多功能倒角銑刀桿系列

Multipurpose Chamfering Toolholders Series

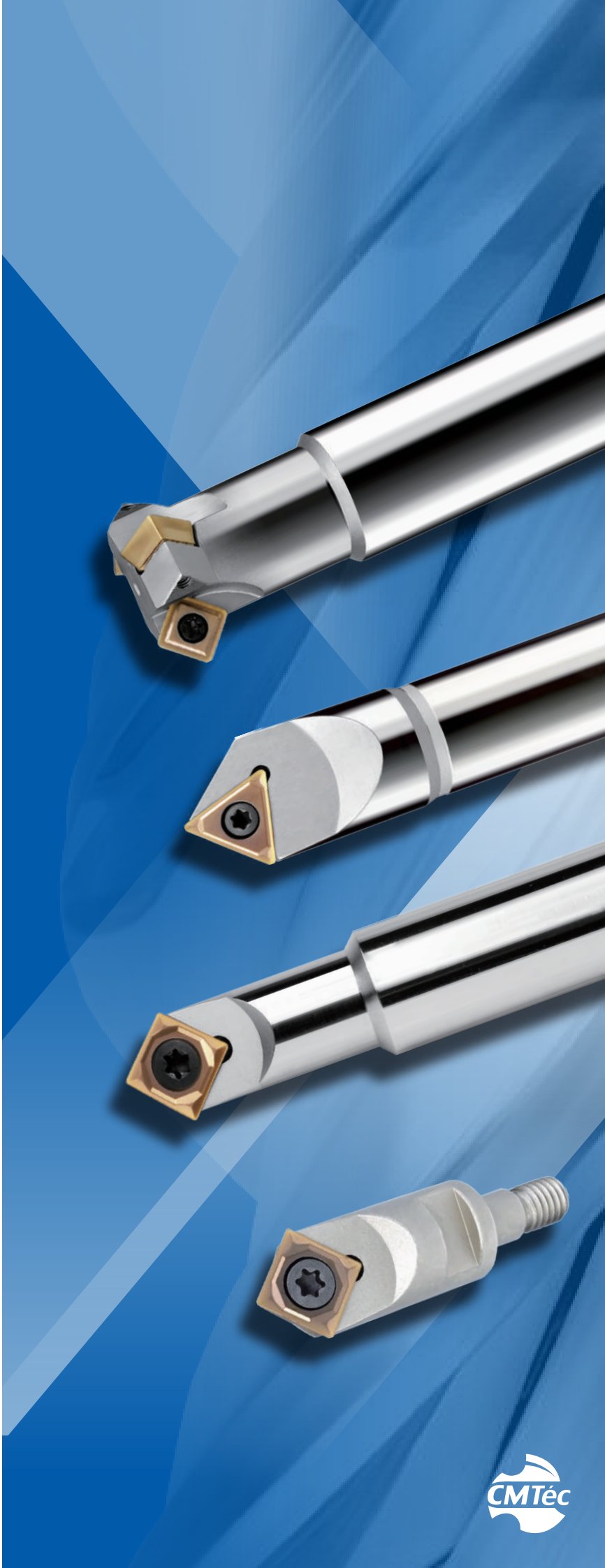
泛用鋼材≦50HRC

不銹鋼

鋁合金 / 銅合金

鑄鐵

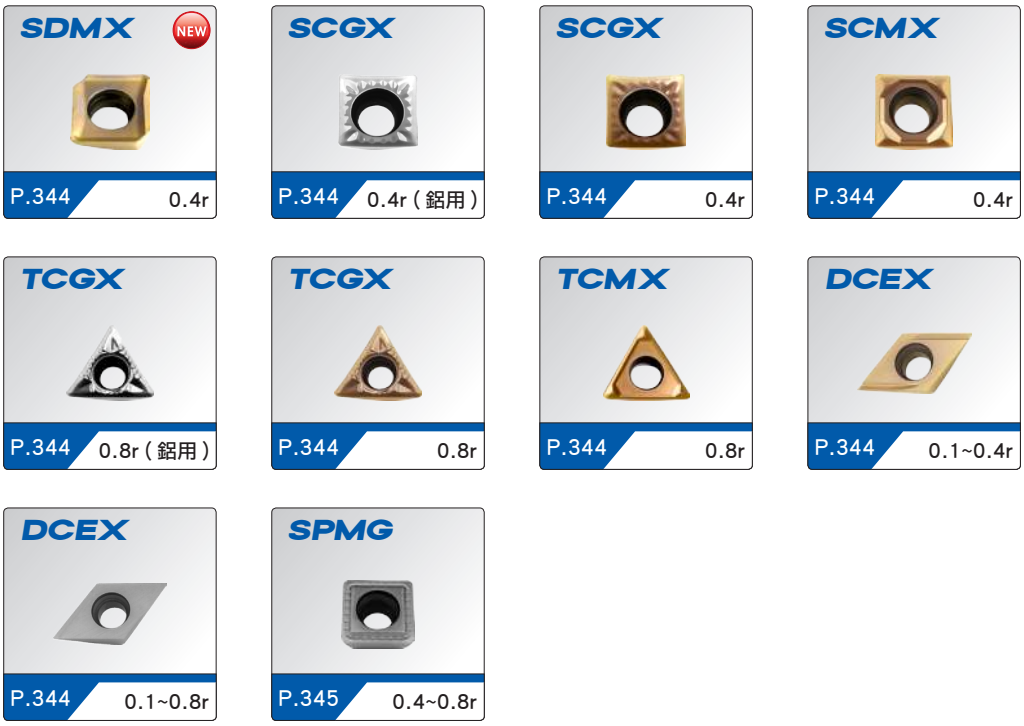
For general steel (≦50HRC), stainless steel, cast iron and aluminum/copper alloy machining.



產品選擇表
Product Selection Table

鎢鋼倒角銑刀片 Carbide Chamfering Inserts

刀片單面使用
Single-Sided
Inserts



多功能倒角加工 Multipurpose Chamfering

刀片單面使用
Single-Sided
Inserts

產品選擇表
Product Selection Table

倒角加工 Chamfering

刀片單面使用
Single-Sided
Inserts

鎢鋼抗震刀桿 Carbide Vibration Holder

計算倒角加工
寬度 Ae
How to calculate
Chamfering
width(Ae)
P.353

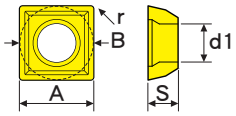
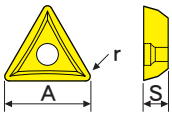
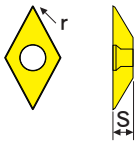
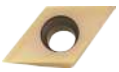
鎢鋼倒角銑刀片

CARBIDE CHAMFERING INSERTS

加工材質		CM10	CM6337	CM6347	CM6213	CM6223	CM6032	CM6233	CM6243
P	鋼材 Alloy Steels	—			○		◎	◎	
M	不銹鋼 Stainless Steels	—			○		◎	◎	
K	鑄鐵 Cast Iron	—			○		◎	◎	
N	鋁合金 Aluminum Alloys	◎			—		—	—	
S	高溫合金 High Temp Alloys	—			○		◎	◎	
H	調質鋼 Hardened Steels	—			◎		◎	◎	

◎：第一推薦 First Recommend
○：第二推薦 Second Recommend
—：不推薦 NO Recommend

F：精加工 Finishing
S：半精加工 Semi Finishing
