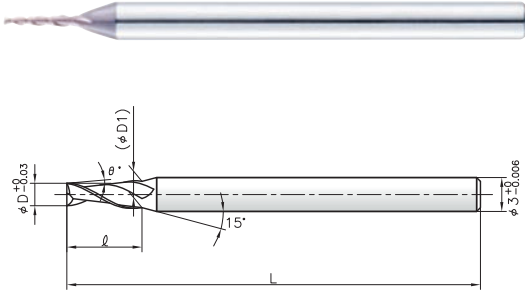


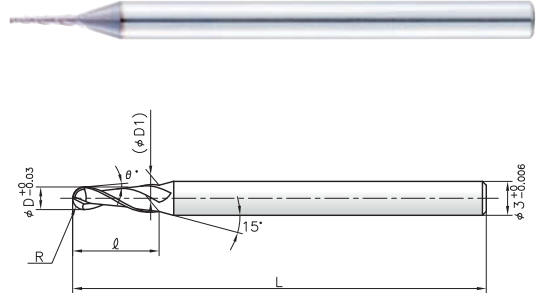
超硬2枚刃 深リブテーパードエンドミル

RB-YTEDS形 $\phi 3$ シャンク
2枚刃
TiAlNコーティング 右ネジレ30°



超硬2枚刃 深リブテーパードボールエンドミル

RB-YTEBDS形 $\phi 3$ シャンク
2枚刃
TiAlNコーティング 右ネジレ30°



●切削条件 P.82

型番	ツールNo.	先端径 D	片角 θ°	刃長 l	大端径 D1	全長 L	価格
RB-YTEDS-02016-050	KY20733	0.2	30'	1.6	0.23	50	16,000
RB-YTEDS-02024-050	KY20734	0.2	30'	2.4	0.24	50	16,670
RB-YTEDS-03024-050	KY20735	0.3	30'	2.4	0.34	50	14,170
RB-YTEDS-03036-050	KY20736	0.3	30'	3.6	0.36	50	15,000
RB-YTEDS-04032-050	KY20737	0.4	30'	3.2	0.46	50	13,170
RB-YTEDS-04048-050	KY20738	0.4	30'	4.8	0.48	50	13,840
RB-YTEDS-05040-050	KY20739	0.5	30'	4	0.57	50	12,170
RB-YTEDS-05060-050	KY20740	0.5	30'	6	0.6	50	12,840
RB-YTEDS-02016-075	KY20741	0.2	45'	1.6	0.24	50	16,000
RB-YTEDS-02024-075	KY20742	0.2	45'	2.4	0.26	50	16,670
RB-YTEDS-03024-075	KY20743	0.3	45'	2.4	0.36	50	14,170
RB-YTEDS-03036-075	KY20744	0.3	45'	3.6	0.39	50	15,000
RB-YTEDS-04032-075	KY20745	0.4	45'	3.2	0.48	50	13,170
RB-YTEDS-04048-075	KY20746	0.4	45'	4.8	0.53	50	13,840
RB-YTEDS-05040-075	KY20747	0.5	45'	4	0.6	50	12,170
RB-YTEDS-05060-075	KY20748	0.5	45'	6	0.66	50	12,840
RB-YTEDS-02016-100	KY20749	0.2	1°	1.6	0.26	50	16,000
RB-YTEDS-02024-100	KY20750	0.2	1°	2.4	0.28	50	16,670
RB-YTEDS-03024-100	KY20751	0.3	1°	2.4	0.38	50	14,170
RB-YTEDS-03036-100	KY20752	0.3	1°	3.6	0.43	50	15,000
RB-YTEDS-04032-100	KY20753	0.4	1°	3.2	0.51	50	13,170
RB-YTEDS-04048-100	KY20754	0.4	1°	4.8	0.57	50	13,840
RB-YTEDS-05040-100	KY20755	0.5	1°	4	0.64	50	12,170
RB-YTEDS-05060-100	KY20756	0.5	1°	6	0.71	50	12,840
RB-YTEDS-02016-150	KY20757	0.2	1°30'	1.6	0.28	50	16,000
RB-YTEDS-02024-150	KY20758	0.2	1°30'	2.4	0.33	50	16,670
RB-YTEDS-03024-150	KY20759	0.3	1°30'	2.4	0.43	50	14,170
RB-YTEDS-03036-150	KY20760	0.3	1°30'	3.6	0.49	50	15,000
RB-YTEDS-04032-150	KY20761	0.4	1°30'	3.2	0.57	50	13,170
RB-YTEDS-04048-150	KY20762	0.4	1°30'	4.8	0.65	50	13,840
RB-YTEDS-05040-150	KY20763	0.5	1°30'	4	0.71	50	12,170
RB-YTEDS-05060-150	KY20764	0.5	1°30'	6	0.81	50	12,840
RB-YTEDS-02016-200	KY20765	0.2	2°	1.6	0.31	50	16,000
RB-YTEDS-02024-200	KY20766	0.2	2°	2.4	0.37	50	16,670
RB-YTEDS-03024-200	KY20767	0.3	2°	2.4	0.47	50	14,170
RB-YTEDS-03036-200	KY20768	0.3	2°	3.6	0.55	50	15,000
RB-YTEDS-04032-200	KY20769	0.4	2°	3.2	0.62	50	13,170
RB-YTEDS-04048-200	KY20770	0.4	2°	4.8	0.74	50	13,840
RB-YTEDS-05040-200	KY20771	0.5	2°	4	0.78	50	12,170
RB-YTEDS-05060-200	KY20772	0.5	2°	6	0.92	50	12,840

