



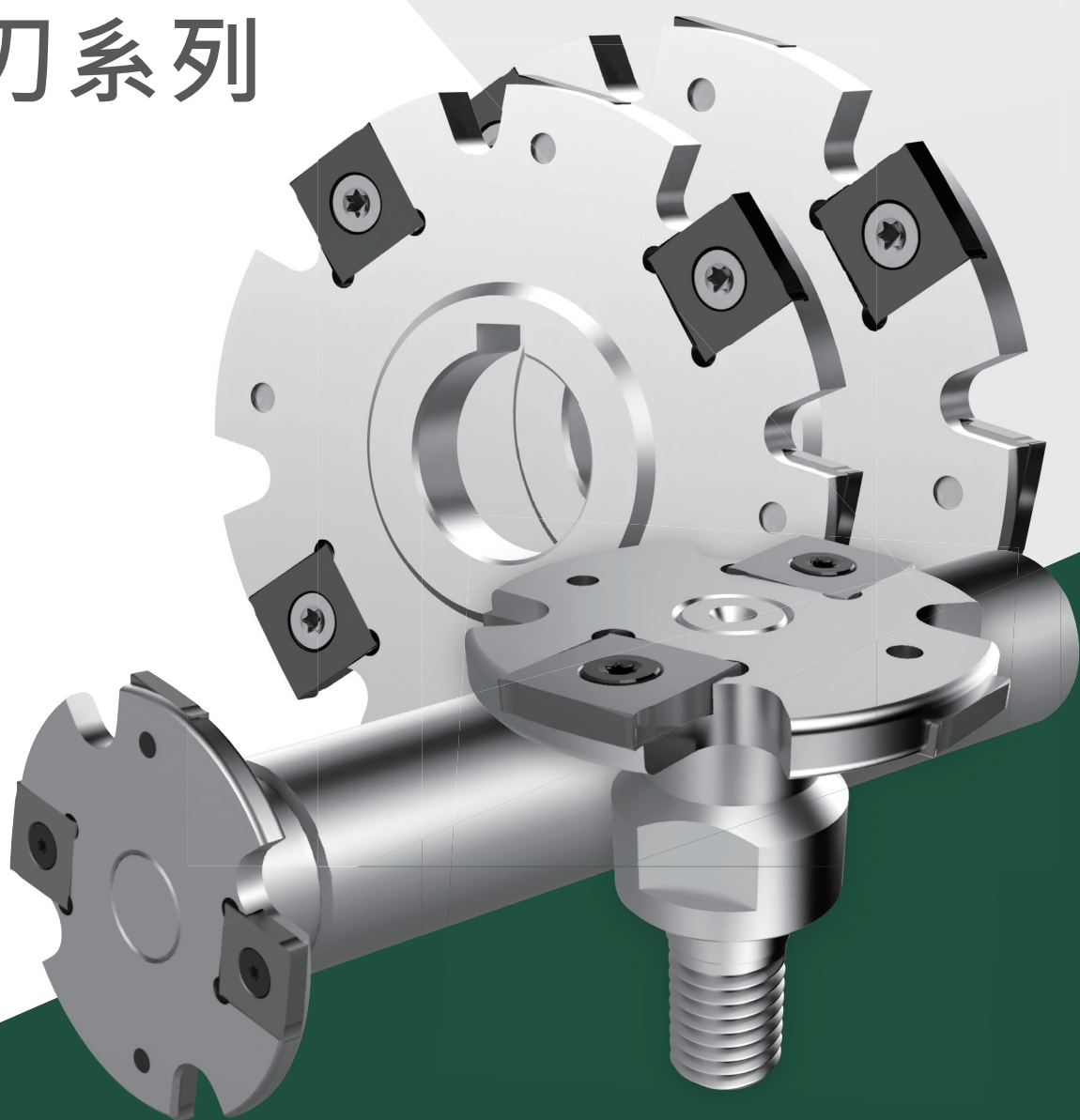
SIDE MILLING CUTTER SERIES

側銑刀系列

No. 240528005



影片
Video



側銑刀系列 產品發展歷史

Side Milling Cutter Development History



SDC 捨棄式側銑刀
SDC INDEXABLE
SIDE DISC CUTTER

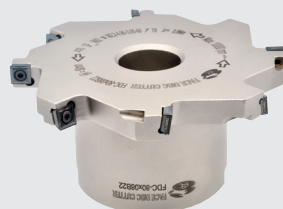


ATS T 形槽端銑刀
ATS T-SLOTS END MILL

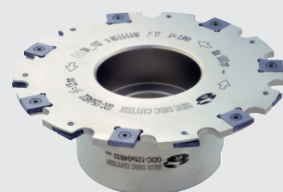
年度
Year

2005-2010

2010-2015



FDC 捨棄式側銑刀
FDC INDEXABLE
SIDE DISC CUTTER



GDC 捨棄式側銑刀
GDC INDEXABLE
SIDE DISC CUTTER



影片
Video



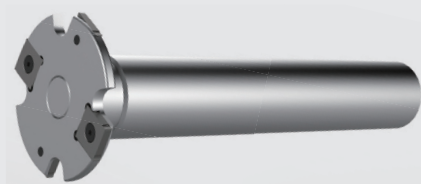
TDC 捨棄式側銑刀
TDC INDEXABLE
SIDE DISC CUTTER