M：中加工 Medium
R：粗加工 Roughing

刀 片 Insert	訂購編號 Order No.	材質碼 Grade CVD CM10	CVD CM6337	CVD CM6347	PVD CM6213	PVD CM6223	PVD CM6032	PVD CM6233	PVD CM6243	尺寸 Dimension (mm) A	B	S	r	d1	刀片 2D 圖 Drawing	刀桿頁數 Tool Page
應用於倒角加工、定點加工、開 V 槽加工、雕刻加工【刀片單面使用】。 Chamfering & Countersinking, Spotting, V-Grooving, Engraving【Single-Sided Inserts】.																
NEW	SDMX05T104-FG				●			●		—	—	—	—	—		346
F S M R																
	SCGX09T304-AG	●								9.53	9.53	3.97	0.4	4.4		347
F S M R																
	SCGX09T304-FG				●					9.53	9.53	3.97	0.4	4.4		
F S M R																
	SCMX09T304-SM						●			9.53	9.53	3.97	0.4	4.4		
F S M R																
	TCGX16T308-AG	●								16.5	—	3.97	0.8	—		348
F S M R																
	TCGX16T308-FG						●			16.5	—	3.97	0.8	—		
F S M R																
	TCMX16T308-SM						●			16.5	—	3.97	0.8	—		
F S M R																
	DCEX11T301-FX						●			—	—	3.97	0.1	—		349
	DCEX11T302-FX						●			—	—	3.97	0.2	—		
	DCEX11T304-FX						●			—	—	3.97	0.4	—		
F S M R																
	DCEX11T301						●			—	—	3.97	0.1	—		
	DCEX11T302						●			—	—	3.97	0.2	—		
	DCEX11T304						●			—	—	3.97	0.4	—		
F S M R	DCEX11T308						●			—	—	3.97	0.8	—		

