

Standard



K-VM 鎢鋼超微小徑2刃立銑刀

Standard, 2 Flute Micro Diameter END MILLS

2 Flute

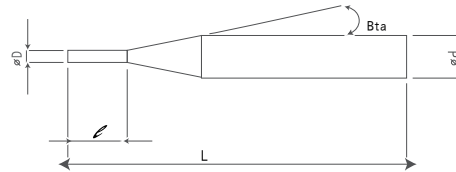
2刃

4 Flute

4刃

3&6 Flute

3&6刃



採用超微粒子合金
Super fine grain alloy is used for the carbide material.



高鋁鈦處理
TiAlN coating is used.



30° 螺旋角
Helix Angle is 30°



加工材料對照表(◎最佳○可)Applicable Work Material(◎ Most suitable ○ suitable)

被削材 Work Material									
碳素鋼 CARBON STEELS	合金鋼 ALLOY STEELS	工具鋼 PREHARDENED STEELS	高溫合金鋼 HARDENED STEELS			鑄鐵 CAST IRON STEELS	鋁合金 ALUMINIUM ALLOYS	石墨 GRAPHITE	銅合金 COPPER ALLOYS
S45C S55C	SK-SCM SUS	(30-45HRC) NAK	(~55HRC)	(~60HRC)	(60~ 65HRC)				
◎	◎	◎	◎	◎	○	○		○	

單位:Unit(mm)

型號 Model Number	外徑 Outside Diameter	刃長 Length of Cut	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)
	ØD	ℓ	Bta	L	Ød	
K-VM-2002-0040	0.2	0.4	12°	45	4	1,500
K-VM-2002-0050		0.5				
K-VM-2002-0060		0.6				1,900
K-VM-2002-0080		0.8				
K-VM-2003-0060	0.3	0.6	12°	45	4	1,400
K-VM-2003-0075		0.75				
K-VM-2003-0090		0.9				1,500
K-VM-2003-0120		1.2				
K-VM-2004-0080	0.4	0.8	12°	45	4	1,400
K-VM-2004-0100		1				
K-VM-2004-0120		1.2				1,500
K-VM-2004-0160		1.6				



單位:Unit(mm)

型號 Model Number	外徑 Outside Diameter	刃長 Length of Cut	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)
	øD	ℓ	Bta	L	ød	
K-VM-2005-0100	0.5	1	12°	45	4	800
K-VM-2005-0125		1.25				
K-VM-2005-0150		1.5				
K-VM-2005-0200		2				1,100
K-VM-2006-0120	0.6	1.2	12°	45	4	800
K-VM-2006-0150		1.5				
K-VM-2006-0180		1.8				
K-VM-2006-0240		2.4				1,100
K-VM-2007-0140	0.7	1.4	12°	45	4	800
K-VM-2007-0175		1.75				
K-VM-2007-0210		2.1				
K-VM-2007-0280		2.8				1,100
K-VM-2008-0160	0.8	1.6	12°	45	4	800
K-VM-2008-0200		2				
K-VM-2008-0240		2.4				
K-VM-2008-0320		3.2				1,100
K-VM-2009-0180	0.9	1.8	12°	45	4	800
K-VM-2009-0225		2.25				
K-VM-2009-0270		2.7				
K-VM-2009-0360		3.6				1,100
K-VM-2010-0200	1	2	12°	45	4	700
K-VM-2010-0250		2.5				
K-VM-2010-0300		3				
K-VM-2010-0400		4				900
K-VM-2012-0240	1.2	2.4	12°	45	4	800
K-VM-2012-0300		3				
K-VM-2012-0360		3.6				
K-VM-2012-0480		4.8				1,000
K-VM-2015-0300	1.5	3	12°	45	4	700
K-VM-2015-0375		3.75				
K-VM-2015-0450		4.5				
K-VM-2015-0600		6				900
K-VM-2018-0360	1.8	3.6	12°	45	4	800
K-VM-2018-0450		4.5				
K-VM-2018-0540		5.4				
K-VM-2018-0720		7.2				1,000



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute

Square

方型

Ball

球型

Corner Radius

角半徑

Taper

錐型

Other

特殊
刀具

單位:Unit(mm)

Standard



2 Flute

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Square

方型

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球型

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Taper

錐型

Other

特殊
刀具

型號 Model Number	外徑 Outside Diameter	刃長 Length of Cut	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)
	øD	ℓ	Bta	L	ød	
K-VM-2020-0400	2	4	12°	45	4	700
K-VM-2020-0500		5				
K-VM-2020-0600		6				
K-VM-2020-0800		8				900
K-VM-2025-0500	2.5	5	12°	45	4	700
K-VM-2025-0625		6.25				
K-VM-2025-0750		7.5				
K-VM-2025-1000		10		50		900
K-VM-2030-0600	3	6	12°	45	4	700
K-VM-2030-0750		7.5				
K-VM-2030-0900		9				
K-VM-2030-1200		12		50		900
K-VM-2040-0800	4	8	12°	50	4	700
K-VM-2040-1000		10				
K-VM-2040-1200		12				
K-VM-2040-1600		16		60		900
K-VM-2050-1000	5	10	12°	50	6	800
K-VM-2050-1250		12.5				
K-VM-2050-1500		15				
K-VM-2050-2000		20		75		1,200
K-VM-2060-1200	6	12	—	50	6	800
K-VM-2060-1500		15				
K-VM-2060-1800		18				
K-VM-2060-2400		24		75		1,200
K-VM-2080-1600	8	16	—	60	8	1,500
K-VM-2080-2000		20				
K-VM-2080-2400		24				
K-VM-2080-3200		32		75		2,000
K-VM-2100-2000	10	20	—	75	10	1,900
K-VM-2100-2500		25				
K-VM-2100-3000		30		80		
K-VM-2100-4000		40		100		2,700
K-VM-2120-2400	12	24	—	75	12	2,600
K-VM-2120-3000		30				
K-VM-2120-3600		36		90		
K-VM-2120-4800		48		100		3,700

K-VM(2刃)切削條件說明表 List of milling for K-VM(2Flutes)

