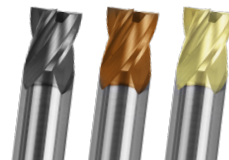
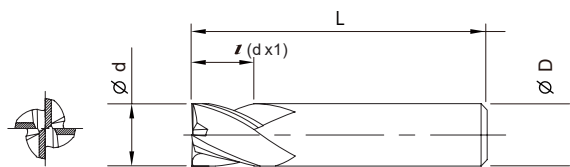


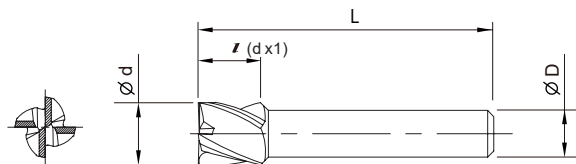
# General for Turning & Machine Center - 4 Flutes 車銑複合機用泛用立銑刀 - 4刃



切削條件表 **P179**  
Cutting Condition



MODE 型號	Diameter d 刃徑	Flute Length z 刃長	Full Length L 全長	Shank Diameter D 柄徑	Flute z 刃數	Coating		
						AlTiN	TiSiN	Zn-A
TSTE0104	1	1	40	6	4	.01	.02	.03
TSTE0154	1.5	1.5	40	6	4	.01	.02	.03
TSTE0204	2	2	40	6	4	.01	.02	.03
TSTE0254	2.5	2.5	40	6	4	.01	.02	.03
TSTE0304	3	3	40	6	4	.01	.02	.03
TSTE0354	3.5	3.5	40	6	4	.01	.02	.03
TSTE0404	4	4	40	6	4	.01	.02	.03
TSTE0504	5	5	40	6	4	.01	.02	.03
TSTE0604	6	6	40	6	4	.01	.02	.03
TSTE0804	8	8	40	8	4	.01	.02	.03
TSTE1004	10	10	45	10	4	.01	.02	.03



MODE 型號	Diameter d 刃徑	Flute Length z 刃長	Full Length L 全長	Shank Diameter D 柄徑	Flute z 刃數	Coating		
						AlTiN	TiSiN	Zn-A
TTE0704	7	7	40	6	4	.01	.02	.03
TTE0804	8	8	40	6	4	.01	.02	.03
TTE1004	10	10	45	6	4	.01	.02	.03
TTE1204	12	12	50	10	4	.01	.02	.03
TTE1604	16	16	60	10	4	.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						
AlTiN	◎	◎	◎	○			○					
TiSiN	○	○	○	◎								
Zn-A	◎	◎	◎	○			◎	○	○			

TSTE/TEE

產品規格表 **P20**  
Specification page

DE

產品規格表 **P42-44**  
Specification page

DH+

產品規格表 **P48-49**  
Specification page

P-SSE/P-MSE/P-SE


產品規格表 **P66**  
Specification page

DH

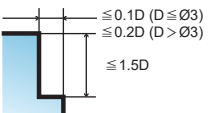
產品規格表 **P56**  
Specification page

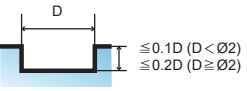
## TSTE/TEE/DE/DH+/DH/P-SSE/P-MSE/P-SE 4 Flutes Side Milling

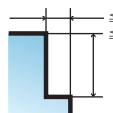
### TSTE/TEE/DE/DH+/DH/P-SSE/P-MSE/P-SE 4 刃側銑