切削條件表 Cutting Condition P.608, 618

鎢鋼倒角銑刀片

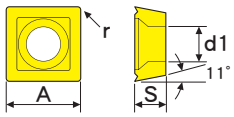
CARBIDE CHAMFERING INSERTS

加工材質		CM10	CM6337	CM6347	CM6213	CM6223	CM6032	CM6233	CM6243
P	鋼材 Alloy Steels						◎	◎	◎
M	不銹鋼 Stainless Steels						◎	◎	◎
K	鑄鐵 Cast Iron						◎	◎	◎
N	鋁合金 Aluminum Alloys						—	—	—
S	高溫合金 High Temp Alloys						◎	◎	◎
H	調質鋼 Hardened Steels						◎	◎	—

◎：第一推薦 First Recommend
O：第二推薦 Second Recommend
—：不推薦 NO Recommend

F：精加工 Finishing
S：半精加工 Semi Finishing
M：中加工 Medium
R：粗加工 Roughing

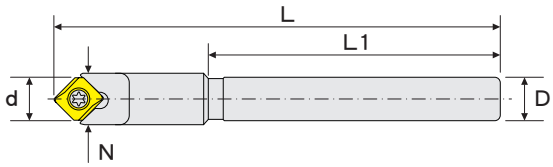
應用於倒角加工【刀片單面使用】。 Chamfering【Single-Sided Inserts】.

刀片 Insert	訂購編號 Order No.	材質碼 Grade CVD CM10	CVD CM6337	CVD CM6347	PVD CM6213	PVD CM6223	PVD CM6032	PVD CM6233	PVD CM6243	尺寸 Dimension (mm) A	B	S	r	d1	刀片 2D 圖 Drawing	刀桿頁數 Tool Page
T	SPMG050204-MG						●	●	●	5.00	—	2.38	0.4	2.30		350
F S M R																
T	SPMG060204-MG						●	●	●	6.00	—	2.38	0.4	2.65		
F S M R																
T	SPMG07T308-MG						●	●	●	7.94	—	3.97	0.8	2.85		
F S M R																
T	SPMG090408-MG						●	●	●	9.80	—	4.30	0.8	4.05		
F S M R																
T	SPMG090408-RG						●	●	●	9.80	—	4.30	0.8	4.05		
F S M R																
T	SPMG110408-MG						●	●	●	11.5	—	4.80	0.8	4.45		—
F S M R																
T	SPMG110408-RG						●	●	●	11.5	—	4.80	0.8	4.45		
F S M R																

➡ 切削條件表 Cutting Condition P.609

ECSD 多功能倒角型銑刀桿

MULTIPURPOSE- CHAMFERING TOOLHOLDERS- ECSD



Milling Table 193

訂購編號 Order No.	尺寸 Dimensions (mm)					刀片數量 Teeth	搭配刀片 Insert	Screw	Wrench
	d	L1	N	L	D				
ECSD05-01005-040L	5.5	20	7	40	6	1	SDMX05T1..	TS1801	ETF06
ECSD05-01005-060L	5.5	40	7	60	6	1			

搭配刀片 Insert P.344
切削條件表 Cutting Condition P.618

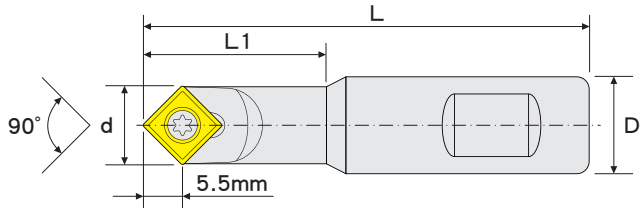
※ 型號後端 -C 為出水孔設計。 Product number end in -C are coolant-through design.

