





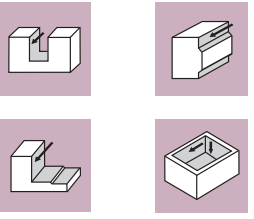
E125X / E127X 超微粒鎢鋼塗層通用立銑刀

Universal End Mills

**MG Carbide**      **AlTiN X-NaNo**

**Type of Operation**

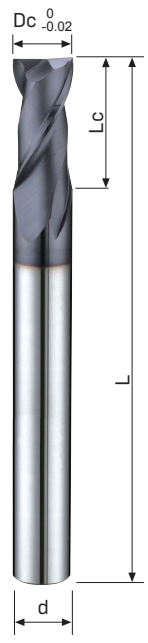


**Work Material**

<b>P</b>	<b>H</b>	<b>M</b>	<b>K</b>	<b>N</b>	<b>S</b>
●	●	○	●	○	○

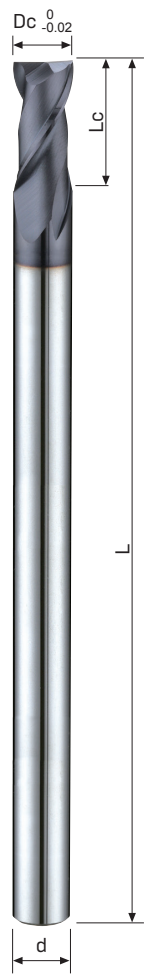
- P** 鋼鐵 Steel
- H** 硬化鋼 <38HRC Hardened Steel
- H** 硬化鋼 <48HRC Hardened Steel
- M** 不銹鋼 Stainless Steel
- K** 鑄鐵 Cast Iron
- N** 銅 Copper

**Feature of product:**  
 2刃一般通用加長立銑刀  
 具有良好的切削表面，採用奈米多層膜塗層具有優異的耐磨性。  
 全長較長可以躲避干涉，可廣泛用於一般通用加工。



Code No. E125X-Dc

Dc 0 -0.02	Lc mm	L mm	d h6	AlTiN E125X
3	12	70	6	●
4	15	70	6	●
5	20	80	6	●
6	20	80	6	●
7	25	100	8	●
8	25	100	8	●
9	30	100	10	●
10	30	100	10	●
11	35	110	12	●
12	40	110	12	●
14	40	120	16	●
16	50	140	16	●
20	60	160	20	●




Code No. E127X-Dc

Dc 0 -0.02	Lc mm	L mm	d h6	AlTiN E127X
3	12	80	4	●
4	15	80	4	●
5	20	100	6	●
6	20	100	6	●
8	25	130	8	●
10	30	160	10	●
12	40	180	12	●
16	50	210	16	●
20	60	210	20	●

## E125X / E127X 切削條件參考表

## Recommended Milling Conditions

## Slotting 溝切削

被削材 Work Material		GR.1 碳鋼 Carbon Steel		GR.2 低合金鋼 Low-alloyed Steel (~24HRC)		GR.3 高合金鋼 Hi-alloyed Steel (~30HRC)		GR.4 硬化鋼 Hardened Steel (30-38HRC)		GR.5 硬化鋼 Hardened Steel (38-48HRC)		GR.9 鑄鐵 Cast Iron	
切削速度 Vc m/min		60		60		50		40		30		80	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)
E125X/E127X-3	3	6,050	140	6,050	140	5,200	120	4,200	80	3,000	65	6,800	140
E125X/E127X-4	4	4,860	149	4,860	149	3,800	120	3,200	90	2,160	65	4,860	149
E125X/E127X-5	5	4,050	162	4,050	162	3,050	120	2,600	90	1,800	75	4,050	162
E125X/E127X-6	6	3,250	162	3,250	162	2,600	120	2,100	90	1,440	75	3,250	162
E125X-7	7	2,850	162	2,850	162	2,275	130	1,850	100	1,260	75	2,850	162
E125X/E127X-8	8	2,450	162	2,450	162	1,950	140	1,600	100	1,080	75	2,450	162
E125X-9	9	2,200	162	2,200	162	1,750	140	1,450	110	970	75	2,200	162
E125X/E127X-10	10	1,950	162	1,950	162	1,550	140	1,300	110	870	75	1,950	162
E125X-11	11	1,780	162	1,780	162	1,420	140	1,200	110	790	75	1,780	162
E125X/E127X-12	12	1,620	162	1,620	162	1,300	140	1,080	110	720	75	1,620	162
E125X-14	14	1,650	180	1,650	180	1,200	150	1,000	118	720	80	1,650	180
E125X/E127X-16	16	1,400	198	1,400	198	1,900	160	900	125	630	90	1,400	198
E125X/E127X-20	20	1,080	198	1,080	198	870	160	720	125	480	90	1,080	198
切入深度 (mm)		ap:0.3D		ap:0.3D		ap:0.3D		ap:0.2D		ap:0.2D		ap:0.3D	

※ Notice: E127X is Long Length series End Mills. Please adjust the parameter according

1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.

※注意E127X為加長柄系列銑刀，請按照適當的伸長度調整刀具的參數。

1. 請使用剛性好、精度高的設備和夾具。
2. 請選擇適用於工件材料的切削液。
3. 此切削條件表中的數值為切削條件的基準值，實際加工時，請考慮加工形狀、目的、使用機台等因素，對切削條件進行調整。
4. 如果機台轉速低於表中所列數值，則進給速度應與轉速按同一比例降低。
5. 切削加工時如果發生振顫，請降低切削條件。