

400⁺ 切削條件表 P365 Cutting Condition

Ball Nose Type - Short Flute - 2 flutes

■ 2刃強力短刃球型立銑刀

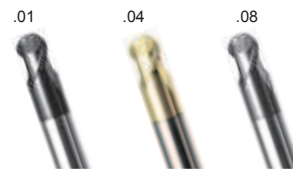
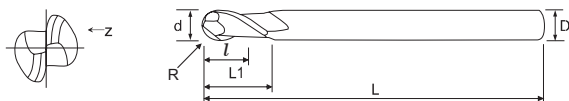
400 PLUS

HRC ▶ 60



● Ultra Fine Micro Grain Carbide

● WC=87 Co=12 HRA=92.1 Rupture=3800N/mm² Grain Size=0.4μm



HRC ▶ 40

HRC ▶ 45

HRC ▶ 50

HRC ▶ 55

HRC ▶ 60

HRC ▶ 65



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 刃徑	R 值	Z 刃長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
1	0.5	1	2.5	50	4	2	P-UBTSX010	.01	.04	.08
1.5	0.75	1.5	4	50	4	2	P-UBTSX015	.01	.04	.08
2	1	2	5	50	4	2	P-UBTSX020	.01	.04	.08
2.5	1.25	2.5	6	50	4	2	P-UBTSX025	.01	.04	.08
3	1.5	3	8	50	4	2	P-UBTSX030	.01	.04	.08
3.5	1.75	3.5	8	50	4	2	P-UBTSX035	.01	.04	.08
3	1.5	3	8	50	6	2	P-UBTSX036	.01	.04	.08
4	2	4	10	50	4	2	P-UBTSX044	.01	.04	.08
4.5	2.25	4.5	11	50	6	2	P-UBTSX045	.01	.04	.08
4	2	4	10	50	6	2	P-UBTSX046	.01	.04	.08
5	2.5	5	13	50	6	2	P-UBTSX050	.01	.04	.08
5.5	2.75	5.5	14	50	6	2	P-UBTSX055	.01	.04	.08
6	3	6	15	50	6	2	P-UBTSX060	.01	.04	.08
7	3.5	7	16	60	8	2	P-UBTSX070	.01	.04	.08
8	4	8	20	60	8	2	P-UBTSX080	.01	.04	.08
9	4.5	9	22	75	10	2	P-UBTSX090	.01	.04	.08
10	5	10	25	75	10	2	P-UBTSX100	.01	.04	.08
12	6	12	30	75	12	2	P-UBTSX120	.01	.04	.08
14	7	14	35	75	16	2	P-UBTSX140	.01	.04	.08
16	8	16	40	100	16	2	P-UBTSX160	.01	.04	.08

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					
ALTiBN	◎	◎	◎	◎	○	○					
ZrN-S	◎	◎	◎	○	○		○				
nACRo	◎	◎	◎	◎	○	◎	○	○			

Unit/單位: mm