應用材質 Work Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels		調質鋼 Hardened Steels		不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys	高溫合金 High-Temp Alloys
	HRC<20	HRC20~30	HRC30~45	HRC45~55	HRC55~63	—	HRC<30	—	HRC<30
	◎	◎	◎	—	—	◎	◎	—	○

◎：第一推薦 First Recommend　○：第二推薦 Second Recommend　—：不推薦 NO Recommend

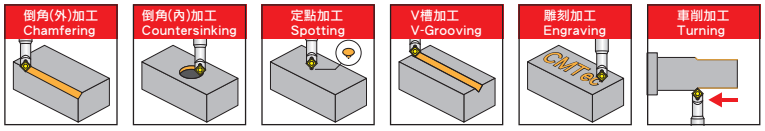
ECSC 多功能倒角型銑刀桿

MULTIPURPOSE- CHAMFERING TOOLHOLDERS- ECSC

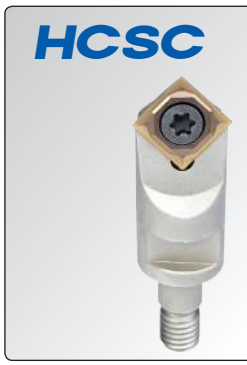


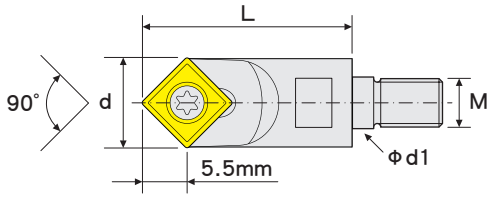
Milling Table 181

訂購編號 Order No.	尺寸 Dimensions (mm)				刀片數量 Teeth	搭配刀片 Insert	Screw	Wrench
	d	L1	L	D				
ECSC09-01013-100L	13	29	100	10	1	SCGX09T3.. SCMX09T3..	TS3520	ETF15
ECSC09-01013-100L-12	13	29	100	12	1			
ECSC09-01013-100L-16	13	29	100	16	1			
ECSC09-01013-150L-16	13	29	150	16	1			



搭配刀片 Insert P.344
切削條件表 Cutting Condition P.608





Milling Table 181

訂購編號 Order No.	尺寸 Dimensions (mm)				刀片數量 Teeth	搭配刀片 Insert	Wrench	Screw	Wrench
	d	L1	d1	M					
HCSC09-01013	13	30	6.5	M6	1	SCGX09T3.. SCMX09T3..	TC08	TS3520	ETF15

搭配刀片 Insert P.344
切削條件表 Cutting Condition P.608
搭配刀桿 Holder P.351, 352

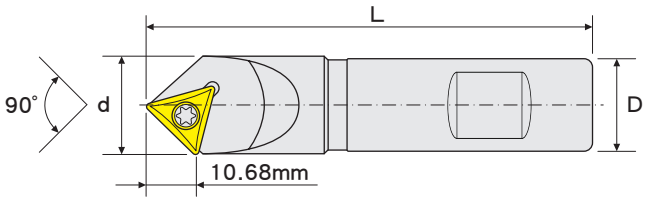
※ 型號後端 -C 為出水孔設計。 Product number end in -C are coolant-through design.

應用材質 Work Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels		調質鋼 Hardened Steels		不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys	高溫合金 High-Temp Alloys
	HRC<20	HRC20~30	HRC30~45	HRC45~55	HRC55~63		HRC<30		HRC<30
	◎	◎	◎	○	—	◎	◎	◎	○

◎：第一推薦 First Recommend　○：第二推薦 Second Recommend　—：不推薦 NO Recommend

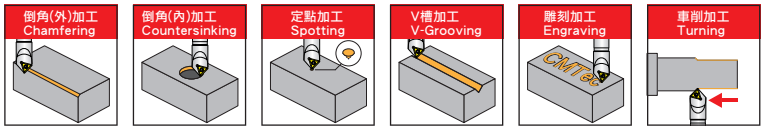
ECTCX 多功能倒角型銑刀桿

MULTIPURPOSE- CHAMFERING TOOLHOLDERS- ECTCX



Milling Table 181

訂購編號 Order No.	尺寸 Dimensions (mm)				刀片數量 Teeth	搭配刀片 Insert	Screw	Wrench
	d	—	L	D				
ECTCX16-01020-120L	20	—	120	20	1	TCGX16T3.. TCMX16T3..	TS3521	ETF15
ECTCX16-01020-150L	20	—	150	20	1			



