

ECSC 多功能捨棄式倒角刀

Indexable- Multipurpose Chamfering Cutter



SCMX09T304-SP
刀尖R角0.4R

特色 / FEATURES:

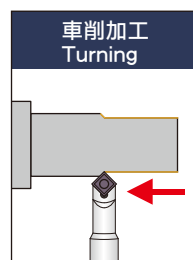
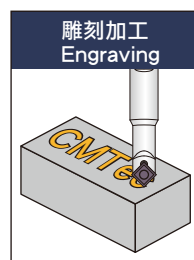
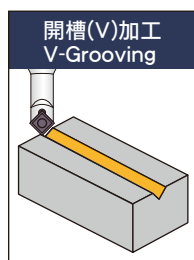
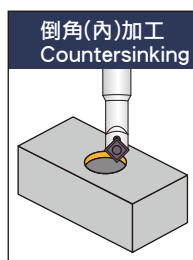
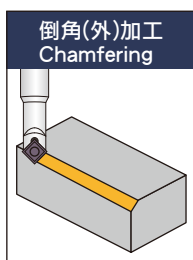
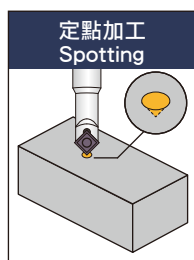
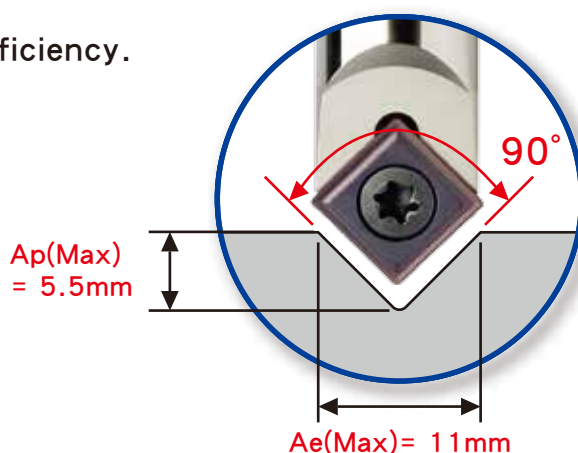
多功能加工方式，可提高性能和效率。
Multiple functions to increase performance and efficiency.

加工震動小、穩定性高。
Less vibration and higher stability.

適用於CNC銑床和CNC車、銑複合加工機。
Applicable to CNC milling machine / CNC turning and milling centers machine.

共有4個切削刃設計，降低客戶刀具使用量。
Total 4 cutting edges for cost-effective cutting.

適合一般鋼材、不銹鋼、鑄鐵之應用。
Use for steels, stainless steels and cast iron.



刀桿尺寸規格表 / HOLDER SIZE:

刀片型號 Insert: SCMX09T304-SP-CM2131

刃徑 Diameter	刃長(Max) Cutting Length	有效長 Effective Length	全長 O.A.L.	柄徑 Shank Dia.	型號 Model Number
13	5.5	29	100	10	ECSC09-01013-100L
13	5.5	29	100	12	ECSC09-01013-100L-12
13	5.5	29	100	16	ECSC09-01013-100L-16
13	5.5	29	150	16	ECSC09-01013-150L-16

切削實例
CUT EXAMPLES



中碳鋼加工 Cut S45C

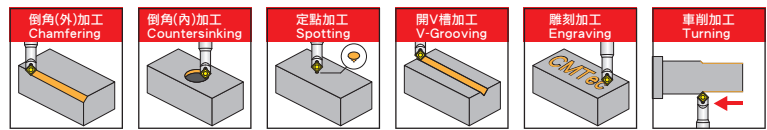
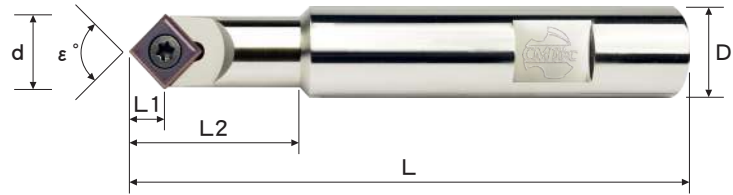


