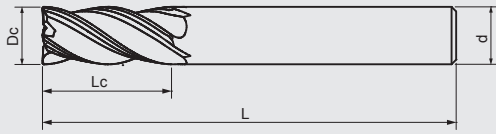


## F604TX / F606TX 極超微粒鎢鋼塗層精加工立銑刀

## Finishing End Mills

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

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。

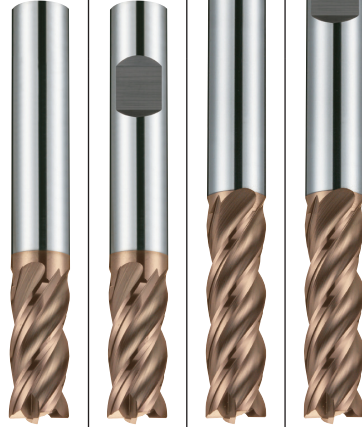


VHM  
Carbide

AITiSiN  
TX



Steel  
<62HRC



With stronger strength of cutting edge is suitable for steels below 62HRC.  
Various application for finishing cutting

刀口强度高適用於切削於62HRC以下各種鋼材。  
泛用於精切削加工應用。

P  
H

P  
H

P  
H

P  
H

## DIN 6527 Standard Length

Dc 0 -0.02	Lc mm	L mm	d h5	45° mm	F604TX HA	F604TX HB				
3	8	57	6	0.03	●	●				
4	11	57	6	0.04	●	●				
5	13	57	6	0.05	●	●				
6	13	57	6	0.06	●	●				
8	19	63	8	0.08	●	●				
10	22	72	10	0.10	●	●				
12	26	83	12	0.12	●	●				
16	32	92	16	0.16	●	●				
20	38	104	20	0.20	●	●				

## Long Length

Dc 0 -0.02	Lc mm	L mm	d h5	45° mm			F606TX HA	F606TX HB		
3	12	63	6	0.03			●	●		
4	17	63	6	0.04			●	●		
5	19	63	6	0.05			●	●		
6	19	63	6	0.06			●	●		
8	28	72	8	0.08			●	●		
10	34	84	10	0.10			●	●		
12	40	97	12	0.12			●	●		
16	48	108	16	0.16			●	●		
20	56	122	20	0.20			●	●		

切削條件

Cutting Conditions

F604TX F606TX		F504TX		F504TX		F506TX		F506TX	
		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)
<b>Carbon Steel Materials</b>									
P	GR1 Carbon Steel	120	0.004xDc	120	0.005xDc	130	0.005xDc	140	0.004xDc
	GR2 <24HRC Low-alloyed Steel	120	0.003xDc	120	0.004xDc	130	0.004xDc	140	0.003xDc
	GR3 <30HRC Hi-alloyed Steel	80	0.003xDc	80	0.003xDc	90	0.003xDc	100	0.003xDc
<b>Hardened Steel Materials</b>									
H	GR4 30-38HRC Hardened Steel	65	0.002xDc	65	0.002xDc	65	0.002xDc	70	0.002xDc
	GR5 38-48HRC Hardened Steel	60	0.0018xDc	60	0.0018xDc	60	0.0018xDc	65	0.0018xDc
	GR6 48-56HRC Hardened Steel	55	0.0015xDc	55	0.0015xDc	55	0.0015xDc	60	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。