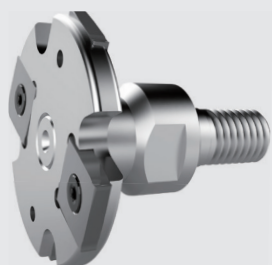
BTS/T 形槽端銑刀
BTS T-SLOTS END MILL

2015-2020

2020-2023



SDC 直柄小徑側銑刀
SDC INDEXABLE SIDE DISC
CUTTER FOR SMALL DIAMETER



SDC 鎖牙式小徑側銑刀
SDC INDEXABLE SIDE DISC
CUTTER FOR SMALL DIAMETER

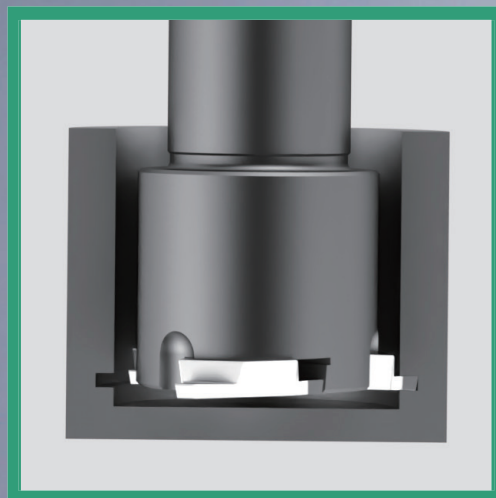
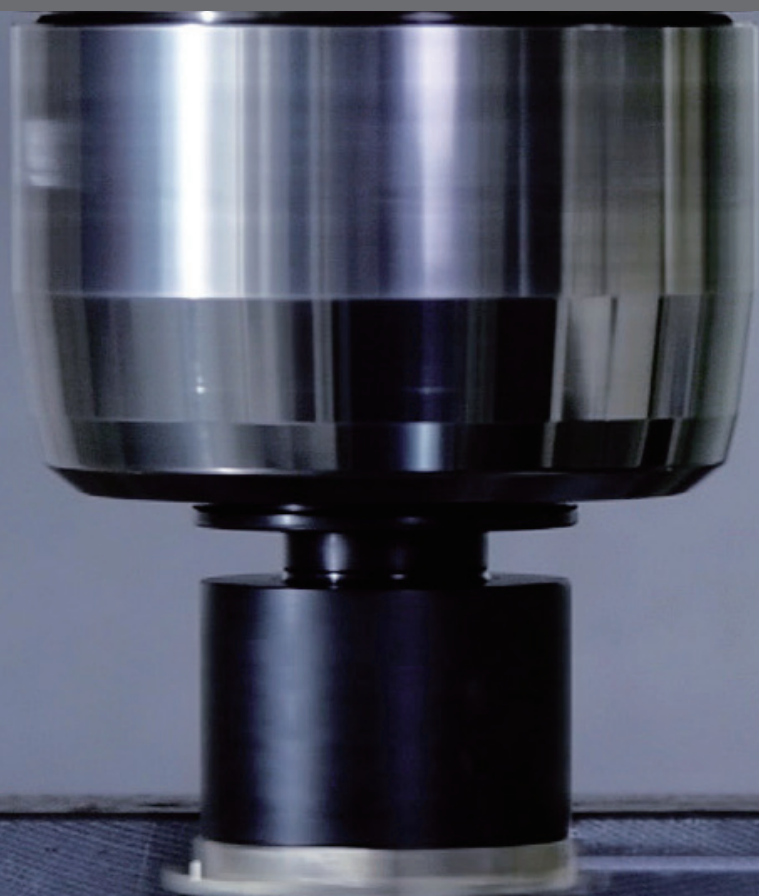
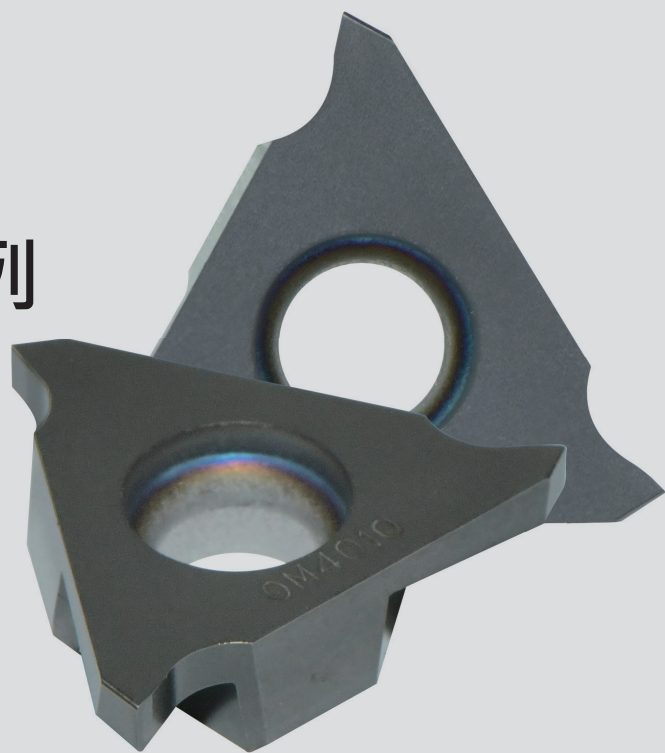


TGC 捨棄式槽銑刀
TGC INDEXABLE GROOVE
MILLING CUTTER

TGAL

捨棄式槽銑刀片系列

INDEXABLE GROOVE
MILLING CUTTER INSERT
SERIES



- 加工槽寬：1.25~4.00mm
- 適用加工 O 型環槽
- 可搭配標準刀片及接受不同 r 角訂製刀片

- Grooving range : 1.25~4.00mm
- Suitable for processing O-ring grooves.
- Available with standard inserts or customized R angle inserts.



TGAL 捨棄式槽銑刀片系列

TGAL INDEXABLE GROOVE

MILLING CUTTER INSERT SERIES

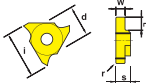
NEW



TGAL 捨棄式槽銑刀片

TGAL Indexable Groove Milling Cutter Insert



ISO 分類	P	合金鋼 Alloyed Steels	○	○					切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels	○	○								
	K	鑄鐵 Cast Iron	○	○								
	N	鋁及鋁合金 Aluminum&Al										
	S	高溫合金 Refractory Alloys										
	H	高硬度材 Hard Material	○									
形狀 Shape	規格 Spec.	鍍層超微粒 Layer coated micro grain				尺寸 (mm)						圖形 Drawing
		CHF				Size						
		OM4010	OM4025			W	L	d	i	s	r	
	TGAL4125	●	●			1.25	1.2	12.70	17.59	4.76	0.20	
	TGAL4150	●	●			1.50	3	12.70	17.59	4.76	0.20	
	TGAL4175	●	●			1.75	3	12.70	17.59	4.76	0.20	
	TGAL4200	●	●			2.00	3	12.70	17.59	4.76	0.20	
	TGAL4235	●	●			2.35	3	12.70	17.59	4.76	0.20	
	TGAL4250	●	●			2.50	4.5	12.70	17.59	4.76	0.30	
	TGAL4300	●	●			3.00	4.5	12.70	17.59	4.76	0.30	
	TGAL4350	●	●			3.50	4.5	12.70	17.59	4.76	0.30	
	TGAL4400	●	●			4.00	4.5	12.70	17.59	4.76	0.40	

TG_41.42.43.44 切削條件數據表 Cutting Parameter

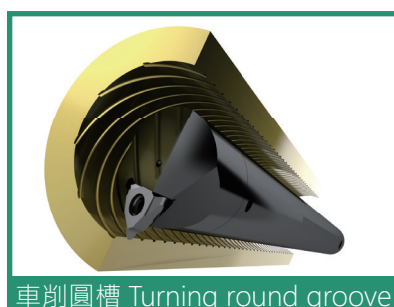
被加工材質 Machining Materials	切削速度 Vc(m/min)	切槽每刃進給 (mm)			
		W=0.5~1.2	W=1.25~2.25	W=2.3~3.25	W=4~4.5
P 合金鋼 Alloyed Steels	80~160	0.03~0.08	0.04~0.09	0.05~0.1	0.05~0.12
M 不鏽鋼 Stainless Steels	60~130	0.03~0.07	0.04~0.08	0.05~0.09	0.05~0.1
K 鑄鐵 Cast Iron	80~300	0.03~0.08	0.04~0.09	0.05~0.1	0.05~0.12
H 高硬度材 Hard Material	80~120	-	0.02~0.05	0.03~0.07	-

量身打造

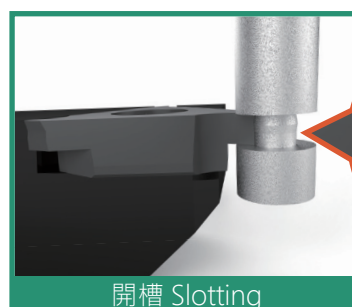
Cutting Edge Solutions

高精度車削

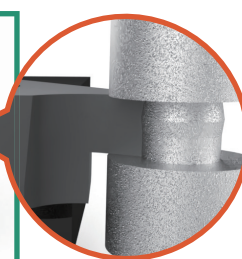
High precision turning



車削圓槽 Turning round groove



開槽 Slotting



TGAL 捨棄式槽銑刀片系列

TGAL INDEXABLE GROOVE MILLING CUTTER INSERT SERIES

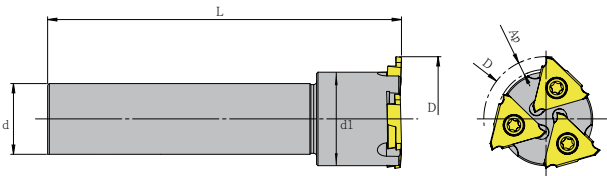


TGC 捨棄式槽銑刀

TGC Indexable Groove Milling Cutter



範例 Example



特點 Feature

- 適用於槽型銑削
 - 多切削刃，有效提升效率
 - 適用加工 O 型環槽
- Used for groove milling applications.
 -Multiple cutting edges for efficient machining.
 -Suitable for processing O-ring grooves.

