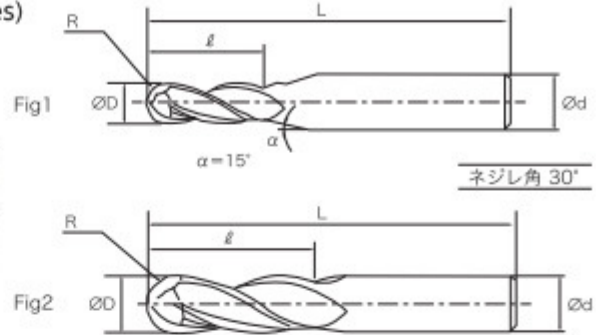


# IC2RBV



## (ザ・)カットミル 高硬度用超硬2枚刃ボールエンドミル

For high hardness steel ball end mill (2Flutes)



### 特長 Feature

- 高い耐摩耗性を持った超々微粒合金と特殊コーティングで高硬度材も難無く加工
- エキセントリック刃型の採用により面粗度と刃先強度が飛躍的に向上
- 高速機での使用にも対応
- High hardness material can be processed due to special coating and super micro-grain alloy which is excellent wear resistant.
- Roughness and edge strength are improved due to eccentric edge type.
- High-speed machine is available.

単位: mm

商品コード Item Code	R±0.01	D 0~-0.02	ℓ 0~0.5	L ±1.0	d h6	Fig.
IC2RBV 0.5R	0.5	1	2	50	4	1
IC2RBV 1R	1	2	4	50	4	1
IC2RBV 1.5R	1.5	3	6	75	6	1
IC2RBV 2R	2	4	8	75	6	1
IC2RBV 3R	3	6	12	75	6	2
IC2RBV 4R	4	8	16	100	8	2
IC2RBV 5R	5	10	20	100	10	2
IC2RBV 6R	6	12	24	100	12	2
IC2RBV 8R	8	16	32	150	16	2
IC2RBV 10R	10	20	40	150	20	2

### 標準切削条件表 (加工傾斜角α≤15°) Recommended cutting conditions

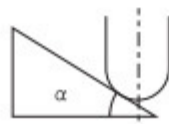
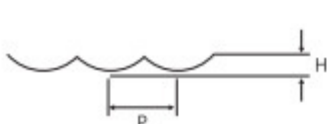
被削材 Work	合金鋼/工具鋼/プレハードン鋼 SCM/SKD61/SKD11/NAK等 (~45HRC)				焼入れ鋼 SKD61/SKD11/STAVAX等 (45~55HRC)				焼入れ鋼 SKD61/SKH/SKS等 (55~62HRC)			
	回転数 n(min <sup>-1</sup> )	送り速度 F(mm/min)	P (mm)	H (mm)	回転数 n(min <sup>-1</sup> )	送り速度 F(mm/min)	P (mm)	H (mm)	回転数 n(min <sup>-1</sup> )	送り速度 F(mm/min)	P (mm)	H (mm)
3	30,000	3,000	≤0.6	≤0.15	20,000	1,700	≤0.6	≤0.15	8,000	670	≤0.3	≤0.075
4	25,000	3,000	≤0.8	≤0.20	17,000	1,700	≤0.8	≤0.20	6,400	640	≤0.4	≤0.10
6	20,000	3,000	≤1.2	≤0.30	13,000	1,700	≤1.2	≤0.30	4,200	530	≤0.6	≤0.15
8	15,000	3,000	≤1.6	≤0.40	10,000	1,700	≤1.6	≤0.40	3,200	540	≤0.8	≤0.20
10	12,000	2,900	≤2.0	≤0.50	8,000	1,600	≤2.0	≤0.50	2,500	510	≤1.0	≤0.25
12	10,000	2,500	≤2.4	≤0.60	6,600	1,400	≤2.4	≤0.50	2,100	440	≤1.2	≤0.30
16	7,500	1,900	≤3.2	≤0.80	4,950	1,000	≤3.2	≤0.50	1,550	310	≤1.6	≤0.30
20	6,000	1,700	≤4.0	≤1.00	3,960	800	≤4.0	≤0.50	1,250	250	≤2.0	≤0.30

### 標準切削条件表 (加工傾斜角α>15°) Recommended cutting conditions

被削材 Work	合金鋼/工具鋼/プレハードン鋼 SCM/SKD61/SKD11/NAK等 (~45HRC)				焼入れ鋼 SKD61/SKD11/STAVAX等 (45~55HRC)				焼入れ鋼 SKD61/SKH/SKS等 (55~62HRC)			
	回転数 n(min <sup>-1</sup> )	送り速度 F(mm/min)	P (mm)	H (mm)	回転数 n(min <sup>-1</sup> )	送り速度 F(mm/min)	P (mm)	H (mm)	回転数 n(min <sup>-1</sup> )	送り速度 F(mm/min)	P (mm)	H (mm)
3	23,000	1,700	≤0.6	≤0.15	15,000	1,000	≤0.6	≤0.15	5,600	350	≤0.3	≤0.075
4	20,000	1,700	≤0.8	≤0.20	13,000	1,000	≤0.8	≤0.20	4,500	340	≤0.4	≤0.10
6	15,000	1,700	≤1.2	≤0.30	10,000	1,000	≤1.2	≤0.30	2,900	270	≤0.6	≤0.15
8	11,000	1,700	≤1.6	≤0.40	7,500	1,000	≤1.6	≤0.40	2,200	280	≤0.8	≤0.20
10	9,000	1,600	≤2.0	≤0.50	6,000	900	≤2.0	≤0.50	1,800	270	≤1.0	≤0.25
12	7,500	1,400	≤2.4	≤0.60	5,000	800	≤2.4	≤0.50	1,500	230	≤1.2	≤0.30
16	5,600	1,120	≤3.2	≤0.80	3,750	600	≤3.2	≤0.50	1,120	180	≤1.6	≤0.30
20	4,500	900	≤4.0	≤1.00	3,000	480	≤4.0	≤0.50	900	140	≤2.0	≤0.30

※切削条件はあくまでも目安です。使用される機械、チップの剛性や切削油等の状況によって変動致します。

These conditions are for general guidance. Therefore they are subject to change to the situation of the machine used, the tool hold rigidity, cutting oil, etc.



構造用鋼/炭素鋼 (SS41, S45C)	工具鋼/プレハードン鋼 (SKD, NAK101)	合金鋼/ステンレス鋼 (SCM, SUS304)	熱処理鋼等	硬質材
HRC30以下	HRC30~35	HRC35~45	HRC45~55	HRC55~62
△	○	◎	⊙	⊙