

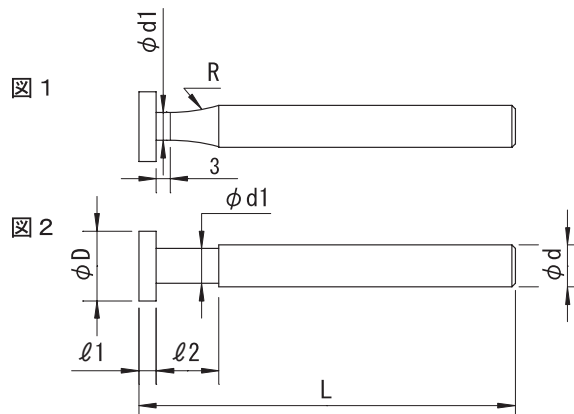
ハイス

TKCLS

切削条件表

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ロングシャンク千鳥刃キーシードカッター Long Shank Staggered Tooth Keyseat Cutter



公差 (Tolerance)	D		$\ell 1$	d	
	10~16	+0.3 +0.18	18~25	+0.35 +0.21	1~3 -0.014 -0.028
	30~40	+0.43 +0.26	50	+0.5 +0.3	4~5 -0.020 -0.038

右刃交互ネジレ15° SKH56
Right hand cut with staggered helix15° HSS-Co.

刃径 (ϕD)	刃厚 ($\ell 1$)	首径 ($d1$)	首長 ($\ell 2$)	R	全長 (L)	シャンク径 (ϕd)	刃数 (N)	形状
Dia.	Cut Width	Neck Dia.	Neck Length	R	Overall Length	Shank Dia.	Number of Flutes	Shape
10	1	4.2	8.8	10	80	8	6	図1
	1.5	4.2	8.8	10	80	8	6	
	2	4.2	8.8	10	80	8	6	
	2.5	4.2	8.8	10	80	8	6	
12	3	4.2	8.8	10	80	8	6	
	1	4.4	10	10	80	10	6	
	1.5	4.4	10	10	80	10	6	
	2	4.4	10	10	80	10	6	
13	2.5	4.4	10	10	80	10	6	
	3	4.4	10	10	80	10	6	
	4	4.4	10	10	80	10	6	
	1	4.4	10	10	80	10	6	
15	1.5	4.4	10	10	80	10	6	
	2	4.4	10	10	80	10	6	
	2.5	4.4	10	10	80	10	6	
	3	4.4	10	10	80	10	6	
16	4	4.4	10	10	80	10	6	
	1	4.7	10.8	13	80	10	6	
	1.5	4.7	10.8	13	80	10	6	
	2	4.7	10.8	13	80	10	6	
18	2.5	4.7	10.8	13	80	10	6	
	3	4.7	10.8	13	80	10	6	
	4	4.7	10.8	13	80	10	6	
	5	4.7	10.8	13	80	10	6	
20	1	5	11.8	13	100	12	6	
	1.5	5	11.8	13	100	12	6	
	2	5	11.8	13	100	12	6	
	2.5	5	11.8	13	100	12	6	
18	3	5	11.8	13	100	12	6	
	4	5	11.8	13	100	12	6	
	5	5	11.8	13	100	12	6	
	1	7	12.6	20	100	12	8	
20	1.5	7	12.6	20	100	12	8	
	2	7	12.6	20	100	12	8	
	2.5	7	12.6	20	100	12	8	
	3	7	12.6	20	100	12	8	
20	4	7	12.6	20	100	12	8	
	5	7	12.6	20	100	12	8	
	1	8	11.7	20	120	12	8	
	1.5	8	11.7	20	120	12	8	

刃径 (ϕD)	刃厚 ($\ell 1$)	首径 ($d1$)	首長 ($\ell 2$)	R	全長 (L)	シャンク径 (ϕd)	刃数 (N)	形状
Dia.	Cut Width	Neck Dia.	Neck Length	R	Overall Length	Shank Dia.	Number of Flutes	Shape
20	2	8	11.7	20	120	12	8	図1
	2.5	8	11.7	20	120	12	8	
	3	8	11.7	20	120	12	8	
	4	8	11.7	20	120	12	8	
25	5	8	11.7	20	120	12	8	
	1	10	12	25	120	12	8	
	1.5	10	12	25	120	12	8	
	2	10	12	25	120	12	8	
30	2.5	10	12	25	120	12	8	
	3	10	12	25	120	12	8	
	4	10	12	25	120	12	8	
	5	10	12	25	120	12	8	
35	1	12	29	-	150	16	10	図2
	1.5	12	28.5	-	150	16	10	
	2	12	28	-	150	16	10	
	2.5	12	27.5	-	150	16	10	
40	3	12	27	-	150	16	10	
	4	12	26	-	150	16	10	
	5	12	25	-	150	16	10	
	1	14	29	-	150	16	10	
50	1.5	14	28.5	-	150	16	10	
	2	14	28	-	150	16	10	
	2.5	14	27.5	-	150	16	10	
	3	14	27	-	150	16	10	
50	4	14	26	-	150	16	10	
	5	14	25	-	150	16	10	
	1.5	14	28.5	-	150	16	12	
	2	14	28	-	150	16	12	
50	2.5	14	27.5	-	150	16	12	
	3	14	27	-	150	16	12	
	4	14	26	-	150	16	12	
	5	14	25	-	150	16	12	