搭配刀片 Insert P.344
切削條件表 Cutting Condition P.608

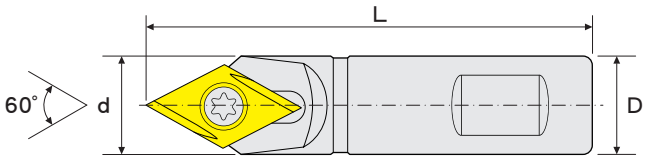
※ 型號後端 -C 為出水孔設計。 Product number end in -C are coolant-through design.

應用材質 Work Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels		調質鋼 Hardened Steels		不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys	高溫合金 High-Temp Alloys
	HRC<20	HRC20~30	HRC30~45	HRC45~55	HRC55~63		HRC<30		HRC<30
	◎	◎	◎	○	—	○	◎	◎	○

◎：第一推薦 First Recommend　○：第二推薦 Second Recommend　—：不推薦 NO Recommend

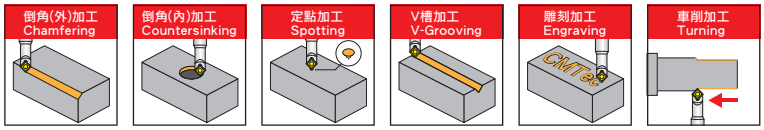
ECDC 多功能倒角型銑刀桿

MULTIPURPOSE- CHAMFERING TOOLHOLDERS- ECDC



Milling Table 181

訂購編號 Order No.	尺寸 Dimensions (mm)				刀片數量 Teeth	搭配刀片 Insert	Screw	Wrench
	d	–	L	D				
ECDC11-01012-060L	12	–	60	10	1	DCEX11T3..	TS3520	ETF15
ECDC11-01012-100L	12	–	100	12	1			



搭配刀片 Insert P.344
切削條件表 Cutting Condition P.608

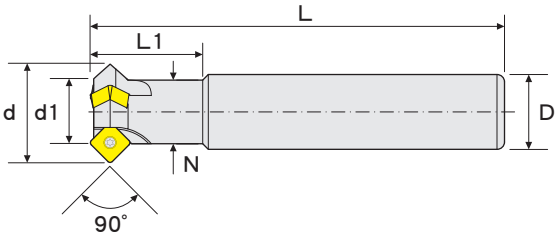
※ 型號後端 -C 為出水孔設計。 Product number end in -C are coolant-through design.

應用材質 Work Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels		調質鋼 Hardened Steels		不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys	高溫合金 High-Temp Alloys
	HRC<20	HRC20~30	HRC30~45	HRC45~55	HRC55~63		HRC<30		HRC<30
	◎	◎	◎	○	—	○	◎	—	○

◎：第一推薦 First Recommend　○：第二推薦 Second Recommend　—：不推薦 NO Recommend

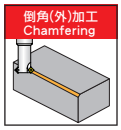
ECSP 倒角型銑刀桿

CHAMFERING TOOLHOLDERS- ECSP



Milling Table 182

訂購編號 Order No.	尺寸 Dimensions (mm)						刀片數量 Teeth	搭配刀片 Insert	Screw	Wrench
	d	d1	L1	N	L	D				
ECSP05-02015-120L	15	8.26	20	10	120	12	2	SPMG0502..	TS2003	ETF06
ECSP05-03017-150L	17	10.26	25	11	150	16	3			
ECSP05-03019-150L	19	12.26	30	13	150	16	3			
ECSP05-04024-150L	24	17.26	35	18	150	20	4			
ECSP06-03022-120L	22	13.85	30	16	120	16	3	SPMG0602..	TS2205	ETF06
ECSP07-03027-120L	27	16.44	30	17	120	20	3	SPMG07T3..	TS2511	ETF08
ECSP09-02030-150L	30	16.80	40	19	150	20	2	SPMG0904..	TS3504	ETF15
ECSP09-03040-150L	40	26.80	40	29	150	25	3			
ECSP09-04050-150L	50	36.80	40	39	150	25	4			



