

B261TX 極超微粒鎢鋼塗層圓頭立銑刀

Ball Nose End Mills

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

Feature of product:

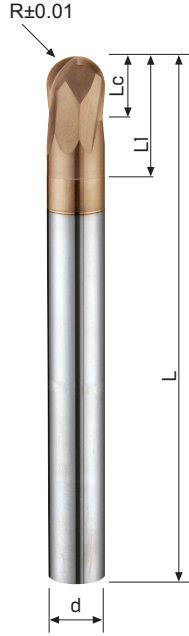
2刃圓頭加長立銑刀

採用SMG特極超微粒碳化鎢材料，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。

適用於高硬度材料精加工。



Code No. B261TX-Dc

Dc 0 -0.02	R ±0.01	Lc mm	L mm	d h6	L1 mm	AlTiSiN B261TX
1	0.5R	1	50	4	2	●
1.5	0.75R	1.5	50	4	3	●
2	1R	2	60	6	4	●
3	1.5R	3	70	6	6	●
4	2R	4	70	6	8	●
5	2.5R	5	80	6	10	●
6	3R	6	80	6	12	●
8	4R	8	100	8	16	●
10	5R	10	100	10	20	●
12	6R	12	110	12	24	●

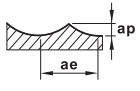
B261TX 切削條件參考表

Recommended Milling Conditions

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		230		200		180	
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)
B261TX-R0.5	1	40,000	1,000	31,500	800	23,000	600
B261TX-R0.75	1.5	34,000	1,000	26,000	800	19,200	600
B261TX-R1	2	26,500	1,300	22,000	1,000	16,200	800
B261TX-R1.5	3	25,500	2,300	21,000	1,800	15,500	1,500
B261TX-R2	4	21,000	2,350	17,300	1,800	12,800	1,400
B261TX-R2.5	5	18,000	2,300	14,800	1,850	11,000	1,380
B261TX-R3	6	12,000	2,300	10,500	2,000	9,500	1,800
B261TX-R4	8	9,100	1,700	7,900	1,500	7,100	1,300
B261TX-R5	10	7,300	1,400	6,300	1,200	5,700	1,000
B261TX-R6	12	6,000	1,200	5,300	1,000	4,700	950
切入深度 (mm)		ap:0.02D		ap:0.02D		ap:0.02D	
		ae:0.02D		ae:0.02D		ae:0.02D	

High-speed machining 高速加工

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		320		250		180	
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)
B261TX-R3	6	17,500	4,000	13,000	3,000	10,000	2,000
B261TX-R4	8	13,000	3,000	9,800	2,300	7,500	1,500
B261TX-R5	10	10,500	2,500	7,900	1,800	6,000	1,200
B261TX-R6	12	8,700	2,000	6,600	1,500	5,000	1,000
切入深度 (mm)		ap:0.02D		ap:0.02D		ap:0.02D	
		ae:0.02D		ae:0.02D		ae:0.02D	

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。