

AMEL/AEL ロング刃 スクエアエンドミル (2枚刃)

Long Flute Square End Mill (2 flutes)

被削材 Work Materials		炭素鋼 S50C Carbon Steel				合金鋼 SCM SK材 Alloy Steel				調質鋼 NAK Prehardened Steel			
刃径 Diameter	刃長 Flute length	回転数 Speed (RPM)	送り Feed (mm/min)	切り込み幅(Ar) Cutting Width	切込深さ(Ad) Cutting Depth	回転数 Speed (RPM)	送り Feed (mm/min)	切り込み幅(Ar) Cutting Width	切込深さ(Ad) Cutting Depth	回転数 Speed (RPM)	送り Feed (mm/min)	切り込み幅(Ar) Cutting Width	切込深さ(Ad) Cutting Depth
0.1	0.7	16,000	10	0.01D	1D	13,000	7	0.01D	1D	12,000	6	0.01D	1D
0.1	1	16,000	10	0.01D	1D	13,000	7	0.01D	1D	12,000	6	0.01D	1D
0.2	1.5	14,000	10	0.05D	1D	11,200	7	0.05D	1D	10,000	6	0.05D	1D
0.2	2.0	14,000	10	0.015D	1D	11,200	7	0.015D	1D	10,000	6	0.015D	1D
0.3	2	14,000	15	0.05	2D	11,200	10	0.05	2D	10,000	8	0.05	2D
0.3	3	14,000	15	0.02	2D	11,200	10	0.02	2D	10,000	8	0.02	2D
0.5	3・4	10,500	40	0.05D	2D	8,400	30	0.05D	2D	6,700	25	0.05D	2D
0.5	5	10,500	40	0.025D	2D	8,400	30	0.025D	2D	6,700	25	0.025D	2D
0.8	5・7	9,100	50	0.05D	2D	7,300	35	0.05D	2D	5,800	25	0.05D	2D
0.8	10	9,100	50	0.025D	2D	7,300	35	0.025D	2D	5,800	25	0.025D	2D
1.0	5・6	9,500	70	0.05D	2D	7,600	45	0.05D	2D	5,700	35	0.05D	2D
1.0	7.5	9,500	70	0.05D	2D	7,600	45	0.05D	2D	5,700	35	0.05D	2D
1.0	10	9,500	70	0.025D	2D	7,600	45	0.025D	2D	5,700	35	0.025D	2D
1.0	12	9,500	70	0.025D	2D	7,600	45	0.025D	2D	5,700	35	0.025D	2D
1.2	7.5・10	8,000	70	0.05D	2D	6,400	45	0.05D	2D	5,700	35	0.05D	2D
1.2	12	8,000	70	0.03D	2D	6,400	45	0.03D	2D	5,700	35	0.03D	2D
1.5	10・15	6,500	70	0.05D	2D	5,200	45	0.05D	2D	3,800	35	0.05D	2D
1.5	18	6,500	70	0.025D	2D	5,200	45	0.025D	2D	3,800	35	0.025D	2D
1.5	20	6,500	70	0.025D	2D	5,200	45	0.025D	2D	3,800	35	0.025D	2D
2.0	10・12・15	5,000	90	0.05D	3D	4,000	55	0.05D	3D	2,900	40	0.05D	3D
2.0	20	5,000	90	0.05D	3D	4,000	55	0.05D	3D	2,900	40	0.05D	3D
2.5	15・20・25	4,000	90	0.05D	3D	3,200	60	0.05D	3D	2,300	40	0.05D	3D
3.0	20・25.30	3,200	90	0.05D	3D	2,600	70	0.05D	3D	1,900	45	0.05D	3D

被削材 Work Materials		アルミ合金 Aluminium Alloy				銅合金 Copper Alloy				樹脂 Resin			
刃径 Diameter	刃長 Flute length	回転数 Speed (RPM)	送り Feed (mm/min)	切り込み幅(Ar) Cutting Width	切込深さ(Ad) Cutting Depth	回転数 Speed (RPM)	送り Feed (mm/min)	切り込み幅(Ar) Cutting Width	切込深さ(Ad) Cutting Depth	回転数 Speed (RPM)	送り Feed (mm/min)	切り込み幅(Ar) Cutting Width	切込深さ(Ad) Cutting Depth
0.1	0.7	21,000	50	0.01D	1D	18,000	35	0.01D	1D	18,000	35	0.01D	1D
0.1	1	21,000	50	0.01D	1D	18,000	35	0.01D	1D	18,000	35	0.01D	1D
0.2	1.5	21,000	50	0.05D	1D	18,000	35	0.05D	1D	18,000	35	0.05D	1D
0.2	2.0	21,000	50	0.015D	1D	18,000	35	0.015D	1D	18,000	35	0.015D	1D
0.3	2	21,000	50	0.05	2D	18,000	50	0.05	2D	18,000	50	0.05	2D
0.3	3	21,000	50	0.02	2D	18,000	50	0.02	2D	18,000	50	0.02	2D
0.5	3・4	19,000	70	0.05D	2D	16,000	50	0.05D	2D	16,000	50	0.05D	2D
0.5	5	19,000	70	0.025D	2D	16,000	50	0.025D	2D	16,000	50	0.025D	2D
0.8	5・7	16,000	100	0.05D	2D	14,000	75	0.05D	2D	14,000	75	0.05D	2D
0.8	10	16,000	100	0.025D	2D	14,000	75	0.025D	2D	14,000	75	0.025D	2D
1.0	5・6	13,000	130	0.05D	2D	11,000	80	0.05D	2D	11,000	80	0.05D	2D
1.0	7.5	13,000	130	0.05D	2D	11,000	80	0.05D	2D	11,000	80	0.05D	2D
1.0	10	13,000	130	0.025D	2D	11,000	80	0.025D	2D	11,000	80	0.025D	2D
1.0	12	13,000	130	0.025D	2D	11,000	80	0.025D	2D	11,000	80	0.025D	2D
1.2	7.5・10	11,000	130	0.05D	2D	9,500	80	0.05D	2D	9,500	80	0.05D	2D
1.2	12	11,000	130	0.03D	2D	9,500	80	0.03D	2D	9,500	80	0.03D	2D
1.5	10・15	8,500	150	0.05D	2D	7,500	110	0.05D	2D	7,500	110	0.05D	2D
1.5	18	8,500	150	0.025D	2D	7,500	110	0.025D	2D	7,500	110	0.025D	2D
1.5	20	8,500	150	0.025D	2D	7,500	110	0.025D	2D	7,500	110	0.025D	2D
2.0	10・12・15	6,300	180	0.05D	3D	5,500	130	0.05D	3D	5,500	130	0.05D	3D
2.0	20	6,300	180	0.05D	3D	5,500	130	0.05D	3D	5,500	130	0.05D	3D
2.5	15・20・25	5,100	180	0.05D	3D	4,500	130	0.05D	3D	4,500	130	0.05D	3D
3.0	20・25.30	4,200	200	0.05D	3D	3,700	150	0.05D	3D	3,700	150	0.05D	3D