

600⁺ 切削條件表 P351 Cutting Condition

Ball Nose Type - Long Neck - 2 flutes 2刃深溝長頸球型立銑刀

600 PLUS

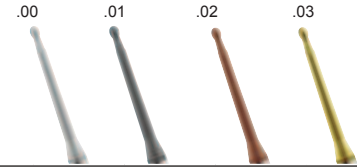
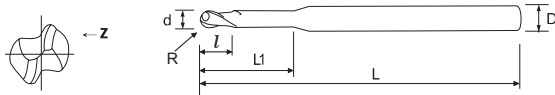
HRC > 45

35°

a/b > a

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



HRC > 40

HRC > 45

HRC > 50

HRC > 55

HRC > 60

HRC > 65

HRC > 70

HRC > 75

HRC > 80

HRC > 85

HRC > 90

HRC > 95

HRC > 100

HRC > 105

HRC > 110

HRC > 115

HRC > 120

HRC > 125

HRC > 130

HRC > 135

HRC > 140

HRC > 145

HRC > 150

Dimension 規格							Purchase Code 採購代碼				
Diameter	Radius	Flute Length	Efficient Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層			
d 刃徑	R 值	Z 刃長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號	ALTIBN	TISIN	ZrN-A	
0.5	0.25	0.75	2	50	4	2	P-LNBT05022	.00	.01	.02	.03
0.5	0.25	0.75	4	50	4	2	P-LNBT05042	.00	.01	.02	.03
0.5	0.25	0.75	6	50	4	2	P-LNBT05062	.00	.01	.02	.03
0.6	0.3	0.9	2	50	4	2	P-LNBT06022	.00	.01	.02	.03
0.6	0.3	0.9	4	50	4	2	P-LNBT06042	.00	.01	.02	.03
0.6	0.3	0.9	6	50	4	2	P-LNBT06062	.00	.01	.02	.03
0.8	0.4	1.2	4	50	4	2	P-LNBT08042	.00	.01	.02	.03
0.8	0.4	1.2	6	50	4	2	P-LNBT08062	.00	.01	.02	.03
0.8	0.4	1.2	8	50	4	2	P-LNBT08082	.00	.01	.02	.03
1	0.5	1.5	6	50	4	2	P-LNBT10062	.00	.01	.02	.03
1	0.5	1.5	8	50	4	2	P-LNBT10082	.00	.01	.02	.03
1	0.5	1.5	10	50	4	2	P-LNBT10102	.00	.01	.02	.03
1	0.5	1.5	12	50	4	2	P-LNBT10122	.00	.01	.02	.03
1.2	0.6	1.8	6	50	4	2	P-LNBT12062	.00	.01	.02	.03
1.2	0.6	1.8	8	50	4	2	P-LNBT12082	.00	.01	.02	.03
1.2	0.6	1.8	10	50	4	2	P-LNBT12102	.00	.01	.02	.03
1.2	0.6	1.8	12	50	4	2	P-LNBT12122	.00	.01	.02	.03
1.4	0.7	2.1	6	50	4	2	P-LNBT14062	.00	.01	.02	.03
1.4	0.7	2.1	10	50	4	2	P-LNBT14102	.00	.01	.02	.03
1.4	0.7	2.1	16	50	4	2	P-LNBT14162	.00	.01	.02	.03
1.5	0.75	2.3	6	50	4	2	P-LNBT15062	.00	.01	.02	.03
1.5	0.75	2.3	8	50	4	2	P-LNBT15082	.00	.01	.02	.03
1.5	0.75	2.3	10	50	4	2	P-LNBT15102	.00	.01	.02	.03
1.5	0.75	2.3	12	50	4	2	P-LNBT15122	.00	.01	.02	.03
1.5	0.75	2.3	14	50	4	2	P-LNBT15142	.00	.01	.02	.03
1.5	0.75	2.3	16	50	4	2	P-LNBT15162	.00	.01	.02	.03
1.5	0.75	2.3	18	50	4	2	P-LNBT15182	.00	.01	.02	.03
1.5	0.75	2.3	20	50	4	2	P-LNBT15202	.00	.01	.02	.03
1.6	0.8	2.4	6	50	4	2	P-LNBT16062	.00	.01	.02	.03
1.6	0.8	2.4	8	50	4	2	P-LNBT16082	.00	.01	.02	.03

Application 適用材質：

★ Perfect 最推薦

◎ Excellent 適合

○ Good 佳

Coating 塗層	Carbon steel, Alloy steel 炭素鋼, 合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Titanium alloy 鈦合金	Nickel/Inconel alloy 鎳基合金	Copper alloy 銅合金, 銅	Aluminum alloy 鋁合金
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
	○	○								○	○
ALTIBN	◎	◎	○	○			○				
TISIN	○	○	○	○							
ZrN-A	◎	◎	○	○			◎	○	○		

