

超硬4枚刃スクエアエンドミル Carbide 4-Flute Square End Mill



ADSE4-4D

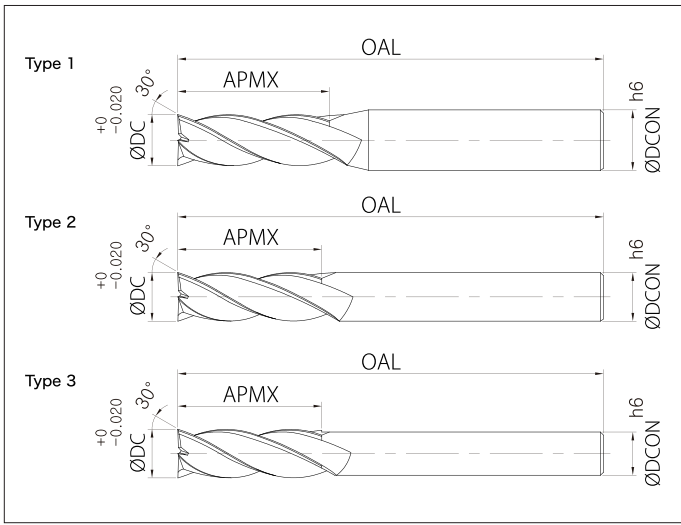
超硬4枚刃スクエアエンドミル 4Dタイプ
Carbide 4-Flute Square End Mill 4D Type



汎用の超硬4枚刃エンドミル 4Dタイプです。
General-purpose 4-flute carbide end mill 4D type

単位(Unit):mm

| TYコード Code | 外径 DC | 刃長 APMX | 全長 OAL | シャンク径 DCON | 形状 Type |
|---------------|----------|------------|-----------|---------------|------------|
| YK07904 | 3 | 12 | 60 | 6 | 1 |
| YK07905 | 4 | 16 | 60 | 6 | 1 |
| YK07906 | 5 | 20 | 60 | 6 | 1 |
| YK07907 | 6 | 24 | 65 | 6 | 2 |
| YK07908 | 7 | 28 | 70 | 8 | 1 |
| YK07909 | 8 | 32 | 75 | 8 | 2 |
| YK07910 | 9 | 36 | 80 | 10 | 1 |
| YK07911 | 10 | 40 | 80 | 10 | 2 |
| YK07912 | 11 | 44 | 95 | 12 | 1 |
| YK07913 | 12 | 48 | 95 | 12 | 2 |
| YK07914 | 14 | 56 | 100 | 12 | 3 |
| YK07915 | 15 | 60 | 110 | 16 | 1 |
| YK07916 | 16 | 64 | 120 | 16 | 2 |
| YK07917 | 18 | 72 | 120 | 16 | 3 |
| YK07918 | 20 | 80 | 150 | 20 | 2 |



超硬2枚刃ボールエンドミル Carbide 2-Flute Ball End Mill



ADSB2

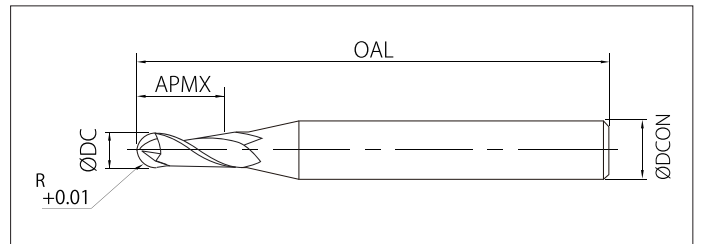
超硬2枚刃ボールエンドミル
Carbide 2-Flute Ball End Mill



汎用の超硬2枚刃ボールエンドミルです。
General-purpose carbide 2-flute ball end mill

単位(Unit):mm

| TYコード Code | ボール半径(R) Radius | 外径 DC | 刃長 APMX | 全長 OAL | シャンク径 DCON |
|---------------|--------------------|----------|------------|-----------|---------------|
| YK07213 | R0.5 | 1 | 2 | 50 | 4 |
| YK07214 | R0.75 | 1.5 | 3 | 50 | 4 |
| YK07215 | R1 | 2 | 4 | 50 | 4 |
| YK07216 | R1.5 | 3 | 6 | 50 | 4 |
| YK07217 | R2 | 4 | 8 | 50 | 4 |
| YK07218 | R2.5 | 5 | 10 | 50 | 6 |
| YK07219 | R3 | 6 | 12 | 90 | 6 |
| YK07220 | R4 | 8 | 14 | 100 | 8 |
| YK07221 | R5 | 10 | 18 | 100 | 10 |
| YK07222 | R6 | 12 | 25 | 110 | 12 |
| YK07223 | R8 | 16 | 30 | 140 | 16 |
| YK07224 | R10 | 20 | 38 | 160 | 20 |



