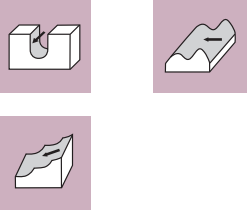


B253TX / B254TX 極超微粒鎢鋼塗層3刃 / 4刃圓頭立銑刀

Ball Nose End Mills - 3 / 4 Flutes

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

S 鈦合金
Titanium

S 鎳
Nickel

S 高溫合金
High Temp Alloys

Feature of product:

B253TX 3刃強力圓頭立銑刀

B254TX 4刃精加工圓頭立銑刀

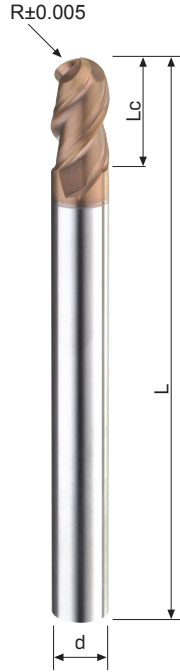
採用SMG特極超微粒碳化鎢鋼材料，並搭配奈米多層膜塗層具有優異的潤滑及耐磨性。

S型球頭幾何設計，刃部小刃帶設計。

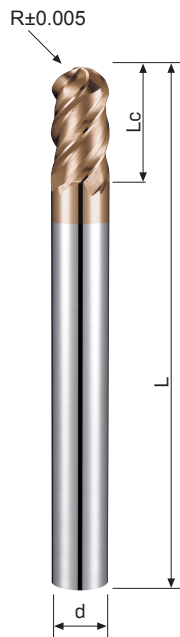
具有良好的刀具壽命。

球頭R值公差更加精密。

適用於高硬度材料、高精度模具加工。



SMG Carbide	AlTiSiN TX	45°	3	N 7-10°	U
Code No. B253TX-Dc					
Dc	R	Lc	L	d	AlTiSiN B253TX
$\begin{matrix} 0 \\ -0.02 \end{matrix}$	±0.005	mm	mm	h6	●
6	3	12	80	6	●
8	4	14	100	8	●
10	5	18	100	10	●
12	6	22	110	12	●

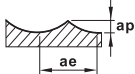


SMG Carbide	AlTiSiN TX	45°	4	N 7-10°	U
Code No. B254TX-Dc					
Dc	R	Lc	L	d	AlTiSiN B254TX
$\begin{matrix} 0 \\ -0.02 \end{matrix}$	±0.005	mm	mm	h6	●
3	1.5R	6	70	6	●
4	2R	8	70	6	●
5	2.5R	10	80	6	●
6	3R	12	80	6	●
8	4R	14	100	8	●
10	5R	18	100	10	●
12	6R	22	110	12	●
16	8R	30	140	16	●
20	10R	38	160	20	●

B253TX / B254TX 切削條件參考表

Recommended Milling Conditions

High feed machining 高進給加工

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)	
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]
B253TX-R3	6	8000~3200	2700~1200	6400~2500	1900~830	4800~1900	1500~700
B253TX-R4	8	6000~2400	2600~1000	4800~1900	1900~800	3800~1500	1500~600
B253TX-R5	10	4800~1900	3400~1400	3800~1500	2400~1000	3000~1000	1600~800
B253TX-R6	12	4000~1600	2400~1000	3200~1300	1700~1100	2200~800	1350~600
切入深度 (mm) 		ap:0.075~0.015		ap:0.075~0.015		ap:0.075~0.015	
		ae:0.2~0.18		ae:0.2~0.18		ae:0.2~0.18	

Finishing 精加工

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)	
切削速度 Vc m/min		280		220		200	
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]
B254TX-R1.5	3	29,000	6,560	23,000	4,500	21,100	4,240
B254TX-R2	4	22,000	6,250	17,100	4,000	15,800	3,520
B254TX-R2.5	5	17,500	5,600	13,600	3,500	12,700	3,200
B254TX-R3	6	15,000	5,000	11,400	3,000	10,600	2,500
B254TX-R4	8	11,000	4,200	8,550	2,500	7,950	2,250
B254TX-R5	10	9,000	3,500	6,850	2,150	6,350	2,000
B254TX-R6	12	7,500	3,000	5,700	2,000	5,300	1,900
B254TX-R8	16	5,500	3,000	4,280	2,000	4,000	1,900
B254TX-R10	20	4,500	3,000	3,500	2,000	3,200	1,900
切入深度 (mm) 		ap:0.02D		ap:0.02D		ap:0.02D	
		ae:0.05D		ae:0.05D		ae:0.05D	

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。