切削條件表 P347-348
Cutting Condition

Ball Nose Type - For Copper & Aluminum - 2 flutes

■ 2刃銅鋁合金球型立銑刀

600 Nano

25°

● Micro Grain Carbide

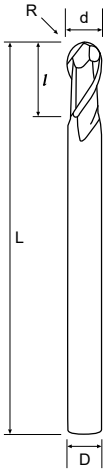
● WC=90 Co=10 HV30=1571 Rupture=3750N/mm^2 Grain Size=0.6μm



MODE	Diameter	Radius	Flute Length	Full Length	Shank Diameter	Flutes
型號	d 刃徑	R 值	l 刃長	L 全長	D 柄徑	Z 刃數
ACB0102	1	0.5	2	50	4	2
ACB0152	1.5	0.75	3	50	4	2
ACB0202	2	1	4	50	4	2
ACB0252	2.5	1.25	5	50	4	2
ACB0302	3	1.5	6	50	4	2
ACB0352	3.5	1.75	7	50	4	2
ACB0402	4	2	8	50	4	2
ACB0452	4.5	2.25	9	50	6	2
ACB0502	5	2.5	10	50	6	2
ACB0552	5.5	2.75	11	50	6	2
ACB0602	6	3	12	50	6	2
ACB0802	8	4	16	60	8	2
ACB1002	10	5	20	75	10	2
ACB1202	12	6	24	75	12	2

• Tolerance for Ball radius : ±0.01mm R容許差





Application 適用材質：

★ Perfect 最推薦 ◎ Excellent 適合 ○ Good 佳

carbon steel, Alloy steel 炭素鋼 ,合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC			
							◎	◎

Unit/單位: mm

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Cutting Condition

Ball Nose Type - For Copper & Aluminum - 2 flutes

■ 2刃銅鋁合金球型立銑刀

600 Nano | 25° | TB

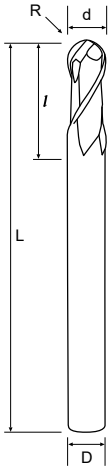
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