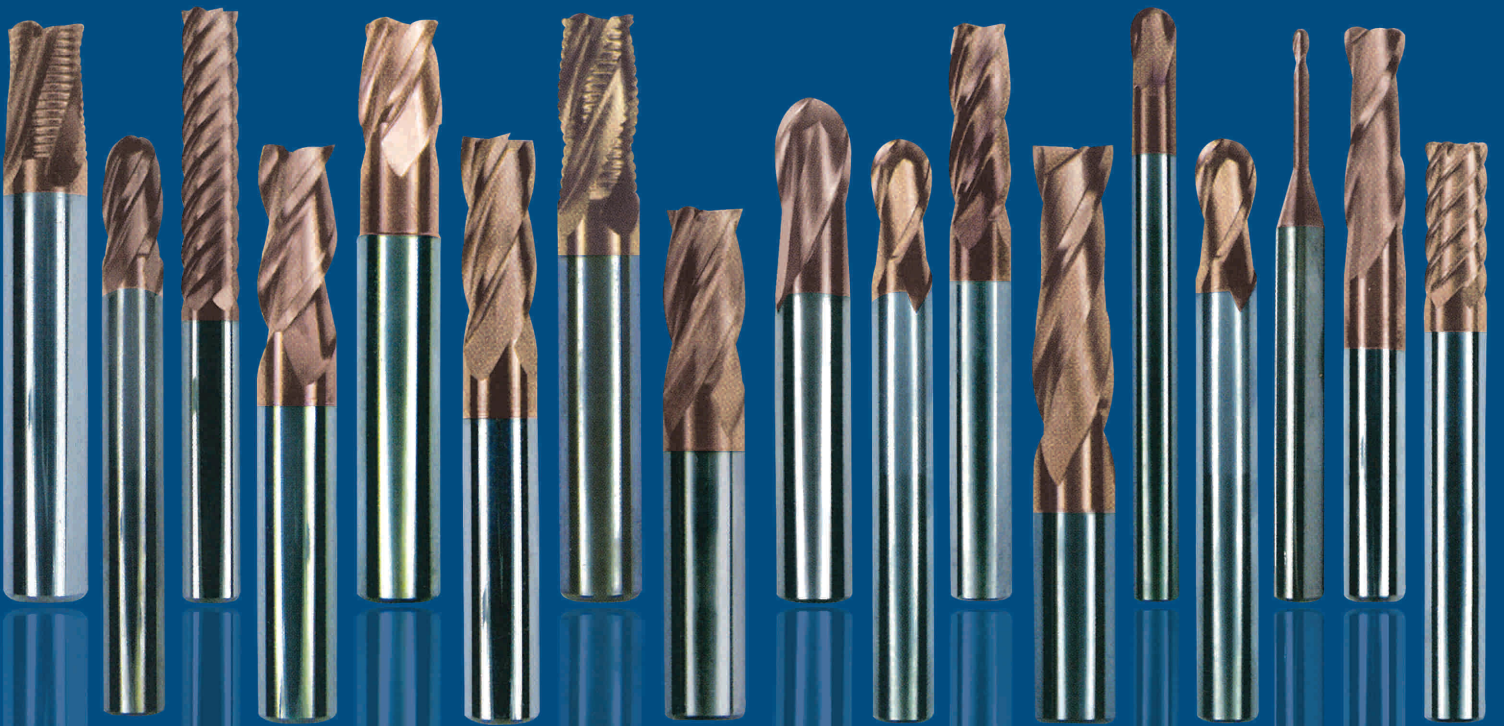


RAPID+[®]

CARBIDE ENDMILLS



2015
CATALOGUE



TiSiN

New Nano-composite coating material achieves extraordinary heat resistance and hardness. This is attained due to the new composite layer, consisting of nano-crystal material (Oxidizing temperature : 1100°C, Layer hardness : HV 3600).

Achieves extraordinary performance in high-speed cutting, and high efficient machining of hardened steel, machining efficiency is more than twice as effective as other manufacturers solid carbide end mills.

Ensuring long life and reliability in hardened steel applications (45~55HRC) material examples : 1.2080, 1.2344, and 1.2379, ASP Power Steels, High Speed Steels.

