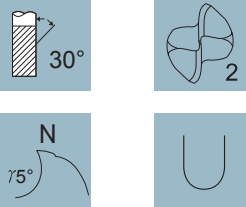


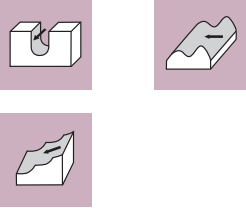
B262TX / B263TX / B264TX 極超微粒鎢鋼塗層圓頭立銑刀

Ball Nose End Mills

SMG Carbide **AlTiSiN TX**



Type of Operation



Work Material

P	H	M	K	N	S
●	●	●	○	●	●

P 鋼鐵
Steel

H 硬化鋼 <38HRC
Hardened Steel

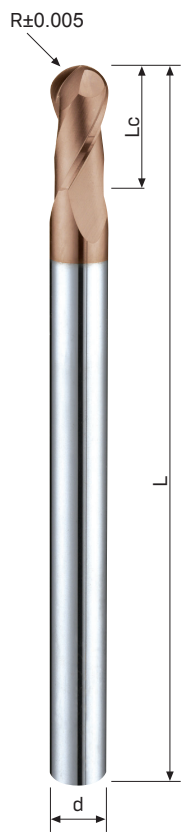
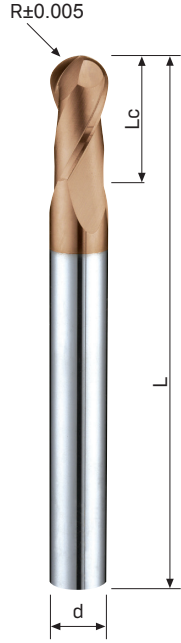
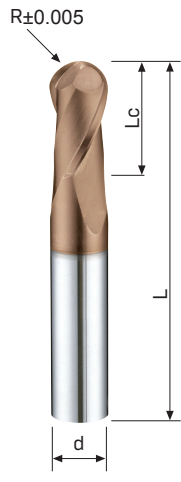
H 硬化鋼 <48HRC
Hardened Steel

H 硬化鋼 <56HRC
Hardened Steel

H 硬化鋼 <68HRC
Hardened Steel

K 鑄鐵
Cast Iron

Feature of product:
2刃圓頭立銑刀 / 加長立銑刀
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。
適用於高硬度材料精加工。



Code No. B262TX-Dc

Dc 0 -0.02	R ±0.005	Lc mm	L mm	d h6	AlTiSiN B262TX
0.1	0.05R	0.2	50	4	●
0.2	0.1R	0.4	50	4	●
0.3	0.15R	0.6	50	4	●
0.4	0.2R	0.8	50	4	●
0.5	0.25R	1	50	4	●
0.6	0.3R	1.2	50	4	●
0.8	0.4R	1.6	50	4	●
1	0.5R	2	50	4	●
1.5	0.75R	3	50	4	●
2	1R	4	50	4	●
2.5	1.25R	5	50	4	●
3A	1.5R	6	50	4	●
4A	2R	8	50	4	●
3	1.5R	6	50	6	●
4	2R	8	50	6	●
5	2.5R	10	50	6	●
6	3R	12	50	6	●
7	3.5R	14	60	8	●
8	4R	14	60	8	●
9	4.5R	18	72	10	●
10	5R	18	72	10	●
12	6R	22	75	12	●
14	7R	26	90	16	●
16	8R	30	100	16	●
20	10R	38	100	20	●

Code No. B263TX-Dc

Dc 0 -0.02	R ±0.005	Lc mm	L mm	d h6	AlTiSiN B263TX
1	0.5R	2	50	6	●
1.5	0.75R	3	50	6	●
2	1R	4	60	6	●
2.5	1.25R	5	60	6	●
3	1.5R	6	70	6	●
4	2R	8	70	6	●
5	2.5R	10	80	6	●
6	3R	12	80	6	●
7	3.5R	14	100	8	●
8	4R	14	100	8	●
9	4.5R	18	100	10	●
10	5R	18	100	10	●
12	6R	22	110	12	●
14	7R	26	120	16	●
16	8R	30	140	16	●
20	10R	38	160	20	●