規格 Spec.	D	切深 Ap	L	d	d ₁	刃數 Flutes	刀 片 Insert	重量 (KGS) Weight
TGC-4020-125	40	2	125	20	30	3	TGAL 4125-4400	0.43
TGC-4420-125	44	3	125	20	34	3		0.5

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
TGAL 4125-4400	M5-11-7.0-55	T20	6.5

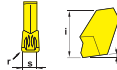
TGTN0311 捨棄式側銑刀片系列

TGTN0311 INDEXABLE SIDE DISC CUTTER INSERT SERIES

NEW

TGTN0311 捨棄式側銑刀片

TGTN0311 Indexable Side Disc Cutter Insert

ISO 分類	P	合金鋼 Alloyed Steels	○	○			切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting				
	M	不鏽鋼 Stainless Steels	○	○							
	K	鑄鐵 Cast Iron	○								
	N	鋁及鋁合金 Aluminum&Al									
	S	高溫合金 Refractory Alloys									
	H	高硬度材 Hard Material									
形狀 Shape	規格 Spec.	鍍層超微粒 Layer coated micro grain		尺寸 (mm)						圖形 Drawing	
		CHF		Size							
		OM4025N	RM4025	W	L	d	i	s	r		
	TGTN0311	●	●			-	11	3.1	0.2		

TGTN0311 切削條件數據表 Cutting Parameter

被加工材質 Machining Materials		刀片材質 Grade	切削速度 Vc(m/min)	每刃進給 (mm)
P	合金鋼 Alloyed Steel	OM4025N	100~220	0.06(0.05-0.12)
		RM4025	100~200	0.06(0.05-0.12)
M	不鏽鋼 Stainless Steels	OM4025N	110-275	0.08(0.06-0.12)
		RM4025	70-120	0.06(0.05-0.12)
K	鑄鐵 Cast Iron	OM4025N	110~275	0.08(0.06~0.12)

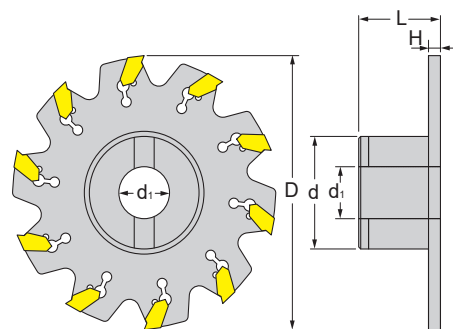
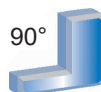
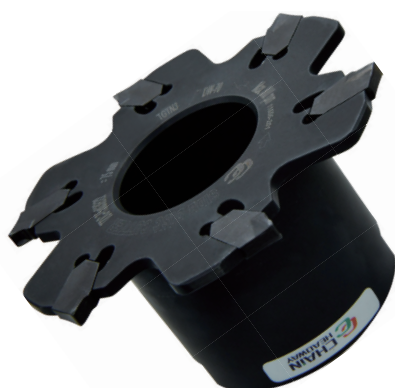
TGTN0311 捨棄式側銑刀片系列

TGTN0311 INDEXABLE SIDE DISC CUTTER INSERT SERIES



TDC 捨棄式側銑刀

TDC Indexable Side Disc Cutter



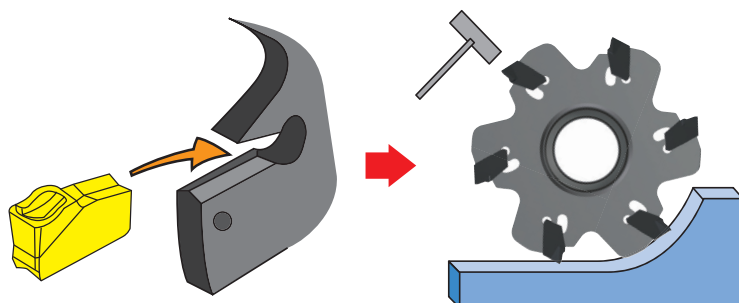
特點 Feature

- 加工 3mm 槽寬

- Slotting width: 3mm

規格 Spec.	L	D	d	d1	H	最大切深 max	刀數 Flutes	刀片 Insert	扳手 Wrench	重量 (KGS) Weight
TDC-75-03B22	40	75	42	22	3	13	6	TGTN0311	DW-70	0.50
TDC-100-03B22	40	100	42	22	3	25	8	TGTN0311	DW-70	0.75
TDC-125-03B22	40	125	42	22	3	38	10	TGTN0311	DW-70	0.90

使用說明 Instructions



取刀片放置刀片座上，輕壓固定，
再使用橡膠槌輕敲，使刀片與刀具密合。

Place the insert onto the insert seat,
press it gently to secure, and then lightly
tap with a rubber hammer to ensure
proper alignment between the insert
and the cutter body.



將DW-70拆卸扳手，置入刀座避讓位置，
順時針旋轉，即可鬆脫刀片。

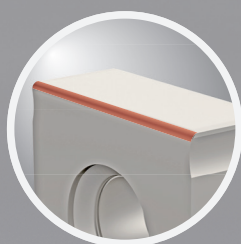
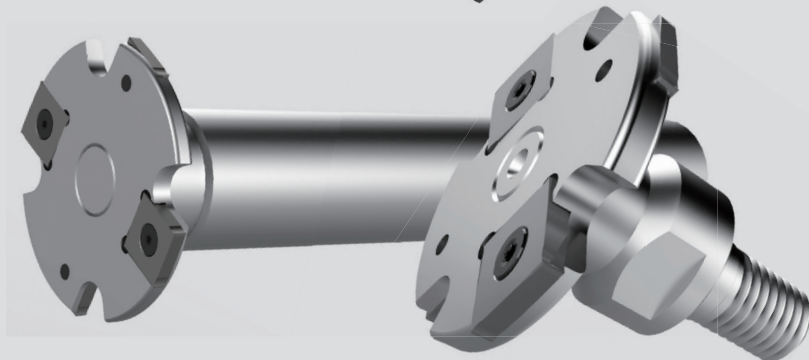
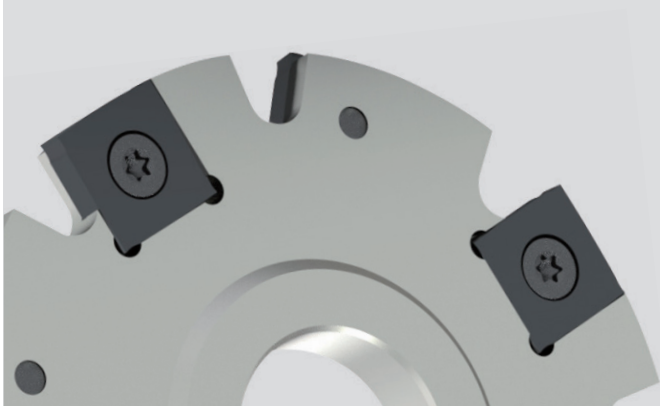
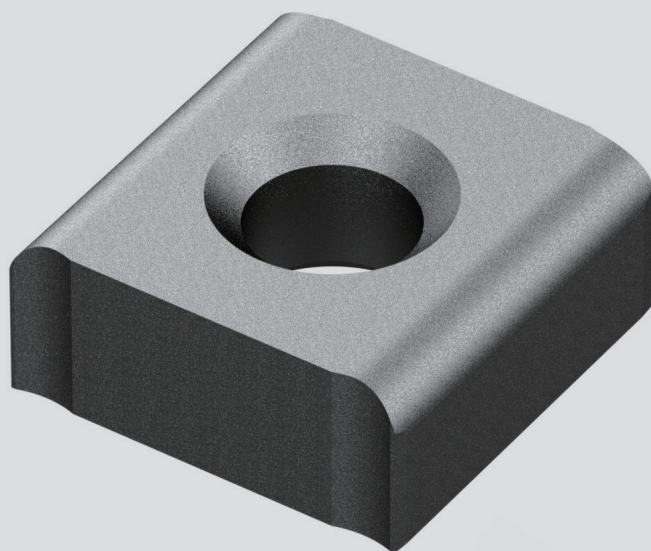
Install the DW-70 wrench into the insert seat and
rotate it clockwise to loosen and remove the insert.

