



# JIB無敵鋼用銑刀系列

JIB Super Strong End Mill For Steel Series

# JIB



## 特點

## SPECIAL FEATURES

- 採用特殊刀刃設計，剛性表現優於一般銑刀!!  
With special blade design, the rigidity performance is better than the normal type !!
- 獨有Tix-H鍍層，提升刀具壽命。  
Unique Tix-H coating leads the longer cutting life time.
- 專為HRC50以下工件加工所設計，保證效率加倍。  
Design for milling work piece (lower than HRC 50), and help users to save over 50% labor time.



實際測試影片

## 實績測試

## Benchmark test:

### JIB-4EN-D10

機台 Machine: CAMPRO- No Air blow  
 工件 Work Piece: P1 (HRC 28)  
 轉速 Spindle Speed: 3600 RPM  
 進給 Feed rate: 1400 mm/min  
 單刃切削量 Feed Rate per Tooth: 0.1mm  
 深度 Depth: 1D  
 寬度 Width: 10mm  
 切削方式 Milling Method: 溝銑 Slot milling

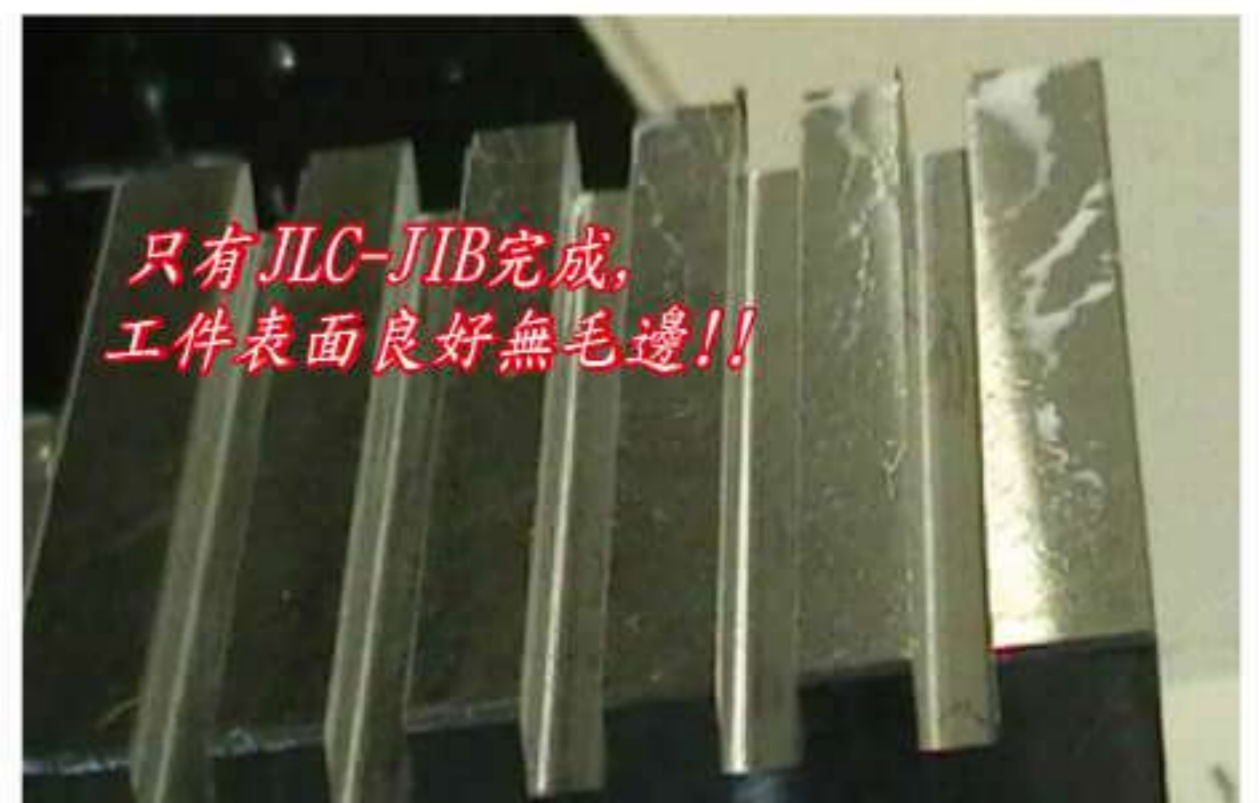
### P1-HRC 28 Test-Life time

### 一般鋼材銑刀測試



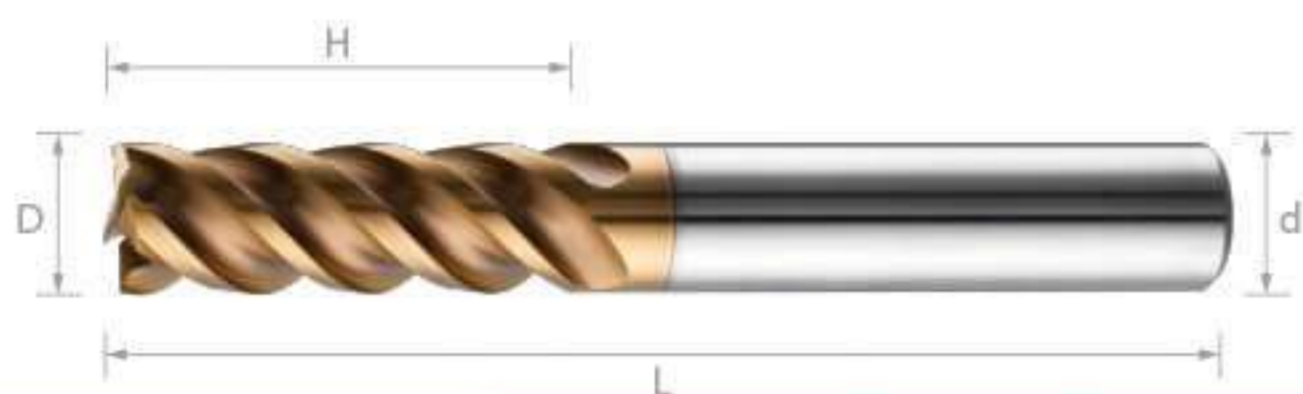
加工真實參數:  
S: 3600 / F: 1400-10mm深度一無Air氣冷

N120	G00	Z50.000	;			
N128	G00	Z50.000	;			
N130	X-25.000	Y-00.000	;			
	絕對座標	殘移動量	G01	G94	G80	
X	0.000	0.000	G17	G21	G98	
Y	35.380	53.870	G90	G40	G50	
Z	-10.000	0.000	G22	G43	G67	
A	0.000	0.000	DRN F		370	
			H	19M	3	
MD.T	19NX.T	2 D				
F	1400	S	3600			
ACT.F	1400MM/MIN	SACT	3598/分			
			S 3598L 49%			
RMT	STRT	MTN ***	15:35:50			



