GDK
END MILL

舍弃式系列

GDK

Production Scene Of Cutter Holder

belmar
automation

捨弃式刀具 刀片規格介紹

1	2	3	4
A	P	F	W

1 (形状) Shape

- A 85°
- H 120°
- M 86°
- O 135°
- R 0°
- S 90°
- T 60°
- X
- Z

2 (离隙角) Clearance

- C 7°
- D 15°
- E 20°
- G 30°
- N 0°
- P 11°

Other normal clearances requiring SPECIAL specification Symbol O.

需要特别注明规格之离隙角则以0符号表示

3 (公差) Tolerance

		d	m	s
A (1)	mm	±0.025	±0.005	±0.025
	inch	±0.0009	±0.0001	±0.0009
C (1)	mm	±0.025	±0.013	±0.025
	inch	±0.0009	±0.0005	±0.0009
E	mm	±0.025	±0.025	±0.025
	inch	±0.0009	±0.0009	±0.0009
F (1)	mm	±0.013	±0.005	±0.025
	inch	±0.0005	±0.0001	±0.0009
G	mm	±0.025	±0.025	±0.130
	inch	±0.0009	±0.0009	±0.0051
H (1)	mm	±0.013	±0.013	±0.025
	inch	±0.0005	±0.0005	±0.0009
J (1)	mm	from ±0.050 to ±0.150	±0.005	±0.025
	inch	from ±0.0196 to ±0.0059	±0.0001 ±0.013	±0.0009 ±0.025
K (1)	mm	from ±0.050 to ±0.150 (2)	±0.0005	±0.0009
	inch	from ±0.0196 to ±0.0059	±0.025 ±0.0009	±0.025 ±0.0009
L (1)	mm	from ±0.050 to ±0.150 (2)	from ±0.080 to ±0.200 (2)	±0.13
	inch	from ±0.0196 to ±0.0059	from ±0.0031 to ±0.0078	±0.005
M	mm	from ±0.050 to ±0.150 (2)	from ±0.080 to ±0.2000 (2)	±0.025
	inch	from ±0.0196 to ±0.0059	from ±0.0031 to ±0.0078	±0.0009
N	mm	from ±0.050 to ±0.150 (2)	from ±0.130 to ±0.380 (2)	±0.13
	inch	from ±0.0196 to ±0.0059	from ±0.0051 to ±0.0149	±0.005
U	mm	from ±0.080 to ±0.250 (2)		
	inch	from ±0.0031 to ±0.0098		

(1)Indexable inserts with ground wiper edges. (2)Dependant upon the insert size(see ISO 1832 Standard)
(1)具有切削导角之舍弃式刀片 (2)与刀片尺寸有关

4 (螺丝孔型式) Type

- N
- R
- W β=40° -60°
- X β=40° -60°

Whth dimensions or details requiring additional specifications.

若需不同尺寸及细节,应须注明其规格

捨弃式刀具 刀片規格介紹

5	6	7	8	9	10
16	04	PD	T	R	■

5 (尺寸) Size

- A
- H
- M
- O
- R
- S
- T
- X
- Z

6 (厚度) Thickness

NOTE: (注)

For insert thickness 1.59mm
Symbol=**01**
(刀片厚度1.59mm以符号01表示)

For insert thickness 1.98mm
Symbol=**T1**
(刀片厚度1.98mm以符号T1表示)

For insert thickness 3.18mm
Symbol=**03**
(刀片厚度3.18mm以符号03表示)

For insert thickness 3.97mm
Symbol=**T3**
(刀片厚度3.97mm以符号T3表示)

7 (角度) Corner

Rounded Corner Inserts
(圆角刀片)

Value of corner radius given in 1/10mm
(刀角每1/10mm之半径值)

NOTE: (注)
For sharp corner
Symbol=**00**
(就尖角而言，符号=00)
Round Inserts(圆刀片)
Symbol=**00**
(英制符号=00)
Symbol=**M0**
(公制符号=M0)

Inserts With Wiper Edges.
(两旁导角之刀片)

Two Letter Symbol:
(表示符号)

① For cutting edge angle Xr (切削角度)	② For wiper edge normal geometry (标准导角度)
A=45°	A=3°
D=60°	B=5°
E=75°	C=7°
F=85°	D=15°
P=90°	E=20°
	F=25°
	G=30°
	N=0°
	P=11°

其它
Z=wiper edge clearance.
(刀边导角之离隙角)

8 (角度) Corner

Sharp Cutting Edges
(大锐角削角)

F
Rounded Cutting Edges
(圆切削角)

E
Chamfered Cutting Edges
(切削导角)

T
Double Chamfered Cutting Edges
(双切削导角)

K
Chamfered&Rounded Cutting Edges
(导角及圆切削角)

S
Double Chamfered& Rounded Cutting Edges
(双导角及圆切削角)

P
OPTIONAL SYMBOL
特殊符号

9 (切削方向) Cutting Direction

R
Right Hand Insert
(左右刀片)

L
Left Hand Insert
(左右刀片)

N
Neutral Insert
左右共用刀片

OPTIONAL SYMBOL
特殊符号

10 (特殊符号) Optional

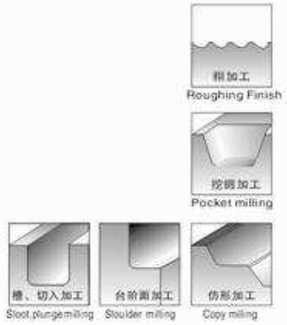
Manufacturers optional symbol consisting of numbers or litters;shall be separated from the standardised designation by a dash(-)

刀片制造厂之特殊符号包含数字、字母。这些标准符号"-"分开以作区分。

OPTIONAL SYMBOL
特殊符号

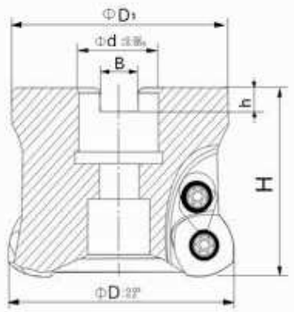
捨弃式刀具 殼形銑刀

ASR/ASF
快進給殼形銑刀
High Feedrate Corner Rounging End Mill

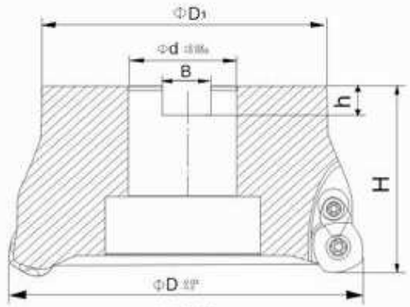


標準配件

刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



A型
A type



B型
B type

ASR2-50-6T

ASF5-63-4T

ASF5-80-5T

ASF5-100-5T

捨弃式刀具 殼形銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No of flutes	樣式 Manner	尺寸 Size D	D1	d	H	B	h	墊片 Circular Cushin	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
ASR2	50-22	6	A	50	47	22	50	10.4	6.3		EPNW0603 TN-8		M25060-55	T8P		●
	60-25.4	6	A	63	47	25.4	50	10	6		EPNT0603 TN-8		M2.5X6	T8		●
ASF5	63-22	3	A	63	60	22	50	10.4	6.3							●
	63-22	4	A	63	60	22	50	10.4	6.3							●
	80-27	4	A	80	70	27	63	12.4	7							
	80-27	5	A	80	70	27	63	12.4	7							
	63-25.4	3	A	63	60	25.4	50	10	6							●
	63-25.4	4	A	63	60	25.4	50	10	6		SD □□1505ZD TN- □15	YM-5	M50120-60 M5 x 12	T20P T20		●
	80-25.4	4	A	80	70	25.4	63	10	6							
	80-25.4	5	A	80	70	25.4	63	10	6							
	100-32	5	B	100	90	32	63	14.4	8	DP-32						
	125-40	6	B	125	100	40	63	16.4	9	DP-40						
	100-31.75	5	B	100	90	31.75	63	13	8	DP-31.75						
	125-38.1	6	B	125	100	38.1	63	16.2	10	DP-38.1						

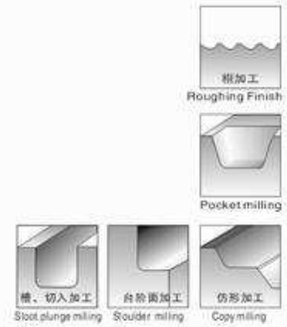
可配用刀片 Inserts

型號 Cat.NO.	JX8045	GX2030	JX1005	JX1015	JX1020	JX1045	JX1060	刀片形狀 Insert shape	尺寸 Size(mm) R	L	S	B	排屑槽	品牌 Brand
EPNW0603TN-8	●	●	●	●	●	●	●		8	10	3.18	6.35	無	HITACHI (日立)
EPMT0603TN-8	●	●	●	●	●	●	●		8	10	3.18	6.35	有	

型號 Cat.NO.	JX1045	TB6005	TB6020	TB6045	TB6060	CY150	CY250	GX30	GX2030	CH550	刀片形狀 Insert shape	尺寸 Size(mm) R	S	B	排屑槽	品牌 Brand
SDNW1505ZDTN-R15	●	●		●	●	●	●	●				15	5.56	18.875	無	HITACHI (日立)
SDMT1505ZDTN-R15	●			●	●							15	5.56	18.875	有	
SDMT1505ZDTN-C15	●			●	●		●	●		●		15	5.56	18.875	有	
SDEW1505ZDTN-R15	●			●	●		●	●				15	5.56	18.875	無	

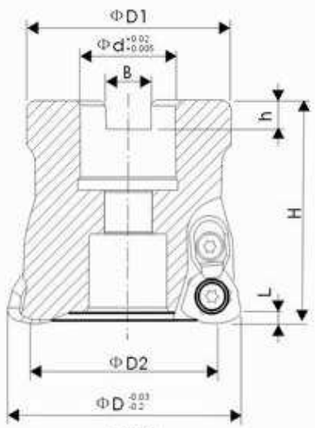
捨弃式刀具 殼形銑刀

AJX
快進給殼形銑刀
Corner Rounding End Mill



標準配件

刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



A型
A type

AJX12-63-4T

AJX14-63-4T

AJX14-80-4T

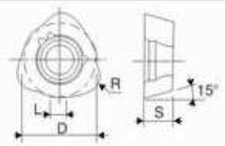
AJX14-100-5T

捨弃式刀具 殼形銑刀

UNIT:MM

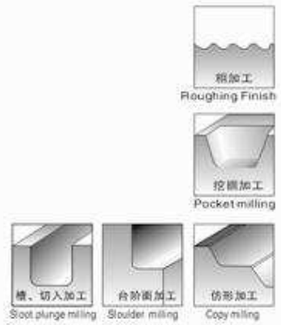
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	D1	D2	d	H	B	h	L	適用刀片 Applicable Inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
AJX12	50-22	3	A	50	47	38.3	22	50	10.4	6.3	1.5	JDMW120420 ZDSR-FT	YM-4	M40100-60 M4×10	T15P T15		●
	50-22	4	A	50	47	38.3	22	50	10.4	6.3	1.5						
	63-22	4	A	63	60	51.3	22	50	10.4	6.3	1.5						●
	50-25.4	3	A	50	47	38.3	25.4	50	10	6	1.5						●
	50-25.4	4	A	50	47	38.3	25.4	50	10	6	1.5						
	63-25.4	4	A	63	60	51.3	25.4	50	10	6	1.5						●
AJX14	63-22	3	A	63	60	51.1	22	50	10.4	6.3	2	JDMW140520 ZDSR-FT	YM-5	M50120-60 M5×12	T20P T20		●
	63-22	4	A	63	60	51.1	22	50	10.4	6.3	2						●
	80-27	4	A	80	76	68.1	27	50	12.4	7	2						
	80-27	5	A	80	76	68.1	27	50	12.4	7	2						
	100-32	5	A	100	96	88.1	32	63	14.4	8	2						
	63-25.4	3	A	63	60	51.1	25.4	50	10	6	2						●
	63-25.5	4	A	63	60	51.1	25.4	50	10	6	2						●
	80-25.4	4	A	80	76	68.1	25.4	50	10	6	2						
	80-25.4	5	A	80	76	68.1	25.4	50	10	6	2						
	100-31.75	5	A	100	96	88.1	31.75	63	13	8	2						

