



# ADVLRE-2.5D

## 超硬ラフィングエンドミル 不等リード 2.5Dタイプ

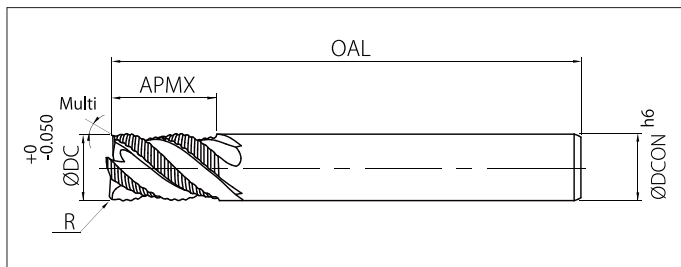
Carbide Roughing End Mill with Variable Lead 2.5D Type



不等リードで、切削抵抗を安定させる防振効果のラフィングエンドミルです。  
The variable lead shape stabilizes cutting resistance to isolate vibration

単位(Unit):mm

| TYコード<br>Code | 外径<br>DC | コーナー半径<br>R | 刃長<br>APMX | 全長<br>OAL | シャンク径<br>DCON | 刃数<br>ZEFP |
|---------------|----------|-------------|------------|-----------|---------------|------------|
| YK07421       | 6        | R0.5        | 15         | 60        | 6             | 4          |
| YK07422       | 8        | R0.5        | 20         | 70        | 8             | 4          |
| YK07423       | 10       | R0.5        | 25         | 75        | 10            | 4          |
| YK07424       | 12       | R0.5        | 30         | 80        | 12            | 4          |
| YK07425       | 16       | R1          | 40         | 100       | 16            | 5          |
| YK07426       | 20       | R1          | 50         | 110       | 20            | 5          |



### ADVLRE-2.5D 基準切削条件表 Recommended Milling Conditions 側面切削 Side Milling

| 被削材<br>Work Material | 炭素鋼 合金鋼 工具鋼 鋳鉄<br>Carbon Steels Alloy Steels Tool Steels Cast Iron |                      | 炭素鋼 合金鋼 工具鋼 鋳鉄 プレハードン鋼<br>Carbon Steels Alloy Steels Tool Steels Cast Iron Prehardened Steels |                      |
|----------------------|--|----------------------|---|----------------------|
|                      | ~25HRC   |                      | 25HRC~40HRC   |                      |
| 外径<br>Mill Dia.      | 回転数<br>Rotation<br>min-1   | 送り<br>Feed<br>mm/min | 回転数<br>Rotation<br>min-1  | 送り<br>Feed<br>mm/min |
| 6                    | 12640  | 2055                 | 11440   | 1480                 |
| 8                    | 9520   | 2160                 | 8560  | 1560                 |
| 10                   | 7600   | 2160                 | 6800  | 1560                 |
| 12                   | 6400   | 2055                 | 5680  | 1480                 |
| 16                   | 4800   | 1960                 | 4320  | 1400                 |
| 20                   | 3840   | 1710                 | 3440  | 1200                 |

| 切込み量:<br>Depth of Cut | ~25HRC | 25HRC~40HRC |
|-----------------------|--------|-------------|
|                       | 0.5D   | 0.35D       |

### 溝切削 Slotting

| 被削材<br>Work Material | 炭素鋼 合金鋼 工具鋼 鋳鉄<br>Carbon Steels Alloy Steels Tool Steels Cast Iron |                      | 炭素鋼 合金鋼 工具鋼 鋳鉄 プレハードン鋼<br>Carbon Steels Alloy Steels Tool Steels Cast Iron Prehardened Steels |                      |
|----------------------|--|----------------------|---|----------------------|
|                      | ~25HRC   |                      | 25HRC~40HRC   |                      |
| 外径<br>Mill Dia.      | 回転数<br>Rotation<br>min-1   | 送り<br>Feed<br>mm/min | 回転数<br>Rotation<br>min-1  | 送り<br>Feed<br>mm/min |
| 6                    | 9600   | 1240                 | 8480  | 880                  |
| 8                    | 7200   | 1320                 | 6480  | 945                  |
| 10                   | 5760   | 1320                 | 5120  | 945                  |
| 12                   | 4800   | 1230                 | 4320  | 910                  |
| 16                   | 3600   | 1200                 | 3280  | 840                  |
| 20                   | 2880   | 1065                 | 2560  | 720                  |

| 切込み量:<br>Depth of Cut | ~25HRC  | 25HRC~40HRC |
|-----------------------|---------|-------------|
|                       | 1.0 X D | 0.8 X D     |