

**600<sup>+</sup>** 切削條件表 **P340-341**  
Cutting Condition

## Square Type - Long Neck - 2 flutes

### 2刃深溝長頸立銑刀

**600 PLUS**

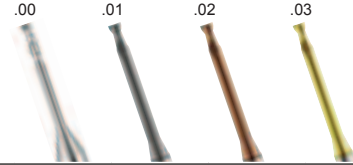
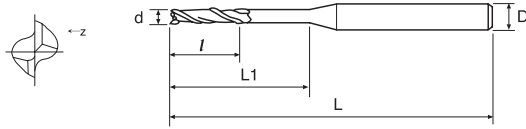
**HRC > 45**

**35°**

**a1**  
**b > a**

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm<sup>2</sup> Grain Size=0.6μm



| Dimension 規格 |              |                  |             |                |        | Purchase Code 採購代碼 |            |        |       |       |
|--------------|--------------|------------------|-------------|----------------|--------|--------------------|------------|--------|-------|-------|
| Diameter     | Flute Length | Efficient Length | Full Length | Shank Diameter | Flutes | MODE               | Coating 塗層 |        |       |       |
| d 刃徑         | l 刃長         | L1 有效長           | L 全長        | D 柄徑           | Z 刃數   | 型號                 |            | ALTiBN | TiSiN | ZrN-A |
| 0.5          | 0.75         | 2                | 50          | 4              | 2      | P-LNT05022         | .00        | .01    | .02   | .03   |
| 0.5          | 0.75         | 4                | 50          | 4              | 2      | P-LNT05042         | .00        | .01    | .02   | .03   |
| 0.5          | 0.75         | 6                | 50          | 4              | 2      | P-LNT05062         | .00        | .01    | .02   | .03   |
| 0.6          | 0.9          | 2                | 50          | 4              | 2      | P-LNT06022         | .00        | .01    | .02   | .03   |
| 0.6          | 0.9          | 4                | 50          | 4              | 2      | P-LNT06042         | .00        | .01    | .02   | .03   |
| 0.6          | 0.9          | 6                | 50          | 4              | 2      | P-LNT06062         | .00        | .01    | .02   | .03   |
| 0.7          | 1.1          | 4                | 50          | 4              | 2      | P-LNT07042         | .00        | .01    | .02   | .03   |
| 0.7          | 1.1          | 6                | 50          | 4              | 2      | P-LNT07062         | .00        | .01    | .02   | .03   |
| 0.8          | 1.2          | 4                | 50          | 4              | 2      | P-LNT08042         | .00        | .01    | .02   | .03   |
| 0.8          | 1.2          | 6                | 50          | 4              | 2      | P-LNT08062         | .00        | .01    | .02   | .03   |
| 0.8          | 1.2          | 8                | 50          | 4              | 2      | P-LNT08082         | .00        | .01    | .02   | .03   |
| 0.9          | 1.4          | 6                | 50          | 4              | 2      | P-LNT09062         | .00        | .01    | .02   | .03   |
| 0.9          | 1.4          | 8                | 50          | 4              | 2      | P-LNT09082         | .00        | .01    | .02   | .03   |
| 0.9          | 1.4          | 10               | 50          | 4              | 2      | P-LNT09102         | .00        | .01    | .02   | .03   |
| 1            | 1.5          | 6                | 50          | 4              | 2      | P-LNT10062         | .00        | .01    | .02   | .03   |
| 1            | 1.5          | 8                | 50          | 4              | 2      | P-LNT10082         | .00        | .01    | .02   | .03   |
| 1            | 1.5          | 10               | 50          | 4              | 2      | P-LNT10102         | .00        | .01    | .02   | .03   |
| 1            | 1.5          | 12               | 50          | 4              | 2      | P-LNT10122         | .00        | .01    | .02   | .03   |
| 1            | 1.5          | 16               | 50          | 4              | 2      | P-LNT10162         | .00        | .01    | .02   | .03   |
| 1.2          | 1.8          | 6                | 50          | 4              | 2      | P-LNT12062         | .00        | .01    | .02   | .03   |
| 1.2          | 1.8          | 8                | 50          | 4              | 2      | P-LNT12082         | .00        | .01    | .02   | .03   |
| 1.2          | 1.8          | 10               | 50          | 4              | 2      | P-LNT12102         | .00        | .01    | .02   | .03   |
| 1.2          | 1.8          | 12               | 50          | 4              | 2      | P-LNT12122         | .00        | .01    | .02   | .03   |
| 1.4          | 2.1          | 6                | 50          | 4              | 2      | P-LNT14062         | .00        | .01    | .02   | .03   |
| 1.4          | 2.1          | 10               | 50          | 4              | 2      | P-LNT14102         | .00        | .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      | ◎                                  | ◎                      | ○                  | ○      |        |        | ◎                   | ○                  | ○                         |                     |                    |

