

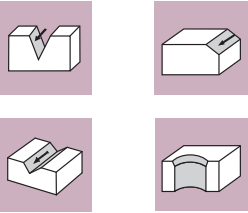
E106X / E107X 超微粒鎢鋼塗層倒角用立銑刀60° / 90° / 120°

End Mills For Chamfering 60° / 90° / 120°

MG Carbide **AlTiN X-NaNO**



Type of Operation



Work Material

P	H	M	K	N	S
●	●	○	●	●	○

P 鋼鐵 Steel

H 硬化鋼 <38HRC Hardened Steel

H 硬化鋼 <48HRC Hardened Steel

M 不銹鋼 Stainless Steel

K 鑄鐵 Cast Iron

N 鋁 Aluminium

N 銅 Copper

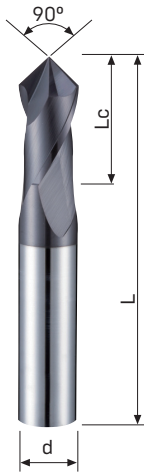
Feature of product:

E106 / E106X-60° 2刃倒角立銑刀
 E107 / E107X-90° 2刃倒角立銑刀
 E107 / E107X-120° 2刃倒角立銑刀
 適用於鑽孔、倒角、深頭孔、定點鑽、及輪廓銑削。
 無塗層鋁合金專用刀。



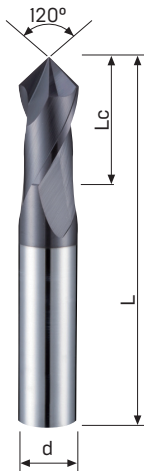
Code No. E106X-60°-Dc

Dc 0 -0.02	Lc mm	L mm	d h6	Bright E106-60°	AlTiN E106X-60°
1	2	38	3	●	●
2	4	38	3	●	●
3	6	50	3	●	●
4	8	50	4	●	●
5	12	50	6	●	●
6	12	50	6	●	●
8	16	60	8	●	●
10	20	72	10	●	●
12	24	75	12	●	●
16	32	100	16	●	●
20	40	100	20	●	●



Code No. E107X-90°-Dc

Dc 0 -0.02	Lc mm	L mm	d h6	Bright E107-90°	AlTiN E107X-90°
0.5	1	38	3		●
0.6	1.2	38	3		●
0.8	1.6	38	3		●
1	2	38	3	●	●
1.2	2.4	38	3		●
1.5	3	38	3		●
1.8	3.6	38	3		●
2	4	38	3	●	●
2.5	5	38	3		●
3	6	50	3	●	●
4	8	50	4	●	●
5	12	50	6	●	●
6	12	50	6	●	●
8	16	60	8	●	●
10	20	72	10	●	●
12	24	75	12	●	●
16	32	100	16	●	●
20	40	100	20	●	●



Code No. E107X-120°-Dc

Dc 0 -0.02	Lc mm	L mm	d h6	Bright E107-120°	AlTiN E107X-120°
1	2	38	3	●	●
2	4	38	3	●	●
3	6	50	3	●	●
4	8	50	4	●	●
5	12	50	6	●	●
6	12	50	6	●	●
8	16	60	8	●	●
10	20	72	10	●	●
12	24	75	12	●	●
16	32	100	16	●	●
20	40	100	20	●	●

