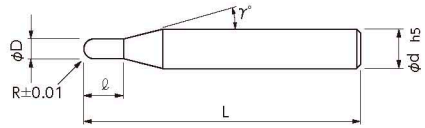


# MSBH345

高硬度材料用 3刃球头铣刀  
3-Flute Ball End Mill for Hardened Steels



- 采用高硬度材质用无限白金涂层，实现了长寿命化。
- 采用独创的3刃形状与不等分割设计，可减少振刀实现高效加工。
- Mugen Coating Premium realizes long tool life for machining on high-hardened steel.
- Original 3-flute design and unequal flute spacing to suppress chattering realize high efficient machining.



### 加工材料 Work Material

碳素钢 Carbon Steels	合金钢·工具钢 Alloy Steels· Tool Steels	预硬钢·调质钢 Prehardened Steels	淬硬钢 Hardened Steels		不锈钢 Stainless Steels	钛合金 Titanium Alloy	铝合金 Aluminum	铜合金 Copper	树脂 Plastic
			~55HRC	55HRC~					
○	○	◎	◎	◎	○	◎	○	○	○

★ 返修对应 (详情请咨询本公司。)

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

产品代码 Code No.	(R)球头半径 Radius	(L)刃长 Length of Cut	(D)刃径 Dia.	(γ)颈角 Neck Taper Angle	(d)柄径 Shank Dia.	(L)全长 Overall Length	定价(日元) Retail Price
08-00607-00050	R0.5	1.5	1	12°	6	60	9,200
08-00607-00060	R0.6	2	1.2	12°	6	60	12,400
08-00607-00070	R0.7	3	1.4	12°	6	60	12,400
08-00607-00080	R0.8	3	1.6	12°	6	60	12,400
08-00607-00090	R0.9	3	1.8	12°	6	60	12,400
08-00607-00100	R1	3	2	12°	6	60	9,200
08-00607-00110	R1.1	3.5	2.2	12°	6	60	13,500
08-00607-00120	R1.2	4	2.4	12°	6	60	13,500
08-00607-00130	R1.3	4	2.6	12°	6	60	13,500
08-00607-00140	R1.4	5	2.8	12°	6	60	13,500
★ 08-00607-00150	R1.5	5	3	12°	6	60	10,000
★ 08-00607-00160	R1.6	5	3.2	12°	6	60	13,500
★ 08-00607-00170	R1.7	6	3.4	12°	6	60	13,500
★ 08-00607-00180	R1.8	6	3.6	12°	6	60	13,500
★ 08-00607-00190	R1.9	6	3.8	12°	6	60	13,500
★ 08-00607-00200	R2	6	4	12°	6	70	10,000
★ 08-00607-00210	R2.1	7	4.2	12°	6	70	14,600
★ 08-00607-00220	R2.2	7	4.4	12°	6	70	14,600
★ 08-00607-00230	R2.3	7	4.6	12°	6	70	14,600
★ 08-00607-00240	R2.4	8	4.8	12°	6	70	14,600
★ 08-00607-00250	R2.5	8	5	12°	6	70	10,800
★ 08-00607-00260	R2.6	8	5.2	12°	6	70	15,700
★ 08-00607-00270	R2.7	9	5.4	12°	6	70	15,700
★ 08-00607-00280	R2.8	9	5.6	12°	6	70	15,700
★ 08-00607-00290	R2.9	9	5.8	12°	6	70	15,700
★ 08-00607-00300	R3	10	6	-	6	80	11,600

### 订购方法

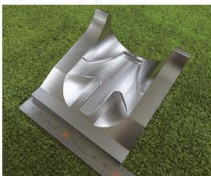
请指定MSBH345 球头半径(R)。 ※(γ)为参考值。

When you order, indicate MSBH345 (R). ※(γ) is reference value.

- 切削参数表记载于第E-003页
- 带■的规格和尺寸为特定代理商的库存产品。详情请咨询本公司。
- Recommended Milling Conditions are shown on page E-003.
- ■: Semi-standard item, please inquire for price and delivery.

### 加工案例1 Technical Data 1

镶边造型模具 Binding sample



- 加工材料: DC53 60HRC  
DC53 60HRC
- 总加工时间: 15 小时 16 分钟  
Total cutting time: 15hr 16min
- 冷却方式: 油雾  
Coolant: Oil mist
- 工件尺寸:  
100×100mm (加工深度 50mm)  
Work Size: 100 x 100mm (cutting 50mm)

加工工序 Process	粗加工 Roughing	中精加工 Semi-finishing	精加工 Finishing	清角加工 Stock removing
使用刀具 Tool	MSBH345 R3	MSBH345 R3	MSBH345 R3	MSBH345 R2
主轴转速 [min <sup>-1</sup> ] Spindle speed	7,200			12,000
进给速度 [mm/min] Feed	3,000	3,000	2,200	2,200
切深量 ap×ae[mm] Depth of cut	0.3×1.5	0.3×0.5	0.1×0.1	0.1×0.1
加工时间 Cutting time	6小时40分钟 6hr 40min	49分钟 49min	7小时20分钟 7hr 20min	27分钟 27min