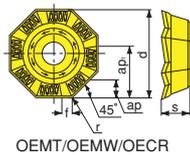


ヘリオクト(06mm切刃) チップレバートリー

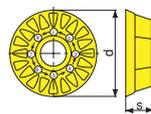


●ヘリオクト06シリーズ チップ用途表

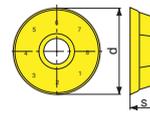
| 型番 | 特長・用途 | 切刃 | 推奨加工条件 | | | | | | | | | | | | | | | | | | | | |
|--------------|--|------|---|-----------|-----------|---------|-----------|----|-----|-----|-----|--------|------|------|------|-----|------|------|------|-----|------|------|------|
| OEMT 0604... | 汎用、一般鋼用 | | <table border="1"> <tr><th colspan="4">fz (mm/刃)</th></tr> <tr><th>ap</th><th>軽切削</th><th>中切削</th><th>重切削</th></tr> <tr><td>2.45mm</td><td>0.12</td><td>0.15</td><td>0.20</td></tr> </table> | fz (mm/刃) | | | | ap | 軽切削 | 中切削 | 重切削 | 2.45mm | 0.12 | 0.15 | 0.20 | | | | | | | | |
| fz (mm/刃) | | | | | | | | | | | | | | | | | | | | | | | |
| ap | 軽切削 | 中切削 | 重切削 | | | | | | | | | | | | | | | | | | | | |
| 2.45mm | 0.12 | 0.15 | 0.20 | | | | | | | | | | | | | | | | | | | | |
| OEMW 0604... | フラットブレイカー、断続加工用 金型材、黒皮加工用 | | <table border="1"> <tr><th colspan="4">fz (mm/刃)</th></tr> <tr><th>ap</th><th>軽切削</th><th>中切削</th><th>重切削</th></tr> <tr><td>2.45mm</td><td>0.12</td><td>0.15</td><td>0.20</td></tr> </table> | fz (mm/刃) | | | | ap | 軽切削 | 中切削 | 重切削 | 2.45mm | 0.12 | 0.15 | 0.20 | | | | | | | | |
| fz (mm/刃) | | | | | | | | | | | | | | | | | | | | | | | |
| ap | 軽切削 | 中切削 | 重切削 | | | | | | | | | | | | | | | | | | | | |
| 2.45mm | 0.12 | 0.15 | 0.20 | | | | | | | | | | | | | | | | | | | | |
| OECR 0604... | ハイレーキ、シャープエッジ ステンレス、チタン、アルミニウム用 薄物加工用 | | <table border="1"> <tr><th colspan="4">fz (mm/刃)</th></tr> <tr><th>ap</th><th>軽切削</th><th>中切削</th><th>重切削</th></tr> <tr><td>2.45mm</td><td>0.12</td><td>0.15</td><td>0.20</td></tr> </table> | fz (mm/刃) | | | | ap | 軽切削 | 中切削 | 重切削 | 2.45mm | 0.12 | 0.15 | 0.20 | | | | | | | | |
| fz (mm/刃) | | | | | | | | | | | | | | | | | | | | | | | |
| ap | 軽切削 | 中切削 | 重切削 | | | | | | | | | | | | | | | | | | | | |
| 2.45mm | 0.12 | 0.15 | 0.20 | | | | | | | | | | | | | | | | | | | | |
| REMT 1505... | 丸駒、汎用、多機能加工用 | | <table border="1"> <tr><th colspan="4">fz (mm/刃)</th></tr> <tr><th>ap</th><th>軽切削</th><th>中切削</th><th>重切削</th></tr> <tr><td>7mm</td><td>0.10</td><td>0.12</td><td>0.15</td></tr> <tr><td>5mm</td><td>0.12</td><td>0.15</td><td>0.20</td></tr> <tr><td>3mm</td><td>0.15</td><td>0.20</td><td>0.25</td></tr> </table> | fz (mm/刃) | | | | ap | 軽切削 | 中切削 | 重切削 | 7mm | 0.10 | 0.12 | 0.15 | 5mm | 0.12 | 0.15 | 0.20 | 3mm | 0.15 | 0.20 | 0.25 |
| fz (mm/刃) | | | | | | | | | | | | | | | | | | | | | | | |
| ap | 軽切削 | 中切削 | 重切削 | | | | | | | | | | | | | | | | | | | | |
| 7mm | 0.10 | 0.12 | 0.15 | | | | | | | | | | | | | | | | | | | | |
| 5mm | 0.12 | 0.15 | 0.20 | | | | | | | | | | | | | | | | | | | | |
| 3mm | 0.15 | 0.20 | 0.25 | | | | | | | | | | | | | | | | | | | | |
| REMW 1505 | 丸駒、強化刃先、断続加工用 | | <table border="1"> <tr><th colspan="4">fz (mm/刃)</th></tr> <tr><th>ap</th><th>軽切削</th><th>中切削</th><th>重切削</th></tr> <tr><td>7mm</td><td>0.10</td><td>0.12</td><td>0.15</td></tr> <tr><td>5mm</td><td>0.12</td><td>0.15</td><td>0.20</td></tr> <tr><td>3mm</td><td>0.15</td><td>0.20</td><td>0.25</td></tr> </table> | fz (mm/刃) | | | | ap | 軽切削 | 中切削 | 重切削 | 7mm | 0.10 | 0.12 | 0.15 | 5mm | 0.12 | 0.15 | 0.20 | 3mm | 0.15 | 0.20 | 0.25 |
| fz (mm/刃) | | | | | | | | | | | | | | | | | | | | | | | |
| ap | 軽切削 | 中切削 | 重切削 | | | | | | | | | | | | | | | | | | | | |
| 7mm | 0.10 | 0.12 | 0.15 | | | | | | | | | | | | | | | | | | | | |
| 5mm | 0.12 | 0.15 | 0.20 | | | | | | | | | | | | | | | | | | | | |
| 3mm | 0.15 | 0.20 | 0.25 | | | | | | | | | | | | | | | | | | | | |
| SEMT 1404 | 汎用、軽切削用 丸駒、八角形チップよりも深切込 ※E45KT/F45KTには取付不可 | | <table border="1"> <tr><th>ap (mm)</th><th>fz (mm/刃)</th></tr> <tr><td>2.0-5.5</td><td>0.12-0.20</td></tr> </table> | ap (mm) | fz (mm/刃) | 2.0-5.5 | 0.12-0.20 | | | | | | | | | | | | | | | | |
| ap (mm) | fz (mm/刃) | | | | | | | | | | | | | | | | | | | | | | |
| 2.0-5.5 | 0.12-0.20 | | | | | | | | | | | | | | | | | | | | | | |



