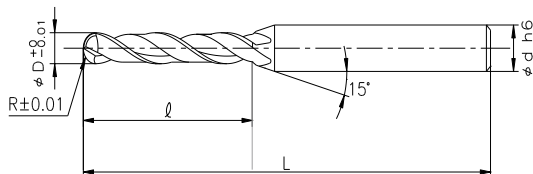


■刃長が刃径の3倍～最大12倍までラインナップ  
Line-upped flute length 3 times to max 12  
times of flute diameter



| 被削材 Workpiece                     |                     |                                   |                             |                 |                         |
|-----------------------------------|---------------------|-----------------------------------|-----------------------------|-----------------|-------------------------|
| 一般構造鋼<br>General Structural Steel | 炭素鋼<br>Caebon Steel | 合金鋼・工具鋼<br>Alloy Steel Tool Steel | プリハードン鋼<br>Pre-Haeden Steel | 鑄鉄<br>Cast Iron | アルミ合金<br>Aluminum Alloy |
| ○                                 | ○                   | ○                                 | ○                           | ○               | ○                       |

●切削条件表はP196に記載  
●Cutting conditions are recommended on page 196.

単位[寸法:mm]  
Unit[size:mm]

| 品番<br>Code No. | R    | 刃径 D<br>Flute Diameter | 刃長 ℓ<br>Flute Length | 全長 L<br>Total Length | 柄径<br>Shank Diameter |
|----------------|------|------------------------|----------------------|----------------------|----------------------|
| KLB-2R01010    | R0.1 | 0.2                    | 1                    | 40                   | 3                    |
| KLB-2R01015    | R0.1 | 0.2                    | 1.5                  | 40                   | 3                    |
| KLB-2R01020    | R0.1 | 0.2                    | 2                    | 40                   | 3                    |
| KLB-2R02020    | R0.2 | 0.4                    | 2                    | 40                   | 3                    |
| KLB-2R02030    | R0.2 | 0.4                    | 3                    | 40                   | 3                    |
| KLB-2R02040    | R0.2 | 0.4                    | 4                    | 40                   | 3                    |
| KLB-2R03040    | R0.3 | 0.6                    | 4                    | 40                   | 3                    |
| KLB-2R03060    | R0.3 | 0.6                    | 6                    | 40                   | 3                    |
| KLB-2R03080    | R0.3 | 0.6                    | 8                    | 40                   | 3                    |
| KLB-2R03100    | R0.3 | 0.6                    | 10                   | 40                   | 3                    |
| KLB-2R04040    | R0.4 | 0.8                    | 4                    | 40                   | 3                    |
| KLB-2R04060    | R0.4 | 0.8                    | 6                    | 40                   | 3                    |
| KLB-2R04080    | R0.4 | 0.8                    | 8                    | 40                   | 3                    |
| KLB-2R04100    | R0.4 | 0.8                    | 10                   | 40                   | 3                    |
| KLB-2R05040    | R0.5 | 1                      | 4                    | 45                   | 4                    |
| KLB-2R05060    | R0.5 | 1                      | 6                    | 45                   | 4                    |
| KLB-2R05080    | R0.5 | 1                      | 8                    | 45                   | 4                    |
| KLB-2R05100    | R0.5 | 1                      | 10                   | 45                   | 4                    |
| KLB-2R10060    | R1   | 2                      | 6                    | 45                   | 4                    |
| KLB-2R10080    | R1   | 2                      | 8                    | 45                   | 4                    |
| KLB-2R10100    | R1   | 2                      | 10                   | 45                   | 4                    |
| KLB-2R10120    | R1   | 2                      | 12                   | 45                   | 4                    |
| KLB-2R10150    | R1   | 2                      | 15                   | 50                   | 4                    |
| KLB-2R10200    | R1   | 2                      | 20                   | 60                   | 4                    |
| KLB-2R15150    | R1.5 | 3                      | 15                   | 70                   | 6                    |
| KLB-2R15200    | R1.5 | 3                      | 20                   | 70                   | 6                    |
| KLB-2R15250    | R1.5 | 3                      | 25                   | 80                   | 6                    |
| KLB-2R15300    | R1.5 | 3                      | 30                   | 80                   | 6                    |
| KLB-2R20150    | R2   | 4                      | 15                   | 70                   | 6                    |
| KLB-2R20200    | R2   | 4                      | 20                   | 80                   | 6                    |

