

# 400<sup>+</sup>

切削條件表 **P363**  
Cutting Condition

## Miniature Ball Nose Type - 2 flutes

### 2刃微小徑球型立銑刀

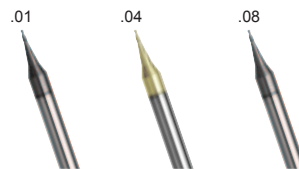
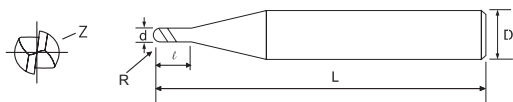
**400 PLUS**

**HRC ▶ 60**



● Ultra Fine Micro Grain Carbide

● WC=87 Co=12 HRA=92.1 Rupture=3800N/mm<sup>2</sup> Grain Size=0.4μm



Dimension 規格						Purchase Code 採購代碼			
Diameter	Radius	Flute Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	Z 刃長	L 全長	D 柄徑	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
0.3	0.15	0.6	38	3	2	P-UMIB3032	.01	.04	.08
0.4	0.2	0.7	38	3	2	P-UMIB3042	.01	.04	.08
0.5	0.25	0.8	38	3	2	P-UMIB3052	.01	.04	.08
0.6	0.3	0.9	38	3	2	P-UMIB3062	.01	.04	.08
0.7	0.35	1.4	38	3	2	P-UMIB3072	.01	.04	.08
0.8	0.4	1.6	38	3	2	P-UMIB3082	.01	.04	.08
0.9	0.45	1.8	38	3	2	P-UMIB3092	.01	.04	.08
1	0.5	2	38	3	2	P-UMIB3102	.01	.04	.08
1.1	0.55	2.2	38	3	2	P-UMIB3112	.01	.04	.08
1.2	0.6	2.4	38	3	2	P-UMIB3122	.01	.04	.08
1.3	0.65	2.6	38	3	2	P-UMIB3132	.01	.04	.08
1.4	0.7	2.8	38	3	2	P-UMIB3142	.01	.04	.08
1.5	0.75	3	38	3	2	P-UMIB3152	.01	.04	.08
1.6	0.8	3.2	38	3	2	P-UMIB3162	.01	.04	.08
1.7	0.85	3.4	38	3	2	P-UMIB3172	.01	.04	.08
1.8	0.9	3.6	38	3	2	P-UMIB3182	.01	.04	.08
1.9	0.95	3.8	38	3	2	P-UMIB3192	.01	.04	.08
2	1	4	38	3	2	P-UMIB3202	.01	.04	.08
2.1	1.05	4.2	38	3	2	P-UMIB3212	.01	.04	.08
2.2	1.1	4.4	38	3	2	P-UMIB3222	.01	.04	.08
2.3	1.15	4.6	38	3	2	P-UMIB3232	.01	.04	.08
2.4	1.2	4.8	38	3	2	P-UMIB3242	.01	.04	.08
2.5	1.25	5	38	3	2	P-UMIB3252	.01	.04	.08
2.6	1.3	5.2	38	3	2	P-UMIB3262	.01	.04	.08
2.7	1.35	5.4	38	3	2	P-UMIB3272	.01	.04	.08
2.8	1.4	5.6	38	3	2	P-UMIB3282	.01	.04	.08
2.9	1.45	5.8	38	3	2	P-UMIB3292	.01	.04	.08
3	1.5	6	38	3	2	P-UMIB3302	.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-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					
ALTiBN	◎	◎	◎	◎	○	○	○	○	○	○	
ZrN-S	◎	◎	◎	○	○	○	○	○	○	○	
nACRo	◎	◎	◎	◎	○	○	◎	○	○	○	

Unit/單位: mm

**400<sup>+</sup>** 切削條件表 **P363**  
Cutting Condition

## Miniature Ball Nose Type - 2 flutes

### 2刃微小徑球型立銑刀

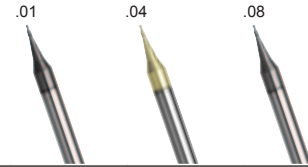
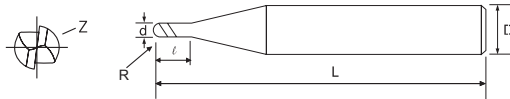
**400 PLUS**

**HRC ▶ 60**



● Ultra Fine Micro Grain Carbide

● WC=87 Co=12 HRA=92.1 Rupture=3800N/mm<sup>2</sup> Grain Size=0.4μm



Dimension 規格						Purchase Code 採購代碼			
Diameter	Radius	Flute Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層		
d 刃徑	R 值	Z 刃長	L 全長	D 柄徑	Z 刃數	型號	ALTiBN	ZrN-S	nACRo
0.3	0.15	0.6	50	4	2	P-UMIB0032	.01	.04	.08
0.4	0.2	0.7	50	4	2	P-UMIB0042	.01	.04	.08
0.5	0.25	0.8	50	4	2	P-UMIB0052	.01	.04	.08
0.6	0.3	0.9	50	4	2	P-UMIB0062	.01	.04	.08
0.7	0.35	1.4	50	4	2	P-UMIB0072	.01	.04	.08
0.8	0.4	1.6	50	4	2	P-UMIB0082	.01	.04	.08
0.9	0.45	1.8	50	4	2	P-UMIB0092	.01	.04	.08
1	0.5	2	50	4	2	P-UMIB0102	.01	.04	.08
1.1	0.55	2.2	50	4	2	P-UMIB0112	.01	.04	.08
1.2	0.6	2.4	50	4	2	P-UMIB0122	.01	.04	.08
1.3	0.65	2.6	50	4	2	P-UMIB0132	.01	.04	.08
1.4	0.7	2.8	50	4	2	P-UMIB0142	.01	.04	.08
1.5	0.75	3	50	4	2	P-UMIB0152	.01	.04	.08
1.6	0.8	3.2	50	4	2	P-UMIB0162	.01	.04	.08
1.7	0.85	3.4	50	4	2	P-UMIB0172	.01	.04	.08
1.8	0.9	3.6	50	4	2	P-UMIB0182	.01	.04	.08
1.9	0.95	3.8	50	4	2	P-UMIB0192	.01	.04	.08
2	1	4	50	4	2	P-UMIB0202	.01	.04	.08
2.1	1.05	4.2	50	4	2	P-UMIB0212	.01	.04	.08
2.2	1.1	4.4	50	4	2	P-UMIB0222	.01	.04	.08
2.3	1.15	4.6	50	4	2	P-UMIB0232	.01	.04	.08
2.4	1.2	4.8	50	4	2	P-UMIB0242	.01	.04	.08
2.5	1.25	5	50	4	2	P-UMIB0252	.01	.04	.08
2.6	1.3	5.2	50	4	2	P-UMIB0262	.01	.04	.08
2.7	1.35	5.4	50	4	2	P-UMIB0272	.01	.04	.08
2.8	1.4	5.6	50	4	2	P-UMIB0282	.01	.04	.08
2.9	1.45	5.8	50	4	2	P-UMIB0292	.01	.04	.08
3	1.5	6	50	4	2	P-UMIB0302	.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-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					
ALTiBN	◎	◎	◎	◎	○		○				
ZrN-S	◎	◎	◎	○	○			○			
nACRo	◎	◎	◎	◎	○		◎	○	○		

Unit/單位: mm