

アルミ加工用 4枚刃スクエアエンドミル DLCコート

DLC 4-Flute Square End Mill for Aluminum

DLC-HEM4

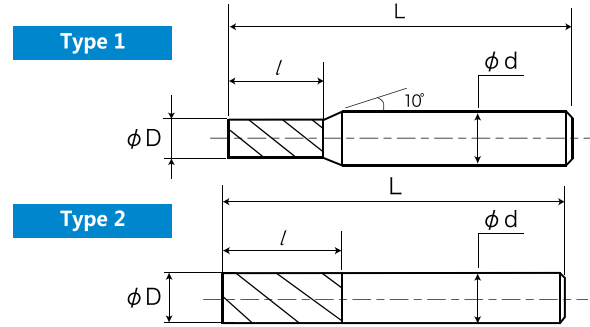


DLC-HEM4010

Model Flute D

特性 Features

- DLC Coating has high abrasion, adhesion and friction resistance. Best for aluminum alloy processing
- Best for drilling, Milling of soft material where the adhesion and the chip packing such as aluminum alloy are generated very easily due to the sharp cutting edge
- 4Flute eliminates chatter and suitable for drilling processing
- CKK Original design Chip pocket enables similar or same cutting depth which 2-flutes could realize



MG
超微粒

45°

Sharp
Edge

DLC
Coat

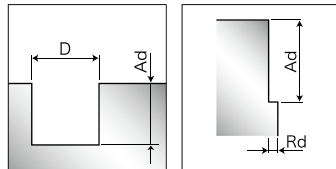
外径公差 Tolerance	0
	-0.02

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	セラファイト Graphite	樹脂 Resin
			~45HRC	~55HRC	~60HRC	~65HRC							
									◎	○		○	

◎ = Best ○ = Good

MODEL 型番	D 外径	l 刃長	L 全長	d シャンク径	Type
DLC-HEM4010	1	2.8	40	4	1
DLC-HEM4015	1.5	4.4	40	4	1
DLC-HEM4020	2	7	40	4	1
DLC-HEM4025	2.5	9	40	4	1
DLC-HEM4030	3	11	50	6	1
DLC-HEM4040	4	14	50	6	1
DLC-HEM4050	5	17	55	6	1
DLC-HEM4060	6	17	55	6	2
DLC-HEM4080	8	22	65	8	2
DLC-HEM4100	10	28	75	10	2
DLC-HEM4120	12	28	80	12	2

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 with in 0.01mm.

被削材 Work Material	アルミニウム合金 Aluminium Alloy			
	送り速度 Feed Rate (mm/min)		回転数 Revolution (min ⁻¹)	
外径 (mm) Diameter	溝切削 Slotting	側面切削 Side Milling		
1	1120	1680	50000	
1.5	1120	1680	48850	
2	1120	1680	47700	
2.5	1290	1940	39700	
3	1460	2200	31800	
4	1460	2200	23900	
5	1460	2200	19100	
6	1460	2200	15900	
8	1460	2200	11900	
10	1460	2200	9500	
12	1460	2200	8000	

切削深度 Depth of Cut	外径 (mm) Diameter		Ad ≤ 1.5D	Rd ≤ 0.2D
	≤ 3	≤ 0.5D		
	> 3	≤ 1.0D		

スクエア Square

スクエア Square

ラジウス Radius

ボール Ball

ロングネック Long Neck

ラフニング Roughing

面取り加工用 Chamfering

ドリル Drill