

**600<sup>+</sup>** 切削條件表 **P334**  
Cutting Condition

## Square Type - 4 flutes

### 4刃立銑刀

600 PLUS

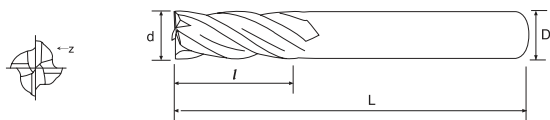
HRC ▶ 45

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	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	TISIN	ZrN-A
1	3	50	3	4	P-SSE0104	.00	.01	.02	.03
1	3	50	4	4	P-MSE0104	.00	.01	.02	.03
1.5	4	50	3	4	P-SSE0154	.00	.01	.02	.03
1.5	4	50	4	4	P-MSE0154	.00	.01	.02	.03
2	6	50	3	4	P-SSE0204	.00	.01	.02	.03
2	6	50	4	4	P-MSE0204	.00	.01	.02	.03
2.5	8	50	3	4	P-SSE0254	.00	.01	.02	.03
2.5	8	50	4	4	P-MSE0254	.00	.01	.02	.03
3	8	50	3	4	P-SSE0304	.00	.01	.02	.03
3	8	50	4	4	P-MSE0304	.00	.01	.02	.03
3.5	10	50	4	4	P-MSE0354	.00	.01	.02	.03
4	11	50	4	4	P-MSE0404	.00	.01	.02	.03
1	3	50	6	4	P-SE0104	.00	.01	.02	.03
1.5	4	50	6	4	P-SE0154	.00	.01	.02	.03
2	6	50	6	4	P-SE0204	.00	.01	.02	.03
2.5	8	50	6	4	P-SE0254	.00	.01	.02	.03
3	8	50	6	4	P-SE0304	.00	.01	.02	.03
3.5	10	50	6	4	P-SE0354	.00	.01	.02	.03
4	11	50	6	4	P-SE0404	.00	.01	.02	.03
4.5	13	50	6	4	P-SE0454	.00	.01	.02	.03
5	13	50	6	4	P-SE0504	.00	.01	.02	.03

- HRC ▶ 40
- HRC ▶ 45
- HRC ▶ 50
- HRC ▶ 55
- HRC ▶ 60
- HRC ▶ 65
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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 ~45HRC	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
			~50HRC	~55HRC	~60HRC	~65HRC						
	○	○								○	○	
ALTIBN	◎	◎	◎	○			○					
TISIN	○	○	○	◎								
ZrN-A	◎	◎	◎	○			◎	○	○			

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Cutting Condition

## Square Type - 4 flutes

### 4刃立銑刀

600 PLUS

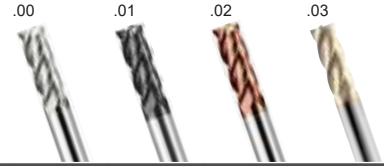
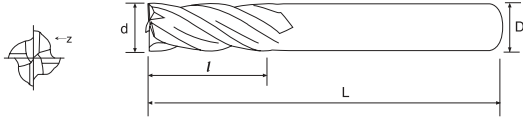
HRC ▶ 45

35°

$a > b$

● 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	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	TISiN	ZrN-A
5.5	13	50	6	4	P-SE0554	.00	.01	.02	.03
6	16	50	6	4	P-SE0604	.00	.01	.02	.03
6.5	16	60	8	4	P-SE0654	.00	.01	.02	.03
7	16	60	8	4	P-SE0704	.00	.01	.02	.03
7.5	19	60	8	4	P-SE0754	.00	.01	.02	.03
8	20	60	8	4	P-SE0804	.00	.01	.02	.03
8.5	20	75	10	4	P-SE0854	.00	.01	.02	.03
9	20	75	10	4	P-SE0904	.00	.01	.02	.03
9.5	25	75	10	4	P-SE0954	.00	.01	.02	.03
10	30	75	10	4	P-SE1004	.00	.01	.02	.03
10.5	30	75	12	4	P-SE1054	.00	.01	.02	.03
11	30	75	12	4	P-SE1104	.00	.01	.02	.03
11.5	30	75	12	4	P-SE1154	.00	.01	.02	.03
12	32	75	12	4	P-SE1204	.00	.01	.02	.03
14	40	100	16	4	P-SE1404	.00	.01	.02	.03
16	40	100	16	4	P-SE1604	.00	.01	.02	.03
18	45	100	20	4	P-SE1804	.00	.01	.02	.03
20	45	100	20	4	P-SE2004	.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	◎	◎	◎	○			◎	○	○			

WORK MATERIAL	MILD STEELS, CARBON STEELS, CAST IRON SS400 · S55C · FC250(~750N/mm <sup>2</sup> )	ALLOY STEELS, TOOL STEELS SCM · SKT · SKS · SKD ~HRC30	HARDENED STEELS, PREHARDENED STEELS SKT · SKD · NAK55 · HPM1 HRC30~38	STAINLESS STEELS, HARDENED STEELS SUS304 · SKD HRC38~45	HARDENED STEELS, TITANIUM ALLOY STEELS HRC45~55	HEAT RESISTANT ALLOY STEELS INCONEL
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### Slotting

MILL DIA. (mm)	SPEED (min <sup>-1</sup> )	FEED (mm/min)	SPEED (min <sup>-1</sup> )	FEED (mm/min)	SPEED (min <sup>-1</sup> )	FEED (mm/min)	SPEED (min <sup>-1</sup> )	FEED (mm/min)	SPEED (min <sup>-1</sup> )	FEED (mm/min)	SPEED (min <sup>-1</sup> )	FEED (mm/min)
6	5,150	592	4,250	508	3,950	460	3,700	456	3,600	436	1,250	116
8	3,850	480	3,200	440	2,950	440	2,800	420	2,700	408	945	124
10	3,100	464	2,550	432	2,350	384	2,250	380	2,150	364	760	116
12	2,600	448	2,150	380	1,950	368	1,850	352	1,800	348	630	116

### Side Milling

MILL DIA. (mm)	SPEED (min <sup>-1</sup> )	FEED (mm/min)	SPEED (min <sup>-1</sup> )	FEED (mm/min)	SPEED (min <sup>-1</sup> )	FEED (mm/min)	SPEED (min <sup>-1</sup> )	FEED (mm/min)	SPEED (min <sup>-1</sup> )	FEED (mm/min)	SPEED (min <sup>-1</sup> )	FEED (mm/min)
6	6,750	1,280	5,250	960	4,450	712	4,200	668	4,050	556	2,100	200
8	5,050	1,240	3,950	880	3,350	652	3,150	648	3,050	540	1,600	180
10	4,100	1,160	3,200	840	2,700	580	2,550	572	2,450	508	1,250	172
12	3,400	1,120	2,650	800	2,250	576	2,100	540	2,050	484	1,050	168

DEPTH  
OF CUT

