

400⁺ 切削條件表 **P372**
Cutting Condition

Pencil Neck Corner Radius Type- 4 flutes

4刃斜頸圓鼻立銑刀

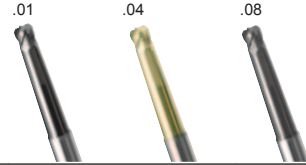
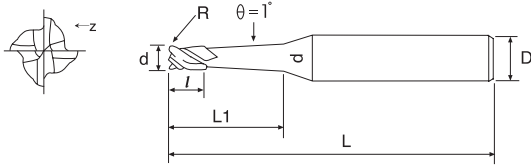
400 PLUS

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	Radius	Flute Length	Efficient Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	Z 刃長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
2	0.2	2	6	50	4	4	P-UCRS020024	.01	.04	.08
2	0.3	2	6	50	4	4	P-UCRS020034	.01	.04	.08
2	0.5	2	6	50	4	4	P-UCRS020054	.01	.04	.08
3	0.2	3	9	50	6	4	P-UCRS030024	.01	.04	.08
3	0.3	3	9	50	6	4	P-UCRS030034	.01	.04	.08
3	0.5	3	9	50	6	4	P-UCRS030054	.01	.04	.08
3	1	3	9	50	6	4	P-UCRS030104	.01	.04	.08
4	0.2	4	12	50	6	4	P-UCRS040024	.01	.04	.08
4	0.3	4	12	50	6	4	P-UCRS040034	.01	.04	.08
4	0.5	4	12	50	6	4	P-UCRS040054	.01	.04	.08
4	1	4	12	50	6	4	P-UCRS040104	.01	.04	.08
5	0.3	5	15	50	6	4	P-UCRS050034	.01	.04	.08
5	0.5	5	15	50	6	4	P-UCRS050054	.01	.04	.08
5	1	5	15	50	6	4	P-UCRS050104	.01	.04	.08
6	0.2	6	18	50	6	4	P-UCRS060024	.01	.04	.08
6	0.3	6	18	50	6	4	P-UCRS060034	.01	.04	.08
6	0.5	6	18	50	6	4	P-UCRS060054	.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

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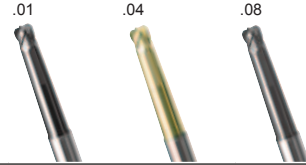
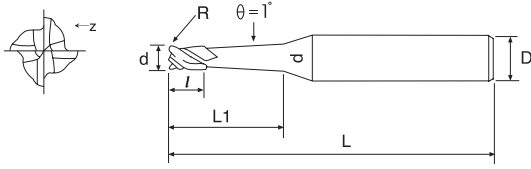
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6	1	6	18	50	6	4	P-UCRS060104	.01	.04	.08
6	2	6	18	50	6	4	P-UCRS060204	.01	.04	.08
8	0.3	8	20	60	8	4	P-UCRS080034	.01	.04	.08
8	0.5	8	20	60	8	4	P-UCRS080054	.01	.04	.08
8	1	8	20	60	8	4	P-UCRS080104	.01	.04	.08
8	2	8	20	60	8	4	P-UCRS080204	.01	.04	.08
10	0.5	10	25	75	10	4	P-UCRS100054	.01	.04	.08
10	1	10	25	75	10	4	P-UCRS100104	.01	.04	.08
10	1.5	10	25	75	10	4	P-UCRS100154	.01	.04	.08
10	2	10	25	75	10	4	P-UCRS100204	.01	.04	.08
10	3	10	25	75	10	4	P-UCRS100304	.01	.04	.08
12	0.5	12	30	75	12	4	P-UCRS120054	.01	.04	.08
12	1	12	30	75	12	4	P-UCRS120104	.01	.04	.08
12	1.5	12	30	75	12	4	P-UCRS120154	.01	.04	.08
12	2	12	30	75	12	4	P-UCRS120204	.01	.04	.08
12	3	12	30	75	12	4	P-UCRS120304	.01	.04	.08



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		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
ALTiBN	◎	◎	◎	◎	○	○					
ZrN-S	◎	◎	◎	○	○		○				
nACRo	◎	◎	◎	◎	○	◎	○	○			

Unit/單位: mm