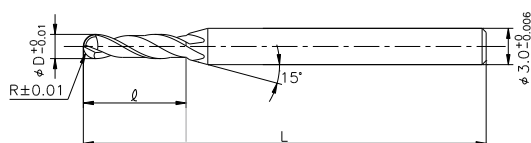


KMBE-2

超硬ミニチュアボールエンドミル
Tungsten Carbide Miniature Ball Endmill

■小径サイズで揃えていますので超精密加工に最適です
Best for ultra-precise processing due to small size



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

●Cutting conditions are recommended on page 194.

Unit [size:mm]

品番 Code No.	R	刃径 D Flute Diameter	刃長 ℓ Flute Length	全長 L Total Length	柄径 Shank Diameter
KMBE-2R0100	R0.1	0.2	0.4	40	3
KMBE-2R0125	R0.125	0.25	0.5	40	3
KMBE-2R0150	R0.15	0.3	1	40	3
KMBE-2R0175	R0.175	0.35	1	40	3
KMBE-2R0200	R0.2	0.4	1	40	3
KMBE-2R0250	R0.25	0.5	1	40	3
KMBE-2R0300	R0.3	0.6	2	40	3
KMBE-2R0350	R0.35	0.7	2	40	3
KMBE-2R0400	R0.4	0.8	2.5	40	3
KMBE-2R0450	R0.45	0.9	2.5	40	3
KMBE-2R0500	R0.5	1	3	40	3
KMBE-2R0550	R0.55	1.1	3	40	3
KMBE-2R0600	R0.6	1.2	3	40	3
KMBE-2R0650	R0.65	1.3	3	40	3
KMBE-2R0700	R0.7	1.4	3	40	3
KMBE-2R0750	R0.75	1.5	5	40	3
KMBE-2R0800	R0.8	1.6	5	40	3
KMBE-2R0850	R0.85	1.7	5	40	3
KMBE-2R0900	R0.9	1.8	5	40	3
KMBE-2R0950	R0.95	1.9	5	40	3
KMBE-2R1000	R1	2	6	40	3
KMBE-2R1050	R1.05	2.1	6	40	3
KMBE-2R1100	R1.1	2.2	6	40	3
KMBE-2R1150	R1.15	2.3	6	40	3
KMBE-2R1200	R1.2	2.4	6	40	3
KMBE-2R1250	R1.25	2.5	8	40	3
KMBE-2R1300	R1.3	2.6	8	40	3
KMBE-2R1350	R1.35	2.7	8	40	3
KMBE-2R1400	R1.4	2.8	8	40	3
KMBE-2R1450	R1.45	2.9	8	40	3

[illegible]

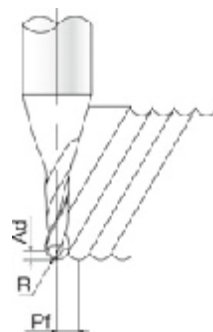
Carbide
Endmill

KMBE-2

切削条件参考

Referential Cutting Conditions

R	切込み深さ Cutting Depth	ピックフィード Pick Feed
	Ad	Pf
R < 0.4	0.05D	0.2D
0.4 ≤ R	0.10D	0.2D



被削材 Workpiece	炭素鋼・一般構造用鋼 Carbon Steel・ General Structural Steel S55C・SS材		合金鋼・工具鋼 Alloy Steel・Tool Steel SCM・SKT・SKS・SKD		プリハードン鋼 Pre-Harden Steel HPM-1・NAK55・SKT		鋳 鉄 Cast iron FC・FCD	
R Flute Diameter mm	回転数 Revolution min ⁻¹	送り速度 Feed mm/min	回転数 Revolution min ⁻¹	送り速度 Feed mm/min	回転数 Revolution min ⁻¹	送り速度 Feed mm/min	回転数 Revolution min ⁻¹	送り速度 Feed mm/min
R0.1	32,000	65	32,000	45	29,200	15	32,000	65
R0.15	32,000	75	29,200	50	19,500	20	32,000	75
R0.2	27,400	95	22,000	50	15,000	20	27,400	95
R0.25	26,300	100	21,900	55	14,600	20	26,300	100
R0.3	21,900	105	18,500	60	12,200	25	21,900	110
R0.4	16,500	105	11,500	60	9,900	30	16,500	110
R0.5	13,000	105	9,500	60	7,950	30	13,000	110
R0.6	11,000	105	7,950	65	6,600	30	11,000	115
R0.7	9,500	110	6,800	65	5,650	30	9,500	120
R0.8	8,350	115	5,950	70	4,950	30	8,350	125
R0.9	7,400	115	5,300	75	4,400	35	7,400	130
R1	6,650	115	4,750	80	3,950	40	6,650	135
R1.1	6,050	120	4,300	85	3,600	40	6,050	140
R1.2	5,550	120	3,950	85	3,300	40	5,550	140
R1.3	5,100	120	3,650	85	3,050	40	5,100	140
R1.4	4,750	125	3,400	90	2,800	40	4,750	140
R1.5	4,450	130	3,150	90	2,650	40	4,450	140
備 考 Remarks	• 回転数と送り速度は同じ割合で調整して下さい。 • ピックフィードは要求品質に合わせて調整して下さい。 • 切削油を使用して下さい。 • Adjust Revolution and Feed Speed at the same rate. • Adjust Pick Feed according to Required Quality. • Use Cutting Oil.							