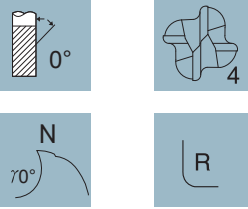


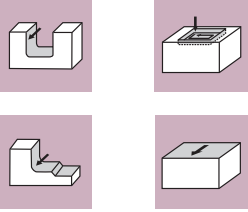
B271TX 極超微粒鎢鋼塗層高效能R角立銑刀

High Performance End Mills With Corner Radius

**SMG Carbide**      **AlTiSiN TX**



**Type of Operation**



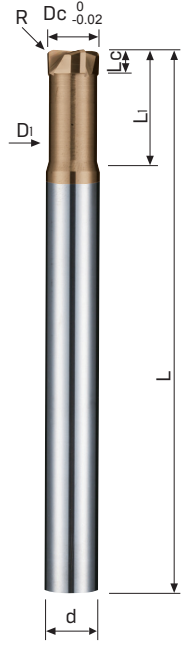
**Work Material**

P	H	M	K	N	S
	●		●		

- H** 硬化鋼 <48HRC  
Hardened Steel
- H** 硬化鋼 <56HRC  
Hardened Steel
- H** 硬化鋼 <68HRC  
Hardened Steel
- K** 鑄鐵  
Cast Iron

**Feature of product:**

高效分層銑削用R角立銑刀  
 採用SMG特極超微粒碳化鎢鋼材料，並搭配奈米多層膜塗層具有優異的潤滑及耐磨性。  
 具有良好的刀具壽命。  
 高精密R值、短刃高強度。  
 適用於高硬度材料、高精密模具分層銑削加工。



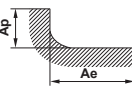
Code No. B271TX-Dc×R

Dc 0 -0.02	R	Lc mm	L mm	d h6	L1 mm	D1 mm	AlTiSiN B271TX
3	R0.75	1.2	70	6	7.5	2.7	●
4	R1	1.6	70	6	10	3.6	●
5	R1	2	80	6	12	4.5	●
5	R1.2	2	80	6	12	4.5	●
6	R1	2.5	80	6	12	5.4	●
6	R1.5	2.5	80	6	12	5.4	●
8	R1	3.5	100	8	16	7.2	●
8	R2	3.5	100	8	16	7.2	●
10	R1	4	100	10	20	9	●
10	R2	4	100	10	20	9	●
12	R1	5	110	12	24	11	●
12	R2	5	110	12	24	11	●
12	R3	5	110	12	24	11	●

## B271TX 切削條件參考表

## Recommended Milling Conditions

## High feed cutting 高進給切削

被削材 Work Material		GR.5 硬化鋼 Hardened Steel (38-48HRC)		GR.6 硬化鋼 Hardened Steel (48-56HRC)		GR.7 硬化鋼 Hardened Steel (56-68HRC)		GR.9 鑄鐵 Cast Iron	
切削速度 Vc m/min		70		50		30		100	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)
B271TX-3	3	7,400	3,800	5,300	2,500	3,200	990	10,500	6,000
B271TX-4	4	5,500	4,100	4,000	2,700	2,400	1,000	8,000	6,500
B271TX-5	5	4,450	4,300	3,200	2,800	1,900	1,100	6,350	6,800
B271TX-6	6	3,700	4,300	2,600	2,800	1,600	1,100	5,300	6,800
B271TX-8	8	2,800	4,300	2,000	2,800	1,200	1,100	4,000	7,000
B271TX-10	10	2,250	4,400	1,600	2,800	1,000	1,100	3,200	7,000
B271TX-12	12	1,850	4,400	1,350	2,800	800	1,100	2,650	7,000
 切入深度 $a_p$ (mm)		ap:0.2xR		ap:0.2xR		ap:0.1xR		ap:0.2xR	
		ae:0.5D		ae:0.5D		ae:0.5D		ae: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。