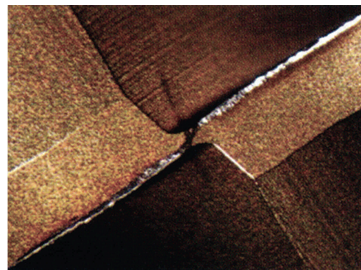
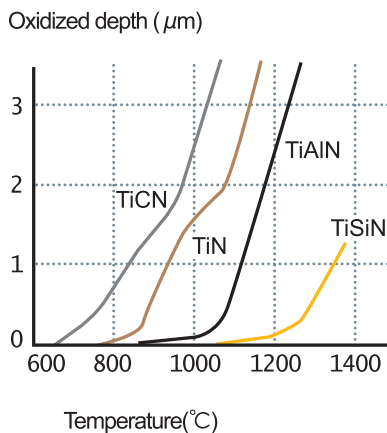
The coating generates less heat during cutting; therefore it is well suited to dry machining conditions.

Newly developed TH Coating has excellent oxidation-resistant properties, this achieves :

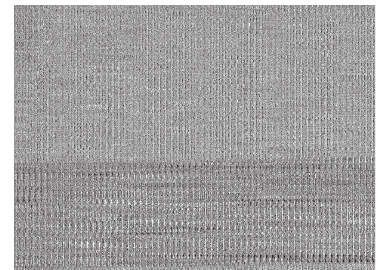
High speed cutting of hard steels = High Efficiency

Improvement in tool life = Lower tooling costs The newly designed flute geometry increases rigidity, with the improved high radius accuracy producing higher tolerance, and smoother surface finish.

Direct milling of hardened steel is now possible = Faster production times.



market standard High performance



SI hard coating



Square series - 4 flutes

600
Nano

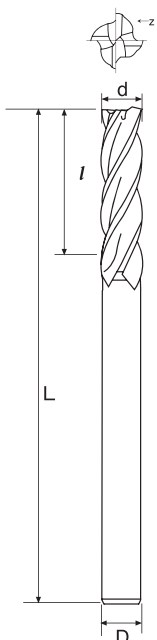
HRC
▶ 55

35°

TISIN

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6µm



Mode	Diameter	Flute Length	Full Length	Shank Diameter	Flute Quantity	Price USD
RP MIE 0022 T	0.2	0.4	50	4	2	33.50
RP MIE 0032 T	0.3	0.6	50	4	2	23.20
RP MIE 0042 T	0.4	0.8	50	4	2	23.20
RP MIE 0052 T	0.5	1	50	4	2	18.30
RP MIE 0062 T	0.6	1.2	50	4	2	21.10
RP MIE 0072 T	0.7	1.4	50	4	2	21.10
RP MIE 0082 T	0.8	1.6	50	4	2	21.10
RP MIE 0092 T	0.9	1.8	50	4	2	21.10
RP MSE 0104 T	1	3	50	4	4	11.70
RP MSE 0154 T	1.5	4	50	4	4	11.70
RP MSE 0204 T	2	6	50	4	4	11.70
RP MSE 0254 T	2.5	8	50	4	4	11.70
RP SSE 0304 T	3	8	50	3	4	11.70
RP MSE 0304 T	3	8	50	4	4	11.70
RP MSE 0354 T	3.5	10	50	4	4	11.70
RP MSE 0404 T	4	11	50	4	4	11.70
RP SE 0104 T	1	3	50	6	4	13.90
RP SE 0154 T	1.5	4	50	6	4	13.90
RP SE 0204 T	2	6	50	6	4	13.90
RP SE 0254 T	2.5	8	50	6	4	13.90
RP SE 0304 T	3	8	50	6	4	13.90
RP SE 0354 T	3.5	10	50	6	4	13.90
RP SE 0404 T	4	11	50	6	4	13.90
RP SE 0504 T	5	13	50	6	4	13.90
RP SE 0604 T	6	16	50	6	4	13.90
RP SE 0704 T	7	16	60	8	4	29.40
RP SE 0804 T	8	20	60	8	4	29.40
RP SE 0904 T	9	20	75	10	4	42.00
RP SE 1004 T	10	30	75	10	4	42.00
RP SE 1104 T	11	30	75	12	4	58.80
RP SE 1204 T	12	32	75	12	4	58.80



