

CX500 2枚刃高硬度ボールエンドミル

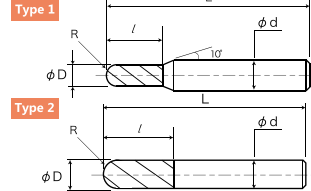
CX500 2-Flute Ball Nose End Mill for hard material

CX500-HBE2



CX500-HBE2005-6

Model Flute R d



特性 Features

- CX500-Coating is new epoch-making coating developed for super-long tool life, High-speed processing and dry cutting due to the high acid resistance and hardening if compared with other conventional and popular coating which is existing in the market.-The optimum tool for alloy steel, S45C/SCM440, NAK to HRC45
- CKK Original design Chip pocket enables similar or same cutting depth which 3-flutes could realize
- Surface finish is very accurate after reprocessing
- Suitable for hardened steel processing (up to 65 HRC)

R 値 Radius R 精度 Accuracy

0.15~2.5

3~6

SMG
超微粒粒

30°

R Ball

CX500 Coat

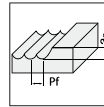
炭素鋼 Carbon Steel	合金鋼 Alloy Steel	調質鋼 Prehardened Steel	焼き入れ鋼 Hardened Steel				鋳鉄 Cast Iron	ステンレス鋼 Stainless Steels	アルミ合金 Aluminium Alloys	銅合金 Copper Alloys	チタン合金 耐熱合金 Ti/Ni Alloy	グラフアイト Graphite	樹脂 Resin
			~45HRC	~55HRC	~60HRC	~65HRC							
○	○	○	◎	◎	◎	◎	◎	○					

◎=Best ○=Good

MODEL 型番	R	D 外径	刃長	L 全長	d 柄径	Type
CX500-HBE20015	0.15	0.3	0.45	50	4	1
CX500-HBE20015-6	0.15	0.3	0.45	50	6	1
CX500-HBE2002-4	0.2	0.4	0.6	50	4	1
CX500-HBE2002-6	0.2	0.4	0.6	50	6	1
CX500-HBE2003-4	0.3	0.6	0.9	50	4	1
CX500-HBE2003-6	0.3	0.6	0.9	50	6	1
CX500-HBE2004-4	0.4	0.8	1.2	50	4	1
CX500-HBE2004-6	0.4	0.8	1.2	50	6	1
CX500-HBE2005-4	0.5	1	1.5	50	4	1
CX500-HBE2005-6	0.5	1	1.5	50	6	1
CX500-HBE20075	0.75	1.5	2	50	6	1
CX500-HBE2010	1	2	3	50	6	1
CX500-HBE2015	1.5	3	4.5	60	6	1
CX500-HBE2020	2	4	6	70	6	1
CX500-HBE2025	2.5	5	7.5	80	6	1
CX500-HBE2030	3	6	9	90	6	2
CX500-HBE2040	4	8	12	100	8	2
CX500-HBE2050	5	10	15	100	10	2
CX500-HBE2060	6	12	18	110	12	2
CX500-HBE2080	8	16	24	140	16	2

CX500-HBE2

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	高硬度鋼 Hardened Steel (40 ~ 55HRC)				高硬度鋼 Hardened Steel (55 ~ 60HRC)				高硬度鋼 Hardened Steel (60 ~ 65HRC)			
	送り速度 (mm/min) Feed rate		回転数 (mm ⁻¹) Revolution		送り速度 (mm/min) Feed rate		回転数 (mm ⁻¹) Revolution		送り速度 (mm/min) Feed rate		回転数 (mm ⁻¹) Revolution	
	Standard	High Speed	Standard	High Speed	Standard	High Speed	Standard	High Speed	Standard	High Speed	Standard	High Speed
0.2	650	-	50000	-	600	-	50000	-	550	-	50000	-
0.3	1040	-	50000	-	960	-	50000	-	780	-	50000	-
0.4	1460	-	50000	-	1180	-	43800	-	900	-	38200	-
0.5	2240	2650	47700	50000	1430	2300	35000	50000	1120	1950	30600	50000
0.75	2310	4800	31800	50000	1450	3900	23300	50000	1460	2740	20400	38200
1	1740	3670	23900	43000	1080	2620	17500	36600	1000	1940	15300	28600
1.5	1730	3430	15900	28600	1080	2570	11700	24400	950	1880	10200	19100
2	1590	3280	11900	21500	1020	2510	8800	18300	930	1820	7600	14300
2.5	1540	3620	9500	17200	990	2600	7000	14600	1040	1900	6100	11500
3	1390	2960	8000	14300	890	2200	5800	12200	840	1670	5100	9500
4	1250	2710	6000	10700	800	2110	4400	9200	760	1570	3800	7200
5	1130	2530	4800	8600	700	1910	3500	7300	700	1440	3100	5700
6	1010	2340	4000	7200	600	1670	2900	6100	620	1280	2500	4800
加工内径 Processing	Ad		Pf		Ad		Pf		Ad		Pf	
粗加工	≤0.1D	≤0.08D	≤0.3D	≤0.24D	≤0.07D	≤0.05D	≤0.21D	≤0.15D	≤0.07D	≤0.05D	≤0.21D	≤0.15D
精加工	≤0.03D	≤0.02D	≤0.1D	≤0.05D	≤0.02D	≤0.01D	≤0.05D	≤0.05D	≤0.02D	≤0.01D	≤0.05D	≤0.05D

ボール
Ball

スクエア
Square

レイジマス
Radius

ボール
Ball

ロングネック
Long Neck

フィニッシュ
Finishing

面取り加工
Chamfering

ドリル
Drill

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