

200⁺ 切削條件表 **P384**
Cutting Condition

Square Type - Long Flute - 4 flute

■ 4刃長刃立銑刀

200 PLUS

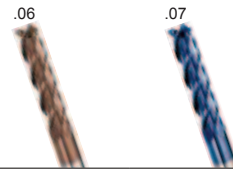
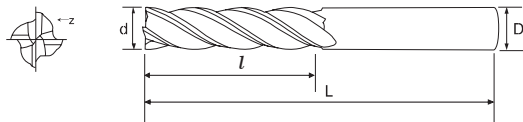
HRC 65

A D
B C
A#B#C#D

L1.3 L1.4
L1.1 L1.2 L1.3 L1.4

● Super Ultra Fine Micro Grain Carbide

● WC=91 Co=9 HRA=93.2 Rupture=4000N/mm² Grain Size=0.2μm



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	TISIN+	P-nACO
1	4	50	4	4	P-SFULET0104	.06	.07
1.5	6	50	4	4	P-SFULET0154	.06	.07
2	8	50	4	4	P-SFULET0204	.06	.07
3	12	60	6	4	P-SFULET0304	.06	.07
4	16	60	6	4	P-SFULET0404	.06	.07
5	20	75	6	4	P-SFULET0504	.06	.07
6	25	75	6	4	P-SFULET0604	.06	.07
7	30	75	8	4	P-SFULET0704	.06	.07
8	30	75	8	4	P-SFULET0804	.06	.07
10	40	100	10	4	P-SFULET1004	.06	.07
12	45	100	12	4	P-SFULET1204	.06	.07
14	45	100	16	4	P-SFULET1404	.06	.07
16	65	150	16	4	P-SFULET1604	.06	.07
20	75	150	20	4	P-SFULET2004	.06	.07
25	80	150	25	4	P-SFULET2504	.06	.07

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 碳素鋼, 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						
TISIN+	○	○	○	◎	◎	◎						
P-nACO	○	○	○	◎	◎	★						

Unit/單位: mm