

KRKC-4

超硬R付キーシードカッター
Tungsten Carbide Keyseed Cutter with R

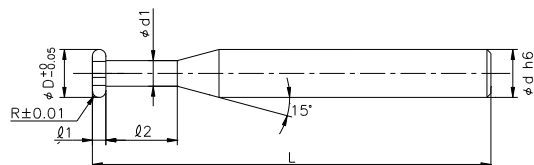
- 刃径φ3～φ12まで取り揃えました
Blade diameters from φ3 to φ12 are available
- R0.2～R2まで幅広くラインナップしました
A wide range of products from R0.2 to R2 are available
- 深溝加工向けに首径を細く設定しました
Narrow neck diameter for deep groove machining



被削材 Workpiece					
一般構造鋼 General Structural Steel	炭素鋼 Carbon Steel	合金鋼・工具鋼 Alloy Steel Tool Steel	プリハードン鋼 Pre-Harden Steel	鋳鉄 Cast Iron	アルミ合金 Aluminum Alloy
○	○	○	○	○	○

- 切削条件表はP252に記載
●Cutting conditions are recommended on page 252.

品番 Code No.	刃径D Flute Diameter	R	刃厚ℓ1 Blade Thickness	首径d1 Neck Diameter	首長ℓ2 Neck Length	全長L Total Length	柄径d Shank Diameter
KRKC-403002005	3	0.2	0.4	1.2	5	50	3
KRKC-403002010	3	0.2	0.4	1.2	10	50	3
KRKC-403002505	3	0.25	0.5	1.2	5	50	3
KRKC-403002510	3	0.25	0.5	1.2	10	50	3
KRKC-403003005	3	0.3	0.6	1.2	5	50	3
KRKC-403003010	3	0.3	0.6	1.2	10	50	3
KRKC-403004005	3	0.4	0.8	1.2	5	50	3
KRKC-403004010	3	0.4	0.8	1.2	10	50	3
KRKC-403005005	3	0.5	1	1.2	5	50	3
KRKC-403005010	3	0.5	1	1.2	10	50	3
KRKC-404002006	4	0.2	0.4	1.5	6	60	4
KRKC-404002012	4	0.2	0.4	1.5	12	60	4
KRKC-404002506	4	0.25	0.5	1.5	6	60	4
KRKC-404002512	4	0.25	0.5	1.5	12	60	4
KRKC-404003006	4	0.3	0.6	1.5	6	60	4
KRKC-404003012	4	0.3	0.6	1.5	12	60	4
KRKC-404004006	4	0.4	0.8	1.5	6	60	4
KRKC-404004012	4	0.4	0.8	1.5	12	60	4
KRKC-404005006	4	0.5	1	1.5	6	60	4
KRKC-404005012	4	0.5	1	1.5	12	60	4
KRKC-404007506	4	0.75	1.5	1.5	6	60	4
KRKC-404007512	4	0.75	1.5	1.5	12	60	4
KRKC-404010006	4	1	2	1.5	6	60	4
KRKC-404010012	4	1	2	1.5	12	60	4
KRKC-405002007	5	0.2	0.4	2	7	60	6
KRKC-405002015	5	0.2	0.4	2	15	60	6
KRKC-405002507	5	0.25	0.5	2	7	60	6
KRKC-405002515	5	0.25	0.5	2	15	60	6
KRKC-405003007	5	0.3	0.6	2	7	60	6
KRKC-405003015	5	0.3	0.6	2	15	60	6



単位[寸法:mm]
Unit [size:mm]