加工材料 WORK MATERIAL		碳素鋼 CARBON STEELS			合金鋼 ALLOY STEELS			工具鋼 PREHARDENED STEELS HARDENED STEELS			高溫合金鋼 HARDENED STEELS		
		S45C.S55C (~225HB)			SK.SCM.SUS (225~325HB)			NAK.SKD (30~45HRC)			SKD11.60.SKT (45~55HRC)		
型號 Model Number	外徑 Outside Diameter (mm)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)
2002	0.2	30,000		85	30,000		85	30,000		30	30,000		25
2003	0.3	30,000	(20~40)	110	30,000	(20~40)	110	30,000	(20~40)	55	22,000	(20)	25
2004	0.4	30,000		120	30,000		120	27,000		60	17,000		25
2005	0.5	30,000		120	30,000		120	21,500		60	13,000		25
2006	0.6	30,000		120	30,000		120	18,000		60	11,000		25
2007	0.7	27,500		120	27,500		120	15,500		60	10,000		25
2008	0.8	24,000	(45~65)	120	24,000	(45~50)	120	13,800	(35~40)	60	8,800	(20~25)	30
2009	0.9	21,500		125	21,500		120	12,000		65	7,800		30
2010	1	20,000		125	20,000		120	11,000		65	7,100		30
2012	1.2	16,700		130	16,700		120	9,400		65	6,000		30
2015	1.5	13,500		130	13,500		120	8,000		70	5,100		35
2018	1.8	11,500		130	11,500		120	7,000		70	4,400		35
2020	2	11,000		130	11,000		120	6,400		70	4,000		40
2025	2.5	8,800		195	8,800		135	5,000		70	3,200		40
2030	3	7,400		195	7,400		145	4,500		80	2,800		45
2040	4	5,900		230	5,900		190	3,500		90	2,150		50
2050	5	5,300	(70~84)	310	5,300	(55~65)	230	2,950	(40~45)	90	1,850	(25~30)	55
2060	6	4,400		305	4,400		230	2,450		100	1,500		50
2080	8	3,300		290	3,300		230	1,850		95	1,200		50
2100	10	2,600		275	2,600		225	1,450		95	950		50
2120	12	2,200		275	2,200		225	1,200		90	800		45

高速加工條件 For high-speed milling

加工材料 WORK MATERIAL		碳素鋼 CARBON STEELS			合金鋼 ALLOY STEELS			工具鋼 PREHARDENED STEELS HARDENED STEELS			高溫合金鋼 HARDENED STEELS		
		S45C.S55C (~225HB)			SK.SCM.SUS (225~325HB)			NAK.SKD (30~45HRC)			SKD11.60.SKT (45~55HRC)		
型號 Model Number	外徑 Outside Diameter (mm)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)
2030	3	30,000		790	26,500		600	21,200		375	15,800		255
2040	4	23,800		930	19,800		750	15,800		405	11,900		275
2050	5	19,000		1,110	15,800		865	12,700		385	9,500		280
2060	6	15,900	(300)	1,100	13,200	(250)	865	10,600	(200)	435	7,900	(150)	290
2080	8	11,900		1,045	9,900		875	7,900		405	5,900		245
2100	10	9,500		1,005	7,900		845	6,300		415	4,700		245
2120	12	7,900		1,000	6,600		850	5,300		400	3,900		219



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



方型



球型



角半徑



錐型



特殊
刀具

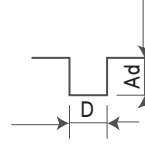
Standard



K-VM(2刃)切削條件說明表 List of milling for K-VM(2flutes)

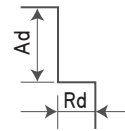
切削量 (mm)
側面切削 Milling Amount Side Milling

加工材料 \ 外徑	$D < \varnothing 1$	$\varnothing 1 \leq D < \varnothing 3$	$\varnothing 3 \leq D$
45HR以下 less than 45HRC	$Ad = 0.1D$	$Ad = 0.25D$	$Ad = 0.5D$
	$D < \varnothing 1$	$\varnothing 1 \leq D$	
45HR以上 more than 45HRS	$Ad = 0.02D$	$Ad = 0.05D$	



切削量 (mm)
側面切削 Milling Amount Side Milling

加工材料 \ 外徑	2D(刃長=外徑 X 2) Length of Cut=Diameter X 2	2.5D(刃長=外徑 X 2.5) Length of Cut=Diameter X 2.5	3D(刃長=外徑 X 3) Length of Cut=Diameter X 3	4D(刃長=外徑 X 2.4) Length of Cut=Diameter X 2.4
45HR以下 less than 45HRC	$Rd = 0.1D$ $Ad = 1.5D$	$Rd = 0.07D$ $Ad = 2D$	$Rd = 0.05D$ $Ad = 2.5D$	$Rd = 0.02D$ $Ad = 3.5D$
45HR以上 more than 45HRC	$Rd = 0.05D$ $Ad = 1D$	$Rd = 0.03D$ $Ad = 1.5D$	$Rd = 0.02D$ $Ad = 2D$	$Rd = 0.01D$ $Ad = 3D$



Ad = 軸方向切削量 (mm) Milling Amount
 Rd = 徑方向切削量 (mm) Radial Depth

Square

方型

Ball

球型

Corner Radius

角半徑

Taper

錐型

Other

特殊
刀具



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



方型



球型



角半徑



錐型



特殊
刀具

Standard



K-VM 鎢鋼 4 刃 立 銑 刀

Standard, 4 Flute END MILLS

2 Flute

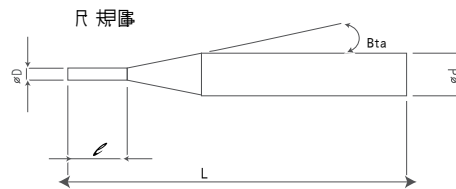
2刃

4 Flute

4刃

3&6 Flute

3&6刃



採用超微粒子合金
Super fine grain alloy is used
for the carbide material.



高鋁鈦處理
TiAlN coating is used.



30° 螺旋角
Helix Angle is 30°



加工材料對照表 (◎ 最佳 ○ 可) Applicable Work Material (◎ Most suitable ○ suitable)

被削材 Work Material									
碳素鋼 CARBON STEELS	合金鋼 ALLOY STEELS	工具鋼 PREHARDENED STEELS	高溫合金鋼 HARDENED STEELS			鑄鐵 CAST IRON STEELS	鋁合金 ALUMINIUM ALLOYS	石墨 GRAPHITE	銅合金 COPPER ALLOYS
S45C S55C	SK-SCM SUS	(30-45HRC) NAK	(~55HRC)	(~60HRC)	(60~ 65HRC)				
◎	◎	◎	◎	◎	○	○			○

單位:Unit(mm)