SNFX

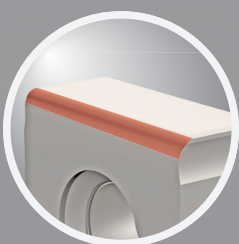
捨棄式

側銑刀片系列

INDEXABLE SIDE DISC
CUTTER INSERT SERIES



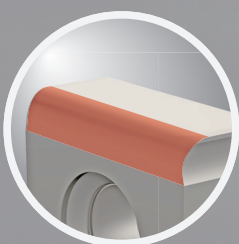
$r=0.5$



$r=1.0$



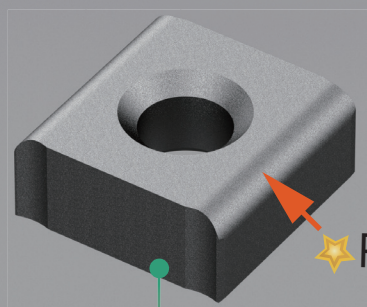
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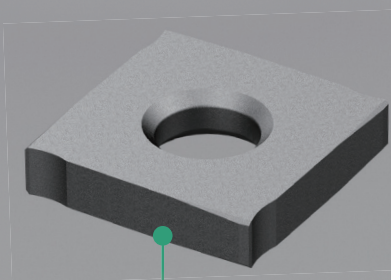
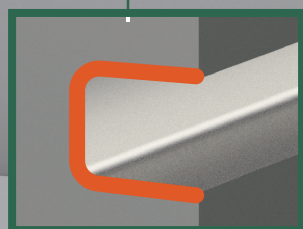
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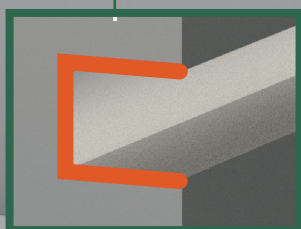
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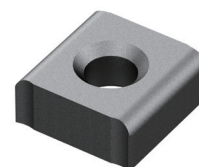
SNFX 120515



SNFX 1102



★R角



● - 接單生產 -Produced order by order.

SNFX 捨棄式側銑刀片系列

SNFX INDEXABLE SIDE DISC CUTTER INSERT SERIES

有效屑片厚度計算公式
Formula of average chip thickness

$$f_z = \sqrt{\frac{D}{A_p}} \times f \quad 0.11 = \sqrt{\frac{D}{A_p}} \times f \quad 0.31 = f$$

D= 有效外徑 Effective outer diameter

f= 每刃進給量 Feed per flutes

A_p= 切深 Depth

h_m= 有效屑片厚度 Effective chip thickness

SN_11.12 切削條件數據表 Cutting Parameter

被加工材質 Machining Materials		刀片材質 Grade	切削速度 Vc(m/min)	每刃進給 (mm)
P	合金鋼 Alloyed Steels	OM4010	90~250	0.08(0.06~0.12)
		OM4025	90~230	0.08(0.06~0.12)
M	不鏽鋼 Stainless Steels	OM4010	55~110	0.06(0.06~0.12)
		OM4025	55~100	0.06(0.06~0.12)
K	鑄鐵 Cast Iron	OM4025	110~275	0.08(0.06~0.12)
N	鋁合金 Aluminum&Al	OM5005	500~700	0.15(0.15~0.17)

主軸轉速 =(1000× 切削速度)÷(3.14× 刀具外徑) Spindle Speed=(1000× Cutting speed)÷(3.14× Cutter outer diameter).

床檯進給 (mm/min)= 每刃進給 × 刀具刃數 × 主軸轉速 Feeding Speed(mm/min)= Feed per Flutes× Flutes× Spindle speed.

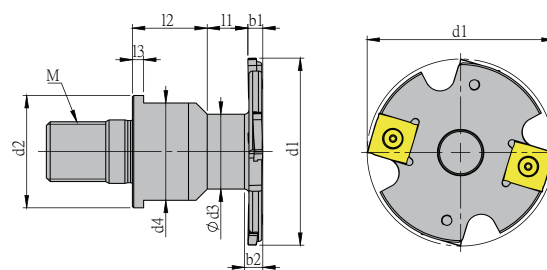
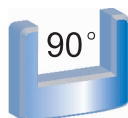
SNFX 捨棄式側銑刀片系列

SNFX INDEXABLE SIDE DISC CUTTER INSERT SERIES



SDC 鎖牙式小徑側銑刀

SDC Indexable Side Disc Cutter For Small Diameter



特點 Feature

- 小徑專用，可搭配鎢鋼延長桿加長使用
- Designed for small diameters, and be able to work with the carbide extension shank.

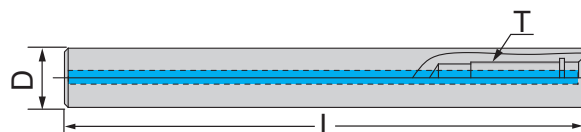
規格 Spec.	d1	d2	d3	d4	b1	b2	l1	l2	l3	最大切深 max	M	刃數 Flutes	刀片 Insert
SDC-40-04M10	40	18.5	14	16	4	4.9	8.3	10.7	3	10	M10	4	SNFX1102
SDC-40-05M10	40	18.5	14	16	5	5.9	8.3	10.7	3	10	M10	4	SNFX1103
SDC-50-04M12	50	23	16	18	4	4.9	11	13	3	14	M12	6	SNFX1102
SDC-50-05M12	50	23	16	18	5	5.9	11	13	3	14	M12	6	SNFX1103
SDC-50-06M12	50	23	16	18	6	6.9	11	13	3	14	M12	4	SNFX1203

- 搭配 SOM 鎖牙式延長桿



直柄 C/M 螺紋鎖固式鎢鋼延長桿

C/M Straight Tungsten Carbide Extension Shank



特點 Feature

- 整支通孔，利於出水及抗震
- Through-hole design for better water coolant and anti-vibration.

