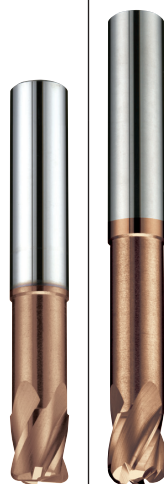
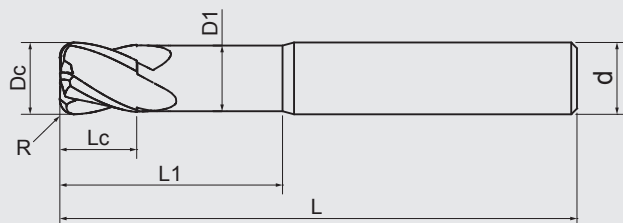


F615TX / F619TX 極超微粒鎢鋼塗層環面立銑刀

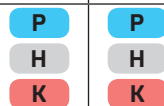
Toric End Mills

Honing cutting edge with AITISIN Nano multilayer coating to improve tool life effectively. 刃口鈍化搭配AITISIN奈米多層膜塗層，有效提升刀具壽命。



Suitable for profile surface machining, roughing and finishing in cutting different steel below 62HRC and cast iron.

適合於鋼材62HRC以下及鑄鐵曲面輪廓仿型粗、精加工切削。



DIN 6527 Standard Length

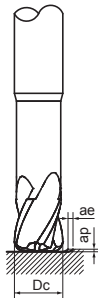
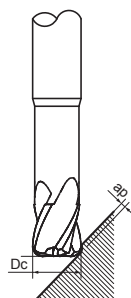
Dc 0 -0.02	R ±0.02	Lc mm	L mm	d h5	L1 mm	D1 mm	F615TX AITISIN					
3	R0.3	4	57	6	14	2.8	●					
3	R0.5	4	57	6	14	2.8	●					
4	R0.3	5	57	6	16	3.7	●					
4	R0.5	5	57	6	16	3.7	●					
4	R1	5	57	6	16	3.7	●					
6	R0.5	7	57	6	20	5.5	●					
6	R1	7	57	6	20	5.5	●					
6	R1.5	7	57	6	20	5.5	●					
8	R0.5	9	63	8	26	7.4	●					
8	R1	9	63	8	26	7.4	●					
8	R1.5	9	63	8	26	7.4	●					
8	R2	9	63	8	26	7.4	●					
10	R0.5	11	72	10	31	9.2	●					
10	R1	11	72	10	31	9.2	●					
10	R1.5	11	72	10	31	9.2	●					
10	R2	11	72	10	31	9.2	●					
10	R2.5	11	72	10	31	9.2	●					
12	R0.5	13	83	12	37	11	●					
12	R1	13	83	12	37	11	●					
12	R1.5	13	83	12	37	11	●					
12	R2	13	83	12	37	11	●					
12	R3	13	83	12	37	11	●					
16	R2	17	92	16	43	14.5	●					
16	R4	17	92	16	43	14.5	●					

Long Length

Dc 0 -0.02	R ±0.02	Lc mm	L mm	d h5	L1 mm	D1 mm	F619TX AITISIN					
6	R0.5	7	70	6	33	5.5	●					
6	R1	7	70	6	33	5.5	●					
6	R1.5	7	70	6	33	5.5	●					
8	R0.5	9	80	8	43	7.4	●					
8	R1	9	80	8	43	7.4	●					
8	R2	9	80	8	43	7.4	●					
10	R0.5	11	90	10	49	9.2	●					
10	R1	11	90	10	49	9.2	●					
10	R2	11	90	10	49	9.2	●					
10	R2.5	11	90	10	49	9.2	●					
12	R0.5	13	100	12	54	11	●					
12	R1	13	100	12	54	11	●					
12	R2	13	100	12	54	11	●					
12	R3	13	100	12	54	11	●					
16	R2	17	115	16	66	14.5	●					
16	R4	17	115	16	66	14.5	●					

切削條件

Cutting Conditions

F615TX F619TX								
		cutting speed Vc (m/min)	feed per tooth fz(mm)	ae	ap	cutting speed Vc (m/min)	feed per tooth fz(mm)	ap
Carbon Steel Materials								
P	GR1 Carbon Steel	280	0.011xDc	0.4xDc	0.03xDc	360	0.008xDc	0.01xDc
	GR2 <24HRC Low-alloyed Steel	260	0.011xDc	0.4xDc	0.03xDc	320	0.008xDc	0.01xDc
	GR3 <30HRC Hi-alloyed Steel	230	0.009xDc	0.4xDc	0.03xDc	270	0.008xDc	0.01xDc
Hardened Steel Materials								
H	GR4 30-38HRC Hardened Steel	100	0.008xDc	0.4xDc	0.03xDc	180	0.006xDc	0.01xDc
	GR5 38-48HRC Hardened Steel	80	0.007xDc	0.3xDc	0.02xDc	160	0.005xDc	0.01xDc
	GR6 48-56HRC Hardened Steel	60	0.006xDc	0.2xDc	0.01xDc	140	0.004xDc	0.01xDc
Cast Iron Materials								
K	GR9-1 Grey cast iron	280	0.02xDc	0.4xDc	0.03xDc	360	0.008xDc	0.01xDc
	GR9-2 Nodular cast iron	250	0.02xDc	0.4xDc	0.03xDc	320	0.008xDc	0.01xDc

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。