



High Speed Cutting
& High Hard Cutting



Micro Diameter

Type No. 型號	Shank Dia 柄徑	Flute Length 刃長 l ₁	O. A. L. 全長 L	Effective Length 有效長 l ₂	Flute No. 刃數
SCR020	2.0	11	49	24	4
SCR021	2.1	11	49	24	4
SCR022	2.2	12	53	26	4
SCR023	2.3	12	53	26	4
SCR024	2.4	14	57	28	4
SCR025	2.5	14	57	28	4
SCR026	2.6	14	57	28	4
SCR027	2.7	15	61	32	4
SCR028	2.8	15	61	32	4
SCR029	2.9	15	61	32	4
SCR030	3.0	15	61	32	4
SCR031	3.1	16	65	35	4
SCR032	3.2	16	65	35	4
SCR033	3.3	16	65	35	4
SCR034	3.4	18	70	40	4
SCR035	3.5	18	70	40	4
SCR036	3.6	18	70	40	4
SCR037	3.7	18	70	40	4
SCR038	3.8	19	75	43	4
SCR039	3.9	19	75	43	4
SCR040	4.0	19	75	43	4
SCR041	4.1	19	75	43	4
SCR042	4.2	19	75	43	4
SCR043	4.3	21	80	47	4
SCR044	4.4	21	80	47	4
SCR045	4.5	21	80	47	4
SCR046	4.6	21	80	47	4
SCR047	4.7	21	80	47	4
SCR048	4.8	23	86	52	4
SCR049	4.9	23	86	52	4
SCR050	5.0	23	86	52	4
SCR051	5.1	23	86	52	4
SCR052	5.2	23	86	52	4
SCR053	5.3	23	86	52	4

		被削材	炭素鋼・高硬度合金鋼 (SKD, SUS)		鋁合金	
			切削條件		切削條件	
刃徑	預留削除量		切削速度: 5 - 9 m/nin		切削速度: 10 - 20m/nin	
			回轉數 (rpm)	進給 (mm/min)	回轉數 (rpm)	進給 (mm/min)
2	0.1 - 0.2		1000	0.1 - 0.2	2800	0.2 - 0.3
4	0.1 - 0.2		500	0.1 - 0.2	1400	0.2 - 0.3
6	0.2 - 0.3		340	0.2 - 0.3	950	0.2 - 0.3
8	0.2 - 0.3		250	0.2 - 0.3	720	0.3 - 0.4
10	0.2 - 0.3		190	0.2 - 0.3	570	0.3 - 0.4
12	0.2 - 0.3		160	0.2 - 0.3	480	0.4 - 0.5