



# EDELSTAR 不等距不鏽鋼銑刀系列

EDELSTAR variable leads design End mill series- for all types Stainless work piece.

# EDELSTAR



## 特點

### SPECIAL FEATURES

採用高進給及不等距設計，實現高效率且穩定的切削。

"variable-lead" shape, providing highly efficient milling!

獨特的刃口與螺旋角溝槽設計，加工去屑快速俐落。

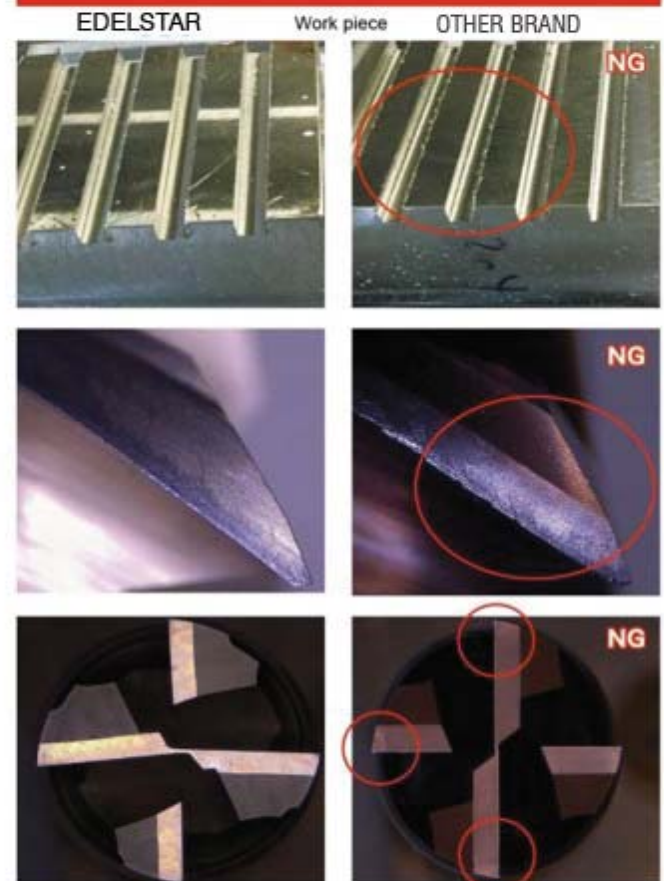
Special flute and helix angle design for deeply depth milling and remove chips more smooth.

G1複合式鍍層專為難切削的不鏽鋼304與4字頭的工件所設計。

Special multilayer coating for milling all types 304 and 4 digit number stainless work piece.

## LIFE TIME Test

### 不鏽鋼刀-壽命破壞性測試



## 實績測試

### Benchmark test:

## ED10 - SEM4100

機台 Machine: CAMPRO- By Coolant

工件 Work Piece: STAINLESS 304

轉速 Spindle Speed: 3600 RPM

進給 Feed rate: 550 mm/min

單刃切削量 Feed Rate per Tooth: 0.05mm

深度 Depth: 1D

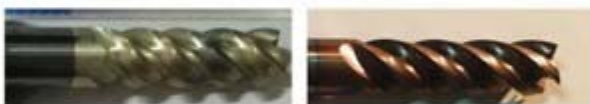
寬度 Width: 10mm

切削方式 Milling Method: 溝銑 Slot milling

EDELSTAR

他社

## ED10 - SEM4100



# EDELSTAR 不等距不鏽鋼銑刀 -4刃

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## 規格表

編號 (Number)	外徑 (D)	刃長 (H)	刃數 (T)	柄徑 (d)	全長 (L)
ED04-SEM 4020	2	5	4	4	50
ED04-SEM 4030	3	8	4	4	50
ED04-SEM 4040	4	10	4	4	50
ED06-SEM 4020	2	5	4	6	50
ED06-SEM 4030	3	8	4	6	50
ED06-SEM 4040	4	10	4	6	50
ED06-SEM 4050	5	12.5	4	6	50
ED06-SEM 4060	6	15	4	6	50
ED08-SEM 4080	8	20	4	8	60
ED10-SEM 4100	10	25	4	10	75
ED12-SEM 4120	12	30	4	12	75
ED16-SEM 4160	16	45	4	16	100
ED20-SEM 4200	20	50	4	20	100

## 切削條件表

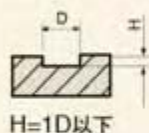
### Recommended Milling Conditions

Cutting Conditions 切削條件	ULTRA micro grain carbide used for EDELSTAR End mills 粉末微粒碳化鎢 不鏽鋼刀- EDELSTAR	Cutting Materials 被切削材	STAINLESS 304 / 316 / 4字頭 熱處理鋼 鈦合金 Ti-6Al-4V	The hardness of the material cut 被切削材 硬度	HRC30-45
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立銑刀刃徑 mm	轉速-spindle speed RPM	進給-feed rate mm/min	立銑刀刃徑 mm	轉速-spindle speed RPM	進給-feed rate mm/min
D3.0	10000	400	D3.0	10000	400
D4.0	8000	500	D4.0	8000	500
D5.0	6500	500	D5.0	6500	500
D6.0	5400	600	D6.0	5400	600
D8.0	4000	600	D8.0	4000	600
D10.0	3200	440	D10.0	3200	440
D12.0	2800	600	D12.0	2800	600
D16.0	2100	400	D16.0	2100	400
D20.0	1700	350	D20.0	1700	350

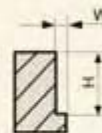
最大切削量 / Max Cutting Range.

Slot Milling- below 1D depth.



H=1D以下

最大切削量 / Max Cutting Range.



Depth= H is within 2D  
W= 0.2D