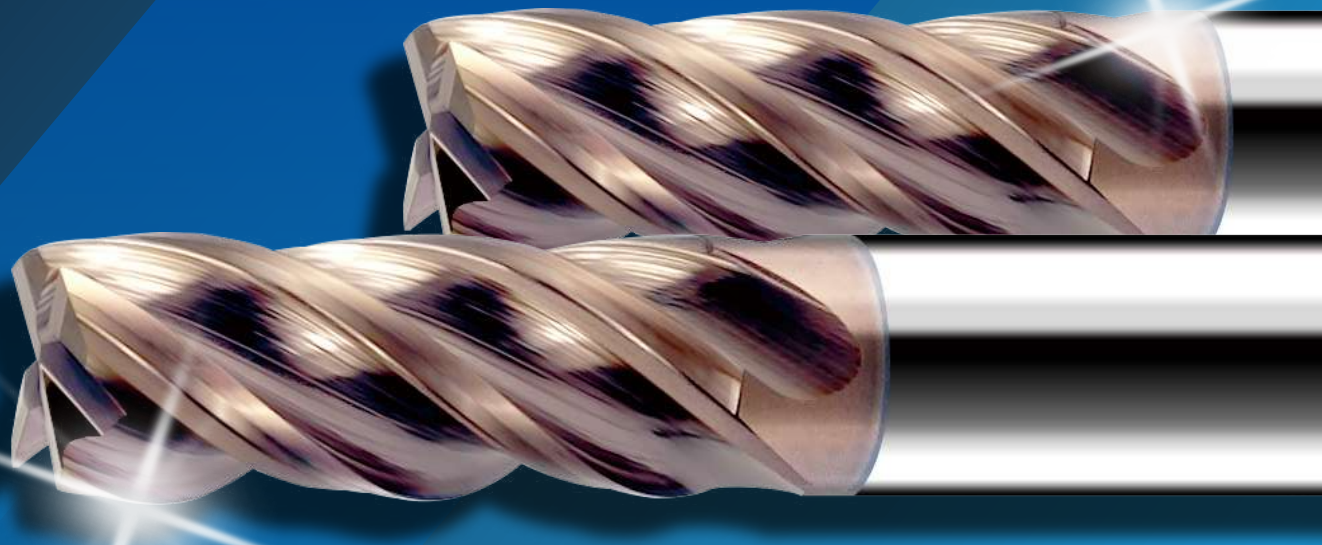
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MEMS

不銹鋼皆由我掌控！ **ALL-NEW**

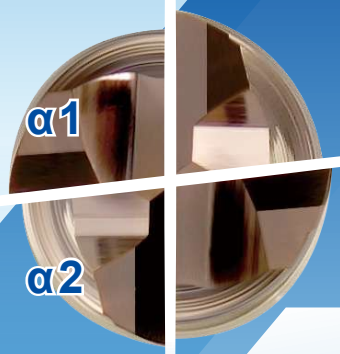
STAINLESS STEEL END MILLS

新一代不銹鋼之刀, 專為不銹鋼、泛用鋼材≦40HRC所設計!

For stainless steel and general steel(≦40HRC) machining.

M520極細鎢鋼不銹鋼用不等距型銑刀

M520 ULTRA CARBIDE END MILLS For STAINLESS- Unequal Flute Spacing Angle



α 1 ≠ α 2 不等距設計



螺旋角38° 設計

採用特殊不等距設計，可降低切削時的震動，提升加工穩定性.
Chattering is decreased dramatically with unequal flute spacing, increase processing stability.

圓弧溝槽設計，使排屑性能更加優異，減少積屑及應力產生，提升刀具剛性.
Circular flute design for better chip disposal, reduces chip packing, release stress and improving rigidity of the tool.

全新ALTISIN鍍層硬度及韌性兼具，更適合在嚴苛的環境下加工，且低摩擦係數特性，亦能降低切削阻力.
The new ALTISIN coating has both hardness and toughness, which is more suitable for processing in harsh environments. The low friction can also reduce the cutting resistance.

