

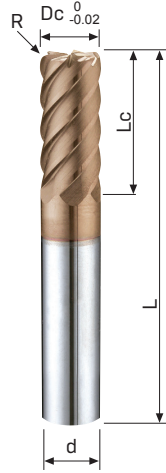
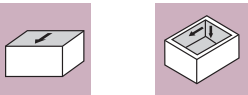
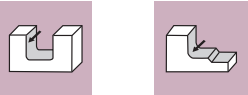
B259TX / B269TX 極超微粒鎢鋼塗層精加工R角立銑刀

Finishing End Mills With Corner Radius

**SMG Carbide** **AlTiSiN TX**



**Type of Operation**



Code No. B259TX-Dc×R

| Dc<br>0<br>-0.02 | R<br>±0.01 | Lc<br>mm | L<br>mm | d<br>h6 | AlTiSiN<br>B259TX |
|------------------|------------|----------|---------|---------|-------------------|
| 6                | R0.5       | 16       | 50      | 6       | ●                 |
| 6                | R1         | 16       | 50      | 6       | ●                 |
| 8                | R0.5       | 20       | 60      | 8       | ●                 |
| 8                | R1         | 20       | 60      | 8       | ●                 |
| 10               | R0.5       | 22       | 72      | 10      | ●                 |
| 10               | R1         | 22       | 72      | 10      | ●                 |
| 12               | R0.5       | 26       | 75      | 12      | ●                 |
| 12               | R1         | 26       | 75      | 12      | ●                 |
| 16               | R1         | 38       | 100     | 16      | ●                 |
| 16               | R2         | 38       | 100     | 16      | ●                 |
| 20               | R1         | 38       | 100     | 20      | ●                 |
| 20               | R2         | 38       | 100     | 20      | ●                 |

**Work Material**

|   |   |   |   |   |   |
|---|---|---|---|---|---|
| P | H | M | K | N | S |
|   | ● |   | ○ |   |   |

**H** 硬化鋼 <48HRC  
Hardened Steel

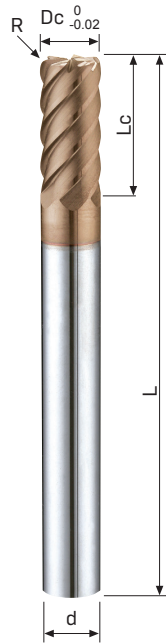
**H** 硬化鋼 <56HRC  
Hardened Steel

**H** 硬化鋼 <68HRC  
Hardened Steel

**K** 鑄鐵  
Cast Iron

**Feature of product:**

6刃精加工R角立銑刀 / 加長立銑刀  
廣泛用於3D曲面輪廓粗、精加工。  
採用奈米多層膜塗層具有優異的潤滑及耐磨性。  
六刃設計具有高強度心厚。  
適用於高硬度鑄鐵材料。



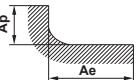
Code No. B269TX-Dc×R

| Dc<br>0<br>-0.02 | R<br>±0.01 | Lc<br>mm | L<br>mm | d<br>h6 | AlTiSiN<br>B269TX |
|------------------|------------|----------|---------|---------|-------------------|
| 6                | R0.5       | 16       | 80      | 6       | ●                 |
| 6                | R1         | 16       | 80      | 6       | ●                 |
| 8                | R0.5       | 20       | 100     | 8       | ●                 |
| 8                | R1         | 20       | 100     | 8       | ●                 |
| 10               | R0.5       | 22       | 100     | 10      | ●                 |
| 10               | R1         | 22       | 100     | 10      | ●                 |
| 12               | R0.5       | 26       | 110     | 12      | ●                 |
| 12               | R1         | 26       | 110     | 12      | ●                 |
| 16               | R1         | 38       | 140     | 16      | ●                 |
| 16               | R2         | 38       | 140     | 16      | ●                 |
| 20               | R1         | 38       | 160     | 20      | ●                 |
| 20               | R2         | 38       | 160     | 20      | ●                 |