型號 Model Number	外徑 Outside Diameter	刃長 Length of Cut	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)
	$\varnothing D$	l	Bta	L	$\varnothing d$	
K-VM-4010-0250	1	2.5	12°	45	4	700
K-VM-4010-0400		4				900
K-VM-4015-0375	1.5	3.75	12°	45	4	700
K-VM-4015-0600		6				900
K-VM-4020-0500	2	5	12°	45	4	700
K-VM-4020-0800		8				900
K-VM-4025-0625	2.5	6.25	12°	45	4	700
K-VM-4025-1000		10		50		900
K-VM-4030-0750	3	7.5	12°	45	4	700
K-VM-4030-1200		12		50		900

單位:Unit(mm)

型號 Model Number	外徑 Outside Diameter	刃長 Length of Cut	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)
	øD	ℓ	Bta	L	ød	
K-VM-4040-1000	4	10	12°	50	6	700
K-VM-4040-1600		16		60		900
K-VM-4050-1250	5	12.5	12°	50	6	800
K-VM-4050-2000		20		60		1,200
K-VM-4060-1500	6	15	—	50	6	800
K-VM-4060-2400		24		60		1,200
K-VM-4080-2000	8	20	—	60	8	1,500
K-VM-4080-3200		32		75		2,000
K-VM-4100-2500	10	25	—	75	10	1,900
K-VM-4100-4000		40		100		2,700
K-VM-4120-3000	12	30	—	75	12	2,600
K-VM-4120-4800		48		100		3,700



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



Standard



2 Flute

2刃

4 Flute

4刃

3&6 Flute

3&6刃

Square

方型

Ball

球型

Corner Radius

角半徑

Taper

錐型

Other

特殊
刀具

K-VM(4刃)切削條件說明表 List of milling for K-VM(4flutes)

加工材料 WORK MATERIAL		碳素鋼 CARBON STEELS			合金鋼 ALLOY STEELS			工具鋼 PREHARDENED STEELS HARDENED STEELS NAK.SKD (30-45HRC)			高溫合金鋼 HARDENED STEELS SKD11.60.SKT (45-55HRC)		
		S45C.S55C (~225HB)			SK.SCM.SUS (225~325HB)								
型號 Model Number	外徑 Outside Diameter (mm)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)
4010	1	20,000	(65)	240	15,000	(45)	215	11,000	(35)	85	7,100	(20)	40
4015	1.5	13,500		245	10,000		215	8,000		90	5,100		50
4020	2	11,000	(70~85)	245	8,500	(55~65)	215	6,400	(40~45)	90	4,000	(25~30)	55
4025	2.5	8,800		370	7,000		245	5,000		90	3,200		55
4030	3	7,400		370	6,400		260	4,500		90	2,800		65
4040	4	5,900		435	5,500		340	3,500		105	2,150		70
4050	5	5,300		590	4,200		415	2,950		120	1,850		75
4060	6	4,400		580	3,500		415	2,450		130	1,500		70
4080	8	3,300		550	2,600		415	1,850		125	1,200		70
4100	10	2,600		525	2,100		405	1,450		125	950		65
4120	12	2,200		525	1,750		405	1,200		120	800		60

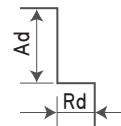
高速加工條件 For high-speed milling

加工材料 WORK MATERIAL		碳素鋼 CARBON STEELS			合金鋼 ALLOY STEELS			工具鋼 PREHARDENED STEELS HARDENED STEELS NAK.SKD (30-45HRC)			高溫合金鋼 HARDENED STEELS SKD11.60.SKT (45-55HRC)		
		S45C.S55C (~225HB)			SK.SCM.SUS (225~325HB)								
型號 Model Number	外徑 Outside Diameter (mm)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	切削速度 Velocity (m/min)	進給量 Feed (mm/min)
4030	3	30,000	(300)	790	26,500	(250)	600	21,200	(200)	375	15,800	(150)	365
4040	4	23,800		930	19,800		750	15,800		405	11,900		385
4050	5	19,000		1,110	15,800		865	12,700		385	9,500		385
4060	6	15,900		1,100	13,200		865	10,600		435	7,900		370
4080	8	11,900		1,045	9,900		875	7,900		405	5,900		345
4100	10	9,500		1,005	7,900		845	6,300		415	4,700		320
4120	12	7,900		1,000	6,600		850	5,300		400	3,900		295

切削量 (mm)

側面切削 Milling Amount of Milling

加工材料	外徑	2.5D(刃長=外徑 X 2.5) Length of Cut=Diameter X 2.5	4D(刃長=外徑 X 4) Length of Cut=Diameter X 4
45HR以下 less than 45HRC		Rd=0.07D Ad=2D	Rd=0.02D Ad=3.5D
45HR以上 more than 45HRC		Rd=0.03D Ad=1.5D	Rd=0.01D Ad=3D



Ad=軸方向切削量 (mm) Milling Amount

Rd=徑方向切削量 (mm) Radial Depth



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



Standard



K-VMS 鎢鋼 3 刃 6 刃 立 銑 刀

Standard, 3 & 6 Flute END MILLS

2 Flute

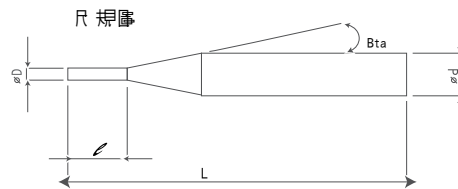
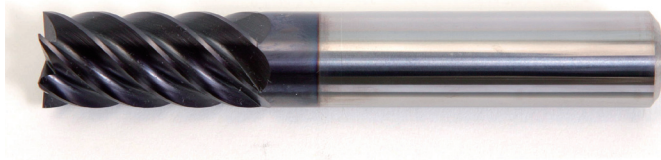
2刃

4 Flute

4刃

3&6 Flute

3&6刃



採用超微粒子合金
Super fine grain alloy is used
for the carbide material.



高鋁鈦處理

TiAlN coating is used.



刃長 (標準長)

For medium length of cut.



