	
STRENGTH 抗拉強度	~1000 N/mm ²	1000~1500 N/mm ²	~950N/mm ²	1300N/mm ²
Cutting Type Vc	Slotting 70~110	Slotting 50~100	Slotting 40~80	Slotting 25~60
Diameter 直徑(mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
3	0.012	0.010	0.010	0.009
4	0.016	0.013	0.013	0.012
5	0.020	0.017	0.017	0.015
6	0.023	0.020	0.020	0.018
7	0.027	0.023	0.023	0.021
8	0.031	0.026	0.026	0.024
9	0.043	0.039	0.036	0.034
10	0.048	0.043	0.040	0.038
12	0.058	0.052	0.048	0.046
14	0.067	0.060	0.056	0.053
16	0.077	0.069	0.064	0.061
20	0.096	0.086	0.080	0.076

$Ae: \leq 1.0 D$ $Ap: \leq 1.0 D$

$D \leq 6 Ap: 0.5D$ $D > 6 Ap: 1.0D$