粗 加 工 Roughing | 中 加 工 Semi Finishing | 精 加 工 Finishing

尺寸規格表 / MEMS Carbide End Mills Size

CMTéc

刃徑 Diameter	刃長 Cutting Length	全長 O.A.L.	柄徑 Shank Dia.	刃數 Flutes	鍍膜訂購編號 Coated Order No.
3.0	8	50	4	4	MEMSM40300S
4.0	10	50	4	4	MEMSM40400S
2.0	5	50	6	4	MEMS40200S
3.0	8	50	6	4	MEMS40300S
4.0	10	50	6	4	MEMS40400S
4.0	12	50	6	4	MEMS40400120CS
5.0	13	50	6	4	MEMS40500S
6.0	15	50	6	4	MEMS40600S
6.0	18	50	6	4	MEMS40600180CS
8.0	20	60	8	4	MEMS40800S
8.0	24	60	8	4	MEMS40800240CS
10.0	25	75	10	4	MEMS41000S
10.0	30	75	10	4	MEMS41000300CS
12.0	30	75	12	4	MEMS41200S
12.0	36	75	12	4	MEMS41200360CS
14.0	30	75	14	4	MEMS4140014S
15.0	35	100	16	4	MEMS41500S
16.0	35	100	16	4	MEMS41600S
20.0	45	100	20	4	MEMS42000S

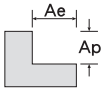
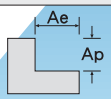
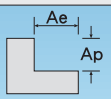
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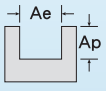
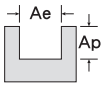
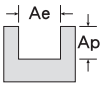


UMG AlCrTiSiN 38° HRC 60

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切削條件表 / Cutting Condition Table

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		不銹鋼 Stainless Steels	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SUS304	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		—	
切削速度 Vc	110m/min		90m/min		75m/min		70m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
3mm	11,670	1,100	9,550	840	7,960	620	7,430	610
4mm	8,750	1,200	7,160	980	5,970	680	5,570	710
5mm	7,000	1,300	5,730	1,050	4,770	720	4,450	770
6mm	5,830	1,600	4,770	1,200	3,980	890	3,710	830
8mm	4,370	1,550	3,580	1,100	2,980	810	2,780	810
10mm	3,500	1,450	2,860	1,050	2,380	720	2,220	710
12mm	2,910	1,400	2,380	1,000	1,990	720	1,850	675
16mm	2,180	1,200	1,790	940	1,490	630	1,390	550
20mm	1,750	980	1,430	750	1,190	590	1,110	510
25mm	1,400	880	1,140	670	955	530	890	480
切削量 Cutting Amount (mm)	Ap≦1.5D Ae≦0.2D 				Ap≦1.5D Ae≦0.1D 		Ap≦1.5D Ae≦0.1D 	

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		不銹鋼 Stainless Steels	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SUS304	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		—	
切削速度 Vc	95m/min		75m/min		70m/min		60m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
3mm	10,080	730	7,960	680	7,430	520	6,360	460
4mm	7,560	730	5,970	770	5,570	520	4,770	510
5mm	6,050	730	4,770	750	4,450	540	3,820	540
6mm	5,040	740	3,980	630	3,710	570	3,180	570
8mm	3,780	600	2,980	550	2,780	550	2,380	520
10mm	3,020	580	2,380	540	2,220	480	1,910	470
12mm	2,520	560	1,990	470	1,850	460	1,590	440
16mm	1,890	550	1,490	430	1,390	370	1,190	370
20mm	1,510	470	1,190	380	1,110	350	955	330
25mm	1,210	450	950	360	890	310	760	280
切削量 Cutting Amount (mm)	Ap≦1D 				Ap≦0.5D 		Ap≦0.5D 	

CMTec 西門德克

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