ADSE4-4D 基準切削条件表 Recommended Milling Conditions 側面切削 Side milling

| 被削材 Work Material | 炭素鋼 Carbon Steels | | 合金鋼 Alloy Steels | | 鋳鉄 Cast Iron | | 合金鋼 Alloy Steels | | 耐熱鋼 Heat Resistant Steels | | ステンレス鋼 Stainless Steels | |
|----------------------|--------------------------|----------------------|--------------------------|----------------------|--------------------------|----------------------|--------------------------|----------------------|------------------------------|----------------------|----------------------------|----------------------|
| | 回転数 Rotation min-1 | 送り Feed mm/min | 回転数 Rotation min-1 | 送り Feed mm/min | 回転数 Rotation min-1 | 送り Feed mm/min | 回転数 Rotation min-1 | 送り Feed mm/min | 回転数 Rotation min-1 | 送り Feed mm/min | 回転数 Rotation min-1 | 送り Feed mm/min |
| 3 | 3240 | 120 | 1875 | 50 | 2420 | 45 | | | | | | |
| 4 | 2625 | 145 | 1490 | 60 | 2040 | 75 | | | | | | |
| 5 | 2240 | 190 | 1270 | 75 | 1660 | 80 | | | | | | |
| 6 | 1930 | 225 | 1100 | 95 | 1495 | 85 | | | | | | |
| 7 | 1670 | 230 | 945 | 95 | 1270 | 90 | | | | | | |
| 8 | 1470 | 240 | 830 | 95 | 1105 | 95 | | | | | | |
| 9 | 1340 | 240 | 770 | 95 | 985 | 85 | | | | | | |
| 10 | 1235 | 240 | 720 | 95 | 885 | 80 | | | | | | |
| 11 | 1110 | 210 | 660 | 85 | 790 | 75 | | | | | | |
| 12 | 1010 | 190 | 605 | 80 | 715 | 65 | | | | | | |
| 14 | 920 | 180 | 525 | 75 | 625 | 60 | | | | | | |
| 15 | 880 | 170 | 495 | 70 | 595 | 55 | | | | | | |
| 16 | 850 | 170 | 470 | 65 | 580 | 50 | | | | | | |
| 18 | 725 | 140 | 405 | 55 | 495 | 50 | | | | | | |
| 20 | 620 | 120 | 355 | 50 | 440 | 40 | | | | | | |

切込み量 : Depth of Cut

2.5D
0.05D

1.0D
0.05D

ADSB2 基準切削条件表 Recommended Milling Conditions

| 被削材 Work Material | 非合金鋼 Non Alloy Steels | | 合金鋼 Alloy Steels | | 鋳鉄 Cast Iron | | 合金鋼 Alloy Steels | | 耐熱鋼 Heat Resistant Steels | | 調質鋼 Hardened Steels | |
|----------------------|--------------------------|----------------------|--------------------------|----------------------|--------------------------|----------------------|--------------------------|----------------------|------------------------------|----------------------|--------------------------|----------------------|
| | 回転数 Rotation min-1 | 送り Feed mm/min | 回転数 Rotation min-1 | 送り Feed mm/min | 回転数 Rotation min-1 | 送り Feed mm/min | 回転数 Rotation min-1 | 送り Feed mm/min | 回転数 Rotation min-1 | 送り Feed mm/min | 回転数 Rotation min-1 | 送り Feed mm/min |
| ボール半径(R) Radius | | | | | | | | | | | | |
| R0.5 | 14180 | 225 | 11450 | 180 | 5220 | 100 | | | | | | |
| R0.75 | 14185 | 315 | 10925 | 245 | 4790 | 110 | | | | | | |
| R1 | 12960 | 675 | 9630 | 440 | 4120 | 135 | | | | | | |
| R1.5 | 11790 | 610 | 9000 | 415 | 4070 | 135 | | | | | | |
| R2 | 9450 | 665 | 7560 | 480 | 3780 | 160 | | | | | | |
| R2.5 | 8225 | 740 | 6570 | 520 | 3310 | 160 | | | | | | |
| R3 | 7640 | 920 | 6210 | 745 | 2860 | 170 | | | | | | |
| R4 | 6445 | 1160 | 5195 | 830 | 2225 | 200 | | | | | | |
| R5 | 5730 | 1380 | 4580 | 920 | 1835 | 205 | | | | | | |
| R6 | 5255 | 1575 | 4175 | 1000 | 1575 | 220 | | | | | | |
| R8 | 4295 | 1550 | 3400 | 955 | 1215 | 220 | | | | | | |
| R10 | 3725 | 1495 | 2935 | 935 | 999 | 225 | | | | | | |

切込み量 : Depth of Cut

Ae: 0.2mm(0.5R~3R)
0.3mm(4R~6R)
Ap: 0.2D

Ae: 0.2mm(0.5R~3R)
0.3mm(4R~6R)
Ap: 0.1D