

200⁺ 切削條件表 P366-367

Cutting Condition

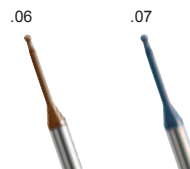
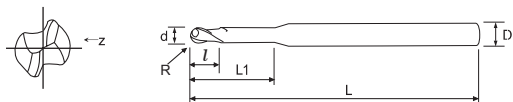
Ball Nose Type - Long Neck - 2 flutes

2刃深溝長頸球型立銑刀



● Super Ultra Fine Micro Grain Carbide

● WC=91 Co=9 HRA=93.2 Rupture=4000N/mm² Grain Size=0.2μm



Dimension 規格							Purchase Code 採購代碼		
Diameter	Radius	Flute Length	Efficient Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層	
d 刀徑	R 值	Z 刃長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	TiSiN+	P-nACo
0.5	0.25	0.75	2	50	4	2	P-SFULNBT05022	.06	.07
0.5	0.25	0.75	4	50	4	2	P-SFULNBT05042	.06	.07
0.5	0.25	0.75	6	50	4	2	P-SFULNBT05062	.06	.07
0.6	0.3	0.9	2	50	4	2	P-SFULNBT06022	.06	.07
0.6	0.3	0.9	4	50	4	2	P-SFULNBT06042	.06	.07
0.6	0.3	0.9	6	50	4	2	P-SFULNBT06062	.06	.07
0.8	0.4	1.2	4	50	4	2	P-SFULNBT08042	.06	.07
0.8	0.4	1.2	6	50	4	2	P-SFULNBT08062	.06	.07
0.8	0.4	1.2	8	50	4	2	P-SFULNBT08082	.06	.07
1	0.5	1.5	6	50	4	2	P-SFULNBT10062	.06	.07
1	0.5	1.5	8	50	4	2	P-SFULNBT10082	.06	.07
1	0.5	1.5	10	50	4	2	P-SFULNBT10102	.06	.07
1	0.5	1.5	12	50	4	2	P-SFULNBT10122	.06	.07
1.5	0.75	2.3	6	50	4	2	P-SFULNBT15062	.06	.07
1.5	0.75	2.3	8	50	4	2	P-SFULNBT15082	.06	.07
1.5	0.75	2.3	10	50	4	2	P-SFULNBT15102	.06	.07
1.5	0.75	2.3	12	50	4	2	P-SFULNBT15122	.06	.07
1.5	0.75	2.3	14	50	4	2	P-SFULNBT15142	.06	.07
1.5	0.75	2.3	16	50	4	2	P-SFULNBT15162	.06	.07
1.5	0.75	2.3	18	50	4	2	P-SFULNBT15182	.06	.07
1.5	0.75	2.3	20	50	4	2	P-SFULNBT15202	.06	.07



Application 適用材質：

★ Perfect 最推薦 ◎ Excellent 適合 ○ Good 佳

Coating 塗層	Carbon steel, Alloy steel 碳素鋼, 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						
TiSiN+	○	○	○	◎	◎	◎						
P-nACo	○	○	○	◎	◎	★						

Unit/單位: mm

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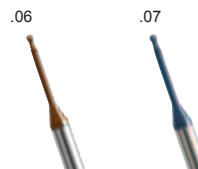
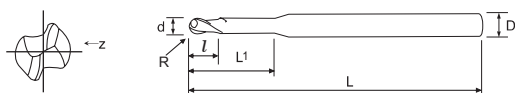
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d 刃徑	R 值	刀長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	TiSiN+	P-nACo
2	1	3	8	50	4	2	P-SFULNBT20082	.06	.07
2	1	3	10	50	4	2	P-SFULNBT20102	.06	.07
2	1	3	12	50	4	2	P-SFULNBT20122	.06	.07
2	1	3	14	50	4	2	P-SFULNBT20142	.06	.07
2	1	3	16	50	4	2	P-SFULNBT20162	.06	.07
2	1	3	18	50	4	2	P-SFULNBT20182	.06	.07
2	1	3	20	50	4	2	P-SFULNBT20202	.06	.07
2.5	1.25	4	8	50	4	2	P-SFULNBT25082	.06	.07
2.5	1.25	4	12	50	4	2	P-SFULNBT25122	.06	.07
2.5	1.25	4	16	50	4	2	P-SFULNBT25162	.06	.07
3	1.5	4.5	10	50	6	2	P-SFULNBT30102	.06	.07
3	1.5	4.5	12	50	6	2	P-SFULNBT30122	.06	.07
3	1.5	4.5	16	60	6	2	P-SFULNBT30162	.06	.07
3	1.5	4.5	20	60	6	2	P-SFULNBT30202	.06	.07
3	1.5	4.5	25	75	6	2	P-SFULNBT30252	.06	.07
4	2	6	12	50	6	2	P-SFULNBT40122	.06	.07
4	2	6	16	60	6	2	P-SFULNBT40162	.06	.07
4	2	6	20	75	6	2	P-SFULNBT40202	.06	.07
4	2	6	25	75	6	2	P-SFULNBT40252	.06	.07
4	2	6	30	75	6	2	P-SFULNBT40302	.06	.07



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		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
TiSiN+	○	○	○	◎	◎	◎						
P-nACo	○	○	○	◎	◎	★						

Unit/單位: mm