45° 螺旋角

Helix Angle is 45°



加工材料對照表 (◎ 最佳 ○ 可) Applicable Work Material (◎ Most suitable ○ suitable)

被削材 Work Material									
碳素鋼 CARBON STEELS	合金鋼 ALLOY STEELS	工具鋼 PREHARDENED STEELS	高溫合金鋼 HARDENED STEELS			鑄鐵 CAST IRON STEELS	鋁合金 ALUMINIUM ALLOYS	石墨 GRAPHITE	銅合金 COPPER ALLOYS
S45C S55C	SK-SCM SUS	(30-45HRC) NAK	(~55HRC)	(~60HRC)	(60~ 65HRC)				
		○	◎	◎	○				○

單位:Unit(mm)

型號 Model Number	外徑 Outside Diameter	刃長 Length of Cut	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)
	ØD	ℓ	Bta	L	Ød	
K-VMS 6060	6	15	—	50	6	2,200
K-VMS 6080	8	20	—	60	8	2,900
K-VMS 6100	10	25	—	75	10	4,500
K-VMS 6120	12	30	—	75	12	5,200
K-VMS 6160	16	45	—	100	16	10,500
K-VMS 6200	20	45	—	100	20	17,000

Square

方型

Ball

球型

Corner Radius

角半徑

Taper

錐型

Other

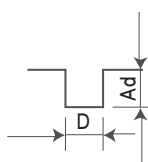
特殊
刀具

K-VMS 切削條件說明表 List of milling for K-VMS(3-6 Flutes)

加工材料的硬度 WORK MATERIAL HARDNESS		45~50HRC		50~60HRC		60~65HRC	
切削速度 Velocity		V = 30m/min前後 around V = 30m/min		V = 20m/min前後 around V = 20m/min		V = 18m/min前後 around V = 18m/min	
型號 Model Number	外徑 Outside Diameter (mm)	轉數 Speed (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/min)	進給量 Feed (mm/min)	轉數 Speed (m/min)	進給量 Feed (mm/min)
6060	6	1,600	170	1,100	120	960	100
6080	8	1,200	170	800	120	720	100
6100	10	950	170	640	100	580	80
6120	12	800	170	530	90	480	70
6160	16	600	130	400	80	360	60
6200	20	480	105	320	70	300	50

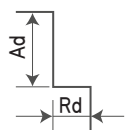
溝切削

切削量 (mm) Milling Amount for slotting
Ad=0.5D以下 Less than 0.05D
D:外徑(mm) Outside Diameter
Ad:軸方向切削量(mm) Milling Amount



側面切削

切削量 (mm) Milling amount for slotting
D≤φ8 Ad=1D
D≤φ10 Ad=1.5D (Max0.5mm)
Rd=0.05D (但max0.05mm)
D:外徑(mm) Outside Diameter
Rd:軸方向切削量(mm) Radial Depth



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



Standard



K-VMSL 鎢鋼 3 刃 6 刃 長刃 立銑刀

Long, 3 & 6 Flute END MILLS

2 Flute

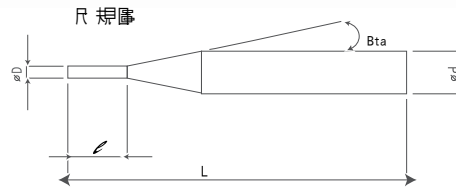
2 刃

4 Flute

4 刃

3&6 Flute

3&6 刃



採用超微粒子合金
Super fine grain alloy is used
for the carbide material.



高鋁鈦處理
TiAlN coating is used.



刃長 (長)
For long length of cut.



45° 螺旋角
Helix Angle is 45°



加工材料對照表 (◎ 最佳 ○ 可) Applicable Work Material (◎ Most suitable ○ suitable)

被削材 Work Material									
碳素鋼 CARBON STEELS	合金鋼 ALLOY STEELS	工具鋼 PREHARDENED STEELS	高溫合金鋼 HARDENED STEELS			鑄鐵 CAST IRON STEELS	鋁合金 ALUMINIUM ALLOYS	石墨 GRAPHITE	銅合金 COPPER ALLOYS
S45C S55C	SK-SCM SUS	(30-45HRC) NAK	(~55HRC)	(~60HRC)	(60~ 65HRC)				
		○	◎	○					○

單位: Unit(mm)

型號 Model Number	外徑 Outside Diameter	刃長 Length of Cut	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	刃數 Number of Flute	定價 Price (NT)
	$\varnothing D$	ℓ	Bta	L	$\varnothing d$		
K-VMSL 6060	6	26	—	70	6	6	2,400
K-VMSL 6080	8	36	—	90	8		3,000
K-VMSL 6100	10	46	—	100	10		4,000
K-VMSL 6120	12	56	—	120	12		5,000
K-VMSL 6160	16	66	—	135	16		10,000
K-VMSL 6200	20	76	—	155	20		14,000

方型

球型

角半徑

錐型

特殊
刀具

K-VMSL 切削條件說明表 List of milling for K-VMSL(3-6 flutes)

加工材料的硬度 WORK MATERIAL HARDNESS		40~50HRC		50~60HRC	
切削速度 Velocity		V = 30m/min前後 around V = 30m/min		V = 20m/min前後 around V = 20m/min	
型號 Model Number	外徑 Outside Diameter (mm)	轉數 Speed (m/in-1)	進給量 Feed (mm/min)	迴轉數 Speed (m/in-1)	進給量 Feed (mm/min)
3010	1	9,500	140~210	6,400	95~143
3020	2	4,700	80~120	3,200	75~115
3030	3	3,200	85~128	2,100	80~120
4040	4	2,400	90~135	1,600	85~128
4050	5	1,900	90~135	1,300	85~128
6060	6	1,600	170~255	1,100	120~180
6080	8	1,200	170~255	800	120~180
6100	10	950	170~255	640	100~150
6120	12	800	170~255	530	90~135
6160	16	600	130~195	400	80~120
6200	20	480	105~158	320	70~105



Standard

2刃

2 Flute

4刃

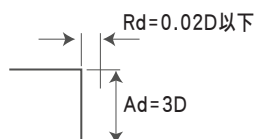
4 Flute

3&6刃

3&6 Flute

側面切削

切削量 (mm) Milling amount for slotting
Ad: 徑方向切削量 (mm) Milling Amount
Rd: 軸方向切削量 (mm) Outside Diameter
D: 外徑 (mm) Outside Diameter



Standard



K-VMD 鎢鋼 2 刃 點 數 立 銑 刀

Standard, 2 Flute Decimal END MILLS

2 Flute

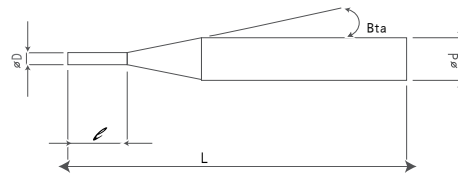
2刃

4 Flute

4刃

3&6 Flute

3&6刃



採用超微粒子合金
Super fine grain alloy is used
for the carbide material.



