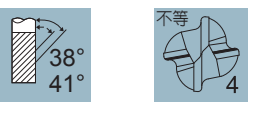


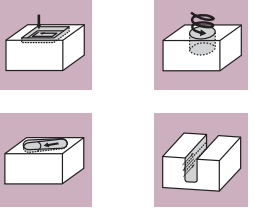
B274HX 極超微粒鎢鋼塗層多用途R角立銑刀

Multipurpose End Mills With Corner Radius

UMG Carbide **AlTiCrN HX**



Type of Operation



Work Material

P	H	M	K	N	S
●	●	●	●	●	●

P 鋼鐵 Steel

H 硬化鋼 <38HRC Hardened Steel

H 硬化鋼 <48HRC Hardened Steel

H 硬化鋼 <56HRC Hardened Steel

M 不銹鋼 Stainless Steel

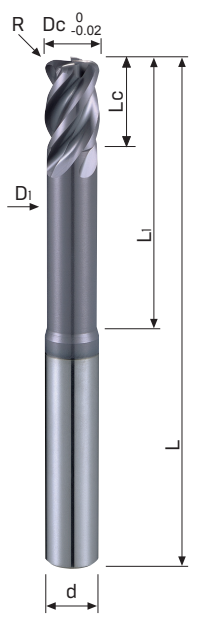
K 鑄鐵 Cast Iron

S 鈦合金 Titanium

S 鎳 Nickel

S 高溫合金 High Temp Alloys

Feature of product:
 4刃多用途短刃長頸R角立銑刀
 採用UMG極超微粒碳化鎢鋼材料，更加耐磨。
 採不等螺旋、不等分割設計，有效抑制振動。
 大排屑溝使其排屑順暢，可應對各式材料。
 刀尖部R角設計並搭配AlTiCrN奈米多層膜塗層，有效提升刀具壽命。
 段差設計增加有效深度。
 適用於多種類材料切削加工。



Code No. B274HX-Dc×R

Dc 0 -0.02	R ±0.01	Lc mm	L mm	d h6	L1 mm	D1 mm	AlTiCrN B274HX
1	0.1	1.5	60	6	5	0.95	●
1	0.2	1.5	60	6	5	0.95	●
1.5	0.1	2.3	60	6	7.5	1.45	●
1.5	0.2	2.3	60	6	7.5	1.45	●
2	0.1	3	60	6	10	1.95	●
2	0.2	3	60	6	10	1.95	●
2	0.5	3	60	6	10	1.95	●
2.5	0.1	3.8	60	6	12.5	2.4	●
2.5	0.2	3.8	60	6	12.5	2.4	●
2.5	0.5	3.8	60	6	12.5	2.4	●
3	0.1	4.5	70	6	15	2.8	●
3	0.2	4.5	70	6	15	2.8	●
3	0.5	4.5	70	6	15	2.8	●
4	0.1	6	70	6	20	3.7	●
4	0.2	6	70	6	20	3.7	●
4	0.5	6	70	6	20	3.7	●
4	1	6	70	6	20	3.7	●
5	0.2	7.5	70	6	25	4.6	●
5	0.5	7.5	70	6	25	4.6	●
5	1	7.5	70	6	25	4.6	●
6	0.2	9	70	6	30	5.5	●
6	0.3	9	70	6	30	5.5	●
6	0.5	9	70	6	30	5.5	●
6	1	9	70	6	30	5.5	●
6	1.5	9	70	6	30	5.5	●
6	2	9	70	6	30	5.5	●
8	0.2	12	80	8	40	7.4	●
8	0.3	12	80	8	40	7.4	●
8	0.5	12	80	8	40	7.4	●
8	1	12	80	8	40	7.4	●
8	1.5	12	80	8	40	7.4	●
8	2	12	80	8	40	7.4	●
8	3	12	80	8	40	7.4	●
10	0.2	15	95	10	50	9.2	●
10	0.3	15	95	10	50	9.2	●
10	0.5	15	95	10	50	9.2	●
10	1	15	95	10	50	9.2	●
10	1.5	15	95	10	50	9.2	●
10	2	15	95	10	50	9.2	●
10	3	15	95	10	50	9.2	●
12	0.2	18	110	12	60	11	●
12	0.3	18	110	12	60	11	●
12	0.5	18	110	12	60	11	●
12	1	18	110	12	60	11	●
12	1.5	18	110	12	60	11	●
12	2	18	110	12	60	11	●
12	3	18	110	12	60	11	●
16	0.5	24	140	16	80	14.5	●
16	1	24	140	16	80	14.5	●
16	1.5	24	140	16	80	14.5	●
16	2	24	140	16	80	14.5	●
16	3	24	140	16	80	14.5	●
20	0.5	30	160	20	100	18.2	●
20	1	30	160	20	100	18.2	●
20	1.5	30	160	20	100	18.2	●
20	2	30	160	20	100	18.2	●
20	3	30	160	20	100	18.2	●
20	5	30	160	20	100	18.2	●