Square series - Long Shank - 4 flutes

600
Nano

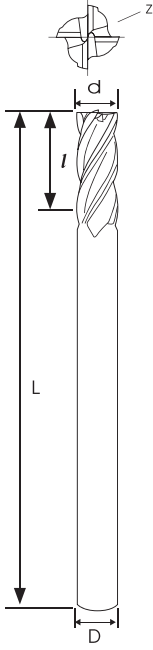
HRC
▶ 55

35°

TISIN

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



Mode	Diameter	Flute Length	Full Length	Shank Diameter	Flute Quantity	Price USD
RP SLE 0604 T	6	16	75	6	4	20.10
RP MLE 0604 T	6	16	100	6	4	24.80
RP SLE 0804 T	8	20	75	8	4	37.20
RP MLE 0804 T	8	20	100	8	4	41.70
RP SLE 1004 T	10	30	100	10	4	56.70
RP MLE 1004 T	10	30	150	10	4	86.70
RP SLE 1204 T	12	32	100	12	4	73.50
RP MLE 1204 T	12	32	150	12	4	107.70

Square series - Long Flute - 4 flutes

600
Nano

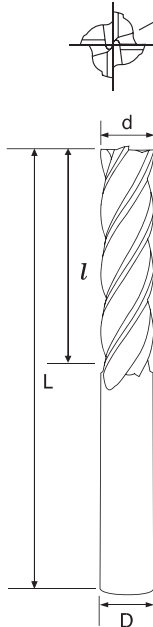
HRC
▶ 55

35°

TISIN

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



Mode	Diameter	Flute Length	Full Length	Shank Diameter	Flute Quantity	Price USD
RP LET 0104 T	1	6	50	4	4	16.60
RP LET 0154 T	1.5	9	50	4	4	16.60
RP LET 0204 T	2	12	50	4	4	16.60
RP LET 0254 T	2.5	12	50	4	4	16.60
RP LET 0304 T	3	15	60	6	4	19.80
RP LET 0354 T	3.5	15	60	6	4	19.80
RP LET 0404 T	4	20	75	6	4	24.20
RP LET 0504 T	5	25	75	6	4	24.20
RP LET 0604 T	6	30	75	6	4	24.20
RP LET 0704 T	7	30	100	8	4	41.70
RP LET 0804 T	8	40	100	8	4	41.70
RP LET 0904 T	9	40	100	10	4	56.70
RP LET 1004 T	10	40	100	10	4	56.70
RP LET 1104 T	11	40	100	12	4	73.50
RP LET 1204 T	12	50	100	12	4	73.50

