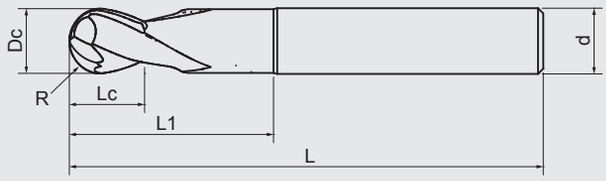
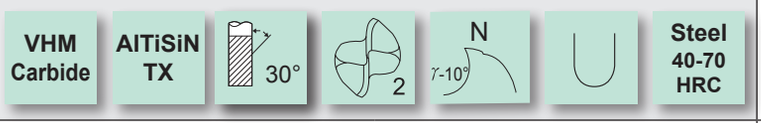
F625TX / F626TX 極超微粒鎢鋼塗層圓頭立銑刀

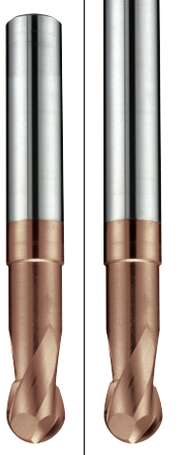
Ball Nose End Mills

Designed with S-style ball nose geometry.
Reduce surface cutting resistance.
Good wear resistance and lubricating effect with Nano multilayer coating
With SMG carbide material is good for cutting hardened materials < 70HRC.

S型球頭幾何設計。
可降低曲面切削阻力。
採用奈米多層膜塗層具有優異的潤滑及耐磨性。
SMG刀具材料適用切削硬材料。







With stronger strength of cutting edge is suitable for hardened steels from 40~70HRC.
Application for finishing profile cutting.

刀口強度適合切削於HRC40~70範圍各種鋼材。
適用於曲面輪廓精切削加工應用。

H H

DIN 6527 Standard Length

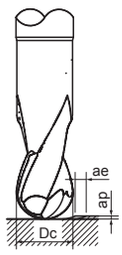
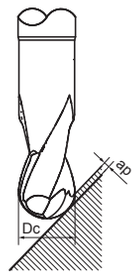
Dc $^{0}_{-0.02}$	R ±0.005	Lc mm	L mm	d h5	L1 mm	D1 mm	F625TX AlTiSiN					
1	0.5R	1	50	6	3	0.95	●					
1.5	0.75R	2	50	6	4	1.4	●					
2	1R	3	57	6	6	1.9	●					
3	1.5R	4	57	6	9	2.8	●					
4	2R	5	57	6	12	3.7	●					
5	2.5R	6	57	6	15	4.6	●					
6	3R	7	57	6	20	5.5	●					
8	4R	9	63	8	26	7.4	●					
10	5R	11	72	10	31	9.2	●					
12	6R	13	83	12	37	11	●					

Long Length

Dc $^{0}_{-0.02}$	R ±0.005	Lc mm	L mm	d h5	L1 mm	D1 mm		F626TX AlTiSiN				
3	1.5R	4	70	6	9	2.8		●				
4	2R	5	70	6	12	3.7		●				
5	2.5R	6	80	6	15	4.6		●				
6	3R	7	80	6	20	5.5		●				
8	4R	9	100	8	26	7.4		●				
10	5R	11	100	10	31	9.2		●				
12	6R	13	110	12	37	11		●				

切削條件

Cutting Conditions

F625TX F626TX		F625TX				F626TX			
									
		cutting speed Vc (m/min)	feed per tooth fz(mm)	ae	ap	cutting speed Vc (m/min)	feed per tooth fz(mm)	ae	ap
		Hardened Steel Materials							
H	GR5 38~48HRC Hardened Steel	65	0.015xDc	0.02xDc	0.02xDc	65	0.015xDc	0.02xDc	0.02xDc
H	GR6 48~56HRC Hardened Steel	60	0.012xDc	0.02xDc	0.02xDc	60	0.012xDc	0.02xDc	0.02xDc
H	GR7 56~68HRC Hardened Steel	55	0.011xDc	0.02xDc	0.02xDc	55	0.011xDc	0.02xDc	0.02xDc

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。