

# CX200 4・6枚刃 ハイヘリカル スクエアエンドミル

CX200 Series 4・6-Flute High-helical Square End Mill

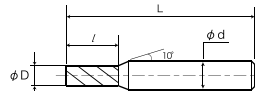
## CX200-PMER



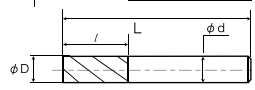
**CX200-PMER6100**

Model Flute D

Type 1



Type 2



### 特性 Features

- Improvement of CX200 Coating have high oxidation resistance and high hardening exceeding the existing coating meet our own high rig requirement to ensure exceptional piece-to-piece conformity and tool life in the processing of prehardened steel and carbon steel
- Combination of Negative radius blade and 45 degree helix blades enables high rigidity and sharpness by high feed speed, with high efficiency
- Positive shaped rake angle, bottom edge corner of the shape edge and 53 degree helix flutes provide best processing of steel, prehardened steel, aluminum and finishing of pocket wall process of Mold base

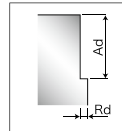
炭素鋼 Carbon Steel	合金鋼 Alloy Steel	調質鋼 Prehardened Steel	焼き入れ鋼 Hardened Steel				鋳鉄 Cast Iron	ステンレス鋼 Stainless Steels	アルミ合金 Aluminium Alloys	銅合金 Copper Alloys	チタン合金 耐熱合金 Ti/Ni Alloy	グラファイト Graphite	樹脂 Resin
			~45HRC	~55HRC	~60HRC	~65HRC							
◎	◎	◎	◎	○			○	◎	○	○			

◎=Best ○=Good

MODEL 型番	D 外径	/ 刃長	L 全長	d シャンク径	Flute 刃数	Type
CX200-PMER4010	1	2.5	60	6	4	1
CX200-PMER4020	2	5	60	6	4	1
CX200-PMER4030	3	10	60	6	4	1
CX200-PMER4040	4	12	60	6	4	1
CX200-PMER4050	5	15	60	6	4	1
CX200-PMER6060	6	15	60	6	6	2
CX200-PMER6080	8	20	75	8	6	2
CX200-PMER6100	10	25	80	10	6	2
CX200-PMER6120	12	30	100	12	6	2
CX200-PMER6160	16	40	110	16	6	2
CX200-PMER6200	20	45	130	20	6	2

# CX200-PMER

### 推奨切削条件 Standard Milling Condition



- The table shows standard milling guidance of perforating process as written picture.
- Use a rigid and precise machine and tool holder.
- Select a cutting fluid appropriate to the particular usage.
- In case the Revolution could not be increased by the machine used, please reduce feed speed and Revolution at same ratio.
- When mounting End Mills, the run out of the lip will have to be set within 0.01mm.
- Down Cut milling is required for side milling processing.
- Reduce milling condition when chattering is occurred in side milling processing.
- For Groove milling, it is recommended to take 80% of feed speed and Revolution written in the table.
- In case of milling for stainless steel, please take wet cut milling.

被削材 Work Material	炭素鋼 Carbon Steel S45-S55C				合金鋼 工具鋼 A Alloy Steel b Tool Steel SKD, SCM				調質鋼 プリハードン鋼 Prehardened Steel 35-40HRC, HPM, JNAK			
	送り速度 (mm/min) Feed rate		回転数 (min <sup>-1</sup> ) Revolution		送り速度 (mm/min) Feed rate		回転数 (min <sup>-1</sup> ) Revolution		送り速度 (mm/min) Feed rate		回転数 (min <sup>-1</sup> ) Revolution	
	Standard	High Speed	Standard	High Speed	Standard	High Speed	Standard	High Speed	Standard	High Speed	Standard	High Speed
1	600	1600	17500	50000	600	1600	17500	50000	500	1600	17500	50000
2	1300	3200	17500	45000	1300	3200	17500	45000	1100	2900	17500	43800
3	1700	3400	14000	30500	1700	3400	14000	30500	1300	3100	13000	29500
4	1700	3800	10500	22800	1700	3800	10500	22800	1300	3400	9500	22000
5	2000	4300	8600	18500	2000	4300	8600	18500	1400	3900	7800	17800
6	2500	5500	6900	15000	2500	5500	6900	15000	1900	5100	6400	14500
8	2600	5600	5200	11300	2600	5600	5200	11300	1900	5100	4800	11000
10	2500	5500	4100	9000	2500	5500	4100	9000	1800	5000	3800	8800
12	2400	5300	3500	7600	2400	5300	3500	7600	1800	4800	3200	7300
16	2200	4900	2600	5700	2200	4900	2600	5700	1700	4400	2400	5500
20	2100	4500	2200	4600	2100	4500	2200	4600	1600	4100	2100	4400
Ad	≤1.5D											
Rd 標準	≤0.1D											
高速	≤0.05D											

スクエア Square

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ラジウス Radius

ボール Ball

ロングネック Long Neck

ラフヤング Roughing

チャンフェリング Chamfering

ドリル Drill

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