

E233SX 超微粒鎢鋼塗層不銹鋼用立銑刀

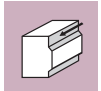
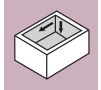
End Mills for Stainless

MG
Carbide

AlTiXN+ZrN
SX



Type of Operation



Work Material

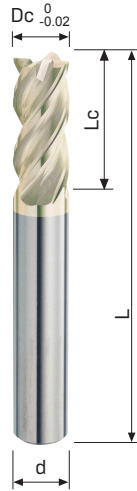
P	H	M	K	N	S
		●			●

M 不銹鋼
Stainless Steel

S 鈦合金
Titanium

S 鎳
Nickel

S 高溫合金
High Temp Alloys



Code No. E233SX-Dc				
Dc	Lc	L	d	AlTiXN+ZrN E233SX
$\begin{matrix} 0 \\ -0.02 \end{matrix}$	mm	mm	h6	
3	8	50	6	●
4	11	50	6	●
5	13	50	6	●
6	16	50	6	●
8	20	60	8	●
10	22	72	10	●
12	26	75	12	●

Feature of product:


4刃不銹鋼用立銑刀
適用於粗、精切削應用於難削材料。

刀口鋒利適用切削於鋼鐵、不銹鋼、鈦合金、鎳基合金及高溫合金…等材料。


E233SX 切削條件參考表

Recommended Milling Conditions

Side Milling 側面切削

被削材 Work Material		GR.8 不銹鋼 Stainless Steel	
切削速度 Vc m/min		75	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min ⁻¹)	Feed 進給速度 (mm/min)
E233SX-3	3	7,650	600
E233SX-4	4	6,050	700
E233SX-5	5	5,000	770
E233SX-6	6	4,200	830
E233SX-8	8	3,100	800
E233SX-10	10	2,600	710
E233SX-12	12	2,100	670
E233SX-16	16	1,600	550
E233SX-20	20	1,250	510
切入深度 (mm) 		ap:1.5D	
		ae:0.1D	

Slotting 溝切削

被削材 Work Material		GR.8 不銹鋼 Stainless Steel	
切削速度 Vc m/min		70	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min ⁻¹)	Feed 進給速度 (mm/min)
E233SX-3	3	7,450	450
E233SX-4	4	5,500	500
E233SX-5	5	4,500	530
E233SX-6	6	3,700	550
E233SX-8	8	2,800	525
E233SX-10	10	2,300	465
E233SX-12	12	1,850	430
E233SX-16	16	1,400	370
E233SX-20	20	1,100	330
切入深度 (mm) 		ap:0.5D	

1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.

1. 請使用剛性好、精度高的設備和夾具。
2. 請選擇適用於工件材料的切削液。
3. 此切削條件表中的數值為切削條件的基準值，實際加工時，請考慮加工形狀、目的、使用機台等因素，對切削條件進行調整。
4. 如果機台轉速低於表中所列數值，則進給速度應與轉速按同一比例降低。
5. 切削加工時如果發生振顫，請降低切削條件。