

Code No. B262TX / B263TX / B264TX

◆ 普通加工 General processing

被削材		GR. 1 碳鋼 Carbon Steels		GR. 2 低合金鋼 Low-alloyed Steel (~24HRC)		GR. 3 高合金鋼 Hi-alloyed Steel (~30HRC)		GR. 4 硬化鋼 Hardened Steel (30~38HRC)		GR. 5 硬化鋼 Hardened Steel (38~48HRC)		GR. 6 硬化鋼 Hardened Steel (48~56HRC)		GR. 7 硬化鋼 Hardened Steel (56~68HRC)			
切削速度Vc m/min		Φ 0.3~0.6 30~60 Φ 0.8~20 80~120		Φ 0.3~0.6 30~60 Φ 0.8~20 80~120		Φ 0.3~0.6 30~60 Φ 0.8~20 80~100		Φ 0.3~0.6 30~60 Φ 0.8~20 73~80		Φ 0.3~0.6 30~60 Φ 0.8~20 65~70		Φ 0.3~0.6 23~46 Φ 0.8~20 48~60		Φ 0.3~0.6 20~35 Φ 0.8~20 35~42			
型號	直徑 (mm)	迴轉速度 (min-1)		進給速度 (mm/min)		迴轉速度 (min-1)		進給速度 (mm/min)		迴轉速度 (min-1)		進給速度 (mm/min)		迴轉速度 (min-1)		進給速度 (mm/min)	
		B262TX-R0.15	0.3	32,000	400	32,000	400	32,000	365	32,000	300	32,000	180	24,500	100	24,500	75
B262TX-R0.2	0.4	32,000	450	32,000	450	32,000	400	32,000	320	32,000	200	24,500	130	24,500	115		
B262TX-R0.25	0.5	32,000	485	32,000	485	32,000	440	32,000	360	32,000	230	24,500	150	24,500	130		
B262TX-R0.3	0.6	32,000	530	32,000	530	31,500	480	32,000	400	32,000	260	24,500	170	23,500	150		
B262TX-R0.4	0.8	32,000	605	32,000	605	31,500	550	29,000	400	27,000	270	19,000	185	14,000	140		
B262TX/B263TX/B264TX-R0.5	1	32,000	680	32,000	680	31,500	620	25,000	400	22,000	280	19,000	200	14,000	130		
B262TX/B263TX-R0.75	1.5	32,000	680	32,000	680	31,500	620	25,000	400	22,000	280	19,000	200	14,000	130		
B262TX/B263TX/B264TX-R1	2	19,000	765	19,000	765	15,500	620	12,500	400	11,000	290	9,500	200	7,100	135		
B262TX/B263TX-R1.25	2.5	19,000	765	19,000	765	15,500	620	12,500	400	11,000	290	9,500	200	6,360	135		
B262TX/B263TX/B264TX-R1.5	3	12,500	765	12,500	765	10,500	630	8,450	400	7,400	290	6,350	200	4,700	140		
B262TX/B236TX/B264TX-R2	4	9,500	765	9,500	765	7,950	630	6,350	450	5,550	370	4,750	270	3,500	170		
B262TX/B236TX/B264TX-R2.5	5	7,600	850	7,600	850	6,350	630	5,050	450	4,450	370	3,800	280	2,860	170		
B262TX/B236TX/B264TX-R3	6	6,350	850	6,350	850	5,300	650	4,200	460	3,700	390	3,150	290	2,300	175		
B262TX/B263TX-R3.5	7	5,050	950	5,050	950	4,650	710	3,650	500	3,200	420	2,750	305	2,000	190		
B262TX/B236TX/B264TX-R4	8	4,750	1,050	4,750	1,050	3,950	780	3,150	550	2,750	450	2,350	325	1,700	200		
B262TX/B263TX-R4.5	9	4,250	1,000	4,250	1,000	3,550	760	2,850	535	2,450	440	2,120	330	1,550	200		
B262TX/B236TX/B264TX-R5	10	3,800	950	3,800	950	3,150	740	2,500	525	2,200	430	1,900	330	1,400	200		
B262TX/B236TX/B264TX-R6	12	3,150	890	3,150	890	2,650	700	2,100	490	1,850	430	1,550	310	1,100	190		
B262TX/B263TX-R7	14	2,700	860	2,700	860	2,250	670	1,800	475	1,550	380	1,350	300	955	180		
B262TX/B236TX/B264TX-R8	16	2,350	840	2,350	840	1,950	640	1,550	475	1,350	380	1,150	265	835	175		
B262TX/B236TX/B264TX-R10	20	1,900	760	1,900	760	1,750	570	1,400	450	1,100	350	955	250	665	170		
切入深度 (mm)		ap: < 1 0.05D ≥ 1 0.1D		ap: < 1 0.05D ≥ 1 0.1D		ap: < 1 0.05D ≥ 1 0.1D		ap: < 1 0.05D ≥ 1 0.1D		ap: < 1 0.05D ≥ 1 0.1D		ap: 0.05D		ap: 0.05D			
		ae: < 1 0.1D ≥ 1 0.1D		ae: < 1 0.1D ≥ 1 0.1D		ae: < 1 0.1D ≥ 1 0.1D		ae: < 1 0.1D ≥ 1 0.1D		ae: < 1 0.1D ≥ 1 0.1D		ae: 0.075D		ae: 0.075D			