30° 螺旋角
Helix Angle is 30°



加工材料對照表(◎最佳○可)Applicable Work Material(◎ Most suitable ○ suitable)

被削材 Work Material									
碳素鋼 CARBON STEELS	合金鋼 ALLOY STEELS	工具鋼 PREHARDENED STEELS	高溫合金鋼 HARDENED STEELS			鑄鐵 CAST IRON STEELS	鋁合金 ALUMINIUM ALLOYS	石墨 GRAPHITE	銅合金 COPPER ALLOYS
S45C S55C	SK-SCM SUS	(30-45HRC) NAK	(~55HRC)	(~60HRC)	(60~ 65HRC)				
◎	◎	◎					○		○

單位:Unit(mm)

型號 Model number	外徑 Outside Diameter	刃長 Length of Cut	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)
K-VMD 2003	0.3	0.5	45	4	1,400
K-VMD2 2003		0.8			
K-VMD 2004		0.6			
K-VMD2 2004	0.4	1	45	4	800
K-VMD 2005		0.8			
K-VMD2 2005		1.2			
K-VMD 2006	0.5	1	45	4	800
K-VMD2 2006		1.5			
K-VMD 2007		1			
K-VMD2 2007	0.6	1.5	45	4	800
K-VMD 2008		1.2			
K-VMD2 2008		2			
K-VMD 2009	0.7	1.2	45	4	800
K-VMD2 2009		2			
K-VMD 2010		2			
K-VMD2 2010	0.8	2.5	45	4	700
K-VMD 2011		2			
K-VMD2 2011		2.5			
K-VMD 2012	0.9	2	45	4	800
K-VMD2 2012		3			
K-VMD 2013		2.5			
K-VMD2 2013	1	3	45	4	800
K-VMD 2014		2.5			
K-VMD2 2014		3			



單位:Unit(mm)

型號 Model number	外徑 Outside Diameter	刃長 Length of Cut	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)
K-VMD 2015	1.5	3	45	4	700
K-VMD2 2015		3	45	4	800
K-VMD 2016	1.6	3	45	4	
K-VMD2 2016		4	45	4	
K-VMD 2017	1.7	3	45	4	
K-VMD2 2017		4	45	4	
K-VMD 2018	1.8	3.5	45	4	
K-VMD2 2018		5	45	4	
K-VMD 2019	1.9	3.5	45	4	
K-VMD2 2019		5	45	4	
K-VMD 2020	2	4	45	4	700
K-VMD2 2020		6	45	4	900
K-VMD 2021	2.1	4	45	4	800
K-VMD2 2021		6	45	4	900
K-VMD 2022	2.2	4	45	4	800
K-VMD2 2022		6	45	4	900
K-VMD 2023	2.3	4.5	45	4	800
K-VMD2 2023		6	45	4	900
K-VMD 2024	2.4	4.5	45	4	800
K-VMD2 2024		8	45	4	900
K-VMD 2025	2.5	5	45	4	700
K-VMD2 2025		8	45	4	900
K-VMD 2030	3	6	45	4	700
K-VMD2 2030		10	45	4	900
K-VMD 2035	3.5	10	45	4	700
K-VMD2 2040	4	8	45	4	700
K-VMD 2040		12	45	4	900
K-VMD2 2045	4.5	12	45	6	800
K-VMD 2050	5	8	50	6	800
K-VMD2 2050		15	50	6	
K-VMD 2055	5.5	15	50	6	
K-VMD2 2060	6	8	50	6	
K-VMD 2060		15	50	6	1,400
K-VMD2 2065	6.5	15	60	8	
K-VMD 2070	7	20	60	8	
K-VMD2 2080	8	20	60	8	1,800
K-VMD 2085	8.5	20	75	10	
K-VMD2 2090	9	20	75	10	
K-VMD 2100	10	15	75	10	2,500
K-VMD2 2100		25	75	10	
K-VMD 2110	11	25	75	12	5,000
K-VMD2 2120	12	25	75	12	
K-VMD 2160	16	40	100	16	8,200
K-VMD2 2180	18	45	100	20	8,200
K-VMD 2200	20	45	100	20	8,200



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



方型



球型



角半徑



錐型



特殊
刀具

Standard



2 Flute

2刃

4 Flute

4刃

3&6 Flute

3&6刃

K-VMD 切削條件說明表 List of milling for K-VMD(2 Flutes)

加工材料 WORK MATERIAL		碳素鋼 CARBON STEELS S45C.S55C (~225HB)		合金鋼 ALLOY STEELS SK.SCM.SUS(225~325HB)		工具鋼 PREHARDENED STEELS/HARDENED STEELS NAK.SKD(30~45HB)	
切削速度 Velocity		V = 35m/min		V = 25m/min		V = 20m/min	
型號 Model Number	外徑 Outside Diameter (mm)	轉數 Speed (m/in-1)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	進給量 Feed (mm/min)
K-VMD-2003	0.3	37,000	50	32,000	45	21,200	30
K-VMD-2005	0.5	25,000	60	20,000	50	12,700	30
K-VMD-2008	0.8	16,000	60	12,000	50	8,000	35
K-VMD-2010	1	12,700	75	9,500	55	6,400	35
K-VMD-2020	2	6,400	90	4,800	70	3,200	40
K-VMD-2030	3	3,700	100	3,180	85	2,100	50
K-VMD-2040	4	2,800	100	2,400	85	1,600	55
K-VMD-2050	5	2,230	100	1,900	85	1,300	55
K-VMD-2060	6	1,860	100	1,600	85	1,060	60
K-VMD-2100	10	1,120	110	960	90	650	60

Square

方型

Ball

球型

Corner Radius

角半徑

Taper

錐型

Other

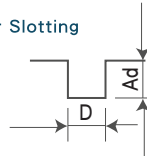
特殊
刀具

溝切削

切削量 (mm) Milling Amount for Slotting

 $D < \phi 3$ $Ad = 0.5D$ $D \leq \phi 3$ $Ad = 1D$

D:外徑(mm) Outside Diameter



K-VMD2 切削條件說明表 List of milling for K-VMD2(2 Flutes)