規格 Spec.	L	D	T	重量 (KGS) Weight
C20-M10-150-C	150	20	M10-1.5P	0.60
C20-M10-200-C	200	20	M10-1.5P	0.85
C25-M12-200-C	200	25	M12-1.75P	1.30
C25-M12-250-C	250	25	M12-1.75P	1.60

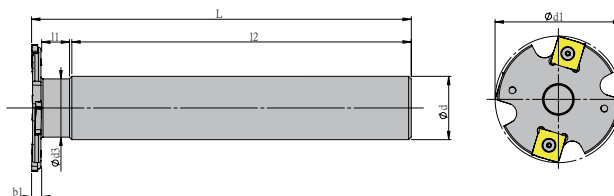
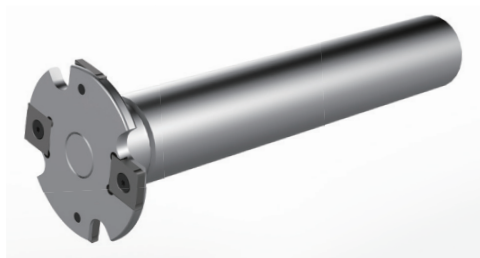
SNFX 捨棄式側銑刀片系列

SNFX INDEXABLE SIDE DISC CUTTER INSERT SERIES



SDC 直柄小徑側銑刀

SDC Indexable Side Disc Cutter For Small Diameter



規格 Spec.	d1	d	d3	b1	最大切深 max	L	l1	l2	刃數 Flutes	刀 片 Insert
SDC-04-5025-150	50	25	23	4	11	150	11	134	4	SNFX1102
SDC-05-5025-150	50	25	23	5	11	150	10	134	4	SNFX1103
SDC-04-6332-150	63	32	33	4	13	150	17	148	4	SNFX1102

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SN..1102	M3-3.5-5.0-90	T7	0.9

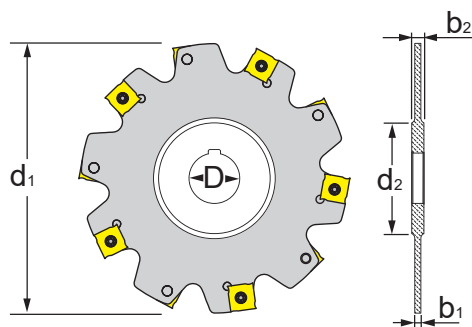
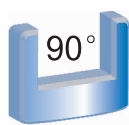
SNFX 捨棄式側銑刀片系列

SNFX INDEXABLE SIDE DISC CUTTER INSERT SERIES



SDC 捨棄式側銑刀

SDC Indexable Side Disc Cutter



規格 Spec.	D	d ₁	d ₂	b ₁	b ₂	刃數 Flutes	刀 片 Insert	重量 (KGS) Weight
SDC-100-04A25.4	25.4	100	41	4	12	12	SN..1102	0.38
SDC-100-05A25.4	25.4	100	41	5	12	12	SN..1103	0.44
SDC-100-06A25.4	25.4	100	41	6	12	10	SN..1203	0.45
SDC-100-07A25.4	25.4	100	41	7	12	9	SN..1203	0.49
SDC-100-08A25.4	25.4	100	41	8	12	9	SN..1203	0.54
SDC-100-10A25.4	25.4	100	41	10	12	10	SN..1205	0.59
SDC-100-11A25.4	25.4	100	41	11	12	10	SN..1207	0.62
SDC-100-12A25.4	25.4	100	41	12	12	10	SN..1207	0.66
SDC-100-14A25.4	25.4	100	41	14	16	9	SN..1207	0.77
SDC-125-04A25.4	25.4	125	41	4	12	14	SN..1102	0.58
SDC-125-05A25.4	25.4	125	41	5	12	14	SN..1103	0.63
SDC-125-06A25.4	25.4	125	41	6	12	12	SN..1203	0.69
SDC-125-07A25.4	25.4	125	41	7	12	12	SN..1203	0.75
SDC-125-08A25.4	25.4	125	41	8	12	12	SN..1203	0.81
SDC-125-09A25.4	25.4	125	41	9	12	12	SN..1205	0.86
SDC-125-10A25.4	25.4	125	41	10	12	12	SN..1205	0.94
SDC-125-12A25.4	25.4	125	41	12	12	12	SN..1207	1.05
SDC-125-14A25.4	25.4	125	41	14	16	12	SN..1207	1.20
SDC-160-06A25.4	25.4	160	41	6	12	16	SN..1203	1.04
SDC-160-07A25.4	25.4	160	41	7	12	15	SN..1203	1.17
SDC-160-08A25.4	25.4	160	41	8	12	15	SN..1203	1.26
SDC-160-09A25.4	25.4	160	41	9	12	16	SN..1205	1.35
SDC-160-10A25.4	25.4	160	41	10	12	16	SN..1205	1.48
SDC-160-12A25.4	25.4	160	41	12	12	16	SN..1207	1.74
SDC-160-14A25.4	25.4	160	41	14	16	15	SN..1207	1.99

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SN..1102	M3-3.5-5.0-90	T7	0.9
SN..1103	M3-4.3-5.0-90	T7	0.9
SN..1203	M4-5.0-6.2-90	T15	3.0
SN..1205	M4-8.2-6.2-90	T15	3.0
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0

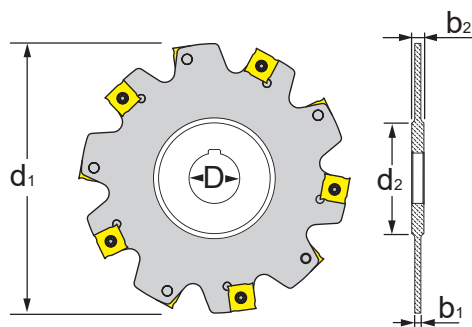
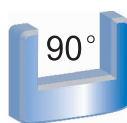
SNFX 捨棄式側銑刀片系列

SNFX INDEXABLE SIDE DISC CUTTER INSERT SERIES



SDC 捨棄式側銑刀

SDC Indexable Side Disc Cutter



規格 Spec.	D	d ₁	d ₂	b ₁	b ₂	刃數 Flutes	刀 片 Insert	重量 (KGS) Weight
SDC-63-04B22	22	63	34	4	8	8	SN..1102	0.27
SDC-63-05B22	22	63	34	5	8	8	SN..1103	0.28
SDC-63-06B22	22	63	34	6	8	6	SN..1203	0.28
SDC-80-04B22	22	80	34	4	8	10	SN..1102	0.31
SDC-80-05B22	22	80	34	5	8	10	SN..1103	0.33
SDC-80-06B22	22	80	34	6	8	8	SN..1203	0.35
SDC-100-04B27	27	100	41	4	12	12	SN..1102	0.38
SDC-100-05B27	27	100	41	5	12	12	SN..1103	0.44
SDC-100-06B27	27	100	41	6	12	10	SN..1203	0.45
SDC-100-07B27	27	100	41	7	12	9	SN..1203	0.49
SDC-100-08B27	27	100	41	8	12	9	SN..1203	0.54
SDC-100-10B27	27	100	41	10	12	10	SN..1205	0.59
SDC-100-12B27	27	100	41	12	12	10	SN..1207	0.70
SDC-100-14B27	27	100	41	14	14	9	SN..1207	0.70
SDC-125-04B32	32	125	47	4	12	14	SN..1102	0.58
SDC-125-05B32	32	125	47	5	12	14	SN..1103	0.63
SDC-125-06B32	32	125	47	6	12	12	SN..1203	0.69
SDC-125-07B32	32	125	47	7	12	12	SN..1203	0.75
SDC-125-08B32	32	125	47	8	12	12	SN..1203	0.81
SDC-125-09B32	32	125	47	9	12	12	SN..1205	0.86
SDC-125-10B32	32	125	47	10	12	12	SN..1205	0.94
SDC-125-12B32	32	125	47	12	12	12	SN..1207	1.05
SDC-125-14B32	32	125	47	14	14	12	SN..1207	1.20

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SN..1102	M3-3.5-5.0-90	T7	0.9
SN..1103	M3-4.3-5.0-90	T7	0.9
SN..1203	M4-5.0-6.2-90	T15	3.0
SN..1205	M4-8.2-6.2-90	T15	3.0
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0

