

**600<sup>+</sup>** 切削條件表 P347-348  
Cutting Condition

## Miniature Ball Nose Type - 2 flutes

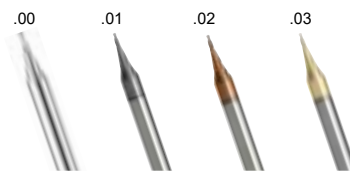
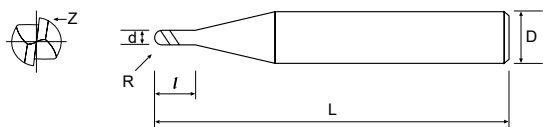
## ■ 2刃微小徑球型立銑刀

600  
PLUSHRC  
40

35°

a  
b  
b>a

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm<sup>2</sup> Grain Size=0.6μmHRC  
40HRC  
45HRC  
50HRC  
55HRC  
60HRC  
65HRC  
70HRC  
75HRC  
80HRC  
85HRC  
90HRC  
95HRC  
100HRC  
105HRC  
110HRC  
115HRC  
120HRC  
125HRC  
130HRC  
135HRC  
140HRC  
145HRC  
150HRC  
155HRC  
160

| Dimension 規格 |        |              |             |                |        | Purchase Code 採購代碼 |            |       |       |       |
|--------------|--------|--------------|-------------|----------------|--------|--------------------|------------|-------|-------|-------|
| Diameter     | Radius | Flute Length | Full Length | Shank Diameter | Flutes | MODE               | Coating 塗層 |       |       |       |
| d 刀徑         | R 值    | 刀長           | L 全長        | D 柄徑           | Z 刃數   | 型號                 |            | ALTBN | TISIN | ZrN-A |
| 0.3          | 0.15   | 0.6          | 50          | 4              | 2      | P-MIB0032          | .00        | .01   | .02   | .03   |
| 0.4          | 0.2    | 0.8          | 50          | 4              | 2      | P-MIB0042          | .00        | .01   | .02   | .03   |
| 0.5          | 0.25   | 1            | 50          | 4              | 2      | P-MIB0052          | .00        | .01   | .02   | .03   |
| 0.6          | 0.3    | 1.2          | 50          | 4              | 2      | P-MIB0062          | .00        | .01   | .02   | .03   |
| 0.7          | 0.35   | 1.4          | 50          | 4              | 2      | P-MIB0072          | .00        | .01   | .02   | .03   |
| 0.8          | 0.4    | 1.6          | 50          | 4              | 2      | P-MIB0082          | .00        | .01   | .02   | .03   |
| 0.9          | 0.45   | 1.8          | 50          | 4              | 2      | P-MIB0092          | .00        | .01   | .02   | .03   |
| 1            | 0.5    | 2            | 50          | 4              | 2      | P-MIB0102          | .00        | .01   | .02   | .03   |
| 1.1          | 0.55   | 2.2          | 50          | 4              | 2      | P-MIB0112          | .00        | .01   | .02   | .03   |
| 1.2          | 0.6    | 2.4          | 50          | 4              | 2      | P-MIB0122          | .00        | .01   | .02   | .03   |
| 1.3          | 0.65   | 2.6          | 50          | 4              | 2      | P-MIB0132          | .00        | .01   | .02   | .03   |
| 1.4          | 0.7    | 2.8          | 50          | 4              | 2      | P-MIB0142          | .00        | .01   | .02   | .03   |
| 1.5          | 0.75   | 3            | 50          | 4              | 2      | P-MIB0152          | .00        | .01   | .02   | .03   |
| 1.6          | 0.8    | 3.2          | 50          | 4              | 2      | P-MIB0162          | .00        | .01   | .02   | .03   |
| 1.7          | 0.85   | 3.4          | 50          | 4              | 2      | P-MIB0172          | .00        | .01   | .02   | .03   |
| 1.8          | 0.9    | 3.6          | 50          | 4              | 2      | P-MIB0182          | .00        | .01   | .02   | .03   |
| 1.9          | 0.95   | 3.8          | 50          | 4              | 2      | P-MIB0192          | .00        | .01   | .02   | .03   |
| 2            | 1      | 4            | 50          | 4              | 2      | P-MIB0202          | .00        | .01   | .02   | .03   |
| 2.1          | 1.05   | 4.2          | 50          | 4              | 2      | P-MIB0212          | .00        | .01   | .02   | .03   |
| 2.2          | 1.1    | 4.4          | 50          | 4              | 2      | P-MIB0222          | .00        | .01   | .02   | .03   |
| 2.3          | 1.15   | 4.6          | 50          | 4              | 2      | P-MIB0232          | .00        | .01   | .02   | .03   |
| 2.4          | 1.2    | 4.8          | 50          | 4              | 2      | P-MIB0242          | .00        | .01   | .02   | .03   |
| 2.5          | 1.25   | 5            | 50          | 4              | 2      | P-MIB0252          | .00        | .01   | .02   | .03   |
| 2.6          | 1.3    | 5.2          | 50          | 4              | 2      | P-MIB0262          | .00        | .01   | .02   | .03   |
| 2.7          | 1.35   | 5.4          | 50          | 4              | 2      | P-MIB0272          | .00        | .01   | .02   | .03   |
| 2.8          | 1.4    | 5.6          | 50          | 4              | 2      | P-MIB0282          | .00        | .01   | .02   | .03   |
| 2.9          | 1.45   | 5.8          | 50          | 4              | 2      | P-MIB0292          | .00        | .01   | .02   | .03   |
| 3            | 1.5    | 6            | 50          | 4              | 2      | P-MIB0302          | .00        | .01   | .02   | .03   |

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 | 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 |
|------------|------------------------------------|------------------------|--------------------|--------|--------|--------|---|---------------------|--------------------|---------------------------|---------------------|--------------------|
|            |                                    | ~45HRC                 | ~50HRC             | ~55HRC | ~60HRC | ~65HRC |   |                     |                    |                           |                     |                    |
|            | ○                                  | ○                      |                    |        |        |        |   |                     |                    |                           | ○                   | ○                  |
| ALTBN      | ◎                                  | ◎                      | ◎                  | ○      |        |        | ○ |                     |                    |                           |                     |                    |
| TISIN      | ○                                  | ○                      | ○                  | ◎      |        |        |   |                     |                    |                           |                     |                    |
| ZrN-A      | ◎                                  | ◎                      | ◎                  | ○      |        |        | ◎ | ○                   | ○                  | ○                         |                     |                    |

Unit/單位: mm