

WXL涂层2刃 2D刃长型

WXL Coating Two Flute-Short 2D Flute Length Type

WXL-2D-DE

切削条件 Cutting Conditions **P483**



新开发的WXL涂层2刃铣刀。无论是钢或是铜合金的加工均可发挥效力。2D刃长型不论湿式、干式均可加工。

2 flute end mill with WXL coating with high hardness and better lubrication. Can be used on steels as well as Copper Alloys. Recommended with lubrications or dry milling.

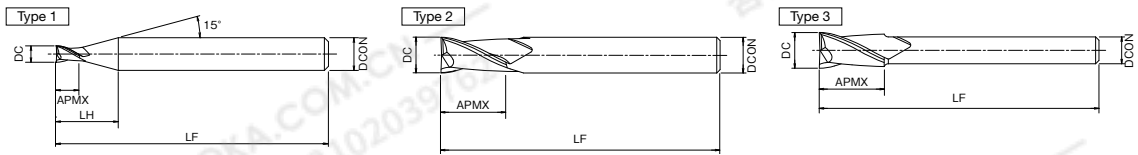


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FROM 外径 DC 7.3~16

(单位:mm) (Unit:mm)

商品号 EDP No.	外径 DC	全长 LF	刃长 APMX	LH	柄径 DCON	形状 Type	库存 Stock	重量 (g)	
3182165	16.5	90	33	—	16	3	●	236	
3182170	17		34				●	240	
3182175	17.5		35				●	244	
3182180	18	100	36	—	20	1	●	249	
3182185	18.5		37				43.3	●	375
3182190	19		38				43.4	●	379
3182195	19.5	105	39	—	20	2	●	384	
3182200	20		40				●	391	
3182210	21		42				●	425	
3182220	22	120	44	—	25	3	●	437	
3182230	23		46				53.3	●	681
3182240	24		48				53.4	●	692
3182250	25	125	50	—	25	2	●	749	
3182300	30	140	60	67.3	32	1	●	1292	



加工材料 Work Material	碳素钢 Carbon Steel	合金钢 Alloy Steel	预硬钢 Prehardened Steel				不锈钢 Stainless Steel	铸铁 Cast Iron	铜合金 Copper Alloy	铝合金 Aluminum Alloy	石墨 Graphite	钛合金 Titanium Alloy	耐热合金 Heat Resistant Alloy	塑料 Plastic
	预硬钢 Prehardened Steel	工具钢 Tool Steel	淬火钢 Hardened Steel	~40HRC	~45HRC	~55HRC	~60HRC	~65HRC	~35HRC	~350HB				
商品记号 Abbreviation														
WXL-2D-DE	○	○	○	○	○	○	○	○	○	○	○	○	○	

库存标识 Inventory symbols

- = 标准库存品
standard stock item
- = 特定代理店库存品
Stocked by specific distributors. Contact us for price & availability.
- ▲ = 由新产品及后续产品取代 (请确认库存)
Scheduled to be replaced by new product or successor item

