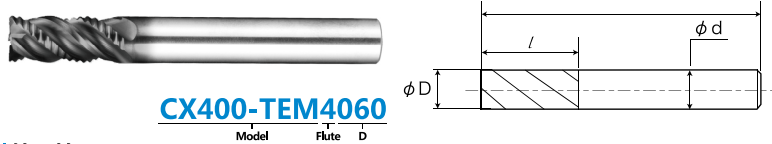


CX400 チタン加工用4枚刃スクエアエンドミル

CX400 Series 4-Flute Square End Mill for Titanium Alloy

CX400-TEM4



特性 Features

- CX400-Coating have high oxidation resistance and hardening which exceeds the existing coating and provides long tool life, and suitable for high speed processing and dry milling.
- 45 Degree Helix Baled Achieves high-feed operation
- The Fine pitch nick achieves high accurate surface roughness after processing



外径公差 Tolerance
+0.06
-0.06

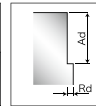
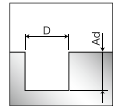
炭素鋼 Carbon Steel	合金鋼 Alloy Steel	調質鋼 Prehardened Steel	焼き入れ鋼 Hardened Steel				鑄鉄 Cast Iron	ステンレス鋼 Stainless Steels	アルミ合金 Aluminium Alloys	銅合金 Copper Alloys	チタン合金 耐熱合金 Ti/Ni Alloy	グラファイト Graphite	樹脂 Resin
◎	◎	◎	◎	◎			◎			◎			

◎=Best ○=Good

MODEL 型番	D 外径	/ 刃長	L 全長	d シャンク径
CX400-TEM4060	6	14	60	6
CX400-TEM4080	8	18	75	8
CX400-TEM4100	10	22	90	10
CX400-TEM4120	12	26	100	12
CX400-TEM4160	16	34	110	16
CX400-TEM4200	20	42	120	20

CX200-TEM4

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.

溝切削 Slotting

被削材 Work Material	チタン合金・ステンレス Titan Alloy・Stainless		炭素鋼 Carbon Steel (S45C~S55C)		合金鋼 工具鋼 Alloy Steel Tool Steel (SKD,SCM)		調質鋼 (35~40HRC) (HPM,NAK)	
外径 (mm) Diameter	送り速度 (mm/min) Feed rate	回転数 (min ⁻¹) Revolution	送り速度 (mm/min) Feed rate	回転数 (min ⁻¹) Revolution	送り速度 (mm/min) Feed rate	回転数 (min ⁻¹) Revolution	送り速度 (mm/min) Feed rate	回転数 (min ⁻¹) Revolution
6	80	2700	140	4200	120	3700	90	2900
8	160	2000	250	3200	220	2800	180	2200
10	150	1600	240	2500	210	2200	170	1800
12	130	1300	200	2100	180	1900	140	11500
16	130	1000	200	1600	180	1400	140	1100
20	120	800	180	1300	160	1100	130	900
Ad	≤0.2D		≤0.5D		≤0.3D			

側面切削 Side Milling

被削材 Work Material	チタン合金・ステンレス Titan Alloy・Stainless		炭素鋼 Carbon Steel (S45C~S55C)		合金鋼 工具鋼 Alloy Steel Tool Steel (SKD,SCM)		調質鋼 (35~40HRC) (HPM,NAK)	
外径 (mm) Diameter	送り速度 (mm/min) Feed rate	回転数 (min ⁻¹) Revolution	送り速度 (mm/min) Feed rate	回転数 (min ⁻¹) Revolution	送り速度 (mm/min) Feed rate	回転数 (min ⁻¹) Revolution	送り速度 (mm/min) Feed rate	回転数 (min ⁻¹) Revolution
6	130	3200	150	4800	170	4200	140	3400
8	240	2400	360	3600	320	3200	260	2600
10	230	1900	340	2900	310	2500	250	2100
12	190	1600	290	2400	250	2100	210	1700
16	190	1200	290	1800	250	1600	210	1300
20	170	1000	260	1400	230	1300	190	1000
Ad	≤1.0D		≤1.5D		≤1.0D			
Rd	≤0.2D		≤0.5D		≤0.3D			

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 Chamfering

ドリル Drill

スクエア Square

スクエア Square

ラジウス Radius

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ドリル Drill