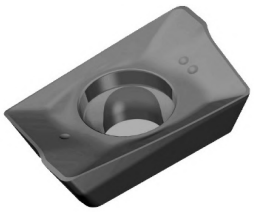
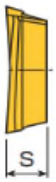
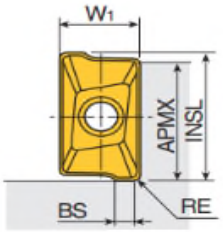
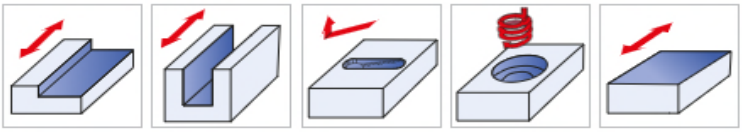
AnyCut®

90도 2코너 커터 인써트(대구텍 타입) / APKT



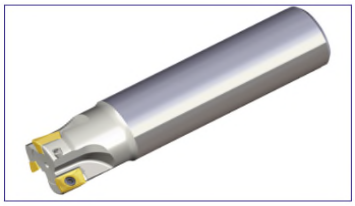




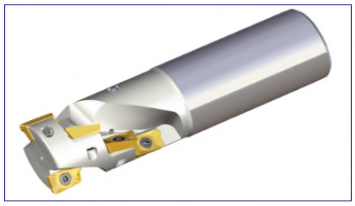


P	M	K	P.M.K	N

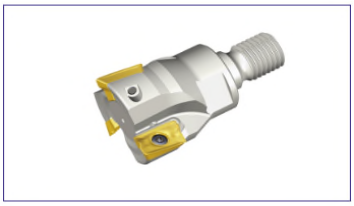
모델	치수(mm)		칩브레이커 / 재종				
	APMX	RE	P30 / AK370	M30 / AK540	K10 / AK650	P20 / AK535	AL / AK10
APKT09T3PER	8.8	0.4	O	O	O	O	O
APKT1705PER	16.0	0.8	O	O	O	O	O



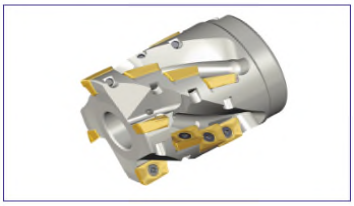
90도 엔드밀 커터	인써트	대구텍	BPK	IL-JIN
	APKT09T3	2S-TE90AP-..-09	EMC..09..	ENCC..09..
		Φ10-40	Φ10-40	Φ16-26
	APKT1705	TE90AP-..-17	EMC..17..	ENCC..17..
		Φ20-40	Φ25-50	Φ25-50



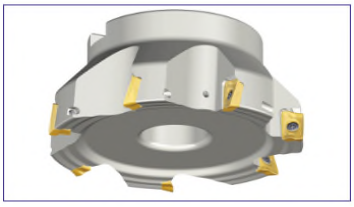
90도 헬리컬 커터	인써트	대구텍	BPK	IL-JIN
	APKT09T3	2S-TEF ..-AP09	X	X
		Φ20-32		
	APKT1705	TEF D..-AP17	X	X
		Φ32-40		



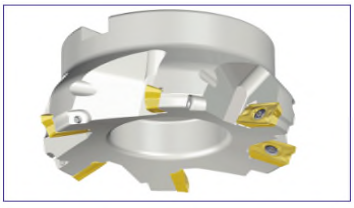
90도 모듈러 헤드	인써트	대구텍	BPK	IL-JIN
	APKT09T3	2S-TE90AP..-M-09	X	M-ENCC..
		Φ10-40		Φ16-21
	APKT1705	TE90AP ..-M..-17	X	M-ENCC..
		Φ20-40		Φ25-40



90도 쉘밀 커터	인써트	대구텍	BPK	IL-JIN
	APKT09T3	X	X	X
	APKT1705	TES D..-AP17	X	X
		Φ50-100		



