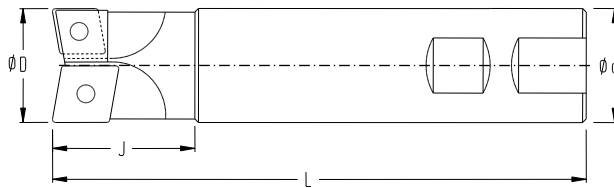


鑽銑刀 (直柄)

POCKETING / END MILLING CUTTER



規格 SPECIFICATION	φD	J	φd	L	刀片規格 INSERTS	刀片螺絲 INSERT SCREW	板手 WRENCH	刃數 NO.OF INSERT	
									
PEM12ST16	12	20	16	90	MPFW0402PPTR	IS204527	T 6	2	
					MPMT060204	IS250538	T 8		
PEM16ST16	16	30	16	100	CCMT060208	IS250638	T 8		
					CPMT080208	IS306545	T 9		
PEM20ST20	20	35	20	110	CPMT080208	IS307545	T 9		
					CPMT090308	IS400855	T 15		
PEM25ST25	25	40	25	130	CPMT090308	IS409555	T 15		
					CPMT120308Z	IS401155			
PEM32ST32	32	40	32	150	CPMT120408	IS501170	T 20		
					CPMT160408Z				
XPEM32ST32	32	40	32	150	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