

600⁺ 切削條件表 **P334**
Cutting Condition

Square Type - Helix Angle 45° - 4 flutes

■ 4刃45° 立銑刀

600 PLUS

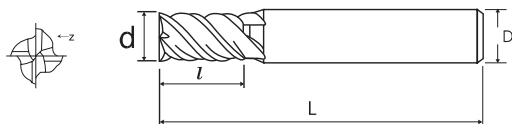
HRC > 45

45°

$a < b$
 $b > a$

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² 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	4	4	P-MPE0104	.00	.01	.02	.03
1.5	4	50	4	4	P-MPE0154	.00	.01	.02	.03
2	6	50	4	4	P-MPE0204	.00	.01	.02	.03
2.5	8	50	4	4	P-MPE0254	.00	.01	.02	.03
3	8	50	3	4	P-MPE3304	.00	.01	.02	.03
3	8	50	4	4	P-MPE0304	.00	.01	.02	.03
3.5	10	50	4	4	P-MPE0354	.00	.01	.02	.03
4	11	50	4	4	P-MPE0404	.00	.01	.02	.03
1	3	50	6	4	P-PE0104	.00	.01	.02	.03
1.5	4	50	6	4	P-PE0154	.00	.01	.02	.03
2	6	50	6	4	P-PE0204	.00	.01	.02	.03
2.5	8	50	6	4	P-PE0254	.00	.01	.02	.03
3	8	50	6	4	P-PE0304	.00	.01	.02	.03
3.5	10	50	6	4	P-PE0354	.00	.01	.02	.03
4	11	50	6	4	P-PE0404	.00	.01	.02	.03
4.5	13	50	6	4	P-PE0454	.00	.01	.02	.03

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-harden 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	◎	◎	◎	○			◎	○	○			

Unit/單位: mm

600⁺ 切削條件表 P334

Cutting Condition

Square Type - Helix Angle 45° - 4 flutes

4刃45° 立銑刀

600 PLUS

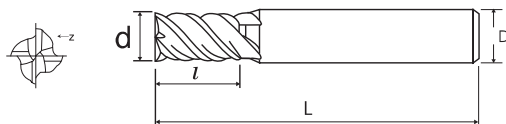
HRC 45

45°

a/b >

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



HRC > 40

HRC > 45

HRC > 50

HRC > 55

HRC > 60

HRC > 65

HRC > 70

HRC > 75

HRC > 80

HRC > 85

HRC > 90

HRC > 95

HRC > 100

HRC > 105

HRC > 110

HRC > 115

HRC > 120

HRC > 125

HRC > 130

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	13	50	6	4	P-PE0504	.00	.01	.02	.03
5.5	13	50	6	4	P-PE0554	.00	.01	.02	.03
6	16	50	6	4	P-PE0604	.00	.01	.02	.03
6.5	16	60	8	4	P-PE0654	.00	.01	.02	.03
7	16	60	8	4	P-PE0704	.00	.01	.02	.03
7.5	19	60	8	4	P-PE0754	.00	.01	.02	.03
8	20	60	8	4	P-PE0804	.00	.01	.02	.03
8.5	20	75	10	4	P-PE0854	.00	.01	.02	.03
9	20	75	10	4	P-PE0904	.00	.01	.02	.03
9.5	25	75	10	4	P-PE0954	.00	.01	.02	.03
10	30	75	10	4	P-PE1004	.00	.01	.02	.03
10.5	30	75	12	4	P-PE1054	.00	.01	.02	.03
11	30	75	12	4	P-PE1104	.00	.01	.02	.03
11.5	30	75	12	4	P-PE1154	.00	.01	.02	.03
12	32	75	12	4	P-PE1204	.00	.01	.02	.03
14	40	100	16	4	P-PE1404	.00	.01	.02	.03
16	40	100	16	4	P-PE1604	.00	.01	.02	.03
18	45	100	20	4	P-PE1804	.00	.01	.02	.03
20	45	100	20	4	P-PE2004	.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-harden 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	◎	◎	◎	○			◎	○			

Unit/單位: mm