可配用刀片 Inserts

型號 Cat.NO.	FH7020	VP15TF	VP30RT	刀片形狀 Insert shape	尺寸 Size(mm) D	S	L	R	排屑槽	品牌 Brand
JDMW120420ZDSR-FT	●	●	●		12	4.76	5	2	無	MITSUBISHI 三菱
140520ZDSR-FT	●	●	●		14	5.56	5	2	無	
JDMT120420ZDSR-ST	●	●	●		12	4.76	5	2	有	
120420ZDSR-JM	●	●	●		12	4.76	5	2	有	
140520ZDSR-ST	●	●	●		14	5.56	5	2	有	
140520ZDSR-JM	●	●	●		14	5.56	5	2	有	

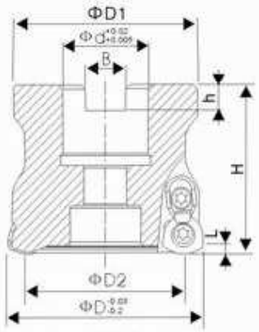
捨弃式刀具 殼形銑刀

TXP
快進給殼形銑刀
Corner Rounding End Mill

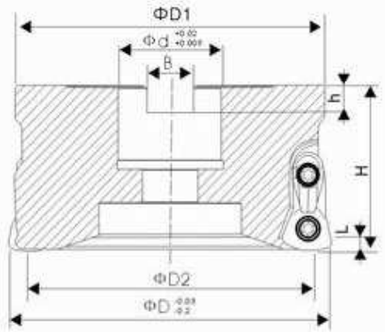


標準配件

刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



A型
A type



B型
B type

TXP06-50-4T

TXP08-50-3T

TXP08-63-4T

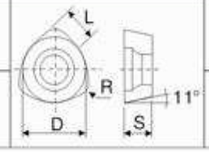
TXP08-80-5T

捨弃式刀具 殼形銑刀

UNIT:MM

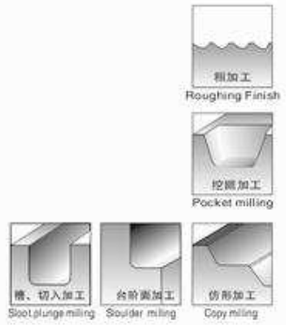
型號 Cat.NO.	規格 Spec	刃數 No of flutes	樣式 Manner	尺寸 Size D	D1	D2	d	H	B	h	L	墊片 Circular Cushin	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
TXP06	50-22	4	A	50	47	41.4	22	50	10.4	6.3	1.5		WPMW 06X415ZPR	YS-15	M40100-60 M4×10	T15P T15		
	50-25.4	4	A	50	47	41.4	25.4	50	10	6	1.5							
TXP08	50-22	3	A	50	47	38.6	22	50	10.4	6.3	1.5		WPMT 080615ZPR	YS-20	M50110-38 M5×11	T20P T20		
	63-22	4	A	63	59	51.6	22	50	10.4	6.3	1.5							
	80-27	4	A	80	76	68.6	27	50	12.4	7	1.5							
	80-27	5	A	80	76	68.6	27	50	12.4	7	1.5							
	100-32	5	B	100	96	88.6	32	50	14.4	8	1.5	DP-32						
	50-25.4	3	A	50	47	38.6	25.4	50	10	6	1.5							
	63-25.4	4	A	63	59	50.6	25.4	50	10	6	1.5							
	80-25.4	4	A	80	76	68.6	25.4	50	10	6	1.5							
	100-31.75	5	B	100	96	88.6	31.75	50	13	8	1.5	DP-31.75						

可配用刀片 Inserts

型號 Cat.NO.	AH120	AH140	T3030	T1015	刀片形狀 Insert shape	尺寸 Size(mm) L	D	S	R	品牌 Brand
WPMW06X415ZPR	●	●	●	●		6	9.525	4.2	1.5	TUNGALOY 美達
WPMT06X415ZPR-ML	●	●	●			6	9.525	4.2	1.5	
06X415ZPR-MH	●	●				6	9.525	4.2	1.5	
WPMT080615ZPR	●	●	●	●		8	12.87	6.35	1.5	
080615ZPR-ML	●	●	●			8	12.87	6.35	1.5	
080615ZPR-MH	●	●				8	12.87	6.35	1.5	

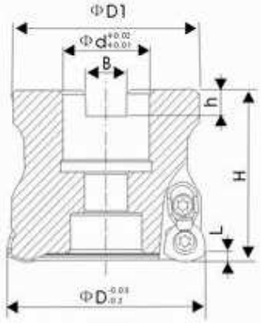
捨弃式刀具 殼形銑刀

SKS
快進給殼形銑刀
Corner Rounding End Mill

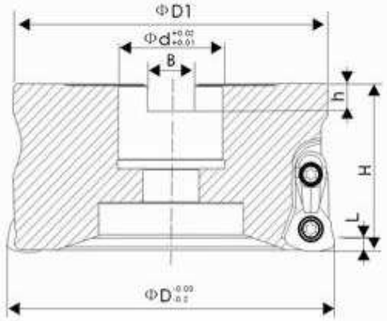


標準配件

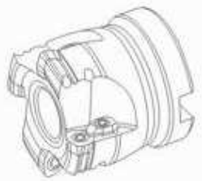
刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



A型
A type



B型
B type


SKS06-50-4T

SKS08-50-3T

TXP08-63-4T

SKS08-80-5T

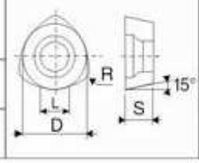
SKS10-100-5T

捨弃式刀具 殼形銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	D1	d	H	B	h	L	墊片 Circular Cushin	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
SKS06	40-16	3	A	40	37	16	45	8.4	5.6	1.5		WDMW06T320ZTR WDHW060320ZTR	YM-4	M40900-50 M4×9	T15P T15		
SKS08	50-22	3	A	50	47	22	50	10.4	6.3	1.5		WDMW080520ZTR WDMT080520ZER WDWO080520ZTR	YS-20	M45105-50 M4.5×10.5 M50110-38 M5×11 (压板螺丝)	T20P T20		
	63-22	3	A	63	60	22	50	10.4	6.3	1.5							
	63-22	4	A	63	60	22	50	10.4	6.3	1.5							
	63-27	3	A	63	60	27	50	12.4	7	1.5							
	63-27	4	A	63	60	27	50	12.4	7	1.5							
	80-27	5	A	80	76	27	55	12.4	7	1.5							
	100-32	6	B	100	96	32	63	14.4	8	1.5	DP-32						
	63-25.4	3	A	63	60	25.4	50	10	6	1.5							
	63-25.4	4	A	63	60	25.4	50	10	6	1.5							
	80-31.75	5	A	80	76	31.75	55	13	8	1.5							
	100-31.75	5	B	100	96	31.75	63	13	8	1.5	DP-31.75						
SKS10	63-22	4	A	63	60	22	50	10.4	6.3	2		WDMW10X620ZTR WDMT10X620ZER					
	63-27	4	A	63	60	27	50	12.4	7	2							
	80-27	5	A	80	76	27	55	12.4	7	2							
	100-32	5	B	100	96	32	63	14.4	8	2	DP-32						
	125-40	6	B	125	96	40	63	16.4	9	2	DP-40						
	63-25.4	4	A	63	60	25.4	50	10	6	2							
	80-31.75	5	A	80	76	31.75	55	13	8	2							
	100-31.75	5	B	100	96	31.75	63	13	8	2	DP-31.75						
	125-38.1	6	B	125	96	38.1	63	16.2	10	2	DP-38.1						

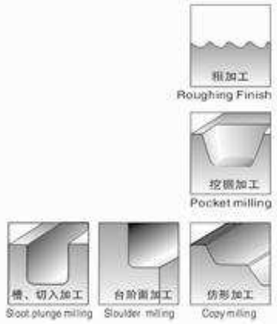
可配用刀片 Inserts

型號 Cat.NO.	JC5015	JC5040	JC600	JC730U	JC8015	刀片形狀 Insert shape	尺寸 Size(mm) D	L	S	R	品牌 Brand
WDMW06T320ZTR	●	●			●		10	1.2	3.97	2	DIJET 戴杰
080520ZTR	●	●			●		13	1.5	5.5	2	
10X620ZTR	●	●					16	2.0	6	2	
WDMT080520ZER			●	●			13	1.5	5.5	2	
10X620ZER			●	●			16	2.0	6	2	
WDHW060320ZTR	●	●					10	1.2	3.97	2	
060520ZTR	●	●					13	1.2	5.5	2	

捨弃式刀具

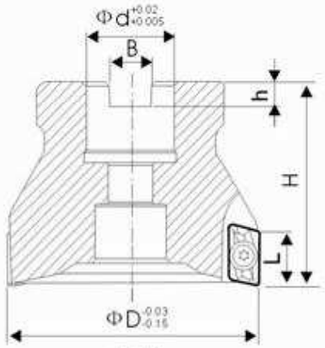
殼形銑刀

AHUB直角臺肩
殼形銑刀
Right Angle Shoulder Rounding End Mill

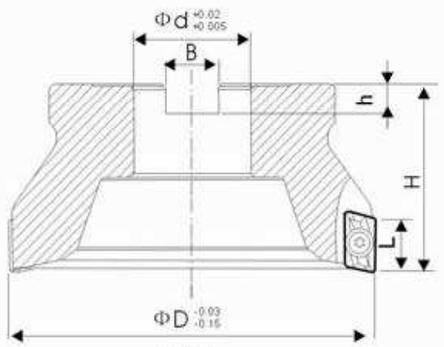


標準配件

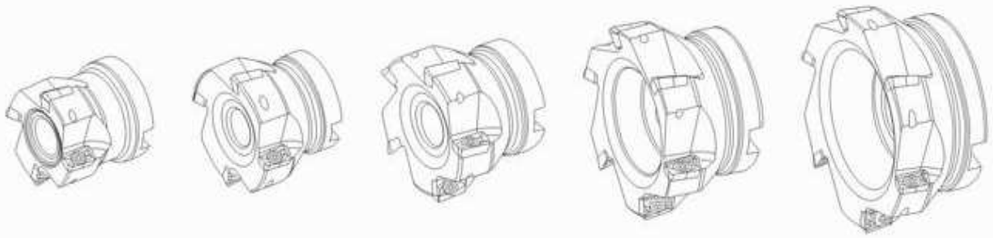
刀片螺絲		1套+2個
旗形扳手		1支



A型
A type



B型
B type



AHUB15-50-4T　AHUB15-63-4T　AHUB15-63-5T　AHUB15-80-6T　AHUB15-100-6T

捨弃式刀具

殼形銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	H	B	h	L	墊片 Circular Cushin	適用刀片 Applicable inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
AHUB15	50-22	4	A	50	22	50	10.4	6.3	14		JDMT 150500R	M40100-60 M4X10	T15P T15		●
	63-22	4	A	63	22	50	10.4	6.3	14						●
	63-22	5	A	63	22	50	10.4	6.3	14						●
	80-27	6	A	80	27	50	12.4	7	14						●
	100-32	6	B	100	32	50	14.4	8	14	DP-32					●
	50-25.4	4	A	50	25.4	50	10	6	14						●
	63-25.4	4	A	63	25.4	50	10	6	14						●
	63-25.4	5	A	63	25.4	50	10	6	14						●
	80-25.4	6	A	80	25.4	50	10	6	14						
	100-31.75	6	B	100	31.75	50	13	8	14	DP-31.75					

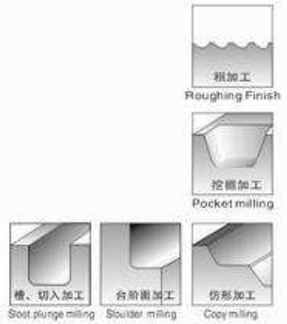
可配用刀片 Inserts

型號 Cat.NO.	PTH30E	TB6045	PTH40H	PTH13S	刀片形狀 Insert shape	尺寸 Size(mm) L	B	S	R	品牌 Brand
JDMT150504R	●	●		●		16	9.12	5	0.4	HITACHI (日立)
JDMT150508R	●	●		●		16	9.12	5	0.8	
JDMT150520R	●		●			16	9.12	5	2.0	
JDMT150530R	●					16	9.12	5	3.0	

捨弃式刀具

殼形銑刀

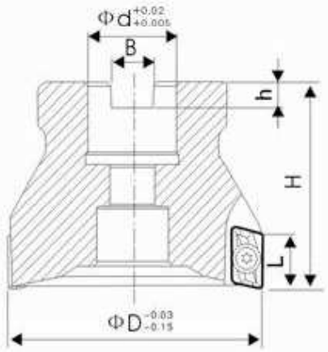
BAP直角臺肩 殼形銑刀
Right Angle Shoulder Rounding End Mill



