

アルミ加工用3枚刃スクエアエンドミル DLCコート

DLC 3-Flute Square End Mill for Aluminum

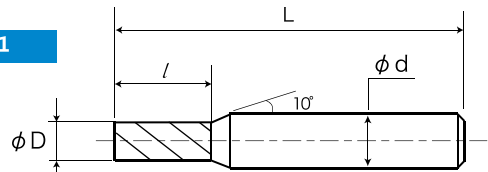
DLC-HEM3



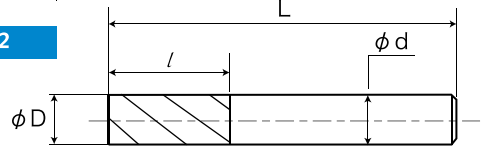
DLC-HEM3010

Model Flute D

Type 1



Type 2



特性 Features

- DLC Coating has high abrasion, adhesion and friction resistance. Best for aluminum alloy processing
- Best for drilling, Milling of soft material where the adhesion and the chip packing such as aluminum alloy are generated very easily due to the sharp cutting edge
- 3Flute eliminates chattering and suitable for drilling processing
- CKK Original design Chip pocket enables similar or same cutting depth which 2-flutes could realize



外径公差 Tolerance
0
-0.02

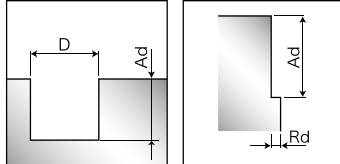


炭素鋼 Carbon Steel	合金鋼 Alloy Steel	調質鋼 Prehardened Steel	焼き入れ鋼 Hardened Steel				鋳鉄 Cast Iron	ステンレス鋼 Stainless Steels	アルミ合金 Aluminium Alloys	銅合金 Copper Alloys	チタン合金 耐熱合金 Ti/Ni Alloy	グラファイト Graphite	樹脂 Resin
			~45HRC	~55HRC	~60HRC	~65HRC							
								◎	○			○	

◎ = Best ○ = Good

MODEL 型番	D 外径	l 刃長	L 全長	d シャンク径	Type
DLC-HEM3010	1	3	40	4	1
DLC-HEM3015	1.5	4.5	40	4	1
DLC-HEM3020	2	6	40	4	1
DLC-HEM3025	2.5	7.5	40	4	1
DLC-HEM3030	3	9	50	6	1
DLC-HEM3040	4	12	50	6	1
DLC-HEM3050	5	15	55	6	1
DLC-HEM3060	6	18	55	6	2
DLC-HEM3080	8	24	65	8	2
DLC-HEM3100	10	30	75	10	2
DLC-HEM3120	12	36	80	12	2

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 with in 0.01mm.

被削材 Work Material	アルミニウム合金 Aluminium Alloy		
	送り速度 Feed Rate (mm/min)		回転数 Revolution (min ⁻¹)
外径 (mm) Diameter	溝切削 Slotting	側面切削 Side Milling	
1	840	1260	50000
1.5	840	1260	48850
2	840	1260	47700
2.5	967	1455	39750
3	1095	1650	31800
4	1095	1650	23900
5	1095	1650	19100
6	1095	1650	15900
8	1095	1650	11900
10	1095	1650	9500
12	1095	1650	8000
切削深度 Depth of Cut	Ad≤0.2D	Ad≤1.5D	Rd≤0.2D

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

ラフニング Roughing

面取り加工用 Chamfering

ドリル Drill