

600⁺ 切削條件表 **P352**
Cutting Condition

Taper Ball Nose Type - 2 flutes

■ 2刃斜度球型立銑刀

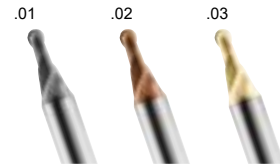
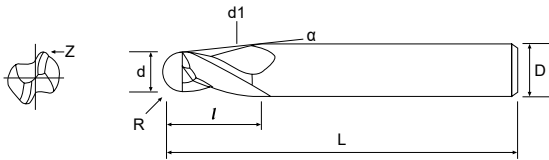
600 PLUS

HRC 55

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	d1		Flutes	MODE	Coating 塗層		
d 刃徑	R 值	刃長	L 全長	D 柄徑	大徑	α	Z 刃數	型號	ALTBN	TISIN	ZrN-A
1	0.5	10	50	4	1.17	30°	2	P-TBTA050005	.01	.02	.03
1	0.5	10	50	4	1.35	1°	2	P-TBTA050010	.01	.02	.03
1	0.5	10	50	4	1.52	1°30'	2	P-TBTA050015	.01	.02	.03
1	0.5	10	50	4	1.7	2°	2	P-TBTA050020	.01	.02	.03
1	0.5	10	50	4	1.87	3°	2	P-TBTA050030	.01	.02	.03
1	0.5	10	50	4	2.05	4°	2	P-TBTA050040	.01	.02	.03
1	0.5	10	50	4	2.74	5°	2	P-TBTA050050	.01	.02	.03
1	0.5	10	50	4	3.44	7°	2	P-TBTA050070	.01	.02	.03
1	0.5	10	50	4	4.51	10°	2	P-TBTA050100	.01	.02	.03
1.5	0.75	10	50	4	1.67	30°	2	P-TBTA075005	.01	.02	.03
1.5	0.75	10	50	4	1.85	1°	2	P-TBTA075010	.01	.02	.03
1.5	0.75	10	50	4	2.02	1°30'	2	P-TBTA075015	.01	.02	.03
1.5	0.75	10	50	4	2.2	2°	2	P-TBTA075020	.01	.02	.03
1.5	0.75	10	50	4	2.37	3°	2	P-TBTA075030	.01	.02	.03
1.5	0.75	10	50	4	2.55	4°	2	P-TBTA075040	.01	.02	.03
1.5	0.75	10	50	4	3.24	5°	2	P-TBTA075050	.01	.02	.03
1.5	0.75	10	50	4	3.94	7°	2	P-TBTA075070	.01	.02	.03
1.5	0.75	10	50	6	5.02	10°	2	P-TBTA075100	.01	.02	.03
2	1	13	50	4	2.22	30°	2	P-TBTA100005	.01	.02	.03
2	1	13	50	4	2.45	1°	2	P-TBTA100010	.01	.02	.03
2	1	13	50	4	2.68	1°30'	2	P-TBTA100015	.01	.02	.03
2	1	13	50	4	3.9	2°	2	P-TBTA100020	.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 不鏽鋼	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

600⁺ 切削條件表 **P352**
Cutting Condition

Taper Ball Nose Type - 2 flutes

■ 2刃斜度球型立銑刀

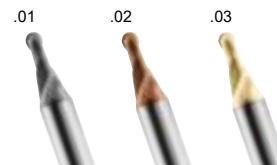
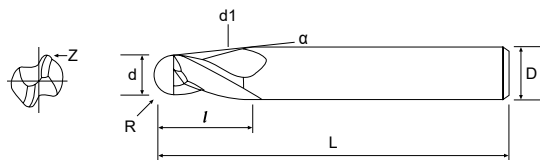
600 PLUS

HRC 55

35°

a
b > a

● Micro Grain Carbide

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

HRC 40

HRC 45

HRC 50

HRC 55

HRC 60

HRC 65

HRC 70

HRC 75

HRC 80

HRC 85

HRC 90

HRC 95

HRC 100

HRC 105

HRC 110

HRC 115

HRC 120

HRC 125

HRC 130

HRC 135

HRC 140

HRC 145

HRC 150

HRC 155

HRC 160

Dimension 規格

Purchase Code 採購代碼

Diameter	Radius	Flute Length	Full Length	Shank Diameter	d1		Flutes	MODE	Coating 塗層		
d 刃徑	R 值	刃長	L 全長	D 柄徑	大徑	α	Z 刃數	型號	ALTiBN	TiSiN	ZrN-A
2	1	13	50	4	3.13	3°	2	P-TBTA100030	.01	.02	.03
2	1	13	50	4	3.36	4°	2	P-TBTA100040	.01	.02	.03
2	1	13	50	6	4.27	5°	2	P-TBTA100050	.01	.02	.03
2	1	13	50	6	5.17	7°	2	P-TBTA100070	.01	.02	.03
2	1	13	60	8	6.56	10°	2	P-TBTA100100	.01	.02	.03
2.5	1.25	15	50	4	2.76	30°	2	P-TBTA125005	.01	.02	.03
2.5	1.25	15	50	4	3.03	1°	2	P-TBTA125010	.01	.02	.03
2.5	1.25	15	50	4	3.29	1°30'	2	P-TBTA125015	.01	.02	.03
2.5	1.25	15	50	4	3.56	2°	2	P-TBTA125020	.01	.02	.03
2.5	1.25	15	50	4	3.81	3°	2	P-TBTA125030	.01	.02	.03
2.5	1.25	15	50	6	4.07	4°	2	P-TBTA125040	.01	.02	.03
2.5	1.25	15	50	6	5.13	5°	2	P-TBTA125050	.01	.02	.03
2.5	1.25	15	60	6	6.17	7°	2	P-TBTA125070	.01	.02	.03
2.5	1.25	15	60	8	7.77	10°	2	P-TBTA125100	.01	.02	.03
3	1.5	20	50	4	3.34	30°	2	P-TBTA150005	.01	.02	.03
3	1.5	20	50	4	3.6	1°	2	P-TBTA150010	.01	.02	.03
3	1.5	20	60	6	4.04	1°30'	2	P-TBTA150015	.01	.02	.03
3	1.5	20	60	6	4.39	2°	2	P-TBTA150020	.01	.02	.03
3	1.5	20	60	6	5.08	3°	2	P-TBTA150030	.01	.02	.03
3	1.5	20	60	6	5.78	4°	2	P-TBTA150040	.01	.02	.03
3	1.5	20	60	8	6.48	5°	2	P-TBTA150050	.01	.02	.03
3	1.5	20	60	8	7.9	7°	2	P-TBTA150070	.01	.02	.03
3	1.5	20	75	10	10.04	10°	2	P-TBTA150100	.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 不鏽鋼	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						
ALTiBN	◎	◎	○	○				○				
TiSiN	○	○	○	○								
ZrN-A	◎	◎	○	○				◎	○	○		

Unit/單位: mm