

錫鋼立銑刀

極細微粒碳化錫立銑刀

Solid Carbide End Mills

Micro Grain Carbide End Mills

SUS

WE-4301



3 刃立銑刀

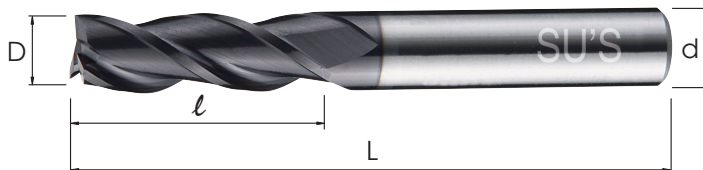
3-Flute End Mills

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 |
|------------|------------|------------|------------|
| 3.0 | 50 | 8.0 | 4.0 |
| 4.0 | 50 | 12.0 | 4.0 |
| 5.0 | 60 | 13.0 | 6.0 |
| 6.0 | 60 | 15.0 | 6.0 |
| 8.0 | 75 | 25.0 | 8.0 |

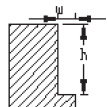
| 直徑 D mm | 全長 L mm | 溝長 l mm | 柄徑 d mm |
|------------|------------|------------|------------|
| 10.0 | 75 | 30.0 | 10.0 |
| 12.0 | 75 | 30.0 | 12.0 |
| 16.0 | 100 | 42.0 | 16.0 |
| 20.0 | 100 | 45.0 | 20.0 |

| 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 |
| 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 | |
| 3 | 7500 | 200 | 6500 | 120 | 4200 | 110 | 2500 | 95 | 2200 | 40 | |
| 4 | 5600 | 250 | 5000 | 150 | 3200 | 130 | 2000 | 125 | 1800 | 50 | |
| 5 | 5000 | 280 | 4300 | 180 | 3000 | 170 | 1900 | 140 | 1600 | 65 | |
| 6 | 4200 | 360 | 3500 | 250 | 2500 | 220 | 1550 | 190 | 1300 | 80 | |
| 8 | 3100 | 360 | 2800 | 300 | 1900 | 230 | 1150 | 200 | 1000 | 80 | |
| 10 | 2500 | 380 | 2100 | 300 | 1500 | 230 | 950 | 200 | 800 | 80 | |
| 12 | 2100 | 380 | 1800 | 300 | 1250 | 220 | 790 | 190 | 660 | 80 | |
| 16 | 1600 | 350 | 1350 | 280 | 950 | 160 | 580 | 145 | 520 | 70 | |
| 20 | 1200 | 320 | 1000 | 280 | 700 | 140 | 480 | 120 | 430 | 60 | |
| 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=0.01D | | |

側銑削場合
Side Milling



槽銑削場合
Slotting