加工材料 WORK MATERIAL		碳素鋼 CARBON STEELS S45C.S55C (~225HB)		合金鋼 ALLOY STEELS SK.SCM.SUS(225~325HB)		工具鋼 PREHARDENED STEELS/HARDENED STEELS NAK.SKD(30~45HB)	
切削速度 Velocity		V = 35m/min		V = 25m/min		V = 20m/min	
型號 Model Number	外徑 Outside Diameter (m/m)	轉數 Speed (m/in-1)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	進給量 Feed (mm/min)	轉數 Speed (m/in-1)	進給量 Feed (mm/min)
K-VMD2-2003	0.3	37,000	55	27,200	50	21,200	30
K-VMD2-2004	0.4	31,000	60	22,000	50	17,000	30
K-VMD2-2005	0.5	25,000	65	17,000	55	12,700	30
K-VMD2-2006	0.6	22,000	65	15,000	55	11,100	30
K-VMD2-2007	0.7	19,000	70	13,000	55	9,600	35
K-VMD2-2008	0.8	16,000	40	10,000	55	8,000	35
K-VMD2-2009	0.9	14,000	75	9,200	55	7,200	35
K-VMD2-2010	1	12,700	75	8,100	60	6,400	35
K-VMD2-2011	1.1	12,000	80	7,700	60	6,100	35
K-VMD2-2012	1.2	11,400	80	7,300	65	5,800	35
K-VMD2-2013	1.3	10,700	85	6,900	65	5,500	35
K-VMD2-2014	1.4	10,100	85	6,500	65	5,200	35
K-VMD2-2015	1.5	9,500	90	6,100	70	4,800	40
K-VMD2-2016	1.6	8,900	90	5,700	70	4,400	40
K-VMD2-2017	1.7	8,300	90	5,300	70	4,100	40
K-VMD2-2018	1.8	7,600	95	4,900	75	3,800	40
K-VMD2-2019	1.9	7,000	95	4,500	75	3,500	40
K-VMD2-2020	2	6,400	95	4,100	75	3,200	40
K-VMD2-2021	2.1	6,200	95	4,000	80	3,100	40
K-VMD2-2022	2.2	6,000	95	3,800	80	3,000	40
K-VMD2-2023	2.3	5,700	100	3,700	80	2,900	45
K-VMD2-2024	2.4	5,400	100	3,600	85	2,800	45
K-VMD2-2025	2.5	5,100	100	3,400	85	2,700	45

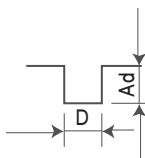
溝切削

切削量 (mm) Milling amount for slotting

Ad=0.5D

D:外徑(mm) Outside Diameter

Ad:軸方向切削量(mm) Milling Amount



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



Square

方型



Ball

球型



Corner Radius

角半徑



Taper

錐型



Other

特殊
刀具

Standard



K-TVL 鎢鋼深溝2刃立銑刀

2 Flute Long Neck END MILLS

2 Flute

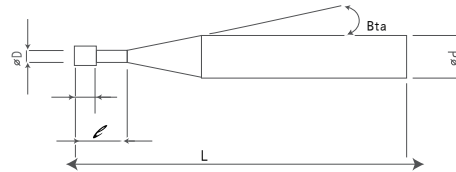
2刃

4 Flute

4刃

3&6 Flute

3&6刃



採用超微粒子合金
Super fine grain alloy is used
for the carbide material .



NANO處理
TiCN coating process
is used .



30° 螺旋角
Helix Angle is 30°



加工材料對照表(◎最佳○可)Applicable Work Material(◎ Most suitable ○ suitable)

被削材 Work Material										
碳素鋼 CARBON STEELS	合金鋼 ALLOY STEELS	工具鋼 PREHARDENED STEELS	高溫合金鋼 HARDENED STEELS			鑄鐵 CAST IRON STEELS	鋁合金 ALUMINIUM ALLOYS	石墨 GRAPHITE	銅合金 COPPER ALLOYS	塑膠 PLASTIC
S45C S55C	SK-SCM SUS	(30-45HRC) NAK	(~55HRC)	(~60HRC)	(60~ 65HRC)					
◎	◎	◎	◎	◎	○	○		○		

單位:Unit(mm)

型號 Model Number	外徑 Outside Diameter	有效長 Effective Length	刃長 Length of Cut	首徑 Neck Diameter	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)
	φD	ℓ ₁	ℓ	φd ₁	Bta	L	φd	
K-TVL 2002-0.5	0.2	0.5	0.3	0.16	12°	45	4	1,700
K-TVL 2002-1		1						2,350
K-TVL 2002-1.5		1.5						2,350
K-TVL 2003-1	0.3	1	0.4	0.26	12°	45	4	1,700
K-TVL 2003-2		2						2,150
K-TVL 2003-3		3						2,150
K-TVL 2004-2	0.4	2	0.6	0.36	12°	45	4	1,700
K-TVL 2004-3		3						2,150
K-TVL 2004-4		4						2,150
K-TVL 2004-5	0.5	5	0.7	0.46	12°	45	4	2,150
K-TVL 2005-2		2						1,100
K-TVL 2005-4		4						1,100
K-TVL 2005-6		6						1,100
K-TVL 2005-8		8						1,250

單位:Unit(mm)

型號 Model Number	外徑 Outside Diameter	有效長 Effective Length	刃長 Length of Cut	首徑 Neck Diameter	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)	
	øD	<i>ℓ</i> ₁	<i>ℓ</i>	ød ₁	Bta	L	ød		
K-TVL 2006-2	0.6	2	0.9	0.56	12°	45	4	1,000	
K-TVL 2006-4		4							
K-TVL 2006-6		6						1,250	
K-TVL 2006-8		8							
K-TVL 2006-10		10							
K-TVL 2007-2	0.7	2	1	0.66	12°	45	4	1,000	
K-TVL 2007-3		3							
K-TVL 2007-4		4							
K-TVL 2007-6		6							
K-TVL 2007-8		8						1,250	
K-TVL 2007-10		10							
K-TVL 2008-4	0.8	4	1.2	0.76	12°	45	4	1,000	
K-TVL 2008-6		6							
K-TVL 2008-8		8				50		1,250	
K-TVL 2008-10		10							
K-TVL 2008-12		12							
K-TVL 2009-4	0.9	4	1.3	0.86	12°	45		1,000	
K-TVL 2009-6		6							
K-TVL 2009-8		8						50	1,250
K-TVL 2009-10		10							
K-TVL 2009-15		15							
K-TVL 2010-4	1	4	1.5	0.93	12°	45	4	1,100	
K-TVL 2010-6		6							
K-TVL 2010-8		8							
K-TVL 2010-10		10				50		1,250	
K-TVL 2010-12		12							
K-TVL 2010-16		16							
K-TVL 2010-20		20							
K-TVL 2012-6	1.2	6	1.8	1.13	12°	45	4	1,100	
K-TVL 2012-8		8							
K-TVL 2012-10		10							
K-TVL 2012-12		12						50	1,250
K-TVL 2012-16		16							
K-TVL 2014-6	1.4	6	2.1	1.33	12°	45	4	1,100	
K-TVL 2014-8		8							
K-TVL 2014-10		10							
K-TVL 2014-12		12				50		1,250	
K-TVL 2014-14		14							
K-TVL 2014-16		16							
K-TVL 2014-22		22							



