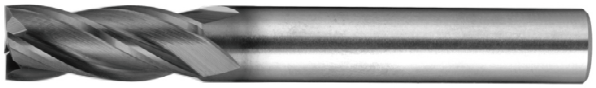
CX200 4枚刃スクエアエンドミル

4-Flute Square End Mill TiAlN Coat

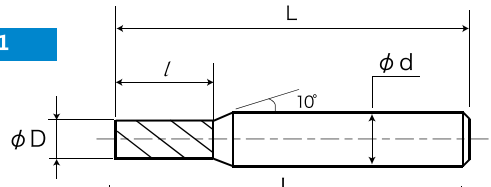
CX200-EM4



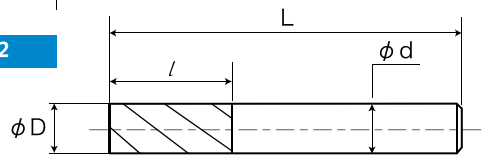
CX200-EM4060S

Model　Flute　D

Type 1



Type 2



外径公差 Tolerance
0
-0.02

特　性 Features

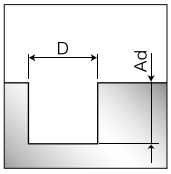
- ●4 Fluted endmill for general application.
- ●Employs TiAlN Coating and is applicable for high speed And high feed operations

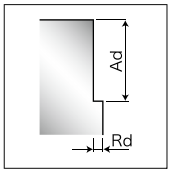
炭素鋼 Carbon Steel	合金鋼 Alloy Steel	調質鋼 Prehardened Steel	焼き入れ鋼 Hardened Steel				鋳鉄 Cast Iron	ステンレス鋼 Stainless Steels	アルミ合金 Aluminium Alloys	銅合金 Copper Alloys	チタン合金 耐熱合金 Ti/Ni Alloy	グラファイト Graphite	樹脂 Resin
			~45HRC	~55HRC	~60HRC	~65HRC							
◎	◎	◎	◎	○			○	○	○	○			

◎ = Best　○ = Good

MODEL 型番	D 外径	l 刃長	L 全長	d シャンク径	Type
CX200-EM4030S	3	8	45	6	1
CX200-EM4040S	4	9	45	6	1
CX200-EM4060S	6	13	50	6	2
CX200-EM4080S	8	19	60	8	2
CX200-EM4100S	10	22	70	10	2
CX200-EM4120S	12	26	75	12	2
CX200-EM4160S	16	32	90	16	2
CX200-EM4200S	20	38	100	20	2

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.

側面切削 Side Milling

被削材 Work Material	一般構造圧延鋼．炭素鋼 Structural steel.Carbon steel (~20HRC) SS400.S45C.S50C AISI 1045.AISI1049 鋳鉄 .FC250 Castiron		炭素鋼．合金鋼 Carbon steel Alloy steel (20~30HRC) S50C.SCM AISI 1049		合金鋼．工具鋼 Alloy steel.Tool steel 調質鋼 Pre-hardened steel (30~45HRC) SKD61.NAK AISI H13		ステンレス鋼 Austenitic stainless steels SUS304 AISI 304 チタン合金 Titanium alloy		調質鋼．焼き入れ鋼 Pre-harden Steel Hardened Steels CENA1.NAK80.SKD (35~45HRC)		焼き入れ鋼、超耐熱合金 Hardened steel, Hert Resistant alloy SKD11 (55~60HRC)	
外径 (mm) Diameter	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	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	送り速度 (mm/min) Feed rate
3	20000	1125	9500	420	5800	330	5500	315	4700	135	2100	60
4	16000	1200	7100	420	4300	330	4100	315	3500	135	1500	60
6	10600	1350	4700	420	2900	330	2800	315	2300	135	1000	60
8	8000	1425	3500	420	2100	330	2000	315	1700	150	790	67.5
10	6400	1425	2800	420	1700	330	1600	315	1400	150	630	67.5
12	5300	1425	2300	420	1400	330	1300	315	1100	150	530	67.5
16	4000	1425	1700	420	1000	330	950	315	800	150	390	67.5
20	3200	1425	1400	420	800	330	760	315	650	150	310	67.5
溝切削 Slotting	Ad≤0.2D(D>Φ3)　Ad≦0.1D(D≦Φ3)　Rd≦1.5D								Ad≤0.05D Rd≤1.5D			
側面切削 Side Milling	Ad≤0.05D(D>Φ3)　Ad≦0.3D(Φ2≦D≦Φ3)								Ad≤0.05D			