●切削条件 P.83

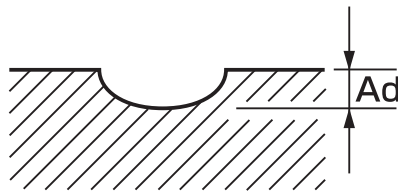
型番	ツールNo.	R	片角 θ°	刃長 l	大端径 D1	全長 L	価格
RB-YTEBDS-R01016-050	KY20693	0.1	30'	1.6	0.23	50	20,500
RB-YTEBDS-R01024-050	KY20694	0.1	30'	2.4	0.24	50	21,670
RB-YTEBDS-R01524-050	KY20695	0.15	30'	2.4	0.34	50	18,500
RB-YTEBDS-R01536-050	KY20696	0.15	30'	3.6	0.36	50	19,500
RB-YTEBDS-R02032-050	KY20697	0.2	30'	3.2	0.46	50	17,000
RB-YTEBDS-R02048-050	KY20698	0.2	30'	4.8	0.48	50	18,000
RB-YTEBDS-R02540-050	KY20699	0.25	30'	4	0.57	50	16,000
RB-YTEBDS-R02560-050	KY20700	0.25	30'	6	0.6	50	16,840
RB-YTEBDS-R01016-075	KY20701	0.1	45'	1.6	0.24	50	20,500
RB-YTEBDS-R01024-075	KY20702	0.1	45'	2.4	0.26	50	21,670
RB-YTEBDS-R01524-075	KY20703	0.15	45'	2.4	0.36	50	18,500
RB-YTEBDS-R01536-075	KY20704	0.15	45'	3.6	0.39	50	19,500
RB-YTEBDS-R02032-075	KY20705	0.2	45'	3.2	0.48	50	17,000
RB-YTEBDS-R02048-075	KY20706	0.2	45'	4.8	0.53	50	18,000
RB-YTEBDS-R02540-075	KY20707	0.25	45'	4	0.6	50	16,000
RB-YTEBDS-R02560-075	KY20708	0.25	45'	6	0.66	50	16,840
RB-YTEBDS-R01016-100	KY20709	0.1	1°	1.6	0.26	50	20,500
RB-YTEBDS-R01024-100	KY20710	0.1	1°	2.4	0.28	50	21,670
RB-YTEBDS-R01524-100	KY20711	0.15	1°	2.4	0.38	50	18,500
RB-YTEBDS-R01536-100	KY20712	0.15	1°	3.6	0.43	50	19,500
RB-YTEBDS-R02032-100	KY20713	0.2	1°	3.2	0.51	50	17,000
RB-YTEBDS-R02048-100	KY20714	0.2	1°	4.8	0.57	50	18,000
RB-YTEBDS-R02540-100	KY20715	0.25	1°	4	0.64	50	16,000
RB-YTEBDS-R02560-100	KY20716	0.25	1°	6	0.71	50	16,840
RB-YTEBDS-R01016-150	KY20717	0.1	1°30'	1.6	0.28	50	20,500
RB-YTEBDS-R01024-150	KY20718	0.1	1°30'	2.4	0.33	50	21,670