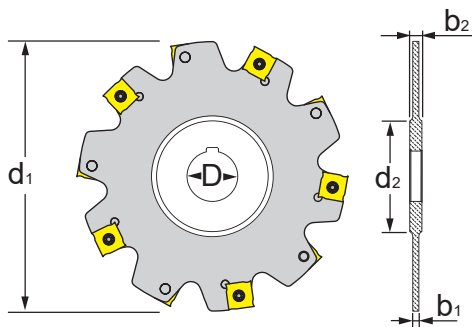
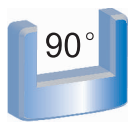
SNFX 捨棄式側銑刀片系列

SNFX INDEXABLE SIDE DISC CUTTER INSERT SERIES



SDC 捨棄式側銑刀

SDC Indexable Side Disc Cutter

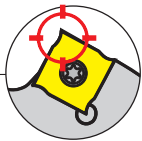
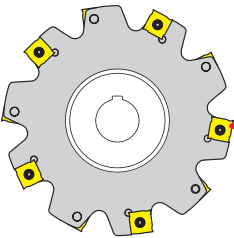


規格 Spec.	D	d ₁	d ₂	b ₁	b ₂	刃數 Flutes	刀 片 Insert	重量 (KGS) Weight
SDC-160-06B40	40	160	55	6	12	16	SN..1203	1.04
SDC-160-07B40	40	160	55	7	12	15	SN..1203	1.17
SDC-160-08B40	40	160	55	8	12	15	SN..1203	1.26
SDC-160-09B40	40	160	55	9	12	16	SN..1205	1.35
SDC-160-10B40	40	160	55	10	12	16	SN..1205	1.48
SDC-160-12B40	40	160	55	12	12	16	SN..1207	1.74
SDC-160-14B40	40	160	55	14	12	15	SN..1207	1.99
SDC-200-06B50	50	200	69	6	12	18	SN..1203	-
SDC-200-08B50	50	200	69	8	12	18	SN..1203	-
SDC-200-10B50	50	200	69	10	12	18	SN..1205	-
SDC-200-12B50	50	200	69	12	12	18	SN..1207	-
SDC-200-14B50	50	200	69	14	14	18	SN..1207	3.20
SDC-250-08B50	50	250	69	8	12	24	SN..1203	4.30
SDC-250-10B50	50	250	69	10	12	24	SN..1205	4.30
SDC-250-12B50	50	250	69	12	12	24	SN..1207	4.50
SDC-250-14B50	50	250	69	14	14	24	SN..1207	4.50

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SN..1203	M4-5.0-6.2-90	T15	3.0
SN..1205	M4-8.2-6.2-90	T15	3.0
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0

⚠ 請注意! Cautions!



刀片安裝時，需留意刀尖方向
(如圖示紅色準心)

When installing inserts,
need to notice the direction
of the nose. (red aim point of
drawing)

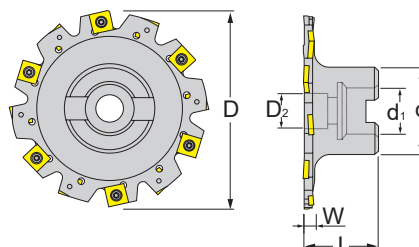
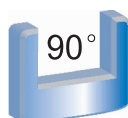
SNFX 捨棄式側銑刀片系列

SNFX INDEXABLE SIDE DISC CUTTER INSERT SERIES



GDC 捨棄式側銑刀

GDC Indexable Side Disc Cutter Insert



規格 Spec.	L	D	D ₂	d	d ₁	W	刃數 Flutes	刀 片 Insert	重量 (KGS) Weight
GDC-80-04B22	40	80	28	45	22	4	10	SN..1102	0.50
GDC-80-05B22	40	80	28	45	22	5	10	SN..1103	0.50
GDC-80-06B22	40	80	28	45	22	6	8	SN..1203	0.55
GDC-80-07B22	40	80	28	45	22	7	9	SN..1203	0.57
GDC-80-08B22	40	80	28	45	22	8	9	SN..1203	0.70
GDC-80-09B22	40	80	28	45	22	9	8	SN..1205	0.60
GDC-80-10B22	40	80	28	45	22	10	8	SN..1205	0.62
GDC-80-12B22	40	80	28	45	22	12	8	SN..1207	0.66
GDC-80-14B22	40	80	28	45	22	14	9	SN..1207	0.70
GDC-100-04B27	40	100	33	50	27	4	12	SN..1102	0.74
GDC-100-05B27	40	100	33	50	27	5	12	SN..1103	0.70
GDC-100-06B27	40	100	33	50	27	6	10	SN..1203	0.73
GDC-100-07B27	40	100	33	50	27	7	9	SN..1203	0.76
GDC-100-08B27	40	100	33	50	27	8	9	SN..1203	0.80
GDC-100-09B27	40	100	33	50	27	9	10	SN..1205	0.82
GDC-100-10B27	40	100	33	50	27	10	10	SN..1205	0.86
GDC-100-12B27	40	100	33	50	27	12	10	SN..1207	0.90
GDC-100-14B27	40	100	33	50	27	14	9	SN..1207	0.98
GDC-125-04B32	45	125	43	70	32	4	14	SN..1102	1.30
GDC-125-05B32	45	125	43	70	32	5	14	SN..1103	1.40
GDC-125-06B32	45	125	43	70	32	6	12	SN..1203	1.40
GDC-125-07B32	45	125	43	70	32	7	12	SN..1203	1.45
GDC-125-08B32	45	125	43	70	32	8	12	SN..1203	1.45
GDC-125-09B32	45	125	43	70	32	9	12	SN..1205	1.58
GDC-125-10B32	45	125	43	70	32	10	12	SN..1205	1.58
GDC-125-12B32	45	125	43	70	32	12	12	SN..1207	1.65
GDC-125-14B32	45	125	43	70	32	14	12	SN..1207	1.76
GDC-160-06B40	50	160	50	90	40	6	16	SN..1203	2.60
GDC-160-07B40	50	160	50	90	40	7	15	SN..1203	2.60
GDC-160-08B40	50	160	50	90	40	8	15	SN..1203	2.80
GDC-160-09B40	50	160	50	90	40	9	16	SN..1205	2.80
GDC-160-10B40	50	160	50	90	40	10	16	SN..1205	2.90
GDC-160-12B40	50	160	50	90	40	12	16	SN..1207	3.08
GDC-160-14B40	50	160	50	90	40	14	15	SN..1207	0.23

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SN..1102	M3-3.5-5.0-90	T7	0.9
SN..1103	M3-4.3-5.0-90	T7	0.9
SN..1203	M4-5.0-6.2-90	T15	3.0
SN..1205	M4-8.2-6.2-90	T15	3.0
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0



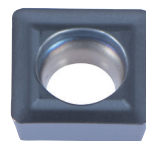
SP 四角捨棄式側銑刀片系列

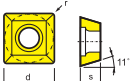
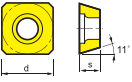
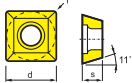
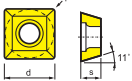
SP INDEXABLE SIDE DISC CUTTER INSERT SERIES