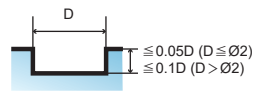
WORK MATERIAL 被切削材 	MILD STEELS, CARBON STEELS, CAST IRON SS400、S55C、FC250 (~750N/mm <sup>2</sup> ) 一般構造用鋼、碳素鋼、鑄鐵		ALLOY STEELS, TOOL STEELS SCM、SKT、SKS、SKD (~30HRC) 合金鋼、工具鋼		HARDENED STEELS, PREHARDENED STEELS SKT、SKD、NAK55、HPM1 (30~38HRC) 調質鋼、預硬鋼		STAINLESS STEELS, HARDENED STEELS SUS304、SKD (38~45HRC)不鏽鋼、調質鋼		HARDENED STEELS, TITANIUM ALLOY STEELS (45~55HRC) 調質鋼、鈦合金		HEAT RESISTANT ALLOY STEELS INCONEL 耐熱合金鋼、高鎳合金	
	MILL DIA. (mm) 直徑	SPEED (min <sup>-1</sup> ) 迴轉速	FEED (mm/min) 進給速	SPEED (min <sup>-1</sup> ) 迴轉速	FEED (mm/min) 進給速	SPEED (min <sup>-1</sup> ) 迴轉速	FEED (mm/min) 進給速	SPEED (min <sup>-1</sup> ) 迴轉速	FEED (mm/min) 進給速	SPEED (min <sup>-1</sup> ) 迴轉速	FEED (mm/min) 進給速	SPEED (min <sup>-1</sup> ) 迴轉速
3	12,500	880	9,550	672	8,100	500	7,650	492	7,400	436	3,800	176
4	9,750	960	7,550	788	6,400	544	6,050	568	5,850	504	3,000	192
5	7,950	1,040	6,150	840	5,250	580	4,950	620	4,800	536	2,450	196
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
16	2,550	960	2,000	752	1,700	508	1,600	444	1,550	404	765	168
20	2,050	788	1,600	604	1,350	472	1,250	412	1,250	368	635	160
25	1,650	704	1,250	540	1,100	428	1,000	388	990	316	510	148

DEPTH OF CUT  
加工深度










## TSTE/TEE/DE/DH+/DH/P-SSE/P-MSE/P-SE 4 Flutes Slotting

### TSTE/TEE/DE/DH+/DH/P-SSE/P-MSE/P-SE 4 刃溝銑

WORK MATERIAL 被切削材 	MILD STEELS, CARBON STEELS, CAST IRON SS400、S55C、FC250 (~750N/mm <sup>2</sup> ) 一般構造用鋼、碳素鋼、鑄鐵		ALLOY STEELS, TOOL STEELS SCM、SKT、SKS、SKD (~30HRC) 合金鋼、工具鋼		HARDENED STEELS, PREHARDENED STEELS SKT、SKD、NAK55、HPM1 (30~38HRC) 調質鋼、預硬鋼		STAINLESS STEELS, HARDENED STEELS SUS304、SKD (38~45HRC)不鏽鋼、調質鋼		HARDENED STEELS, TITANIUM ALLOY STEELS (45~55HRC) 調質鋼、鈦合金		HEAT RESISTANT ALLOY STEELS INCONEL 耐熱合金鋼、高鎳合金	
	MILL DIA. (mm) 直徑	SPEED (min <sup>-1</sup> ) 迴轉速	FEED (mm/min) 進給速	SPEED (min <sup>-1</sup> ) 迴轉速	FEED (mm/min) 進給速	SPEED (min <sup>-1</sup> ) 迴轉速	FEED (mm/min) 進給速	SPEED (min <sup>-1</sup> ) 迴轉速	FEED (mm/min) 進給速	SPEED (min <sup>-1</sup> ) 迴轉速	FEED (mm/min) 進給速	SPEED (min <sup>-1</sup> ) 迴轉速
3	10,500	584	8,550	544	7,850	416	7,450	368	7,200	352	2,500	100
4	7,750	584	6,400	620	5,900	416	5,550	412	5,400	396	1,900	108
5	6,200	588	5,100	604	4,700	436	4,450	436	4,300	428	1,500	116
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
16	1,950	444	1,600	344	1,500	296	1,400	296	1,350	292	475	88
20	1,550	380	1,300	304	1,200	284	1,100	264	1,100	264	380	88
25	1,250	360	1,000	292	945	252	890	228	865	188	300	84

DEPTH OF CUT  
加工深度

