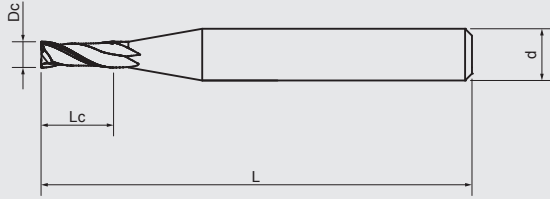


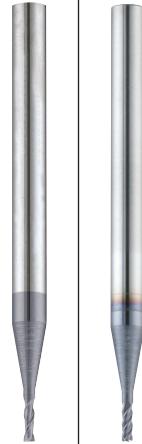
E102HX / E104HX 超微粒鎢鋼塗層通用立銑刀 / 精加工立銑刀

Universal End Mills / Finishing End Mills

Small diameter series with specification in step of 0.1mm. 小徑系列每0.1mm一種尺寸規格。
 Good wear resistance and lubricating effect with Nano multilayer coating. 採用奈米多層膜塗層具有優異的潤滑及耐磨性。



VHM Carbide AlTiCrN HX 30° N 90° Steel <48HRC



Suitable for cutting different steels below 48HRC as well as cast iron. 適用切削於48HRC以下各種鋼材及鑄鐵。
 Various application for general cutting. 泛用於一般切削加工應用。

P H K P H K

Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	E102HX AlTiCrN	E104HX AlTiCrN				
0.2	0.5	38	3	●					
0.3	0.8	38	3	●					
0.4	1	38	3	●					
0.5	1.2	38	3	●					
0.6	1.5	38	3	●					
0.7	1.8	38	3	●					
0.8	2	38	3	●					
0.9	2.5	38	3	●					
1	3	38	3	●	●				
1.1	3	38	3	●	●				
1.2	4	38	3	●	●				
1.3	4	38	3	●	●				
1.4	4	38	3	●	●				
1.5	5	38	3	●	●				
1.6	5	38	3	●	●				
1.7	5	38	3	●	●				
1.8	5	38	3	●	●				
1.9	5	38	3	●	●				
2	6	38	3	●	●				
2.1	6	38	3	●	●				
2.2	6	38	3	●	●				
2.3	6	38	3	●	●				
2.4	8	38	3	●	●				
2.5	8	38	3	●	●				
2.6	8	38	3	●	●				
2.7	8	38	3	●	●				
2.8	8	38	3	●	●				
2.9	8	38	3	●	●				
3	8	38	3	●	●				

切削條件

Cutting Conditions

E102HX E104HX		E102HX		E102HX		E104HX		E104HX	
		cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)
Carbon Steel Materials									
P	GR1 Carbon Steel	120	0.0015xDc	120	0.0018xDc	120	0.0015xDc	120	0.0018xDc
	GR2 <24HRC Low-alloyed Steel	120	0.0015xDc	120	0.0018xDc	120	0.0015xDc	120	0.0018xDc
	GR3 <30HRC Hi-alloyed Steel	80	0.0012xDc	80	0.0015xDc	80	0.0012xDc	80	0.0015xDc
Hardened Steel Materials									
H	GR4 30-38HRC Hardened Steel	60	0.001xDc	65	0.001xDc	60	0.001xDc	65	0.001xDc
	GR5 38-48HRC Hardened Steel	55	0.001xDc	60	0.001xDc	55	0.001xDc	60	0.001xDc
Cast Iron Materials									
K	GR9-1 Grey cast iron	120	0.0015xDc	120	0.0018xDc	120	0.0015xDc	120	0.0018xDc
	GR9-2 Nodular cast iron	120	0.0015xDc	120	0.0018xDc	120	0.0015xDc	120	0.0018xDc

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。