

切削條件表 **P320**  
Cutting Condition

**SPEED TIGER**

Square series - Long Neck - 2flutes

■ 2刃深溝專用長頸立銑刀

500 Nano

HRC > 50

35°

RS

● Micro Grain Carbide

● WC=88 Co=12 HRA=92.4 Rupture=3950N/mm<sup>2</sup> Grain Size=0.5µm



| MODE        | Diameter | Flute Length | Efficient Length | Full Length | Shank Diameter | Flutes |
|-------------|----------|--------------|------------------|-------------|----------------|--------|
| 型號          | d 刃徑     | l 刃長         | L1 有效長           | L 全長        | D 柄徑           | Z 刃數   |
| SULNT 05022 | 0.5      | 0.75         | 2                | 50          | 4              | 2      |
| SULNT 05042 | 0.5      | 0.75         | 4                | 50          | 4              | 2      |
| SULNT 05062 | 0.5      | 0.75         | 6                | 50          | 4              | 2      |
| SULNT 06022 | 0.6      | 0.9          | 2                | 50          | 4              | 2      |
| SULNT 06042 | 0.6      | 0.9          | 4                | 50          | 4              | 2      |
| SULNT 06062 | 0.6      | 0.9          | 6                | 50          | 4              | 2      |
| SULNT 07042 | 0.7      | 1.1          | 4                | 50          | 4              | 2      |
| SULNT 07062 | 0.7      | 1.1          | 6                | 50          | 4              | 2      |
| SULNT 08042 | 0.8      | 1.2          | 4                | 50          | 4              | 2      |
| SULNT 08062 | 0.8      | 1.2          | 6                | 50          | 4              | 2      |
| SULNT 08082 | 0.8      | 1.2          | 8                | 50          | 4              | 2      |
| SULNT 09062 | 0.9      | 1.4          | 6                | 50          | 4              | 2      |
| SULNT 09082 | 0.9      | 1.4          | 8                | 50          | 4              | 2      |
| SULNT 09102 | 0.9      | 1.4          | 10               | 50          | 4              | 2      |
| SULNT 10062 | 1        | 1.5          | 6                | 50          | 4              | 2      |
| SULNT 10082 | 1        | 1.5          | 8                | 50          | 4              | 2      |
| SULNT 10102 | 1        | 1.5          | 10               | 50          | 4              | 2      |
| SULNT 10122 | 1        | 1.5          | 12               | 50          | 4              | 2      |
| SULNT 10162 | 1        | 1.5          | 16               | 50          | 4              | 2      |
| SULNT 12062 | 1.2      | 1.8          | 6                | 50          | 4              | 2      |
| SULNT 12082 | 1.2      | 1.8          | 8                | 50          | 4              | 2      |
| SULNT 12102 | 1.2      | 1.8          | 10               | 50          | 4              | 2      |
| SULNT 12122 | 1.2      | 1.8          | 12               | 50          | 4              | 2      |
| SULNT 14062 | 1.4      | 2.1          | 6                | 50          | 4              | 2      |
| SULNT 14102 | 1.4      | 2.1          | 10               | 50          | 4              | 2      |
| SULNT 14162 | 1.4      | 2.1          | 16               | 50          | 4              | 2      |
| SULNT 15062 | 1.5      | 2.3          | 6                | 50          | 4              | 2      |
| SULNT 15082 | 1.5      | 2.3          | 8                | 50          | 4              | 2      |
| SULNT 15102 | 1.5      | 2.3          | 10               | 50          | 4              | 2      |
| SULNT 15122 | 1.5      | 2.3          | 12               | 50          | 4              | 2      |
| SULNT 15142 | 1.5      | 2.3          | 14               | 50          | 4              | 2      |
| SULNT 15162 | 1.5      | 2.3          | 16               | 50          | 4              | 2      |
| SULNT 15182 | 1.5      | 2.3          | 18               | 50          | 4              | 2      |
| SULNT 15202 | 1.5      | 2.3          | 20               | 50          | 4              | 2      |
| SULNT 16062 | 1.6      | 2.4          | 6                | 50          | 4              | 2      |
| SULNT 16082 | 1.6      | 2.4          | 8                | 50          | 4              | 2      |
| SULNT 16102 | 1.6      | 2.4          | 10               | 50          | 4              | 2      |
| SULNT 16122 | 1.6      | 2.4          | 12               | 50          | 4              | 2      |

- HRC > 40
- HRC > 45
- HRC > 50
- HRC > 55
- HRC > 60
- HRC > 65
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Application 適用材質：

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

| carbon steel,<br>Alloy steel<br>炭素鋼,合金鋼 | Pre-hardened steel<br>預硬鋼 | High-hardened<br>高硬度鋼 |        |        |        | Stainless steel<br>不銹鋼 | Copper alloy<br>銅合金,銅 | Aluminun alloy<br>鋁合金 |
|---|---------------------------|-----------------------|--------|--------|--------|------------------------|-----------------------|-----------------------|
|   | ~45HRC                    | ~50HRC                | ~55HRC | ~60HRC | ~65HRC |                        |                       |                       |
| ◎                                       | ◎                         | ◎                     | ○      |        |        | ◎                      | ○                     | ○                     |



