

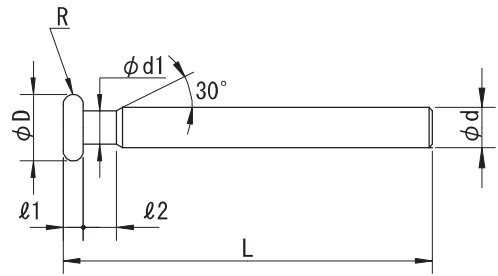
超硬

# CSMUL-A

切削条件表

P254

超硬スーパーミニコンベックス ロング Carbide Solid Super Mini Convex Cutter Long



|               |                                                       |                                                         |          |                                                       |
|---------------|-------------------------------------------------------|---------------------------------------------------------|----------|-------------------------------------------------------|
| 公差(Tolerance) | D: $\begin{smallmatrix} 0 \\ -0.05 \end{smallmatrix}$ | ℓ1: $\begin{smallmatrix} 0 \\ -0.035 \end{smallmatrix}$ | R: ±0.01 | d: $\begin{smallmatrix} 0 \\ -0.01 \end{smallmatrix}$ |
|---------------|-------------------------------------------------------|---------------------------------------------------------|----------|-------------------------------------------------------|

右刃ストレート TiAlNコーティング 超微粒子  
Straight Flute TiAlN Coating Ultra Micro Grain Carbide

| 刃径 (ΦD)<br>Dia. | R    | 刃厚 (ℓ1)<br>Cut Width | 首径 (d1)<br>Neck Dia. | 首長 (ℓ2)<br>Neck Length | 全長 (L)<br>Overall Length | シャンク径 (Φd)<br>Shank Dia. | 刃数 (N)<br>Number of Flutes |
|-----------------|------|----------------------|----------------------|------------------------|--------------------------|--------------------------|----------------------------|
| 4               | 0.25 | 0.5                  | 2                    | 5                      | 80                       | 3                        | 4                          |
|                 | 0.3  | 0.6                  | 2                    | 5                      | 80                       | 3                        | 4                          |
|                 | 0.5  | 1                    | 2                    | 5                      | 80                       | 3                        | 4                          |
|                 | 0.75 | 1.5                  | 2                    | 5                      | 80                       | 3                        | 4                          |
|                 | 1    | 2                    | 1.8                  | 5                      | 80                       | 3                        | 4                          |
| 5               | 0.25 | 0.5                  | 2.6                  | 5                      | 80                       | 3                        | 4                          |
|                 | 0.3  | 0.6                  | 2.6                  | 5                      | 80                       | 3                        | 4                          |
|                 | 0.5  | 1                    | 2.6                  | 5                      | 80                       | 3                        | 4                          |
|                 | 0.75 | 1.5                  | 2.6                  | 5                      | 80                       | 3                        | 4                          |
|                 | 1    | 2                    | 2.6                  | 5                      | 80                       | 3                        | 4                          |
| 6               | 0.25 | 0.5                  | 2.9                  | 5                      | 80                       | 3                        | 4                          |
|                 | 0.3  | 0.6                  | 2.9                  | 5                      | 80                       | 3                        | 4                          |
|                 | 0.5  | 1                    | 2.9                  | 5                      | 80                       | 3                        | 4                          |
|                 | 0.75 | 1.5                  | 2.9                  | 5                      | 80                       | 3                        | 4                          |
|                 | 1    | 2                    | 2.9                  | 5                      | 80                       | 3                        | 4                          |
| 8               | 0.25 | 0.5                  | 3.9                  | 5                      | 80                       | 4                        | 6                          |
|                 | 0.3  | 0.6                  | 3.9                  | 5                      | 80                       | 4                        | 6                          |
|                 | 0.5  | 1                    | 3.9                  | 5                      | 80                       | 4                        | 6                          |
|                 | 0.75 | 1.5                  | 3.9                  | 5                      | 80                       | 4                        | 6                          |

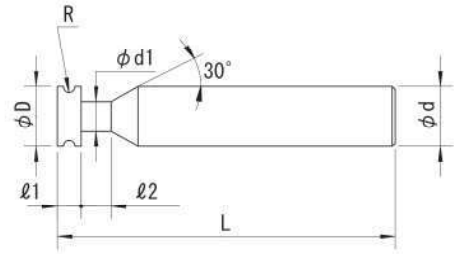
| 刃径 (ΦD)<br>Dia. | R    | 刃厚 (ℓ1)<br>Cut Width | 首径 (d1)<br>Neck Dia. | 首長 (ℓ2)<br>Neck Length | 全長 (L)<br>Overall Length | シャンク径 (Φd)<br>Shank Dia. | 刃数 (N)<br>Number of Flutes |
|-----------------|------|----------------------|----------------------|------------------------|--------------------------|--------------------------|----------------------------|
| 8               | 1    | 2                    | 3.9                  | 5                      | 80                       | 4                        | 6                          |
|                 | 1.25 | 2.5                  | 3.9                  | 5                      | 80                       | 4                        | 6                          |
| 10              | 0.25 | 0.5                  | 5                    | 6                      | 100                      | 6                        | 6                          |
|                 | 0.3  | 0.6                  | 5                    | 6                      | 100                      | 6                        | 6                          |
|                 | 0.5  | 1                    | 5                    | 6                      | 100                      | 6                        | 6                          |
|                 | 0.75 | 1.5                  | 5                    | 6                      | 100                      | 6                        | 6                          |
|                 | 1    | 2                    | 5                    | 6                      | 100                      | 6                        | 6                          |
|                 | 1.25 | 2.5                  | 5                    | 6                      | 100                      | 6                        | 6                          |
|                 | 1.5  | 3                    | 5                    | 6                      | 100                      | 6                        | 6                          |
|                 | 2    | 4                    | 5                    | 6                      | 100                      | 6                        | 6                          |
| 12              | 0.25 | 0.5                  | 5.9                  | 6                      | 100                      | 6                        | 6                          |
|                 | 0.3  | 0.6                  | 5.9                  | 6                      | 100                      | 6                        | 6                          |
|                 | 0.5  | 1                    | 5.9                  | 6                      | 100                      | 6                        | 6                          |
|                 | 0.75 | 1.5                  | 5.9                  | 6                      | 100                      | 6                        | 6                          |
|                 | 1    | 2                    | 5.9                  | 6                      | 100                      | 6                        | 6                          |
|                 | 1.25 | 2.5                  | 5.9                  | 6                      | 100                      | 6                        | 6                          |
|                 | 1.5  | 3                    | 5.9                  | 6                      | 100                      | 6                        | 6                          |
|                 | 2    | 4                    | 5.9                  | 6                      | 100                      | 6                        | 6                          |
| 2.5             | 5    | 5.9                  | 6                    | 100                    | 6                        | 6                        |                            |

