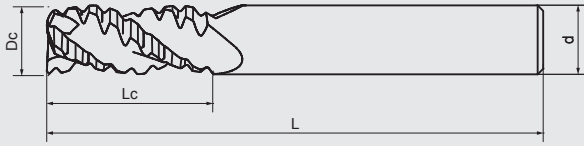


F642ZX / F643ZX 超微粒鎢鋼粗加工塗層鋁用立銑刀

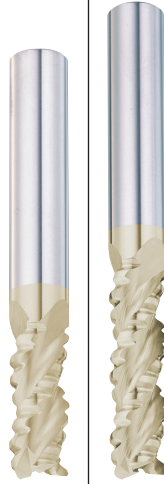
Roughing End Mills For Aluminium

Coarse tooth staggered chip breaker design on cutting flutes are good for easily chip breaking. 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.

粗波浪齒形設計，齒形交錯利於斷屑。採用ZrN氮化鈦塗層不含鋁鈦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° 3 N 0.3-0.5 45° 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重加工應用。

N N

DIN 6527 Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	F642ZX ZrN					
3	8	57	6	●					
4	11	57	6	●					
5	13	57	6	●					
6	13	57	6	●					
8	19	63	8	●					
10	22	72	10	●					
12	26	83	12	●					
16	32	92	16	●					
20	38	104	20	●					

Long Length

Dc 0 -0.02	Lc mm	L mm	d h5		F643ZX ZrN				
6	19	63	6		●				
8	28	72	8		●				
10	34	84	10		●				
12	40	97	12		●				
16	48	108	16		●				
20	56	122	20		●				

切削條件

Cutting Conditions

F642ZX F643ZX					
	cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)	
Aluminium Steel Materials					
N	GR10-1 Wrought Aluminium alloys	400	0.008xDc	400	0.009xDc
	GR10-2 Aluminium cast alloys <10%	400	0.008xDc	400	0.009xDc
	GR10-3 Aluminium cast alloys >10%	350	0.008xDc	380	0.009xDc

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。