

T740TX 超微粒鎢鋼塗層內冷螺紋鑽銑刀

Oil-Feed Thread Mills Drills

ISO Metric Standard Thread

Design with left-handed and right-cutting edge is beneficial for cutting and getting better chip removal rate.

Cutter tip with chamfering function.

Internal oil-feed design to provide with better cooling effect and chip removal.

Good wear resistance effect with Nano multilayer coating.

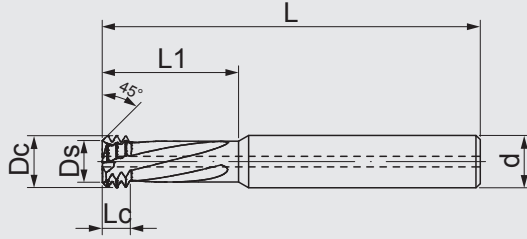
ISO公制標準螺紋。

刃口左旋右刃設計，利於切削及排屑。

刀尖具有倒角功能。

內部給水利與於加工冷卻及排屑。

採用奈米多層膜塗層具有優異的耐磨性。



VHM Carbide

AITiSiN TX



Steel <52HRC



Milling with Thread holes with plunging Helix directly.

Suitable for carbon steel, below 52HRC hardened steel, stainless steel, cast iron...etc.

螺旋下刀方式可一次加工出螺紋孔。

適用切削於碳鋼、52HRC以下硬化鋼、不銹鋼、鑄鐵...等各種材料。




Standard Length

Thread		Pitch	Dc	Lc	L1	L	d	Ds	t	T740TX AITiSiN					
Coarse	Fine	mm	mm	mm	mm	mm	h6	mm	mm						
M3×0.5	M4×0.5	0.5	2.4	1.5	7	57	6	2.1	3	●					
		0.7	3.2	2.1	9.2	57	6	2.9	3	●					
		0.8	3.9	2.4	11.5	57	6	3.5	3	●					
M6~M7×1	M8~M9×1	1	4.7	3	14	57	6	4.2	3	●					
		1.25	6.1	3.75	18	63	8	5.6	4	●					
M10×1.5	M11~M15×1.5	1.5	7.8	4.5	23	63	8	7.2	4	●					
		1.75	9	5.25	26	72	10	8.4	4	●					
M16×2	M17~M23×2	2	11.8	6	35	83	12	11.2	4	●					

切削條件

Cutting Conditions

T740TX			
Carbon Steel Materials			
P	GR1 Carbon Steel	60	0.016xDc
	GR2 <24HRC Low-alloyed Steel	60	0.016xDc
	GR3 <30HRC Hi-alloyed Steel	60	0.016xDc
Hardened Steel Materials			
H	GR4 30-38HRC Hardened Steel	30	0.01xDc
	GR5 38-48HRC Hardened Steel	20	0.01xDc
Stainless Steel Materials			
M	GR8-1 Ferritic、Martensitic	30	0.01xDc
	GR8-2 Austenitic	30	0.01xDc
	GR8-3 Austenitic-ferritic	20	0.01xDc
	GR8-4 Austenitic-ferritic Heat-resistant	15	0.01xDc
Cast Iron Materials			
K	GR9-1 Grey cast iron	60	0.016xDc
	GR9-2 Nodular cast iron	60	0.016xDc

All cutting data serve for orientation only and should be adapted individually to the technical conditions on location

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。

