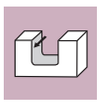
E235-2.5SX / 5.0SX 超微粒鎢鋼塗層不銹鋼用R角立銑刀

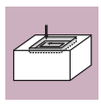
End Mills With Corner Radius for Stainless

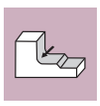
MG Carbide

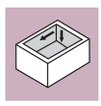
AlTiXN+ZrN SX

Type of Operation









Work Material

P	H	M	K	N	S
		●			●

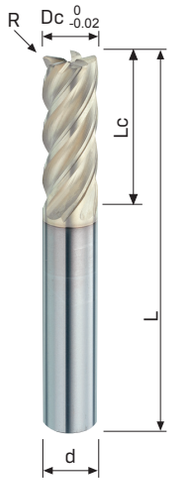
M	不銹鋼 Stainless Steel
S	鈦合金 Titanium
S	鎳 Nickel
S	高溫合金 High Temp Alloys

Feature of product:

5刃不銹鋼用立銑刀

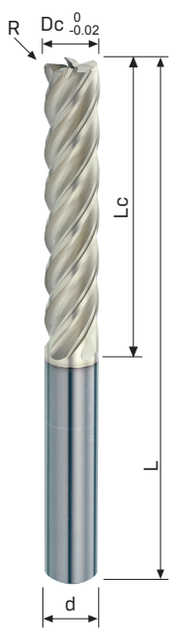
適用於粗、精切削應用於難削材料。

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。



Code No. E235-2.5SX-Dc×R

Dc 0 -0.02	R ±0.01	Lc mm	L mm	d h6	AlTiXN+ZrN E235-2.5SX
6	0.5	15	50	6	●
8	0.5	20	60	8	●
10	0.5	25	72	10	●
12	0.5	30	75	12	●
16	0.5	40	100	16	●
20	0.5	50	100	20	●



Code No. E235-5.0SX-Dc×R

Dc 0 -0.02	R ±0.01	Lc mm	L mm	d h6	AlTiXN+ZrN E235-5.0SX
6	0.5	30	75	6	●
8	0.5	40	90	8	●
10	0.5	50	100	10	●
12	0.5	60	110	12	●
16	0.5	80	160	16	●
20	0.5	100	200	20	●

E235-2.5SX / 5.0SX 切削條件參考表

Recommended Milling Conditions

E235-2.5SX / 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)
E235-2.5SX-6	6	4,200	990
E235-2.5SX-8	8	3,100	960
E235-2.5SX-10	10	2,600	850
E235-2.5SX-12	12	2,100	800
E235-2.5SX-16	16	1,600	660
E235-2.5SX-20	20	1,250	615
切入深度 （mm） 		ap:1.5D	
		ae:0.1D	

E235-5.0SX / 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)
E235-5.0SX-6	6	2,120	500
E235-5.0SX-8	8	1,590	475
E235-5.0SX-10	10	1,275	410
E235-5.0SX-12	12	1,060	400
E235-5.0SX-16	16	800	300
E235-5.0SX-20	20	640	250
切入深度 （mm） 		ap:3.0D	
		ae:0.05D	

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。