

600⁺ 切削條件表 **P309**
Cutting Condition

SPEED TIGER

Square series - Flute Angle 45° - 4 flutes

■ 4刃45° 立銑刀

600
PLUS

HRC
55

45°

AlTiN

● Micro Grain Carbide

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



| MODE | Diameter | Flute Length | Full Length | Shank Diameter | Flutes |
|-----------------|----------|--------------|-------------|----------------|--------|
| 型號 | d 刀徑 | l 刃長 | L 全長 | D 柄徑 | Z 刃數 |
| P-MPE0104 AlTiN | 1 | 3 | 50 | 4 | 4 |
| P-MPE0154 AlTiN | 1.5 | 4 | 50 | 4 | 4 |
| P-MPE0204 AlTiN | 2 | 6 | 50 | 4 | 4 |
| P-MPE0254 AlTiN | 2.5 | 8 | 50 | 4 | 4 |
| P-MPE3304 AlTiN | 3 | 8 | 50 | 3 | 4 |
| P-MPE0304 AlTiN | 3 | 8 | 50 | 4 | 4 |
| P-MPE0354 AlTiN | 3.5 | 10 | 50 | 4 | 4 |
| P-MPE0404 AlTiN | 4 | 11 | 50 | 4 | 4 |
| P-PE0104 AlTiN | 1 | 3 | 50 | 6 | 4 |
| P-PE0154 AlTiN | 1.5 | 4 | 50 | 6 | 4 |
| P-PE0204 AlTiN | 2 | 6 | 50 | 6 | 4 |
| P-PE0254 AlTiN | 2.5 | 8 | 50 | 6 | 4 |
| P-PE0304 AlTiN | 3 | 8 | 50 | 6 | 4 |
| P-PE0354 AlTiN | 3.5 | 10 | 50 | 6 | 4 |
| P-PE0404 AlTiN | 4 | 11 | 50 | 6 | 4 |
| P-PE0454 AlTiN | 4.5 | 13 | 50 | 6 | 4 |
| P-PE0504 AlTiN | 5 | 13 | 50 | 6 | 4 |
| P-PE0554 AlTiN | 5.5 | 13 | 50 | 6 | 4 |
| P-PE0604 AlTiN | 6 | 16 | 50 | 6 | 4 |
| P-PE0654 AlTiN | 6.5 | 16 | 60 | 8 | 4 |
| P-PE0704 AlTiN | 7 | 16 | 60 | 8 | 4 |
| P-PE0754 AlTiN | 7.5 | 19 | 60 | 8 | 4 |
| P-PE0804 AlTiN | 8 | 20 | 60 | 8 | 4 |
| P-PE0854 AlTiN | 8.5 | 20 | 75 | 10 | 4 |
| P-PE0904 AlTiN | 9 | 20 | 75 | 10 | 4 |
| P-PE0954 AlTiN | 9.5 | 25 | 75 | 10 | 4 |
| P-PE1004 AlTiN | 10 | 30 | 75 | 10 | 4 |
| P-PE1054 AlTiN | 10.5 | 30 | 75 | 12 | 4 |
| P-PE1104 AlTiN | 11 | 30 | 75 | 12 | 4 |
| P-PE1154 AlTiN | 11.5 | 30 | 75 | 12 | 4 |
| P-PE1204 AlTiN | 12 | 32 | 75 | 12 | 4 |
| P-PE1404 AlTiN | 14 | 40 | 100 | 16 | 4 |
| P-PE1604 AlTiN | 16 | 40 | 100 | 16 | 4 |
| P-PE1804 AlTiN | 18 | 45 | 100 | 20 | 4 |
| P-PE2004 AlTiN | 20 | 45 | 100 | 20 | 4 |

HRC
▶ 40

HRC
▶ 45

HRC
▶ 50

HRC
▶ 55

HRC
▶ 60

HRC
▶ 65



Application 適用材質：

◎ Recommend 最適合 ○ Suitable 適合 X Not Recommend 不建議

| carbon steel, Alloy steel 炭素鋼, 合金鋼 | Pre-hardened steel 預硬鋼 | High-hardened 高硬度鋼 | | | | Stainless steel 不銹鋼 | Copper alloy 銅合金, 銅 | Aluminun alloy 鋁合金 |
|--|---------------------------|-----------------------|--------|--------|--------|------------------------|------------------------|-----------------------|
| | ~45HRC | ~50HRC | ~55HRC | ~60HRC | ~65HRC | | | |
| ○ | ◎ | ◎ | ○ | | | ○ | | |