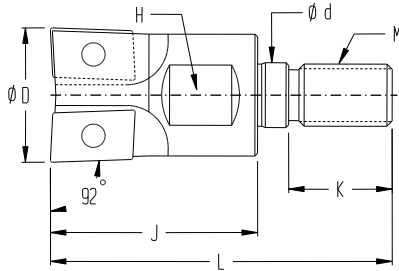
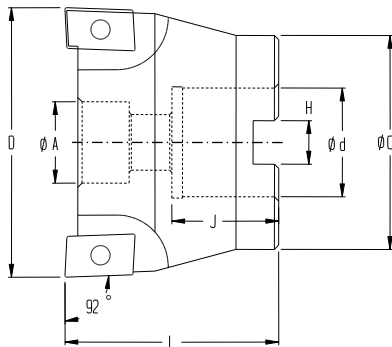


92° 端銑刀 END MILLING CUTTER (92°)



規格 SPECIFICATION	φD	J	φd	L	M	K	H	刀片規格 INSERTS	刀片螺絲 INSERT SCREW	板手 WRENCH	刃數 NO. OF INSERT
HEM21AP12M10	21	35	10.5	56	M10	15	15	APET120204SR	IS350855	T 15	2
HEM26AD16M12	26	40	12.5	66	M12	20	21	ADET160304SR	IS401155	T 15	2
HEM26AD16M12-A	26	40	14	66	M12	20	21				
HEM33AD16M16	33	40	17	68	M16	22	27	ADET160304SR	IS401155	T 15	3
HEM33AD16M16-A	33	40	22	68	M16	22	27				
HEM40AD16M22	40	40	25	75	M22	25	35	ADET160304SR	IS401155	T 15	3



規格 SPECIFICATION	φD	φd	J	L	H	φA	φC	刀片規格 INSERTS	刀片螺絲 INSERT SCREW	板手 WRENCH	刃數 NO. OF INSERT
HEM40AD16D16	40	16	19	36	8.4	14	37.5	ADET160304SR	IS401155	T 15	3
HEM63AD16D25.4	63	25.4	25	50	10.15	19	50	ADET160304SR	IS401155	T 15	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	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-ferric 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