

**400<sup>+</sup>** 切削條件表 P374-379  
Cutting Condition

## Square Type - Short / Medium / Long Flute

### 4刃不等立銑刀 - 1倍 / 1.5倍 / 3倍長刃

400 PLUS

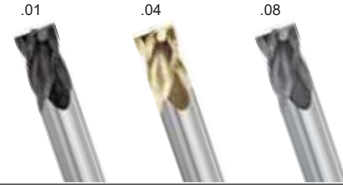
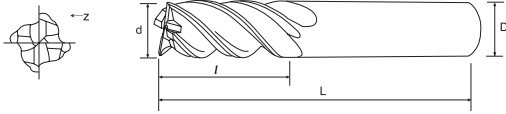
HRC 55

A B A≠B



Ultra Fine Micro Grain Carbide

WC=87 Co=12 HRA=92.1 Rupture=3800N/mm<sup>2</sup> Grain Size=0.4μm



#### Short Flute (1D) - 1 倍長刃

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	Zr-N-S	nACRo
6	6	50	6	4	PVES0604	.01	.04	.08
8	8	60	8	4	PVES0804	.01	.04	.08
10	10	75	10	4	PVES1004	.01	.04	.08
12	12	75	12	4	PVES1204	.01	.04	.08
16	16	100	16	4	PVES1604	.01	.04	.08
20	20	100	20	4	PVES2004	.01	.04	.08

#### Medium Flute (1.5D) - 1.5 倍長刃

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	Zr-N-S	nACRo
6	9	50	6	4	PVEM0604	.01	.04	.08
8	12	60	8	4	PVEM0804	.01	.04	.08
10	15	75	10	4	PVEM1004	.01	.04	.08
12	18	75	12	4	PVEM1204	.01	.04	.08
16	24	100	16	4	PVEM1604	.01	.04	.08
20	30	100	20	4	PVEM2004	.01	.04	.08

#### Long Flute (3D) - 3 倍長刃

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	Zr-N-S	nACRo
6	20	75	6	4	PVEL0604	.01	.04	.08
8	25	75	8	4	PVEL0804	.01	.04	.08
10	30	100	10	4	PVEL1004	.01	.04	.08
12	35	100	12	4	PVEL1204	.01	.04	.08
16	45	120	16	4	PVEL1604	.01	.04	.08
20	50	120	20	4	PVEL2004	.01	.04	.08

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 不銹鋼	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	◎	◎	◎	◎	○		○					
Zr-N-S	◎	◎	◎	○	○			○				
nACRo	◎	◎	◎	◎	○		◎	◎	★	○	○	

Unit/單位: mm