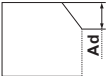
E106X / E107X 切削條件參考表

Recommended Milling Conditions

E106X / Chamfering 倒角加工

被削材 Work Material		GR.1 碳鋼 Carbon Steel		GR.2 低合金鋼 Low-alloyed Steel (~24HRC)		GR.3 高合金鋼 Hi-alloyed Steel (~30HRC)		GR.4 硬化鋼 Hardened Steel (30~38HRC)		GR.5 硬化鋼 Hardened Steel (38~48HRC)		GR.8 不銹鋼 Stainless Steel 使用切削液		GR.9 鑄鐵 Cast Iron		GR.10 鋁 Aluminium	
切削速度 Vc m/min		40~70		40~70		40~70		30~50		30~50		30~50		40~70		100~200	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)
E106X-1	1	17,500	1050	17,500	1050	17,500	1050	9,550	286	9,550	286	9,550	286	17,500	1050	31,830	2,864
E106X-2	2.0	11,670	700	11,670	700	11,670	700	4,774	143	4,774	143	4,774	143	11,670	700	15,915	1,432
E106X-3	3	8,753	525	8,753	525	8,753	525	3,183	100	3,183	100	3,183	100	8,753	525	10,610	954
E106X-4	4.0	7,000	420	7,000	420	7,000	420	3,183	100	3,183	100	3,183	100	7,000	420	9,550	955
E106X-5	5	5,729	343	5,729	343	5,729	343	2,546	100	2,546	100	2,546	100	5,729	343	7,639	763
E106X-6	6.0	4,774	286	4,774	286	4,774	286	2,122	90	2,122	90	2,122	90	4,774	286	6,366	700
E106X-8	8	3,580	358	3,580	358	3,580	358	1,989	120	1,989	120	1,989	120	3,580	358	5,570	668
E106X-10	10.0	2,864	286	2,864	286	2,864	286	1,591	95	1,591	95	1,591	95	2,864	286	4,456	712
E106X-12	12	2,387	238	2,387	238	2,387	238	1,591	127	1,591	127	1,591	127	2,387	238	3,978	716
E106X-16	16.0	1,790	116	1,790	116	1,790	116	1,193	119	1,193	119	1,193	119	1,790	116	2,984	537
E106X-20	20	1,432	186	1,432	186	1,432	186	954	95	954	95	954	95	1,432	186	2,387	477

E107X / Chamfering / V groove machining 倒角加工 / V槽加工

被削材 Work Material		GR.1 碳鋼 Carbon Steel		GR.2 低合金鋼 Low-alloyed Steel (~24HRC)		GR.3 高合金鋼 Hi-alloyed Steel (~30HRC)		GR.4 硬化鋼 Hardened Steel (30~38HRC)		GR.5 硬化鋼 Hardened Steel (38~48HRC)		GR.10 鋁 Aluminium	
切削速度 Vc m/min		Ø0.5~0.8 48~50 Ø1.0~3.0 55~70 Ø3.1~20 90		Ø0.5~0.8 48~50 Ø1.0~3.0 55~70 Ø3.1~20 90		Ø0.5~0.8 48~50 Ø1.0~3.0 55~70 Ø3.1~20 90		Ø0.5~0.8 40 Ø1.0~3.0 45~65 Ø3.1~20 75		Ø0.5~0.8 40 Ø1.0~3.0 45~65 Ø3.1~20 75		Ø0.5~0.8 50 Ø1.0~3.0 60~95 Ø3.1~20 120	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)
E107X-0.5	0.5	31,000	460	31,000	460	31,000	460	25,480	320	25,480	320	32,000	650
E107X-0.6	0.6	27,000	500	27,000	500	27,000	500	21,230	320	21,230	320	26,540	700
E107X-0.8	0.8	21,500	530	21,500	530	21,500	530	15,920	350	15,920	350	19,900	750
E107X-1.0	1	17,500	530	17,500	530	17,500	530	14,330	350	14,330	350	17,510	800
E107X-1.2	1.2	15,000	600	15,000	600	15,000	600	13,270	360	13,270	360	14,590	850
E107X-1.5	1.5	12,500	620	12,500	620	12,500	620	10,610	360	10,610	360	12,740	900
E107X-1.8	1.8	10,500	630	10,500	630	10,500	630	9,730	380	9,730	380	10,610	950
E107X-2.0	2	9,700	630	9,700	630	9,700	630	9,555	380	9,555	380	10,350	980
E107X-2.5	2.5	8,200	650	8,200	650	8,200	650	7,640	400	7,640	400	10,192	1,010
E107X-3.0	3	7,430	670	7,430	670	7,430	670	6,900	410	6,900	410	10,080	1,150
E107X-4.0	4	7,200	650	7,200	650	7,200	650	6,000	360	6,000	360	9,600	860
E107X-5.0	5	5,730	515	5,730	515	5,730	515	4,770	290	4,770	290	7,645	690
E107X-6.0	6	4,800	430	4,800	430	4,800	430	4,000	240	4,000	240	6,400	580
E107X-8.0	8	3,600	430	3,600	430	3,600	430	3,000	180	3,000	180	4,800	580
E107X-10.0	10	2,900	410	2,900	410	2,900	410	2,400	140	2,400	140	3,800	530
E107X-12.0	12	2,400	336	2,400	336	2,400	336	2,000	120	2,000	120	3,200	510
E107X-16.0	16	1,800	252	1,800	252	1,800	252	1,500	100	1,500	100	2,400	400
E107X-20.0	20	1,400	196	1,400	196	1,400	196	1,200	95	1,200	95	1,900	340
切入深度 (mm)		≤ 0.3 D		≤ 0.3 D		≤ 0.3 D		≤ 0.3 D		≤ 0.3 D		≤ 0.3 D	

