

F618ZX / F620ZX 極超微粒鎢鋼塗層圓頭立銑刀

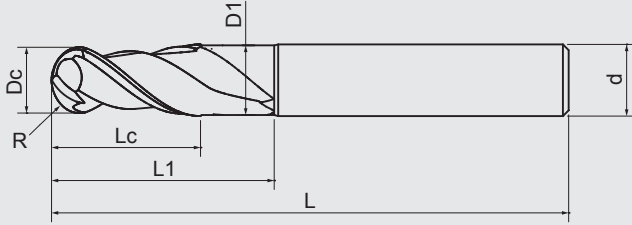
Ball Nose End Mills For Aluminium

40° helix with round cutting edge and mirror sharp grinding on side cutting edge.

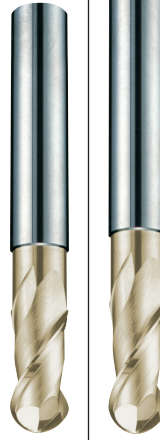
Various applications on Aluminium for curved profile milling.

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

螺旋角40°搭配圓頭刃口及側刃刃口鏡面銳利研磨。可應用於各種鋁合金材質的曲面仿形加工應用。採用奈米ZrN氮化鎢塗層，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、光滑度及降低摩擦係數，提高刀具使用壽命。



VHM Carbide ZrN ZX 40° 2 N U Aluminium



Suitable for cutting aluminium.

Application for roughing cutting with high chip removal rate.

適用切削於鋁合金材料

適用於高效率移除粗切削加工應用。

N N

DIN 6527 Standard Length

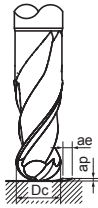
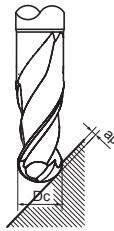
Dc 0 -0.02	R ±0.005	Lc mm	L mm	Lc mm	L1 mm	D1 h5	F618ZX ZrN				
3	1.5R	6	57	6	9	2.8	●				
4	2R	8	57	6	12	3.7	●				
5	2.5R	10	57	6	15	4.6	●				
6	3R	12	57	6	20	5.5	●				
8	4R	16	63	8	26	7.4	●				
10	5R	20	72	10	31	9.2	●				
12	6R	24	83	12	37	11.0	●				

Long Length

Dc 0 -0.02	R ±0.005	Lc mm	L mm	Lc mm	L1 mm	D1 h5		F620ZX ZrN			
3	1.5R	6	70	6	9	2.8		●			
4	2R	8	70	6	12	3.7		●			
5	2.5R	10	80	6	15	4.6		●			
6	3R	12	80	6	20	5.5		●			
8	4R	16	100	8	26	7.4		●			
10	5R	20	100	10	31	9.2		●			
12	6R	24	110	12	37	11.0		●			

切削條件

Cutting Conditions

F618ZX F620ZX								
	cutting speed Vc (m/min)	feed per tooth fz(mm)	ae	ap	cutting speed Vc (m/min)	feed per tooth fz(mm)	ap	
Aluminium Steel Materials								
N	GRI0-1 Wrought Aluminium alloys	800	0.021xDc	0.2xDc	0.05xDc	900	0.016xDc	0.02xDc
	GRI0-2 Aluminium cast alloys <10%	800	0.021xDc	0.2xDc	0.05xDc	900	0.014xDc	0.02xDc
	GRI0-3 Aluminium cast alloys >10%	700	0.020xDc	0.2xDc	0.05xDc	800	0.012xDc	0.02xDc

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。