Unit/單位: mm

600⁺ 切削條件表 **P351**
Cutting Condition

Ball Nose Type - Long Neck - 2 flutes

2刃深溝長頸球型立銑刀

600 PLUS

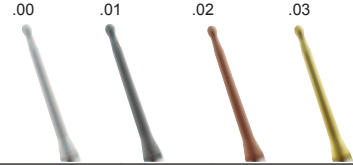
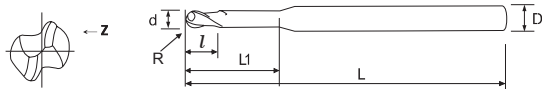
HRC > 45

35°

$a > b$

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



Dimension 規格							Purchase Code 採購代碼				
Diameter	Radius	Flute Length	Efficient Length	Full Length	Shank Diameter	Flutes	MODE	Coating 塗層			
d 刃徑	R 值	Z 刃長	L1 有效長	L 全長	D 柄徑	Z 刃數	型號		ALTIBN	TISIN	ZrN-A
1.6	0.8	2.4	10	50	4	2	P-LNBT16102	.00	.01	.02	.03
1.6	0.8	2.4	12	50	4	2	P-LNBT16122	.00	.01	.02	.03
1.6	0.8	2.4	14	50	4	2	P-LNBT16142	.00	.01	.02	.03
1.6	0.8	2.4	16	50	4	2	P-LNBT16162	.00	.01	.02	.03
1.6	0.8	2.4	18	50	4	2	P-LNBT16182	.00	.01	.02	.03
1.6	0.8	2.4	20	50	4	2	P-LNBT16202	.00	.01	.02	.03
1.8	0.9	2.7	8	50	4	2	P-LNBT18082	.00	.01	.02	.03
1.8	0.9	2.7	14	50	4	2	P-LNBT18142	.00	.01	.02	.03
1.8	0.9	2.7	20	50	4	2	P-LNBT18202	.00	.01	.02	.03
2	1	3	8	50	4	2	P-LNBT20082	.00	.01	.02	.03
2	1	3	10	50	4	2	P-LNBT20102	.00	.01	.02	.03
2	1	3	12	50	4	2	P-LNBT20122	.00	.01	.02	.03
2	1	3	14	50	4	2	P-LNBT20142	.00	.01	.02	.03
2	1	3	16	50	4	2	P-LNBT20162	.00	.01	.02	.03
2	1	3	18	50	4	2	P-LNBT20182	.00	.01	.02	.03
2	1	3	20	50	4	2	P-LNBT20202	.00	.01	.02	.03
2.5	1.25	4	8	50	4	2	P-LNBT25082	.00	.01	.02	.03
2.5	1.25	4	12	50	4	2	P-LNBT25122	.00	.01	.02	.03
2.5	1.25	4	16	50	4	2	P-LNBT25162	.00	.01	.02	.03
2.5	1.25	4	20	50	4	2	P-LNBT25202	.00	.01	.02	.03
3	1.5	4.5	10	50	6	2	P-LNBT30102	.00	.01	.02	.03
3	1.5	4.5	12	50	6	2	P-LNBT30122	.00	.01	.02	.03
3	1.5	4.5	16	60	6	2	P-LNBT30162	.00	.01	.02	.03
3	1.5	4.5	20	60	6	2	P-LNBT30202	.00	.01	.02	.03
3	1.5	4.5	25	75	6	2	P-LNBT30252	.00	.01	.02	.03
4	2	6	12	50	6	2	P-LNBT40122	.00	.01	.02	.03
4	2	6	16	60	6	2	P-LNBT40162	.00	.01	.02	.03
4	2	6	20	75	6	2	P-LNBT40202	.00	.01	.02	.03
4	2	6	25	75	6	2	P-LNBT40252	.00	.01	.02	.03
4	2	6	30	75	6	2	P-LNBT40302	.00	.01	.02	.03

Application 適用材質：

★ Perfect 最推薦

◎ Excellent 適合

○ Good 佳

Coating 塗層	Carbon steel, Alloy steel 炭素鋼, 合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Titanium alloy 鈦合金	Nickel/Inconel alloy 鎳基合金	Copper alloy 銅合金, 銅	Aluminum alloy 鋁合金
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
	○	○								○	○
ALTIBN	◎	◎	○	○			○				
TISIN	○	○	○	○							
ZrN-A	◎	◎	○	○			◎	○	○		

Unit/單位: mm