AnyCut®

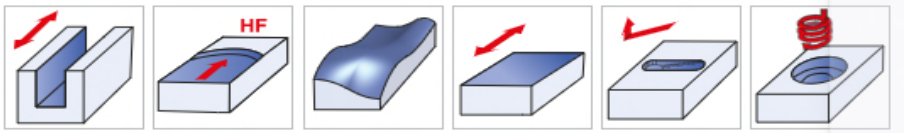
고이송 커터 인써트(히다찌 타입) / EPNW & EDNW



Fig-1



Fig-2



P	M	P.M.K	N

모델	Fig	치수(mm)				재종			
		INSL	W1	S	RE	AK370	AK540	AK530	AK10
EPNW0603TN-8	1	8.10	7.94	3.18	8.00		O	O	
EPNW0803TN-10	2	8.10	7.94	3.18	10.00		O	O	
EDNW10T3TN-10	2	10.00	10.00	3.97	10.00		O	O	
EDNW13T4TN-15	2	13.50	12.70	5.10	15.00		O	O	



고이송 엔드밀 커터	인써트	BPK	IL-JIN
	EPNW0603	X	ASRL-..-.F
			Φ16-33
	EPNW0803	ASRL-..	ASRL-..
		Φ20-21	Φ20-21
	EDNW10T3	ASRL-..	ASRL-..
		Φ25-26	Φ25-26
	EDNW13T4	ASRL-..	ASRL-..
		Φ33	Φ32-40



고이송 모듈러 헤드	인써트	BPK	IL-JIN
	EPNW0603	X	ASRL-..-.F
			Φ16-33
	EPNW0803	ASRL-..	ASRL-..
		Φ20-21	Φ20-21
	EDNW10T3	ASRL-..	ASRL-..
		Φ25-26	Φ25-26
	EDNW13T4	ASRL-..	ASRL-..
		Φ33	Φ32-40



고이송 페이스밀 커터	인써트	BPK	IL-JIN
	EPNW0603	X	ASRL-..-.F
			Φ42-66
	EPNW0803	X	X
	EDNW10T3	X	X
	EDNW13T4	X	ASRL-..
			Φ50-100

ASRL용 절삭데이타 ASRL Recommended Cutting Data

Material 피삭재		Hardness 경도	Cutting Speed 절삭속도 VC(m/min)	Feed Rate 이송속도 FZ(mm/TOOTH)	Ø20			Ø25			Ø30			Ø40		
					Revolution min⁻¹	Feed Speed mm/min	Q cm³/min	Revolution min⁻¹	Feed Speed mm/min	Q cm³/min	Revolution min⁻¹	Feed Speed mm/min	Q cm³/min	Revolution min⁻¹	Feed Speed mm/min	Q cm³/min
P 강 Steel	일반강 General Structural Steels	GX2140 JS4060 JS4045	180~200	0.6~1.5	2,860	3,430	69	2,290	2,750	69	1,900	5,700	171	1,430	6,400	256
					Vc=180m/min fz=0.6mm/tooth ap=1.0mm ae=1.0D						Vc=180m/min fz=1.5mm/tooth ap=1.0mm ae=1.0D					
			90~150	0.6~2.0	1,430	1,720	34	1,150	1,380	34	960	2,880	86	720	3,240	130
					Vc=90m/min fz=0.6mm/tooth ap=1.0mm ae=1.0D						Vc=90m/min fz=1.5mm/tooth ap=1.0mm ae=1.0D					
	탄소, 합금강 Carbon, Alloy Steel (30HCR orless)	GX2140 JS4045 JS4060	180~200	0.6~1.5	2,860	3,430	69	2,290	2,750	69	1,900	5,700	171	1,430	6,400	256
					Vc=180m/min fz=0.6mm/tooth ap=1.0mm ae=1.0D						Vc=180m/min fz=1.5mm/tooth ap=1.0mm ae=1.0D					
			90~150	0.6~2.0	1,430	1,720	34	1,150	1,380	34	960	2,880	86	720	3,240	130
					Vc=90m/min fz=0.6mm/tooth ap=1.0mm ae=1.0D						Vc=90m/min fz=1.5mm/tooth ap=1.0mm ae=1.0D					
	탄소, 합금강 Carbon, Alloy Steel (30~45HCR)	JP4120 JS4045 JS4060	80~120	0.4~0.8	1,430	1,430	29	1,150	1,150	29	960	1,500	45	720	1,730	69
					Vc=90m/min fz=0.5mm/tooth ap=1.0mm ae=1.0D						Vc=90m/min fz=0.8mm/tooth ap=1.0mm ae=1.0D					
M 스테인레스강 Stainless steel	스테인레스강 Stainless Steel (SUS304 등)	JM4160	80~130	0.5~1.0	1,592	1,910	387	1,274	1,528	38	1,061	1,273	38	796	1,433	57
					Vc=100m/min fz=0.6mm/tooth ap=1.0mm ae=1.0D											
			150~200	0.5~1.0	3,183	3,820	61	2,547	3,056	61	2,122	2,547	61	1,592	2,865	92
					Vc=200m/min fz=0.6mm/tooth ap=0.8mm ae=1.0D											
K 주철 Cast iron	주철 Cast iron (FC300 등)	JP4120	180~200	0.8~2.0	2,860	4,580	92	2,290	3,670	92	1,900	7,600	342	1,430	8,580	515
					Vc=180m/min fz=0.8mm/tooth ap=1.0mm ae=1.0D						Vc=180m/min fz=2.0mm/tooth ap=1.5mm ae=1.0D					
		GX2140 JS4045	90~150	0.8~2.0	1,430	2,290	57	1,150	1,840	58	960	3,840	173	720	4,320	259
					Vc=90m/min fz=0.8mm/tooth ap=1.25mm ae=1.0D						Vc=90m/min fz=2.0mm/tooth ap=1.5mm ae=1.0D					
H 열처리강 Hardened Steel	열처리강 Hardened Steel (45~50HRC)	JP4120 JS4045	70~120	0.2~0.6	1,600	950	19	1,270	760	19	1,060	640	19	790	710	28
					Vc=100m/min fz=0.3mm/tooth ap=1.0mm ae=1.0D											
					1,110	440	9	890	350	9	740	300	9	550	330	13
					Vc=70m/min fz=0.2mm/tooth ap=1.0mm ae=1.0D											
	열처리강 Hardened Steel (50~55HRC)	JP4105	70~100	0.05~0.2	1,110	440	5	890	350	5	740	300	5	550	330	7
					Vc=70m/min fz=0.2mm/tooth ap=0.5mm ae=1.0D											
	열처리강 Hardened Steel (55~60HRC)	JP4105	50~100	0.05~0.2	790	80	1	630	60	1	530	53	0.8	400	60	1
					Vc=50m/min fz=0.05mm/tooth ap=0.5mm ae=1.0D											

