

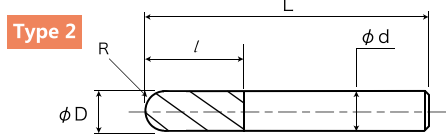
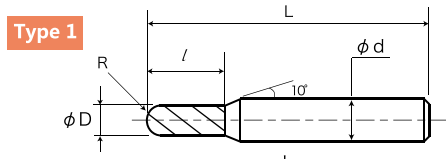
3枚刃ボールエンドミル

3-Flute Ball Nose End Mill

BE3



BE3060S
Model Flute R



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

30°

R
Ball

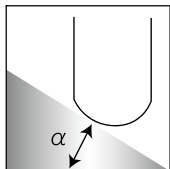
R 精度 Accuracy	
+0.010	
-0.010	

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
BE3005S	0.5	2.5	50	4	1
BE30075S	0.75	4	50	4	1
BE3010S	1	4	50	4	1
BE3015S	1.5	6	60	4	1
BE3020S	2	8	60	4	2
BE3025S	2.5	10	80	6	2
BE3030S	3	12	80	6	2
BE3040S	4	14	90	8	2
BE3050S	5	18	100	10	2
BE3060S	6	22	100	12	1
BE3080S	8	30	100	16	1
BE3100S	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 (mm) 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 (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	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
R 1	4100	90	2800	55	10500	455	7300	270	8400	290	5500		
R 2	2600	160	1650	110	7200	650	5100	390	5900	470	4300		
R 3	1900	200	1200	125	5200	730	3600	460	4200	530	2900		
R 4	1400	210	900	135	4000	830	2700	500	3100	570	2200		
R 5	1100	180	710	125	3200	910	2200	500	2500	600	1750		
R 6	940	230	600	110	2600	830	1750	450	2100	560	1450		
R 8	700	130	450	80	1900	810	1300	430	1550	560	1100		
R 10	560	100	360	65	1500	770	1000	400	1250	530	860		
粗加工 (取代 ≤ 0.8 R) Roughing (Large depth of cut ≤ 0.05R)					精加工 (取代 ≤ 0.05 R) Finishing (Large depth of cut ≤ 0.05R)								