

錫鋼立銑刀

極細微粒碳化錫立銑刀

Solid Carbide End Mills

Micro Grain Carbide End Mills

WE-4201



2 刃立銑刀

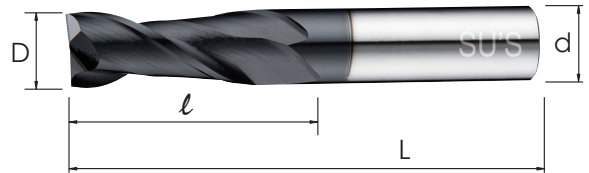
2-Flute End Mills

適用材質：

鑄鐵、構造用鋼、碳素鋼、合金鋼、工具鋼、調質鋼、預硬鋼、不銹鋼、耐熱合金鋼

Applicable materials :

Cast Iron, Structural Steels, Carbon Steels, Alloy Steels, Tool Steels, Hardened Steels, Prehardened Steels, Stainless Steels, Nickel Alloy



直徑 D mm	全長 L mm	溝長 l mm	柄徑 d mm
1.0	50	3.0	4.0
1.5	50	4.0	4.0
2.0	50	6.0	4.0
2.5	50	7.0	4.0
3.0	50	8.0	4.0
3.5	50	10.0	4.0
4.0	50	12.0	4.0
4.5	50	13.0	6.0
5.0	50	13.0	6.0
5.5	50	13.0	6.0
6.0	50	13.0	6.0
6.0	60	15.0	6.0
6.5	60	15.0	8.0
7.0	60	17.0	8.0
7.5	60	17.0	8.0

直徑 D mm	全長 L mm	溝長 l mm	柄徑 d mm
8.0	60	20.0	8.0
8.5	75	25.0	10.0
9.0	75	25.0	10.0
9.5	75	25.0	10.0
10.0	75	25.0	10.0
10.5	75	25.0	12.0
11.0	75	28.0	12.0
11.5	75	28.0	12.0
12.0	75	30.0	12.0
12.5	80	30.0	14.0
13.0	80	32.0	14.0
14.0	80	32.0	14.0
15.0	80	32.0	16.0
16.0	80	32.0	16.0
17.0	100	45.0	18.0

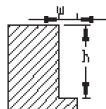
直徑 D mm	全長 L mm	溝長 l mm	柄徑 d mm
18.0	100	45.0	18.0
19.0	100	45.0	20.0
20.0	100	45.0	20.0

外徑 D(mm)		公差 (mm) Tolerance
大於 > Greater than	等於 = Equal 小於 < Less than	
	3	-0.005 ~ -0.025
3	20	-0.010 ~ -0.035

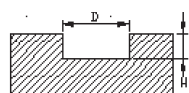
切削條件建議值 Recommended Milling Conditions

被削材 Work Material	鑄鐵 Cast Iron 構造用鋼 Structural Steels 碳素鋼 Carbon Steels FC SS400 S45C		合金鋼 Alloy Steels 工具鋼 Tool Steels SCM SKS SKD		調質鋼 Hardened Steels 預硬鋼 Prehardened Steels SKT,SKD		不銹鋼 Stainless Steels 調質鋼 Hardened Steels SUS,SKD		調質鋼 Hardened Steels 耐熱合金鋼 Nickel Alloy	
	硬度 Hardness	抗張強度 ~750N/mm ²	~HRC30	HRC30~40	HRC40~45	HRC45~50				
切削速度 Cutting Speed V m/min	60~85		50~70		35~50		25~35		20~30	
銑刀外徑 Dia Of End Mill	回轉速 R.P.M.	進給速度 Feed mm/min	回轉速 R.P.M.	進給速度 Feed mm/min	回轉速 R.P.M.	進給速度 Feed mm/min	回轉速 R.P.M.	進給速度 Feed mm/min	回轉速 R.P.M.	進給速度 Feed mm/min
1	22400	120	17000	90	11000	35	6600	20	6500	18
2	11200	220	9000	100	6000	40	3800	25	3600	23
3	7500	230	6500	120	4200	55	2500	35	2200	28
4	5600	230	5000	130	3200	70	2000	40	1800	35
5	5000	230	4300	150	3000	90	1900	50	1600	45
6	4200	250	3500	180	2500	90	1550	50	1300	50
8	3100	300	2800	220	1900	100	1150	60	1000	60
10	2500	300	2100	250	1500	100	950	60	800	60
12	2100	320	1800	250	1250	110	790	60	660	60
14	1900	320	1500	250	1100	110	650	70	580	60
16	1600	300	1350	230	950	110	580	65	520	55
18	1400	300	1200	230	800	100	520	65	480	55
20	1200	300	1000	230	700	100	480	65	440	55
切削深度值 Depth Of Cut	h=1.5D W=0.25D H=0.5D		h=1.5D W=0.2D H=0.3D		h=1.2D W=0.1D H=0.2D		h=1.2D W=0.05D H=0.15D		h=1D W=0.03D H=0.1D	

側銑削場合
Side Milling



槽銑削場合
Slotting



側銑場合進給速度可提高10%~20%
Feed speed may be increased by 10-20% when performing side milling