

600
NanoHRC
▶ 55

35°



TiSiN

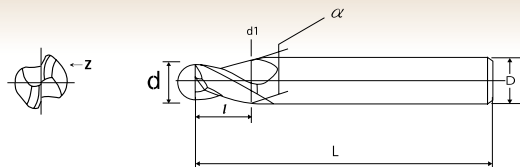
end mill expert



• Taper Ball Nose - 2 flutes

• 2刃球型斜度立銑刀

Micro Grain Carbide
WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



NO	MODE	Diameter	radius of Ball Nose	Flute Length	Full Length	Shank Diameter	d1	α	Flutes	Price (NT)
項次	型號	d 刃徑	R 角	l 刃長	L 全長	D 柄徑	大徑		Z 刃數	建議售價
1	TBTA050005 TiSiN	1	0.5	10	50	4	1.17	30°	2	1,700
2	TBTA050010 TiSiN	1	0.5	10	50	4	1.35	1°	2	1,700
3	TBTA050015 TiSiN	1	0.5	10	50	4	1.52	1° 30'	2	1,700
4	TBTA050020 TiSiN	1	0.5	10	50	4	1.7	2°	2	1,700
5	TBTA050030 TiSiN	1	0.5	10	50	4	1.87	3°	2	1,700
6	TBTA050040 TiSiN	1	0.5	10	50	4	2.05	4°	2	1,700
7	TBTA050050 TiSiN	1	0.5	10	50	4	2.74	5°	2	1,700
8	TBTA050070 TiSiN	1	0.5	10	50	4	3.44	7°	2	1,700
9	TBTA050100 TiSiN	1	0.5	10	50	4	4.51	10°	2	1,700
10	TBTA075005 TiSiN	1.5	0.75	10	50	4	1.67	30°	2	1,650
11	TBTA075010 TiSiN	1.5	0.75	10	50	4	1.85	1°	2	1,650
12	TBTA075015 TiSiN	1.5	0.75	10	50	4	2.02	1° 30'	2	1,650
13	TBTA075020 TiSiN	1.5	0.75	10	50	4	2.2	2°	2	1,650
14	TBTA075030 TiSiN	1.5	0.75	10	50	4	2.37	3°	2	1,650
15	TBTA075040 TiSiN	1.5	0.75	10	50	4	2.55	4°	2	1,650
16	TBTA075050 TiSiN	1.5	0.75	10	50	4	3.24	5°	2	1,650
17	TBTA075070 TiSiN	1.5	0.75	10	50	4	3.94	7°	2	1,650
18	TBTA075100 TiSiN	1.5	0.75	10	50	6	5.02	10°	2	2,140
19	TBTA100005 TiSiN	2	1	13	50	4	2.22	30°	2	1,510
20	TBTA100010 TiSiN	2	1	13	50	4	2.45	1°	2	1,510
21	TBTA100015 TiSiN	2	1	13	50	4	2.68	1° 30'	2	1,510
22	TBTA100020 TiSiN	2	1	13	50	4	3.9	2°	2	1,510
23	TBTA100030 TiSiN	2	1	13	50	4	3.13	3°	2	1,510
24	TBTA100040 TiSiN	2	1	13	50	4	3.36	4°	2	1,700
25	TBTA100050 TiSiN	2	1	13	50	6	4.27	5°	2	1,700
26	TBTA100070 TiSiN	2	1	13	50	6	5.17	7°	2	1,700
27	TBTA100100 TiSiN	2	1	13	60	8	6.56	10°	2	2,200
28	TBTA125005 TiSiN	2.5	1.25	15	50	4	2.76	30°	2	1,650
29	TBTA125010 TiSiN	2.5	1.25	15	50	4	3.03	1°	2	1,650
30	TBTA125015 TiSiN	2.5	1.25	15	50	4	3.29	1° 30'	2	1,650
31	TBTA125020 TiSiN	2.5	1.25	15	50	4	3.56	2°	2	1,650
32	TBTA125030 TiSiN	2.5	1.25	15	50	4	3.81	3°	2	1,650
33	TBTA125040 TiSiN	2.5	1.25	15	50	6	4.07	4°	2	1,650
34	TBTA125050 TiSiN	2.5	1.25	15	50	6	5.13	5°	2	1,700
35	TBTA125070 TiSiN	2.5	1.25	15	60	6	6.17	7°	2	1,700
36	TBTA125100 TiSiN	2.5	1.25	15	60	8	7.77	10°	2	2,200

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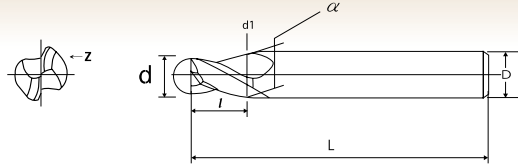


Unit/單位: mm

• Pencil Neck Ball nose - 2 flutes

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37	TBTA150005 TiSiN	3	1.5	20	50	4	3.34	30°	2	1,650
38	TBTA150010 TiSiN	3	1.5	20	50	4	3.6	1°	2	1,650
39	TBTA150015 TiSiN	3	1.5	20	60	6	4.04	1° 30"	2	1,650
40	TBTA150020 TiSiN	3	1.5	20	60	6	4.39	2°	2	1,650
41	TBTA150030 TiSiN	3	1.5	20	60	6	5.08	3°	2	1,650
42	TBTA150040 TiSiN	3	1.5	20	60	6	5.78	4°	2	1,700
43	TBTA150050 TiSiN	3	1.5	20	60	8	6.48	5°	2	2,000
44	TBTA150070 TiSiN	3	1.5	20	60	8	7.9	7°	2	2,000
45	TBTA150100 TiSiN	3	1.5	20	75	10	10.04	10°	2	2,280



Attention : In order to get better cutting surface and lengthen the life-time of the end mill, please use high accuracy, high rigidity and dynamic equilibrium of holder.

請特別注意：為了得到較佳之切削表面及延長刀具壽命，請務必使用高精度、高剛性、動平衡佳之刀把夾治具。

- Before using the end mill, please examine the end mill to lean towards and put, when the precision of the leaning towards of end mill exceeds 0.01mm, please cut after correcting.
- It is better that end mill stretches out shorter from chuck, when the end mill stretches out longer, please adjust the rotational speed, feeding speed or cutting amount.
- Unusual vibrations or sound happen when cutting, please adjust and lower the rotational speed of the main shaft one by one, feeding speed and cutting amount until improving the situation, or change the high-quality end mill.
- It is the best way to cool steel material by spraying or air in order to make **TiSiN** efficiently; we commend to adopt non-water cutting liquid to cool the stainless steel, titanium alloy or heat-resisting alloy.
- Cutting will be influenced by work piece, machine and software; the above-mentioned data are only for reference, please improve feeding speed by 30%~50% up after cutting situation steadily.

- 使用本刀具前請測刀具偏擺，刀具之偏擺精度超過0.01mm時，請改正後再切削。
- 刀具伸出夾頭之長度越短越好，刀具之伸出量若伸出較長時，請自行調降轉速、進給速度或切削量。
- 在切削中如果產生異常之震動或聲音時，請逐一調降主軸轉速，進給速度與切削量至情況改善為止，或更換高品質刀把。
- 鋼料冷卻以噴霧式或噴氣式為最佳選用方式，以使 **TiSiN** 發揮最佳效果，不銹鋼鈦合金或耐熱合金建議採用不水溶性切削液。
- 切削方式依工件、機器、軟件之影響，以上之數據僅供參考，待切削狀況穩定後再將進給速度往上提高 30%~50%。

