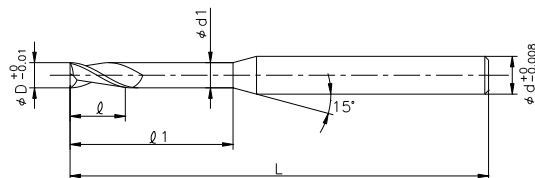


PRE-2

樹脂加工用超硬リブ用エンドミル
Tungsten Carbide Long Shank Endmill for Resin Processing

- 刃形状を樹脂加工用に調整し切れ味を良好にしました
Flute shape is arranged for resin processing with sharp edge
- 深彫り加工などに最適です
Ideal for deep engraving, etc



被削材 Workpiece	
樹脂 Resin	アルミ合金 Aluminum Alloy

- 切削条件表はP282に記載
- Cutting conditions are recommended on page 282.

単位[寸法: mm/価格: JPY]
Unit [size: mm/Retail Price: JPY]

品番 Code No.	刃径 D Flute Diameter	有効長 ℓ Effective Length	刃長 ℓ Flute Length	首下径 d1 Neck Diameter	全長 L Total Length	柄径 d Shank Diameter	標準価格 Retail Price
PRE-203020	0.3	2	0.6	0.27	45	4	11,100
PRE-203040	0.3	4	0.6	0.27	45	4	11,100
PRE-203060	0.3	6	0.6	0.27	45	4	12,400
PRE-204020	0.4	2	0.8	0.37	45	4	11,100
PRE-204040	0.4	4	0.8	0.37	45	4	11,100
PRE-204060	0.4	6	0.8	0.37	45	4	12,400
PRE-205020	0.5	2	1	0.45	45	4	6,600
PRE-205040	0.5	4	1	0.45	45	4	6,600
PRE-205060	0.5	6	1	0.45	45	4	6,600
PRE-205080	0.5	8	1	0.45	45	4	8,300
PRE-205100	0.5	10	1	0.45	50	4	8,300
PRE-206040	0.6	4	1.2	0.55	45	4	6,600
PRE-206060	0.6	6	1.2	0.55	45	4	6,600
PRE-206100	0.6	10	1.2	0.55	50	4	8,300
PRE-207040	0.7	4	1.4	0.65	45	4	6,600
PRE-207060	0.7	6	1.4	0.65	45	4	6,600
PRE-207100	0.7	10	1.4	0.65	50	4	8,300
PRE-208060	0.8	6	1.6	0.75	45	4	6,600
PRE-208080	0.8	8	1.6	0.75	45	4	6,600
PRE-208120	0.8	12	1.6	0.75	50	4	8,000
PRE-209060	0.9	6	1.8	0.85	45	4	6,600
PRE-209080	0.9	8	1.8	0.85	45	4	6,600
PRE-209120	0.9	12	1.8	0.85	50	4	8,000
PRE-210060	1	6	2	0.9	50	4	5,900
PRE-210080	1	8	2	0.9	50	4	5,900
PRE-210100	1	10	2	0.9	50	4	5,900
PRE-210120	1	12	2	0.9	50	4	5,900
PRE-210160	1	16	2	0.9	60	4	6,600
PRE-210200	1	20	2	0.9	60	4	6,600
PRE-212080	1.2	8	2.4	1.1	50	4	5,900

品番 Code No.	刃径 D Flute Diameter	有効長 ℓ Effective Length	刃長 ℓ Flute Length	首下径 d1 Neck Diameter	全長 L Total Length	柄径 d Shank Diameter	標準価格 Retail Price
PRE-212120	1.2	12	2.4	1.1	50	4	5,900
PRE-212160	1.2	16	2.4	1.1	60	4	6,600
PRE-215060	1.5	6	3	1.4	50	4	5,900
PRE-215100	1.5	10	3	1.4	50	4	5,900
PRE-215120	1.5	12	3	1.4	50	4	5,900
PRE-215160	1.5	16	3	1.4	60	4	6,600
PRE-215200	1.5	20	3	1.4	60	4	6,600
PRE-215250	1.5	25	3	1.4	70	4	8,000
PRE-220080	2	8	4	1.9	50	4	5,900
PRE-220100	2	10	4	1.9	50	4	5,900
PRE-220120	2	12	4	1.9	50	4	5,900
PRE-220160	2	16	4	1.9	60	4	6,600
PRE-220200	2	20	4	1.9	60	4	6,600
PRE-220250	2	25	4	1.9	70	4	8,000
PRE-220300	2	30	4	1.9	70	4	8,300
PRE-230080	3	8	6	2.8	60	6	6,800
PRE-230120	3	12	6	2.8	60	6	6,800
PRE-230160	3	16	6	2.8	60	6	6,800
PRE-230200	3	20	6	2.8	60	6	6,800
PRE-230250	3	25	6	2.8	70	6	7,300
PRE-230300	3	30	6	2.8	70	6	8,600
PRE-230350	3	35	6	2.8	80	6	10,500
PRE-230400	3	40	6	2.8	80	6	11,800
PRE-240120	4	12	8	3.8	60	6	7,300
PRE-240160	4	16	8	3.8	60	6	7,300
PRE-240200	4	20	8	3.8	60	6	7,300
PRE-240250	4	25	8	3.8	70	6	8,000
PRE-240300	4	30	8	3.8	70	6	8,900
PRE-240350	4	35	8	3.8	80	6	10,500
PRE-240400	4	40	8	3.8	80	6	11,800

PRE-2

切削条件参考

Referential Cutting Conditions

被削材 Workpiece	樹脂 Resin			アルミ合金 Aluminum Alloy		
	刃径 Flute Diameter mm	回転数 Revolution min ⁻¹	送り速度 Feed mm/min	切り込み深さ Cutting Depth	回転数 Revolution min ⁻¹	送り速度 Feed mm/min
0.3	32,000	700~ 900	0.05~0.2	32,000	300~ 450	0.002~0.01
0.4	32,000	750~1,000	0.05~0.25	32,000	300~ 500	0.003~0.01
0.5	32,000	800~1,200	0.05~0.25	32,000	350~ 750	0.005~0.015
0.6	32,000	750~1,200	0.1 ~0.4	32,000	350~ 900	0.005~0.02
0.7	30,000	700~1,100	0.1 ~0.4	32,000	350~ 850	0.005~0.03
0.8	26,000	600~1,000	0.12~0.5	32,000	400~1,050	0.005~0.05
0.9	22,000	550~ 880	0.12~0.5	32,000	400~ 950	0.005~0.07
1	20,000	500~ 800	0.15~0.6	28,000	400~1,200	0.005~0.08
1.2	16,000	500~ 800	0.2 ~0.7	24,000	450~1,350	0.007~0.1
1.5	12,600	450~ 700	0.25~0.9	19,000	450~1,200	0.01 ~0.12
2	9,600	400~ 600	0.35~1.5	14,000	500~1,600	0.02 ~0.2
3	6,400	350~ 550	0.5 ~2	9,500	500~1,750	0.03 ~0.25
4	4,800	320~ 500	0.6 ~2.5	7,500	550~1,750	0.05 ~0.3
5	4,000	300~ 450	0.8 ~3	6,000	550~1,800	0.1 ~0.3
備考 Remarks	<ul style="list-style-type: none"> 有効長により回転数、送り速度を調整して下さい。 樹脂はエアブロー、アルミ合金の場合は切削油を使用して下さい。 			<ul style="list-style-type: none"> Adjust Revolution and Feed Speed according to Effective Length. Use Air Blow for Resin and use Cutting Oil for Aluminum Alloy. 		