SP 四角捨棄式側銑刀片

SP Indexable Side Disc Cutter Insert



ISO 分類	P	合金鋼 Alloyed Steels	○	○	○	○										切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting		
	M	不鏽鋼 Stainless Steels	○	○		○												
	K	鑄鐵 Cast Iron	○	○														
	N	鋁及鋁合金 Aluminum&Al								■								
	S	高溫合金 Refractory Alloys																
	H	高硬度材 Hard Material	○															
形狀 Shape	規格 Spec.	鍍層超微粒 Layer coated micro grain	超微粒硬質合金 Micro grain cemented carbide								尺寸 (mm)				圖形 Drawing			
		CHF						HF						Size				
		OM4010	OM4025	RM4025	RM4030			OM5005								d	i	s
	SPGT060204-M02				●									6	-	2.38	0.4	
	SPMT090308-M01			●										9.525	-	3.18	0.8	
	SPMW090304	●	●											9.525	-	3.18	0.4	
	SPET120408-M02						●							12.7	-	4.76	0.8	
	SPMT120408-R01			●										12.7	-	4.76	0.8	

SP_06.09.12 切削條件數據表 Cutting Parameter

被加工材質 Machining Materials		刀片材質 Grade	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)	切深 Ap(mm)
P	低合金鋼 Low-Alloy Steels	OM4010	100~220	0.10~0.35	2.0~9.0
		OM4025	100~220	0.10~0.35	2.0~9.0
		RM4025	100~220	0.10~0.35	2.0~9.0
	合金鋼 Alloyed Steels	OM4010	70~120	0.10~0.25	1.0~5.0
		OM4025	70~120	0.10~0.25	1.0~5.0
		RM4025	70~120	0.10~0.25	1.0~5.0
M	不鏽鋼 Stainless Steels	OM4010	130~200	0.12~0.30	3.0~8.0
		OM4025	130~200	0.12~0.30	3.0~8.0
K	鑄鐵 Cast Iron	OM4025	100~210	0.10~0.20	2.0~9.0
		RM3130	100~210	0.10~0.20	2.0~9.0
N	鋁合金 Aluminum&Al	OM5005	300(250-450)	0.2(0.15-0.35)	2.0~9.0

主軸轉速 = (1000 × 切削速度) ÷ (3.14 × 刀具外徑) Spindle Speed = (1000 × Cutting speed) ÷ (3.14 × Cutter outer diameter).

18 | 床檯進給 (mm/min) = 每刃進給 × 刀具刃數 × 主軸轉速 Feeding Speed(mm/min) = Feed per Flutes × Flutes × Spindle speed.

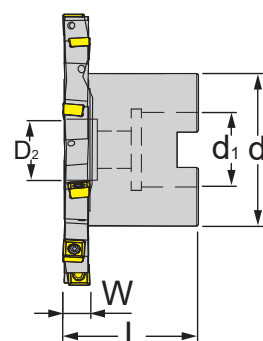
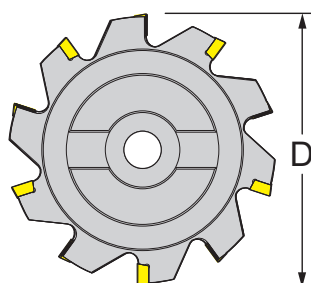
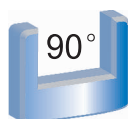
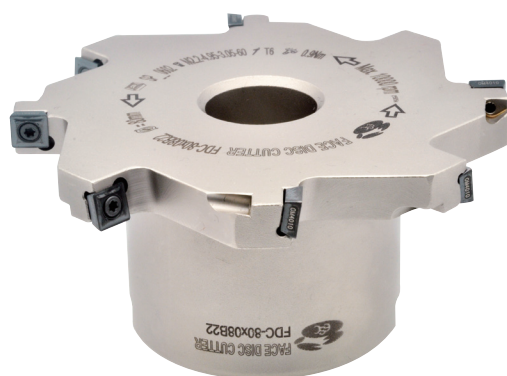
SP 四角捨棄式側銑刀片系列

SP INDEXABLE SIDE DISC CUTTER INSERT SERIES



FDC 捨棄式側銑刀

FDC Indexable Side Disc Cutter



特點 Feature

- 採用抗震性工具鋼材質
- 整體預硬後，再行精修，避免二次處理所產生應變
- 刀片使用四個刃口，可有效降低成本
- Made of anti-vibration tool steel.
- After the heat treatment, we will finish the cutter again for better accuracy.
- 4 edges usable, effective cost-saving.

規格 Spec.	L	D	D ₂	d	d ₁	W	刃數 Flutes	刀 片 Insert	重量 (KGS) Weight
FDC-80-08B22	40	80	18	45	22	8	8	SP.0602	0.73
FDC-100-08B27	40	100	19	50	27	8	10	SP.0602	0.96
FDC-100-10B27	40	100	19	50	27	10	10	SP.0602	1.03
FDC-100-14B27	40	100	19	50	27	14	10	SP.0903	1.02
FDC-125-10B32	45	125	43	70	32	10	12	SP.0602	1.70
FDC-125-12B32	45	125	43	70	32	12	12	SP.0903	1.70
FDC-160-12B40	50	160	50	80	40	12	14	SP.0903	2.70
FDC-200-12B40	50	200	50	90	40	12	16	SP.0903	4.00
FDC-125-16B32	45	125	43	70	32	16	10	SP.1204	1.80
FDC-160-16B40	50	160	50	80	40	16	12	SP.1204	2.90
FDC-160-18B40	50	160	50	80	40	18	12	SP.1204	2.90
FDC-200-16B40	50	200	50	90	40	16	14	SP.1204	4.50
FDC-200-18B40	50	200	50	90	40	18	14	SP.1204	4.90
FDC-200-20B40	50	200	50	90	40	20	14	SP.1204	5.19

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP.0602	M2.2-5.2-3.1-60-T7-TIN	T7	0.9
SP.0903	M4-10-5.7-60	T15	3.0
SP.1204	M5-11-6.4-43	T20	5.0

★ 推薦 Recommended

被加工材質 Machining Materials		切削速度 Vc(m/min)	每刃進給 fz(mm/rev)
P	合金鋼 Alloyed Steel	130~200	0.08~0.12
K	鑄鐵 Cast Iron	110~230	0.07~0.01
N	鋁及鋁合金 Aluminum&Al	180~600	0.12~0.15

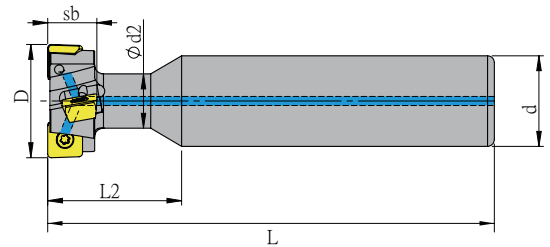
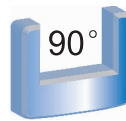
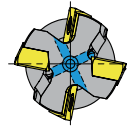
主軸轉速 = (1000 × 切削速度) ÷ (3.14 × 刀具外徑) Spindle Speed = (1000 × Cutting speed) ÷ (3.14 × Cutter outer diameter).

床檯進給 (mm/min)= 每刃進給 × 刀具刃數 × 主軸轉速 Feeding Speed(mm/min)= Feed per Flutes× Flutes× Spindle speed.

SP 四角 T 形槽端銑刀片系列 SP T-SLOT END MILL INSERT SERIES



BTS/T 形槽端銑刀 BTS T-slot End Mill



特點 Feature

- 採用抗震性工具鋼材質，中心出水
- 整體預硬後，再行精修，避免二次處理所產生應變
- Made of anti-vibration tool steel with through coolant.
- After the heat treatment, we will finish the cutter again for better accuracy.

