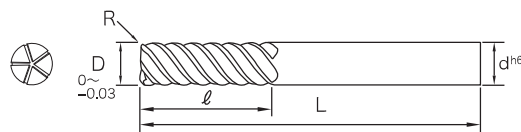




(ザ・) カットミル 超硬5枚刃高硬度用ラジアスエンドミル

For High Hardness Steel, Coated Solid Carbide Corner Radius Endmills (5-flute)



特長 Feature

- 耐摩耗性と耐熱性に優れ、滑りが良く、溶着しにくい特殊コーティングを採用
- 生材から難削材まで幅広い加工領域を実現
- 革新の刃形状・最強の超硬+特殊コーティングで高速高送りが可能
- Wear and heat resistance are excellent, low cutting resistance. Special coating which is not easily adhered to is used.
- Ability to process a range of materials from alloyed steel to difficult-to-machine.
- High speed feed is possible due to innovative edge shape and the strongest carbide coating.

単位: mm

商品コード Item Code	D	R±0.015	ℓ	L	d
IC5HSVR-6X0.5R	6	0.5	17	60	6
IC5HSVR-6X1.0R	6	1	17	60	6
IC5HSVR-8X0.5R	8	0.5	22	80	8
IC5HSVR-8X1.0R	8	1	22	80	8
IC5HSVR-8X1.5R	8	1.5	22	80	8
IC5HSVR-10X0.5R	10	0.5	27	80	10
IC5HSVR-10X1.0R	10	1	27	80	10
IC5HSVR-10X1.5R	10	1.5	27	80	10
IC5HSVR-10X2.0R	10	2	27	80	10
IC5HSVR-12X0.5R	12	0.5	32	110	12
IC5HSVR-12X1.0R	12	1	32	110	12
IC5HSVR-12X1.5R	12	1.5	32	110	12
IC5HSVR-12X2.0R	12	2	32	110	12
IC5HSVR-16X1.0R	16	1	45	110	16
IC5HSVR-16X1.5R	16	1.5	45	110	16
IC5HSVR-16X2.0R	16	2	45	110	16

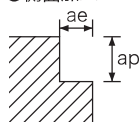
標準切削条件表 (側面加工 $ae < 0.1D$) Recommended cutting conditions (Side cutting $ae < 0.1D$)

被削材 Work	炭素鋼/合金鋼 (180~250HB)		工具鋼 (25~35HRC)		プリハードン鋼 (35~45HRC)		焼入れ鋼 (45~55HRC)		焼入れ鋼 (55~65HRC)	
D	回転数 n(min ⁻¹)	送り速度 F(mm/min)	回転数 n(min ⁻¹)	送り速度 F(mm/min)	回転数 n(min ⁻¹)	送り速度 F(mm/min)	回転数 n(min ⁻¹)	送り速度 F(mm/min)	回転数 n(min ⁻¹)	送り速度 F(mm/min)
6	16,000	6,700	13,800	5,000	13,300	4,800	6,400	2,300	5,300	1,900
8	12,000	7,200	10,300	4,330	9,950	4,180	4,800	2,000	4,000	1,680
10	9,550	6,300	8,300	4,000	8,000	3,840	3,800	1,800	3,200	1,500
12	8,000	5,760	6,900	4,140	6,600	3,900	3,200	1,920	2,650	1,590
16	6,000	4,680	5,200	3,750	5,000	3,600	2,400	1,730	2,000	1,440
切込み量 Depth of cut	ap=1.5D, ae=0.1~0.05D		ap=1.5D, ae=0.1~0.05D		ap=1.5D, ae=0.1~0.02D		ap=1.5D, ae=0.1~0.01D		ap=1.5D, ae=0.1~0.01D	

※ 切削条件はあくまでも目安です。使用される機械、チャックの剛性や切削油等の状況によって変動致します。

These conditions are for general guidance. Therefore they are subject to change to the situation of the machine used, the tool hold rigidity, cutting oil, etc.

● 側面加工



構造用鋼/炭素鋼 (SS41, S45C) HRC ≤ 30	工具鋼/プリハードン鋼 (SKD, NAK101) HRC30~35	合金鋼/ステンレス鋼 (SCM, SUS304) HRC35~40	熱処理鋼等 Hardened Steels HRC40~45	硬質材 Hard material HRC45~65
◎	◎	○	◎	○