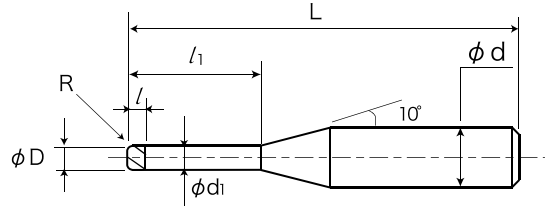


CX500 4枚刃ロングネックラジアスエンドミル

CX500 4-Flute Long Neck Radius End Mill

CX500-QEMSN



CX500-QEMSN4-2-10-R0.3

Model Flute D / l1 R

特性 Features

- Provide high accurate deep rib processing with $\pm 5\mu\text{m}$ radius accuracy
- Suitable for carbon steel processing and radius positive blade designed for tougher and shaper cutting
- Seamless shape (from peripheral blade to radius blade and bottom center are made by one process)
- Minimize deflection of tool due to tapered radius neck design
- Improvement of CX500-Coating having high oxidation resistance (1300°C) and high hardening exceeding the existing coating meet our own high rig requirement to ensure exceptional piece-to-piece conformity in the processing of prehardened steel and carbon steel



MG
超微粒



30°

外径公差 Tolerance
0
-0.02



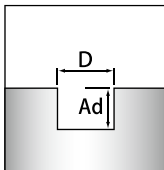
CX500
Coat

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	R	/ 刃長	/ l1	d1	L 全長	d 柄径	Actual effective length in incline angles			
								30°	1	2	3
CX500-QEMSN4-2-10	2	0.2 0.5	3	10	1.95	50	4	10.47	10.99	12.21	13.73
CX500-QEMSN4-2-12				12				12.57	13.19	14.65	16.48
CX500-QEMSN4-2-16				16				16.75	17.58	19.53	Free
CX500-QEMSN4-2-20				20				20.94	21.98	24.41	Free
CX500-QEMSN4-3-16	3	0.3 0.5	4.5	16	2.9	70	6	16.75	17.58	19.53	21.97
CX500-QEMSN4-3-20				20				20.94	21.98	24.41	27.46
CX500-QEMSN4-3-25				25				26.18	27.47	30.51	Free
CX500-QEMSN4-3-30				30				31.41	32.97	36.62	Free
CX500-QEMSN4-3-40				40				41.88	43.96	Free	Free
CX500-QEMSN4-4-16				16				16.75	17.58	19.53	Free
CX500-QEMSN4-4-20	4	0.2 0.5	6	20	3.8	70	6	20.94	21.98	24.41	Free
CX500-QEMSN4-4-30				30				31.41	32.97	36.62	Free
CX500-QEMSN4-4-40				40				41.88	43.96	Free	Free

推奨切削条件 Standard Milling Condition



- The table show 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 speed at same ration
- When mounting End Mills, The run out of the till will have to be set within 0.01mm

被削材 Work Material			炭素鋼 Carbon Steel (S45C~S55C)		合金鋼・工具鋼 Alloy steel・Tool steel (SKD,SUS,SCM)		調質鋼 (35~40HRC) (HRM,NAK)	
D	/ l1	Ad (mm)	送り速度 (mm/min) Feed rate	回転数 (mm ⁻¹) Revolution	送り速度 (mm/min) Feed rate	回転数 (mm ⁻¹) Revolution	送り速度 (mm/min) Feed rate	回転数 (mm ⁻¹) Revolution
2	10	0.037~0.088	1000	13000	700	10500	500	8900
	12	0.018~0.044	830	11700	580	9500	420	8000
	16	0.018~0.044	630	9500	440	7700	310	6500
	20	0.010~0.025	500	7700	350	6200	250	5300
3	16	0.028~0.067	1000	8900	700	7200	500	5900
	20	0.028~0.067	800	8000	560	6500	400	5300
	25	0.015~0.036	640	7200	450	5900	320	4800
	30	0.015~0.036	530	6500	370	5300	270	4300
4	40	0.005~0.012	400	5900	280	4800	200	3900
	16	0.045~0.015	1000	6500	700	5400	500	4450
	20	0.045~0.015	1000	6500	700	5400	500	4450
	30	0.023~0.076	670	6000	470	4900	330	4000
	40	0.017~0.046	500	5400	350	4400	250	3600

ロングネック Long Neck

スクエア Square

ラジアス 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