Unit/單位: mm

## 600<sup>+</sup> 切削條件表 P340-341

Cutting Condition

### Square Type - Long Neck - 2 flutes

## 2刃深溝長頸立銑刀

600 PLUS

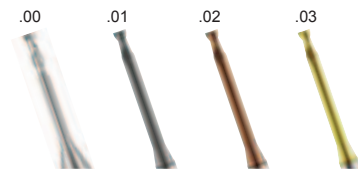
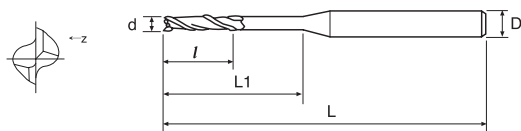
HRC > 45

35°

a/b  
b>a

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm<sup>2</sup> Grain Size=0.6μm



| Dimension 規格 |              |                  |             |                |        | Purchase Code 採購代碼 |            |        |       |       |
|--------------|--------------|------------------|-------------|----------------|--------|--------------------|------------|--------|-------|-------|
| Diameter     | Flute Length | Efficient Length | Full Length | Shank Diameter | Flutes | MODE               | Coating 塗層 |        |       |       |
| d 刃徑         | l 刃長         | L1 有效長           | L 全長        | D 柄徑           | Z 刃數   | 型號                 |            | ALTiBN | TiSiN | ZrN-A |
| 1.4          | 2.1          | 16               | 50          | 4              | 2      | P-LNT14162         | .00        | .01    | .02   | .03   |
| 1.5          | 2.3          | 6                | 50          | 4              | 2      | P-LNT15062         | .00        | .01    | .02   | .03   |
| 1.5          | 2.3          | 8                | 50          | 4              | 2      | P-LNT15082         | .00        | .01    | .02   | .03   |
| 1.5          | 2.3          | 10               | 50          | 4              | 2      | P-LNT15102         | .00        | .01    | .02   | .03   |
| 1.5          | 2.3          | 12               | 50          | 4              | 2      | P-LNT15122         | .00        | .01    | .02   | .03   |
| 1.5          | 2.3          | 14               | 50          | 4              | 2      | P-LNT15142         | .00        | .01    | .02   | .03   |
| 1.5          | 2.3          | 16               | 50          | 4              | 2      | P-LNT15162         | .00        | .01    | .02   | .03   |
| 1.5          | 2.3          | 18               | 50          | 4              | 2      | P-LNT15182         | .00        | .01    | .02   | .03   |
| 1.5          | 2.3          | 20               | 50          | 4              | 2      | P-LNT15202         | .00        | .01    | .02   | .03   |
| 1.6          | 2.4          | 6                | 50          | 4              | 2      | P-LNT16062         | .00        | .01    | .02   | .03   |
| 1.6          | 2.4          | 8                | 50          | 4              | 2      | P-LNT16082         | .00        | .01    | .02   | .03   |
| 1.6          | 2.4          | 10               | 50          | 4              | 2      | P-LNT16102         | .00        | .01    | .02   | .03   |
| 1.6          | 2.4          | 12               | 50          | 4              | 2      | P-LNT16122         | .00        | .01    | .02   | .03   |
| 1.6          | 2.4          | 14               | 50          | 4              | 2      | P-LNT16142         | .00        | .01    | .02   | .03   |
| 1.6          | 2.4          | 16               | 50          | 4              | 2      | P-LNT16162         | .00        | .01    | .02   | .03   |
| 1.6          | 2.4          | 18               | 50          | 4              | 2      | P-LNT16182         | .00        | .01    | .02   | .03   |
| 1.8          | 2.7          | 8                | 50          | 4              | 2      | P-LNT18082         | .00        | .01    | .02   | .03   |
| 1.8          | 2.7          | 14               | 50          | 4              | 2      | P-LNT18142         | .00        | .01    | .02   | .03   |
| 1.8          | 2.7          | 20               | 50          | 4              | 2      | P-LNT18202         | .00        | .01    | .02   | .03   |
| 2            | 3            | 6                | 50          | 4              | 2      | P-LNT20062         | .00        | .01    | .02   | .03   |
| 2            | 3            | 8                | 50          | 4              | 2      | P-LNT20082         | .00        | .01    | .02   | .03   |
| 2            | 3            | 10               | 50          | 4              | 2      | P-LNT20102         | .00        | .01    | .02   | .03   |
| 2            | 3            | 12               | 50          | 4              | 2      | P-LNT20122         | .00        | .01    | .02   | .03   |
| 2            | 3            | 14               | 50          | 4              | 2      | P-LNT20142         | .00        | .01    | .02   | .03   |
| 2            | 3            | 16               | 50          | 4              | 2      | P-LNT20162         | .00        | .01    | .02   | .03   |

