

DHB DIB2T

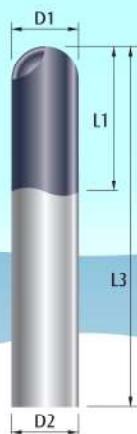


超微粒長柄圓頭立銑刀 Ball Nose End Mills

經濟型系列
Economy Series

Long Shank

	乾式切削 Dry Machining
	油霧切削 MQL (Mist)
	水溶性切削 Emulsion Machining
	油性切削 Oil Machining
	精銑 Finishing
	中銑 Semi-finishing
	粗銑 Roughing



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.
DHB0202	R1	4	75	6
DHB0252	R1.25	5	75	6
DHB0302	R1.5	6	75	6
DHB0402	R2	8	75	6
DHB0502	R2.5	10	75	6
DHB0602	R3	12	75	6
DHB0802	R4	16	75	8
DIB0202	R1	4	100	6
DIB0302	R1.5	6	100	6
DIB0402	R2	8	100	6
DIB0602	R3	12	100	6
DIB0802	R4	16	100	8
DIB1002	R5	20	100	10
DIB1202	R6	24	100	12

unit : mm

直徑 D1	球頭公差值 R Tolerance	柄徑 D2	柄徑公差值 D2 Tolerance
R1	±0.01	Ø6	$\frac{0}{-0.008}$
R1.5	±0.01	Ø8	$\frac{0}{-0.009}$
R2	±0.01	Ø10	$\frac{0}{-0.009}$
R2.5	±0.01	Ø12	$\frac{0}{-0.011}$
R3	±0.01		
R4	±0.01		
R5	±0.015		
R6	±0.015		

unit : mm

DHB.DIB^{2T}

切削條件表 MILLING CONDITIONS

被切削材 Work Material		合金工具鋼 / 碳工具鋼 : Alloy Tool Steels / Carbon Tool Steels P20 / P5 / SK3 / SKD61 / SKD11 : 1.2311 / 1.1545 / 1.2379 / 1.2344 : H13 / D2 (HRc23~32)					
冷卻方式 Coolant Type		乾式切削 Dry 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 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
DHB0202	40	100	15000~16000	900~1200	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DHB0252	40	125	15000~16000	1000~1300	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DHB0302	40	130	13000~14000	1000~1300	0.04~0.05	0.08~0.1	3D 銑 (3D milling)
DHB0402	40	150	11500~12500	1000~1300	0.04~0.08	0.12~0.16	3D 銑 (3D milling)
DHB0502	40	175	10000~11000	1100~1400	0.04~0.08	0.12~0.16	3D 銑 (3D milling)
DHB0602	40	160	7800~8300	1300~1700	0.1~0.15	0.24~0.3	3D 銑 (3D milling)
DHB0602	40	175	8800~9300	1400~1800	0.05~0.09	0.14~0.18	3D 銑 (3D milling)
DHB0802	40	235	8700~9200	1300~1700	0.12~0.2	0.32~0.4	3D 銑 (3D milling)
DHB0802	40	265	9500~10500	1400~1800	0.05~0.1	0.16~0.2	3D 銑 (3D milling)
DIB0202	50	150	11500~12000	700~1000	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DIB0302	50	150	11500~12000	800~1100	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DIB0402	50	150	11500~12000	900~1200	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DIB0602	50	230	11000~12000	900~1200	0.06~0.08	0.12~0.16	3D 銑 (3D milling)
DIB0802	50	185	6700~7300	900~1200	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DIB0802	50	225	8300~8800	1000~1400	0.06~0.1	0.16~0.2	3D 銑 (3D milling)
DIB1002	60	290	8700~9200	1000~1400	0.09~0.14	0.18~0.28	3D 銑 (3D milling)
DIB1202	60	325	8200~8600	900~1200	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DIB1202	60	325	8200~8600	1000~1400	0.1~0.15	0.2~0.3	3D 銑 (3D milling)