B274HX 切削條件參考表

Recommended Milling Conditions

Side Milling 側面切削

被削材 Work Material		GR.1 碳鋼 Carbon Steel		GR.2 低合金鋼 Low-alloyed Steel (~24HRC)		GR.3 高合金鋼 Hi-alloyed Steel (~30HRC)		GR.4 硬化鋼 Hardened Steel (30~38HRC)		GR.5 硬化鋼 Hardened Steel (38~48HRC)		GR.6 硬化鋼 Hardened Steel (48~56HRC)		GR.8 不銹鋼 Stainless Steel		GR.9 鑄鐵 Cast Iron		GR.15 鈦合金 Titanium	
切削速度 Vc m/min		Ø1.0~2.5 60~80 Ø3.0~20 80~85		Ø1.0~2.5 60~80 Ø3.0~20 80~85		Ø1.0~2.5 47~70 Ø3.0~20 70~75		Ø1.0~1.5 47~57 Ø1.5~20 57~70		Ø1.0~2.5 30~47 Ø3.0~20 50~60		Ø1.0~20 22~30		Ø1.0~2.5 55~65 Ø3.0~20 60~70		Ø1.0~2.5 60~80 Ø3.0~20 80~85		Ø1.0~2.5 30~35 Ø3.0~0 35~40	
型號 Code No.	刃徑 Dc	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed
		(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)
B274HX-1	1	20,000	240	20,000	240	15,000	215	15,000	215	10,000	85	7,100	40	17,500	250	20,000	240	9,550	136
B274HX-1.5	1.5	13,500	245	13,500	245	12,000	215	12,000	215	8,000	90	5,100	50	11,600	250	13,500	245	6,366	115
B274HX-2	2	13,000	300	13,000	300	11,000	280	11,000	280	7,000	110	3,900	60	8,750	263	13,000	300	4,775	122
B274HX-2.5	2.5	10,000	320	10,000	320	9,000	300	9,000	300	6,000	120	3,000	60	7,000	275	10,000	320	3,820	127
B274HX-3	3	8,800	500	8,800	500	7,200	350	7,200	350	5,300	125	2,700	60	6,370	361	8,800	500	3,714	181
B274HX-4	4	6,600	530	6,600	530	5,500	360	5,500	360	4,200	130	2,200	70	4,770	365	6,600	530	2,785	182
B274HX-5	5	5,300	600	5,300	600	4,350	420	4,350	420	3,500	140	1,900	75	3,800	430	5,300	600	2,228	215
B274HX-6	6	4,500	610	4,500	610	3,700	425	3,700	425	2,900	145	1,500	70	3,185	426	4,500	610	1,857	213
B274HX-8	8	3,300	590	3,300	590	2,700	425	2,700	425	2,200	145	1,100	65	2,390	438	3,300	590	1,392	219
B274HX-10	10	2,600	580	2,600	580	2,200	420	2,200	420	1,700	145	950	65	1,910	425	2,600	580	1,114	213
B274HX-12	12	2,200	580	2,200	580	1,800	420	1,800	420	1,400	140	800	60	1,590	433	2,200	580	928	216
B274HX-16	16	1,600	530	1,600	530	1,300	400	1,300	400	1,200	130	600	45	1,195	428	1,600	530	696	214
B274HX-20	20	1,300	510	1,300	510	1,100	370	1,100	370	890	110	470	35	955	374	1,300	510	557	187
切入深度 (mm)		ap:1.0D		ap:1.0D		ap:1.0D		ap:1.0D		ap:1.0D		ap:1.0D		ap:1.0D		ap:1.0D		ap:1.0D	
		ae:0.05D		ae:0.05D		ae:0.05D		ae:0.05D		ae:0.05D		ae:0.02D		ae:0.05D		ae:0.05D		ae:0.05D	