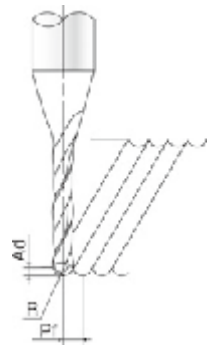
[illegible]

# KLB-2

## 切削条件参考

Referential Cutting Conditions

| R            | 切込み深さ<br>Cutting Depth | ピックフィード<br>Pick Feed |
|--------------|------------------------|----------------------|
|              | Ad                     | Pf                   |
| $R < 0.5$    | 0.02D                  | 0.1D                 |
| $0.5 \leq R$ | 0.04D                  | 0.1D                 |



| 被削材<br>Workpiece          | 炭素鋼・一般構造用鋼<br>Carbon Steel・<br>General Structural Steel<br>S55C・SS材                                                                                                                                                                                                                                                                                                                                   |                        | 合金鋼・工具鋼<br>Alloy Steel・Tool Steel<br><br>SCM・SKT・SKS・SKD |                        | プリハードン鋼<br>Pre-Harden Steel<br><br>HPM-1・NAK55・SKT |                        | 鋳 鉄<br>Cast iron<br><br>FC・FCD         |                        |
|---------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|----------------------------------------------------------|------------------------|----------------------------------------------------|------------------------|----------------------------------------|------------------------|
| R<br>Flute Diameter<br>mm | 回転数<br>Revolution<br>min <sup>-1</sup>                                                                                                                                                                                                                                                                                                                                                                | 送り速度<br>Feed<br>mm/min | 回転数<br>Revolution<br>min <sup>-1</sup>                   | 送り速度<br>Feed<br>mm/min | 回転数<br>Revolution<br>min <sup>-1</sup>             | 送り速度<br>Feed<br>mm/min | 回転数<br>Revolution<br>min <sup>-1</sup> | 送り速度<br>Feed<br>mm/min |
| R0.1                      | 32,000                                                                                                                                                                                                                                                                                                                                                                                                | 25                     | 32,000                                                   | 20                     | 32,000                                             | 10                     | 32,000                                 | 25                     |
| R0.2                      | 32,000                                                                                                                                                                                                                                                                                                                                                                                                | 43                     | 23,000                                                   | 26                     | 19,800                                             | 15                     | 32,000                                 | 45                     |
| R0.3                      | 18,500                                                                                                                                                                                                                                                                                                                                                                                                | 43                     | 13,100                                                   | 26                     | 11,300                                             | 15                     | 18,500                                 | 45                     |
| R0.4                      | 14,500                                                                                                                                                                                                                                                                                                                                                                                                | 43                     | 10,200                                                   | 26                     | 8,800                                              | 15                     | 14,500                                 | 45                     |
| R0.5                      | 13,000                                                                                                                                                                                                                                                                                                                                                                                                | 43                     | 9,500                                                    | 26                     | 7,950                                              | 15                     | 13,000                                 | 45                     |
| R1                        | 6,650                                                                                                                                                                                                                                                                                                                                                                                                 | 46                     | 4,750                                                    | 35                     | 3,950                                              | 20                     | 6,650                                  | 55                     |
| R1.5                      | 4,450                                                                                                                                                                                                                                                                                                                                                                                                 | 55                     | 3,150                                                    | 40                     | 2,650                                              | 20                     | 4,450                                  | 60                     |
| R2                        | 4,450                                                                                                                                                                                                                                                                                                                                                                                                 | 55                     | 3,150                                                    | 40                     | 2,650                                              | 20                     | 4,450                                  | 60                     |
| R3                        | 4,450                                                                                                                                                                                                                                                                                                                                                                                                 | 55                     | 3,150                                                    | 40                     | 2,650                                              | 20                     | 4,450                                  | 60                     |
| 備 考<br>Remarks            | <ul style="list-style-type: none"> <li>• 回転数と送り速度は同じ割合で調整して下さい。</li> <li>• ピックフィードは要求品質に合わせて調整して下さい。</li> <li>• 刃長により回転数、送り速度を調整して下さい。</li> <li>• 切削油を使用して下さい。</li> <li>• Adjust Revolution and Feed Speed at the same rate.</li> <li>• Adjust Pick Feed according to Required Quality.</li> <li>• Adjust Revolution and Feed Speed according to Flute Length.</li> <li>• Use Cutting Oil.</li> </ul> |                        |                                                          |                        |                                                    |                        |                                        |                        |