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ECSC 多功能倒角型銑刀桿

ECSC- INDEXABLE- Multipurpose Chamfering Cutter

Milling Table 08



頂角 ϵ°	刃徑 d	刃長 L1	有效長 L2	全長 L	柄徑 D	刀片 數量 Teeth	螺絲 Screw	螺絲 扳手 Wrench	刀桿訂購編號 Cutter Order No.
90°	13	5.5	29	100	10	1	TS3520	ETF15	ECSC09-01013-100L
90°	13	5.5	29	100	12	1			ECSC09-01013-100L-12
90°	13	5.5	29	100	16	1			ECSC09-01013-100L-16
90°	13	5.5	29	150	16	1			ECSC09-01013-150L-16

刀片2D圖 Drawing	尺寸 Dimension (mm)					刀片 Insert	刀片訂購編號 Insert Order No.
	A	B	S	r	d1		
	9.53	9.53	3.97	0.4	4.4		SCGX09T304-AG-CM10
	9.53	9.53	3.97	0.4	4.4		SCGX09T304-AG-CM6012
	9.53	9.53	3.97	0.4	4.4		SCMX09T304-SM-CM6032
	9.53	9.53	3.97	0.4	4.4		SCMX09T304-SP-CM6032

※ SP斷屑槽【SCMX09T304-SP】不適合用於雕刻加工。 ※ SP chip breaker is not suitable for engraving.

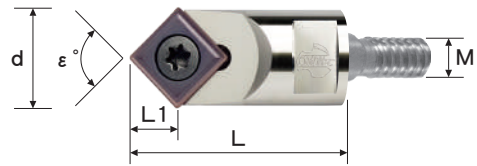
刀片 Insert	應用材質 Work Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels		調質鋼 Hardened Steels		不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys	高溫合金 High Temp Alloys
		HRC<20	HRC20~30	HRC30~45	HRC45~55	HRC55~63	—	HRC<30	—	HRC<30
SCGX09T304-AG-CM10	—	—	—	—	—	—	—	—	⊙	—
SCGX09T304-AG-CM6012	—	—	—	—	—	—	—	—	⊙	—
SCMX09T304-SM-CM6032	⊙	⊙	⊙	—	—	—	○	⊙	—	○
SCMX09T304-SP-CM6032	⊙	⊙	⊙	○	—	—	—	⊙	—	—

HCSC 多功能倒角型銑刀頭



HCSC- THREAD- INDEXABLE- Multipurpose Chamfering Cutter

Milling Table 08



頂角 ϵ°	刃徑 d	刃長 L1	全長 L	螺紋M Thread	刀片 數量 Teeth	螺絲 Screw	螺絲 扳手 Wrench	開口 扳手 Wrench	刀桿訂購編號 Cutter Order No.
90°	13	5.5	30	M6×1.0	1	TS3520	ETF15	TC08	HCSC09-01013

刀片2D圖 Drawing	尺寸 Dimension (mm)					刀片 Insert	刀片訂購編號 Insert Order No.
	A	B	S	r	d1		
	9.53	9.53	3.97	0.4	4.4		SCGX09T304-AG-CM10
	9.53	9.53	3.97	0.4	4.4		SCGX09T304-AG-CM6012
	9.53	9.53	3.97	0.4	4.4		SCMX09T304-SM-CM6032
	9.53	9.53	3.97	0.4	4.4		SCMX09T304-SP-CM6032

外徑 Diameter	全長 L	螺紋M Thread	刀桿 Holder	鎢鋼抗震刀桿訂購編號 CARBIDE ANTI-VIBRATION HOLDER Order No.
12	75	M6×1.0		LCL012-075L
12	100	M6×1.0		LCL012-100L
12	150	M6×1.0		LCL012-150L
12	200	M6×1.0		LCL012-200L






※ SP斷屑槽【SCMX09T304-SP】不適合用於雕刻加工。 ※ SP chip breaker is not suitable for engraving.