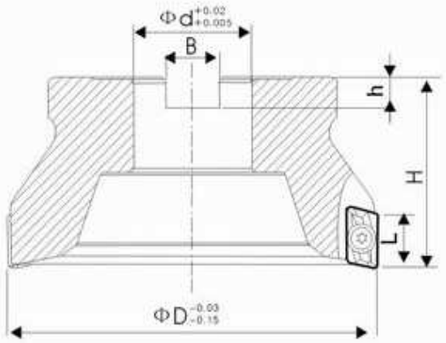
提示：請保留您的報廢刀片,RAP-75° 給您更大的驚喜

標準配件

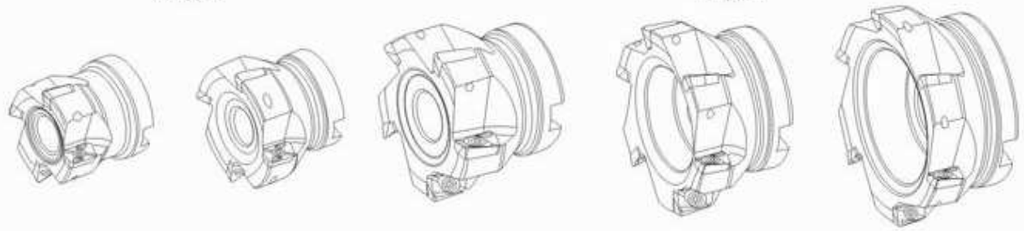
刀片螺絲		1套+2個
旗形扳手		1支



A型
A type



B型
B type



BAP400R-50-4T　BAP400R-63-4T　BAP400R-63-5T　BAP400R-80-6T　BAP400R-100-6T

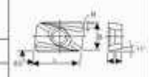
捨弃式刀具

殼形銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	H	B	h	L	墊片 Circular Cushin	適用刀片 Applicable Inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
BAP400R	50-22	4	A	50	22	50	10.4	6.3	14		APMT1604PDER	M40100-60 M4X10	T15P T15		●
	63-22	4	A	63	22	50	10.4	6.3	14						●
	63-22	5	A	63	22	50	10.4	6.3	14						●
	80-27	6	A	80	27	50	12.4	7	14						●
	100-32	6	B	100	32	50	14.4	8	14	DP-32					●
	125-40	6	B	125	40	63	16.4	9	14	DP-40					●
	50-25.4	4	A	50	25.4	50	10	6	14						●
	63-25.4	4	A	63	25.4	50	10	6	14						●
	63-25.4	5	A	63	25.4	50	10	6	14						●
	80-25.4	6	A	80	25.4	50	10	6	14						
	100-31.75	6	B	100	31.75	50	13	8	14	DP-31.75					

可配用刀片 Inserts

型號 Cat.NO.	F7030	F620	VP15TF	UP20M	NX2525	NX4545	UT120T	HTI10	NCM325	PC3535	PC3545	PC3530	PC6510	PD2000	H01	H101	H102	KC25	PP30	PC35	刀片形狀 Insert shape	尺寸 Size(mm) L	B	S	L1	R	品牌 Brand
APMT1604PDER-H1	●		●				●															16.5	9.525	4.76	1.7	0.4	MITSUBISHI(三菱)
1604PDER-H2	●	●	●	●	●	●	●	●														16.5	9.525	4.76	1.7	0.8	
1604PDER-H4	●						●															16.5	9.525	4.76	1.7	1.6	
1604PDER-H6	●						●															16.5	9.525	4.76	1.7	2.4	
1604PDER-H8	●						●															16.5	9.525	4.76	1.7	3.2	
APMT1604PDER-M2	●	●	●			●																16.5	9.525	4.76	1.7	0.8	
APGT1604PFDR-G2	●							●														16.5	9.525	4.76	1.7	0.8	
APKT1604PDSR									●	●	●	●	●									16.4	9.525	4.76	–	0.8	KORLOY(可力)
1604PDFR-MA														●	●							16.4	9.525	4.76	–	0.8	

捨弃式刀具

殼形銑刀

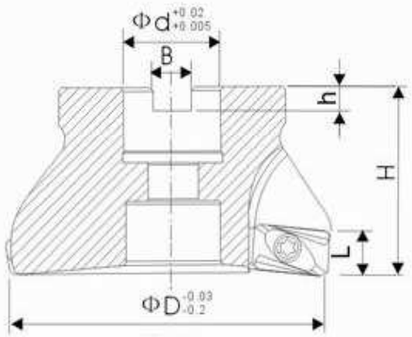
RAP-75
殼形銑刀
Corner Rounding End Mill

粗加工
Roughing Finish

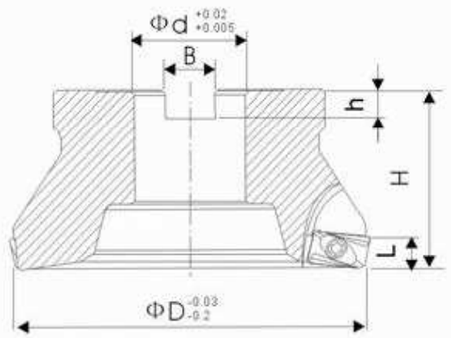
使用BAP400R系列的报废刀片“0”刀具损耗

標準配件

刀片螺絲		1套+2個
旗形扳手		1支



A型
A type



B型
B type

RAP-63-4T

RAP-80-5T

RAP-100-5T

RAP-125-6T

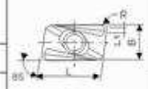
捨弃式刀具

殼形銑刀

UNIT:MM

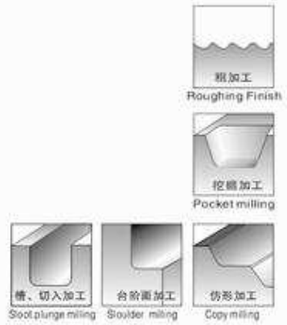
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	H	B	h	L	墊片 Circular Cushin	適用刀片 Applicable Inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
RAP	63-22	4	A	63	22	50	10.4	6.3	8		APMT1604PDER	M40100-60 M4×10	T15P T15		●
	80-27	5	A	80	27	50	12.4	7	8						●
	100-32	5	B	100	32	50	14.4	8	8	DP-32					●
	125-40	6	B	125	40	50	16.4	9	8	DP-40					●
	63-25.4	4	A	63	25.4	50	10	6	8						
	80-25.4	5	A	80	25.4	50	10	6	8						
	100-31.75	5	B	100	31.75	50	13	6	8	DP-31.75					

可配用刀片 Inserts

型號 Cat.NO.	F7030	F620	VP15TF	UP20M	NX2525	NX4545	UTI20T	HTI10	NCM325	PC3535	PC3545	PC3530	PC6510	PD2000	H01	H101	H102	KC25	PP30	PC35	刀片形狀 Insert shape	尺寸 Size(mm) L	B	S	L1	R	品牌 Brand
APMT1135PDER-H1	●	●	●	●	●	●	●	●														11	6.35	3.5	1.5	0.4	MITSUBISHI(三菱)
1135PDER-H2	●	●	●	●	●	●	●	●														11	6.35	3.5	1.2	0.8	
1135PDER-H3	●	●		●			●															11	6.35	3.5	0.8	1.2	
1135PDER-H4	●	●		●			●															11	6.35	3.5	0.4	1.6	
1135PDER-H6	●	●		●			●															11	6.35	3.5	0.4	2.4	
APMT1135PDER-M0	●																					11	6.35	3.5	1.8	0.2	
1135PDER-M1	●																					11	6.35	3.5	1.5	0.4	
1135PDER-M2	●	●	●			●																11	6.35	3.5	1.2	0.8	
APGT1135PFDR-G2								●														11	6.35	3.5	1.2	0.8	
APMT1604PDER-H1	●		●				●															16.5	9.525	4.76	1.7	0.4	MITSUBISHI(三菱)
1604PDER-H2	●	●	●	●	●	●	●	●														16.5	9.525	4.76	1.7	0.8	
1604PDER-H4	●						●															16.5	9.525	4.76	1.7	1.6	
1604PDER-H6	●						●															16.5	9.525	4.76	1.7	2.4	
1604PDER-H8	●						●															16.5	9.525	4.76	1.7	3.2	
APMT1604PDER-M2	●	●	●			●																16.5	9.525	4.76	1.7	0.8	
APGT1604PFDR-G2	●							●														16.5	9.525	4.76	1.7	0.8	
APKT1604PDSR									●	●	●	●	●									16.4	9.525	4.76	-	0.8	KORLOY
1604PDFR-MA															●	●						16.4	9.525	4.76	-	0.8	

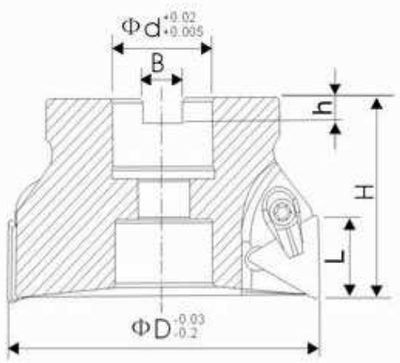
捨弃式刀具 殼形銑刀

TP
臺肩殼形銑刀
Shoulder Corner Rounding End Mill

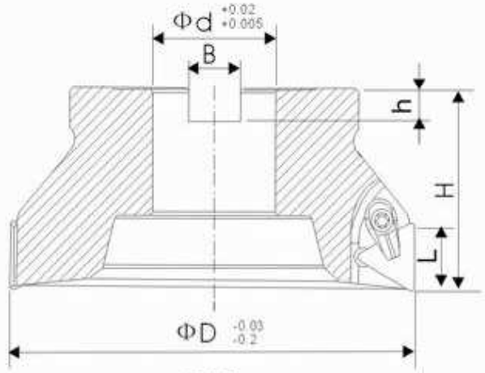


標準配件

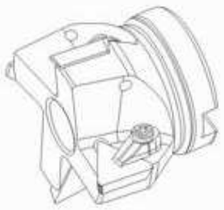
壓板螺絲		1套+2個
壓板		1 個
旗形扳手		1支



A型
A type

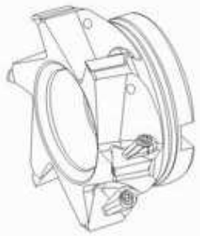


B型
B type

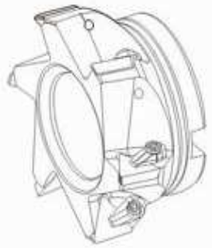


TP22-63-4T

TP22-80-5T



TP22-100-6T



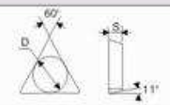
TP22-125-6T

捨弃式刀具 殼形銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No of flutes	樣式 Manner	尺寸 Size D	d	H	B	h	L	墊片 Circular Cushin	適用刀片 Applicable inserts	墊片 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
TP16	50-22	4	A	50	22	50	10.4	6.3	14		TPMN1603 TPKN1603	YM-4	M40100-60 M4X10	T15P T15		●
TP22	63-22	4	A	63	22	50	10.4	6.3	18		TPMN2204 TPKN2204	YS-20	M50110-38 M5X11	T20P T20		●
	80-27	4	A	80	27	50	12.4	7	18							●
	100-32	5	B	100	32	50	14.4	8	18	DP-32						●
	125-40	6	B	125	40	50	16.4	9	18	DP-40						●
	63-25.4	4	A	63	25.4	50	10	6	18							●
	80-25.4	5	A	80	25.4	50	10	6	18							
	100-31.75	5	B	100	31.75	50	13	6	18	DP-31.75						
	125-38.1	6	B	125	38.1	50	16.2	10	18	DP-38.1						

可配用刀片 Inserts

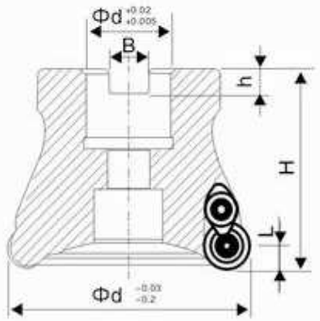
型號 Cat.NO.	CY25	EX35	CH550	WH10	PJ20	PP30	PC35	PP20	KC25	刀片形狀 Insert shape	尺寸 Size(mm) D	S	品牌 Brand
TPMN160308		●	●	●							9.525	3.18	HITACHI (日立)
TPMN220412		●	●	●							12.7	4.76	
TPMN220408Y	●										12.7	4.76	

