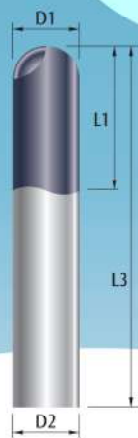


# DB2T



## 超微粒圓頭立銑刀 Ball Nose End Mills

經濟型系列  
Economy Series



### 產品規格 / SPECIFICATIONS

| 型號<br>Type No. | D1<br>直徑<br>Diameter | L1<br>刃長<br>Flute Length | L3<br>全長<br>O.A.L. | D2<br>柄徑<br>Shank Dia. |
|----------------|----------------------|--------------------------|--------------------|------------------------|
| DB0102         | R0.5                 | 2                        | 50                 | 4                      |
| DB0152         | R0.75                | 3                        | 50                 | 4                      |
| DB0202         | R1                   | 4                        | 50                 | 4                      |
| DB0252         | R1.25                | 5                        | 50                 | 4                      |
| DB0302         | R1.5                 | 6                        | 50                 | 4                      |
| DB0402         | R2                   | 8                        | 50                 | 4                      |
| DB0502         | R2.5                 | 10                       | 50                 | 6                      |
| DB0602         | R3                   | 12                       | 50                 | 6                      |
| DB0802         | R4                   | 16                       | 60                 | 8                      |
| DB1002         | R5                   | 20                       | 75                 | 10                     |
| DB1202         | R6                   | 24                       | 75                 | 12                     |
| DB1602         | R8                   | 32                       | 100                | 16                     |

unit : mm

| 直徑<br>D1 | 球頭公差值<br>R Tolerance | 柄徑<br>D2  | 柄徑公差值<br>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                |           |                                                     |

# DB<sup>2T</sup>

## 切削條件表 MILLING CONDITIONS

| 被切削材 Work Material |                                  | 碳素鋼 / 鑄鐵 : Carbon Steels / Cast Iron<br>S50C / Fc250 / S5440 : 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<br>Type NO.     | 刀具伸長量<br>Extension<br>Length(mm) | 切削速度<br>Cutting<br>Speed(m/min)                                                                                              | 迴轉速度<br>Speed<br>(min <sup>-1</sup> ) | 進給速度<br>Feed<br>(mm/min) | 加工深度<br>(Aa)<br>Depth of Cut | 加工寬度<br>(Ap)<br>Width of Cut | 加工方式<br>Milling Type |
| DB0102             | 10                               | 60                                                                                                                           | 18000~20000                           | 600~900                  | 0.05~0.08                    | 0.12~0.16                    | 3D 銑 (3D milling)    |
| DB0102             | 10                               | 60                                                                                                                           | 18000~20000                           | 800~1200                 | 0.02~0.04                    | 0.04~0.08                    | 3D 銑 (3D milling)    |
| DB0152             | 10                               | 90                                                                                                                           | 18000~20000                           | 600~900                  | 0.05~0.09                    | 0.14~0.18                    | 3D 銑 (3D milling)    |
| DB0152             | 10                               | 90                                                                                                                           | 18000~20000                           | 800~1200                 | 0.03~0.05                    | 0.06~0.1                     | 3D 銑 (3D milling)    |
| DB0202             | 12                               | 120                                                                                                                          | 18000~20000                           | 600~900                  | 0.05~0.09                    | 0.14~0.18                    | 3D 銑 (3D milling)    |
| DB0202             | 12                               | 120                                                                                                                          | 18000~20000                           | 800~1200                 | 0.03~0.05                    | 0.06~0.1                     | 3D 銑 (3D milling)    |
| DB0252             | 12                               | 135                                                                                                                          | 17000~18000                           | 600~900                  | 0.06~0.1                     | 0.16~0.2                     | 3D 銑 (3D milling)    |
| DB0252             | 12                               | 135                                                                                                                          | 17000~18000                           | 800~1200                 | 0.04~0.06                    | 0.08~0.12                    | 3D 銑 (3D milling)    |
| DB0302             | 13                               | 150                                                                                                                          | 16000~17000                           | 600~900                  | 0.07~0.12                    | 0.2~0.24                     | 3D 銑 (3D milling)    |
| DB0302             | 13                               | 150                                                                                                                          | 16000~17000                           | 800~1200                 | 0.05~0.07                    | 0.1~0.14                     | 3D 銑 (3D milling)    |
| DB0402             | 15                               | 190                                                                                                                          | 15000~16000                           | 600~900                  | 0.1~0.14                     | 0.22~0.26                    | 3D 銑 (3D milling)    |
| DB0402             | 15                               | 190                                                                                                                          | 15000~16000                           | 900~1300                 | 0.06~0.08                    | 0.14~0.22                    | 3D 銑 (3D milling)    |
| DB0502             | 18                               | 220                                                                                                                          | 14000~15000                           | 600~900                  | 0.1~0.16                     | 0.26~0.32                    | 3D 銑 (3D milling)    |
| DB0502             | 18                               | 220                                                                                                                          | 14000~15000                           | 1000~1400                | 0.07~0.09                    | 0.14~0.18                    | 3D 銑 (3D milling)    |
| DB0602             | 20                               | 245                                                                                                                          | 13000~14000                           | 800~1200                 | 0.15~0.2                     | 0.3~0.4                      | 3D 銑 (3D milling)    |
| DB0602             | 20                               | 245                                                                                                                          | 13000~14000                           | 1200~1600                | 0.07~0.11                    | 0.14~0.22                    | 3D 銑 (3D milling)    |
| DB0802             | 30                               | 255                                                                                                                          | 10000~11000                           | 900~1200                 | 0.1~0.23                     | 0.36~0.46                    | 3D 銑 (3D milling)    |
| DB0802             | 30                               | 255                                                                                                                          | 10000~11000                           | 1300~1700                | 0.08~0.13                    | 0.16~0.26                    | 3D 銑 (3D milling)    |
| DB1002             | 35                               | 285                                                                                                                          | 8700~9200                             | 900~1200                 | 0.2~0.28                     | 0.46~0.56                    | 3D 銑 (3D milling)    |
| DB1002             | 35                               | 285                                                                                                                          | 8700~9200                             | 1300~1700                | 0.1~0.15                     | 0.2~0.3                      | 3D 銑 (3D milling)    |
| DB1202             | 40                               | 265                                                                                                                          | 7000~8000                             | 900~1200                 | 0.2~0.3                      | 0.54~0.64                    | 3D 銑 (3D milling)    |
| DB1202             | 40                               | 265                                                                                                                          | 7000~8000                             | 1200~1600                | 0.15~0.2                     | 0.3~0.4                      | 3D 銑 (3D milling)    |
| DB1602             | 50                               | 255                                                                                                                          | 5000~6000                             | 700~1100                 | 0.3~0.4                      | 0.7~0.8                      | 3D 銑 (3D milling)    |
| DB1602             | 50                               | 255                                                                                                                          | 5000~6000                             | 1000~1400                | 0.15~0.2                     | 0.36~0.46                    | 3D 銑 (3D milling)    |