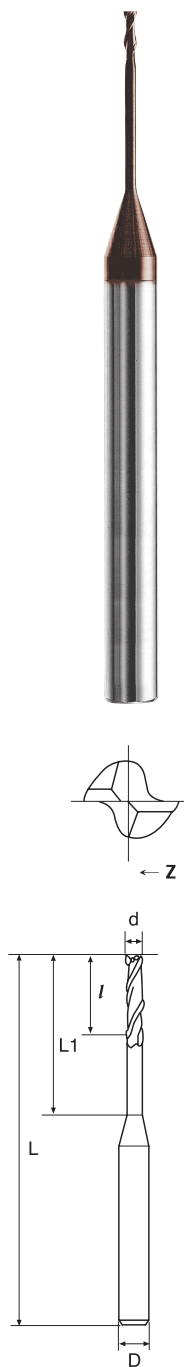


Square / Ball Nose series - Long Neck - 2 flutes



● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6µm



Mode	Diameter	Flute Length	Efficient Length	Full Length	Shank Diameter	Flute Quantity	Square Price USD	Ball Nose Price USD
RP LNT 05022 T	0.5	0.75	2	50	4	2	33.10	35.90
RP LNT 05042 T	0.5	0.75	4	50	4	2	33.10	35.90
RP LNT 05062 T	0.5	0.75	6	50	4	2	33.10	35.90
RP LNT 06022 T	0.6	0.9	2	50	4	2	30.30	34.30
RP LNT 06042 T	0.6	0.9	4	50	4	2	30.30	34.30
RP LNT 06062 T	0.6	0.9	6	50	4	2	30.30	34.30
RP LNT 07042 T	0.7	1.1	4	50	4	2	30.30	34.30
RP LNT 07062 T	0.7	1.1	6	50	4	2	30.30	34.30
RP LNT 08042 T	0.8	1.2	4	50	4	2	30.30	34.30
RP LNT 08062 T	0.8	1.2	6	50	4	2	30.30	34.30
RP LNT 08082 T	0.8	1.2	8	50	4	2	30.30	34.30
RP LNT 09062 T	0.9	1.4	6	50	4	2	30.30	34.30
RP LNT 09082 T	0.9	1.4	8	50	4	2	30.30	34.30
RP LNT 09102 T	0.9	1.4	10	50	4	2	30.30	34.30
RP LNT 10062 T	1	1.5	6	50	4	2	22.30	25.90
RP LNT 10082 T	1	1.5	8	50	4	2	22.30	25.90
RP LNT 10102 T	1	1.5	10	50	4	2	22.30	25.90
RP LNT 10122 T	1	1.5	12	50	4	2	22.30	25.90
RP LNT 10162 T	1	1.5	16	50	4	2	22.30	25.90
RP LNT 12062 T	1.2	1.8	6	50	4	2	30.30	31.90
RP LNT 12082 T	1.2	1.8	8	50	4	2	30.30	31.90
RP LNT 12102 T	1.2	1.8	10	50	4	2	30.30	31.90
RP LNT 12122 T	1.2	1.8	12	50	4	2	30.30	31.90
RP LNT 14062 T	1.4	2.1	6	50	4	2	30.30	31.90
RP LNT 14102 T	1.4	2.1	10	50	4	2	30.30	31.90
RP LNT 14162 T	1.4	2.1	16	50	4	2	30.30	31.90
RP LNT 15062 T	1.5	2.3	6	50	4	2	22.30	25.90
RP LNT 15082 T	1.5	2.3	8	50	4	2	22.30	25.90
RP LNT 15102 T	1.5	2.3	10	50	4	2	22.30	25.90
RP LNT 15122 T	1.5	2.3	12	50	4	2	22.30	25.90
RP LNT 15142 T	1.5	2.3	14	50	4	2	22.30	25.90
RP LNT 15162 T	1.5	2.3	16	50	4	2	22.30	25.90
RP LNT 15182 T	1.5	2.3	18	50	4	2	22.30	25.90
RP LNT 15202 T	1.5	2.3	20	50	4	2	22.30	25.90
RP LNT 16062 T	1.6	2.4	6	50	4	2	30.30	31.90
RP LNT 16082 T	1.6	2.4	8	50	4	2	30.30	31.90
RP LNT 16102 T	1.6	2.4	10	50	4	2	30.30	31.90
RP LNT 16122 T	1.6	2.4	12	50	4	2	30.30	31.90