90도 페이스밀 커터	인써트	대구텍	BPK	IL-JIN
	APKT09T3	2S-TFM90AP..R-09	X	X
		Φ40-80		
	APKT1705	TFM90AP ..R-17	ESC..17..	ESCC-..17..
		Φ40-200	Φ40-125	Φ50-80



75도 페이스밀 커터	인써트	대구텍	BPK	IL-JIN
	APKT09T3	X	X	X
	APKT1705	TFM75AP ..R-17	X	X
		Φ80-125		

EMC-09,12,17 용 절삭 데이타 EMC-09,12,17 Recommended Cutting Data

Material 피삭재		Hardness 경도	Cutting Depth 절삭깊이 (mm)	Cutting Speed 절삭속도 (m/min)	Inserts Grade 추천재종	Feed Rate 이송(mm/TOOTH)					
						Ø20	Ø40	Ø50	Ø63	Ø80	Ø100
P 강 Steel	저탄소강 Low Carbon Steel	85~175	0.5-EDGE/2	210~300	TT7030,TT8020	0.12~0.60	0.15~0.75	0.15~0.85	0.15~1.20	0.15~1.40	0.15~1.60
	고탄소강 High Carbon Steel	175~225	0.5-EDGE/2	120~210	TT7030,TT8020	0.12~0.60	0.15~0.75	0.15~0.85	0.15~1.20	0.15~1.40	0.15~1.60
	합금강 Alloy Steel	275~325	0.5-EDGE/2	90~180	TT8020,TT7030	0.10~0.40	0.12~0.55	0.12~0.75	0.12~1.05	0.12~1.24	0.12~1.40
	공구강 Tool Steel	200~250	0.5-EDGE/2	75~140	TT8020,TT7030	0.10~0.40	0.12~0.55	0.12~0.75	0.12~1.05	0.12~1.24	0.12~1.40
	고경도 합금 인코넬 High Temp. Alloy - Inconel		0.5-EDGE2	22~45	TT8020,TT7030	0.10~0.40	0.12~0.55	0.12~0.75	0.12~1.05	0.12~1.24	0.12~1.40
	티타늄합금 Titanium Alloy		0.5-EDGE/2	36~54	TT8020	0.10~0.40	0.12~0.55	0.12~0.75	0.12~1.05	0.12~1.24	0.12~1.40
M 스테인레스강 Stainless steel	스테인레스 300시리즈 Stainless 300Series		0.5-EDGE/2	120~180	TT8020,TT7030	0.10~0.40	0.12~0.55	0.12~0.75	0.12~1.05	0.12~1.24	0.12~1.40
	스테인레스 400시리즈 Stainless 400Series		0.5-EDGE/2	120~210	TT8020,TT7030	0.12~0.60	0.15~0.75	0.15~0.85	0.15~1.20	0.15~1.40	0.15~1.60
K 주철 Cast iron	회주철 Grey Castiron	190~220	0.5-EDGE/2	120~210	TT6080	0.60~0.12	0.15~0.75	0.15~0.85	0.15~1.20	0.15~1.40	0.15~1.60
	가단주철 Malleable Cast iron	140~200	0.5-EDGE/2	120~210	TT6080	0.12~0.60	0.15~0.75	0.15~0.85	0.15~1.20	0.15~1.40	0.15~1.60
N 비철금속 Nonferrous metals	알루미늄합금 Aluminium Alloy		0.5-EDGE/2	450+	K10	0.25~1.00	0.25~1.00	0.25~1.25	0.25~1.50	0.25~1.75	0.25~2.00

- 계산된 이송은 실제 칩두께를 고려함.
- 절삭폭이 커터 직경의 3/4이상인 경우 속도 20%감소 요망 또는 APKT1705인서트를 사용하여 엔드밀 및 커터로 여러번 가공도 가능