

400⁺

切削條件表 **P355**
Cutting Condition

Miniature Square Type - 2 flutes

■ 2刃微小徑立銑刀

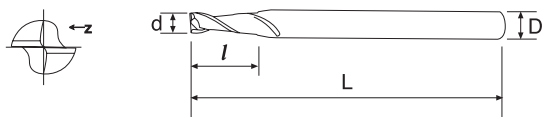
400 PLUS

HRC ▶ 60



● Ultra Fine Micro Grain Carbide

● WC=87 Co=12 HRA=92.1 Rupture=3800N/mm² Grain Size=0.4μm



HRC ▶ 40

HRC ▶ 45

HRC ▶ 50

HRC ▶ 55

HRC ▶ 60

HRC ▶ 65



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
0.2	0.4	38	3	2	P-UMIE3022	.01	.04	.08
0.3	0.6	38	3	2	P-UMIE3032	.01	.04	.08
0.4	0.7	38	3	2	P-UMIE3042	.01	.04	.08
0.5	0.8	38	3	2	P-UMIE3052	.01	.04	.08
0.6	0.9	38	3	2	P-UMIE3062	.01	.04	.08
0.7	1.4	38	3	2	P-UMIE3072	.01	.04	.08
0.8	1.6	38	3	2	P-UMIE3082	.01	.04	.08
0.9	1.8	38	3	2	P-UMIE3092	.01	.04	.08
1	3	38	3	2	P-UMIE3102	.01	.04	.08
1.1	3	38	3	2	P-UMIE3112	.01	.04	.08
1.2	3	38	3	2	P-UMIE3122	.01	.04	.08
1.3	3	38	3	2	P-UMIE3132	.01	.04	.08
1.4	3	38	3	2	P-UMIE3142	.01	.04	.08
1.5	4	38	3	2	P-UMIE3152	.01	.04	.08
1.6	4	38	3	2	P-UMIE3162	.01	.04	.08
1.7	4	38	3	2	P-UMIE3172	.01	.04	.08
1.8	4	38	3	2	P-UMIE3182	.01	.04	.08
1.9	4	38	3	2	P-UMIE3192	.01	.04	.08
2	6	38	3	2	P-UMIE3202	.01	.04	.08
2.1	6	38	3	2	P-UMIE3212	.01	.04	.08
2.2	6	38	3	2	P-UMIE3222	.01	.04	.08
2.3	6	38	3	2	P-UMIE3232	.01	.04	.08
2.4	6	38	3	2	P-UMIE3242	.01	.04	.08
2.5	8	38	3	2	P-UMIE3252	.01	.04	.08
2.6	8	38	3	2	P-UMIE3262	.01	.04	.08
2.7	8	38	3	2	P-UMIE3272	.01	.04	.08
2.8	8	38	3	2	P-UMIE3282	.01	.04	.08
2.9	8	38	3	2	P-UMIE3292	.01	.04	.08
3	8	38	3	2	P-UMIE3302	.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

400⁺ 切削條件表 **P355**
Cutting Condition

Miniature Square Type - 2 flutes

■ 2刃微小徑立銑刀

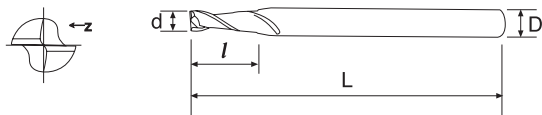
400 PLUS

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
0.2	0.4	50	4	2	P-UMIE0022	.01	.04	.08
0.3	0.6	50	4	2	P-UMIE0032	.01	.04	.08
0.4	0.7	50	4	2	P-UMIE0042	.01	.04	.08
0.5	0.8	50	4	2	P-UMIE0052	.01	.04	.08
0.6	0.9	50	4	2	P-UMIE0062	.01	.04	.08
0.7	1.4	50	4	2	P-UMIE0072	.01	.04	.08
0.8	1.6	50	4	2	P-UMIE0082	.01	.04	.08
0.9	1.8	50	4	2	P-UMIE0092	.01	.04	.08
1	3	50	4	2	P-UMIE0102	.01	.04	.08
1.1	3	50	4	2	P-UMIE0112	.01	.04	.08
1.2	3	50	4	2	P-UMIE0122	.01	.04	.08
1.3	3	50	4	2	P-UMIE0132	.01	.04	.08
1.4	3	50	4	2	P-UMIE0142	.01	.04	.08
1.5	4	50	4	2	P-UMIE0152	.01	.04	.08
1.6	4	50	4	2	P-UMIE0162	.01	.04	.08
1.7	4	50	4	2	P-UMIE0172	.01	.04	.08
1.8	4	50	4	2	P-UMIE0182	.01	.04	.08
1.9	4	50	4	2	P-UMIE0192	.01	.04	.08
2	6	50	4	2	P-UMIE0202	.01	.04	.08
2.1	6	50	4	2	P-UMIE0212	.01	.04	.08
2.2	6	50	4	2	P-UMIE0222	.01	.04	.08
2.3	6	50	4	2	P-UMIE0232	.01	.04	.08
2.4	6	50	4	2	P-UMIE0242	.01	.04	.08
2.5	8	50	4	2	P-UMIE0252	.01	.04	.08
2.6	8	50	4	2	P-UMIE0262	.01	.04	.08
2.7	8	50	4	2	P-UMIE0272	.01	.04	.08
2.8	8	50	4	2	P-UMIE0282	.01	.04	.08
2.9	8	50	4	2	P-UMIE0292	.01	.04	.08
3	8	50	4	2	P-UMIE0302	.01	.04	.08

HRC ▶ 40

HRC ▶ 45

HRC ▶ 50

HRC ▶ 55

HRC ▶ 60

HRC ▶ 65



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