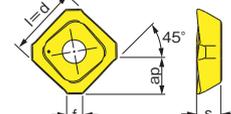
OEMT/OEMW/OECR



REMT



REMW



SEMT

OEMT/OEMW/OECR/REMT/REMW/SEMT

販売単位：10個

| 型番 | 寸法(mm) | | | | | | 在庫 | | | | | | | | | | | | |
|-------------------|--------|------|-----|------|------|-----|-----------|-------|-------|-------|-------|-------|-------|-------|-----------|--------|--------|--------|------|
| | | | | | | | PVDコーティング | | | | | | | | CVDコーティング | | | 超硬 | |
| | d | ap | ap' | s | f | r | IC328 | IC330 | IC808 | IC810 | IC830 | IC908 | IC910 | IC928 | IC950 | IC4050 | IC5100 | IC5400 | IC28 |
| OEMT 060405AER-76 | 14.27 | 2.45 | 7.4 | 4.74 | 1.60 | 0.5 | ● | ● | ● | ▲ | ● | ● | ● | ● | ● | ● | ▲ | ▲ | ● |
| OEMW 060405-AETN | 14.27 | 2.45 | 7.4 | 4.74 | 1.05 | 0.5 | | | ▲ | | | ○ | | ○ | | | | | |
| OECR 060405AER-P | 14.45 | 3.70 | — | 4.90 | 1.60 | 0.5 | | | | | ● | | | ● | | | | | ● |
| OECR 060405AER | 14.45 | 3.70 | — | 4.90 | 1.60 | 0.5 | | | ▲ | | | ● | | | | | | | |
| REMT 1505-LM-76 | 15.87 | — | — | 5.24 | — | — | ● | ▲ | | | ▲ | | | ● | ○ | | | | |
| REMW 1505 | 15.87 | — | — | 5.24 | — | — | ● | | | | | | | | | | | | |
| SEMT 140405ATR | 14.20 | 5.50 | — | 4.95 | 2.75 | — | | | ▲ | ▲ | ▲ | ▲ | | | | | | | ▲ |

※ヘリオクト06シリーズは、斜め沈み加工が可能です。

8コーナー仕様と、丸駒チップそれぞれ使用の際の斜め沈み込み角を下図に示します。

斜め沈み加工

| ホルダー | ヘリオクトチップ | | 丸駒チップ | |
|--------------------|-----------------------|-------------|-----------------------|-------------|
| | OEMT 060405AER-76 | | REMT 1505-LM-76 | |
| | $\alpha^{\circ} \max$ | ap max (mm) | $\alpha^{\circ} \max$ | ap max (mm) |
| E45KT-D32-C32-R06 | 7.5° | 5.0 | 10.0° | 5.0 |
| E45KT-D40-C32-R06 | 6.0° | 4.7 | 7.6° | 4.7 |
| E45KT-D50-C32-R06 | 4.2° | 4.5 | 5.7° | 4.5 |
| F45KT-D50-22-R06 | 4.2° | 7.0 | 5.7° | 7.5 |
| F45KT-D63-R06...J | 3.2° | 7.0 | 4.0° | 7.5 |
| F45KT-D80-R06...J | 2.5° | 7.0 | 2.9° | 7.5 |
| F45KT-D100-R06...J | 1.9° | 6.0 | 2.2° | 7.5 |
| F45KT-D125-R06...J | 1.4° | 6.0 | 1.6° | 7.5 |

テスト条件 Vc=100m/min
Fz=0.12~0.15mm/刃
ワーク 炭素鋼

