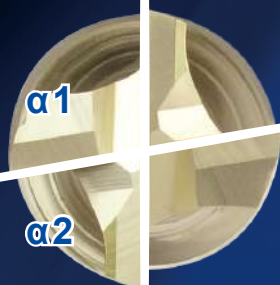


METV

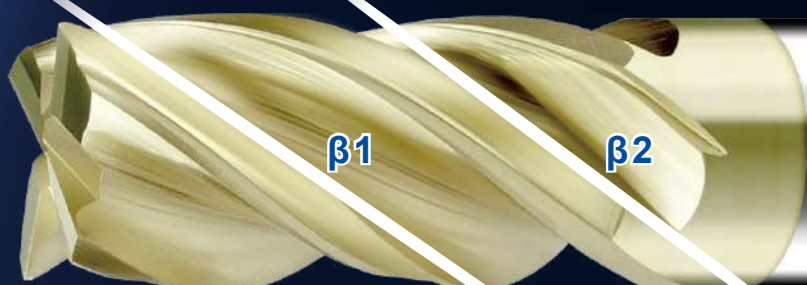
航太專用 · 超乎完美

全新鈦合金專用刀 高效型

FOR TITANIUM ALLOYS



$\alpha 1 \neq \alpha 2$ / 通過不等距幾何，有效抑制切削時的週期性震動！



$\beta 1 \neq \beta 2$ / 不等螺旋角幾何隨側刃不同變化，強力抑制震動，完成良好的面粗度！

航太領域專用切削刀具，為高溫合金材質、3字頭不銹鋼

高效率加工新利器！

1. 專剋鈦合金 & 3字頭不銹鋼難切削材質之應用。

For titanium alloy and stainless steel(300 series) machining.

2. 不等距 & 不等螺旋角設計大幅降低切削時的震動。

Chattering is decreased with unequal flute spacing angle & nonequivalent helix angle.

3. 圓弧溝槽設計，使排屑性能更加優異，減少積屑及應力產生，提升刀具剛性。

Circular flute design for better chip disposal, reduces chip packing and release stress, and improving rigidity of the tool.

4. 適合粗、中、精加工。

Use for roughing cutting, semi finishing, finishing.

切削實例

CUT EXAMPLES

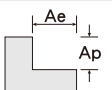
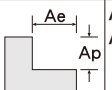
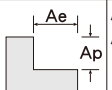



SUS304乾式切削

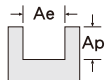


METV 尺寸規格表 SIZE- METV CUTTER

刃徑 Diameter	刃長 Cutting Length	全長 O.A.L.	柄徑 Shank Dia.	鍍膜訂購編號 Coated Order No.
4.0	10	50	6	METV40400A
6.0	15	50	6	METV40600A
8.0	20	60	8	METV40800A
10.0	25	75	10	METV41000A
10.0	30	75	10	METV41000300CA
12.0	30	75	12	METV41200A

側銑加工 SIDE MILLING

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		調質鋼 Hardened Steels		不銹鋼 Stainless Steels		鈦合金 Titanium Alloys					
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SKT,SKD		SUS304		-					
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		HRC45~55		-		HRC<30					
切削速度 Vc	110m/min		90m/min		75m/min		70m/min		70m/min		35m/min					
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)				
3mm	11,670	1,100	9,550	840	7,960	620	7,430	540	7,430	610	3,710	220				
4mm	8,750	1,200	7,160	980	5,970	680	5,570	630	5,570	710	2,780	240				
5mm	7,000	1,300	5,730	1,050	4,770	720	4,450	670	4,450	770	2,220	240				
6mm	5,830	1,600	4,770	1,200	3,980	890	3,710	690	3,710	830	1,850	250				
8mm	4,370	1,550	3,580	1,100	2,980	810	2,780	670	2,780	810	1,390	220				
10mm	3,500	1,450	2,860	1,050	2,380	720	2,220	630	2,220	710	1,110	210				
12mm	2,910	1,400	2,380	1,000	1,990	720	1,850	600	1,850	675	920	210				
16mm	2,180	1,200	1,790	940	1,490	630	1,390	500	1,390	550	690	210				
20mm	1,750	980	1,430	750	1,190	590	1,110	460	1,110	510	550	200				
25mm	1,400	880	1,140	670	955	530	890	390	890	480	440	180				
切削量 Cutting Amount (mm)	Ap ≤ 1.5D Ae ≤ 0.2D				Ap ≤ 1.5D Ae ≤ 0.05D				Ap ≤ 1.5D Ae ≤ 0.1D				Ap ≤ 1.5D Ae ≤ 0.05D			

溝銑加工 SLOT MILLING

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		調質鋼 Hardened Steels		不銹鋼 Stainless Steels		鈦合金 Titanium Alloys					
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SKT,SKD		SUS304		-					
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		HRC45~55		-		HRC<30					
切削速度 Vc	95m/min		75m/min		70m/min		60m/min		60m/min		20m/min					
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)				
3mm	10,080	730	7,960	680	7,430	520	6,360	440	6,360	460	2,120	120				
4mm	7,560	730	5,970	770	5,570	520	4,770	490	4,770	510	1,590	130				
5mm	6,050	730	4,770	750	4,450	540	3,820	530	3,820	540	1,270	140				
6mm	5,040	740	3,980	630	3,710	570	3,180	540	3,180	570	1,060	140				
8mm	3,780	600	2,980	550	2,780	550	2,380	510	2,380	520	790	150				
10mm	3,020	580	2,380	540	2,220	480	1,910	450	1,910	470	630	140				
12mm	2,520	560	1,990	470	1,850	460	1,590	430	1,590	440	530	140				
16mm	1,890	550	1,490	430	1,390	370	1,190	360	1,190	370	390	110				
20mm	1,510	470	1,190	380	1,110	350	955	330	955	330	310	110				
25mm	1,210	450	950	360	890	310	760	230	760	280	250	100				
切削量 Cutting Amount (mm)	Ap ≤ 1D Ap(MAX)=12mm				Ap ≤ 0.2D				Ap ≤ 0.5D				Ap ≤ 0.2D		