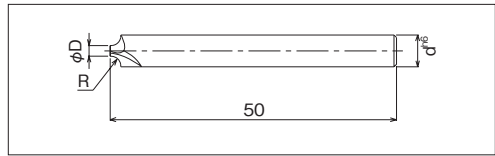


コーナーRカッター (2枚刃)

2-Flute Corner Radius Cutter

ACR



※刃部詳細図はP.180参照

■ 精密加工用高精度インナーRカッターです。
High precision inner radius cutter for fine processing.

R公差：±0.02
R Tolerance



単位 Unit : mm

| 型番 CODE NUMBER | R | 先端径 φD | 全長 L | シャンク d | 定価 ¥ |
|-------------------|------|-----------|---------|-----------|---------|
| ACR-2010 | 0.1 | 1 | 50 | 3 | 13,500 |
| ACR-2015 | 0.15 | 1 | 50 | 3 | 13,500 |
| ACR-2020 | 0.2 | 1 | 50 | 3 | 11,700 |
| ACR-2025 | 0.25 | 1 | 50 | 3 | 11,700 |
| ACR-2030 | 0.3 | 1 | 50 | 3 | 11,700 |
| ACR-2035 | 0.35 | 1 | 50 | 3 | 11,700 |
| ACR-2040 | 0.4 | 1 | 50 | 3 | 10,000 |
| ACR-2045 | 0.45 | 1 | 50 | 3 | 10,000 |
| ACR-2050 | 0.5 | 1 | 50 | 3 | 7,300 |
| ACR-2055 | 0.55 | 1 | 50 | 3 | 8,200 |
| ACR-2060 | 0.6 | 1.5 | 50 | 4 | 8,200 |
| ACR-2065 | 0.65 | 1.5 | 50 | 4 | 8,200 |
| ACR-2070 | 0.7 | 1.5 | 50 | 4 | 8,200 |
| ACR-2075 | 0.75 | 1.5 | 50 | 4 | 7,300 |
| ACR-2080 | 0.8 | 1.5 | 50 | 4 | 8,200 |
| ACR-2085 | 0.85 | 1.5 | 50 | 4 | 8,200 |
| ACR-2090 | 0.9 | 1.5 | 50 | 4 | 8,200 |
| ACR-2095 | 0.95 | 1.5 | 50 | 4 | 8,200 |
| ACR-2100 | 1 | 1.5 | 50 | 4 | 7,300 |
| ACR-2105 | 1.05 | 1.5 | 50 | 4 | 8,200 |
| ACR-2110 | 1.1 | 2 | 50 | 6 | 8,200 |
| ACR-2115 | 1.15 | 2 | 50 | 6 | 8,200 |
| ACR-2120 | 1.2 | 2 | 50 | 6 | 8,200 |
| ACR-2125 | 1.25 | 2 | 50 | 6 | 7,300 |
| ACR-2130 | 1.3 | 2 | 50 | 6 | 12,200 |
| ACR-2135 | 1.35 | 2 | 50 | 6 | 12,200 |
| ACR-2140 | 1.4 | 2 | 50 | 6 | 12,200 |

| 型番 CODE NUMBER | R | 先端径 φD | 全長 L | シャンク d | 定価 ¥ |
|-------------------|------|-----------|---------|-----------|---------|
| ACR-2145 | 1.45 | 2 | 50 | 6 | 12,200 |
| ACR-2150 | 1.5 | 2 | 50 | 6 | 11,200 |
| ACR-2155 | 1.55 | 2 | 50 | 6 | 12,200 |
| ACR-2160 | 1.6 | 2 | 50 | 6 | 12,200 |
| ACR-2165 | 1.65 | 2 | 50 | 6 | 12,200 |
| ACR-2170 | 1.7 | 2 | 50 | 6 | 12,200 |
| ACR-2175 | 1.75 | 2 | 50 | 6 | 11,200 |
| ACR-2180 | 1.8 | 2 | 50 | 6 | 12,200 |
| ACR-2185 | 1.85 | 2.5 | 50 | 8 | 13,700 |
| ACR-2190 | 1.9 | 2.5 | 50 | 8 | 13,700 |
| ACR-2195 | 1.95 | 2.5 | 50 | 8 | 13,700 |
| ACR-2200 | 2 | 2.5 | 50 | 8 | 11,200 |
| ACR-2205 | 2.05 | 2.5 | 50 | 8 | 13,700 |
| ACR-2210 | 2.1 | 2.5 | 50 | 8 | 13,700 |
| ACR-2215 | 2.15 | 2.5 | 50 | 8 | 13,700 |
| ACR-2220 | 2.2 | 2.5 | 50 | 8 | 13,700 |
| ACR-2225 | 2.25 | 2.5 | 50 | 8 | 13,700 |
| ACR-2230 | 2.3 | 2.5 | 50 | 8 | 13,700 |
| ACR-2235 | 2.35 | 2.5 | 50 | 8 | 13,700 |
| ACR-2240 | 2.4 | 2.5 | 50 | 8 | 13,700 |
| ACR-2245 | 2.45 | 2.5 | 50 | 8 | 13,700 |
| ACR-2250 | 2.5 | 2.5 | 50 | 8 | 11,700 |