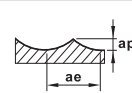
Code No. B264TX-Dc

Dc 0 -0.02	R ±0.005	Lc mm	L mm	d h6	AlTiSiN B264TX
1	0.5R	2	70	3	●
2	1R	4	70	3	●
3	1.5R	6	80	4	●
4	2R	8	80	4	●
5	2.5R	10	100	6	●
6	3R	12	100	6	●
8	4R	14	130	8	●
10	5R	18	160	10	●
12	6R	22	180	12	●
16	8R	30	210	16	●
20	10R	38	210	20	●

B262TX / B263TX / B264TX 切削條件參考表

Recommended Milling Conditions

General processing 普通加工

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.7 硬化鋼 Hardened Steel (56~68HRC)			
切削速度 Vc m/min		Ø0.1~0.6 30~60 Ø0.8~20 80~120		Ø0.1~0.6 30~60 Ø0.8~20 80~120		Ø0.1~0.6 30~60 Ø0.8~20 80~100		Ø0.1~0.6 30~60 Ø0.8~20 73~80		Ø0.1~0.6 30~60 Ø0.8~20 65~70		Ø0.1~0.6 23~46 Ø0.8~20 48~60		Ø0.1~0.6 20~35 Ø0.8~20 35~42			
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)	
		B262TX-R0.05	0.1	32,000	320	32,000	320	32,000	300	32,000	250	24,500	160	24,500	100	24,500	50
B262TX-R0.1	0.2	32,000	360	32,000	360	32,000	320	32,000	280	24,500	180	24,500	100	24,500	75		
B262TX-R0.15	0.3	32,000	400	32,000	400	32,000	365	32,000	300	32,000	180	24,500	100	24,500	75		
B262TX-R0.2	0.4	32,000	450	32,000	450	32,000	400	32,000	320	32,000	200	24,500	130	24,500	115		
B262TX-R0.25	0.5	32,000	485	32,000	485	32,000	440	32,000	360	32,000	230	24,500	150	24,500	130		
B262TX-R0.3	0.6	32,000	530	32,000	530	31,500	480	32,000	400	32,000	260	24,500	170	23,500	150		
B262TX-R0.4	0.8	32,000	605	32,000	605	31,500	550	29,000	400	27,000	270	19,000	185	14,000	140		
B262TX/B263TX/B264TX-R0.5	1	32,000	680	32,000	680	31,500	620	25,000	400	22,000	280	19,000	200	14,000	130		
B262TX/B263TX-R0.75	1.5	32,000	680	32,000	680	31,500	620	25,000	400	22,000	280	19,000	200	14,000	130		
B262TX/B263TX/B264TX-R1	2	19,000	765	19,000	765	15,500	620	12,500	400	11,000	290	9,500	200	7,100	135		
B262TX/B263TX/R1.25	2.5	19,000	765	19,000	765	15,500	620	12,500	400	11,000	290	9,500	200	6,360	135		
B262TX/B236TX/B264TX-R1.5	3	12,500	765	12,500	765	10,500	630	8,450	400	7,400	290	6,350	200	4,700	140		
B262TX/B236TX/B264TX-R2	4	9,500	765	9,500	765	7,950	630	6,350	450	5,550	370	4,750	270	3,500	170		
B262TX/B236TX/B264TX-R2.5	5	7,600	850	7,600	850	6,350	630	5,050	450	4,450	370	3,800	280	2,860	170		
B262TX/B236TX/B264TX-R3	6	6,350	850	6,350	850	5,300	650	4,200	460	3,700	390	3,150	290	2,300	175		
B262TX/B263TX-R3.5	7	5,050	950	5,050	950	4,650	710	3,650	500	3,200	420	2,750	305	2,000	190		
B262TX/B236TX/B264TX-R4	8	4,750	1,050	4,750	1,050	3,950	780	3,150	550	2,750	450	2,350	325	1,700	200		
B262TX/B263TX-R4.5	9	4,250	1,000	4,250	1,000	3,550	760	2,850	535	2,450	440	2,120	330	1,550	200		
B262TX/B236TX/B264TX-R5	10	3,800	950	3,800	950	3,150	740	2,500	525	2,200	430	1,900	330	1,400	200		
B262TX/B236TX/B264TX-R6	12	3,150	890	3,150	890	2,650	700	2,100	490	1,850	430	1,550	310	1,100	190		
B262TX/B263TX-R7	14	2,700	860	2,700	860	2,250	670	1,800	475	1,550	380	1,350	300	955	180		
B262TX/B236TX/B264TX-R8	16	2,350	840	2,350	840	1,950	640	1,550	475	1,350	380	1,150	265	835	175		
B262TX/B236TX/B264TX-R10	20	1,900	760	1,900	760	1,750	570	1,400	450	1,100	350	955	250	665	170		
切入深度 (mm) 	ap:<1 0.05D ≥1 0.1D		ap:<1 0.05D ≥1 0.1D		ap:<1 0.05D ≥1 0.1D		ap:<1 0.05D ≥1 0.1D		ap:<1 0.05D ≥1 0.1D		ap:0.05D		ap:0.05D				
	ae:<1 0.1D ≥1 0.1D		ae:<1 0.1D ≥1 0.1D		ae:<1 0.1D ≥1 0.1D		ae:<1 0.1D ≥1 0.1D		ae:<1 0.1D ≥1 0.1D		ae:<1 0.1D ≥1 0.1D		ae:0.075D		ae:0.075D		

