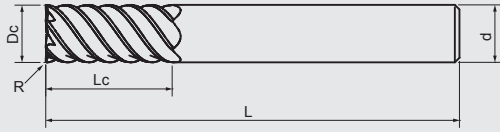


## F660TX / F661TX 極超微粒鎢鋼塗層精加工立銑刀

## Finishing End Mills

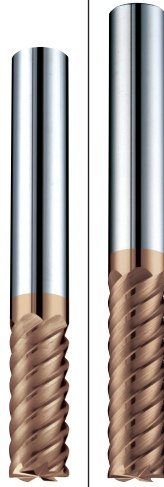
Negative rake angle is good for cutting hardened materials.  
Selected Super SMG as tool material.  
Good wear resistance and lubricating effect with Nano multilayer coating.

刀口負前角設定適用切削硬度材料。  
刀具材料選用特級SMG。  
採用奈米多層膜塗層具有優異的潤滑及耐磨性。



Stronger strength of cutting edge is suitable for various materials from 40-70HRC.  
Various application for finishing cutting.

刀口強度適用切削於40-70HRC範圍各種材料。  
適用於精切削加工應用。



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## DIN 6527 Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	Z	R mm	F660TX AlTiSiN					
6	13	57	6	6	0.2	●					
8	19	63	8	6	0.2	●					
10	22	72	10	6	0.2	●					
12	26	83	12	6	0.2	●					
16	32	92	16	8	0.2	●					
20	38	104	20	10	0.2	●					

## Long Length

Dc 0 -0.02	Lc mm	L mm	d h5	Z	R mm		F661TX AlTiSiN				
6	19	63	6	6	0.2		●				
8	28	72	8	6	0.2		●				
10	34	84	10	6	0.2		●				
12	40	97	12	6	0.2		●				
16	48	108	16	8	0.2		●				
20	56	122	20	10	0.2		●				

切削條件

Cutting Conditions

F660TX F661TX	F660TX			F661TX		
	cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)		
Hardened Steel Materials						
H	GR5 38-48HRC Hardened Steel	150	0.01xDc	130	0.002xDc	
	GR6 48-56HRC Hardened Steel	100	0.008xDc	90	0.0018xDc	
	GR7 56-68HRC Hardened Steel	90	0.007xDc	80	0.0015xDc	

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。