※ Pls. set up the feed speed under the 50% of conditions we described as above when you do the processing of V groove.

※ The standard of Ap[cutting depth] is 0.3d.

※ V槽加工時，進給速度請以上述條件的50%以下使用。

※ Ad(切入深度)以0.3d為基準。

超微粒鎢鋼塗層倒角用立銑刀

Chamfer Mills

2 Flute Chamfering 60°&90°

MG
CarbideBright
AlTiN

Code No: E106-DC-60°

Code No: E107-DC-90°

Work Material

P	H	M	K	N	S
●	●	○	●	●	○

P	鋼鐵 Steel
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H	硬化鋼 <48HRC Hardened Steel
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M	不銹鋼 Stainless Steel
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K	鑄鐵 Cast Iron
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N	鋁 Aluminium
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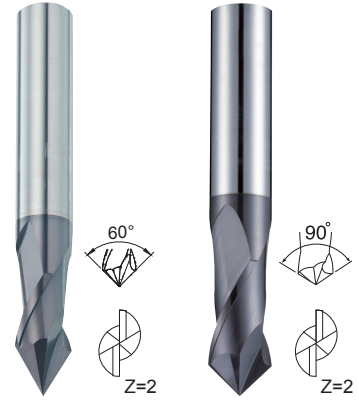
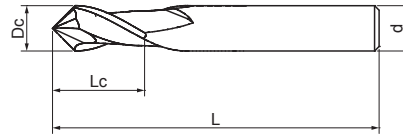
N	銅 Copper
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Tolerance: DC

All Sizes: +0/-0.001"

Feature of product:

適用於鑽孔、倒角、深頭孔、定點鑽、及輪廓銑削。



Standard Length

Dc 0 -0.001"	Lc Inch	L Inch	d h6	Bright E106	AlTiN E106X	Bright E107	AlTiN E107X
1/16	3/16	1-1/2	1/8	●	●	●	●
3/32	3/8	1-1/2	1/8	●	●	●	●
1/8	1/2	1-1/2	1/8	●	●	●	●
3/16	5/8	2	3/16	●	●	●	●
1/4	3/4	2-1/2	1/4	●	●	●	●
5/16	13/16	2-1/2	5/16	●	●	●	●
3/8	1	2-1/2	3/8	●	●	●	●
7/16	1	2-3/4	7/16	●	●	●	●
1/2	1	3	1/2	●	●	●	●
5/8	1-1/4	3-1/2	5/8	●	●	●	●
3/4	1-1/2	4	3/4	●	●	●	●