捨弃式刀具 殼形銑刀

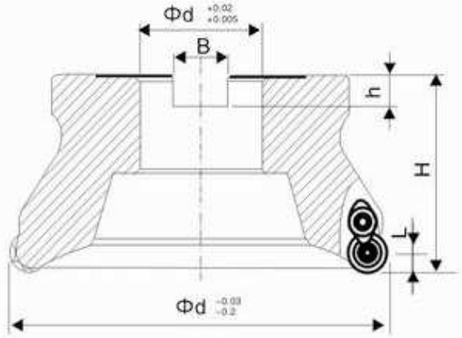
EMRW
圓鼻殼形銑刀
Corner Rounding End Mill

標準配件

刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



A型
A type



B型
B type

EMEW-6R50-4T

EMEW-6R63-4T

EMEW-6R63-5T

EMEW-6R80-6T

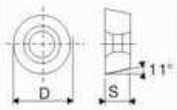
EMEW-6R100-6T

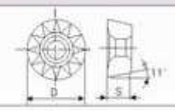
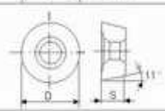
捨弃式刀具 殼形銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	H	B	h	L	墊片 Circular Cushin	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 V-wrench	價格 Price	庫存 Stock
EMRW5R	50-22	3	A	50	22	50	10.4	6.3	5		RPMW 1003MO	Y-5R	M40100-60 M4×10	T15P T15		●
	63-22	4	A	63	22	50	10.4	6.3	5							●
	63-22	5	A	63	22	50	10.4	6.3	5							●
	80-27	6	A	80	27	50	12.4	7	5							●
	100-32	6	B	100	32	50	14.4	8	5	DP-32						●
	50-25.4	3	A	50	25.4	50	10	6	5				M35100-60 M35×10 (压板螺丝)			●
	63-25.4	4	A	63	25.4	50	10	6	5							●
	63-25.4	5	A	63	25.4	50	10	6	5							●
	80-25.4	6	A	80	25.4	50	10	6	5							
	100-31.75	6	B	100	31.75	50	13	8	5	DP-31.75						
EMRW6R	50-22	3	A	50	22	50	10.4	6.3	6		RPMW 1204MO RPMT 1204MO	Y-6R	M40100-60 M4×10			●
	63-22	4	A	63	22	50	10.4	6.3	6							●
	63-22	5	A	63	22	50	10.4	6.3	6							●
	80-27	6	A	80	27	50	12.4	7	6							●
	100-32	6	B	100	32	50	14.4	8	6	DP-32						●
	125-40	6	B	125	40	50	16.4	9	6	DP-40						●
	50-25.4	3	A	50	25.4	50	10	6	6							●
	63-25.4	4	A	63	25.4	50	10	6	6							●
	63-25.4	5	A	63	25.4	50	10	6	6							●
	80-25.4	6	A	80	25.4	50	10	6	6							
	100-31.75	6	B	100	31.75	50	13	8	6	DP-31.75						

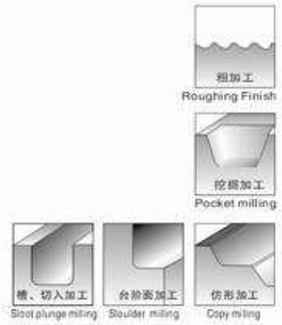
可配用刀片 Inserts

型號 Cat.NO.	UP20M	NX2525	UT120T	F7030	VP15TF	SH8020	SH8250	JC3535	NIT	NAT	UMS	DX25	KT9	H101	H102	KC25	PP30	PC35	刀片形狀 Insert shape	尺寸Size(mm) D	S	排屑槽	品牌 Brand
RPMW1003MO	●	●	●																	10 10	3.18 3.97	无 有	MITSUBISHI 三菱
RPMW1003MOEN						●	●													10	3.18	无	HITACHI 日立
RPMW1003NO								●	●	●	●	●	●							10	3.18	无	DIJET 黛杰

型號 Cat.NO.	F7030	F620	VP15TF	NX4545	UT120T	TN100M	PR510	PR660	QR730	KW10	H101	H102	KC25	PP30	PC35	刀片形狀 Insert shape	尺寸 Size(mm) D	S	排屑槽	品牌 Brand
RPMT1204MOE-JS	●	●	●														12	4.76	有	MITSUBISHI 三菱
RPMT1204MO 1204MO-H						●	●	●	●	●							12 12	4.76 4.76	有 有	KYOCERA (京瓷)
RPNW1204MOE 1204MOT	●	●	●	●	●												12 12	4.76 4.76	无 无	MITSUBISHI 三菱

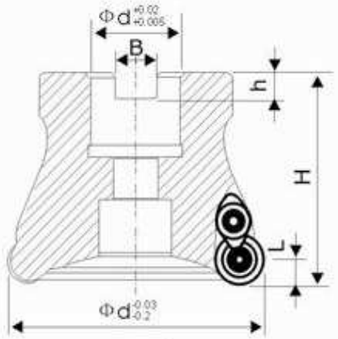
捨弃式刀具 殼形銑刀

R200
圓鼻殼形銑刀
Corner Rounding End Mill

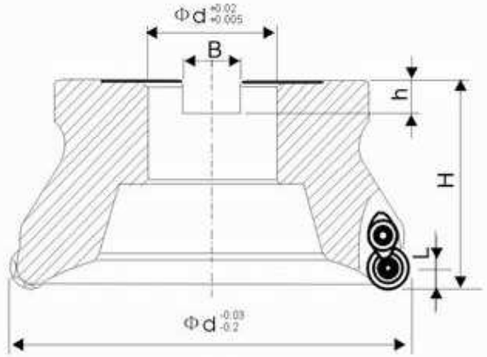


標準配件

刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



A型
A type



B型
B type

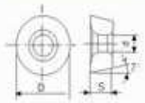
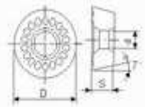
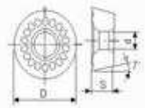
R200-6R50-4T　R200-6R63-4T　R200-6R63-5T　R200-8R63-4T　R200-8R80-5T

捨弃式刀具 殼形銑刀

UNIT:MM

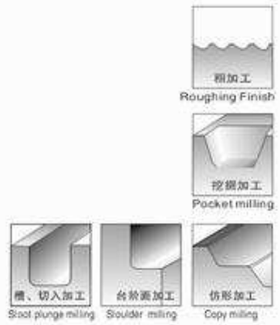
型號 Cat.NO.	規格 Spec	刃數 No of flutes	樣式 Manner	尺寸 Size D	D1	d	H	W	h	墊片 Circular Cushin	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
R200-5R	50-22	4	A	50	22	50	10.4	6.3	5		RC□T10T3 MO	Y-6R	M35100-60 M3.5×10	T15P T15		
	63-22	4	A	63	22	50	10.4	6.3	5							
	63-22	5	A	63	22	50	10.4	6.3	5							
	80-27	6	A	80	27	50	12.4	7	5							
	100-32	6	B	100	32	50	14.4	8	5	DP-32						
	50-25.4	4	A	50	25.4	50	10	6	5							
	63-25.4	4	A	63	25.4	50	10	6	5							
	63-25.4	5	A	63	25.4	50	10	6	5							
	80-25.4	6	A	80	25.4	50	10	6	5							
	100-31.75	6	B	100	31.75	50	13	8	5	DP-31.75						
R200-6R	50-22	4	A	50	22	50	10.4	6.3	6		RC□T1204 MO		M40100-60 M4×10 (压板螺丝)			●
	63-22	4	A	63	22	50	10.4	6.3	6							●
	63-22	5	A	63	22	50	10.4	6.3	6							
	80-27	6	A	80	27	50	12.4	7	6							
	100-32	6	B	100	32	50	14.4	8	6	DP-32						
	50-25.4	4	A	50	25.4	50	10	6	6							
	63-25.4	4	A	63	25.4	50	10	6	6							
	63-25.4	5	A	63	25.4	50	10	6	6							
	80-25.4	6	A	80	25.4	50	10	6	6							
	100-31.75	6	B	100	31.75	50	13	8	6	DP-31.75						
R200-8R	50-22	3	A	50	22	50	10.4	6.3	8		RC□T1606 MO	Y-8R	M50120-60 M5×12	T20P T20P		
	63-22	3	A	63	22	50	10.4	6.3	8							
	63-22	4	A	63	22	50	10.4	6.3	8							●
	80-27	5	A	80	27	50	12.4	7	8							●
	100-32	6	B	100	32	50	14.4	8	8	DP-32						
	50-25.4	3	A	50	25.4	50	10	6	8							
	63-25.4	3	A	63	25.4	50	10	6	8							
	63-25.4	4	A	63	25.4	50	10	6	8							
	80-25.4	5	A	80	25.4	50	10	6	8							
	100-31.75	6	B	100	31.75	50	13	8	8	DP-31.75						

可配用刀片 Inserts

型號 Cat.NO.	530	1025	2030	2040	3020	3040	4020	4030	4040	H10F	H13A	SM30	H101	H102	KC25	PP30	PC35	刀片形狀 Insert shape	尺寸 Size(mm) D	d	S	品牌 Brand
RCHT10T3MO-PL	●	●																	10	4.0	3.97	SANDVIK 山特维克
10T3MO-KL											●								10	4.0	3.97	
10T3MO-ML			●	●															10	4.0	3.97	
RCHT1204MO-PL	●	●																	12	4.0	4.76	
1204MO-KL											●								12	4.0	4.76	
1204MO-ML			●	●															12	4.0	4.76	
RCHT1606MO-PL	●	●																	16	5.5	6.35	
1606MO-KL											●								16	5.5	6.35	
1606MO-ML			●	●															16	5.5	6.35	
RCKT10T3MO-PM							●	●	●										10	4.0	3.97	SANDVIK 山特维克
10T3MO-KM					●	●													10	4.0	3.97	
10T3MO-WM	●									●		●							10	4.0	3.97	
10T3MO-MM			●	●															10	4.0	3.97	
RCKT1204MO-PM							●	●	●										12	4.0	4.76	
1204MO-KM					●	●													12	4.0	4.76	
1204MO-WM	●									●		●							12	4.0	4.76	
1204MO-MM			●	●															12	4.0	4.76	
RCKT1606MO-DM							●	●	●										16	5.5	6.35	
1606MO-KM					●	●													16	5.5	6.35	
1606MO-WM	●									●		●							16	5.5	6.35	
1606MO-MM			●	●															16	5.5	6.35	
RCKT10T3MO-PH							●	●	●										10	4.0	3.97	SANDVIK 山特维克
10T3MO-KH					●	●													10	4.0	3.97	
10T3MO-WH												●							10	4.0	3.97	
RCKT1204MO-PH							●	●	●										12	4.0	4.76	
1204MO-KH					●	●													12	4.0	4.76	
1204MO-WH												●							12	4.0	4.76	
RCKT1606MO-PH							●	●	●										16	5.5	6.35	
1606MO-KH					●	●													16	5.5	6.35	
1606MO-WH												●							16	5.5	6.35	

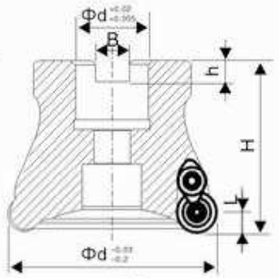
捨弃式刀具 殼形銑刀

TRS
圓鼻殼形銑刀
Corner Rounding End Mill

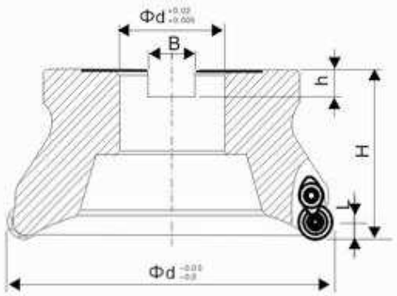


標準配件

刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



A型
A type



B型
B type

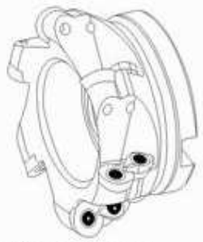
TRS-5/6R50-4T

TRS-5/6R63-4T

TRS-6R63-5T

TRS-8R63-4T

TRS-8R80-5T



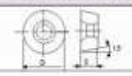
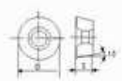
TRS-8R100-6T