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○ 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      | ◎                                  | ◎                      | ○                  | ○      |        |        | ◎                   | ○                  | ○                         |                     |                    |

Unit/單位: mm

**600<sup>+</sup>** 切削條件表 **P340-341**  
Cutting Condition

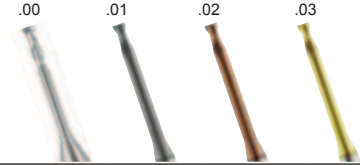
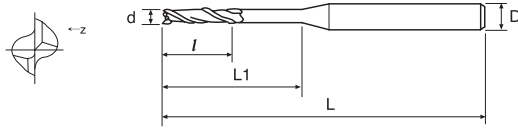
## Square Type - Long Neck - 2 flutes

### 2刃深溝長頸立銑刀



● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm<sup>2</sup> Grain Size=0.6μm



| Dimension 規格 |              |                  |             |                |        | Purchase Code 採購代碼 |            |        |       |       |
|--------------|--------------|------------------|-------------|----------------|--------|--------------------|------------|--------|-------|-------|
| Diameter     | Flute Length | Efficient Length | Full Length | Shank Diameter | Flutes | MODE               | Coating 塗層 |        |       |       |
| d 刃徑         | l 刃長         | L1 有效長           | L 全長        | D 柄徑           | Z 刃數   | 型號                 |            | ALTiBN | TiSiN | ZrN-A |
| 2            | 3            | 18               | 50          | 4              | 2      | P-LNT20182         | .00        | .01    | .02   | .03   |
| 2            | 3            | 20               | 50          | 4              | 2      | P-LNT20202         | .00        | .01    | .02   | .03   |
| 2.5          | 4            | 8                | 50          | 4              | 2      | P-LNT25082         | .00        | .01    | .02   | .03   |
| 2.5          | 4            | 10               | 50          | 4              | 2      | P-LNT25102         | .00        | .01    | .02   | .03   |
| 2.5          | 4            | 12               | 50          | 4              | 2      | P-LNT25122         | .00        | .01    | .02   | .03   |
| 2.5          | 4            | 14               | 50          | 4              | 2      | P-LNT25142         | .00        | .01    | .02   | .03   |
| 2.5          | 4            | 16               | 50          | 4              | 2      | P-LNT25162         | .00        | .01    | .02   | .03   |
| 2.5          | 4            | 20               | 50          | 4              | 2      | P-LNT25202         | .00        | .01    | .02   | .03   |
| 3            | 4.5          | 8                | 50          | 6              | 2      | P-LNT30082         | .00        | .01    | .02   | .03   |
| 3            | 4.5          | 10               | 50          | 6              | 2      | P-LNT30102         | .00        | .01    | .02   | .03   |
| 3            | 4.5          | 12               | 50          | 6              | 2      | P-LNT30122         | .00        | .01    | .02   | .03   |
| 3            | 4.5          | 16               | 60          | 6              | 2      | P-LNT30162         | .00        | .01    | .02   | .03   |
| 3            | 4.5          | 20               | 60          | 6              | 2      | P-LNT30202         | .00        | .01    | .02   | .03   |
| 3            | 4.5          | 25               | 75          | 6              | 2      | P-LNT30252         | .00        | .01    | .02   | .03   |
| 3.5          | 6            | 12               | 50          | 6              | 2      | P-LNT35122         | .00        | .01    | .02   | .03   |
| 3.5          | 6            | 16               | 60          | 6              | 2      | P-LNT35162         | .00        | .01    | .02   | .03   |
| 3.5          | 6            | 20               | 75          | 6              | 2      | P-LNT35202         | .00        | .01    | .02   | .03   |
| 3.5          | 6            | 25               | 75          | 6              | 2      | P-LNT35252         | .00        | .01    | .02   | .03   |
| 3.5          | 6            | 30               | 75          | 6              | 2      | P-LNT35302         | .00        | .01    | .02   | .03   |
| 4            | 6            | 12               | 50          | 6              | 2      | P-LNT40122         | .00        | .01    | .02   | .03   |
| 4            | 6            | 16               | 60          | 6              | 2      | P-LNT40162         | .00        | .01    | .02   | .03   |
| 4            | 6            | 20               | 75          | 6              | 2      | P-LNT40202         | .00        | .01    | .02   | .03   |
| 4            | 6            | 25               | 75          | 6              | 2      | P-LNT40252         | .00        | .01    | .02   | .03   |
| 4            | 6            | 30               | 75          | 6              | 2      | P-LNT40302         | .00        | .01    | .02   | .03   |
| 4            | 6            | 35               | 75          | 6              | 2      | P-LNT40352         | .00        | .01    | .02   | .03   |

Application 適用材質：

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| 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      | ◎                                  | ◎                      | ○                  | ○      |        |        | ◎      | ○                   | ○                  |                           |                     |                    |

Unit/單位: mm