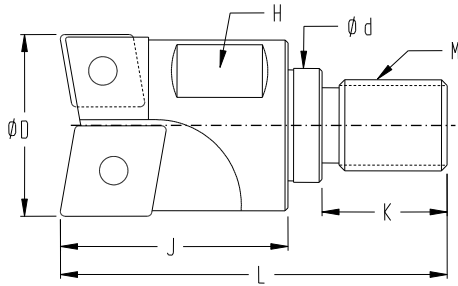


鑽銑刀 (接合式)

POCKETING / END MILLING CUTTER



規格 SPECIFICATION	φD	J	φd	L	M	K	H	刀片規格 INSERTS	刀片螺絲 INSERT SCREW	板手 WRENCH	刀數 NO.OF INSERT	
												
PEM12M06	12	20	6.5	35	M6	11	9	MPFW0402PPTR	IS204527	T 6	2	
								MPMT060204	IS250538	T 8		
PEM16M08	16	30	8.5	50	M8	15	12	CCMT060208	IS250638	T 8		
								CPMT080208	IS306545	T 9		
PEM20M10	20	35	10.5	56	M10	15	15	CPMT080208	IS307545	T 9		
								CPMT090308	IS400855	T 15		
PEM25M12	25	40	12.5	66	M12	20	20	CPMT090308	IS409555	T 15		
								CPMT120308Z	IS401155			
PEM32M16	32	40	17	68	M16	22	27	CPMT120408	IS501170	T 20		
								CPMT160408Z				
XPEM32M16	32	40	17	68	M16	22	27	MPMT060204	IS250638	T 8		3
								CPMT090308	IS401155	T 15		
								CPMT120408	IS501170	T 20		

建議切削條件一覽表 Recommended Cutting Conditions

工件材質 Workpiece Material	Facing 面銑			Drilling 鑽銑	
	速度 Speed Vc (m / min)	每迴轉進給 Feed (mm / rev)	切削深度 D.O.C (mm)	速度 Speed Vc (m / min)	每迴轉進給 Feed (mm / rev)
Unalloyed steels 一般碳鋼	220 - 260	0.10 - 0.25	0.5 - 5.5	80 - 200	0.05 - 0.12
Alloyed steels 合金鋼	100 - 150	0.10 - 0.20	0.5 - 5.5	80 - 180	0.05 - 0.15
Stainless steels 不鏽鋼	140 - 180	0.10 - 0.25	0.5 - 5.5	80 - 200	0.05 - 0.12
Cast Irons 鑄鐵	180 - 300	0.10 - 0.25	0.5 - 5.5	100 - 220	0.05 - 0.18
Non-ferric metal 鋁, 銅, 鎂等非鐵金屬	400 - 750	0.08 - 0.25	0.5 - 5.5	150 - 300	0.05 - 0.22