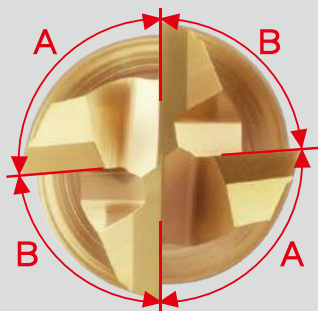


Unequal Flute Spacing Angle End Mills

MEHU

全新 - 不等距高導型銑刀

- 1** 專剋鋼料(HRC<50)之應用。
For Alloy Steels(HRC<50).
- 2** 不等距設計降低切削時的震動。
Chattering is decreased with unequal flute spacing angle.
- 3** 圓弧溝槽設計，使排屑性能更加優異，減少積屑及應力產生，提升刀具剛性。
Circular flute geometry design for chip evacuation is great.
- 4** 適合中加工、精加工。
Use for semi finishing cutting, finishing.



A≠B不等距抗震設計，有效抑制切削時的震動，大幅提升刀具壽命！

This geometry suppresses vibration!!!



CMTéc

尺寸規格表 Size:



刃徑 Diameter	刃長 Cutting Length	全長 O.A.L.	柄徑 Shank Dia.	刃數 Flute	鍍膜訂購編號 Coated Order No.
3.0	8	50	4	4	MEHUM40300A
4.0	10	50	4	4	MEHUM40400A
3.0	8	50	6	4	MEHU40300A
4.0	10	50	6	4	MEHU40400A
5.0	13	50	6	4	MEHU40500A
6.0	15	50	6	4	MEHU40600A
6.0	18	50	6	4	MEHU40600180CA
8.0	20	60	8	4	MEHU40800A
8.0	24	60	8	4	MEHU40800240CA
10.0	25	75	10	4	MEHU41000A
10.0	30	75	10	4	MEHU41000300CA
12.0	30	75	12	4	MEHU41200A
12.0	36	75	12	4	MEHU41200360CA
16.0	35	100	16	4	MEHU41600A

切削實例 CUT EXAMPLES

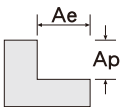
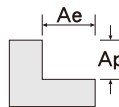


性能測試 Test S45C

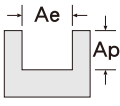


型錄下載 Download

側銑加工 Side Milling

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		調質鋼 Hardened Steels	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SKT,SKD	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		HRC45~55	
切削速度 Vc	110m/min		90m/min		75m/min		70m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
3mm	11,670	770	9,550	580	7,960	430	7,430	380
4mm	8,750	840	7,160	680	5,970	470	5,570	440
5mm	7,000	910	5,730	730	4,770	500	4,450	460
6mm	5,830	1,120	4,770	840	3,980	620	3,710	480
8mm	4,370	1,080	3,580	770	2,980	570	2,780	470
10mm	3,500	1,010	2,860	730	2,380	500	2,220	440
12mm	2,910	980	2,380	700	1,990	500	1,850	420
16mm	2,180	840	1,790	650	1,490	440	1,390	350
20mm	1,750	680	1,430	520	1,190	410	1,110	320
25mm	1,400	610	1,140	470	955	370	890	270
切削量 Cutting Amount (mm)	$A_p \leq 1.5D$ $A_e \leq 0.2D$ 					$A_p \leq 1.5D$ $A_e \leq 0.05D$ 		

溝銑加工 Slot Milling

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		調質鋼 Hardened Steels	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SKT,SKD	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		HRC45~55	
切削速度 Vc	95m/min		75m/min		70m/min		60m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
3mm	10,080	510	7,960	480	7,430	360	6,360	310
4mm	7,560	510	5,970	540	5,570	360	4,770	340
5mm	6,050	510	4,770	530	4,450	380	3,820	370
6mm	5,040	520	3,980	440	3,710	400	3,180	380
8mm	3,780	420	2,980	390	2,780	390	2,380	360
10mm	3,020	410	2,380	380	2,220	340	1,910	320
12mm	2,520	390	1,990	330	1,850	320	1,590	300
16mm	1,890	380	1,490	300	1,390	260	1,190	250
20mm	1,510	330	1,190	270	1,110	250	955	230
25mm	1,210	320	950	250	890	220	760	160
切削量 Cutting Amount (mm)	$A_p \leq 1D$ $A_p(\text{MAX})=12\text{mm}$ 					$A_p \leq 0.2D$ 