F607ZX 超微粒鎢鋼塗層鋁用立銑刀

Toric End Mills For Aluminium

Designed with three variable helix geometry and three unequal flutes.

Designed with sharp cutting edge, high removal cutting geometry, and fine grinding smooth surface to prevent sticking problem.

Cutting edge with corner radius for profile machining.

Adopting ZrN coating without AlTi in the formula would prevent from chemical affinity with Alu metal and enhance tool life by gaining better surface hardness.

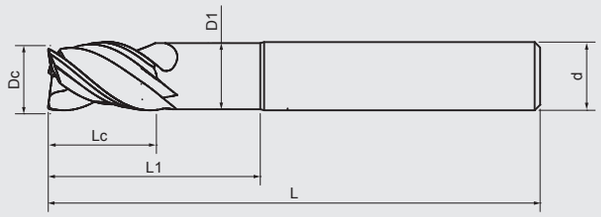
三個不等螺旋角。

三個不等分割刃。

刀口鋒利且高移除率刀形幾何設計及細緻抗沾黏性。

刀尖帶有R角可應用於曲面輪廓切削應用。

採用ZrN氮化鋯塗層不含鋁鈦AlTi配方不會與鋁金屬產生親合作用，並得到表面硬度提高刀具壽命。



VHM Carbide | ZrN ZX | 40° | 不等 3 | N 120° | 90° | Aluminium

Suitable for cutting aluminium.

Application for HPC/ roughing cutting process with high chip removal rate as well as for HSC/ finishing cutting process with fine and smooth surface finishing.

適用切削於鋁合金材料。

可適用於高效率移除材料的粗切削加工應用及曲面輪廓切削應用。

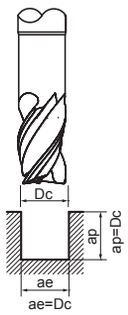
N

DIN 6527 Standard Length

Dc $^{0}_{-0.02}$	Lc mm	L mm	d h5	L1 mm	D1 mm	F607ZX ZrN
3	4.5	57	6	9	2.8	●
4	6	57	6	12	3.7	●
5	7.5	57	6	15	4.6	●
6	9	57	6	20	5.5	●
8	12	63	8	26	7.4	●
10	15	72	10	31	9.2	●
12	18	83	12	37	11	●
16	24	92	16	43	14.5	●
20	30	104	20	53	18.2	●

切削條件

Cutting Conditions

F607ZX									
		 ae=Dc		 ae=0.4xDc		 ae=0.1xDc		 ae=0.02xDc	
		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)
	Aluminium Steel Materials								
N	GRI0-1 Wrought Aluminium alloys	400	0.005xDc	400	0.006xDc	400	0.007xDc	400	0.008xDc
N	GRI0-2 Aluminium cast alloys <10%	400	0.005xDc	400	0.006xDc	400	0.007xDc	400	0.008xDc
N	GRI0-3 Aluminium cast alloys >10%	350	0.005xDc	380	0.006xDc	380	0.007xDc	380	0.008xDc

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。