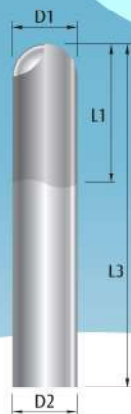


銅鋁用圓頭立銑刀 Ball Nose End Mills

經濟型系列
Economy Series



產品規格 / SPECIFICATIONS

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.
DBC0102	R0.5	2	50	4
DBC0152	R0.75	3	50	4
DBC0202	R1	4	50	4
DBC0302	R1.5	6	50	3
DBC0402	R2	8	50	4
DBC0602	R3	12	50	6
DBC0802	R4	16	60	8
DBC1002	R5	20	75	10
DBC1202	R6	24	75	12

unit : mm

直徑 D1	球頭公差值 R Tolerance	柄徑 D2	柄徑公差值 D2 Tolerance
R0.5	±0.01	Ø3	$\begin{smallmatrix} 0 \\ -0.006 \end{smallmatrix}$
R0.75	±0.01	Ø4	$\begin{smallmatrix} 0 \\ -0.008 \end{smallmatrix}$
R1	±0.01	Ø6	$\begin{smallmatrix} 0 \\ -0.008 \end{smallmatrix}$
R1.5	±0.01	Ø8	$\begin{smallmatrix} 0 \\ -0.009 \end{smallmatrix}$
R2	±0.01	Ø10	$\begin{smallmatrix} 0 \\ -0.009 \end{smallmatrix}$
R3	±0.01	Ø12	$\begin{smallmatrix} 0 \\ -0.011 \end{smallmatrix}$
R4	±0.01	unit : mm	
R5	±0.015		
R6	±0.015		

DBC

建議機器轉速 $RPM = 10000 \text{ (min}^{-1}\text{)}$ 以下
 < Be used under the machine of $RPM = 10000 \text{ (min}^{-1}\text{)}$ >

切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 Wet coolant					
型號 Type NO.	刀具伸長量 Extension Length(mm)	切削速度 Cutting Speed(m/min)	迴轉速度 Speed (min^{-1})	進給速度 Feed (mm/min)	加工深度 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
DBC0102	10	30	9500~10000	600~1000	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0102	10	30	9500~10000	1000~1400	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0152	12	45	9500~10000	800~1200	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0152	12	45	9500~10000	1200~1600	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0202	12	60	9000~9500	1000~1400	0.1~0.13	0.2~0.25	3D 銑 (3D milling)
DBC0202	12	60	9000~9500	1600~2000	0.04~0.06	0.06~0.1	3D 銑 (3D milling)
DBC0302	14	85	9000~9500	1100~1500	0.12~0.15	0.23~0.28	3D 銑 (3D milling)
DBC0302	14	85	9000~9500	1800~2200	0.05~0.07	0.8~0.12	3D 銑 (3D milling)
DBC0402	14	115	9000~9500	1400~1800	0.15~0.18	0.3~0.4	3D 銑 (3D milling)
DBC0402	14	115	9000~9500	1800~2200	0.06~0.08	0.1~0.13	3D 銑 (3D milling)
DBC0602	20	160	8500~9000	1400~1800	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DBC0602	20	170	9000~9500	1800~2200	0.08~0.1	0.12~0.15	3D 銑 (3D milling)
DBC0802	25	200	8000~8500	1600~2000	0.25~0.3	0.5~0.6	3D 銑 (3D milling)
DBC0802	25	230	9000~9500	2000~2400	0.08~0.13	0.15~0.2	3D 銑 (3D milling)
DBC1002	35	255	8000~8500	1600~2000	0.3~0.35	0.7~0.8	3D 銑 (3D milling)
DBC1002	35	285	9000~9500	2000~2400	0.1~0.15	0.18~0.23	3D 銑 (3D milling)
DBC1202	40	290	7700~8200	1600~2000	0.4~0.45	0.8~1	3D 銑 (3D milling)
DBC1202	40	290	7700~8200	2000~2400	0.13~0.16	0.2~0.25	3D 銑 (3D milling)

DBC

建議機器轉速 $RPM = 20000 \text{ (min}^{-1}\text{)}$ 以下< Be used under the machine of $RPM = 20000 \text{ (min}^{-1}\text{)}$ >

切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 Wet coolant					
型號 Type NO.	刀具伸長量 Extension Length(mm)	切削速度 Cutting Speed(m/min)	迴轉速度 Speed (min^{-1})	進給速度 Feed (mm/min)	加工深度 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
DBC0102	10	65	19000~20000	800~1200	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0102	10	65	19000~20000	1200~1600	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0152	12	90	18000~19000	1000~1400	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0152	12	90	18000~19000	1400~1800	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0202	12	120	18000~19000	1200~1600	0.1~0.13	0.2~0.25	3D 銑 (3D milling)
DBC0202	12	120	18000~19000	1800~2200	0.04~0.06	0.06~0.1	3D 銑 (3D milling)
DBC0302	14	160	17000~18000	1300~1700	0.12~0.15	0.23~0.28	3D 銑 (3D milling)
DBC0302	14	160	17000~18000	2000~2400	0.05~0.07	0.8~0.12	3D 銑 (3D milling)
DBC0402	14	200	16000~17000	1600~2000	0.15~0.18	0.3~0.4	3D 銑 (3D milling)
DBC0402	14	200	16000~17000	2000~2400	0.06~0.08	0.1~0.13	3D 銑 (3D milling)
DBC0602	20	285	15000~16000	1600~2000	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DBC0602	20	285	15000~16000	2000~2400	0.08~0.1	0.12~0.15	3D 銑 (3D milling)
DBC0802	25	330	13000~14000	2000~2400	0.25~0.3	0.5~0.6	3D 銑 (3D milling)
DBC0802	25	330	13000~14000	2400~2800	0.08~0.13	0.15~0.2	3D 銑 (3D milling)
DBC1002	35	380	12000~13000	2000~2400	0.3~0.35	0.7~0.8	3D 銑 (3D milling)
DBC1002	35	380	12000~13000	2400~2800	0.1~0.15	0.18~0.23	3D 銑 (3D milling)
DBC1202	40	415	11000~12000	2000~2400	0.4~0.45	0.8~1	3D 銑 (3D milling)
DBC1202	40	415	11000~12000	2400~2800	0.13~0.16	0.2~0.25	3D 銑 (3D milling)