

B258X 極超微粒鎢鋼塗層R角立銑刀

End Mills With Corner Radius

UMG Carbide

AlTiN X-NaNo



Type of Operation



Work Material

P	H	M	K	N	S
●	●	○	●	○	○

P 鋼鐵 Steel

H 硬化鋼 <38HRC Hardened Steel

H 硬化鋼 <48HRC Hardened Steel

H 硬化鋼 <56HRC Hardened Steel

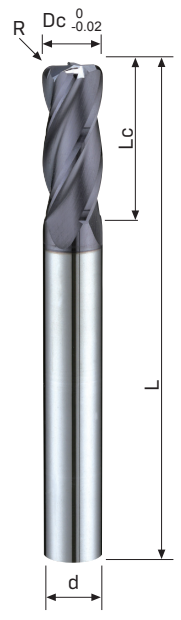
M 不銹鋼 Stainless Steel

K 鑄鐵 Cast Iron

N 銅 Copper

Feature of product:

4刃R角加長立銑刀
 廣泛用於3D曲面輪廓粗、精加工。
 採用AlTiN高鋁鈦塗層具有良好的耐磨性。
 可用於硬度HRC56以下各式鋼鐵材料。



Code No. B258X-Dc×R

Dc 0 -0.02	R ±0.01	Lc mm	L mm	d h6	AlTiN B258X
3	R0.1	10	50	3	●
3	R0.2	10	50	3	●
3	R0.3	10	50	3	●
3	R0.5	10	50	3	●
4	R0.1	15	60	4	●
4	R0.2	15	60	4	●
4	R0.3	15	60	4	●
4	R0.5	15	60	4	●
4	R1	15	60	4	●
5	R0.2	18	70	5	●
5	R0.3	18	70	5	●
5	R0.5	18	70	5	●
5	R1	18	70	5	●
6	R0.2	20	80	6	●
6	R0.3	20	80	6	●
6	R0.5	20	80	6	●
6	R1	20	80	6	●
6	R1.5	20	80	6	●
6	R2	20	80	6	●
8	R0.2	25	100	8	●
8	R0.3	25	100	8	●
8	R0.5	25	100	8	●
8	R1	25	100	8	●
8	R1.5	25	100	8	●
8	R2	25	100	8	●
8	R3	25	100	8	●
10	R0.2	30	100	10	●
10	R0.3	30	100	10	●
10	R0.5	30	100	10	●
10	R1	30	100	10	●
10	R1.5	30	100	10	●
10	R2	30	100	10	●
10	R3	30	100	10	●
12	R0.2	40	110	12	●
12	R0.3	40	110	12	●
12	R0.5	40	110	12	●
12	R1	40	110	12	●
12	R1.5	40	110	12	●
12	R2	40	110	12	●
12	R3	40	110	12	●
16	R0.5	50	140	16	●
16	R1	50	140	16	●
16	R1.5	50	140	16	●
16	R2	50	140	16	●
16	R3	50	140	16	●
16	R4	50	140	16	●
20	R0.5	60	160	20	●
20	R1	60	160	20	●
20	R1.5	60	160	20	●
20	R2	60	160	20	●
20	R3	60	160	20	●
20	R4	60	160	20	●
20	R5	60	160	20	●

B258X 切削條件參考表

Recommended Milling Conditions

Side Milling 側面切削

被削材 Work Material		GR.1 碳鋼 Carbon Steel		GR.2 低合金鋼 Low-alloyed Steel (~24HRC)		GR.3 高合金鋼 Hi-alloyed Steel (~30HRC)		GR.4 硬化鋼 Hardened Steel (30~38HRC)		GR.5 硬化鋼 Hardened Steel (38~48HRC)		GR.6 硬化鋼 Hardened Steel (48~56HRC)		GR.9 鑄鐵 Cast Iron			
切削速度 Vc m/min		85		85		75		70		60		30		85			
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min-1)		Feed 進給速度 (mm/min)		RPM 迴轉速度 (min-1)		Feed 進給速度 (mm/min)		RPM 迴轉速度 (min-1)		Feed 進給速度 (mm/min)		RPM 迴轉速度 (min-1)		Feed 進給速度 (mm/min)	
		B258X-3	3	8,800	500	8,800	500	7,200	350	7,200	350	5,300	125	2,700	60	8,800	500
B258X-4	4	6,600	530	6,600	530	5,500	360	5,500	360	4,200	130	2,200	70	6,600	530		
B258X-5	5	5,300	600	5,300	600	4,350	420	4,350	420	3,500	140	1,900	75	5,300	600		
B258X-6	6	4,500	610	4,500	610	3,700	425	3,700	425	2,900	145	1,500	70	4,500	610		
B258X-8	8	3,300	590	3,300	590	2,700	425	2,700	425	2,200	145	1,100	65	3,300	590		
B258X-10	10	2,600	580	2,600	580	2,200	420	2,200	420	1,700	145	950	65	2,600	580		
B258X-12	12	2,200	580	2,200	580	1,800	420	1,800	420	1,400	140	800	60	2,200	580		
B258X-16	16	1,600	530	1,600	530	1,300	400	1,300	400	1,200	130	600	45	1,600	530		
B258X-20	20	1,300	510	1,300	510	1,100	370	1,100	370	890	110	470	35	1,300	510		
切入深度 (mm)		ap:1.5D		ap:1.5D		ap:1.5D		ap:1.5D		ap:1.5D		ap:1.5D		ap:1.5D			
		ae:0.1D		ae:0.1D		ae:0.1D		ae:0.1D		ae:0.1D		ae:0.02D		ae:0.1D			

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。