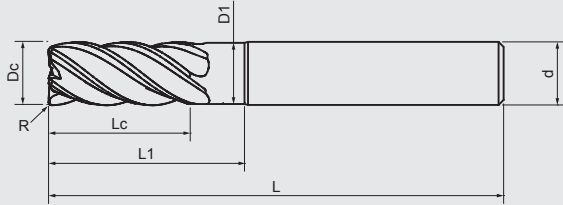


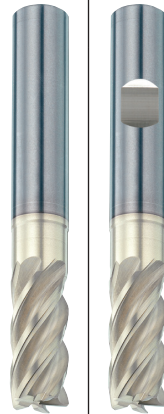
F653SX 超微粒鎢鋼塗層難削材用R角立銑刀

End Mills With Corner Radius For Difficult To Cut Materials

Designed with two variable helix geometry and two unequal flutes. 兩個不等螺旋角。
 Sharp cutting edge is good for cutting toughness materials. 兩個不等分劃刃。
 Designed with high removal cutting geometry. 刀口鋒利適用切割韌性材料。
 Improved cutting edge strength with corner radius. 高移除率刀形幾何設計。
 Good wear resistance and lubricating effect with Nano multilayer coating. 刀尖帶有R角亦可增加刀尖強度。
 採用奈米多層膜塗層具有優異的潤滑及耐磨性。



VHM Carbide
AlTiXN+ZrN SX
38°
不等 5
N 78°
R
Stainless Titanium Nickel



Sharp cutting edge is suitable for cutting stainless steel, titanium, nickel and high temp alloys... etc. 刀口鋒利適用切割於不銹鋼、鈦合金、鎳合金及高溫合金...等材料。
 Application for HPC/ roughing cutting and HSC/ finishing cutting. 適用於HPC粗切加工應用及HSC精切加工應用。

M
S

DIN 6527 Standard Length

Dc 0 -0.02	R ±0.01	Lc mm	L mm	d h5	L1 mm	D1 mm	F653SX HA	F653SX HB				
3	R0.5	8	57	6	14	2.8	●	●				
4	R0.5	11	57	6	16	3.8	●	●				
5	R0.5	13	57	6	18	4.8	●	●				
6	R0.5	13	57	6	20	5.8	●	●				
8	R0.5	19	63	8	26	7.7	●	●				
10	R0.5	22	72	10	31	9.7	●	●				
12	R0.5	26	83	12	37	11.6	●	●				
16	R0.5	32	92	16	43	15.5	●	●				
20	R0.5	38	104	20	53	19.5	●	●				

切削條件

Cutting Conditions

F653SX									
		cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)
Stainless Steel Materials									
M	GR8-1 Ferritic、Martensitic	80		0.003xDc		90		0.004xDc	
	GR8-2 Austenitic	70		0.003xDc		80		0.003xDc	
	GR8-3 Austenitic-ferritic	40		0.002xDc		50		0.003xDc	
	GR8-4 Austenitic-ferritic Heat-resistant	30		0.002xDc		40		0.003xDc	
Cast Iron Materials									
	GRI5 Titanium	35		0.002xDc		40		0.002xDc	
Nickel Materials									
S	GRI6-1 Nickel	30		0.002xDc		35		0.002xDc	
	GRI6-2 cobalt-base alloys	30		0.002xDc		35		0.002xDc	
	GRI6-3 Iron-based alloy	30		0.002xDc		35		0.002xDc	
Heat-resistant Steel Materials									
	GRI7 Heat-resistant Steel	30		0.002xDc		35		0.002xDc	

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。