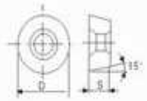
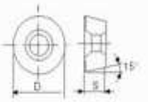
捨弃式刀具 殼形銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No of flutes	樣式 Manner	尺寸 Size D	d	H	h	B	L	墊片 Circular Cushin	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
TRS 5R	50-22	4	A	50	22	50	10.4	6.3	5		RD□□T10T3 MO	Y-5R	M40090-50 M4×9(日立专用) M3510-50 M3.5×10 (压板螺丝)	T15P T15		●
	63-22	4	A	63	22	50	10.4	6.3	5							●
	63-22	5	A	63	22	50	10.4	6.3	5							
	80-27	6	A	80	27	50	12.4	7	5							
	100-32	6	B	100	32	50	14.4	8	5	DP-32						
	50-25.4	4	A	50	25.4	50	10	6	5							
	63-25.4	4	A	63	25.4	50	10	6	5							
	63-25.4	5	A	63	25.4	50	10	6	5							
	80-25.4	6	A	80	25.4	50	10	6	5							
	100-31.75	6	B	100	31.75	50	13	6	5	DP-31.75						
TRS 6R	50-22	4	A	50	22	50	10.4	6.3	6		RD□□T1204 MO	Y-6R	M40100-50 M4×10(日立专用) M40090-50 M4×9 (压板螺丝)			●
	63-22	4	A	63	22	50	10.4	6.3	6							●
	80-27	5	A	80	27	50	12.4	7	6							
	100-32	6	B	100	32	50	14.4	8	6	DP-32						
	50-25.4	3	A	50	25.4	50	10	6	6							
	63-25.4	4	A	63	25.4	50	10	6	6							●
	80-25.4	5	A	80	25.4	50	10	6	6							
	100-31.75	6	B	100	31.75	50	13	8	6	DP-31.75						
TRS 8R	63-22	4	A	63	22	50	10.4	6.3	8		RD□□T1606 MO	Y-8R	M50115-60 M5×11.5	T20P T20P		●
	80-27	4	A	80	27	50	12.4	7	8							
	100-32	5	B	100	32	50	14.4	8	8	DP-32						
	63-25.4	4	A	63	25.4	50	10	6	8							
	80-25.4	4	A	80	25.4	50	10	6	8							
	100-31.75	5	B	100	31.75	50	13	8	8	DP-31.75						

可配用刀片 Inserts

型號 Cat.NO.	CY100H	CY15	CY25	CY150	CY250	GF30	TB6005	TB6020	TB6045	TB6060	WH10	H101	H102	KC25	PP30	PC35	刀片形狀 Insert shape	尺寸 Size(mm) D	S	排屑槽	品牌 Brand
RDHW10T3MOTN				●	●	●			●									10	3.97	无	HITACHI (日立)
1204MOTN				●	●	●			●									12	4.76	无	
1604MOTN				●	●	●			●									16	4.76	无	
RDMT10T3MOTN			●	●	●	●	●	●	●	●								10	3.97	有	
10T3MOEN	●										●							10	3.97	有	
1204MOTN				●	●	●	●	●	●	●								12	4.76	有	
1204MOEN											●							12	4.76	有	
RDMX1604MOTN		●	●	●	●	●	●	●	●	●								16	4.76	有	
1604MOEN	●										●							16	4.76	有	

型號 Cat.NO.	WAP25	WAP35	WXP45	WXM35	WAK15	WAK25	WXN15	WXN15	WK10	WCB50	WCB80	WMG40	刀片形狀 Insert shape	尺寸 Size(mm) D	S	排屑槽	品牌 Brand
RDHW10T3MOT-A25										●	●			10	3.97	无	WALTER (瓦尔特)
10T3MOT-A27		●	●			●								10	3.97	无	
10T3MO-A57	●				●			●						10	3.97	无	
RDMW10T3MOT-A27		●	●			●								10	3.97	无	
RDHW1204MOT-A25										●	●			12	4.76	有	
1204MOT-A27		●	●			●								12	4.76	有	
1204MO-A57	●				●			●						12	4.76	有	
RDMW1204MOT-A27		●	●			●								12	4.76	有	
RDMT10T3MO-D57		●		●		●						●		10	3.97	有	
RDGT10T3MO-G85														10	3.97	有	
10T3MO-G88							●		●					10	3.97	有	
RDMT1204MO-D57		●		●		●						●		12	4.76	有	
RDGT1204MO-G85														12	4.76	有	
1204MO-G88							●		●					12	4.76	有	

捨弃式刀具 殼形銑刀

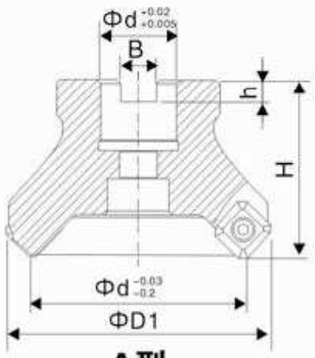
KM-45°
殼形銑刀
Corner Rounding End Mill

精加工 Plane Finishing

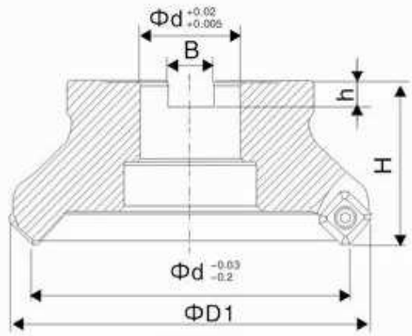
粗加工 Roughing

標準配件

刀片螺絲		1套+2個
旗形扳手		1支



A型
A type



B型
B type

KM12-63-4T

KM12-80-5T

KM12-100-5T

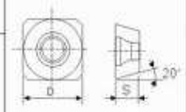
KM12-125-6T

捨弃式刀具 殼形銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No of flutes	樣式 Manner	尺寸 Size D	D1	d	H	B	L	墊片 Circular Cushin	適用刀片 Applicable inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
KM12	50-22	4	A	50	65	22	50	10.4	6.3		SEKT1204	M50110-38 M5×11	T20P T20		●
	63-22	4	A	63	78	22	50	10.4	6.3						●
	80-27	5	A	80	95	27	50	12.4	7						●
	100-32	5	B	100	115	32	50	14.4	8	DP-32					●
	125-40	6	B	125	140	40	63	16.4	9	DP-40					●
	50-25.4	4	A	50	65	25.4	50	10	6						●
	63-25.4	4	A	63	78	25.4	50	10	6						●
	80-25.4	5	A	80	95	25.4	50	10	6						●
	100-31.75	5	B	100	115	31.75	50	13	8	DP-31.75					●
	125-40	6	B	125	140	38.1	63	16.2	10	DP-38.1					●

可配用刀片 Inserts

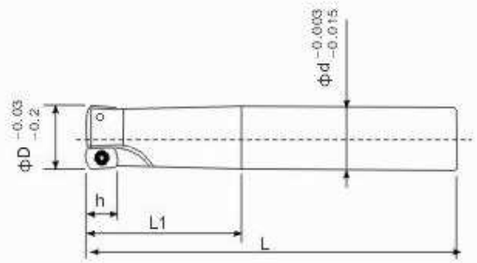
型号 Cat.NO.	WAP25	WAP35	WTP35	WXP45	WPM	WXM35	WAK15	WAK25	WKM	WK10	NCM325	PC5535	PC9530	PC6510	PC230	CN30	H01	刀片形狀 Insert shape	尺寸 Size(mm) D	S	排屑槽	品牌 Brand
SEHT1204AFN		●	●	●		●				●									12.7	4.76	有	WHLIER 瓦尔特
1204AFN-K88										●									12.7	4.76	有	
SEHW1204AFN	●	●	●		●	●	●	●	●										12.7	4.76	无	
SECA1204AFSN											●	●							12.7	4.76	无	KORLOY 刀片
1204AFTN													●		●	●			12.7	4.76	无	
1204AFFN														●					12.7	4.76	无	
1204AFEN											●								12.7	4.76	无	
SEHT1204AFFN-M																	●		12.7	4.76	无	

捨弃式刀具 立銑刀

ASR
快進給立銑刀
High Feedrate End Mill

標準配件

刀片螺絲		1套+2個
旗形扳手		1支



可配用刀片 Inserts

型號 Cat.NO.	JX8045	GX2030	JX1005	JX1015	JX1020	JX1045	JX1060	刀片形狀 Insert shape	尺寸 Size(mm) R	L	S	B	排屑槽	品牌
EPNW0603TN-8	●	●	●	●	●	●	●		8	10	3.18	6.35	无	HITACHI (日立)
EPMT0603TN-8	●	●	●	●	●	●	●		8	10	3.18	6.35	有	

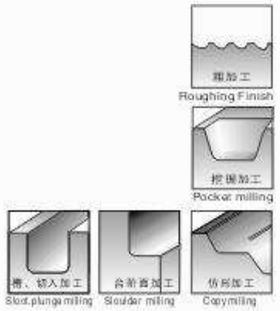
捨弃式刀具 立銑刀

UNIT :MM

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	尺寸 Size D	d	L	L1	h	適用刀片 Applicable inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
ASR2	16 × 120	2	16	16	120	40	7	EPNW0603TN-8 EPMT0603TN-8	M25060-55 M2.5X6	T8P T8		●
	17 × 120-C16	2	17	16	120	30	7					●
	16 × 160	2	16	16	160	50	7					●
	17 × 160-C16	2	17	16	160	30	7					●
	20 × 120	2	20	20	120	40	7					●
	20 × 160	2	20	20	160	50	7					●
	21 × 160-C20	2	21	20	160	30	7					●
	25 × 160	3	25	25	160	50	7					●
	25 × 200	3	25	25	200	70	7					
	26 × 200-C25	3	26	25	200	50	7					
	32 × 160	4	32	32	160	50	7					
	33 × 160-C32	4	33	32	160	40	7					●
	32 × 200	4	32	32	200	80	7					
	33 × 200-C32	4	33	32	200	60	7					●
	35 × 200-C32	4	35	32	200	60	7					
	40 × 160-C32	4	40	32	160	50	7					●
	40 × 200-C32	4	40	32	200	60	7					●

捨弃式刀具 立銑刀

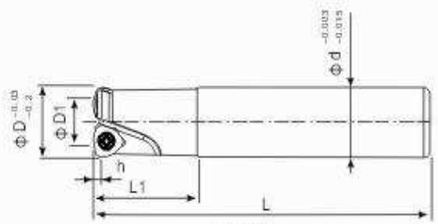
AJX
快進給立銑刀
High Feedrate End Mill



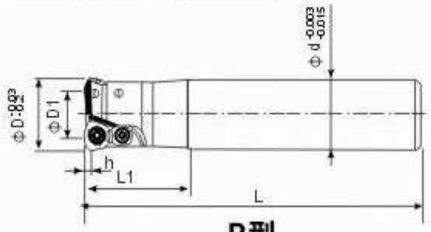
標準配件

A型		
刀片螺絲		1套+2個
旗形扳手		1支

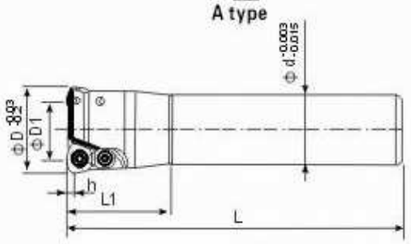
B、C型		
刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



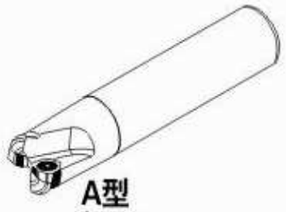
A型
A type



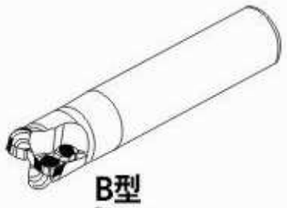
B型
B type



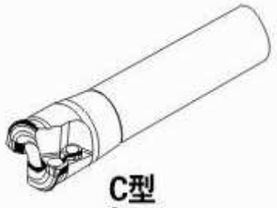
C型
C type



A型
A type



B型
B type



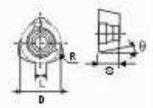
C型
C type

捨弃式刀具 立銑刀

UNIT :MM

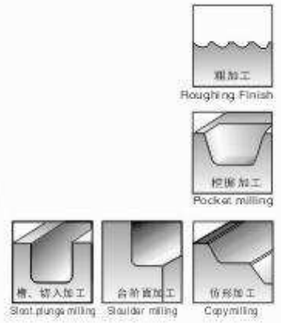
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	D1	d	L	L1	h	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
AJX06	16×120	2	A	16	8.9	16	120	40	1	JOMT06T215ZZSR		M25060-55 M2.5×6	T8P T8		
	16×160	2	A	16	8.9	16	160	40	1						
	17×160-C16	2	A	17	9.9	16	160	40	1						
AJX08	20×120	2	A	20	11.4	20	120	40	1.5	JOMT080320ZZSR		M30070-55 M3×7	T10P T10		
	20×160	2	A	20	11.4	20	160	50	1.5						
	20×200	2	A	20	11.4	20	200	50	1.5						
	21×160-C20	2	A	21	12.4	20	160	50	1.5						
	21×200-C20	2	A	21	12.4	20	200	50	1.5						
AJX09	25×160	2	A	25	14.9	25	160	60	2	JDMT09T320ZDSR	YS-15	M35085-60 M3.5×8.5 M40100-60 M4×10 (馬板螺絲)	T15P T15		
	25×200	2	A	25	14.9	25	200	120	2						
	26×160-C25	2	A	26	15.9	25	160	50	2						
	26×200-C25	2	A	26	15.9	25	200	50	2						
AJX12R	32×160	2	B	32	20.3	32	160	60	2	JDMT120420ZDSR	YM-4	M40100-60 M4×10	T15P T15		●
	32×200	2	B	32	20.3	32	200	80	2						●
	32×250	2	B	32	20.3	32	250	140	2						
	32×300	2	B	32	20.3	32	300	160	2						
	33×160-C32	2	B	33	21.3	32	160	50	2						●
	33×200-C32	2	B	33	21.3	32	200	50	2						●
	33×250-C32	2	B	33	21.3	32	250	60	2						
	33×300-C32	2	B	33	21.3	32	300	60	2						
	35×160-C32	2	C	35	23.3	32	160	50	2						●
	35×200-C32	2	C	35	23.3	32	200	50	2						●
	35×250-C32	2	C	35	23.3	32	250	60	2						
	35×300-C32	2	C	35	23.3	32	300	60	2						
	40×160-C32	3	C	40	28.3	32	160	50	2						●
	40×200-C32	3	C	40	28.3	32	200	50	2						●
	40×250-C32	3	C	40	28.3	32	250	60	2						
	40×300-C32	3	C	40	28.3	32	300	60	2						
	40×350-C32	3	C	40	28.3	32	350	60	2						
	40×350-C42	3	C	40	28.3	42	350	80	2						