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



方型



球型



角半徑



錐型



特殊
刀具

Standard



2 Flute

2刃

4 Flute

4刃

3&6 Flute

3&6刃

Square

方型

Ball

球型

Corner Radius

角半徑

Taper

錐型

Other

特殊
刀具

型號 Model Number	外徑 Outside Diameter	有效長 Effective Length	刃長 Length of Cut	首徑 Neck Diameter	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Pruce (NT)
	øD	ℓ ₁	ℓ	ød ₁	Bta	L	ød	
K-TVL 2015-6	1.5	6	2.3	1.43	12°	45	4	1100
K-TVL 2015-8		8						
K-TVL 2015-10		10						
K-TVL 2015-12		12				50		
K-TVL 2015-14		14						
K-TVL 2015-16		16						
K-TVL 2015-18		18				55		
K-TVL 2015-20		20						
K-TVL 2016-6	1.6	6	2.4	1.5	12°	45	4	1100
K-TVL 2016-8		8						
K-TVL 2016-10		10						
K-TVL 2016-12		12				50		
K-TVL 2016-14		14						
K-TVL 2016-16		16						
K-TVL 2016-18		18				55		
K-TVL 2016-20		20						
K-TVL 2016-26		26				60		1250
K-TVL 2018-6	1.8	6	2.7	1.7	12°	45	4	1100
K-TVL 2018-10		10						
K-TVL 2018-12		12				50		
K-TVL 2018-14		14						
K-TVL 2018-16		16				55		
K-TVL 2018-20		18						
K-TVL 2018-25		25				60		1250
K-TVL 2020-6	2	6	3	1.9	12°	45	4	1000
K-TVL 2020-8		8						
K-TVL 2020-10		10				50		
K-TVL 2020-12		12						
K-TVL 2020-14		14				55		
K-TVL 2020-16		16						
K-TVL 2020-18		18				60		
K-TVL 2020-20		20						
K-TVL 2020-25		25				70		1250
K-TVL 2020-30		30						
K-TVL 2025-8	2.5	8	3.7	2.4	12°	45	4	1100
K-TVL 2025-10		10						
K-TVL 2025-12		12				50		
K-TVL 2025-14		14						
K-TVL 2025-16		16				55		
K-TVL 2025-18		18						
K-TVL 2025-20		20				60		
K-TVL 2025-25		25						
K-TVL 2025-30		30				70		1250

單位:Unit(mm)

型號 Model Number	外徑 Outside Diameter	有效長 Effective Length	刃長 Length of Cut	首徑 Neck Diameter	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Pruce (NT)		
	øD	ℓ ₁	ℓ	ød ₁	Bta	L	ød			
K-TVL 2030-8	3	8	4.5	2.9	12°	45	6	1,250		
K-TVL 2030-10		10				50				
K-TVL 2030-12		12								
K-TVL 2030-14		14				60				
K-TVL 2030-16		16								
K-TVL 2030-18		18				70				
K-TVL 2030-20		20								
K-TVL 2030-25		25				80		1600		
K-TVL 2030-30		30				90				
K-TVL 2030-35		35				100				
K-TVL 2030-40	3.5	40	5	3.35	12°	50	6	1,250		
K-TVL 2035-12		12				60				
K-TVL 2035-15		15								
K-TVL 2035-16		16				70				
K-TVL 2035-20		20								
K-TVL 2035-25		25				80		1600		
K-TVL 2035-30		30				90				
K-TVL 2035-35	35	100								
K-TVL 2040-12	4	12	6	3.8	12°	50	6	1,250		
K-TVL 2040-16		16				60				
K-TVL 2040-20		20								
K-TVL 2040-25		25				70				
K-TVL 2040-30		30								
K-TVL 2040-35		35				80		1600		
K-TVL 2040-40		40				90		1900		
K-TVL 2040-45		45				100		2400		
K-TVL 2040-50		50								
K-TVL 2050-16	5	16	7.5	4.8	12°	60	6	1600		
K-TVL 2050-20		20				80				
K-TVL 2050-25		25								
K-TVL 2050-30		30				110				
K-TVL 2050-35		35								
K-TVL 2050-40		40								
K-TVL 2050-50		50				2400				
K-TVL 2060-20	6	20	9	5.8	—	80	6	1600		
K-TVL 2060-30		30				100				
K-TVL 2060-40		40								
K-TVL 2060-50		50				120			2400	
K-TVL 2060-60		60							3000	



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



Square

方型



Ball

球型



Corner Radius

角半徑



Taper

錐型



Other

特殊
刀具

Standard



2 Flute

2刃

4 Flute

4刃

3&6 Flute

3&6刃

Square

方型

Ball

球型

Corner Radius

角半徑

Taper

錐型

Other

特殊
刀具

K-TVL(2刃)切削條件說明表 List of milling for K-TVL(2Flutes)

加工材料 WORK MATERIAL		工具鋼 PREHARDENED STEELS/HARDENED STEELS NAK, SKD (30-45HRC)		
型號 Model Number	外徑 Outside Diameter (mm)	轉數 Speed (m/min-1)	進給量 Feed (mm/min)	Ad (mm/min)
2002-0.5	0.2	26,000~36,000	200~300	0.012
2002-1				0.009
2002-1.5				0.007
2003-1	0.3	26,000~36,000	250~350	0.015
2003-2				0.011
2003-3				0.007
2004-2	0.4	26,000~36,000	300~400	0.015
2004-3				0.011
2004-4				0.007
2004-5				0.004
2005-2	0.5	26,000~36,000	300~400	0.0185
2005-4				0.009
2005-6				0.003
2005-8				0.002
2006-2	0.6	21,000~32,000	300~400	0.025
2006-4				0.015
2006-6				0.006
2006-8				0.004
2006-10				0.003
2007-2	0.7	18,000~27,000	300~400	0.04
2007-3				0.035
2007-4				0.03
2007-6				0.02
2007-8				0.015
2007-10	0.8	16,000~25,000	300~400	0.01
2008-4				0.06
2008-6				0.05
2008-8				0.04
2008-10				0.03
2008-12	0.9	14,000~22,000	400~600	0.02
2009-4				0.06
2009-6				0.05
2009-8				0.04
2009-10				0.03
2009-15				0.01