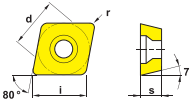
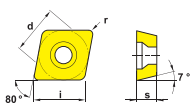
規格 Spec.	D	sb	d2	L2	L	d	t	刀片 Insert
NEW BTS-1210-SO04-07	12	7	6	15	80	10	2	SO..0402
NEW BTS-1612-SO04-07	16	7	8	20	100	12	4	SO..0402
BTS-1916-SP05-08	19	8	9.5	25	120	16	4	SP.0502
BTS-2116-SP06-09	21	9	11	27	120	16	4	SP.0602
BTS-2520-SP07-11	25	11	12	30	120	20	4	SP.07T3
BTS-3225-SP07-11	32	11	23	30	150	25	4	SP.07T3
BTS-3225-SP09-14	32	14	17	39	150	25	4	SP.0904
BTS-3525-SP09-14	35	14	20	39	150	25	4	SP.0904
BTS-4025-SP11-18	40	18	21	49	150	25	4	SP.1104
BTS-5032-SP14-22	50	22	27	61	150	32	4	SP.1405
BTS-5525-SP07-11	55	11	20	40	180	25	6	SP.07T3
BTS-6025-SP09-15	60	15	25	40	180	25	6	SP.0904
BTS-6032-SP14-15	60	25	32	55	180	32	4	SP.1405

NEW 新品 New Product

配件表 Accessories

刀片 Insert	板手 Wrench	螺絲 Screw	扭力值 (N.m) Torque
SO..0402	T6	M2-3.8-2.68-43	0.6
SP.0502	T6	M2-4.3-2.7-60-T6-TIN	0.6
SP.0602	T7	M2.2-5.2-3.1-60-T7-TIN	0.9
SP.07T3	T8	M2.5-6.33-3.5-48-T8-TIN	1.2
SP.0904	T10	M3.5-8.4-5.0-60-T10-TIN	2.0
SP.1104	T15	M4-9.35-5.65-60-T15-TIN	3.0
SP.1405	T20	M5-12.8-7.0-60-T20-TIN	5.0



ISO 分類	P	合金鋼 Alloyed Steels	○											切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting	
	M	不鏽鋼 Stainless Steels	○												
	K	鑄鐵 Cast Iron		○											
	N	鋁及鋁合金 Aluminum&Al						○							
	S	高溫合金 Refractory Alloys													
	H	高硬度材 Hard Material													
形狀 Shape	規格 Spec.	鍍層硬質合金 Layer coated carbide alloy				超微粒硬質合金 Micro grain carbide alloy				尺寸 (mm)				圖形 Drawing	
		CVD				HF				Size					
		RM425	RM315				RM5005					d	i		s
	CCMT060204-HM	●	●								6.35	6.4	2.38	0.4	
	CCMT060208-HM	●	●								6.35	6.4	2.38	0.8	
	CCMT09T304-HM	●	●								9.525	9.7	3.97	0.4	
	CCMT09T308-HM	●	●								9.525	9.7	3.97	0.8	
	CCMT120404-HM	●	●								12.7	12.9	4.76	0.4	
	CCMT120408-HM	●	●								12.7	12.9	4.76	0.8	
	CCGT060202-NK						●				6.35	6.5	2.38	0.2	
	CCGT060204-NK						●				6.35	6.5	2.38	0.4	
	CCGT060208-NK						●				6.35	6.5	2.38	0.8	
	CCGT09T304-NK						●				9.525	9.7	3.97	0.4	
	CCGT09T308-NK						●				9.525	9.7	3.97	0.8	
	CCGT120404-NK						●				12.7	12.9	4.76	0.4	
	CCGT120408-NK						●				12.7	12.9	4.76	0.8	
	CCGT120408-NK						●				12.7	12.9	4.76	0.8	

★ 推薦 Recommended NEW 新品 New Product

CC_06.09.12

切削條件數據表 Cutting Parameter

被加工材質 Machining Materials	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)
P 合金鋼 Alloyed Steel	180~220	0.08~0.12
K 鑄鐵 Cast Iron	110~230	0.07~0.01
N 鋁及鋁合金 Aluminum&Al	180~600	0.12~0.15

主軸轉速 = (1000 × 切削速度) ÷ (3.14 × 刀具外徑) Spindle Speed = (1000 × Cutting speed) ÷ (3.14 × Cutter outer diameter).

床檯進給 (mm/min) = 每刃進給 × 刀具刃數 × 主軸轉速 Feeding Speed(mm/min) = Feed per Flutes × Flutes × Spindle speed.

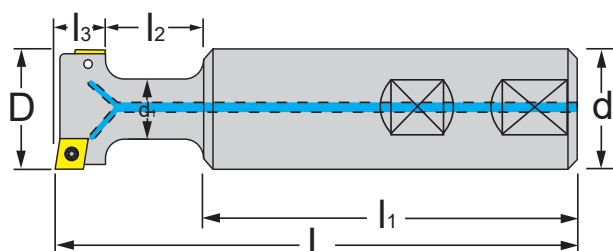
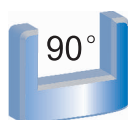
CCMT T 形槽端銑刀片系列

CCMT T-SLOT END MILL INSERT SERIES



ATS T 形槽端銑刀

ATS T-slot End Mill



特點 Feature

- 採用抗震性工具鋼材質，中心出水
- 整體預硬後，再行精修，避免二次處理所產生應變

- Made of anti-vibration tool steel with through coolant.
- After the heat treatment, we will finish the cutter again for better accuracy.

規格 Spec.	L	l ₁	l ₂	l ₃	D	d	d ₁	刃數 Flutes	刀片 Insert	重量 (KGS) Weight
ATS-25-11	112	80	21	11	25	25	12.5	2	CC..0602	0.35
ATS-32-14	120	77	30	14	32	32	16	4	CC..0803	0.55
ATS-40-18	130	80	32	18	40	32	20	4	CC..09T3	0.67
ATS-50-22	140	80	39	22	50	32	26	4	CC..1204	0.77

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
CC..0602	M2.5-6.0-3.5-60	T8	1.2
CC..0803	M3-8.0-4.0-43	T9	1.4
CC..09T3	M4-10-5.7-60	T15	3.0
CC..1204	M5-11-7.5-60	T20	5.0

JIS B 0952-1987
JIS B 0953-1987

公稱 尺寸	A					B		C		H		參考		JIS B 0953
	基準 尺寸	容許差				基準 尺寸	容許差	基準 尺寸	容許差	最大值	最小值	n 最大	f 最大	槽間隔 p
		1 級 H8	2 級 H12	3 級 H14	4 級									
5	5	+0.018 0	+0.12 0	-	-	10	+1 0	3	+0.5 0	10	8	1	0.6	20、25、32
6	6					11	+1.5 0	5		13	11			25、32、40
8	8	+0.022	+0.15	-	-	14.5	0	7	+1 0	18	15			32、40、50
10	10	0	0			16				21	17			40、50、63
12	12					19	+2 0			8				25
14	14	+0.027	+0.18	+0.43	+2.7 0	23	0	9		28	23			63、80、100
18	18	0	0	0	0	30		12	+2 0	36	30	1.6	1	80、100、125
22	22	+0.033	+0.21	+0.52	+3.3 0	37	+3 0	16		45	38			100、125、160
28	28	0	0	0	0	46		20		56	48			125、160、200
36	36					56	+4 0	25	+3 0	71	61			160、200、250
42	42	+0.039	+0.25	+0.62	+0.39 0	68	0	32		85	74			200、250、320
48	48	0	0	0		80		36	+4 0	95	84	250、320、400		
54	54	+0.046 0	+0.30 0	+0.74 0		90	+5 0	40		106	94	320、400、500		



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