

400⁺ 切削條件表 P366-367

Cutting Condition

Ball Nose Type - Long Neck - 2 flutes

2刃深溝長頸球型立銑刀

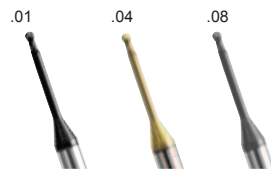
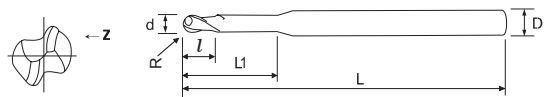
400 PLUS

HRC ▶ 60



● 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	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	Z 刃長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
0.5	0.25	0.75	2	50	4	2	P-ULNBT05022	.01	.04	.08
0.5	0.25	0.75	4	50	4	2	P-ULNBT05042	.01	.04	.08
0.5	0.25	0.75	6	50	4	2	P-ULNBT05062	.01	.04	.08
0.6	0.3	0.9	2	50	4	2	P-ULNBT06022	.01	.04	.08
0.6	0.3	0.9	4	50	4	2	P-ULNBT06042	.01	.04	.08
0.6	0.3	0.9	6	50	4	2	P-ULNBT06062	.01	.04	.08
0.8	0.4	1.2	4	50	4	2	P-ULNBT08042	.01	.04	.08
0.8	0.4	1.2	6	50	4	2	P-ULNBT08062	.01	.04	.08
0.8	0.4	1.2	8	50	4	2	P-ULNBT08082	.01	.04	.08
1	0.5	1.5	6	50	4	2	P-ULNBT10062	.01	.04	.08
1	0.5	1.5	8	50	4	2	P-ULNBT10082	.01	.04	.08
1	0.5	1.5	10	50	4	2	P-ULNBT10102	.01	.04	.08
1	0.5	1.5	12	50	4	2	P-ULNBT10122	.01	.04	.08
1.5	0.75	2.3	6	50	4	2	P-ULNBT15062	.01	.04	.08
1.5	0.75	2.3	8	50	4	2	P-ULNBT15082	.01	.04	.08
1.5	0.75	2.3	10	50	4	2	P-ULNBT15102	.01	.04	.08
1.5	0.75	2.3	12	50	4	2	P-ULNBT15122	.01	.04	.08
1.5	0.75	2.3	14	50	4	2	P-ULNBT15142	.01	.04	.08
1.5	0.75	2.3	16	50	4	2	P-ULNBT15162	.01	.04	.08
1.5	0.75	2.3	18	50	4	2	P-ULNBT15182	.01	.04	.08
1.5	0.75	2.3	20	50	4	2	P-ULNBT15202	.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	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	◎	◎	◎	◎	○	○	○				
ZrN-S	◎	◎	◎	○	○		○				
nACRo	◎	◎	◎	◎	○	◎	○	○			

Unit/單位: mm

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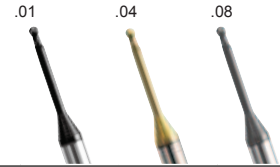
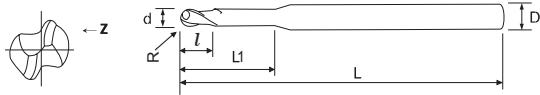
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d 刃徑	R 值	Z 刃長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
2	1	3	8	50	4	2	P-ULNBT20082	.01	.04	.08
2	1	3	10	50	4	2	P-ULNBT20102	.01	.04	.08
2	1	3	12	50	4	2	P-ULNBT20122	.01	.04	.08
2	1	3	14	50	4	2	P-ULNBT20142	.01	.04	.08
2	1	3	16	50	4	2	P-ULNBT20162	.01	.04	.08
2	1	3	18	50	4	2	P-ULNBT20182	.01	.04	.08
2	1	3	20	50	4	2	P-ULNBT20202	.01	.04	.08
2.5	1.25	4	8	50	4	2	P-ULNBT25082	.01	.04	.08
2.5	1.25	4	12	50	4	2	P-ULNBT25122	.01	.04	.08
2.5	1.25	4	16	50	4	2	P-ULNBT25162	.01	.04	.08
2.5	1.25	4	20	50	4	2	P-ULNBT25202	.01	.04	.08
3	1.5	4.5	10	50	6	2	P-ULNBT30102	.01	.04	.08
3	1.5	4.5	12	50	6	2	P-ULNBT30122	.01	.04	.08
3	1.5	4.5	16	60	6	2	P-ULNBT30162	.01	.04	.08
3	1.5	4.5	20	60	6	2	P-ULNBT30202	.01	.04	.08
3	1.5	4.5	25	75	6	2	P-ULNBT30252	.01	.04	.08
4	2	6	12	50	6	2	P-ULNBT40122	.01	.04	.08
4	2	6	16	60	6	2	P-ULNBT40162	.01	.04	.08
4	2	6	20	75	6	2	P-ULNBT40202	.01	.04	.08
4	2	6	25	75	6	2	P-ULNBT40252	.01	.04	.08
4	2	6	30	75	6	2	P-ULNBT40302	.01	.04	.08

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		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
ALTiBN	◎	◎	◎	◎	○	○					
ZrN-S	◎	◎	◎	○	○		○				
nACRo	◎	◎	◎	◎	○	◎	○	○			

Unit/單位: mm