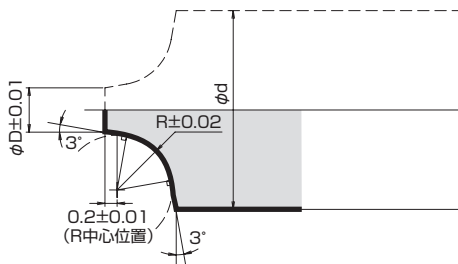
ACR コーナーRカッター

2-Flute Corner Radius Cutter

| R Radius | 炭素鋼 SS材 S50C Carbon Steel | | 合金鋼 SCM SKD Alloy Steel | | 調質鋼 NAK Hardened Steel | | アルミ・銅合金・樹脂 Aluminium・Copper Alloy & Resin | |
|-------------|------------------------------|------------------------|----------------------------|------------------------|---------------------------|------------------------|---|------------------------|
| | 回転数 Speed (RPM) | 送り Feed (mm/min) | 回転数 Speed (RPM) | 送り Feed (mm/min) | 回転数 Speed (RPM) | 送り Feed (mm/min) | 回転数 Speed (RPM) | 送り Feed (mm/min) |
| R0.1~R0.25 | 6,400 | 55 | 5,100 | 45 | 3,800 | 35 | 10,000 | 100 |
| R0.3~R0.5 | 5,300 | 55 | 4,200 | 45 | 3,200 | 35 | 8,800 | 100 |
| R0.55~R0.75 | 4,200 | 55 | 3,500 | 45 | 2,800 | 35 | 7,000 | 100 |
| R0.8~R1.0 | 3,800 | 55 | 3,200 | 45 | 2,500 | 35 | 6,300 | 100 |
| R1.05~R1.25 | 3,400 | 55 | 2,900 | 45 | 2,400 | 35 | 5,600 | 100 |
| R1.3~R1.5 | 3,200 | 55 | 2,700 | 45 | 2,300 | 35 | 5,300 | 100 |
| R1.55~R1.75 | 3,000 | 55 | 2,500 | 45 | 2,100 | 35 | 5,000 | 100 |
| R1.8~R2.0 | 2,500 | 55 | 2,100 | 45 | 1,800 | 35 | 4,200 | 100 |
| R2.05~R2.25 | 2,300 | 55 | 2,000 | 45 | 1,700 | 35 | 3,800 | 100 |
| R2.3~R2.5 | 2,200 | 55 | 1,900 | 45 | 1,600 | 35 | 3,700 | 100 |

刃部詳細図

Details of cutting edge



備考

- 1) 機械、チャックは剛性のある精度の高いものをご使用下さい。
- 2) チャッキング時のエンドミルの振れ精度は0.01mm以下に抑えて下さい。
- 3) ご使用の機械の最高回転数が上記切削条件に達しない場合は、なるべく安定領域での高い回転数で使用し、送り速度を調整して下さい。

Remarks:

- 1) Use a rigid and precise machine and holder.
- 2) The run out with an end mill in a spindle should be within 0.01mm.
- 3) When using low speed machines, use the maximum speed but in stable rotation range and adjust the feed rate.