

# CX200 4枚刃 スクエアエンドミル

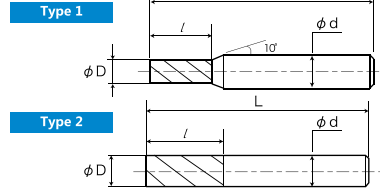
CX200 Series 4-Flute Square End Mill For Plunge Cutting

## CX200-ZHEM4



**CX200-ZHEM4010**

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.
- Combination of Negative radius blade and 45 degree helix blades enables high rigidity and sharpness by high feed speed, with high efficiency
- 4Flute eliminates chattering and suitable for drilling processing
- CKK Original design Chip pocket enables similar or same cutting depth which 2-flutes could realize
- Feed rate can be increased more than double if compared with standard End-Mills

MG 超微粒

45°

Sharp Edge

CX200 Coat

外径公差 Tolerance  
0  
-0.02

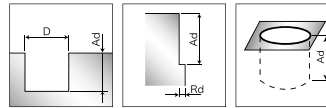
炭素鋼 Carbon Steel	合金鋼 Alloy Steel	調質鋼 Prehardened Steel	焼き入れ鋼 Hardened Steel				鋳鉄 Cast Iron	ステンレス鋼 Stainless Steels	アルミ合金 Aluminum Alloys	銅合金 Copper Alloys	チタン合金 耐熱合金 Ti/Ni Alloy	グラファイト Graphite	樹脂 Resin
◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

◎=Best ○=Good

MODEL 型番	D 外径	l 刃長	L 全長	d シャンク径	Type
CX200-ZHEM4030	3	8	60	6	1
CX200-ZHEM4040	4	11	60	6	1
CX200-ZHEM4050	5	13	60	6	1
CX200-ZHEM4060	6	13	60	6	2
CX200-ZHEM4080	8	19	75	8	2
CX200-ZHEM4100	10	22	80	10	2
CX200-ZHEM4120	12	26	100	12	2

# CX200-ZHEM4

### 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.
- In case of milling for stainless steel, please take wet cut milling.

### 溝切削 Slotting

被削材 Work Material	炭素鋼 Carbon Steel S 45-S55 C				合金鋼 工具鋼 Alloy Steel Tool Steel SKD,SCM				調質鋼 プリハードン鋼 Prehardened Steel 35-40HRC,HPM1NAK			
	外径 (mm) Diameter	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	送り速度 (mm/min) Feed rate	回転数 (min <sup>-1</sup> ) Revolution			
3	670	10600	340	9000	310	8000						
4	700	8000	360	6800	320	6000						
5	790	6400	400	5400	360	4800						
6	780	5300	400	4500	360	4000						
8	780	4000	400	3400	360	3000						
10	760	3200	390	2700	350	2400						
12	770	2700	400	2300	350	2000						

Ads:0.3D

### 側面切削 Side Milling

被削材 Work Material	炭素鋼 Carbon Steel S 45-S55 C				合金鋼 工具鋼 Alloy Steel Tool Steel SKD,SCM				調質鋼 プリハードン鋼 Prehardened Steel 35-40HRC,HPM1NAK			
	外径 (mm) Diameter	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	送り速度 (mm/min) Feed rate	回転数 (min <sup>-1</sup> ) Revolution			
3	1000	1530	10600	21200	670	980	9000	18000	570	870	8000	15900
4	1050	1600	8000	15900	670	1030	6800	13500	590	910	6000	11900
5	1170	1790	6400	12700	750	1150	5400	10800	660	1010	4800	9500
6	1170	1800	5300	10600	750	1150	4500	9000	670	1020	4000	8000
8	1160	1790	4000	8000	750	1150	3400	6800	660	1010	3000	6000
10	1140	1750	3200	6400	730	1120	2700	5400	650	990	2400	4800
12	1150	1740	2700	5300	740	1120	2300	4500	640	990	2000	4000

Ads:1.5D Rds:0.1D

### 突っ込み切削 Perforating

被削材 Work Material	炭素鋼 Carbon Steel S 45-S55 C				合金鋼 工具鋼 Alloy Steel Tool Steel SKD,SCM				調質鋼 プリハードン鋼 Prehardened Steel 35-40HRC,HPM1NAK			
	外径 (mm) Diameter	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	送り速度 (mm/min) Feed rate	回転数 (min <sup>-1</sup> ) Revolution			
3	200	90	6000	100	6000							
4	210	7200	110	4500	110	4500						
5	260	5700	110	3600	120	3600						
6	300	4800	140	3000	130	3000						
8	300	3600	120	2300	100	2300						
10	290	2900	90	1800	80	1800						
12	260	2400	80	1500	70	1500						

Ads:0.3D

スクエア Square

スクエア Square

ラジアス Radius

ボール Ball

ロングネック Long Neck

ラフヤング Roughing

面取り加工 Chamfering

ドリル Drill

スクエア Square

スクエア Square

ラジアス Radius

ボール Ball

ロングネック Long Neck

ラフヤング Roughing

面取り加工 Chamfering

ドリル Drill