

錫鋼立銑刀

Solid Carbide End Mills

極細微粒碳化錫圓鼻立銑刀

Micro Grain Carbide Corner-Radius End Mills

SUS

WE-4221



圓鼻 2 刃立銑刀

2-Flute Corner-Radius End Mills

適用材質：

鑄鐵、構造用鋼、碳素鋼、合金鋼、工具鋼、調質鋼、預硬鋼、不銹鋼、耐熱合金鋼

Applicable materials :

Cast Iron, Structural Steels, Carbon Steels, Alloy Steels, Tool Steels, Hardened Steels, Prehardened Steels, Stainless Steels, Nickel Alloy



直徑 D mm	R 徑 mm	全長 L mm	溝長 l mm	柄徑 d mm
1.0	0.2	50	2.0	4.0
1.5	0.2	50	3.0	4.0
2.0	0.3	50	5.0	4.0
2.0	0.5	50	5.0	4.0
3.0	0.3	50	7.5	4.0
3.0	0.5	50	7.5	4.0
4.0	0.3	50	8.0	4.0
4.0	0.5	50	8.0	4.0
4.0	1.0	50	8.0	4.0
5.0	0.3	60	12.0	6.0

直徑 D mm	R 徑 mm	全長 L mm	溝長 l mm	柄徑 d mm
5.0	0.5	60	12.0	6.0
5.0	1.0	60	12.0	6.0
6.0	0.3	75	20.0	6.0
6.0	0.5	75	20.0	6.0
6.0	1.0	75	20.0	6.0
8.0	0.3	75	25.0	8.0
8.0	0.5	75	25.0	8.0
8.0	1.0	75	25.0	8.0
10.0	0.5	75	30.0	10.0
10.0	1.0	75	30.0	10.0

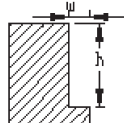
直徑 D mm	R 徑 mm	全長 L mm	溝長 l mm	柄徑 d mm
10.0	1.5	75	30.0	10.0
10.0	2.0	75	30.0	10.0
12.0	1.0	75	30.0	12.0
12.0	1.5	75	30.0	12.0
12.0	2.0	75	30.0	12.0

外徑 D(mm)		公差 (mm) Tolerance
大於 > Greater than	等於 = Equal 小於 < Less than	
	3	-0.005 ~ -0.025
3	12	-0.010 ~ -0.035

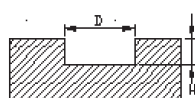
切削條件建議值 Recommended Milling Conditions

被削材 Work Material	鑄鐵Cast Iron 構造用鋼Structural Steels 碳素鋼Carbon Steels FC SS400 S45C		合金鋼Alloy Steels 工具鋼Tool Steels SCM SKS SKD		調質鋼Hardened Steels 預硬鋼Prehardened Steels SKT,SKD		不銹鋼Stainless Steels 調質鋼Hardened Steels SUS,SKD		調質鋼Hardened Steels 耐熱合金鋼Nickel Alloy		
	硬度 Hardness	抗張強度 ~750N/mm ²	~HRC30	HRC30~40	HRC40~45	HRC45~50	切削速度 Cutting Speed V m/min	60~80	50~70	35~50	25~35
銑刀外徑 Dia Of End Mill	回轉速 R.P.M.	進給速度 Feed mm/min	回轉速 R.P.M.	進給速度 Feed mm/min	回轉速 R.P.M.	進給速度 Feed mm/min	回轉速 R.P.M.	進給速度 Feed mm/min	回轉速 R.P.M.	進給速度 Feed mm/min	
2	11200	200	8600	90	5600	60	3800	40	3500	20	
3	7500	230	5800	120	4000	80	2500	60	2200	25	
4	5600	230	5000	160	3000	90	2000	80	1600	35	
5	500	230	4000	200	2600	110	1900	90	1500	40	
6	4300	250	3200	260	2200	140	1550	120	1100	100	
8	3200	300	2400	260	1600	150	1150	120	800	100	
10	2600	300	1900	250	1300	150	950	120	650	100	
12	2100	320	1600	250	1050	140	790	110	530	90	
切削深度值 Depth Of Cut	h=1.5D W=0.1D H=0.3D		h=1.5D W=0.05D H=0.25D		h=1.5D W=0.05D H=0.25D		h=1.5D W=0.03D H=0.2D		h=1D W=0.03D H=0.2D		

側銑削場合
Side Milling



槽銑削場合
Slotting



側銑場合進給速度可提高10%~15%
Feed speed may be increased by 10-15% when performing side milling