

600⁺ 切削條件表 **P349**
Cutting Condition

Ball Nose Type - 2 flutes

■ 2刃球型立銑刀

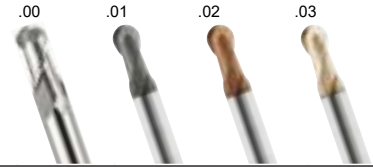
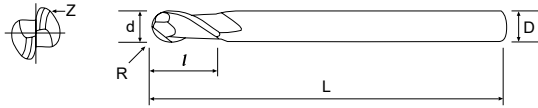
600 PLUS

HRC > 45

35°

a/b
b>a

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm

Dimension 規格						Purchase Code 採購代碼				
Diameter	Radius	Flute Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層			
d 刃徑	R 值	刀長	L 全長	D 柄徑	Z 刃數	型號		ALTBN	TiSiN	ZrN-A
1	0.5	2	50	3	2	P-SSB0102	.00	.01	.02	.03
1	0.5	2	50	4	2	P-MSB0102	.00	.01	.02	.03
1.5	0.75	3	50	3	2	P-SSB0152	.00	.01	.02	.03
1.5	0.75	3	50	4	2	P-MSB0152	.00	.01	.02	.03
2	1	4	50	3	2	P-SSB0202	.00	.01	.02	.03
2	1	4	50	4	2	P-MSB0202	.00	.01	.02	.03
2.5	1.25	5	50	3	2	P-SSB0252	.00	.01	.02	.03
2.5	1.25	5	50	4	2	P-MSB0252	.00	.01	.02	.03
3	1.5	6	50	3	2	P-SSB0302	.00	.01	.02	.03
3	1.5	6	50	4	2	P-MSB0302	.00	.01	.02	.03
3.5	1.75	7	50	4	2	P-MSB0352	.00	.01	.02	.03
4	2	8	50	4	2	P-MSB0402	.00	.01	.02	.03
1	0.5	2	50	6	2	P-SB0102	.00	.01	.02	.03
1.5	0.75	3	50	6	2	P-SB0152	.00	.01	.02	.03
2	1	4	50	6	2	P-SB0202	.00	.01	.02	.03
2.5	1.25	5	50	6	2	P-SB0252	.00	.01	.02	.03
3	1.5	6	50	6	2	P-SB0302	.00	.01	.02	.03
3.5	1.75	7	50	6	2	P-SB0352	.00	.01	.02	.03
4	2	8	50	6	2	P-SB0402	.00	.01	.02	.03
4.5	2.25	9	50	6	2	P-SB0452	.00	.01	.02	.03
5	2.5	10	50	6	2	P-SB0502	.00	.01	.02	.03
5.5	2.75	11	50	6	2	P-SB0552	.00	.01	.02	.03
6	3	12	50	6	2	P-SB0602	.00	.01	.02	.03
7	3.5	14	60	8	2	P-SB0702	.00	.01	.02	.03
8	4	16	60	8	2	P-SB0802	.00	.01	.02	.03
9	4.5	18	75	10	2	P-SB0902	.00	.01	.02	.03
10	5	20	75	10	2	P-SB1002	.00	.01	.02	.03
11	5.5	22	75	12	2	P-SB1102	.00	.01	.02	.03
12	6	24	75	12	2	P-SB1202	.00	.01	.02	.03
14	7	28	100	16	2	P-SB1402	.00	.01	.02	.03
16	8	32	100	16	2	P-SB1602	.00	.01	.02	.03
18	9	36	100	20	2	P-SB1802	.00	.01	.02	.03
20	10	40	100	20	2	P-SB2002	.00	.01	.02	.03

R High precision radius accuracy request is available
±0.003 高精度R值可訂製

Application 適用材質：

★ Perfect 最推薦

◎ Excellent 適合

○ Good 佳

Coating 塗層	Carbon steel, Alloy steel 炭素鋼, 合金鋼	Pre-hardened steel 預硬鋼 ~45HRC	High-hardened 高硬度鋼				Stainless steel 不銹鋼	Titanium alloy 鈦合金	Nickel/Inconel alloy 鎳基合金	Copper alloy 銅合金, 銅	Aluminum alloy 鋁合金
	○	○	~50HRC	~55HRC	~60HRC	~65HRC				○	○
ALTBN	◎	◎	◎	○			○				
TISIN	○	○	○	◎							
ZrN-A	◎	◎	◎	○			◎	○	○		

Unit/單位: mm