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Cutting Condition

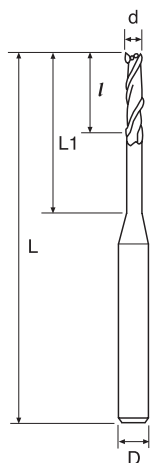
Square series - Long Neck - 2flutes

■ 2刃深溝專用長頸立銑刀



● Micro Grain Carbide

● WC=88 Co=12 HRA=92.4 Rupture=3950N/mm<sup>2</sup> Grain Size=0.5μm



| MODE        | Diameter | Flute Length | Efficient Length | Full Length | Shank Diameter | Flutes |
|-------------|----------|--------------|------------------|-------------|----------------|--------|
| 型號          | d 刃徑     | ℓ 刃長         | L1 有效長           | L 全長        | D 柄徑           | Z 刃數   |
| SULNT 16142 | 1.6      | 2.4          | 14               | 50          | 4              | 2      |
| SULNT 16162 | 1.6      | 2.4          | 16               | 50          | 4              | 2      |
| SULNT 16182 | 1.6      | 2.4          | 18               | 50          | 4              | 2      |
| SULNT 18082 | 1.8      | 2.7          | 8                | 50          | 4              | 2      |
| SULNT 18142 | 1.8      | 2.7          | 14               | 50          | 4              | 2      |
| SULNT 18202 | 1.8      | 2.7          | 20               | 50          | 4              | 2      |
| SULNT 20062 | 2        | 3            | 6                | 50          | 4              | 2      |
| SULNT 20082 | 2        | 3            | 8                | 50          | 4              | 2      |
| SULNT 20102 | 2        | 3            | 10               | 50          | 4              | 2      |
| SULNT 20122 | 2        | 3            | 12               | 50          | 4              | 2      |
| SULNT 20142 | 2        | 3            | 14               | 50          | 4              | 2      |
| SULNT 20162 | 2        | 3            | 16               | 50          | 4              | 2      |
| SULNT 20182 | 2        | 3            | 18               | 50          | 4              | 2      |
| SULNT 20202 | 2        | 3            | 20               | 50          | 4              | 2      |
| SULNT 25082 | 2.5      | 4            | 8                | 50          | 4              | 2      |
| SULNT 25102 | 2.5      | 4            | 10               | 50          | 4              | 2      |
| SULNT 25122 | 2.5      | 4            | 12               | 50          | 4              | 2      |
| SULNT 25142 | 2.5      | 4            | 14               | 50          | 4              | 2      |
| SULNT 25162 | 2.5      | 4            | 16               | 50          | 4              | 2      |
| SULNT 25202 | 2.5      | 4            | 20               | 50          | 4              | 2      |
| SULNT 30082 | 3        | 4.5          | 8                | 50          | 6              | 2      |
| SULNT 30102 | 3        | 4.5          | 10               | 50          | 6              | 2      |
| SULNT 30122 | 3        | 4.5          | 12               | 50          | 6              | 2      |
| SULNT 30162 | 3        | 4.5          | 16               | 60          | 6              | 2      |
| SULNT 30202 | 3        | 4.5          | 20               | 60          | 6              | 2      |
| SULNT 30252 | 3        | 4.5          | 25               | 75          | 6              | 2      |
| SULNT 35122 | 3.5      | 6            | 12               | 50          | 6              | 2      |
| SULNT 35162 | 3.5      | 6            | 16               | 60          | 6              | 2      |
| SULNT 35202 | 3.5      | 6            | 20               | 75          | 6              | 2      |
| SULNT 35252 | 3.5      | 6            | 25               | 75          | 6              | 2      |
| SULNT 35302 | 3.5      | 6            | 30               | 75          | 6              | 2      |
| SULNT 40122 | 4        | 6            | 12               | 50          | 6              | 2      |
| SULNT 40162 | 4        | 6            | 16               | 60          | 6              | 2      |
| SULNT 40202 | 4        | 6            | 20               | 75          | 6              | 2      |
| SULNT 40252 | 4        | 6            | 25               | 75          | 6              | 2      |
| SULNT 40302 | 4        | 6            | 30               | 75          | 6              | 2      |
| SULNT 40352 | 4        | 6            | 35               | 75          | 6              | 2      |

Application 適用材質：

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

| carbon steel,<br>Alloy steel<br>炭素鋼, 合金鋼 | Pre-hardened steel<br>預硬鋼 | High-hardened<br>高硬度鋼 |        |        |        | Stainless steel<br>不銹鋼 | Copper alloy<br>銅合金, 銅 | Aluminun alloy<br>鋁合金 |
|--|---------------------------|-----------------------|--------|--------|--------|------------------------|------------------------|-----------------------|
|  | ~45HRC                    | ~50HRC                | ~55HRC | ~60HRC | ~65HRC |                        |                        |                       |
| ◎  | ◎                         | ◎                     | ○      |        |        | ◎                      | ○                      | ○                     |