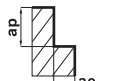
## B259TX / B269TX 切削條件參考表

## Recommended Milling Conditions

## High feed cutting 高進給切削

| 被削材<br>Work Material   |          | GR.5 硬化鋼<br>Hardened Steel<br>(38-48HRC) |                          | GR.6 硬化鋼<br>Hardened Steel<br>(48-56HRC) |                          | GR.7 硬化鋼<br>Hardened Steel<br>(56-68HRC) |                          | GR.9 鑄鐵<br>Cast Iron   |                          |
|--|----------|--|--------------------------|--|--------------------------|--|--------------------------|------------------------|--------------------------|
| 切削速度<br>Vc m/min   |          | 200                                      |                          | 180                                      |                          | 160                                      |                          | 200                    |                          |
| 型號<br>Code No.   | 刃徑<br>Dc | RPM<br>迴轉速度<br>(min-1)                   | Feed<br>進給速度<br>(mm/min) | RPM<br>迴轉速度<br>(min-1)                   | Feed<br>進給速度<br>(mm/min) | RPM<br>迴轉速度<br>(min-1)                   | Feed<br>進給速度<br>(mm/min) | RPM<br>迴轉速度<br>(min-1) | Feed<br>進給速度<br>(mm/min) |
| B259TX/B269TX  | 6        | 10,617                                   | 2,548                    | 9,555                                    | 2,293                    | 8,493                                    | 2,038                    | 10,617                 | 2,548                    |
| B259TX/B269TX  | 8        | 7,963                                    | 2,389                    | 7,166                                    | 2,150                    | 6,370                                    | 2,293                    | 7,963                  | 2,389                    |
| B259TX/B269TX  | 10       | 6,370                                    | 3,058                    | 5,733                                    | 2,752                    | 5,096                                    | 2,446                    | 6,370                  | 3,058                    |
| B259TX/B269TX  | 12       | 5,308                                    | 3,185                    | 4,778                                    | 2,867                    | 4,247                                    | 2,548                    | 5,308                  | 3,185                    |
| B259TX/B269TX  | 16       | 3,981                                    | 2,867                    | 3,583                                    | 2,580                    | 3,185                                    | 2,293                    | 3,981                  | 2,867                    |
| B259TX/B269TX  | 20       | 3,185                                    | 2,293                    | 2,867                                    | 2,064                    | 2,548                                    | 1,835                    | 3,185                  | 2,293                    |
| 切入深度<br>(mm)  |          | ap:0.2×R                                 |                          | ap:0.2×R                                 |                          | ap:0.1×R                                 |                          | ap:0.2×R               |                          |
|  |          | ae:0.5D                                  |                          | ae:0.5D                                  |                          | ae:0.5D                                  |                          | ae:0.5D                |                          |

## Side Milling 側面切削

| 被削材<br>Work Material   |          | GR.5 硬化鋼<br>Hardened Steel<br>(38-48HRC) |                          | GR.6 硬化鋼<br>Hardened Steel<br>(48-56HRC) |                          | GR.7 硬化鋼<br>Hardened Steel<br>(56-68HRC) |                          | GR.9 鑄鐵<br>Cast Iron   |                          |
|--|----------|--|--------------------------|--|--------------------------|--|--------------------------|------------------------|--------------------------|
| 切削速度<br>Vc m/min   |          | 150                                      |                          | 100                                      |                          | 90                                       |                          | 145                    |                          |
| 型號<br>Code No.   | 刃徑<br>Dc | RPM<br>迴轉速度<br>(min-1)                   | Feed<br>進給速度<br>(mm/min) | RPM<br>迴轉速度<br>(min-1)                   | Feed<br>進給速度<br>(mm/min) | RPM<br>迴轉速度<br>(min-1)                   | Feed<br>進給速度<br>(mm/min) | RPM<br>迴轉速度<br>(min-1) | Feed<br>進給速度<br>(mm/min) |
| B259TX/B269TX-6  | 6        | 6,600                                    | 2,300                    | 5,300                                    | 1,800                    | 4,000                                    | 1,000                    | 7,400                  | 2,600                    |
| B259TX/B269TX-8  | 8        | 4,900                                    | 2,350                    | 4,000                                    | 1,850                    | 3,000                                    | 1,000                    | 5,500                  | 2,600                    |
| B259TX/B269TX-10   | 10       | 4,000                                    | 2,400                    | 3,200                                    | 1,900                    | 2,400                                    | 1,000                    | 4,500                  | 2,600                    |
| B259TX/B269TX-12   | 12       | 3,300                                    | 2,400                    | 2,600                                    | 1,900                    | 2,000                                    | 1,000                    | 3,700                  | 2,600                    |
| B259TX/B269TX-16   | 16       | 2,500                                    | 2,100                    | 2,000                                    | 1,700                    | 1,500                                    | 900                      | 2,800                  | 2,400                    |
| B259TX/B269TX-20   | 20       | 2,000                                    | 1,900                    | 1,600                                    | 1,400                    | 1,200                                    | 830                      | 2,300                  | 2,100                    |
| 切入深度<br>(mm)  |          | ap:1.5D                                  |                          | ap:1.5D                                  |                          | ap:1.5D                                  |                          | ap:1.6D                |                          |
|  |          | ae:0.1D                                  |                          | ae:0.05D                                 |                          | ae:0.03D                                 |                          | ae:0.1D                |                          |

※ Notice: B269TX is Long Length series End Mills. Please adjust the parameter according

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.

※注意B269TX為加長柄系列銑刀，請按照適當的伸長度調整刀具的參數。

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。