High feed cutting 高進給切削

被削材 Work Material		GR.1 碳鋼 Carbon Steel		GR.2 低合金鋼 Low-alloyed Steel (~24HRC)		GR.3 高合金鋼 Hi-alloyed Steel (~30HRC)		GR.4 硬化鋼 Hardened Steel (30~38HRC)		GR.5 硬化鋼 Hardened Steel (38~48HRC)		GR.6 硬化鋼 Hardened Steel (48~56HRC)		GR.8 不銹鋼 Stainless Steel		GR.9 鑄鐵 Cast Iron		GR.15 鈦合金 Titanium	
切削速度 Vc m/min		Ø1.0~2.5 60~80 Ø3.0~20 80~85		Ø1.0~2.5 60~80 Ø3.0~20 80~85		Ø1.0~2.5 47~70 Ø3.0~20 70~75		Ø1.0~1.5 47~57 Ø1.5~20 57~70		Ø1.0~2.5 30~47 Ø3.0~20 50~60		Ø1.0~20 22~30		Ø1.0~2.5 80~100 Ø3.0~20 130~150		Ø1.0~2.5 60~80 Ø3.0~20 80~85		Ø1.0~2.5 60~80 Ø3~20 80~85	
型號 Code No.	刃徑 Dc	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed
		(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)	(min-1)	(mm/min)
B274HX-1	1	32,000	1,280	32,000	1,280	26,000	1,040	26,000	1,040	20,000	800	20,000	800	25,400	1,016	32,000	1,280	19,100	760
B274HX-1.5	1.5	22,000	1,760	22,000	1,760	17,000	1,360	17,000	1,360	13,000	1,040	13,000	1,040	16,800	1,344	22,000	1,760	12,732	1,018
B274HX-2	2	16,000	1,920	16,000	1,920	14,000	1,680	14,000	1,680	10,000	1,200	10,000	1,200	12,700	1,524	16,000	1,920	9,550	1,146
B274HX-2.5	2.5	14,000	2,240	14,000	2,240	12,000	1,920	12,000	1,920	9,000	1,440	9,000	1,440	10,185	1,629	14,000	2,240	7,640	1,222
B274HX-3	3	13,000	2,600	13,000	2,600	10,500	2,100	10,500	2,100	8,500	1,700	8,500	1,700	13,793	2,758	13,000	2,600	8,488	1,698
B274HX-4	4	12,000	2,880	12,000	2,880	10,000	2,400	10,000	2,400	8,500	2,040	8,500	2,040	10,345	2,482	12,000	2,880	6,366	1,528
B274HX-5	5	9,500	2,660	9,500	2,660	8,500	2,380	8,500	2,380	7,000	1,960	7,000	1,960	8,276	2,317	9,500	2,660	5,093	1,426
B274HX-6	6	8,000	2,560	8,000	2,560	7,500	2,400	7,500	2,400	6,500	2,080	6,500	2,080	6,897	2,207	8,000	2,560	4,244	1,358
B274HX-8	8	6,500	2,340	6,500	2,340	5,500	1,980	5,500	1,980	5,500	1,760	5,500	1,760	5,173	1,862	6,500	2,340	3,183	1,145
B274HX-10	10	5,500	2,200	5,500	2,200	4,800	1,920	4,800	1,920	4,000	1,440	4,000	1,440	4,138	1,655	5,500	2,200	2,546	1,018
B274HX-12	12	5,000	2,200	5,000	2,200	4,000	1,760	4,000	1,760	3,500	1,400	3,500	1,400	3,448	1,517	5,000	2,200	2,122	934
B274HX-16	16	4,000	1,920	4,000	1,920	3,000	1,440	3,000	1,440	2,500	1,000	2,500	1,000	2,586	1,241	4,000	1,920	1,592	764
B274HX-20	20	3,000	1,560	3,000	1,560	2,400	1,248	2,400	1,248	2,000	800	2,000	800	2,069	1,075	3,000	1,560	1,273	662
切入深度 (mm)		ap:0.3×R		ap:0.3×R		ap:0.3×R		ap:0.3×R		ap:0.2×R		ap:0.1×R		ap:0.3×R		ap:0.3×R		ap:0.3×R	
		ae:0.3×D		ae:0.3×D		ae:0.3×D		ae:0.3×D		ae:0.3×D		ae:0.3×D		ae:0.3×D		ae:0.3×D		ae:0.3×D	

1. Please work with good rigidity / high precision facilities and collet chuck.
 2. Please choose proper cutting fluid.
 3. The cutting data is reference value only. Please adjust it according to your real working conditions.
 4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
 5. If vibration occurs during cutting, please reduce cutting parameter.
1. 請使用剛性好、精度高的設備和夾具。
 2. 請選擇適用於工件材料的切削液。
 3. 此切削條件表中的數值為切削條件的基準值，實際加工時，請考慮加工形狀、目的、使用機台等因素，對切削條件進行調整。
 4. 如果機台轉速低於表中所列數值，則進給速度應與轉速按同一比例降低。
 5. 切削加工時如果發生振顫，請降低切削條件。