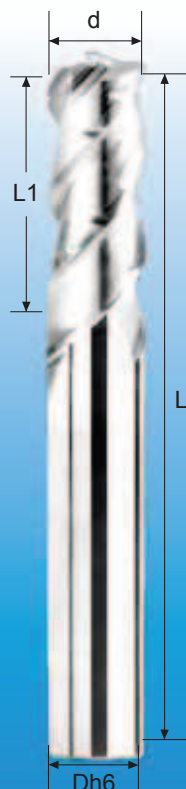


MICRO GRAIN CARBIDE END MILLS - High Helix - Semi - Finishing - 3F / 4F

鎢鋼平銑刀-高導粗精型

ENS-SR3

ENS-SR4



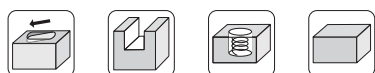
Order No. 訂購編號	Dia. 刃徑 (d)	CL 刃長 (L1)	OAL 全長 (L)	Shank 柄徑 (D)	Flutes 刃數 (F)
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High Helix - Semi - Finishing - 3F

ENSSR306000	6	15	50	6	3
ENSSR308000	8	20	60	8	3
ENSSR310000	10	25	75	10	3
ENSSR312000	12	30	75	12	3
ENSSR316000	16	40	100	16	3
ENSSR320000	20	45	100	20	3

High Helix - Semi - Finishing - 4F

ENSSR406000	6	15	50	6	4
ENSSR408000	8	20	60	8	4
ENSSR410000	10	25	75	10	4
ENSSR412000	12	30	75	12	4
ENSSR416000	16	40	100	16	4
ENSSR420000	20	45	100	20	4



$\phi < 3$ 採尖角型式
 $\phi \geq 3$ 以上採平面型式
 $\phi < 3$ has sharp corner type. $\phi \geq 3$ has flatland type.

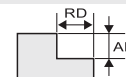
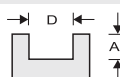
d (刃徑)	Tolerance (公差)
$\phi < 3$	0 ~ -0.02
$3 \leq \phi \leq 10$	0 ~ -0.03
$\phi > 10$	0 ~ -0.04

Finishing (精銑)	
Semi-Finishing (中銑)	
Roughing (粗銑)	

WORKING MATERIAL	ALLUMINUM Alloy			
MATERIAL CODE	A5052			
	Slotting (2F, 3F)		Side Milling (3F)	
Vc	150 M / min		250 M / min	
DIAMETER	R.P.M	FEED (mm / min)	R.P.M	FEED (mm / min)
3MM	16,000	1,200	26,600	1,350
4MM	12,000	1,000	20,000	1,360
5MM	9,600	900	15,900	1,350
6MM	8,000	820	13,300	1,350
8MM	6,000	750	10,000	1,360
10MM	4,800	680	7,900	1,350
12MM	4,000	620	6,600	1,350

Milling Amount
(mm)

Ad=0.1D



The Feed & RPM may be changed depending on the M/C Conditions, Lubricating & Cooling systems.