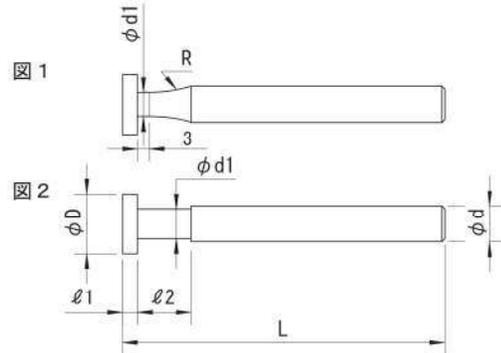


ハイス

TKCLS

切削条件表
P269

ロングシャンク干鳥刃キーシードカッター Long Shank Staggered Tooth Keyseat Cutter



公差 (Tolerance)	D				ℓ1		d
	10~16	+0.3 +0.18	18~25	+0.35 +0.21	1~3	-0.014 -0.028	
	30~40	+0.43 +0.26	50	+0.5 +0.3	4~5	-0.020 -0.038	

右刃交互ネジレ15° SKH56
Right hand cut with staggered helix15° HSS-Co.

刃径 (ΦD)	刃厚 (ℓ1)	首径 (d1)	首長 (ℓ2)	R	全長 (L)	シャンク径 (Φd)	刃数 (N)	形状
Dia.	Cut Width	Neck Dia.	Neck Length	R	Overall Length	Shank Dia.	Number of Flutes	Shape
10	1	4.2	8.8	10	80	8	6	図1
	1.5	4.2	8.8	10	80	8	6	
	2	4.2	8.8	10	80	8	6	
	2.5	4.2	8.8	10	80	8	6	
	3	4.2	8.8	10	80	8	6	
12	1	4.4	10	10	80	10	6	
	1.5	4.4	10	10	80	10	6	
	2	4.4	10	10	80	10	6	
	2.5	4.4	10	10	80	10	6	
	3	4.4	10	10	80	10	6	
13	1	4.4	10	10	80	10	6	
	1.5	4.4	10	10	80	10	6	
	2	4.4	10	10	80	10	6	
	2.5	4.4	10	10	80	10	6	
	3	4.4	10	10	80	10	6	
15	1	4.7	10.8	13	80	10	6	
	1.5	4.7	10.8	13	80	10	6	
	2	4.7	10.8	13	80	10	6	
	2.5	4.7	10.8	13	80	10	6	
	3	4.7	10.8	13	80	10	6	
16	1	5	11.8	13	100	12	6	
	1.5	5	11.8	13	100	12	6	
	2	5	11.8	13	100	12	6	
	2.5	5	11.8	13	100	12	6	
	3	5	11.8	13	100	12	6	
18	1	7	12.6	20	100	12	8	
	1.5	7	12.6	20	100	12	8	
	2	7	12.6	20	100	12	8	
	2.5	7	12.6	20	100	12	8	
	3	7	12.6	20	100	12	8	
20	1	8	11.7	20	120	12	8	
	1.5	8	11.7	20	120	12	8	

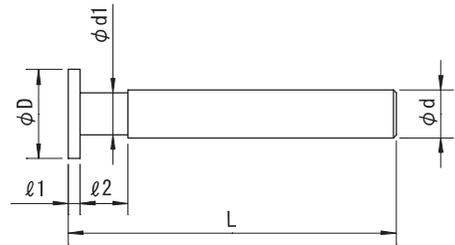
刃径 (ΦD)	刃厚 (ℓ1)	首径 (d1)	首長 (ℓ2)	R	全長 (L)	シャンク径 (Φd)	刃数 (N)	形状
Dia.	Cut Width	Neck Dia.	Neck Length	R	Overall Length	Shank Dia.	Number of Flutes	Shape
20	2	8	11.7	20	120	12	8	図1
	2.5	8	11.7	20	120	12	8	
	3	8	11.7	20	120	12	8	
	4	8	11.7	20	120	12	8	
	5	8	11.7	20	120	12	8	
25	1	10	12	25	120	12	8	
	1.5	10	12	25	120	12	8	
	2	10	12	25	120	12	8	
	2.5	10	12	25	120	12	8	
	3	10	12	25	120	12	8	
30	1	12	29	-	150	16	10	
	1.5	12	28.5	-	150	16	10	
	2	12	28	-	150	16	10	
	2.5	12	27.5	-	150	16	10	
	3	12	27	-	150	16	10	
35	1	14	29	-	150	16	10	
	1.5	14	28.5	-	150	16	10	
	2	14	28	-	150	16	10	
	2.5	14	27.5	-	150	16	10	
	3	14	27	-	150	16	10	
40	1	14	26	-	150	16	10	
	1.5	14	25	-	150	16	10	
	1.5	14	28.5	-	150	16	12	
	2	14	28	-	150	16	12	
	2.5	14	27.5	-	150	16	12	
50	1	14	26	-	150	16	12	
	1.5	14	25	-	150	16	12	
	1.5	14	28.5	-	150	16	12	
	2	14	28	-	150	16	12	
	2.5	14	27.5	-	150	16	12	