搭配刀片 Insert P.345
切削條件表 Cutting Condition P.609

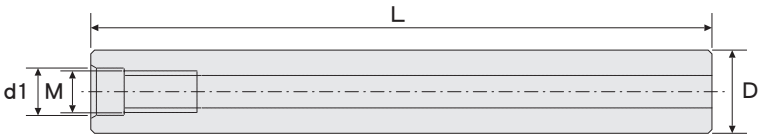
※ 型號後端 -C 為出水孔設計。 Product number end in -C are coolant-through design.

應用材質 Work Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels		調質鋼 Hardened Steels		不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys	高溫合金 High-Temp Alloys
	HRC<20	HRC20~30	HRC30~45	HRC45~55	HRC55~63		HRC<30		HRC<30
	◎	◎	◎	○	—	◎	◎	—	○

◎：第一推薦 First Recommend　○：第二推薦 Second Recommend　—：不推薦 NO Recommend

鎢鋼抗震刀桿

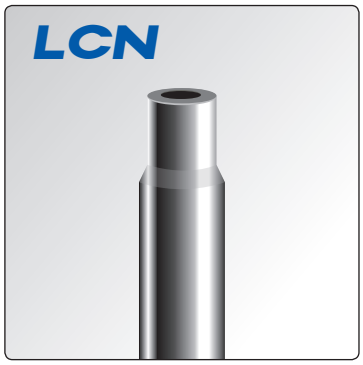
CARBIDE ANTI-VIBRATION HOLDER

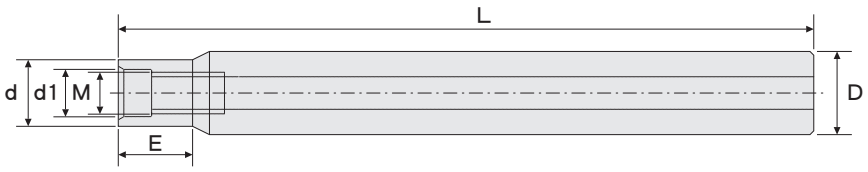


訂購編號 Order No.	尺寸 Dimensions (mm)			
	螺紋 Thread	柄徑 D	d1	全長 L
LCL008-060L	M4 × 0.7	8	4.5	60
LCL008-100L	M4 × 0.7	8	4.5	100
LCL008-120L	M4 × 0.7	8	4.5	120
LCL010-075L	M5 × 0.8	10	5.5	75
LCL010-100L	M5 × 0.8	10	5.5	100
LCL010-150L	M5 × 0.8	10	5.5	150
LCL012-075L	M6 × 1.0	12	6.5	75
LCL012-100L	M6 × 1.0	12	6.5	100
LCL012-150L	M6 × 1.0	12	6.5	150
LCL012-200L	M6 × 1.0	12	6.5	200
LCL016-100L	M8 × 1.25	16	8.5	100
LCL016-150L	M8 × 1.25	16	8.5	150
LCL016-200L	M8 × 1.25	16	8.5	200
LCL016-250L	M8 × 1.25	16	8.5	250
LCL020-100L	M10 × 1.5	20	10.5	100
LCL020-150L	M10 × 1.5	20	10.5	150
LCL020-200L	M10 × 1.5	20	10.5	200
LCL020-250L	M10 × 1.5	20	10.5	250
LCL020-300L	M10 × 1.5	20	10.5	300
LCL025-100L	M12 × 1.75	25	12.5	100
LCL025-150L	M12 × 1.75	25	12.5	150
LCL025-200L	M12 × 1.75	25	12.5	200
LCL025-250L	M12 × 1.75	25	12.5	250
LCL025-300L	M12 × 1.75	25	12.5	300
LCL032-100L	M16 × 2.0	32	17.0	100
LCL032-150L	M16 × 2.0	32	17.0	150
LCL032-200L	M16 × 2.0	32	17.0	200
LCL032-250L	M16 × 2.0	32	17.0	250
LCL032-300L	M16 × 2.0	32	17.0	300