Material 피삭재		Hardness 경도	Cutting Speed 절삭속도 VC(m/min)	Feed Rate 이송속도 FZ(mm/TOOTH)	Ø50			Ø63			Ø80			Ø100		
					Revolution min⁻¹	Feed Speed mm/min	Q cm³/min	Revolution min⁻¹	Feed Speed mm/min	Q cm³/min	Revolution min⁻¹	Feed Speed mm/min	Q cm³/min	Revolution min⁻¹	Feed Speed mm/min	Q cm³/min
P 강 Steel	일반강 General Structural Steels	GX2140 JS4060 JS4045	180~200	0.6~1.5	1.15	6,900	510	910	5,500	520	720	5,400	650	570	5,130	770
					Vc=180m/min fz=1.5mm/tooth ap=1.5mm ae=1.0D											
			90~150	0.6~2.0	570	3,420	257	455	2,730	258	360	2,700	325	290	2,610	390
					Vc=90m/min fz=1.5mm/tooth ap=1.5mm ae=1.0D											
	탄소, 합금강 Carbon, Alloy Steel (30HCR orless)	GX2140 JS4045 JS4060	180~200	0.6~1.5	1,150	6,900	510	910	5,500	520	720	5,400	650	570	5,130	770
					Vc=180m/min fz=1.5mm/tooth ap=1.5mm ae=1.0D											
			90~150	0.6~2.0	570	3,420	257	455	2,730	258	360	2,700	325	290	2,610	390
					Vc=90m/min fz=1.5mm/tooth ap=1.5mm ae=1.0D											
	탄소, 합금강 Carbon, Alloy Steel (30~45HCR)	JP4120 JS4045 JS4060	80~120	0.4~0.8	570	1,820	130	455	1,450	140	360	1,440	170	290	1,400	210
					Vc=90m/min fz=0.8mm/tooth ap=1.5mm ae=1.0D											
M 스테인레스강 Stainless steel	스테인레스강 Stainless Steel (SUS304 등)	JM4160	80~130	0.5~1.0	637	1,528	76	505	1,213	76	398	1,194	96	319	1,146	115
					Vc=100m/min fz=0.6mm/tooth ap=1.0mm ae=1.0D											
			150~200	0.5~1.0	1,274	3,056	122	1,011	2,426	122	796	2,388	153	637	2,292	184
					Vc=200m/min fz=0.6mm/tooth ap=0.8mm ae=1.0D											
K 주철 Cast iron	주철 Cast iron (FC300 등)	JP4120	180~200	0.8~2.0	1,150	9,200	920	910	7,280	920	720	7,200	1,150	570	6,840	1,370
					Vc=180m/min fz=2.0mm/tooth ap=2.0mm ae=1.0D											
		GX2140 JS4045	90~150	0.8~2.0	570	4,560	456	455	3,640	459	360	3,600	576	290	3,480	696
					Vc=90m/min fz=2.0mm/tooth ap=2.0mm ae=1.0D											
H 열처리강 Hardened Steel	열처리강 Hardened Steel (45~50HRC)	JP4120 JS4045	70~120	0.2~0.6	630	760	38	500	600	38	400	600	48	320	576	58
					Vc=100m/min fz=0.3mm/tooth ap=1.0mm ae=1.0D											
					440	360	18	350	280	18	280	280	22	220	260	26
					Vc=70m/min fz=0.2mm/tooth ap=1.0mm ae=1.0D											
	열처리강 Hardened Steel (50~55HRC)	JP4105	70~100	0.05~0.2	440	350	9	350	280	9	270	270	11	220	260	13
					Vc=70m/min fz=0.2mm/tooth ap=0.5mm ae=1.0D											
	열처리강 Hardened Steel (55~60HRC)	JP4105	50~100	0.05~0.2	310	62	1.5	250	50	1.5	200	50	2.0	160	48	2.4
					Vc=50m/min fz=0.05mm/tooth ap=0.5mm ae=1.0D											