MSS-TiN

切削条件表

P271

柄付メタルソー Metal Saw With Straight Shank(TiN Coated)



公差 (Tolerance)	D: $\begin{matrix} +0.25 \\ 0 \end{matrix}$	ℓ1: $\begin{matrix} 0 \\ -0.03 \end{matrix}$	d: h7
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右刃ストレート TiNコーティング 粉末ハイス
Straight Flute TiN Coating Powder Metallurgy

刃径 (ΦD)	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
16	0.8	7.5	14.2	75	8	16
	0.9	7.5	14.1	75	8	16
	1	7.5	14	75	8	16
	1.1	7.5	13.9	75	8	16
	1.2	7.5	13.8	75	8	16
	1.3	7.5	13.7	75	8	16
	1.4	7.5	13.6	75	8	16
	1.5	7.5	13.5	75	8	16
	1.6	7.5	13.4	75	8	16
	1.7	7.5	13.3	75	8	16
	1.8	7.5	13.2	75	8	16
	1.9	7.5	13.1	75	8	16
	2	7.5	13	75	8	16
	2.1	7.5	12.9	75	8	16
	2.2	7.5	12.8	75	8	16
	2.3	7.5	12.7	75	8	16
	2.4	7.5	12.6	75	8	16
	2.5	7.5	12.5	75	8	16
	2.6	7.5	12.4	75	8	16
2.7	7.5	12.3	75	8	16	
2.8	7.5	12.2	75	8	16	
2.9	7.5	12.1	75	8	16	
3	7.5	12	75	8	16	
18	0.8	7.5	14.2	75	8	18
	0.9	7.5	14.1	75	8	18
	1	7.5	14	75	8	18
	1.1	7.5	13.9	75	8	18
	1.2	7.5	13.8	75	8	18
	1.3	7.5	13.7	75	8	18
	1.4	7.5	13.6	75	8	18
	1.5	7.5	13.5	75	8	18
	1.6	7.5	13.4	75	8	18
	1.7	7.5	13.3	75	8	18
	1.8	7.5	13.2	75	8	18
	1.9	7.5	13.1	75	8	18
	2	7.5	13	75	8	18
	2.1	7.5	12.9	75	8	18
	2.2	7.5	12.8	75	8	18
	2.3	7.5	12.7	75	8	18
	2.4	7.5	12.6	75	8	18
	2.5	7.5	12.5	75	8	18
	2.6	7.5	12.4	75	8	18
2.7	7.5	12.3	75	8	18	
2.8	7.5	12.2	75	8	18	
2.9	7.5	12.1	75	8	18	
3	7.5	12	75	8	18	

刃径 (ΦD)	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
20	0.8	9.5	14.2	80	10	18
	0.9	9.5	14.1	80	10	18
	1	9.5	14	80	10	18
	1.1	9.5	13.9	80	10	18
	1.2	9.5	13.8	80	10	18
	1.3	9.5	13.7	80	10	18
	1.4	9.5	13.6	80	10	18
	1.5	9.5	13.5	80	10	18
	1.6	9.5	13.4	80	10	18
	1.7	9.5	13.3	80	10	18
	1.8	9.5	13.2	80	10	18
	1.9	9.5	13.1	80	10	18
	2	9.5	13	80	10	18
	2.1	9.5	12.9	80	10	18
	2.2	9.5	12.8	80	10	18
	2.3	9.5	12.7	80	10	18
	2.4	9.5	12.6	80	10	18
	2.5	9.5	12.5	80	10	18
	2.6	9.5	12.4	80	10	18
2.7	9.5	12.3	80	10	18	
2.8	9.5	12.2	80	10	18	
2.9	9.5	12.1	80	10	18	
3	9.5	12	80	10	18	
25	0.8	11.5	14.2	80	12	22
	0.9	11.5	14.1	80	12	22
	1	11.5	14	80	12	22
	1.1	11.5	13.9	80	12	22
	1.2	11.5	13.8	80	12	22
	1.3	11.5	13.7	80	12	22
	1.4	11.5	13.6	80	12	22
	1.5	11.5	13.5	80	12	22
	1.6	11.5	13.4	80	12	22
	1.7	11.5	13.3	80	12	22
	1.8	11.5	13.2	80	12	22
	1.9	11.5	13.1	80	12	22
	2	11.5	13	80	12	22
	2.1	11.5	12.9	80	12	22
	2.2	11.5	12.8	80	12	22
	2.3	11.5	12.7	80	12	22
	2.4	11.5	12.6	80	12	22
	2.5	11.5	12.5	80	12	22
	2.6	11.5	12.4	80	12	22
2.7	11.5	12.3	80	12	22	
2.8	11.5	12.2	80	12	22	
2.9	11.5	12.1	80	12	22	
3	11.5	12	80	12	22	

