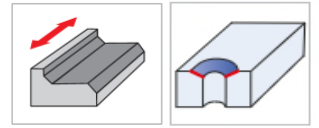
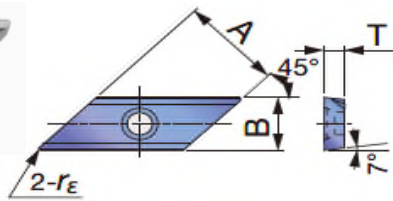


첼퍼-밀 인서트(당가로이 타입) / XCET



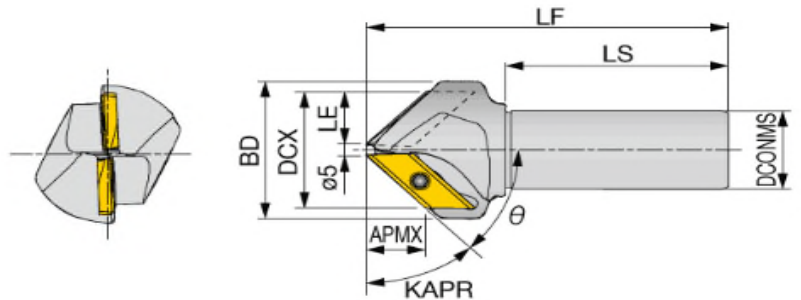
Fig-1



모델	Fig	치수(mm)				재종			
		A	B	T	r	AK370	AK430	AK530	초경
XCET310404ER	1	22.00	12.70	4.50	-				O



Fig-2



인서트	Fig	DCX	θ	Z	당가로이	BPK	IJ-JIN
XCET310404ER	2	26	10	1			CSCC05031R-10
		29	15	1			CSCC05031R-15
		29	20	1			CSCC05031R-20
		33	25	1			CSCC05031R-25
		34	30	1	ECC31005R-30	CSC-05031R-30	CSCC05031R-30
		40	35	1			CSCC05031R-35
		43	40	1			CSCC05031R-40
		48	45	2	ECC31005R-45	CSC-05031R-45	CSCC05031R-45
		53	50	2			CSCC05031R-50
		55	55	2			CSCC05031R-55
		57	60	2	ECC31005R-60	CSC-05031R-60	CSCC05031R-60

Material 피삭재	Grade 재종	Φ5 ~ Φ20		Φ5 ~ Φ20	
		VC(m/min)	FZ(mm/t)	VC(m/min)	FZ(mm/t)
P 강 Steel	PC3700	160~270	0.05~0.25	160~270	0.05~0.25
	PC5300	190~310		190~310	
	A30	60~100		60~100	
M 스테인레스강 Stainless steel	PC5300	100~160	0.05~0.20	100~160	0.10~0.30
	PC5400	70~120		70~120	
K 주철 Cast iron	PC5300	110~180	0.10~0.30	110~180	0.30~0.50
	G10E	50~90		50~90	