

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

## Ball Nose Type - Long Shank - 2 flutes

### 2刃長柄球型立銑刀

600 PLUS

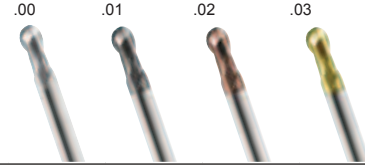
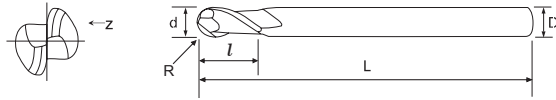
HRC > 45

35°

$a_1$   
 $b > a$

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm<sup>2</sup> 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 刀徑	R 值	Z 刃長	L 全長	D 柄徑	Z 刃數	型號		ALTiBN	TiSiN	ZrN-A
1	0.5	2	75	6	2	P-SLB0102	.00	.01	.02	.03
1	0.5	2	100	6	2	P-MLB0102	.00	.01	.02	.03
1.5	0.75	3	75	6	2	P-SLB0152	.00	.01	.02	.03
1.5	0.75	3	100	6	2	P-MLB0152	.00	.01	.02	.03
2	1	4	75	6	2	P-SLB0202	.00	.01	.02	.03
2	1	4	100	6	2	P-MLB0202	.00	.01	.02	.03
2.5	1.25	5	75	6	2	P-SLB0252	.00	.01	.02	.03
2.5	1.25	5	100	6	2	P-MLB0252	.00	.01	.02	.03
3	1.5	6	75	6	2	P-SLB0302	.00	.01	.02	.03
3	1.5	6	100	6	2	P-MLB0302	.00	.01	.02	.03
3.5	1.75	7	100	6	2	P-MLB0352	.00	.01	.02	.03
4	2	8	75	6	2	P-SLB0402	.00	.01	.02	.03
4	2	8	100	6	2	P-MLB0402	.00	.01	.02	.03
5	2.5	10	75	6	2	P-SLB0502	.00	.01	.02	.03
5	2.5	10	100	6	2	P-MLB0502	.00	.01	.02	.03
6	3	12	75	6	2	P-SLB0602	.00	.01	.02	.03
6	3	12	100	6	2	P-MLB0602	.00	.01	.02	.03
6	3	12	150	6	2	P-LLB0602	.00	.01	.02	.03
8	4	16	75	8	2	P-SLB0802	.00	.01	.02	.03
8	4	16	100	8	2	P-MLB0802	.00	.01	.02	.03
8	4	16	150	8	2	P-LLB0802	.00	.01	.02	.03
10	5	20	100	10	2	P-MLB1002	.00	.01	.02	.03
10	5	20	150	10	2	P-LLB1002	.00	.01	.02	.03
10	5	20	200	10	2	P-XLB1002	.00	.01	.02	.03
12	6	24	100	12	2	P-MLB1202	.00	.01	.02	.03
12	6	24	150	12	2	P-LLB1202	.00	.01	.02	.03
12	6	24	200	12	2	P-XLB1202	.00	.01	.02	.03
16	8	32	150	16	2	P-LLB1602	.00	.01	.02	.03
16	8	32	200	16	2	P-XLB1602	.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-harden 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