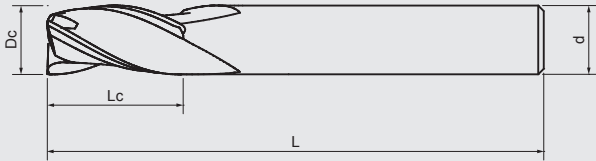


F503HX / F504HX / F603TX 極/超微粒鎢鋼塗層通用立銑刀

Universal End Mills

F503HX / F504HX With MG carbide material is good for cutting materials < 48HRC.
 F603TX With UMG carbide material is good for cutting hardened materials < 62HRC.
 Good wear resistance and lubricating effect with Nano multilayer coating.

F503HX / F504HX MG 刀具材料適用切削軟材料。
 F603TX UMG 刀具材料適用切削硬材料。
 採用奈米多層膜塗層具有優異的潤滑及耐磨性。



VHM Carbide | **AlTiCrN HX** / **AlTiSiN TX** | 30° | 3 | N | 0.05-0.2 | 45°

F503HX / F504HX With sharp cutting edge is good for cutting different steels below 48HRC as well as cast iron.
 F603TX With stronger strength of cutting edge is suitable for steels below 62HRC.
 Various application for general cutting.

F503HX / F504HX 刀口鋒利適用切削於48HRC以下各種鋼材及鑄鐵。
 F603TX 刀口强度高適用於切削於62HRC以下各種鋼材。
 泛用於一般切削加工應用。

P H K	P H K	P H K	P H K	P H	P H
AlTiCrN <48HRC	AlTiCrN <48HRC	AlTiCrN <48HRC	AlTiCrN <48HRC	AlTiSiN <62HRC	AlTiSiN <62HRC

DIN 6527 Stub Length

Dc 0 -0.02	Lc mm	L mm	d h5	45° mm	F503HX HA	F503HX HB				
2	3	50	6	0.02	●	●				
3	4	50	6	0.03	●	●				
4	5	54	6	0.04	●	●				
5	6	54	6	0.05	●	●				
6	7	54	6	0.06	●	●				
8	9	58	8	0.08	●	●				
10	11	66	10	0.10	●	●				
12	12	73	12	0.12	●	●				
14	14	75	14	0.14	●	●				
16	16	82	16	0.16	●	●				
18	18	84	18	0.18	●	●				
20	20	92	20	0.20	●	●				

DIN 6527 Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	45° mm			F504HX HA	F504HX HB		
3	7	57	6	0.03			●	●		
4	8	57	6	0.04			●	●		
5	10	57	6	0.05			●	●		
6	10	57	6	0.06			●	●		
8	16	63	8	0.08			●	●		
10	19	72	10	0.10			●	●		
12	22	83	12	0.12			●	●		
14	22	83	14	0.14			●	●		
16	26	92	16	0.16			●	●		
18	26	92	18	0.18			●	●		
20	32	104	20	0.20			●	●		

DIN 6527 Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	45° mm					F603TX HA	F603TX HB
3	7	57	6	0.03					●	●
4	8	57	6	0.04					●	●
5	10	57	6	0.05					●	●
6	10	57	6	0.06					●	●
8	16	63	8	0.08					●	●
10	19	72	10	0.10					●	●
12	22	83	12	0.12					●	●
16	26	92	16	0.16					●	●
20	32	104	20	0.20					●	●

切削條件

Cutting Conditions

F503HX F504HX F603TX		F503HX		F503HX		F504HX		F504HX		F603TX		F603TX		F603TX	
		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)	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)
Carbon Steel Materials															
P	GR1 Carbon Steel	120	0.004xDc	120	0.005xDc	130	0.005xDc	140	0.006xDc	120	0.004xDc	120	0.005xDc	130	0.005xDc
	GR2 <24HRC Low-alloyed Steel	120	0.003xDc	120	0.004xDc	130	0.004xDc	140	0.005xDc	120	0.003xDc	120	0.004xDc	130	0.004xDc
	GR3 <30HRC Hi-alloyed Steel	80	0.003xDc	80	0.003xDc	90	0.003xDc	100	0.004xDc	80	0.003xDc	80	0.003xDc	90	0.003xDc
Hardened Steel Materials															
H	GR4 30-38HRC Hardened Steel	65	0.002xDc	65	0.002xDc	65	0.002xDc	70	0.002xDc	65	0.002xDc	65	0.002xDc	65	0.002xDc
	GR5 38-48HRC Hardened Steel	60	0.0018xDc	60	0.0018xDc	60	0.0018xDc	65	0.0018xDc	60	0.0018xDc	60	0.0018xDc	60	0.0018xDc
	GR6 48-56HRC Hardened Steel									55	0.0015xDc	55	0.0015xDc	55	0.0015xDc
Cast Iron Materials															
K	GR9-1 Grey cast iron	120	0.004xDc	120	0.005xDc	130	0.005xDc	140	0.006xDc						
	GR9-2 Nodular cast iron	120	0.004xDc	120	0.005xDc	130	0.005xDc	140	0.006xDc						

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。