

# CX200 3枚刃 / 4枚刃 20° ラフィングエンドミル

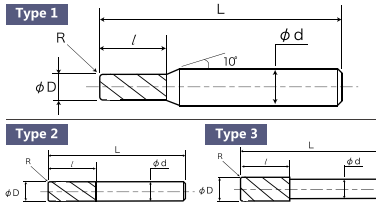
CX200 3・4-Flute 20° Roughing End Mill

## CX200-RER



**CX200-RER4100**

Model Flute D



### 特性 Features

- CX200-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.
- Best for high speed processing and groove milling due to the high chip ejection.
- The fine pitch nick, will hardly cause chipping when processing stainless steel, alloy steel and other hard-to-cut material, also, ensure tool long life and high-efficiency surface finishing after processing.
- CKK Original design Chip pocket enables similar or same cutting depth which 3-flutes could realize

MG  
超微粒

20°

CX200  
Coat

外径公差 Tolerance

+0.06

-0.06

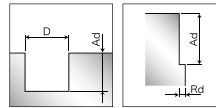
炭素鋼 Carbon Steel	合金鋼 Alloy Steel	調質鋼 Prehardened Steel	焼き入れ鋼 Hardened Steel				鋳鉄 Cast Iron	ステンレス鋼 Stainless Steels	アルミ合金 Aluminium Alloys	銅合金 Copper Alloys	チタン合金 耐熱合金 Ti/Ni Alloy	グラファイト Graphite	樹脂 Resin
			~45HRC	~55HRC	~60HRC	~65HRC							
◎	◎	◎	◎	○			○	○	○	○			

◎=Best ○=Good

MODEL 型番	D 外径	/ 刃長	L 全長	d シャンク径	Flute	Type
CX200-RER3030	3	15	60	6	3	1
CX200-RER3040	4	15	60	6	3	1
CX200-RER3050	5	15	60	6	3	1
CX200-RER3060	6	15	60	6	3	2
CX200-RER4080	8	20	75	8	4	2
CX200-RER4090	9	20	75	10	4	1
CX200-RER4100	10	25	75	10	4	2
CX200-RER4110	11	25	75	12	4	1
CX200-RER4120	12	30	100	12	4	2
CX200-RER4130	13	30	100	12	4	3
CX200-RER4140	14	35	100	12	4	3
CX200-RER4160	16	40	110	16	4	2
CX200-RER4180	18	45	110	16	4	3
CX200-RER4200	20	45	130	20	4	2

# CX200-RER

### 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

### 溝切削 Slotting

被削材 Work Material	炭素鋼 Carbon Steel S 45-S55 C		合金工具鋼 Alloy Steel Tool Steel SKD,SCM		調質鋼 Prehardened Steel 35-40HRC,HPM,NAK	
	送り速度 (mm/min) Feed rate	回転数 (rpm) Revolution	送り速度 (mm/min) Feed rate	回転数 (rpm) Revolution	送り速度 (mm/min) Feed rate	回転数 (rpm) Revolution
外径 (mm) Diameter						
3	340	6800	240	5500	190	4800
4	340	5100	230	4100	190	3600
5	340	4500	240	3300	170	3100
6	340	4000	240	2500	190	2800
8	380	2900	270	2200	210	2100
9	400	2700	290	2000	230	1800
10	390	2400	280	1700	230	1700
11	400	2200	270	1600	230	1500
12	390	2000	280	1400	220	1400
13	350	1800	250	1400	210	1300
14	330	1700	250	1200	190	1200
16	290	1500	210	1200	160	1000
18	270	1400	190	1100	160	1000
20	230	1200	180	1000	140	900
Ad			≤0.4D			≤0.3D

### 側面切削 Side Milling

被削材 Work Material	炭素鋼 Carbon Steel S 45-S55 C		合金工具鋼 Alloy Steel Tool Steel SKD,SCM		調質鋼 Prehardened Steel 35-40HRC,HPM,NAK	
	送り速度 (mm/min) Feed rate	回転数 (rpm) Revolution	送り速度 (mm/min) Feed rate	回転数 (rpm) Revolution	送り速度 (mm/min) Feed rate	回転数 (rpm) Revolution
外径 (mm) Diameter						
3	530	8500	370	6900	290	5900
4	530	6400	370	5200	290	4500
5	530	5600	370	4500	290	4200
6	530	5000	370	4100	290	3500
8	600	3700	420	3100	330	2600
9	610	3300	440	2700	360	2300
10	610	3000	440	2500	360	2100
11	610	2700	440	2200	360	1900
12	610	2500	440	2000	360	1800
13	560	2300	400	1800	320	1600
14	510	2100	400	1800	300	1500
16	460	1900	330	1500	260	1300
18	410	1700	310	1400	240	1200
20	370	1500	260	1200	220	1100
Ad			≤1.5D			≤1.5D
Rd			≤0.3D			≤0.2D

ラフィング  
Roughing

スクエア  
Square

ラジアス  
Radius

ボール  
Ball

ロングネック  
Long Neck

フィヤンク  
Roughing

面取り  
Chamfering

ドリル  
Drill

ラフィング  
Roughing

スクエア  
Square

ラジアス  
Radius

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フィヤンク  
Roughing

面取り  
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ドリル  
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