可配用刀片 Inserts

型號 Cat.NO.	FH7020	VP15TF	VP30RT	刀片形狀 Insert shape	尺寸 Size(mm) θ	D	S	L	R	品牌 Brand
JOMW06T215ZZSR-FT	●	●	●		13	6.35	2.78	1.2	1.5	MTSUBISHI(三菱)
080320ZZSR-FT	●	●	●		13	8	3.18	1.4	2	
JDMW09T320ZDSR-FT	●	●	●		15	9.525	3.97	1.8	2	
120420ZDSR-FT	●	●	●		15	12	4.76	5	2	
JOMT06T215ZZSR-JM	●	●	●		13	6.35	2.78	1.2	1.5	
080320ZZSR-JM	●	●	●		13	8	3.18	1.4	2	
JDMT09T320ZDSR-JM	●	●	●		15	9.525	3.97	1.8	2	
120420ZDSR-ST	●	●	●		15	12	4.76	5	2	
120420ZDSR-JM	●	●	●		15	12	4.76	5	2	

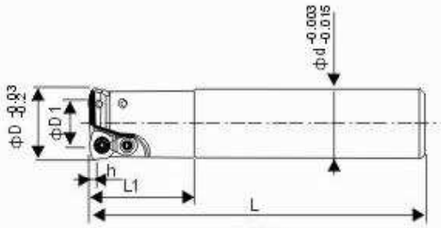
捨弃式刀具 立銑刀

TXP
快進給立銑刀
High Feedrate End Mill

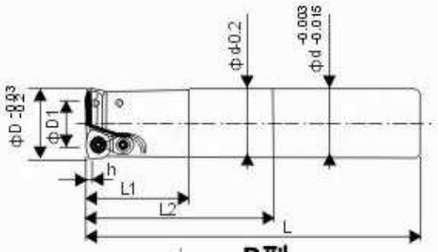


標準配件

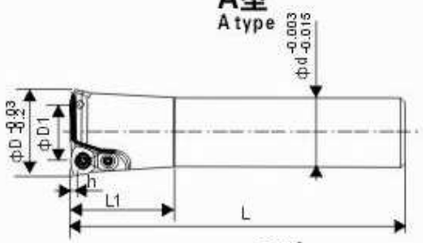
刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



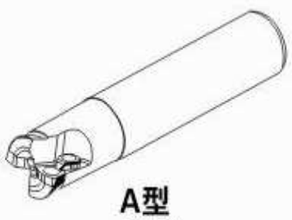
A型
A type



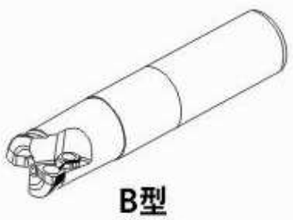
B型
B type



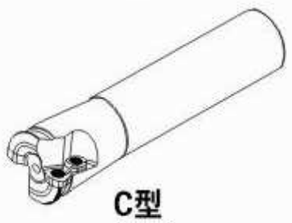
C型
C type



A型
A type



B型
B type



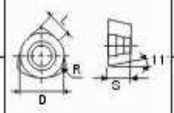
C型
C type

捨弃式刀具 立銑刀

UNIT : MM

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	D1	L	L1	L2	h	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
TXP05	20×120	2	A	20	20	12.4	120	40		1.5	WPMW05H315ZPR		M35080-50 M3.5×8	T15P T15		
	20×160	2	A	20	20	12.4	160	50		1.5						
	20×200	2	B	20	20	12.4	200	50	100	1.5						
	21×120-C20	2	A	21	20	13.4	120	50		1.5						
	21×160-C20	2	A	21	20	13.4	160	50		1.5						
	21×200-C20	2	A	21	20	13.4	200	50		1.5						
TXP06	25×160	2	A	25	25	16.4	160	60		1.5	WPMW06X415ZPR	YS-15	M40100-60 M4×10			
	25×160-C24	2	A	25	24	16.4	160	50		1.5						
	25×200	2	A	25	25	16.4	200	75		1.5						
	26×200-C25	2	A	26	25	17.4	200	60		1.5						
	32×160	3	A	32	32	23.4	160	75		1.5						
	32×200	3	A	32	32	23.4	200	115		1.5						
	32×250	3	A	32	32	23.4	250	115		1.5						
	33×160-C32	3	A	33	32	24.4	160	80		1.5						
	33×200-C32	3	A	33	32	24.4	200	120		1.5						
	33×250-C32	3	A	33	32	24.4	250	120		1.5						
	40×200-C32	3	C	40	32	31.4	200	60		1.5						
	40×250-C32	3	C	40	32	31.4	250	60		1.5						
	40×300-C32	3	C	40	32	31.4	300	60		1.5						
	40×300-C42	3	C	40	42	31.4	300	60		1.5						

可配用刀片 Inserts

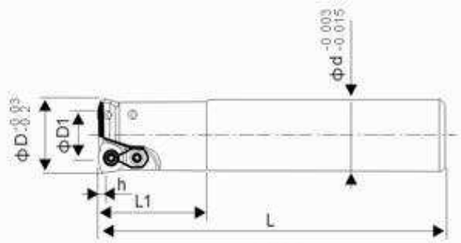
型號 Cat.NO.	AH120	AH140	T3030	T1015	刀片形狀 Insert shape	尺寸 Size(mm) L	D	S	R	品牌 Brand
WPMW05H315ZPR	●	●	●	●		5	7.94	3.5	1.5	TUNGALOY(株式会社)
WPMT05H315ZPR-ML	●	●	●			5	7.94	3.5	1.5	
05H315ZPR-MH	●	●				5	7.94	3.5	1.5	
WPMW06X415ZPR	●	●	●	●		6	9.525	4.2	1.5	
WPMT06X415ZPR-ML	●	●	●			6	9.525	4.2	1.5	
06X415ZPR-MH	●	●				6	9.525	4.2	1.5	

捨弃式刀具 立銑刀

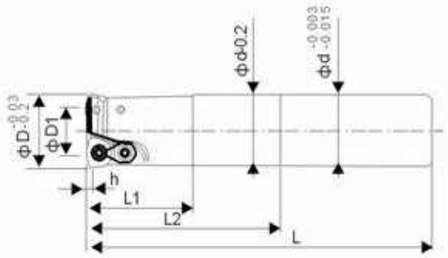
SKS
快進給立銑刀
High Feedrate End Mill

標準配件

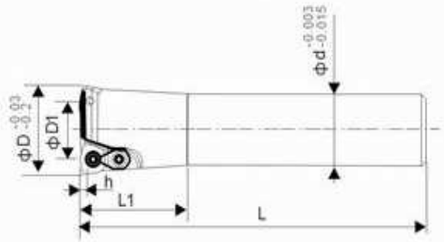
刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



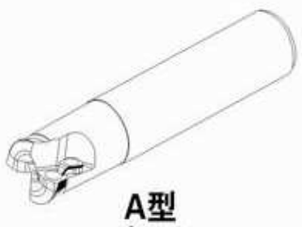
A型
A type



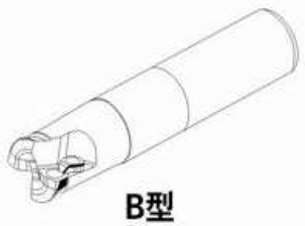
B型
B type



C型
C type



A型
A type



B型
B type

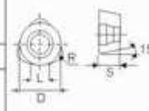
C型
C type

捨弃式刀具 立銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
SKS05	20×130	2	A	20	20	130	50		1.25	WDMW050316ZTR WDHW050316ZTR		M30070-55 M3×7	T10P T10		
	20×180	2	A	20	20	180	80		1.25						
	21×130-C20	2	A	21	20	130	50		1.25						
	21×180-C20	2	A	21	20	180	50		1.25						
SKS06	25×140	2	A	25	25	140	60		1.5	WDMW06T320ZTR WDHW060320ZTR	YM-4	M40090-50 M4×9	T15P T15		
	25×200	2	B	25	25	200	60	120	1.5						
	26×140-C25	2	A	26	25	140	60		1.5						
	26×200-C25	2	B	26	25	200	60	120	1.5						
	30×150-C32	2	A	30	32	150	70		1.5						
	30×200-C32	2	B	30	32	200	60	120	1.5						
	32×150	3	A	32	32	150	70		1.5						
	32×200	3	B	32	32	200	60	120	1.5						
	33×150-C32	2	A	33	32	150	70		1.5						
	33×200-C32	2	B	33	32	200	70		1.5						
	33×150-C32	3	A	33	32	150	70		1.5						
	33×200-C32	3	B	33	32	200	60	120	1.5						
SKS08	32×150	2	A	32	32	150	70		2	WDMW080520ZTR WDMT080520ZER WDHW080520ZTR	YS-20	M45105-50 M4.5×10.5 M50110-38 M5×11 (压板螺丝)	T20P T20		
	32×200	2	B	32	32	200	60	120	2						
	40×150-C32	3	C	40	32	150	50		2						
	40×200-C32	3	C	40	32	200	50		2						
	50×150-C32	3	C	50	32	150	50		2						
	50×150-C42	3	C	50	42	150	50		2						
	50×250-C42	3	C	50	42	250	50		2						

可配用刀片 Inserts

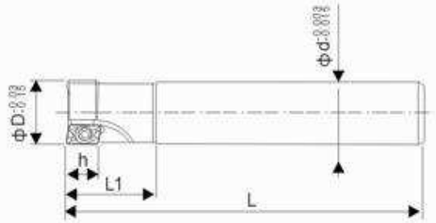
型號 Cat.NO.	JC5015	JC5040	JC600	JC730U	JC8015	刀片形狀 Insert shape	尺寸 Size(mm) D	L	S	R	品牌 Brand
WDMW050316ZTR	●	●			●		8	1.0	3.2	1.6	DIJET(賀杰)
06T320ZTR	●	●			●		10	1.2	3.97	2	
080520ZTR	●	●			●		13	1.5	5.5	2	
WDMT080520ZER			●	●			13	1.5	5.5	2	
WDHW050316ZTR	●	●					8	1.0	3.2	1.6	
060320ZTR	●	●					10	1.2	3.97	2	
080520ZTR	●	●					13	1.5	5.5	2	

捨弃式刀具 立銑刀

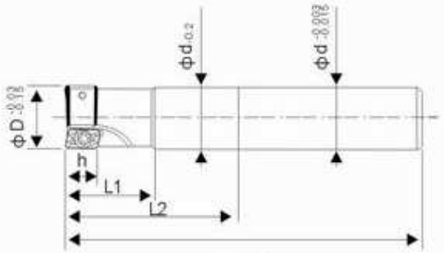
AHU
直角臺肩銑刀
Right Angle Shoulder Corner RoundingEnd Mill