Square / Ball Nose series - Long Neck - 2 flutes

600
Nano

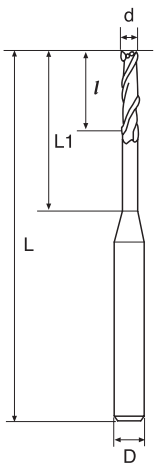
HRC
▶ 55

30°

TISIN

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



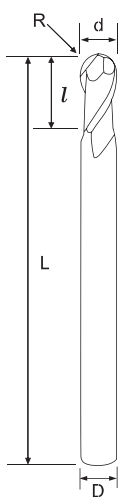
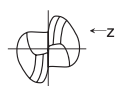
Mode	Diameter	Flute Length	Efficient Length	Full Length	Shank Diameter	Flute Quantity	Square Price USD	Ball Nose Price USD
RP LNT 16142 T	1.6	2.4	14	50	4	2	30.30	31.90
RP LNT 16162 T	1.6	2.4	16	50	4	2	30.30	31.90
RP LNT 16182 T	1.6	2.4	18	50	4	2	30.30	31.90
RP LNT 18082 T	1.8	2.7	8	50	4	2	30.30	31.90
RP LNT 18142 T	1.8	2.7	14	50	4	2	30.30	31.90
RP LNT 18202 T	1.8	2.7	20	50	4	2	30.30	31.90
RP LNT 20062 T	2	3	6	50	4	2	22.30	25.90
RP LNT 20082 T	2	3	8	50	4	2	22.30	25.90
RP LNT 20102 T	2	3	10	50	4	2	22.30	25.90
RP LNT 20122 T	2	3	12	50	4	2	22.30	25.90
RP LNT 20142 T	2	3	14	50	4	2	22.30	25.90
RP LNT 20162 T	2	3	16	50	4	2	22.30	25.90
RP LNT 20182 T	2	3	18	50	4	2	22.30	25.90
RP LNT 20202 T	2	3	20	50	4	2	22.30	25.90
RP LNT 25082 T	2.5	4	8	50	4	2	22.30	25.90
RP LNT 25102 T	2.5	4	10	50	4	2	22.30	25.90
RP LNT 25122 T	2.5	4	12	50	4	2	22.30	25.90
RP LNT 25142 T	2.5	4	14	50	4	2	22.30	25.90
RP LNT 25162 T	2.5	4	16	50	1	2	22.30	25.90
RP LNT 25202 T	2.5	4	20	50	4	2	22.30	25.90
RP LNT 30022 T	3	4.5	8	50	6	2	26.30	30.30
RP LNT 30102 T	3	4.5	10	50	6	2	26.30	30.30
RP LNT 30122 T	3	4.5	12	50	6	2	26.30	30.30
RP LNT 30162 T	3	4.5	16	60	6	2	27.90	33.10
RP LNT 30202 T	3	4.5	20	60	6	2	27.90	33.10
RP LNT 30252 T	3	6	25	75	6	2	30.30	35.20
RP LNT 35122 T	3.5	6	12	50	6	2	26.30	30.30
RP LNT 35162 T	3.5	6	16	60	6	2	30.30	35.20
RP LNT 35202 T	3.5	6	20	75	6	2	30.30	35.20
RP LNT 35252 T	3.5	6	25	75	6	2	30.30	35.20
RP LNT 35302 T	3.5	6	30	75	6	2	30.30	35.20
RP LNT 40122 T	4	6	12	50	6	2	26.30	30.30
RP LNT 40162 T	4	6	16	60	6	2	27.90	33.10
RP LNT 40202 T	4	6	20	75	6	2	30.30	35.20
RP LNT 40252 T	4	6	25	75	6	2	30.30	35.20
RP LNT 40302 T	4	6	30	75	6	2	30.30	35.20
RP LNT 40352 T	4	6	35	75	6	2	30.30	35.20

Ball Nose - 2 flutes



● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6µm



Mode	Diameter	Flute Length	Full Length	Shank Diameter	Radius of Ball Nose	Flute Quantity	Price USD
RP MIB0032 T	0.3	0.6	50	4	0.15	2	41.20
RP MIB0042 T	0.4	0.8	50	4	0.20	2	37.50
RP MIB0052 T	0.5	1	50	4	0.25	2	27.60
RP MIB0062 T	0.6	1.2	50	4	0.30	2	27.60
RP MIB0072 T	0.7	1.4	50	4	0.35	2	27.60
RP MIB0082 T	0.8	1.6	50	4	0.40	2	25.10
RP MIB0092 T	0.9	1.8	50	4	0.45	2	25.10
RP MSB0102 T	1	2	50	4	0.5	2	15.10
RP MSB0152 T	1.5	3	50	4	0.75	2	15.10
RP MSB0202 T	2	4	50	4	1	2	15.10
RP MSB0252 T	2.5	5	50	4	1.25	2	15.10
RP SSB0302 T	3	6	50	3	1.5	2	15.10
RP MSB0302 T	3	6	50	4	1.5	2	15.10
RP SSB0352 T	3.5	7	50	4	1.75	2	15.10
RP MSB0402 T	4	7	50	4	2	2	15.10
RP SB0102 T	1	2	50	6	0.5	2	19.50
RP SB0152 T	1.5	3	50	6	0.75	2	19.50
RP SB0202 T	2	4	50	6	1	2	19.50
RP SB0252 T	2.5	5	50	6	1.25	2	19.50
RP SB0302 T	3	6	50	6	1.5	2	19.50
RP SB0352 T	3.5	7	50	6	1.75	2	19.50
RP SB0402 T	4	8	50	6	2	2	19.50
RP SB0502 T	5	10	50	6	2.5	2	19.50
RP SB0602 T	6	12	50	6	3	2	19.50
RP SB0702 T	7	14	60	8	3.5	2	33.30
RP SB0802 T	8	16	60	8	4	2	33.30
RP SB0902 T	9	18	75	10	4.5	2	49.70
RP SB1002 T	10	20	75	10	5	2	49.70
RP SB1102 T	11	22	75	12	5.5	2	71.50
RP SB1202 T	12	24	75	12	6	2	71.50



