

CX200 4枚刃スクエアエンドミルピンカド

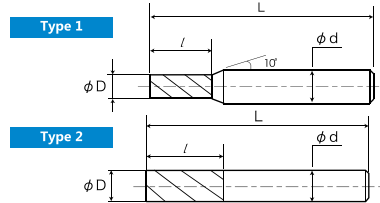
CX200 Series 4-Flute Square End Mill Sharp Edge

CX200-PHEM4



CX200-PHEM4100

Model Flute D



特性 Features

- New series CX200-PHEM4 Shape Edge
- 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

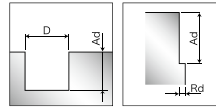
炭素鋼 Carbon Steel	合金鋼 Alloy Steel	調質鋼 Prehardened Steel	焼き入れ鋼 Hardened Steel				鋳鉄 Cast Iron	ステンレス鋼 Stainless Steels	アルミ合金 Aluminum Alloys	銅合金 Copper Alloys	チタン合金 耐熱合金 Ti/Ni Alloy	グラファイト Graphite	樹脂 Resin
◎	◎	◎	◎	○	○	○	◎	○	○	○	○	○	

◎=Best ○=Good

MODEL 型番	D 外径	l 刃長	L 全長	d シャンク径	Type
CX200-PHEM4020	2	8	60	6	1
CX200-PHEM4025	2.5	10	60	6	1
CX200-PHEM4030	3	16	60	6	1
CX200-PHEM4040	4	18	60	6	1
CX200-PHEM4050	5	21	60	6	1
CX200-PHEM4060	6	21	60	6	2
CX200-PHEM4070	7	24	60	8	1
CX200-PHEM4075	7.5	24	60	8	1
CX200-PHEM4080	8	26	75	8	2
CX200-PHEM4100	10	34	90	10	2
CX200-PHEM4120	12	38	100	12	2
CX200-PHEM4160	16	48	110	16	2
CX200-PHEM4200	20	56	130	20	2

CX200-PHEM4

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 SKD5SCM		超硬鋼 35-40HRC/HPM/NAK	
	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
外径 Diameter						
2 ~ 2.5	610	14700	310	12300	270	10700
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
7 ~ 7.5	770	4500	410	3900	350	3400
8	780	4000	400	3400	360	3000
10	760	3200	390	2700	350	2400
12	770	2700	400	2300	350	2000
16	630	2000	320	1700	280	1500
20	460	1600	240	1400	210	1200

Ad:0.3D

側面切削 Side Milling

被削材 Work Material	炭素鋼 S 45-S55 C				合金鋼 工具鋼 Alloy Steel Tool Steel SKD5SCM				超硬鋼 35-40HRC/HPM/NAK			
	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	
外径 Diameter												
2 ~ 2.5	910	1400	14700	29400	580	890	12300	24700	500	770	10700	21500
3	1000	1530	10600	21200	640	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
7 ~ 7.5	1150	1790	4500	9100	760	1150	3900	7700	660	1010	3400	6800
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
16	930	1430	2000	4000	600	920	1700	3400	530	810	1500	3000
20	680	1050	1600	3200	450	670	1400	2700	390	600	1200	2400

Ad:1.5D Rds:0.1D

スクエア Square

スクエア Square

径バネス Radius

ボール Ball

ロングネック Long Neck

径バネス Roughing

面取り加工 Chamfering

ドリル Drill

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