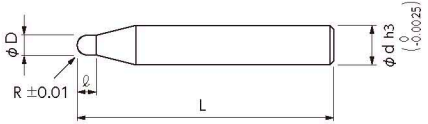
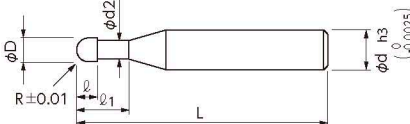




### Type I : 全刃长型



### Type II : 有效长型



#### 【颈部形状】

颈部干扰角度的基准为12°。担心加工材料和颈部会干扰时，请务必实际测量进行确认。

〔Neck Profile〕  
Reference value of interference angle after length of cut is 12°. Actual measurement required, in order to avoid interference between tool and work material.

- 采用了刃口的强度和锋利度兼具的螺旋球头形状，以及新开发的粘性极强的钻石涂层。
- Spiral ball shape with balanced strength and sharpness of cutting edges Adopted newly-developed diamond coating with enhanced sticking force



#### 加工材料 Work Material

硬质合金 Cemented Carbide	陶瓷 Ceramics	玻璃 glass	其他硬脆材料 Other Hard brittle material
◎	◎	◎	○

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)有效长 Effective Length	(L)刃长 Length of Cut	形状 Type	(d2)颈径 Under Neck Dia.	(d)柄径 Shank Dia.	(L)全长 Overall Length	定价(日元) Retail Price
05-00500-00100	R0.1	—	0.15	I	—	4	45	38,000
05-00500-00101	R0.1	0.5	0.12	II	0.18	4	45	38,400
05-00500-00200	R0.2	—	0.3	I	—	4	45	35,000
05-00500-00201	R0.2	1	0.25	II	0.37	4	45	35,400
05-00500-00300	R0.3	—	0.45	I	—	4	45	31,100
05-00500-00301	R0.3	1.5	0.35	II	0.56	4	45	31,500
05-00500-00500	R0.5	—	0.75	I	—	4	45	31,100
05-00500-00501	R0.5	2.5	0.6	II	0.95	4	45	31,500
05-00500-00750	R0.75	—	1.1	I	—	4	45	31,100
05-00500-00751	R0.75	3.8	0.9	II	1.45	4	45	31,500
05-00500-01000	R1	—	1.5	I	—	4	45	31,100
05-00500-01001	R1	5	1.2	II	1.94	4	45	31,500

#### 订购方法

请指定DCMB 球头半径(R)[×有效长(L)]。  
When you order, indicate DCMB (R)[×(L)].

- 切削参数表记载于第C-015页
- Recommended Milling Conditions are shown on page C-015.

### 加工案例 1 Technical Data 1

加工材料: 硬质合金 (硬度: 89HRA)

Work Material: Cemented Carbide (89HRA)



工件尺寸: 20mm×20mm×10mm  
Work Size

使用刀具: DCMB R1

Tool

精加工  
Finishing

主轴转速 Spindle Speed	20,000min <sup>-1</sup>
进给速度 Feed	200mm/min
切深量 Depth of Cut	(ap) 0.005mm×(ae) 0.01mm
加工时间 Time	3小时55分钟 3hr 55min
冷却方式 Coolant	油雾 Oil Mist

表面粗糙度(Rz) 0.51 μm~1.04 μm  
Surface Roughness