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## CSMV

切削条件表  
P255

超硬スーパーミニコンケーブ Carbide Solid Super Mini Concave Cutter



|                |                                             |                                               |          |                                              |
|----------------|---------------------------------------------|-----------------------------------------------|----------|----------------------------------------------|
| 公差 (Tolerance) | D: $\begin{matrix} 0 \\ -0.05 \end{matrix}$ | ℓ1: $\begin{matrix} 0 \\ -0.035 \end{matrix}$ | R: ±0.01 | d: $\begin{matrix} 0 \\ -0.009 \end{matrix}$ |
|----------------|---------------------------------------------|-----------------------------------------------|----------|----------------------------------------------|

右刃ストレート 超微粒子

Straight Flute Ultra Micro Grain Carbide

| 刃径 (ΦD) | R    | 刃厚 (ℓ1)   | 首径 (d1)   | 首長 (ℓ2)     | 全長 (L)         | シャンク径 (Φd) | 刃数 (N)           |
|---------|------|-----------|-----------|-------------|----------------|------------|------------------|
| Dia.    |      | Cut Width | Neck Dia. | Neck Length | Overall Length | Shank Dia. | Number of Flutes |
| 4       | 0.25 | 2.5       | 2         | 3.5         | 50             | 6          | 4                |
|         | 0.3  | 2.6       | 2         | 3.5         | 50             | 6          | 4                |
|         | 0.5  | 3         | 2         | 3.5         | 50             | 6          | 4                |
| 5       | 0.25 | 2.5       | 2.2       | 3.5         | 50             | 6          | 4                |
|         | 0.3  | 2.6       | 2.2       | 3.5         | 50             | 6          | 4                |
|         | 0.5  | 3         | 2.2       | 3.5         | 50             | 6          | 4                |
| 6       | 0.25 | 2.5       | 2.7       | 4           | 50             | 6          | 4                |
|         | 0.3  | 2.6       | 2.7       | 4           | 50             | 6          | 4                |
|         | 0.5  | 3         | 2.7       | 4           | 50             | 6          | 4                |
| 8       | 0.25 | 2.5       | 3.6       | 4           | 60             | 8          | 6                |
|         | 0.3  | 2.6       | 3.6       | 4           | 60             | 8          | 6                |
|         | 0.5  | 3         | 3.6       | 4           | 60             | 8          | 6                |
|         | 0.75 | 3.5       | 3.6       | 4           | 60             | 8          | 6                |
| 1       | 4    | 3.6       | 4         | 60          | 8              | 6          |                  |

| 刃径 (ΦD) | R    | 刃厚 (ℓ1)   | 首径 (d1)   | 首長 (ℓ2)     | 全長 (L)         | シャンク径 (Φd) | 刃数 (N)           |
|---------|------|-----------|-----------|-------------|----------------|------------|------------------|
| Dia.    |      | Cut Width | Neck Dia. | Neck Length | Overall Length | Shank Dia. | Number of Flutes |
| 10      | 0.25 | 2.5       | 4.5       | 6           | 70             | 10         | 6                |
|         | 0.3  | 2.6       | 4.5       | 6           | 70             | 10         | 6                |
|         | 0.5  | 3         | 4.5       | 6           | 70             | 10         | 6                |
|         | 0.75 | 3.5       | 4.5       | 6           | 70             | 10         | 6                |
|         | 1    | 4         | 4.5       | 6           | 70             | 10         | 6                |
|         | 1.5  | 5         | 4.5       | 6           | 70             | 10         | 6                |
| 12      | 0.25 | 2.5       | 5.5       | 6           | 70             | 12         | 6                |
|         | 0.3  | 2.6       | 5.5       | 6           | 70             | 12         | 6                |
|         | 0.5  | 3         | 5.5       | 6           | 70             | 12         | 6                |
|         | 0.75 | 3.5       | 5.5       | 6           | 70             | 12         | 6                |
|         | 1    | 4         | 5.5       | 6           | 70             | 12         | 6                |
|         | 1.5  | 5         | 5.5       | 6           | 70             | 12         | 6                |
| 2       | 6    | 5.5       | 6         | 70          | 12             | 6          |                  |