品番 Code No.	刃径D Flute Diameter	R	刃厚ℓ1 Blade Thickness	首径d1 Neck Diameter	首長ℓ2 Neck Length	全長L Total Length	柄径d Shank Diameter
KRKC-405004007	5	0.4	0.8	2	7	60	6
KRKC-405004015	5	0.4	0.8	2	15	60	6
KRKC-405005007	5	0.5	1	2	7	60	6
KRKC-405005015	5	0.5	1	2	15	60	6
KRKC-405007507	5	0.75	1.5	2	7	60	6
KRKC-405007515	5	0.75	1.5	2	15	60	6
KRKC-405010007	5	1	2	2	7	60	6
KRKC-405010015	5	1	2	2	15	60	6
KRKC-406002007	6	0.2	0.4	2.4	7	60	6
KRKC-406002015	6	0.2	0.4	2.4	15	60	6
KRKC-406002507	6	0.25	0.5	2.4	7	60	6
KRKC-406002515	6	0.25	0.5	2.4	15	60	6
KRKC-406003007	6	0.3	0.6	2.4	7	60	6
KRKC-406003015	6	0.3	0.6	2.4	15	60	6
KRKC-406004007	6	0.4	0.8	2.4	7	60	6
KRKC-406004015	6	0.4	0.8	2.4	15	60	6
KRKC-406005007	6	0.5	1	2.4	7	60	6
KRKC-406005015	6	0.5	1	2.4	15	60	6
KRKC-406007507	6	0.75	1.5	2.4	7	60	6
KRKC-406007515	6	0.75	1.5	2.4	15	60	6
KRKC-406010007	6	1	2	2.4	7	60	6
KRKC-406010015	6	1	2	2.4	15	60	6
KRKC-406015007	6	1.5	3	2.4	7	60	6
KRKC-406015015	6	1.5	3	2.4	15	60	6
KRKC-408002008	8	0.2	0.4	3	8	70	8
KRKC-408002016	8	0.2	0.4	3	16	70	8
KRKC-408002508	8	0.25	0.5	3	8	70	8
KRKC-408002516	8	0.25	0.5	3	16	70	8
KRKC-408003008	8	0.3	0.6	3	8	70	8
KRKC-408003016	8	0.3	0.6	3	16	70	8

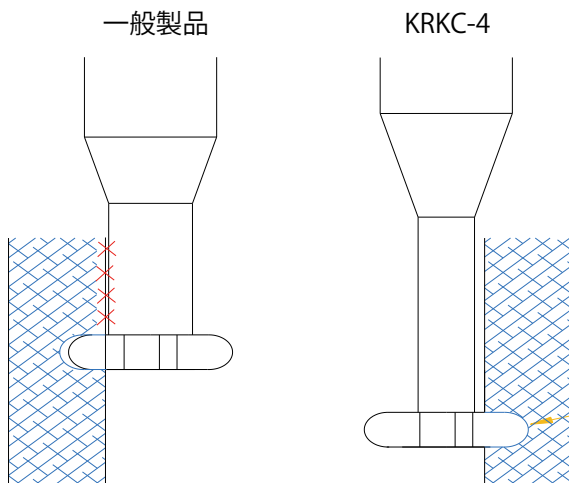
KRKC-4

品番 Code No.	刃径 D Flute Diameter	R	刃厚 $\ell 1$ Blade Thickness	首径 d1 Neck Diameter	首長 $\ell 2$ Neck Length	全長 L Total Length	柄径 d Shank Diameter
KRKC-408004008	8	0.4	0.8	3	8	70	8
KRKC-408004016	8	0.4	0.8	3	16	70	8
KRKC-408005008	8	0.5	1	3	8	70	8
KRKC-408005016	8	0.5	1	3	16	70	8
KRKC-408007508	8	0.75	1.5	3	8	70	8
KRKC-408007516	8	0.75	1.5	3	16	70	8
KRKC-408010008	8	1	2	3	8	70	8
KRKC-408010016	8	1	2	3	16	70	8
KRKC-408015008	8	1.5	3	3	8	70	8
KRKC-408015016	8	1.5	3	3	16	70	8
KRKC-408020008	8	2	4	3	8	70	8
KRKC-408020016	8	2	4	3	16	70	8
KRKC-410002010	10	0.2	0.4	3.5	10	80	10
KRKC-410002020	10	0.2	0.4	3.5	20	80	10
KRKC-410002510	10	0.25	0.5	3.5	10	80	10
KRKC-410002520	10	0.25	0.5	3.5	20	80	10
KRKC-410003010	10	0.3	0.6	3.5	10	80	10
KRKC-410003020	10	0.3	0.6	3.5	20	80	10
KRKC-410004010	10	0.4	0.8	3.5	10	80	10
KRKC-410004020	10	0.4	0.8	3.5	20	80	10
KRKC-410005010	10	0.5	1	3.5	10	80	10
KRKC-410005020	10	0.5	1	3.5	20	80	10
KRKC-410007510	10	0.75	1.5	3.5	10	80	10
KRKC-410007520	10	0.75	1.5	3.5	20	80	10
KRKC-410010010	10	1	2	3.5	10	80	10
KRKC-410010020	10	1	2	3.5	20	80	10
KRKC-410015010	10	1.5	3	3.5	10	80	10

