

High Feed Milling - CALP 高進給銑刀

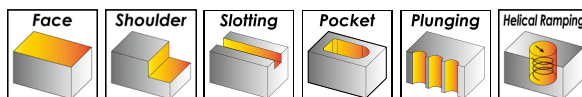
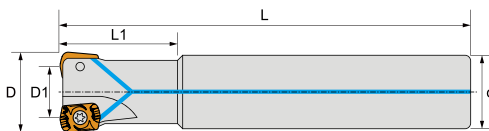
CALP Series



- Use LPGX inserts with 2 cutting edges.
- High feed and small size cutter for replacing solid carbide tools.
- 8~16mm cutter diameter, max. 0.5mm depth of cut.
- 使用 LPGX 銑刀片，2 個可用切削角
- 高進給及小尺寸刀具可取代全鎢鋼刀具，適用於廣泛的加工及材質應用
- 8~16mm 刀桿直徑，最大切削深度可達 0.5mm

Indexable Milling

CALPE - Milling Tools 高進給銑刀



Insert Brand 建議刀片 : Winstar, Kyocera, ...

Order No. 訂購編碼	D	D1	L1	L	d	T	Coolant Hole	Inserts	Screw	Wrench	Stock
ICALPE101008080	8	4.2	16	80	10	1		LPGX0102	IMS1804A	ITK06	●
ICALPE101008081	8	4.2	16	80	10	1	✓				●
ICALPE102010080	10	6.2	20	80	10	2					●
ICALPE102010081	10	6.2	20	80	10	2	✓				●
ICALPE103012080	12	8.2	20	80	12	3					●
ICALPE103012081	12	8.2	20	80	12	3	✓				●
ICALPE104016090	16	12.2	20	90	16	4					●
ICALPE104016091	16	12.2	20	90	16	4	✓				●

● stock ○ by inquiry

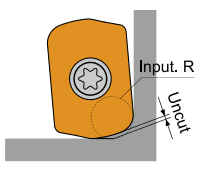
Customize available.

Recommended Cutting Conditions 建議切削數據

Working Material	Vc	fz	ap
Carbon Steel / Alloy Steel	120 ~ 250	0.2 ~ 0.8	0.2 ~ 0.5
Stainless Steel	100 ~ 180	0.2 ~ 0.6	0.2 ~ 0.4
Cast Iron	120 ~ 250	0.2 ~ 0.8	0.2 ~ 0.5
High Temperature Alloy	40 ~ 100	0.2 ~ 0.4	0.2 ~ 0.3
Hardened Steel	50 ~ 100	0.2 ~ 0.5	0.2 ~ 0.3

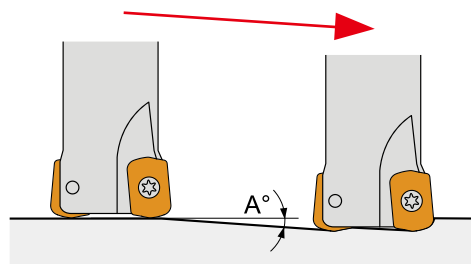
Corner R Programming R角軟體模擬設定

Designation	Approx. R (mm)	
	Input. R	Uncut
LPGX0102	1.2	0.17



For Ramping 斜坡加工

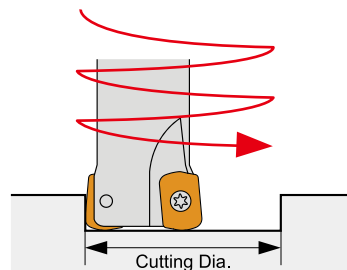
Cutter Dia. (mm)	Max. ramping angle (A°)	tan (A°)
10	3.0°	0.052
11	2.5°	0.044
12	2.0°	0.035
16	1.2°	0.021
17	1.0°	0.017



For Helical Milling 螺旋加工

Mini Cutting Dia.	Max Cutting Dia.
2 × Cutter Dia. - 3.5	2 × Cutter Dia. - 2

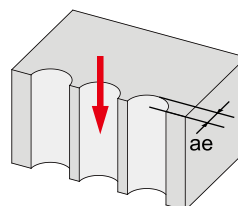
※Do not exceed the Max Cutting Dia and lower than the Mini Cutting Dia.



For Plunging 垂直加工

Max. ae
1.7mm

※Reduce feed rate to fz=0.2mm/t or less.



Insert Specifications 刀片規格

Insert	Dimensions (mm)					
	A	B	S	r	d1	
LPGX0102	6.26	4.19	2.19	1.0	2.2	

※ Suitable for M2.0 or M1.8 screw.

Indexable Milling

Insert Designation 刀片型號

Insert	Order No. 訂購編碼	Designation	Working Material					
			P	M	K	N	S	H
	ILPGX0102SG33TX	LPGX0102-SG-CX33TX	●	●	●		●	●
	ILPGX0102SG43TX	LPGX0102-SG-CX43TX	●	●	●		●	
	ILPGX0102MG33TX	LPGX0102-MG-CX33TX	●	●	●		●	●
	ILPGX0102MG43TX	LPGX0102-MG-CX43TX	●	●	●		●	