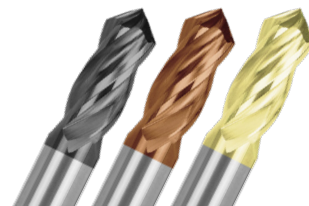
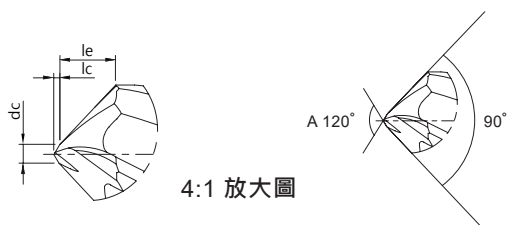
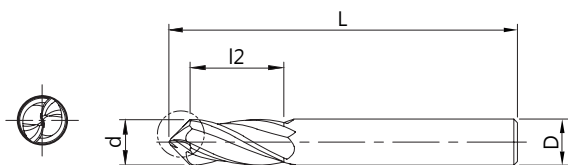


Positioning / Side Milling Chamfer End Mill - 4 Flutes 定位、雕刻、側銑 120-90 度多功能 S 型倒角刀 - 4 刃



切削條件表 **P186**
Cutting Condition



MODE 型號	Diameter d 刃徑	A Angle A 角度	120°		90°	Full Length L全長	Flute Z刃數	Coating			List Price 最低售價	
			dc	lc	le			L2	AITiBN	TiSiN		ZrN-A
SCDM0604-90	6	120°-90°	1.04	0.3	2.48	12	50	4	.01	.02	.03	360
SCDM0804-90	8		1.39	0.4	3.31	16	60	4	.01	.02	.03	650
SCDM1004-90	10		1.73	0.5	4.13	20	75	4	.01	.02	.03	800
SCDM1204-90	12		2.08	0.6	4.96	24	75	4	.01	.02	.03	950

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						
AITiBN	◎	◎	○	○			○					
Si	○	○	○	◎								
ZrN-A	◎	◎	○	○			○	○				

SSM/SCDM Chamfer End Mill
SSM/SCDM 倒角銑刀

TSAE/TAE

產品規格表 **P30**

Specification page

SCDM

產品規格表 **P31-32**

Specification page

WORK MATERIAL 被切削材	MILD STEELS, CARBON STEELS, CAST IRON SS400、S55C、FC250 (~750N/mm ²) 一般構造用鋼、碳素鋼、鑄鐵		ALLOY STEELS, TOOL STEELS SCM、SKT、SKS、SKD (~30HRC) 合金鋼、工具鋼		HARDENED STEELS, PREHARDENED STEELS SKT、SKD、NAK55、HPM1 (30-38HRC) 調質鋼、預硬鋼		STAINLESS STEELS, HARDENED STEELS SUS304、SKD (38-45HRC)不鏽鋼、調質鋼		HARDENED STEELS, TITANIUM ALLOY STEELS (45-55HRC) 調質鋼、鈦合金		MAGNALIUM ALLOY, TITANIUM, TITANIUM ALLOY 鋁鎂合金、鈦及鈦合金	
MILL DIA. (mm) 直徑	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速
Cutting Type 切削條件	Chamfer 倒角	Hole Chamfer/ Centering 孔倒角/ 定點	Chamfer 倒角	Hole Chamfer/ Centering 孔倒角/ 定點	Chamfer 倒角	Hole Chamfer/ Centering 孔倒角/ 定點	Chamfer 倒角	Hole Chamfer/ Centering 孔倒角/ 定點	Chamfer 倒角	Hole Chamfer/ Centering 孔倒角/ 定點	Chamfer 倒角	Hole Chamfer/ Centering 孔倒角/ 定點
Vc	80-140	40-70	60-100	30-50	30-80	15-40	20-50	10-25	15-40	7.5-20	120-200	60-100
Diameter 直徑(mm)	fz (mm/z)	fz (mm/rev)	fz (mm/z)	fz (mm/rev)	fz (mm/z)	fz (mm/rev)	fz (mm/z)	fz (mm/rev)	fz (mm/z)	fz (mm/rev)	fz (mm/z)	fz (mm/rev)
6	0.05	0.075	0.045	0.0675	0.045	0.0675	0.035	0.0525	0.03	0.045	0.07	0.105
8	0.06	0.09	0.055	0.0825	0.055	0.0825	0.04	0.06	0.035	0.0525	0.08	0.12
10	0.07	0.105	0.065	0.0975	0.065	0.0975	0.045	0.0675	0.04	0.06	0.09	0.135
12	0.08	0.12	0.075	0.1125	0.075	0.1125	0.05	0.075	0.045	0.0675	0.1	0.15
DEPTH OF CUT 加工深度	