鎢鋼抗震刀桿 - 頸型

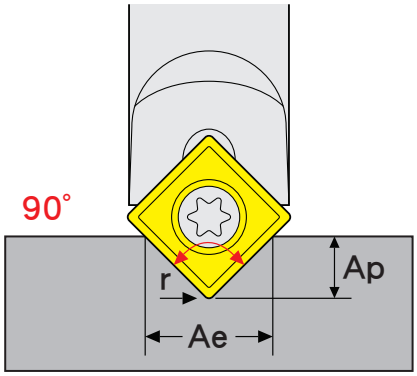
CARBIDE ANTI-VIBRATION HOLDER- NECK



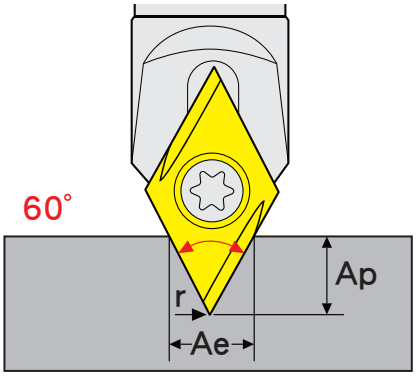


訂購編號 Order No.	尺寸 Dimensions (mm)					
	螺紋 Thread	刃徑 d	d1	有效長 E	全長 L	柄徑 D
LCN011-075L-030E	M6 × 1.0	11.7	6.5	30	75	12
LCN011-100L-040E	M6 × 1.0	11.7	6.5	40	100	12
LCN011-150L-050E	M6 × 1.0	11.7	6.5	50	150	12
LCN015-100L-040E	M8 × 1.25	15.7	8.5	40	100	16
LCN015-150L-050E	M8 × 1.25	15.7	8.5	50	150	16
LCN019-100L-040E	M10 × 1.5	19.5	10.5	40	100	20
LCN019-150L-050E	M10 × 1.5	19.5	10.5	50	150	20
LCN019-200L-060E	M10 × 1.5	19.5	10.5	60	200	20
LCN024-100L-040E	M12 × 1.75	24.5	12.5	40	100	25
LCN024-150L-050E	M12 × 1.75	24.5	12.5	50	150	25
LCN024-200L-060E	M12 × 1.75	24.5	12.5	60	200	25
LCN024-250L-080E	M12 × 1.75	24.5	12.5	80	250	25
LCN031-100L-040E	M16 × 2.0	31.5	17.0	40	100	32
LCN031-150L-050E	M16 × 2.0	31.5	17.0	50	150	32
LCN031-200L-060E	M16 × 2.0	31.5	17.0	60	200	32
LCN031-250L-080E	M16 × 2.0	31.5	17.0	80	250	32

計算倒角加工寬度 Ae
How to calculate Chamfering width(Ae)



倒角角度 90°
Chamfering Angle 90°
Formula：
公式：Ae ≒ 2×(Ap + 0.4r)



倒角角度 60°
Chamfering Angle 60°
Formula：
公式：Ae ≒ 0.58×(Ap + r)×2

範例 1.
倒角角度 = 90°
加工深度 Ap = 1mm
刀尖 r 角 = 0.4mm
求加工寬度 Ae?

Ae ≒ 2×(Ap + 0.4r)
≒ 2×(1 + (0.4×0.4))
≒ 2×1.16
≒ 2.32mm

範例 2.
倒角角度 = 90°
加工深度 Ap = 3mm
刀尖 r 角 = 0.4mm
求加工寬度 Ae?

Ae ≒ 2×(Ap + 0.4r)
≒ 2×(3 + (0.4×0.4))
≒ 2×3.16
≒ 6.32mm

範例 3.
倒角角度 = 60°
加工深度 Ap = 1mm
刀尖 r 角 = 0.1mm
求加工寬度 Ae?

Ae ≒ 0.58×(Ap + r)×2
≒ 0.58×(1 + 0.1)×2
≒ 0.58×1.1×2
≒ 1.27mm

範例 4.
倒角角度 = 60°
加工深度 Ap = 3mm
刀尖 r 角 = 0.4mm
求加工寬度 Ae?

Ae ≒ 0.58×(Ap + r)×2
≒ 0.58×(3 + 0.4)×2
≒ 0.58×3.4×2
≒ 3.94mm

MEMO