

600⁺ 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 PLUS

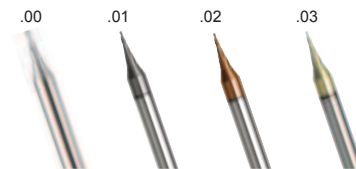
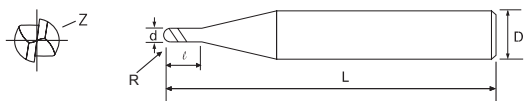
HRC > 40

35°

a_1
 $b > a$

● 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



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
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