V系列 全面進化・性能再升級!

・大幅度降低刀具震動(抗震性好)
・俱有斷屑效果展現驚人的排屑性
・可達成切深1D之高進給加工

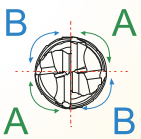
全新V系列銑刀
All New V Series End mills

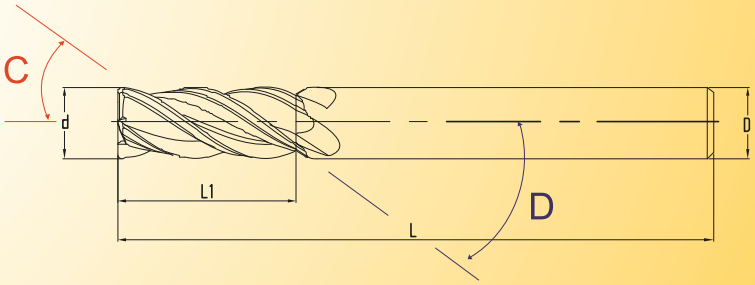
特殊刀具幾何設計讓您的「高效率；重切削」
及「大切深；高進給」可行!

專剋泛用鋼材:	General Cutting Steels:
・碳素鋼	・Carbon Steels
・合金鋼	・Alloy Steels
・調質鋼(45~55HRC)	・Hardened Steels(45~55HRC)
・鑄鐵	・Cast Iron

不等距+不等螺旋角銑刀
"Variable-Pitch & Lead" End mills

驚奇防震動表現；高效率加工展現！
Suppresses chattering, allowing for
outstanding milling performance.





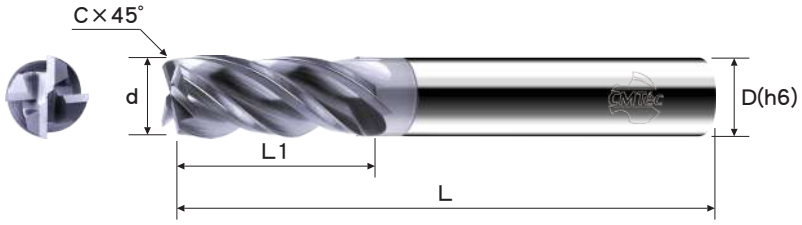
A≠B
刀底不等分割設計
可降低切削時震動
Chattering is decreased
with " Variable Pitch."

C≠D
側刃不等螺旋角設計亦
可降低切削時震動
"Variable-lead" shape stabilizes
cutting resistance to isolate vibration.

M520 極細鎢鋼平銑刀- 高效型- 4刃

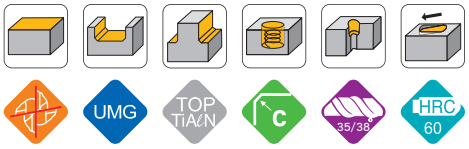
M520 ULTRA CARBIDE END MILLS- High Performance- 4F

· MEV4□□□□A



刃徑 d	公差 Tolerance
Φ<3	0 ~ -0.02
3≦Φ≦10	-0.01 ~ -0.03
10<Φ	-0.01 ~ -0.04

超精銑 Bright Finishing	—
精銑 Finishing	◎
中銑 Semi Finishing	◎
粗銑 Roughing	◎



Milling Table 67,68

性能升級 UPGRADE

切削實例 CUT EXAMPLES

刃徑 d	倒C角 C(Max)	刃長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
3.0	0.1	6	50	6	4	MEV40300A
4.0	0.2	8	50	6	4	MEV40400A
5.0	0.2	10	50	6	4	MEV40500A
6.0	0.2	12	50	6	4	MEV40600A
6.0	0.2	18	50	6	4	MEV40600180CA
8.0	0.3	16	60	8	4	MEV40800A
8.0	0.3	24	60	8	4	MEV40800240CA
10.0	0.3	20	75	10	4	MEV41000A
10.0	0.3	30	75	10	4	MEV41000300CA
12.0	0.4	24	75	12	4	MEV41200A
12.0	0.4	36	75	12	4	MEV41200360CA