MSS-TiN 柄付メタルソー

刃径 (ΦD)	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
30	0.8	11.5	14.2	85	12	22
	0.9	11.5	14.1	85	12	22
	1	11.5	14	85	12	22
	1.1	11.5	13.9	85	12	22
	1.2	11.5	13.8	85	12	22
	1.3	11.5	13.7	85	12	22
	1.4	11.5	13.6	85	12	22
	1.5	11.5	13.5	85	12	22
	1.6	11.5	13.4	85	12	22
	1.7	11.5	13.3	85	12	22
	1.8	11.5	13.2	85	12	22
	1.9	11.5	13.1	85	12	22
	2	11.5	13	85	12	22
	2.1	11.5	12.9	85	12	22
	2.2	11.5	12.8	85	12	22
	2.3	11.5	12.7	85	12	22
	2.4	11.5	12.6	85	12	22
	2.5	11.5	12.5	85	12	22
	2.6	11.5	12.4	85	12	22
	2.7	11.5	12.3	85	12	22
2.8	11.5	12.2	85	12	22	
2.9	11.5	12.1	85	12	22	
3	11.5	12	85	12	22	
35	1	15.5	14	85	16	24
	1.1	15.5	13.9	85	16	24
	1.2	15.5	13.8	85	16	24
	1.3	15.5	13.7	85	16	24
	1.4	15.5	13.6	85	16	24
	1.5	15.5	13.5	85	16	24
	1.6	15.5	13.4	85	16	24
	1.7	15.5	13.3	85	16	24
	1.8	15.5	13.2	85	16	24
	1.9	15.5	13.1	85	16	24
	2	15.5	13	85	16	24
	2.1	15.5	12.9	85	16	24
	2.2	15.5	12.8	85	16	24
	2.3	15.5	12.7	85	16	24
	2.4	15.5	12.6	85	16	24
	2.5	15.5	12.5	85	16	24
	2.6	15.5	12.4	85	16	24
	2.7	15.5	12.3	85	16	24
	2.8	15.5	12.2	85	16	24
	2.9	15.5	12.1	85	16	24
3	15.5	12	85	16	24	
40	1	15.5	14	90	16	28
	1.1	15.5	13.9	90	16	28
	1.2	15.5	13.8	90	16	28
	1.3	15.5	13.7	90	16	28
	1.4	15.5	13.6	90	16	28
	1.5	15.5	13.5	90	16	28
	1.6	15.5	13.4	90	16	28
	1.7	15.5	13.3	90	16	28
	1.8	15.5	13.2	90	16	28
	1.9	15.5	13.1	90	16	28
	2	15.5	13	90	16	28
	2.1	15.5	12.9	90	16	28
	2.2	15.5	12.8	90	16	28
	2.3	15.5	12.7	90	16	28
	2.4	15.5	12.6	90	16	28
	2.5	15.5	12.5	90	16	28
	2.6	15.5	12.4	90	16	28
	2.7	15.5	12.3	90	16	28
	2.8	15.5	12.2	90	16	28
	2.9	15.5	12.1	90	16	28
3	15.5	12	90	16	28	

刃径 (ΦD)	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
45	1	19.5	14	95	20	28
	1.1	19.5	13.9	95	20	28
	1.2	19.5	13.8	95	20	28
	1.3	19.5	13.7	95	20	28
	1.4	19.5	13.6	95	20	28
	1.5	19.5	13.5	95	20	28
	1.6	19.5	13.4	95	20	28
	1.7	19.5	13.3	95	20	28
	1.8	19.5	13.2	95	20	28
	1.9	19.5	13.1	95	20	28
	2	19.5	13	95	20	28
	2.1	19.5	12.9	95	20	28
	2.2	19.5	12.8	95	20	28
	2.3	19.5	12.7	95	20	28
	2.4	19.5	12.6	95	20	28
	2.5	19.5	12.5	95	20	28
	2.6	19.5	12.4	95	20	28
	2.7	19.5	12.3	95	20	28
	2.8	19.5	12.2	95	20	28
	2.9	19.5	12.1	95	20	28
3	19.5	12	95	20	28	
50	1	19.5	14	100	20	30
	1.1	19.5	13.9	100	20	30
	1.2	19.5	13.8	100	20	30
	1.3	19.5	13.7	100	20	30
	1.4	19.5	13.6	100	20	30
	1.5	19.5	13.5	100	20	30
	1.6	19.5	13.4	100	20	30
	1.7	19.5	13.3	100	20	30
	1.8	19.5	13.2	100	20	30
	1.9	19.5	13.1	100	20	30
	2	19.5	13	100	20	30
	2.1	19.5	12.9	100	20	30
	2.2	19.5	12.8	100	20	30
	2.3	19.5	12.7	100	20	30
	2.4	19.5	12.6	100	20	30
	2.5	19.5	12.5	100	20	30
	2.6	19.5	12.4	100	20	30
	2.7	19.5	12.3	100	20	30
	2.8	19.5	12.2	100	20	30
	2.9	19.5	12.1	100	20	30
3	19.5	12	100	20	30	