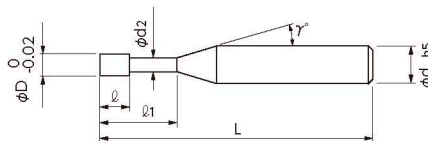


# DCHR230

## 钻石涂层 2刃长颈平底铣刀

Diamond Coating 2-Flute Long Neck End Mill



- 采用独创的钻石涂层，在加工石墨或高硅铝合金时可提高刀具的寿命。
- 适用于深沟加工的长颈避空型。
- Original Diamond Coating realized a long tool life for the machining of Graphite, silicon-aluminum alloy and brittle materials.
- Long neck design is suited for the machining of narrow and deep area.



### 加工材料 Work Material

石墨 Graphite	纤维树脂 Fiber Reinforced Plastics (FRP)	高硅铝 High Silicon Aluminum Alloy
◎	○	○

单位 [规格: mm / 价格: 日元] Unit [size: mm / Retail Price: JPY]

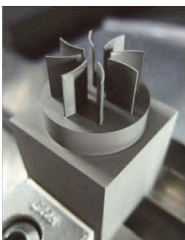
产品代码 Code No.	(D)刃径 Dia.	( $\ell_1$ )有效长 Effective Length	( $\ell$ )刃长 Length of Cut	( $d_2$ )颈径 Neck Dia.	( $\gamma$ )颈角 Neck Taper Angle	(d)柄径 Shank Dia.	(L)全长 Overall Length	定价(日元) Retail Price
05-00200-00502	0.5	2	1	0.46	12°	4	45	18,000
05-00200-00504		4	1	0.46	12°	4	45	18,000
05-00200-00506		6	1	0.46	12°	4	45	18,000
05-00200-01004	1	4	2	0.95	12°	4	50	18,000
05-00200-01006		6	2	0.95	12°	4	50	18,000
05-00200-01008		8	2	0.95	12°	4	50	18,000
05-00200-01010		10	2	0.95	12°	4	50	18,000
05-00200-01506	1.5	6	3	1.45	12°	4	50	18,000
05-00200-01512		12	3	1.45	12°	4	50	18,000
05-00200-01520		20	3	1.45	12°	4	60	18,000
05-00200-02006	2	6	4	1.94	12°	4	50	18,000
05-00200-02010		10	4	1.94	12°	4	50	18,000
05-00200-02016		16	4	1.94	12°	4	60	18,000
05-00200-02020		20	4	1.94	12°	4	60	18,000
05-00200-03016	3	16	6	2.85	12°	6	60	22,100
05-00200-03030		30	6	2.85	12°	6	70	25,400
05-00200-04020	4	20	8	3.8	12°	6	60	24,500
05-00200-04040		40	8	3.8	12°	6	90	27,600
05-00200-06030		6	30	12	5.8	—	6	90

### 订购方法

请指定DCHR230 刃径(D)×有效长( $\ell_1$ )。 ※( $\gamma$ )为参考值。  
When you order, indicate DCHR230 (D)×( $\ell_1$ ). ※( $\gamma$ ) is reference value.

- 切削参数表记载于第C-013页
- Recommended Milling Conditions are shown on page C-013.

### 加工案例 1 Technical Data 1



- 螺旋桨 propeller
- 加工材料: 石墨 (TTK-5)  
Material: Graphite (TTK-5)
  - 总加工时间: 1小时20分钟  
Total cutting time: 1hr 20min
  - 冷却方式: 吹气  
Coolant: Air blow
  - 尺寸 $\phi$ 14mm (叶片高度: 6mm)  
Size:  $\phi$ 14mm Height of blade: 6mm

加工工序 Cutting process	圆柱部粗加工 Roughing (Cylinder)	粗加工 Roughing	中精加工 Semi-finishing	精加工 Finishing
使用刀具 Tool	DCE235 $\phi 6$	DCHR230 $\phi 1 \times 10$		
主轴转速 [min <sup>-1</sup> ] Spindle speed	8,000	20,000		
进给速度 [mm/min] Feed	600	2,000	1,000	800
切深量 $a_p \times a_e$ [mm] Depth of cut	8×0.5	0.2×0.6	0.05×0.2	
加工长度 [m] Cutting Length	7	67		18
加工时间 Cutting time	5分钟 5min	1小时5分钟 1hr 5min		10分钟 10min