RB-YTEBDS-R01524-150	KY20719	0.15	1°30'	2.4	0.43	50	18,500
RB-YTEBDS-R01536-150	KY20720	0.15	1°30'	3.6	0.49	50	19,500
RB-YTEBDS-R02032-150	KY20721	0.2	1°30'	3.2	0.57	50	17,000
RB-YTEBDS-R02048-150	KY20722	0.2	1°30'	4.8	0.65	50	18,000
RB-YTEBDS-R02540-150	KY20723	0.25	1°30'	4	0.71	50	16,000
RB-YTEBDS-R02560-150	KY20724	0.25	1°30'	6	0.81	50	16,840
RB-YTEBDS-R01016-200	KY20725	0.1	2°	1.6	0.31	50	20,500
RB-YTEBDS-R01024-200	KY20726	0.1	2°	2.4	0.37	50	21,670
RB-YTEBDS-R01524-200	KY20727	0.15	2°	2.4	0.47	50	18,500
RB-YTEBDS-R01536-200	KY20728	0.15	2°	3.6	0.55	50	19,500
RB-YTEBDS-R02032-200	KY20729	0.2	2°	3.2	0.62	50	17,000
RB-YTEBDS-R02048-200	KY20730	0.2	2°	4.8	0.74	50	18,000
RB-YTEBDS-R02540-200	KY20731	0.25	2°	4	0.78	50	16,000
RB-YTEBDS-R02560-200	KY20732	0.25	2°	6	0.92	50	16,840

超硬リブ用エンドミル

切削条件参考

超硬2枚刃深リブテーパボールエンドミル

RB-YTEBDS形
TiAlNコーティング



被削材	炭素鋼・一般構造用鋼 SS材・S55C			合金鋼・工具鋼 SCM・SKT・SKS・SKD		
	回転数 min ⁻¹	送り速度 mm/min	Ad (切込み深さ) mm	回転数 min ⁻¹	送り速度 mm/min	Ad (切込み深さ) mm
0.1	32,000	50~100	0.003~0.006	32,000	50~100	0.003~0.006
0.15	32,000	60~150	0.003~0.009	32,000	60~150	0.003~0.009
0.2	32,000	100~350	0.003~0.012	31,500	100~350	0.003~0.012
0.25	32,000	150~400	0.003~0.018	25,500	150~400	0.003~0.018

被削材	プリハードン鋼 HPM-1・NAK55・SKT			鋳鉄 FC・FCD		
	回転数 min ⁻¹	送り速度 mm/min	Ad (切込み深さ) mm	回転数 min ⁻¹	送り速度 mm/min	Ad (切込み深さ) mm
0.1	32,000	50~100	0.003~0.006	32,000	50~100	0.003~0.006
0.15	31,000	60~150	0.003~0.009	32,000	60~150	0.003~0.009
0.2	22,000	100~350	0.003~0.012	32,000	100~350	0.003~0.012
0.25	18,000	150~400	0.003~0.018	32,000	150~400	0.003~0.018