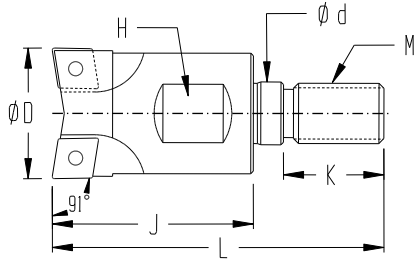
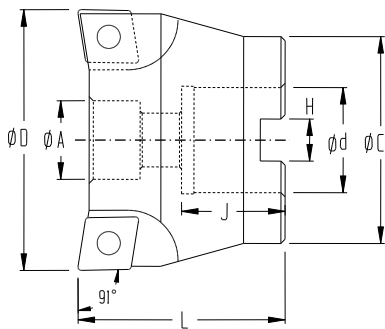


91° 端銑刀 (接合式)

END MILLING CUTTER (91°)



規格 SPECIFICATION	φ D	J	φ d	L	M	K	H	刀片規格 INSERTS	刀片螺絲 INSERT SCREW	板手 WRENCH	刃數 NO. OF INSERT
CEM17CC06M08	17	30	8.5	50	M8	15	12	CCMT060204	IS250638	T 8	2
CEM21CC06M10	21	35	10.5	56	M10	15	15				3
CEM26CP08M12	26	40	12.5	66	M12	20	21	CPMT080204	IS250638	T8	3
CEM26CP08M12-A	26	40	14	66	M12	20	21				
CEM33CP09M16	33	40	17	68	M16	22	27	CPMT090308	IS401055	T 15	3
CEM33CP09M16-A	33	40	22	68	M16	22	27		IS401155		
CEM40CP12M16	40	40	22	66	M16	22	32	CPMT120408	IS501170	T20	3
CEM40CP12M22	40	40	25	75	M22	25	35				



規格 SPECIFICATION	φ D	J	φ d	L	H	φ A	φ C	刀片規格 INSERTS	刀片螺絲 INSERT SCREW	板手 WRENCH	刃數 NO. OF INSERT
CEM63CP12D25.4	63	25	25.4	50	10.15	19	50	CPMT120408	IS501170	T20	4

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	150 - 200	0.10 - 0.20	3.5 ↑	200 - 240	0.10 - 0.15	1.0 - 3.5	220 - 260	0.10 - 0.15	0.2 - 1.0
Alloyed steels 合金鋼	80 - 150	0.10 - 0.20	3.5 ↑	100 - 150	0.10 - 0.15	1.0 - 3.5	120 - 220	0.10 - 0.15	0.2 - 1.0
Stainless steels 不鏽鋼	100 - 160	0.10 - 0.20	3.5 ↑	140 - 180	0.10 - 0.15	1.0 - 3.5	180 - 230	0.10 - 0.15	0.2 - 1.0
Cast Irons 鑄鐵	150 - 250	0.10 - 0.20	3.5 ↑	180 - 300	0.10 - 0.15	1.0 - 3.5	200 - 350	0.10 - 0.15	0.2 - 1.0
Non-ferrous metal 鋁, 銅, 鎂等非鐵金屬	250 - 500	0.08 - 0.25	3.5 ↑	400 - 750	0.04 - 0.15	1.0 - 3.5	700 - 1000	0.10 - 0.15	0.2 - 1.0