硬质合金铣刀切削条件基准表

CUTTING CONDITIONS FOR CARBIDE END MILLS

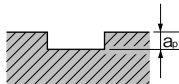
WXL涂层2刃 2D刃长型 槽铣

WXL Coating Two Flute Short 2D Flute Length Type
SLOTING

加工材料 Work Material	铜·铜合金 Copper·Copper Alloy		一般构造用钢·碳素钢 Mild Steel·Carbon Steel FC250·S5400·S55C ~32HRC		调质钢·预硬钢·不锈钢 Hardened Steel·Prehardened Steel·Stainless Steel SKT·SKD61·NAK55·NAK80·HPM1·DH**·SUS304				
	外径 Mill Dia. (mm)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	33~41HRC		42~50HRC	
						转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)
0.1	50,000	100	32,000	70	32,000	60	32,000	30	
0.2	50,000	140	32,000	90	32,000	75	32,000	35	
0.3	50,000	170	32,000	110	32,000	80	32,000	55	
0.4	50,000	190	32,000	120	32,000	90	27,500	60	
0.5	50,000	200	31,000	120	25,000	90	22,000	60	
0.6	50,000	230	27,000	120	19,500	90	17,000	60	
0.7	50,000	250	24,000	120	17,000	90	15,000	60	
0.8	50,000	290	21,500	120	15,500	90	13,500	65	
0.9	49,000	320	19,000	120	13,500	90	12,000	65	
1	47,500	350	17,500	120	12,500	90	11,000	65	
1.1	43,000	340	16,000	120	11,500	90	9,900	65	
1.2	40,500	340	15,000	120	10,500	90	9,300	65	
1.3	38,000	330	14,000	120	9,900	90	8,700	65	
1.4	35,000	330	13,000	120	9,200	90	8,100	65	
1.5	32,000	320	12,500	120	8,900	90	7,900	65	
1.6	31,000	320	12,000	120	8,500	90	7,500	65	
1.7	29,000	320	11,000	120	7,900	90	7,000	65	
1.8	28,000	320	10,500	130	7,500	90	6,800	68	
1.9	26,000	320	10,000	130	7,100	90	6,300	68	
2	24,000	310	9,700	130	7,000	90	6,300	70	
2.1	23,000	330	9,300	140	6,600	90	5,900	70	
2.2	22,500	330	9,000	140	6,500	90	5,700	70	
2.3	22,000	330	8,800	150	6,400	90	5,600	70	
2.4	20,500	350	8,600	150	6,300	90	5,500	70	
2.5	20,000	350	8,200	160	6,100	90	5,300	70	
2.6	19,000	380	7,900	160	5,900	100	5,000	70	
2.7	18,000	380	7,600	160	5,700	100	4,900	70	
2.8	17,500	380	7,300	170	5,500	100	4,700	75	
2.9	17,000	380	7,100	170	5,300	100	4,500	75	
3	16,000	400	6,900	170	5,300	100	4,400	75	
3.1	15,500	410	6,700	180	5,100	100	4,300	75	
3.2	15,000	420	6,500	180	5,000	110	4,200	80	
3.3	14,500	420	6,300	190	4,800	110	4,000	80	
3.4	14,000	420	6,100	190	4,600	110	3,900	80	
3.5	14,000	420	6,000	190	4,600	120	3,800	80	
3.6	13,500	430	5,900	200	4,500	120	3,700	85	
3.7	12,500	430	5,700	200	4,400	120	3,600	85	
3.8	12,500	440	5,600	210	4,400	120	3,600	85	
3.9	12,000	440	5,500	210	4,200	125	3,500	85	
4	12,000	450	5,400	210	4,200	125	3,500	90	
4.1	11,500	480	5,300	220	4,100	125	3,400	90	
4.2	11,500	480	5,300	220	4,100	125	3,300	90	
4.3	11,000	480	5,200	230	4,000	125	3,300	90	
4.4	11,000	500	5,100	240	3,900	130	3,200	95	
4.5	10,500	500	5,100	240	3,900	130	3,200	95	
4.6	10,500	520	5,000	250	3,800	130	3,200	95	
4.7	10,500	520	5,000	260	3,800	130	3,100	95	
4.8	10,500	530	4,900	260	3,700	130	3,100	95	
4.9	10,000	530	4,900	270	3,600	130	3,100	95	
5	9,500	540	4,800	270	3,500	130	3,000	100	
5.1	9,500	540	4,700	270	3,500	130	3,000	100	
5.2	9,300	540	4,600	270	3,400	130	2,900	100	
5.3	9,200	540	4,600	270	3,400	130	2,900	100	
5.4	9,000	540	4,500	270	3,300	130	2,800	100	
5.5	8,800	540	4,400	270	3,200	130	2,700	100	
5.6	8,700	540	4,300	270	3,100	130	2,600	100	
5.7	8,500	540	4,200	270	3,100	130	2,600	100	
5.8	8,400	530	4,200	270	3,000	130	2,600	100	
5.9	8,200	530	4,100	270	2,900	130	2,500	100	
6	7,900	530	4,000	270	2,900	130	2,500	100	
6.5	7,500	530	3,700	270	2,700	130	2,300	100	
7	6,900	530	3,400	270	2,500	130	2,100	100	
7.5	6,400	530	3,200	270	2,300	130	2,000	100	
8	5,900	520	3,000	260	2,200	125	1,900	100	
8.5	5,600	520	2,800	260	2,000	125	1,700	100	
9	5,300	510	2,600	260	1,900	125	1,500	100	
9.5	5,100	510	2,500	260	1,800	125	1,400	95	
10	4,700	500	2,400	250	1,700	125	1,500	95	
11	4,400	500	2,200	250	1,600	125	1,100	95	
12	4,000	510	2,000	250	1,400	125	1,200	95	
16	3,000	400	1,500	200	1,100	115	800	80	
18	2,700	360	1,300	180	900	100	700	70	
20	2,400	300	1,200	150	800	90	600	60	
25	1,900	270	960	150	640	65	500	50	
30	1,600	230	800	130	530	50	420	40	

切深量
Depth of Cut

DC < φ1	0.1D
φ1 ≤ DC < φ3	0.3D
φ3 ≤ DC	0.5D



1. 请使用刚性较高的机床和刀柄。
2. 发生振动时请同比下降转速和进给速度。
3. 请使用适合工件材料发烟性少的切削油剂，通常推荐气冷。
4. 上表直径为参考。实际加工中请根据实际状况参考上表。

1. Use a rigid and precise machine and holder.
2. When chattering occurs, reduce the speed and feed at the same ratio.
3. Use an air blow or a suitable cutting fluid with high smoke retardant properties.
4. Refer to the table above to set the milling conditions in accordance with the actual situation.