400+

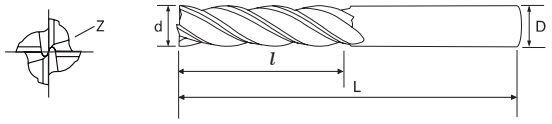
切削條件表 P359
Cutting Condition

Square Type - Long Flute - 4 flutes

■ 4刃長刃立銑刀

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	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	ZrN-S	nACRo
1	5	50	4	4	P-ULET0104	.01	.04	.08
1.5	6	50	4	4	P-ULET0154	.01	.04	.08
2	9	50	4	4	P-ULET0204	.01	.04	.08
2.5	10	50	4	4	P-ULET0254	.01	.04	.08
3	12	50	6	4	P-ULET0304	.01	.04	.08
3.5	14	50	6	4	P-ULET0354	.01	.04	.08
4	16	60	6	4	P-ULET0404	.01	.04	.08
4.5	18	60	6	4	P-ULET0454	.01	.04	.08
5	25	75	6	4	P-ULET0504	.01	.04	.08
6	25	75	6	4	P-ULET0604	.01	.04	.08
7	30	75	8	4	P-ULET0704	.01	.04	.08
8	35	100	8	4	P-ULET0804	.01	.04	.08
10	40	100	10	4	P-ULET1004	.01	.04	.08
12	45	100	12	4	P-ULET1204	.01	.04	.08
12	60	150	12	4	P-ULET1214	.01	.04	.08
14	45	100	14	4	P-ULET1404	.01	.04	.08
16	65	150	16	4	P-ULET1604	.01	.04	.08
20	75	150	20	4	P-ULET2004	.01	.04	.08
25	80	150	25	4	P-ULET2504	.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-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	◎	◎	◎	◎	○		○				
ZrN-S	◎	◎	◎	○	○			○			
nACRo	◎	◎	◎	◎	○		◎	○	○		

Unit/單位: mm