

DB4T



超微粒圓頭立銑刀 Ball Nose End Mills

經濟型系列
Economy Series

Perfect
MG

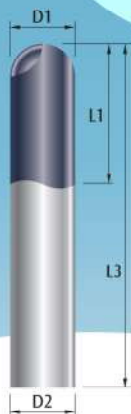
0.6
μm

30°

4-flutes

HRC
>50

T1



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.
DB0104	R0.5	2	50	4
DB0154	R0.75	3	50	4
DB0204	R1	4	50	4
DB0304	R1.5	6	50	4
DB0404	R2	8	50	4
DB0504	R2.5	10	50	6
DB0604	R3	12	50	6
DB0804	R4	16	60	8
DB1004	R5	20	75	10
DB1204	R6	24	75	12
DB1604	R8	32	100	16

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	Ø4	$\begin{smallmatrix} 0 \\ -0.008 \end{smallmatrix}$
R0.75	±0.01	Ø6	$\begin{smallmatrix} 0 \\ -0.008 \end{smallmatrix}$
R1	±0.01	Ø8	$\begin{smallmatrix} 0 \\ -0.009 \end{smallmatrix}$
R1.5	±0.01	Ø10	$\begin{smallmatrix} 0 \\ -0.009 \end{smallmatrix}$
R2	±0.01	Ø12	$\begin{smallmatrix} 0 \\ -0.011 \end{smallmatrix}$
R2.5	±0.01	Ø16	$\begin{smallmatrix} 0 \\ -0.011 \end{smallmatrix}$
R3	±0.01	unit : mm	
R4	±0.01		
R5	±0.015		
R6	±0.015		
R8	±0.02		

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切削條件表 MILLING CONDITIONS

被切削材 Work Material		碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron S50C / Fc250 / SS400 : 1.1210 / 0.6025 / 1.0036 : 1050 / N0.35 / A570 Gr.45 (~HRc22)					
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
DB0104	10	60	18000~20000	800~1200	0.06~0.08	0.12~0.16	3D 銑 (3D milling)
DB0104	10	60	18000~20000	1100~1500	0.02~0.04	0.04~0.08	3D 銑 (3D milling)
DB0154	10	90	18000~20000	800~1200	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0154	10	90	18000~20000	1100~1500	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0204	12	120	18000~20000	800~1200	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0204	12	120	18000~20000	1100~1500	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0304	13	150	16000~17000	800~1200	0.1~0.12	0.2~0.24	3D 銑 (3D milling)
DB0304	13	150	16000~17000	1100~1500	0.05~0.07	0.1~0.14	3D 銑 (3D milling)
DB0404	15	190	15000~16000	800~1200	0.11~0.13	0.22~0.26	3D 銑 (3D milling)
DB0404	15	190	15000~16000	1200~1600	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0504	18	220	14000~15000	800~1200	0.13~0.16	0.26~0.32	3D 銑 (3D milling)
DB0504	18	220	14000~15000	1200~1600	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0604	20	245	13000~14000	1100~1500	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB0604	20	245	13000~14000	1400~1800	0.07~0.11	0.14~0.22	3D 銑 (3D milling)
DB0804	25	305	12000~13000	1100~1500	0.18~0.23	0.36~0.46	3D 銑 (3D milling)
DB0804	25	305	12000~13000	1500~1900	0.08~0.13	0.16~0.26	3D 銑 (3D milling)
DB1004	35	285	8700~9200	1100~1500	0.23~0.28	0.46~0.56	3D 銑 (3D milling)
DB1004	35	285	8700~9200	1500~1900	0.1~0.15	0.2~0.3	3D 銑 (3D milling)
DB1204	40	265	7000~8000	1100~1500	0.27~0.32	0.54~0.64	3D 銑 (3D milling)
DB1204	40	265	7000~8000	1500~1900	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB1604	50	255	5000~6000	900~1200	0.35~0.4	0.7~0.8	3D 銑 (3D milling)
DB1604	50	255	5000~6000	1200~1600	0.18~0.23	0.36~0.46	3D 銑 (3D milling)

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切削條件表 MILLING CONDITIONS

被切削材 Work Material

調質鋼 / 預硬鋼 : Prehardened Steels
NAK80 : 1.2083 : AISI420 : M310 (HRc 36~45)

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
DB0104	10	50	16000~17000	400~700	0.06~0.08	0.12~0.16	3D 銑 (3D milling)
DB0104	10	50	16000~17000	700~1000	0.02~0.04	0.04~0.08	3D 銑 (3D milling)
DB0154	10	80	16000~17000	400~700	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0154	10	80	16000~17000	700~1000	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0204	12	100	15000~16000	400~700	0.07~0.09	0.14~0.18	3D 銑 (3D milling)
DB0204	12	100	15000~16000	700~1000	0.03~0.05	0.06~0.1	3D 銑 (3D milling)
DB0304	13	135	14000~15000	400~700	0.09~0.11	0.18~0.22	3D 銑 (3D milling)
DB0304	13	135	14000~15000	700~1000	0.04~0.06	0.08~0.12	3D 銑 (3D milling)
DB0404	15	170	13000~14000	500~800	0.11~0.13	0.22~0.26	3D 銑 (3D milling)
DB0404	15	170	13000~14000	1000~1400	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0504	18	195	12000~13000	600~900	0.11~0.13	0.22~0.26	3D 銑 (3D milling)
DB0504	18	195	12000~13000	1000~1400	0.06~0.08	0.14~0.22	3D 銑 (3D milling)
DB0604	20	215	11000~12000	700~1000	0.15~0.18	0.3~0.36	3D 銑 (3D milling)
DB0604	20	215	11000~12000	1100~1500	0.07~0.11	0.14~0.22	3D 銑 (3D milling)
DB0804	25	240	9000~10000	900~1200	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB0804	25	240	9000~10000	1200~1600	0.08~0.12	0.16~0.24	3D 銑 (3D milling)
DB1004	35	235	7000~8000	900~1200	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DB1004	35	235	7000~8000	1200~1600	0.1~0.15	0.2~0.3	3D 銑 (3D milling)
DB1204	40	190	5000~6000	800~1100	0.27~0.32	0.54~0.64	3D 銑 (3D milling)
DB1204	40	190	5000~6000	1200~1600	0.15~0.2	0.3~0.4	3D 銑 (3D milling)
DB1604	50	255	4500~5500	600~900	0.3~0.35	0.6~0.7	3D 銑 (3D milling)
DB1604	50	255	4500~5500	1000~1300	0.15~0.23	0.36~0.46	3D 銑 (3D milling)