- 1.注意B263TX/B264TX為加長柄系列銑刀，請按照適當的伸出長度調整刀具的參數。Notice: B263TX/B264TX is Long Length series End Mills. Please adjust the parameter according
- 2.請使用剛性好、精度高的設備和夾具。Please work with good rigidity / high precision facilities and collet chuck.
- 3.請選擇適用於工件材料的切削液。Please choose proper cutting fluid.
- 4.此切削條件表中的數值為切削條件的基準值，實際加工時，請考慮加工形狀、目的、使用機台等因素，對切削條件進行調整。  
The cutting data is reference value only. Please adjust it according to your real working conditions.
- 5.如果機台轉速低於表中列數值，則進給速度應與轉速按同一比例降低。If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
- 6.切削加工時如果發生振顫，請降低切削條件。If vibration occurs during cutting, please reduce cutting parameter.

◆ 高速加工 High-speed machining

被削材		GR. 1 碳鋼 Carbon Steels		GR. 2 低合金鋼 Low-alloyed Steel (~24HRC)		GR. 3 高合金鋼 Hi-alloyed Steel (~30HRC)		GR. 4 硬化鋼 Hardened Steel (30~38HRC)		GR. 5 硬化鋼 Hardened Steel (38~48HRC)		GR. 6 硬化鋼 Hardened Steel (48~56HRC)		GR. 7 硬化鋼 Hardened Steel (56~68HRC)			
切削速度Vc m/min		Φ 1~3 157~198 Φ 4~20 226~300		Φ 1~3 157~198 Φ 4~20 226~300		Φ 1~3 155~165 Φ 4~20 195~250		Φ 1~3 140~160 Φ 4~20 188~220		Φ 1~3 125~153 Φ 4~20 170~180		Φ 1~3 100~113 Φ 4~20 138~180		Φ 1~3 79~92 Φ 4~20 119~126			
型號	直徑 (mm)	迴轉速度 (min-1)		進給速度 (mm/min)		迴轉速度 (min-1)		進給速度 (mm/min)		迴轉速度 (min-1)		進給速度 (mm/min)		迴轉速度 (min-1)		進給速度 (mm/min)	
		B262TX/B263TX/B264TX-R0.5	1	50,000	2,800	50,000	2,800	50,000	2,800	50,000	2,500	47,500	2,200	32,000	1,400	25,000	1,000
B262TX/B263TX-R0.75	1.5	41,800	2,800	41,800	2,800	33,000	2,800	30,000	2,500	26,500	2,200	24,000	1,400	19,500	1,000		
B262TX/B263TX/B264TX-R1	2	31,500	3,500	31,500	3,500	25,000	2,800	24,500	2,500	23,500	2,250	17,000	1,500	12,500	1,000		
B262TX/B263TX-R1.25	2.5	41,800	3,500	41,800	3,500	21,000	2,800	20,000	2,500	19,500	2,200	14,000	1,500	10,000	950		
B262TX/B236TX/B264TX-R1.5	3	21,000	3,500	21,000	3,500	16,500	2,800	16,000	2,500	15,500	2,200	11,000	1,500	8,400	950		
B262TX/B236TX/B264TX-R2	4	18,000	3,700	18,000	3,700	15,500	3,200	15,000	2,700	13,500	2,400	11,000	1,900	7,900	1,000		
B262TX/B236TX/B264TX-R2.5	5	15,500	4,000	15,500	4,000	15,000	4,000	14,000	2,800	11,000	2,300	10,000	2,000	7,600	1,200		
B262TX/B236TX/B264TX-R3	6	15,000	4,800	15,000	4,800	13,500	4,300	11,500	2,700	9,500	2,200	9,500	2,200	6,600	1,050		
B262TX/B236TX/B264TX-R4	8	11,500	3,600	11,500	3,600	10,000	3,200	8,900	2,000	7,100	1,700	7,100	1,700	4,900	880		
B262TX/B236TX/B264TX-R5	10	9,500	3,000	9,500	3,000	8,200	2,500	7,100	1,700	5,700	1,300	5,700	1,300	3,900	700		
B262TX/B236TX/B264TX-R6	12	7,900	2,450	7,900	2,450	6,800	2,100	5,900	1,350	4,700	1,000	4,700	1,000	3,300	580		
B262TX/B236TX/B264TX-R8	16	5,900	1,800	5,900	1,800	5,000	1,500	4,500	1,000	3,500	800	3,500	800	2,450	400		
B262TX/B236TX/B264TX-R10	20	4,700	1,300	4,700	1,300	4,000	1,200	3,500	800	2,800	650	2,800	650	2,000	320		
切入深度 (mm)		ap: 0.02D		ap: 0.02D		ap: 0.02D		ap: 0.02D		ap: 0.02D		ap: 0.02D		ap: 0.02D			
		ae: 0.02D		ae: 0.02D		ae: 0.02D		ae: 0.02D		ae: 0.02D		ae: 0.02D		ae: 0.02D			

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