

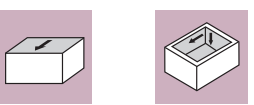
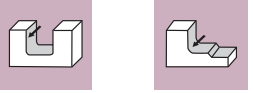
B255X 極超微粒鎢鋼塗層R角立銑刀

End Mills With Corner Radius

UMG Carbide
AlTiN X-NaNo



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

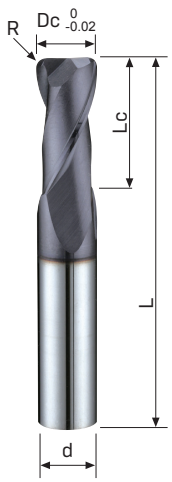
M 不銹鋼
Stainless Steel

K 鑄鐵
Cast Iron

N 銅
Copper

Feature of product:

2刃R角立銑刀
廣泛用於3D曲面輪廓粗加工及一般加工。
採用AlTiN高鋁鈦塗層具有良好的耐磨性。
可用於硬度HRC56以下各式鋼鐵材料。



Dc	R	Lc	L	d	AlTiN B255X
0 -0.02	±0.01	mm	mm	h6	
1	R0.1	3	50	4	●
1	R0.2	3	50	4	●
1	R0.3	3	50	4	●
1.5	R0.1	5	50	4	●
1.5	R0.2	5	50	4	●
1.5	R0.3	5	50	4	●
1.5	R0.5	5	50	4	●
2	R0.1	6	50	4	●
2	R0.2	6	50	4	●
2	R0.3	6	50	4	●
2	R0.5	6	50	4	●
2.5	R0.1	8	50	4	●
2.5	R0.2	8	50	4	●
2.5	R0.3	8	50	4	●
2.5	R0.5	8	50	4	●
3A	R0.1	8	50	4	●
3A	R0.2	8	50	4	●
3A	R0.3	8	50	4	●
3A	R0.5	8	50	4	●
4A	R0.1	11	50	4	●
4A	R0.2	11	50	4	●
4A	R0.3	11	50	4	●
4A	R0.5	11	50	4	●
4A	R1	11	50	4	●
3	R0.1	8	50	6	●
3	R0.2	8	50	6	●
3	R0.3	8	50	6	●
3	R0.5	8	50	6	●
4	R0.1	11	50	6	●
4	R0.2	11	50	6	●
4	R0.3	11	50	6	●
4	R0.5	11	50	6	●
4	R1	11	50	6	●
5	R0.2	13	50	6	●
5	R0.3	13	50	6	●
5	R0.5	13	50	6	●
5	R1	13	50	6	●
6	R0.2	16	50	6	●
6	R0.3	16	50	6	●
6	R0.5	16	50	6	●
6	R1	16	50	6	●
6	R1.5	16	50	6	●
6	R2	16	50	6	●
8	R0.2	20	60	8	●
8	R0.3	20	60	8	●
8	R0.5	20	60	8	●
8	R1	20	60	8	●
8	R1.5	20	60	8	●
8	R2	20	60	8	●
8	R3	20	60	8	●
10	R0.2	22	72	10	●
10	R0.3	22	72	10	●
10	R0.5	22	72	10	●
10	R1	22	72	10	●
10	R1.5	22	72	10	●
10	R2	22	72	10	●
10	R3	22	72	10	●

Code No. B255X-Dc×R

Dc	R	Lc	L	d	AlTiN B255X
0 -0.02	±0.01	mm	mm	h6	
12	R0.2	26	75	12	●
12	R0.3	26	75	12	●
12	R0.5	26	75	12	●
12	R1	26	75	12	●
12	R1.5	26	75	12	●
12	R2	26	75	12	●
12	R3	26	75	12	●
16	R0.5	38	100	16	●
16	R1	38	100	16	●
16	R1.5	38	100	16	●
16	R2	38	100	16	●
16	R3	38	100	16	●
16	R4	38	100	16	●
20	R0.5	38	100	20	●
20	R1	38	100	20	●
20	R1.5	38	100	20	●
20	R2	38	100	20	●
20	R3	38	100	20	●
20	R4	38	100	20	●
20	R5	38	100	20	●

B255X 切削條件參考表

Recommended Milling Conditions

Slotting 溝切削

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.9 鑄鐵 Cast Iron	
切削速度 Vc m/min		Ø1.0~3.0 62~70 Ø3.1~20 75~80		Ø1.0~3.0 62~70 Ø3.1~20 75~80		Ø1.0~3.0 62~70 Ø3.1~20 75~80		Ø1.0~3.0 40~50 Ø3.1~20 53~55		Ø1.0~3.0 34~40 Ø3.1~20 44~50		Ø1.0~3.0 22~25 Ø3.1~20 28~30		Ø1.0~3.0 62~70 Ø3.1~20 75~80	
型號 Code No.	刃徑 Dc	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed
		迴轉速度 (min-1)	進給速度 (mm/min)	迴轉速度 (min-1)	進給速度 (mm/min)	迴轉速度 (min-1)	進給速度 (mm/min)	迴轉速度 (min-1)	進給速度 (mm/min)	迴轉速度 (min-1)	進給速度 (mm/min)	迴轉速度 (min-1)	進給速度 (mm/min)	迴轉速度 (min-1)	進給速度 (mm/min)
B255X-1	1	19,500	120	19,500	120	14,500	120	12,500	85	11,000	65	7,000	30	19,500	120
B255X-1.5	1.5	14,000	120	14,000	120	10,500	120	8,500	85	8,000	65	5,000	40	14,000	120
B255X-2	2	11,000	130	11,000	130	8,350	120	7,000	85	6,300	70	3,900	40	11,000	130
B255X-2.5	2.5	9,900	115	9,900	115	7,000	130	6,000	85	5,000	70	3,500	40	9,900	115
B255X-3	3	7,500	190	7,500	190	6,350	150	5,300	100	4,350	75	2,700	40	7,500	190
B255X-4	4	6,000	225	6,000	225	4,900	180	4,200	120	3,500	90	2,200	50	6,000	225
B255X-5	5	5,200	300	5,200	300	4,300	230	3,500	125	3,000	100	1,900	55	5,200	300
B255X-6	6	4,500	300	4,500	300	3,600	230	2,900	120	2,500	100	1,600	55	4,500	300
B255X-8	8	3,300	280	3,300	280	2,700	230	2,200	120	1,900	100	1,100	50	3,300	280
B255X-10	10	2,600	270	2,600	270	2,100	220	1,700	120	1,500	90	950	50	2,600	270
B255X-12	12	2,200	270	2,200	270	1,800	210	1,450	125	1,200	95	800	45	2,200	270
B255X-16	16	1,600	250	1,600	250	1,350	190	1,100	100	950	85	600	35	1,600	250
B255X-20	20	1,300	200	1,300	200	1,050	150	880	75	750	65	480	30	1,300	200
切入深度 (mm)		ap: ≤3 0.3D >3 0.5D		ap: ≤3 0.3D >3 0.5D		ap: ≤3 0.3D >3 0.5D		ap: ≤3 0.3D >3 0.5D		ap: ≤3 0.3D >3 0.5D		ap : 0.05D		ap: ≤3 0.3D >3 0.5D	

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。