

硬脆材加工用球头铣刀

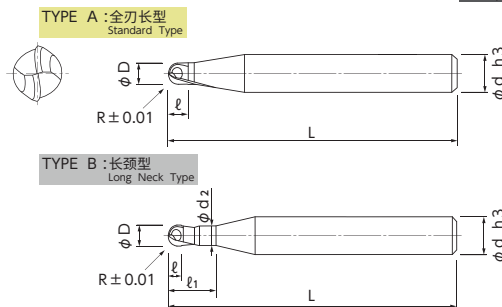
Ball End Mill for Hard Brittle Material

共有12种规格

Total 12 sizes

可对硬质合金、陶瓷、玻璃进行直接加工的球头铣刀

Ball end mill for direct milling on cemented carbide, ceramic and glass



- 采用了刃口的强度和锋利度兼具的螺旋球头形状，以及新开发的高粘性钻石涂层。
- Spiral ball shape with balanced strength and sharpness of cutting edges adopted newly-developed DIAMOND COATING with enhanced sticking force.

[颈部形状]

颈部干涉角度的基准为12°。

如果担心加工材料和颈部会干涉时，请务必实际测量进行确认。

[Neck Profile]

Reference value of interference angle after length of cut is 12°.

Actual measurement required, in order to avoid interference between tool and work material.

单位 [规格:mm/价格:日元]
Unit [Size : mm / Retail Price : JPY]

产品代码 Code No.	(R)球头半径 Radius	(l1)颈长 Under Neck Length	(l)刃长 Length of Cut	形状 Type	(d2)颈径 Neck Dia.	(d)柄径 Shank Dia.	(L)全长 Overall Length	定价(日元) Retail Price
05-00500-00100	R0.1	-	0.15	A	-	4	45	39,900
05-00500-00101		0.5	0.12	B	0.18	4	45	40,300
05-00500-00200	R0.2	-	0.3	A	-	4	45	36,800
05-00500-00201		1	0.25	B	0.37	4	45	37,200
05-00500-00300	R0.3	-	0.45	A	-	4	45	32,700
05-00500-00301		1.5	0.35	B	0.56	4	45	33,100
05-00500-00500	R0.5	-	0.75	A	-	4	45	32,700
05-00500-00501		2.5	0.6	B	0.95	4	45	33,100
05-00500-00750	R0.75	-	1.1	A	-	4	45	32,700
05-00500-00751		3.8	0.9	B	1.45	4	45	33,100
05-00500-01000	R1	-	1.5	A	-	4	45	32,700
05-00500-01001		5	1.2	B	1.94	4	45	33,100

订购方法 How to Order

请指定DCMB 球头半径(R) [×颈长(l1)]。
When you order, indicate DCMB (R) [×(l1)].

加工案例 1 Machining Case 1

加工材料：硬质合金（硬度：89HRA）
Work Material : Cemented Carbide (89HRA)



工件尺寸：20×20×10mm
Work size : 20×20×10mm

使用刀具：DCMB R1
Tool

精加工 Finishing

主轴转速 Spindle speed	20,000min ⁻¹
进给速度 Feed	200mm/min
切深量 Depth of cut	0,005mm×0,01mm (ap×ae)
加工时间 Machining time	3小时55分钟 3hr 55min
冷却方式 Coolant	油雾 Oil mist

表面粗糙度(Rz) : 0.51 μm ~ 1.04 μm
Surface roughness

球头

全刃长
Full Cutting Length

长颈
Long Neck

Ball

涂层
Coating

硬脆材
Hard Brittle
Material

硬脆材加工
Hard Brittle
Material Milling