刀片 Insert	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			
SCGX09T304-AG-CM10	—	—	—	—	—	—	—	—	—	◎	—	
SCGX09T304-AG-CM6012	—	—	—	—	—	—	—	—	—	◎	—	
SCMX09T304-SM-CM6032	◎	◎	◎	—	—	○	◎	—	—	—	○	
SCMX09T304-SP-CM6032	◎	◎	◎	○	—	—	◎	—	—	—	—	






➔ 切削條件表
Cutting Condition P.020





Table 08 ECSC / HCSC / ECDC / ECTCX 多功能倒角型銑刀桿 切削條件表

ECSC / HCSC / ECDC / ECTCX- INDEXABLE TOOLS- CUTTING CONDITION TABLE

加工方式 Cutting Mode	倒角加工 Chamfering				
加工材質 Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels	不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys
工件料號 Material Code	S35C,S45C,S50C	SCM,SKT,SKD	SUS304	FC,FCD	Al 5052 / 6061 / 7075
硬度 Hardness	HRC<20	HRC20~30	—	HRC<30	—
切削速度 Vc	150~300m/min	100~250m/min	60~120m/min	150~250m/min	150~350m/min
每轉進給量 f	0.15~0.20mm/rev	0.1~0.2mm/rev	0.1~0.2mm/rev	0.15~0.25mm/rev	0.15~0.30mm/rev
切削量 Cutting Amount (mm)	Ap=0.5~1mm 	Ap=0.5~1mm 	Ap=0.5~1mm 	Ap=0.5~1mm 	Ap=0.5~1mm 

加工方式 Cutting Mode	定點加工 Spotting				
加工材質 Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels	不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys
工件料號 Material Code	S35C,S45C,S50C	SCM,SKT,SKD	SUS304	FC,FCD	Al 5052 / 6061 / 7075
硬度 Hardness	HRC<20	HRC20~30	—	HRC<30	—
切削速度 Vc	60~250m/min	50~200m/min	60~120m/min	100~200m/min	100~300m/min
每轉進給量 f	0.05~0.10mm/rev	0.04~0.06mm/rev	0.03~0.06mm/rev	0.05~0.10mm/rev	0.05~0.10mm/rev
切削量 Cutting Amount (mm)	Ap≤5.5mm 	Ap≤5.5mm 	Ap≤5.5mm 	Ap≤5.5mm 	Ap≤5.5mm 

加工方式 Cutting Mode	開V槽加工 V-Grooving				
加工材質 Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels	不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys
工件料號 Material Code	S35C,S45C,S50C	SCM,SKT,SKD	SUS304	FC,FCD	Al 5052 / 6061 / 7075
硬度 Hardness	HRC<20	HRC20~30	—	HRC<30	—
切削速度 Vc	60~250m/min	50~200m/min	60~120m/min	100~200m/min	100~300m/min
每轉進給量 f	0.05~0.07mm/rev	0.04~0.06mm/rev	0.03~0.06mm/rev	0.05~0.07mm/rev	0.05~0.07mm/rev
切削量 Cutting Amount (mm)	Ap≤5.5mm 	Ap≤5.5mm 	Ap≤5.5mm 	Ap≤5.5mm 	Ap≤5.5mm 

加工方式 Cutting Mode	雕刻加工 Engraving				
加工材質 Material	碳素鋼 Carbon Steels	合金鋼 Alloy Steels	不銹鋼 Stainless Steels	鑄鐵 Cast Iron	鋁合金 Aluminum Alloys
工件料號 Material Code	S35C,S45C,S50C	SCM,SKT,SKD	SUS304	FC,FCD	Al 5052 / 6061 / 7075
硬度 Hardness	HRC<20	HRC20~30	—	HRC<30	—
切削速度 Vc	60~250m/min	50~200m/min	60~120m/min	100~200m/min	100~300m/min
每轉進給量 f	0.02~0.05mm/rev	0.02~0.03mm/rev	0.01~0.02mm/rev	0.02~0.05mm/rev	0.02~0.05mm/rev
切削量 Cutting Amount (mm)	Ap=0.2~1mm 	Ap=0.2~1mm 	Ap=0.2~1mm 	Ap=0.2~1mm 	Ap=0.2~1mm 