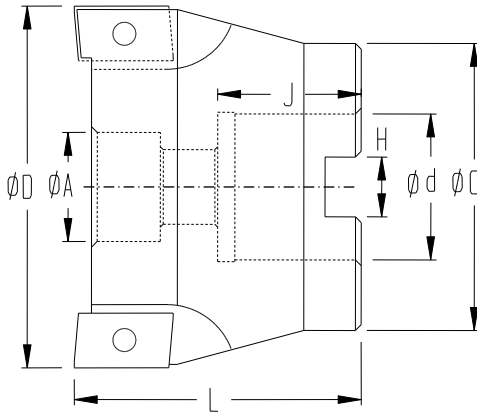


# 直角面銑刀

## SQUARE SHOULDER FACE MILLING CUTTER



規格 SPECIFICATION	φ D	φ d	J	L	H	φ A	φ C	刃數 NO.OF INSERT
FMC40AP16D16	40	16	19	36	8.4	14	35	3
FMC50AP16D22	50	22	20	42	8.4	17	45	4
FMC63AP16D25.4	63	25.4	25	50	10.4	19	50	5
FMC80AP16D31.75	80	31.75	30	50	13	42	65	6
FMC100AP16D31.75	100	31.75	30	50	13	42	80	7

### 部品 PARTS

規格 SPECIFICATION	刀片規格 INSERTS	刀片螺絲 INSERT SCREW	板手 WRENCH
FMC40AP16D16	APMT1604PDER	IS401155	T15
FMC50AP16D22			
FMC63AP16D25.4			
FMC80AP16D31.75			
FMC100AP16D31.75			

### 建議切削條件一覽表 Recommended Cutting Conditions

工件材質 Workpiece Material	Roughing 粗加工			Semi-Finishing 中加工			Finishing 精加工		
	速度 Speed Vc (m/min)	每刃進給 Feed (mm/tooth)	切削深度 D.O.C (mm)	速度 Speed Vc (m/min)	每刃進給 Feed (mm/tooth)	切削深度 D.O.C (mm)	速度 Speed Vc (m/min)	每刃進給 Feed (mm/tooth)	切削深度 D.O.C (mm)
Unalloyed steels 一般碳鋼	180 - 220	0.14 - 0.25	4.5 ↑	220 - 260	0.12 - 0.30	2.0 - 4.5	220 - 300	0.08 - 0.35	0.2 - 2.0
Alloyed steels 合金鋼	70 - 110	0.12 - 0.20	4.5 ↑	100 - 150	0.10 - 0.25	2.0 - 4.5	100 - 195	0.08 - 0.30	0.2 - 2.0
Stainless steels 不鏽鋼	100 - 160	0.10 - 0.20	4.5 ↑	140 - 180	0.08 - 0.20	2.0 - 4.5	180 - 230	0.05 - 0.25	0.2 - 2.0
Cast Irons 鑄鐵	140 - 280	0.10 - 0.15	4.5 ↑	180 - 300	0.10 - 0.20	2.0 - 4.5	200 - 350	0.05 - 0.25	0.2 - 2.0
Non-ferrous metal 鋁、銅、鎂等非鐵金屬	275 - 450	0.05 - 0.20	4.5 ↑	400 - 750	0.05 - 0.20	2.0 - 4.5	700 - 1000	0.05 - 0.25	0.2 - 2.0