Ball Nose - Long Shank - 2 flutes

600
Nano

HRC
▶ 55

30°

TISIN

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



Mode	Diameter	Flute Length	Full Length	Shank Diameter	Radius of Ball Nose	Flute Quantity	Price USA
RP SLB0102 T	1	2	75	6	0,5	2	25,10
RP MLB0102 T	1	2	100	6	0,5	2	29,10
RP SLB0152 T	1,5	3	75	6	0,75	2	25,10
RP MLB0152 T	1,5	3	100	6	0,75	2	29,10
RP SLB0202 T	2	4	75	6	1	2	25,10
RP MLB0202 T	2	4	100	6	1	2	29,10
RP SLB0252 T	2,5	5	75	6	1,25	2	25,10
RP MLB0252 T	2,5	5	100	6	1,25	2	29,10
RP SLB0302 T	3	6	75	6	1,5	2	25,10
RP MLB0302 T	3	6	100	6	1,5	2	29,10
RP MLB0352 T	3,5	7	100	6	1,75	2	29,10
RP SLB0402 T	4	8	75	6	2	2	25,10
RP MLB0402 T	4	8	100	6	2	2	29,10
RP SLB0502 T	5	10	75	6	2,5	2	26,30
RP MLB0502 T	5	10	100	6	2,5	2	31,80
RP SLB0602 T	6	12	75	6	3	2	26,30
RP MLB0602 T	6	12	100	6	3	2	31,80
RP LLB0602 T	6	12	150	6	3	2	46,40
RP SLB0802 T	8	16	75	8	4	2	37,80
RP MLB0802 T	8	16	100	8	4	2	48,10
RP LLB0802 T	8	16	150	8	4	2	66,10
RP MLB1002 T	10	20	100	10	5	2	63,10
RP LLB1002 T	10	20	150	10	5	2	79,80
RP XLB1002 T	10	20	200	10	5	2	105,10
RP MLB1202 T	12	24	100	12	6	2	83,30
RP LLB1202 T	12	24	150	12	6	2	94,60
RP XLB1202 T	12	24	200	12	6	2	143,70

Corner Radius series - 4 flutes

600
Nano

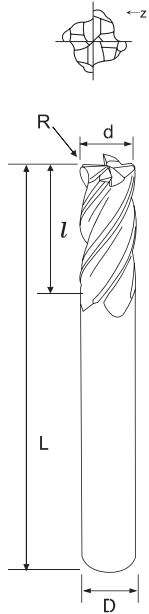
HRC
▶ 55

35°

TISIN

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6µm



Mode	Diameter	Flute Length	Full Length	Shank Diameter	Radius of Ball Nose	Flute Quantity	Price USD
RP RTA 020054 T	2	6	50	3	0.5	4	21.90
RP RTA 030054 T	3	8	50	3	0.5	4	21.90
RP RTA 030104 T	3	8	50	3	1	4	21.90
RP RTA 040054 T	4	10	50	4	0.5	4	21.90
RP RTA 040104 T	4	10	50	4	1	4	21.90
RP RTA 050054 T	5	13	50	6	0.5	4	24.20
RP RTA 050104 T	5	13	50	6	1	4	24.20
RP RTA 060054 T	6	15	50	6	0.5	4	24.20
RP RTA 060104 T	6	15	50	6	1	4	24.20
RP RTA 080054 T	8	20	60	8	0.5	4	37.10
RP RTA 080104 T	8	20	60	8	1	4	37.10
RP RTA 100054 T	10	25	75	10	0.5	4	51.80
RP RTA 100104 T	10	25	75	10	1	4	51.80
RP RTA 120054 T	12	30	75	12	0.5	4	71.40
RP RTA 120104 T	12	30	75	12	1	4	71.40

