

2枚刃ボールエンドミル

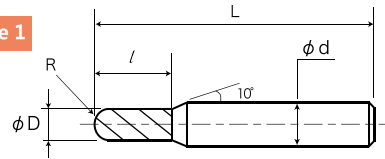
2-Flute Ball Nose End Mill

BE2

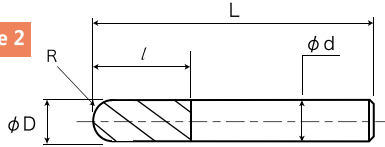


BE2060S
Model Flute R

Type 1



Type 2



特性 Features

- A highly rigid long necked, short tooth endmill.
- The optimum tool for alloy steel, S45C/SCM440
- Recommend oil or water soluble coolant for copper milling.



MG
超微粒



R 値 Radius	R 精度 Accuracy
0.5~2	+0.005 -0.005
3~6	+0.003 -0.003
8~10	+0.007 -0.007
	+0.010 -0.010

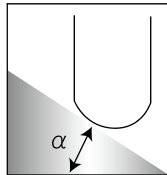


炭素鋼 Carbon Steel	合金鋼 Alloy Steel	調質鋼 Prehardened Steel	焼き入れ鋼 Hardened Steel				鋳鉄 Cast Iron	ステンレス鋼 Stainless Steels	アルミ合金 Aluminium Alloys	銅合金 Copper Alloys	チタン合金 耐熱合金 Ti/Ni Alloy	グラファイト Graphite	樹脂 Resin
			~45HRC	~55HRC	~60HRC	~65HRC							
◎	◎	○	○				○	○	○	○			

◎ = Best ○ = Good

MODEL 型番	R	l 刃長	L 全長	d 柄径	Type
BE2005S	0.5	2.5	50	4	1
BE20075S	0.75	4	50	4	1
BE2010S	1	4	50	4	1
BE2015S	1.5	6	60	4	1
BE2020S	2	8	60	4	2
BE2025S	2.5	10	80	6	2
BE2030S	3	12	80	6	2
BE2040S	4	14	90	8	2
BE2050S	5	18	100	10	2
BE2060S	6	22	100	12	1
BE2080S	8	30	100	16	1
BE2100S	10	38	105	20	1

推奨切削条件 Standard Milling Condition



- The table show standard milling guidance of perforating process as written picture
- Use a rigid and precise machine and tool holder
- Select a cutting fluid appropriate to the particular usage
- In case the revolution could not be increased by the machine used, Please reduce feed speed and Revolution speed at same ration
- When mounting End Mills, The run out of the till will have to be set within 0.01mm

被削材 Work Material	炭素鋼, 合金鋼 Carbon steel, Alloy steel (~30HRC) S55C, SCM AISI 1055		合金鋼, 工具鋼 Alloy steel, Tool steel プレハードン鋼 Pre-hardend steel (30~45HRC) SKD61, NAK AISI H13		炭素鋼, 合金鋼 Carbon steel, Alloy steel (~30HRC) S55C, SCM AISI 1055				合金鋼, 調質鋼, プレハードン鋼 Alloy steel, Tool steel, Pre-hardend steel (30~45HRC) SKD61, NAK AISI H13, AISI D2				
	R 値 Radius	回転数 (mm ⁻²) Revolution	送り速度 (mm/min) Feed rate	回転数 (mm ⁻²) Revolution	送り速度 (mm/min) Feed rate	a ≤ 15°		a > 15°		a ≤ 15°		a > 15°	
						回転数 Revolution	送り速度 Feed rate	回転数 Revolution	送り速度 Feed rate	回転数 Revolution	送り速度 Feed rate	回転数 Revolution	送り速度 Feed rate
R 0.5	-	-	-	-	14000	180	10000	120	12000	150	7000	80	
R 1	4100	70	2800	40	10500	350	7300	210	8400	220	5500	130	
R 2	2600	120	1650	85	7200	500	5100	300	5900	360	4300	210	
R 3	1900	150	1200	95	5200	560	3600	350	4200	410	2900	240	
R 4	1400	160	900	105	4000	640	2700	380	3100	440	2200	240	
R 5	1100	140	710	95	3200	700	2200	380	2500	460	1750	250	
R 6	940	130	600	85	2600	640	1750	350	2100	430	1450	250	
R 8	700	100	450	60	1900	620	1300	330	1550	430	1100	250	
R 10	560	80	360	50	1500	590	1000	310	1250	410	860	250	

粗加工(取代 ≤ 0.8R) Roughing (Large depth of cut ≤ 0.05R)

精加工(取代 ≤ 0.05R) Finishing (Large depth of cut ≤ 0.05R)