
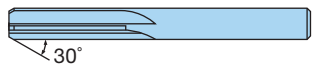

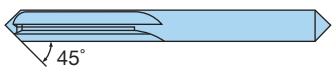

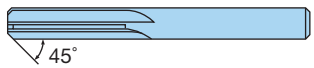

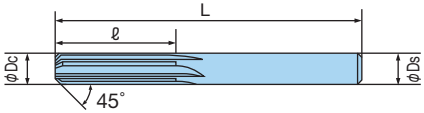




特に厳選された超硬を使用

切味、精度、面粗度、剛性において、他社の追隨を許しません。

寸法表

呼び番号	Dc	L	ℓ	Ds	
MRS0050	0.50	50	15	1.0	 
MRS0051~0099	0.51~0.99	50	15	1.0	
MRS0100	1.00	50	25	1.0	
MRS0101~0149	1.01~1.49	50	25	1.5	
MRS0150	1.50	50	25	1.5	
MRS0151~0199	1.51~1.99	50	25	2.0	
MRS0200	2.00	50	25	2.0	 
MRS0201~0249	2.01~2.49	50	25	2.5	
MRS0250	2.50	70	30	2.5	
MRS0251~0299	2.51~2.99	70	30	3.0	
MRS0300	3.00	70	30	3.0	
MRS0301~0349	3.01~3.49	70	30	3.5	
MRS0350	3.50	80	35	3.5	 
MRS0351~0399	3.51~3.99	80	35	4.0	
MRS0400	4.00	80	35	4.0	
MRS0401~0449	4.01~4.49	80	35	4.5	
MRS0450	4.50	80	35	4.5	
MRS0451~0499	4.51~4.99	80	35	5.0	
MRS0500	5.00	90	35	5.0	 
MRS0501~0509	5.01~5.09	90	35	5.5	
MRS0510~0549	5.10~5.49	100	35	5.5	
MRS0550	5.50	100	35	5.5	
MRS0551~0599	5.51~5.99	100	35	6.0	
MRS0600	6.00	100	40	6.0	
MRS0601~0649	6.01~6.49	100	40	7.0	
MRS0650	6.50	100	40	7.0	
MRS0651~0699	6.51~6.99	100	40	7.0	
MRS0700	7.00	100	40	7.0	
MRS0701~0749	7.01~7.49	100	40	8.0	
MRS0750	7.50	100	40	8.0	
MRS0751~0799	7.51~7.99	100	40	8.0	
MRS0800	8.00	100	40	8.0	
MRS0801~0849	8.01~8.49	100	40	9.0	
MRS0850	8.50	100	40	9.0	
MRS0851~0899	8.51~8.99	100	40	9.0	
MRS0900	9.00	100	40	9.0	
MRS0901~0949	9.01~9.49	100	40	10.0	
MRS0950	9.50	100	40	10.0	
MRS0951~0999	9.51~9.99	100	40	10.0	
MRS1000	10.00	100	40	10.0	

刃径(Dc)の許容差

外径	許容差 m5
3以下	+0.006 +0.002
3を越え6以下	+0.009 +0.004
6を越え10以下	+0.012 +0.006

推奨切削条件

被削材	切削速度 Vc (m/min)	送り量 f(mm/rev)				
		φ0.5~φ1.0	φ1.0~φ2.0	φ2.0~φ3.0	φ3.0~φ6.0	φ6.0~φ10.0
鋳鉄	5~15	0.005~0.02	0.008~0.02	0.010~0.10	0.030~0.20	0.10~0.40
アルミ合金	5~25	0.010~0.08	0.020~0.10	0.050~0.15	0.060~0.20	0.10~0.40
炭素	5~20	0.002~0.01	0.005~0.02	0.01~0.08	0.02~0.20	0.05~0.40
合金鋼	3~20	0.001~0.005	0.003~0.01	0.005~0.03	0.01~0.15	0.05~0.30
特殊鋼	2~7	0.002~0.01	0.008~0.02	0.01~0.04	0.02~0.15	0.05~0.20
リーマ取代(mm/加工径)		0.05~0.10	0.05~0.15	0.10~0.20	0.10~0.30	0.20~0.30