標準配件

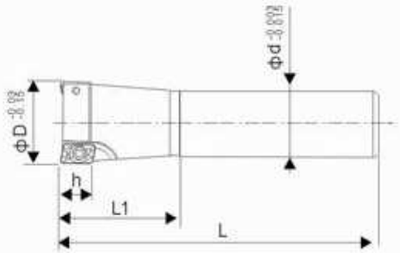
刀片螺絲		1套+2個
旗形扳手		1支



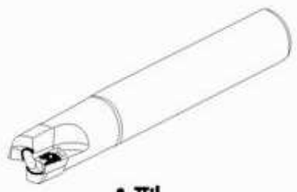
A型
A type



B型
B type



C型
C type



A型
A type

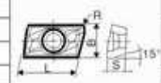
B型
B type

C型
C type

捨弃式刀具 立銑刀

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Applicable inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
AHU10	12×120	1	A	12	12	120	30		9	JDMT 1003□□R	M25050-55 M2.5×5	T8P T8		●
	12×150	1	A	12	12	150	30		9					●
	13×120-C12	1	A	13	12	120	30		9					●
	13×150-C12	1	A	13	12	150	35		9					
	16×120	2	A	16	16	120	40		9		M25060-55 M2.5×6			●
	16×120-C15	2	A	16	15	120	40		9					
	16×160	2	A	16	16	160	40		9					●
	16×160-C15	2	A	16	15	160	40		9					
	16×160-C15.6	2	A	16	15.6	160	40		9					
	16×180	2	B	16	16	180	40	90	9					
	16×180-C15	2	A	16	15	180	40		9					
	16×200	2	B	16	16	200	40	100	9					●
	17×120-C16	2	A	17	16	120	40		9					
	17×160-C16	2	A	17	16	160	40		9					●
	17×200-C16	2	A	17	16	200	40		9					●
	20×120	2	A	20	20	120	40		9					●
	20×160	2	A	20	20	160	50		9					●
	20×160-C19	2	A	20	19	160	50		9					
	20×200	2	B	20	20	200	50	100	9					●
	20×200-C19	2	A	20	19	200	50		9					
	21×160-C20	2	A	21	20	160	40		9					●
	21×200-C20	2	A	21	20	200	50		9					●
	25×160	3	A	25	25	160	50		9					●
	25×200	3	A	25	25	200	70		9					●
	25×160-C24	3	A	25	24	160	50		9					
	26×160-C25	3	A	26	25	160	50		9					
	30×160-C25	3	C	30	25	160	50		9					
	30×200-C25	3	C	30	25	200	50		9					
	30×250-C25	3	C	30	25	250	50		9					
AHU15	25×160	2	A	25	25	160	50		14	JDMT 1505□□R	M40090-55 M4×9	T15P T15		●
	25×160-C24	2	A	25	24	160	50		14					
	25×200	2	A	25	25	200	70		14					●
	25×200-C24	2	A	25	24	200	50		14					
	26×160-C25	2	A	26	25	160	50		14					
	26×200-C25	2	A	26	25	200	50		14					
	32×160-C25	2/3	C	32	25	160	50		14					●
	32×200-C25	2/3	C	32	25	200	50		14					
	32×160	2/3	A	32	32	160	50		14					●
	32×200	2/3	A	32	32	200	80		14					●
	32×250-C25	2/3	C	32	25	250	50		14					
	32×250	2/3	B	32	32	250	60	110	14					●
	32×300	2/3	B	32	32	300	60	160	14					
	35×200-C32	3	C	35	32	200	50		14					●
	35×250-C32	3	C	35	32	250	60		14					●
	35×300-C32	3	C	35	32	300	60		14					●
	35×350-C32	3	C	35	32	350	60		14					
	40×200-C32	3/4	C	40	32	200	50		14					
	40×250-C32	3/4	C	40	32	250	60		14					
	40×300-C32	3/4	C	40	32	300	60		14					
	40×350-C32	3/4	C	40	32	350	60		14					

可配用刀片 Inserts

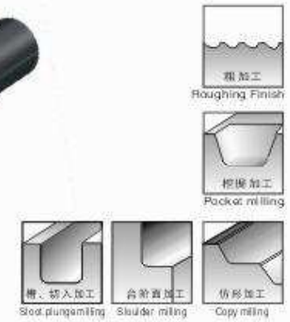
型號 Cat.NO.	SH8020	PTH30E	TB6045	PTH40H	PTH13S	刀片形狀 Insert shape	尺寸 Size(mm) L	B	S	R	品牌 Brand
JDMT100308R-FW	●	●					11	6.1	3.5	0.8	HTACHI(日立)
JDMT100304R	●	●	●		●		11	6.1	3.5	0.4	
JDMT100308R	●	●	●	●	●		11	6.1	3.5	0.8	
JDMT100320R	●	●					11	6.1	3.5	2.0	
JDMT150504R	●	●	●		●		16	9.12	5	0.4	
JDMT150508R	●	●	●	●	●		16	9.12	5	0.8	
JDMT150520R	●	●					16	9.12	5	2.0	
JDMT150530R	●	●		●			16	9.12	5	3.0	

捨弃式刀具

立銑刀

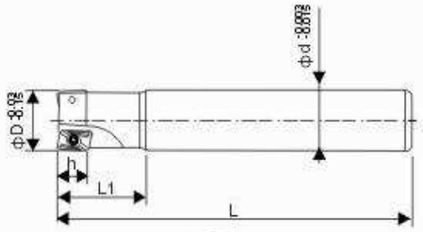
BAP
直角臺肩銑刀
Right Angle Shoulder Corner Rounding End Mill

提示：請保留您的報廢的1604刀片,RAP-75°給您更大的驚喜

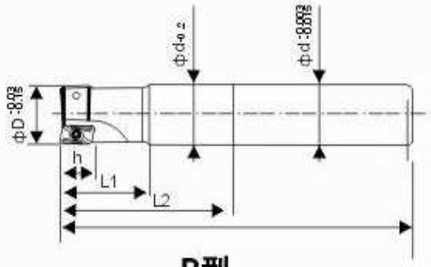


標準配件

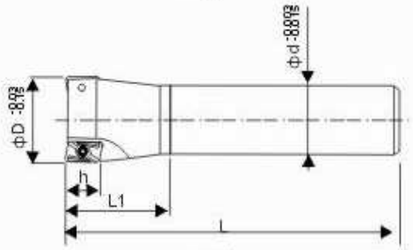
刀片螺絲		1套+2個
旗形扳手		1支



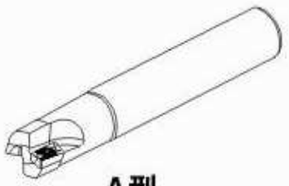
A型
A type



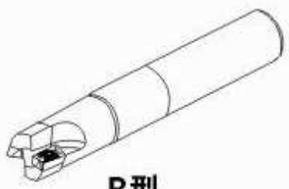
B型
B type



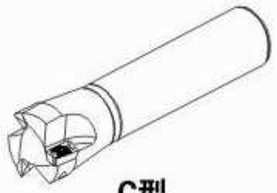
C型
C type



A型
A type



B型
B type



C型
C type

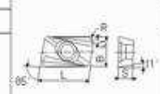
捨弃式刀具

臺肩銑刀

型號 Cat.NO.	規格 Spec	刃數 No.of blade	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Applicable inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
BAP300R	10×120	1	A	10	10	120	30		9	APMT 1135 PDER	M25050-55 M2.5×5.0	T8P T8		●
	12×120	1	A	12	12	120	30		9					●
	12×150	1	A	12	12	150	36		9					●
	13×120-C12	1	A	13	12	120	30		9					●
	13×150-C12	1	A	13	12	150	36		9					●
	16×120	2	A	16	16	120	40		9		M25060-55 M2.5×6.0	T8P T8		
	16×160	2	A	16	16	160	40		9					●
	16×160-C15.6	2	A	16	15.6	160	40		9					●
	16×180	2	B	16	16	180	40	90	9					
	16×180-C15	2	A	16	15	180	40		9					●
	16×200	2	B	16	16	200	40	100	9					●
	16×160-C15	2	A	16	15	160	40		9					
	17×160-C16	2	A	17	16	160	40		9					●
	17×200-C16	2	A	17	16	200	40		9					●
	20×120	2	A	20	20	120	40		9					●
	20×160	2	A	20	20	160	50		9					●
	20×160-C19	2	A	20	19	160	50		9					
	20×180	2	B	20	20	180	50	90	9					●
	20×180-C19	2	A	20	19	180	45		9					
	20×200	2	B	20	20	200	50	100	9					●
	20×200-C19	2	A	20	19	200	50		9					●
	21×160-C20	2	A	21	20	160	40		9					●
	21×180-C20	2	A	21	20	180	50		9					
	21×200-C20	2	A	21	20	200	50		9					●
	25×160	3	A	25	25	160	50		9					●
	25×160-C24	3	A	25	24	160	50		9					
	25×200	3	A	25	25	200	75		9					●
	25×200-C24	3	A	25	24	200	50		9					
	26×160-C25	3	A	26	25	160	40		9					
	26×200-C25	3	A	26	25	200	50		9					
	30×160-C25	3	C	30	25	160	50		9					●
	30×200-C25	3	C	30	25	200	50		9					
	30×250-C25	3	C	30	25	250	50		9					
	30×300-C25	3	C	30	25	300	50		9					
BAP400R	25×160	2	A	25	25	160	50		14	APMT 1604 PDER	M40090-55 M4×9	T15P T15		●
	25×160-C24	2	A	25	24	160	50		14					●
	25×200	2	A	25	25	200	75		14					●
	25×200-C24	2	A	25	24	200	50		14					●
	25×250	2	B	25	25	250	50	110	14					●
	25×250-C24	2	A	25	24	250	50		14					●
	26×160-C25	2	A	26	25	160	50		14					●
	26×200-C25	2	A	26	25	200	50		14					
	32×160-C25	2/3	C	32	25	160	50		14					●
	32×200-C25	2/3	C	32	25	200	50		14					●
	32×200	2/3	A	32	32	200	80		14					●
	32×250-C25	2/3	C	32	25	250	60		14					
	32×250	2/3	B	32	32	250	60	110	14					
	32×300	2/3	B	32	32	300	60	160	14					
	32×350	2/3	B	32	32	350	60	160	14					
	35×160-C32	3	C	35	32	160	50		14					●
	35×250-C32	3	C	35	32	250	60		14					●
	35×300-C32	3	C	35	32	300	60		14					●
	35×350-C32	3	C	35	32	350	60		14					●
	40×200-C32	3	C	40	32	200	50		14					●
	40×250-C32	3	C	40	32	250	60		14					●
	40×300-C32	3	C	40	32	300	60		14					
	40×350-C32	3	C	40	32	350	60		14					

捨弃式刀具 臺肩銑刀

可配用刀片 Inserts

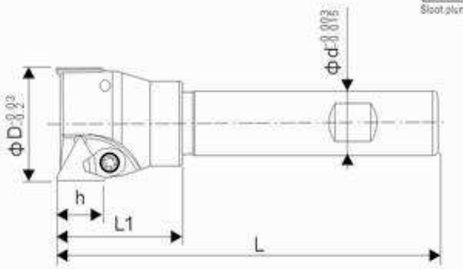
型號 Cat.NO.	F7030	F620	VP15TF	UP20M	NX2525	NX4545	UT120T	HT110	NCM325	PC3535	PC3545	PC3530	PC6510	PD2000	H01	H101	H102	KC25	PP30	Pc35	刀片形狀 Insert shape	尺寸 Size(mm) L	B	S	L1	R	品牌 Brand
APMT1135PDER-H1	●	●	●	●	●	●	●	●														11	6.35	3.5	1.5	0.4	MITSUBISHI(日本)
1135PDER-H2	●	●	●	●	●	●	●	●														11	6.35	3.5	1.2	0.8	
1135PDER-H3	●	●		●			●															11	6.35	3.5	0.8	1.2	
1135PDER-H4	●	●		●			●															11	6.35	3.5	0.4	1.6	
1135PDER-H6	●	●		●			●															11	6.35	3.5	0.4	2.4	
APMT1135PDER-M0	●																					11	6.35	3.5	1.8	0.2	
1135PDER-M1	●																					11	6.35	3.5	1.5	0.4	
1135PDER-M2	●	●	●			●																11	6.35	3.5	1.2	0.8	
APGT1135PFDR-G2								●														11	6.35	3.5	1.2	0.8	
APMT1604PDER-H1	●		●				●															16.5	9.525	4.76	1.7	0.4	
1604PDER-H2	●	●	●	●	●	●	●	●														16.5	9.525	4.76	1.7	0.8	
1604PDER-H4	●						●															16.5	9.525	4.76	1.7	1.6	
1604PDER-H6	●						●															16.5	9.525	4.76	1.7	2.4	
1604PDER-H8	●						●															16.5	9.525	4.76	1.7	3.2	
APMT1604PDER-M2	●	●	●			●																16.5	9.525	4.76	1.7	0.8	
APGT1604PFDR-G2	●							●														16.5	9.525	4.76	1.7	0.8	
APKT1604PDSR									●	●	●	●	●									16.4	9.525	4.76	-	0.8	KORLOY
1604DFR-MA														●	●							16.4	9.525	4.76	-	0.8	