Corner Radius - Long Shank - 4 flutes

600
Nano

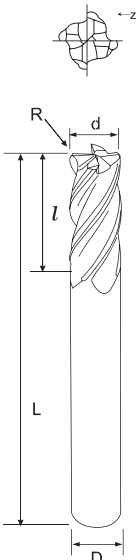
HRC
▶ 55

35°

TISIN

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6µm



Mode	Diameter	Flute Length	Full Length	Shank Diameter	Radius of Ball Nose	Flute Quantity	Price USD
RP LRTA 030054 T	3	8	75	3	0.5	4	25.40
RP LRTA 030104 T	3	8	75	3	1	4	25.40
RP LRTA 040054 T	4	10	75	4	0.5	4	25.40
RP LRTA 040104 T	4	10	75	4	1	4	25.40
RP LRTA 060054 T	6	15	100	6	0.5	4	33.30
RP LRTA 060104 T	6	15	100	6	1	4	33.30
RP LRTA 080054 T	8	20	100	8	0.5	4	52.50
RP LRTA 080104 T	8	20	100	8	1	4	52.50
RP LRTA 100054 T	10	25	100	10	0.5	4	66.90
RP LRTA 100104 T	10	25	100	10	1	4	66.90
RP LRTA 120054 T	12	30	100	12	0.5	4	84.00
RP LRTA 120104 T	12	30	100	12	1	4	84.00

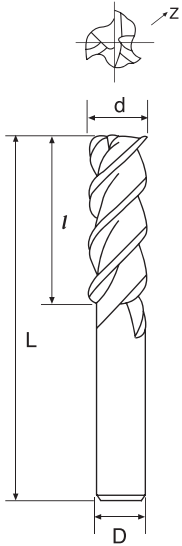


Square Series - For Aluminum - 3 flutes



● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



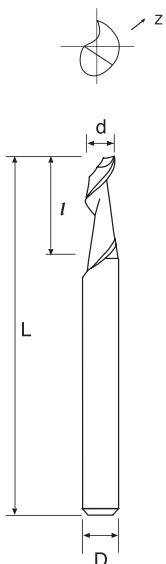
Mode	Diameter	Flute Length	Full Length	Shank Diameter	Flute Quantity	Price USD
RP AE50303	3	9	50	6	3	14.60
RP AE50403	4	12	50	6	3	14.60
RP AE50503	5	15	50	6	3	14.60
RP AE50603	6	18	50	6	3	14.60
RP AE50803	8	20	60	8	3	31.20
RP AE51003	10	30	75	10	3	46.20
RP AE51203	12	32	75	12	3	62.30

Square series - For Wood & Plastic & Aluminum - 1 flute



● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



Mode	Diameter	Flute Length	Full Length	Shank Diameter	Flute Quantity	Price USD
RP AP 0300	3	12	50	3	1	14.10
RP AP 0400	4	15	50	4	1	15.60
RP AP 0500	5	16	50	5	1	17.30
RP AP 0600	6	19	57	6	1	22.30
RP AP 0800	8	22	60	8	1	37.50
RP AP 1000	10	23	72	10	1	45.40
RP AP 1200	12	25	80	12	1	57.40
RP AP 0301	3	15	60	3	1	18.60
RP AP 0401	4	16	60	4	1	20.80
RP AP 0501	5	18	63	5	1	21.50
RP AP 0601	6	25	75	6	1	29.50
RP AP 0801	8	32	75	8	1	41.10
RP AP 1001	10	40	100	10	1	60.10
RP AP 1201	12	45	100	12	4	76.00