High-speed machining 高速加工

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.7 硬化鋼 Hardened Steel (56~68HRC)			
切削速度 Vc m/min		Ø1~3 157~198 Ø4~20 226~300		Ø1~3 157~198 Ø4~20 226~300		Ø1~3 155~165 Ø4~20 195~250		Ø1~3 140~160 Ø4~20 188~220		Ø1~3 125~153 Ø4~20 170~180		Ø1~3 100~113 Ø4~20 138~180		Ø1~3 79~92 Ø4~20 119~126			
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)	
		B262TX/B263TX/B264TX-R0.5	1	50,000	2,800	50,000	2,800	50,000	2,800	50,000	2,500	47,500	2,200	32,000	1,400	25,000	1,000
B262TX/B263TX-R0.75	1.5	41,800	2,800	41,800	2,800	33,000	2,800	30,000	2,500	26,500	2,200	24,000	1,400	19,500	1,000		
B262TX/B263TX/B264TX-R1	2	31,500	3,500	31,500	3,500	25,000	2,800	24,500	2,500	23,500	2,250	17,000	1,500	12,500	1,000		
B262TX/B263TX-R1.25	2.5	41,800	3,500	41,800	3,500	21,000	2,800	20,000	2,500	19,500	2,200	14,000	1,500	10,000	950		
B262TX/B236TX/B264TX-R1.5	3	21,000	3,500	21,000	3,500	16,500	2,800	16,000	2,500	15,500	2,200	11,000	1,500	8,400	950		
B262TX/B236TX/B264TX-R2	4	18,000	3,700	18,000	3,700	15,500	3,200	15,000	2,700	13,500	2,400	11,000	1,900	7,900	1,000		
B262TX/B236TX/B264TX-R2.5	5	15,500	4,000	15,500	4,000	15,000	4,000	14,000	2,800	11,000	2,300	10,000	2,000	7,600	1,200		
B262TX/B236TX/B264TX-R3	6	15,000	4,800	15,000	4,800	13,500	4,300	11,500	2,700	9,500	2,200	9,500	2,200	6,600	1,050		
B262TX/B236TX/B264TX-R4	8	11,500	3,600	11,500	3,600	10,000	3,200	8,900	2,000	7,100	1,700	7,100	1,700	4,900	880		
B262TX/B236TX/B264TX-R5	10	9,500	3,000	9,500	3,000	8,200	2,500	7,100	1,700	5,700	1,300	5,700	1,300	3,900	700		
B262TX/B236TX/B264TX-R6	12	7,900	2,450	7,900	2,450	6,800	2,100	5,900	1,350	4,700	1,000	4,700	1,000	3,300	580		
B262TX/B236TX/B264TX-R8	16	5,900	1,800	5,900	1,800	5,000	1,500	4,500	1,000	3,500	800	3,500	800	2,450	400		
B262TX/B236TX/B264TX-R10	20	4,700	1,300	4,700	1,300	4,000	1,200	3,500	800	2,800	650	2,800	650	2,000	320		
切入深度 (mm) 	ap:0.02D		ap:0.02D		ap:0.02D		ap:0.02D		ap:0.02D		ap:0.02D		ap:0.02D		ap:0.02D		
	ae:0.02D		ae:0.02D		ae:0.02D		ae:0.02D		ae:0.02D		ae:0.02D		ae:0.02D		ae:0.02D		ae:0.02D

※ Notice: B263TX/B264TX is Long Length series End Mills. Please adjust the parameter according

※ 注意 B263TX/B264TX 為加長柄系列銑刀，請按照適當的伸長度調整刀具的參數。