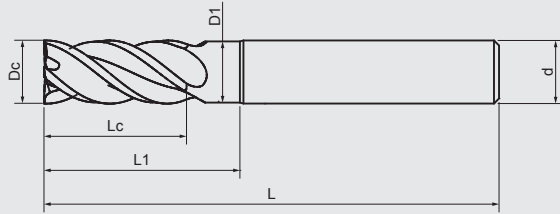


F524SX / F525SX 超微粒鎢鋼塗層超能切立銑刀

Premium Cut End Mills

Two unequal flutes, and small edge cutting land with the relief angle, with better impact resistance. Designed with high removal cutting geometry. The use of Si-silicon AlTiSiN coating has excellent wear resistance.

兩個不等分劃刃。刃徑的離隙角有小刃帶設計，具有耐衝擊特性。高移除率刀形幾何設計。採用Si硅系AlTiSiN塗層具有優異的耐磨性。

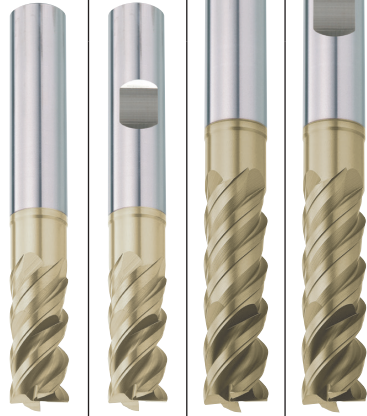


VHM Carbide

AlTiXN+ZrN SX



Steel <48HRC



Improved cutting edge strength for cutting different materials below 48HRC, stainless steel, cast iron as well as aluminium.

Application from roughing to finishing cutting, drilling, ramping... in different materials.

強度增加更適用切削48HRC以下的各種鋼材並可切削不銹鋼和鑄鐵亦可切削鋁合金適用。於粗、中、精切削、鑽孔、斜插進給...多功能應於各種材料。

P
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DIN 6527 Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	L1 mm	D1 mm	45° mm	F524SX HA	F524SX HB				
3	8	57	6	14	2.8	0.10	●	●				
4	11	57	6	16	3.8	0.10	●	●				
5	13	57	6	18	4.8	0.15	●	●				
6	13	57	6	20	5.8	0.15	●	●				
8	19	63	8	26	7.7	0.15	●	●				
10	22	72	10	31	9.7	0.20	●	●				
12	26	83	12	37	11.6	0.20	●	●				
14	26	83	14	37	13.5	0.20	●	●				
16	32	92	16	43	15.5	0.20	●	●				
18	32	92	18	43	17.5	0.20	●	●				
20	38	104	20	53	19.5	0.20	●	●				

Long Length

Dc 0 -0.02	Lc mm	L mm	d h5	L1 mm	D1 mm	45° mm			F525SX HA	F525SX HB		
6	19	63	6	26	5.8	0.15			●	●		
8	28	72	8	35	7.7	0.15			●	●		
10	34	84	10	43	9.7	0.20			●	●		
12	40	97	12	51	11.6	0.20			●	●		
16	48	108	16	59	15.5	0.20			●	●		
20	56	122	20	71	19.5	0.20			●	●		

切削條件

Cutting Conditions

F524SX F525SX		F524SX		F524SX		F524SX		F524SX		F525SX		F525SX	
								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	0.006xDc	120	0.006xDc	130	0.006xDc	140	0.007xDc	110	0.006xDc	120	0.006xDc
	GR2 <24HRC Low-alloyed Steel	120	0.005xDc	120	0.005xDc	130	0.005xDc	140	0.006xDc	110	0.005xDc	120	0.005xDc
	GR3 <30HRC Hi-alloyed Steel	80	0.005xDc	80	0.005xDc	90	0.005xDc	100	0.006xDc	70	0.005xDc	80	0.005xDc
Hardened Steel Materials													
H	GR4 30-38HRC Hardened Steel	65	0.004xDc	90	0.003xDc	90	0.003xDc	100	0.003xDc	90	0.004xDc	100	0.003xDc
	GR5 38-48HRC Hardened Steel	60	0.003xDc	80	0.003xDc	80	0.003xDc	90	0.003xDc	70	0.003xDc	80	0.003xDc
Stainless Steel Materials													
M	GR8-1 Ferritic, Martensitic	80	0.003xDc	90	0.004xDc	110	0.003xDc	130	0.003xDc	70	0.003xDc	80	0.004xDc
	GR8-2 Austenitic	70	0.003xDc	80	0.003xDc	90	0.003xDc	100	0.003xDc	60	0.003xDc	70	0.003xDc
	GR8-3 Austenitic-ferritic	40	0.002xDc	50	0.003xDc	90	0.002xDc	60	0.002xDc	50	0.002xDc	60	0.003xDc
	GR8-4 Austenitic-ferritic Heat-resistant	30	0.002xDc	40	0.003xDc	40	0.002xDc	50	0.002xDc	40	0.002xDc	50	0.003xDc
Cast Iron Materials													
K	GR9-1 Grey cast iron	110	0.006xDc	110	0.006xDc	120	0.006xDc	130	0.007xDc	100	0.006xDc	110	0.005xDc
	GR9-2 Nodular cast iron	120	0.006xDc	120	0.006xDc	130	0.006xDc	140	0.007xDc	110	0.006xDc	120	0.005xDc

All cutting data serve for orientation only and should be adapted individually to the technical conditions on location

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。