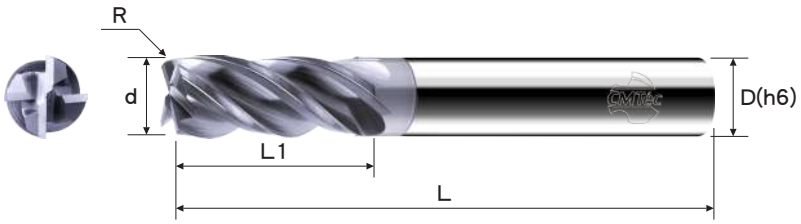
➡ 切削條件表 Cutting Condition P.288,289

➡ 技術資料 Technical Data P.302

M520 極細鎢鋼圓鼻銑刀- 高效型- 4刃

M520 ULTRA CARBIDE END MILLS- Corner Radius- High Performance- 4F

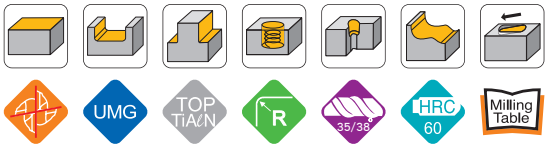
· MEVC4000000A



刃徑 d	公差 Tolerance
Φ<3	0 ~ -0.02
3≦Φ≦10	-0.01 ~ -0.03
10<Φ	-0.01 ~ -0.04

半徑 R	公差 Tolerance
R	±0.02

超精銑 Bright Finishing	—
精銑 Finishing	◎
中銑 Semi Finishing	◎
粗銑 Roughing	◎



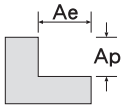
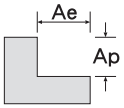
69,70

性能升級 UPGRADE

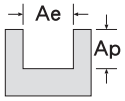
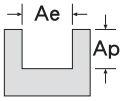
刃徑 d	R角 R	刃長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
3.0	0.2R	8	50	6	4	MEVC4030002A
3.0	0.5R	8	50	6	4	MEVC4030005A
4.0	0.2R	11	50	6	4	MEVC4040002A
4.0	0.5R	11	50	6	4	MEVC4040005A
4.0	1.0R	11	50	6	4	MEVC4040010A
5.0	0.2R	13	50	6	4	MEVC4050002A
5.0	0.5R	13	50	6	4	MEVC4050005A
5.0	1.0R	13	50	6	4	MEVC4050010A
6.0	0.3R	13	50	6	4	MEVC4060003A
6.0	0.5R	13	50	6	4	MEVC4060005A
6.0	1.0R	13	50	6	4	MEVC4060010A
8.0	0.3R	19	60	8	4	MEVC4080003A
8.0	0.5R	19	60	8	4	MEVC4080005A
8.0	1.0R	19	60	8	4	MEVC4080010A
8.0	1.5R	19	60	8	4	MEVC4080015A
8.0	2.0R	19	60	8	4	MEVC4080020A
10.0	0.3R	22	75	10	4	MEVC4100003A
10.0	0.5R	22	75	10	4	MEVC4100005A
10.0	1.0R	22	75	10	4	MEVC4100010A
10.0	1.5R	22	75	10	4	MEVC4100015A
10.0	2.0R	22	75	10	4	MEVC4100020A
10.0	3.0R	22	75	10	4	MEVC4100030A
12.0	0.5R	26	75	12	4	MEVC4120005A
12.0	1.0R	26	75	12	4	MEVC4120010A
12.0	1.5R	26	75	12	4	MEVC4120015A
12.0	2.0R	26	75	12	4	MEVC4120020A
12.0	3.0R	26	75	12	4	MEVC4120030A
16.0	1.0R	35	100	16	4	MEVC4160010A
16.0	1.5R	35	100	16	4	MEVC4160015A
16.0	2.0R	35	100	16	4	MEVC4160020A
16.0	3.0R	35	100	16	4	MEVC4160030A
20.0	1.0R	40	100	20	4	MEVC4200010A
20.0	1.5R	40	100	20	4	MEVC4200015A
20.0	2.0R	40	100	20	4	MEVC4200020A
20.0	3.0R	40	100	20	4	MEVC4200030A

→ 切削條件表 Cutting Condition P.289,290
→ 技術資料 Technical Data P.302

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)	Ap≦1.5D Ae≦0.2D						Ap≦1.5D Ae≦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)	Ap≦1D Ap(MAX)=12mm						Ap≦0.2D	

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