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



加工材料 WORK MATERIAL		工具鋼 PREHARDENED STEELS/HARDENED STEELS NAK.SKD (30-45HRC)		
型號 Model Number	外徑 Outside Diameter (mm)	轉數 Speed (m/in-1)	進給量 Feed (mm/min)	Ad (mm/min)
2010-4	1	13,000~20,000	400~600	0.06
2010-6				0.05
2010-8				0.04
2010-10				0.03
2010-12				0.02
2010-16				0.01
2010-20				0.004
2012-6	1.2	10,500~17,000	400~600	0.06
2012-8				0.05
2012-10				0.04
2012-12				0.03
2012-16				0.02
2014-6	1.4	9,000~14,000	400~600	0.08
2014-8				0.07
2014-10				0.06
2014-12				0.05
2014-14				0.045
2014-16				0.04
2014-22				0.03
2015-6	1.5	8,500~13,000	400~600	0.014
2015-8				0.12
2015-10				0.10
2015-12				0.085
2015-14				0.07
2015-16				0.05
2015-18				0.03
2015-20				0.015
2016-6	1.6	8,000~12,500	400~600	0.24
2016-8				0.21
2016-10				0.18
2016-12				0.15
2016-14				0.12
2016-16				0.09
2016-18				0.05
2016-20				0.02
2016-26				0.01

Standard



K-SVM 鎢鋼 2 刃 鋁合金 專用刀

Standard, 2 Flute Alloy END MILLS

2 Flute

2 刃

4 Flute

4 刃

3&6 Flute

3&6 刃



採用微粒子合金
Micro grain is used for
the carbide material.

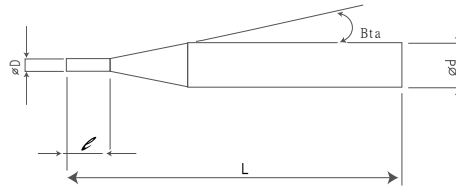


直角

Sharp corner edge.



55° 螺旋角
Helix Angle is 55°



加工材料對照表(◎最佳○可)Applicable Work Material(◎ Most suitable ○ suitable)

被削材 Work Material									
碳素鋼 CARBON STEELS	合金鋼 ALLOY STEELS	工具鋼 PREHARDENED STEELS	高溫合金鋼 HARDENED STEELS			鑄鐵 CAST IRON STEELS	鋁合金 ALUMINIUM ALLOYS	石墨 GRAPHITE	銅合金 COPPER ALLOYS
S45C S55C	SK-SCM SUS	(30-45HRC) NAK	(~55HRC)	(~60HRC)	(60~ 65HRC)				
							○		○

單位:Unit(mm)

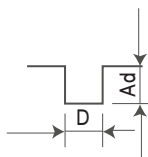
型號 Model Number	外徑 Outside Diameter	刃長 Length of Cut	單角 Shank Taper Angle	全長 Overall Length	柄徑 Shank Diameter	定價 Price (NT)
	$\varnothing D$	ℓ	Bta	L	$\varnothing d$	
K-SVM 2030-0450	3	9	12°	50	6	750
K-SVM 2030-0900						
K-SVM 2040-0600						
K-SVM 2040-1200	4	12				
K-SVM 2050-0750	5	15	—	60	8	1,260
K-SVM 2050-1500			—			
K-SVM 2060-0900			—			
K-SVM 2060-1500	6	15	—			
K-SVM 2080-1200	8	20	—	75	10	1,900
K-SVM 2080-2000			—			
K-SVM 2100-1500			—			
K-SVM 2100-2500	10	30	—			
K-SVM 2120-1800	12	32	—	75	12	2,460
K-SVM 2120-3000			—			

K-SVM 切削條件說明表 List of milling for K-SVM

溝加工 Milling amount for slotting

型號 Model Number	鋁合金等 ALMINIUM ALLOYS .etc A50522		
	外徑 Outside Diameter (m/m)	進給量 Speed (m/in-1)	進給量 Feed (mm/min)
2030-0450	3	16,000	16,000
2040-0600	4	12,000	12,000
2050-0750	5	9,600	1,920
2060-0900	6	8,000	1,600
2080-1200	8	6,000	1,200
2100-1500	10	12,000	2,400
2120-1800	12	10,000	2,000

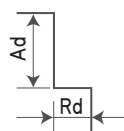
切削量 (mm)
Milling amount for slotting
Ad=0.05D
D:外徑 (mm) Outside Diameter
Ad:軸方向切削量 (mm)
Milling Amount



溝加工 Milling amount for slotting

型號 Model Number	鋁合金等 ALMINIUM ALLOYS .etc A50522		
	外徑 Outside Diameter (m/m)	進給量 Speed (m/in-1)	進給量 Feed (mm/min)
2030-0450	3	16,000	3,200
2030-0900			
2040-0600	4	12,000	2,400
2040-1200			
2050-0750	5	9,600	1,920
2050-1500			
2060-0900	6	8,000	1,600
2060-1500			
2080-1200	8	6,000	1,200
2080-2000			
2100-1500	10	4,800	960
2100-2500			
2120-1800	12	4,000	800
2120-3000			

切削量 (mm)
Milling amount for slotting
刃長=1.5D
Length of cut=2.5~3D
Ad=2.5D
Rd=0.1D
D:外徑 (mm) Outside Diameter
Ad:軸方向切削量 (mm)
Milling Amount
Rd:徑方向切削量 (mm)
Radial Depth



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



Standard



2 Flute

2刃

4 Flute

4刃

3&6 Flute

3&6刃

K-SVM 切削條件說明表 List of milling for K-SVM

高速加工條件 For high-speed milling

型號 Model Number	外徑 Outside Diameter (mm)	鋁合金等 ALUMINIUM ALLOYS .etc A50522	
		進給數 Speed (m/in-1)	進給數 Feed (mm/min)
2030-0450	3	20,000	4,000
2040-0600	4	18,200	3,640
2050-0750	5	17,000	3,400
2060-0900	6	16,000	3,200
2080-1200	8	14,400	2,880
2100-1500	10	13,200	2,640
2120-1800	12	12,000	2,400

切削量 (mm)

Milling amount for slotting

Ad=1.5D

Rd=0.2D

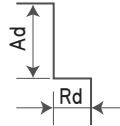
D:外徑 (mm) Outside Diameter

Ad:軸方向切削量 (mm)

Milling Amount

Rd:徑方向切削量 (mm)

Radial Depth



Square

方型

Ball

球型

Corner Radius

角半徑

Taper

錐型

Other

特殊
刀具



Standard

2刃

2 Flute

4刃

4 Flute

3&6刃

3&6 Flute



Square

方型



Ball

球型



Corner Radius

角半徑



Taper

錐型



Other

特殊
刀具