

產品規格表 **P68**
Specification page

● P-PBTA 2 Flutes Standard Cutting Conditons 標準切削

Working material hardness 被切削材硬度	HRC45~52		HRC52~ 55	
	Rotational speed 轉速	Feeding speed 進給	Rotational speed 轉速	Feeding speed 進給
	RPM 轉/分	mm/min mm/分	RPM 轉/分	mm/min mm/分
PBTA0101T	8800	260	7920	234
PBTA0151T	6900	190	4950	171
PBTA0201T	5600	420	5040	378
PBTA0205T	5600	420	4320	378
PBTA0301T	7200	380	6480	342
PBTA0305T	7200	380	6480	342
PBTA0401T	7200	380	6480	342
PBTA0405T	5400	300	4860	270
PBTA0605T	9728	1280	7040	768
PBTA0603T	9728	1216	6400	704
PBTA0805T	5120	1536	3200	832
PBTA0803T	5120	1152	2048	640

產品規格表 **P69-70**
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● P-TBTA 2 Flutes Standard Cutting Conditons 標準切削

WORK MATERIAL 被切削材	Carbon Steels S50C 碳素鋼		Alloy Steels Prehardened Steels SCM SKD HPM NAK 合金鋼、調質鋼		Hardened Steels SKD61~HRC50 調質鋼		Aluminum 鋁		Copper 銅	
Cutting Speed 切削速度	150m/min		120~150m/min		80~100m/min		150~m/min		100~150m/min	
Shank 柄徑(mm)	SPEED (min ⁻¹) 迴轉速	Feed Rate (mm/min) 進給速度	SPEED (min ⁻¹) 迴轉速	Feed Rate (mm/min) 進給速度	SPEED (min ⁻¹) 迴轉速	Feed Rate (mm/min) 進給速度	SPEED (min ⁻¹) 迴轉速	Feed Rate (mm/min) 進給速度	SPEED (min ⁻¹) 迴轉速	Feed Rate (mm/min) 進給速度
4	12,000	930	10,000	570	7,200	450	24,000	2,400	12,000	1,200
6	8,000	930	6,400	540	4,800	450	16,000	2,400	8,000	1,200
8	6,000	900	4,800	540	3,600	450	12,000	2,400	6,000	1,200
10	4,800	900	3,800	540	2,900	450	9,600	2,300	4,800	1,150

DEPTH OF CUT 加工深度	0.1XR (~45HRC) ~0.08XR (~50HRC)	(R0.1~0.5=0.2XR) 0.3XR	~0.16XR R ₃ ≤0.3 (~45HRC) ~0.25XR R ₃ ≤3 (~45HRC) ~0.17XR R ₃ ≥4 (~45HRC) ~0.05XR (~50HRC)
			