• P-SSE/P-MSE/P-SE/P-MPE/P-PE(45°) 4T SIDE MILLING P-SSE/P-MSE/P-SE/P-MPE/P-PE(45°) 4刃 側銑

WORK MATERIAL 被切材料	MILD STEELS, CARBON STEELS, CAST IRON S45C - S55C - FC250 (+750N/mm) 一般構造用鋼、碳素鋼、鑄鐵		ALLOY STEELS, TOOL STEELS S20M - SKT - SK3 - SKD (+30HRC) 合金鋼、工具鋼		HARDENED STEELS, PREHARDENED STEELS SKT - SKD - NAK55 - HPMM (30-38HRC) 硬鋼、預硬鋼		STAINLESS STEELS, HARDENED STEELS SUS304 - SKD (38-45HRC) 不銹鋼、硬鋼		HARDENED STEELS, TITANIUM ALLOY STEELS (45-55HRC) 硬鋼、鈦合金		HEAT RESISTANT ALLOY STEELS INCONEL 耐熱合金鋼、高純合金	
	MILL DIA (mm) 直徑	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速
3	12,500	880	9,550	672	9,100	500	7,650	492	7,400	436	3,800	176
4	9,750	960	7,550	788	6,400	544	6,050	568	5,850	504	3,000	192
5	7,950	1,040	6,150	840	5,250	580	4,350	620	4,800	536	2,450	196
6	6,750	1,280	5,250	960	4,450	712	4,200	668	4,050	596	2,100	200
8	5,050	1,240	3,950	880	3,350	652	3,150	648	3,050	540	1,600	180
10	4,100	1,160	3,200	840	2,700	580	2,550	572	2,450	508	1,250	172
12	3,400	1,120	2,650	800	2,250	576	2,100	540	2,050	464	1,050	168
16	2,550	960	2,000	752	1,700	508	1,600	444	1,550	404	785	168
20	2,050	788	1,600	604	1,350	472	1,250	412	1,250	368	635	160
25	1,650	704	1,250	540	1,100	428	1,000	368	990	316	510	148

DEPTH OF CUT
加工深度

• P-SSE/P-MSE/P-SE/P-MPE/P-PE(45°) 4T 溝銑 P-SSE/P-MSE/P-SE/P-MPE/P-PE(45°) 4T 溝銑

WORK MATERIAL 被切材料	MILD STEELS, CARBON STEELS, CAST IRON S45C - S55C - FC250 (+750N/mm) 一般構造用鋼、碳素鋼、鑄鐵		ALLOY STEELS, TOOL STEELS S20M - SKT - SK3 - SKD (+30HRC) 合金鋼、工具鋼		HARDENED STEELS, PREHARDENED STEELS SKT - SKD - NAK55 - HPMM (30-38HRC) 硬鋼、預硬鋼		STAINLESS STEELS, HARDENED STEELS SUS304 - SKD (38-45HRC) 不銹鋼、硬鋼		HARDENED STEELS, TITANIUM ALLOY STEELS (45-55HRC) 硬鋼、鈦合金		HEAT RESISTANT ALLOY STEELS INCONEL 耐熱合金鋼、高純合金	
	MILL DIA (mm) 直徑	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速	FEED (mm/min) 進給速	SPEED (min ⁻¹) 迴轉速
3	10,500	584	3,550	544	7,650	416	7,450	368	7,200	352	2,500	100
4	7,750	584	6,400	620	5,900	416	5,550	412	5,400	396	1,900	108
5	6,200	588	5,100	604	4,700	436	4,450	436	4,300	428	1,500	116
6	5,150	532	4,250	568	3,950	460	3,700	456	3,600	436	1,250	116
8	3,850	480	3,200	440	2,950	440	2,800	420	2,700	408	945	124
10	3,100	464	2,550	432	2,350	384	2,250	360	2,150	364	760	116
12	2,600	448	2,150	380	1,950	368	1,850	352	1,800	348	630	116
16	1,950	444	1,600	344	1,500	296	1,400	296	1,350	292	475	88
20	1,550	360	1,300	304	1,200	264	1,100	264	1,100	264	380	68
25	1,250	360	1,000	292	945	252	890	228	865	168	300	64

DEPTH OF CUT
加工深度



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