品番 Code No.	刃径 D Flute Diameter	R	刃厚 $\ell 1$ Blade Thickness	首径 d1 Neck Diameter	首長 $\ell 2$ Neck Length	全長 L Total Length	柄径 d Shank Diameter
KRKC-410015020	10	1.5	3	3.5	20	80	10
KRKC-410020010	10	2	4	3.5	10	80	10
KRKC-410020020	10	2	4	3.5	20	80	10
KRKC-412002012	12	0.2	0.4	4	12	80	12
KRKC-412002024	12	0.2	0.4	4	24	80	12
KRKC-412002512	12	0.25	0.5	4	12	80	12
KRKC-412002524	12	0.25	0.5	4	24	80	12
KRKC-412003012	12	0.3	0.6	4	12	80	12
KRKC-412003024	12	0.3	0.6	4	24	80	12
KRKC-412004012	12	0.4	0.8	4	12	80	12
KRKC-412004024	12	0.4	0.8	4	24	80	12
KRKC-412005012	12	0.5	1	4	12	80	12
KRKC-412005024	12	0.5	1	4	24	80	12
KRKC-412007512	12	0.75	1.5	4	12	80	12
KRKC-412007524	12	0.75	1.5	4	24	80	12
KRKC-412010012	12	1	2	4	12	80	12
KRKC-412010024	12	1	2	4	24	80	12
KRKC-412015012	12	1.5	3	4	12	80	12
KRKC-412015024	12	1.5	3	4	24	80	12
KRKC-412020012	12	2	4	4	12	80	12
KRKC-412020024	12	2	4	4	24	80	12

超硬
カッター

Carbide
Cutter



POINT

- 一般製品より、深位置の溝加工が可能
- 一般製品より、深溝の加工が可能
- Rを施しました

KRKC-4

切削条件参考

Referential Cutting Conditions

被削材 Workpiece	炭素鋼・一般構造用鋼 Carbon Steel・ General Structural Steel S55C・SS材		合金鋼・工具鋼 Alloy Steel・Tool Steel SCM・SKT・SKS・SKD		プリハードン鋼 Pre-Harden Steel HPM-1・NAK55・SKT	
切削速度 Cutting Speed	20m/min		20m/min		20m/min	
加工深さ Machining Depth	0.1D		0.1D		0.1D	
刃 径 Flute Diameter mm	回転数 Revolution min ⁻¹	送り速度 Feed mm/min	回転数 Revolution min ⁻¹	送り速度 Feed mm/min	回転数 Revolution min ⁻¹	送り速度 Feed mm/min
3	2,120	120	2,100	70	2,100	70
4	1,590	120	1,500	67	1,500	67
5	1,270	95	1,200	54	1,200	54
6	1,060	80	1,060	47	1,060	47
8	800	60	800	47	800	47
10	640	60	650	47	650	47
12	530	50	550	35	550	35

被削材 Workpiece	アルミニウム合金 Aluminum Alloy ADC・AC		樹 脂 Resin			
切削速度 Cutting Speed	40m/min		45m/min			
加工深さ Machining Depth	0.25D		0.25D			
刃 径 Flute Diameter mm	回転数 Revolution min ⁻¹	送り速度 Feed mm/min	回転数 Revolution min ⁻¹	送り速度 Feed mm/min		
3	4,200	280	4,800	380		
4	3,100	280	3,600	380		
5	2,500	225	2,900	300		
6	2,100	190	2,400	250		
8	1,500	135	1,800	190		
10	1,200	135	1,400	190		
12	1,060	115	1,200	160		
備 考 Remarks	・回転数と送り速度は同じ割合で調整して下さい。・Adjust Revolution and Feed Speed at the same rate. ・切削油を使用して下さい。・Use Cutting Oil.					