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## JIB Super Strong End Mill For Steel



### 規格表

編號 (Number)	外徑 (D)	刃長 (H)	刃數 (T)	柄徑 (d)	全長 (L)	價格 (Price)
JIB0204	2	5	4	4	50	
JIB0304	3	8	4	4	50	
JIB0404	4	10	4	4	50	
JIB0206	2	5	4	6	50	
JIB0306	3	8	4	6	50	
JIB0406	4	10	4	6	50	
JIB0506	5	13	4	6	50	
JIB0606	6	15	4	6	50	
JIB0708	7	18	4	8	60	
JIB0808	8	20	4	8	60	
JIB1010	10	30	4	10	75	
JIB1212	12	32	4	12	75	
JIB1616	16	50	4	16	100	
JIB2020	20	50	4	20	100	

### 切削條件表

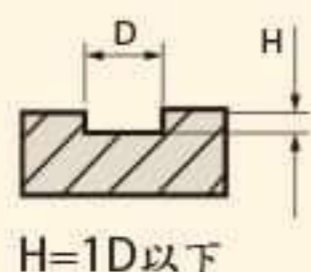
#### Recommended Milling Conditions

切削條件	粉末微粒碳化鎢 JIB鋼件刀	被切削材	合金鋼,工具鋼 模具鋼,熱處理鋼 SCr,SCM,SNC,SNCM SKD,NAK101	被切削材 硬度	HRC30-45
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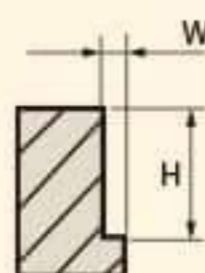
立銑刀刀徑 mm	轉速-spindle speed RPM	進給-feed rate mm/min	立銑刀刀徑 mm	轉速-spindle speed RPM	進給-feed rate mm/min
D3.0	10600	2100	D3.0	10600	2100
D4.0	8000	1600	D4.0	8000	1600
D5.0	6300	1200	D5.0	6300	1200
D6.0	5300	1000	D6.0	5300	1000
D8.0	4400	1400	D8.0	4400	1400
D10.0	3800	1200	D10.0	3800	1200
D12.0	3200	1000	D12.0	3200	1000
D16.0	2400	700	D16.0	2400	700
D20.0	1900	600	D20.0	1900	600

最大切削量 / Max Cutting Range.

Slot Milling- below 1D depth.



最大切削量 / Max Cutting Range.



Depth=H is within 2D  
W=0.2D