捨弃式刀具 殼形銑刀

TP
臺肩殼形銑刀
Shoulder Corner Rounding End Mill

標準配件

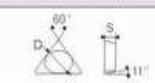
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支



UNIT:MM

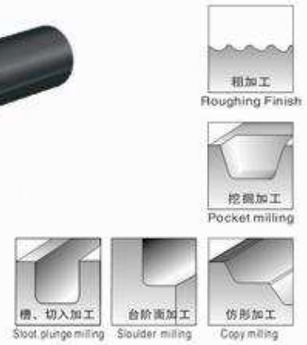
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	尺寸 Size D	d	L	L1	h	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
TP16	30×100-C20	2	30	20	100	45	14	TPMN1603 TPKN1603	YM-4	M40100-60 M4×10	T15T T15		●
	35×100-C20	2	35	20	100	45	14						●
	35×105-C25	2	35	25	105	45	14						
	35×110-C32	2	35	32	110	45	14						●
	40×110-C20	3	40	20	110	45	14						●
	40×110-C25	3	40	25	110	45	14						●
	40×115-C32	3	40	32	115	45	14						●
TP22	50×110-C20	3	50	20	110	42	20	TPMN2204 TPKN2204	YS-20	M50110-38 M5×11	T20T T20		●
	50×110-C25	3	50	25	110	42	20						
	50×115-C32	3	50	32	115	42	20						●
	63×110-C20	3	63	20	110	42	20						
	63×110-C25	3	63	25	110	42	20						
	63×110-C32	3	63	32	110	42	20						

可配用刀片 Inserts

型號 Cat.NO.	CY25	EX35	CH550	WH10	PJ20	PP30	PC35	PP20	KC25	刀片形狀 Insert shape	尺寸 Size(mm) D	S	品牌 Brand
TPMN160308		●	●	●							9.525	3.18	HITACHI (日立)
TPMN220412		●	●	●							12.7	4.76	
TPMN220408Y	●										12.7	4.76	

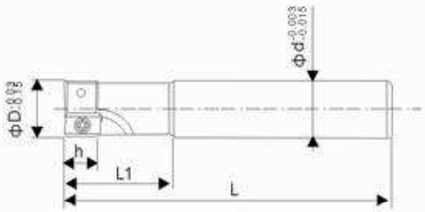
捨弃式刀具 精銑刀

UEX
直角臺肩精銑刀
Right Angle Shoulder Precision End Mill

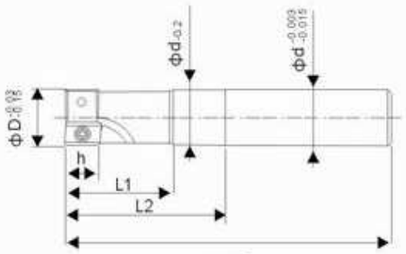


標準配件

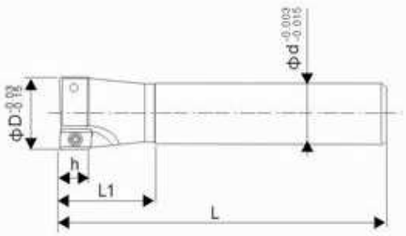
刀片螺絲		1套+2個
旗形扳手		1支



A型
A type



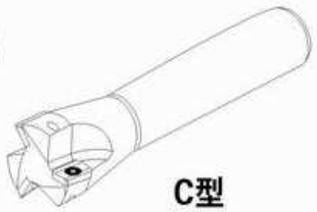
B型
B type



C型
C type

A型
A type

B型
B type



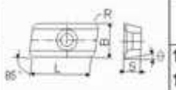
C型
C type

捨弃式刀具 精銑刀

UNIT:MM

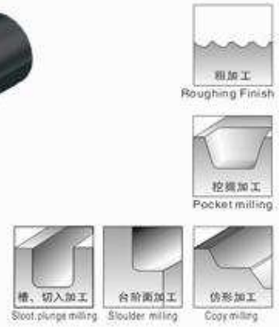
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Applicable Inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
UEX12	16×120	1	A	16	16	120	40		12	APET1202□□□R APEW120204SR APNT120208□R	M35080-50 M3.5×8	T15P T15		
	16×160	1	A	16	16	160	50		12					
	16×180	1	B	16	16	180	40	90	12					
	16×200	1	B	16	16	200	40	100	12					
	17×160-C16	1	A	17	16	160	40		12					
	17×200-C16	1	A	17	16	200	40		12					
	20×120	2	A	20	20	120	40		12					
	20×160	2	A	20	20	160	50		12					
	20×180	2	B	20	20	180	50	90	12					
	20×180-C19	2	A	20	19	180	45		12					
	20×200	2	B	20	20	200	50	100	12					
	21×160-C20	2	A	21	20	160	40		12					
	21×180-C20	2	A	21	20	180	45		12					
	21×200-C20	2	A	21	20	200	50		12					
UEX16	25×160	2	A	25	25	160	50		15	ADET1603□□R ADEW160308SR ADNT160308□R	M4×7.5			
	25×160-C24	2	A	25	24	160	50		15					
	25×200	2	A	25	25	200	75		15					
	25×200-C24	2	A	25	24	200	50		15					
	25×250-C24	2	A	25	24	250	60		15					
	25×250	2	B	25	25	250	60	110	15					
	26×200-C25	2	A	26	25	200	50		15					
	26×250-C25	2	A	26	25	250	50		15					
	32×200-C25	2/3	C	32	25	200	50		15					
	32×200	2/3	A	32	32	200	80		15					
	32×250-C25	2/3	C	32	25	250	60		15					
	32×250	2/3	B	32	32	250	60	110	15					
	32×300	2/3	B	32	32	300	60	160	15					
	32×350	2/3	B	32	32	350	60	160	15					
	35×200-C32	3	C	35	32	200	50		15					
	35×250-C32	3	C	35	32	250	60		15					
	35×300-C32	3	C	35	32	300	60		15					
	35×350-C32	3	C	35	32	350	60		15					
	40×200-C32	3	C	40	32	200	50		15					
	40×250-C32	3	C	40	32	250	60		15					
	40×300-C32	2	C	40	32	300	60		15					
	40×350-C32	2	C	40	32	350	60		15					

可配用刀片 Inserts

型號 Cat.NO.	CY100H	HC844	CH550	EX35	WH10	刀片形狀 Insert shape	尺寸 Size(mm) L	B	S	θ	R	品牌 Brand
APET120202SR		●	●				12.7	7.938	2.5	11	0.2	HTACHI(日立)
120202ER							12.7	7.938	2.5	11	0.2	
120202FR					●		12.7	7.938	2.5	11	0.2	
APET120204SR		●	●	●			12.7	7.938	2.5	11	0.4	
120204ER					●		12.7	7.938	2.5	11	0.4	
APET120208SR		●	●	●			12.7	7.938	2.5	11	0.8	
120208ER					●		12.7	7.938	2.5	11	0.8	
APEW120204SR							12.7	7.938	2.5	11	0.4	
APNT120208SR		●	●	●			12.7	7.938	2.5	11	0.8	
120208ER					●		12.7	7.938	2.5	11	0.8	
ADET160302SR		●	●				15.875	9.525	3.18	15	0.2	
160302ER							15.875	9.525	3.18	15	0.2	
160302FR					●		15.875	9.525	3.18	15	0.2	
ADET160304SR		●	●				15.875	9.525	3.18	15	0.4	
160304ER					●		15.875	9.525	3.18	15	0.4	
ADET160308SR		●	●	●			15.875	9.525	3.18	15	0.8	
160308ER	●				●		15.875	9.525	3.18	15	0.8	
ADEW160308ER							15.875	9.525	3.18	15	0.8	
ADNT160308SR		●	●	●			15.875	9.525	3.18	15	0.8	
160308ER	●				●		15.875	9.525	3.18	15	0.8	

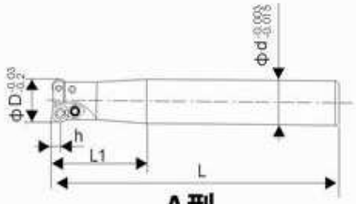
捨弃式刀具 圓鼻立銑刀

EMR 圓鼻立銑刀 Corner Radius End Mill

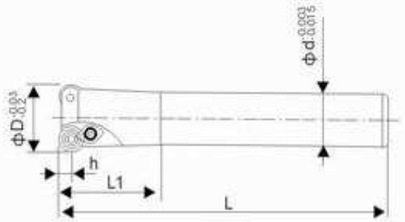


標準配件

刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支

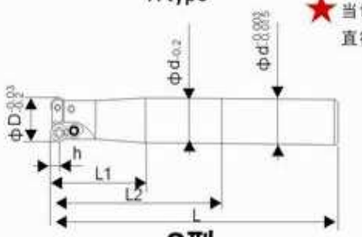


A型
A type

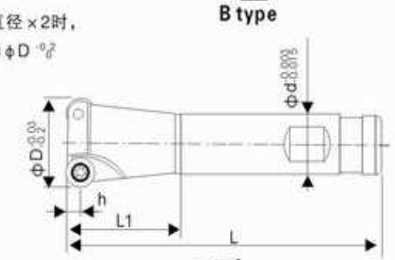


B型
B type

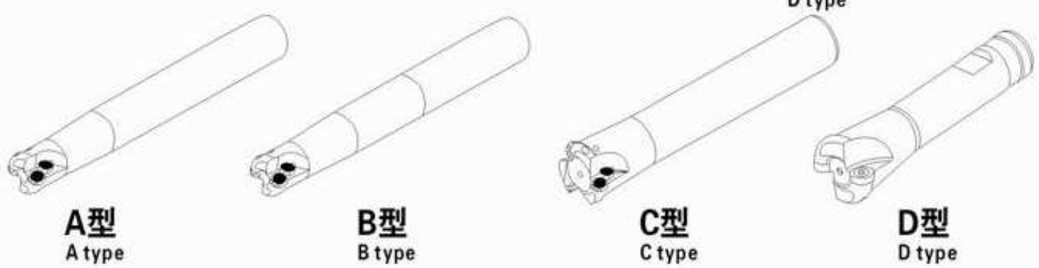
★ 当切削直径 ϕD = 刀片直径 ×2时，
直径公差由 ϕD 改为 ϕD



C型
C type



D型
D type



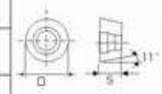
A型 A type　B型 B type　C型 C type　D型 D type

捨弃式刀具 圓鼻立銑刀

UNIT:MM

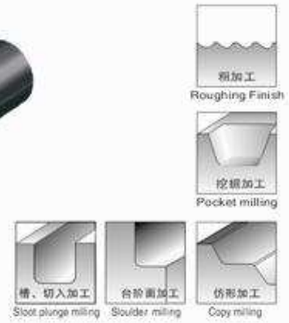
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
EMR-4R	12×120	1	A	12	12	120	40		4	RPMW 0802 MO	Y-4R	M30070-55 M3×7	T10P T10		●
	13×120-C12	1	A	13	12	120	40		4						●
	16×120	2	A	16	16	120	40		4						
	16×120-C15	2	A	16	15	120	40		4						●
	16×160	2	A	16	16	160	40		4						●
	16×160-C15	2	A	16	15	160	40		4						
	16×160-C15.6	2	A	16	15.6	160	40		4						
	16×180	2	B	16	16	180	40	90	4						
	16×180-C15.6	2	A	16	15.6	180	40		4						
	16×200	2	B	16	16	200	40	100	4						●
	16×200-C15	2	A	16	15	200	50		4						
	17×120-C16	2	A	17	16	120	40		4						
	17×160-C16	2	A	17	16	160	40		4						●
	17×200-C16	2	A	17	16	200	40		4						●
	20×160	2	A	20	20	160	50		4						●
	20×160-C19	2	C	20	19	160	50		4						●
	20×180	2	B	20	20	180	50	90	4						
	20×180-C19	2	C	20	19	180	50		4						
	20×200	2	B	20	20	200	50	100	4						●
	20×200-C19	2	A	20	19	200	50		4						
	21×160-C20	2	A	21	20	160	50		4						●
	21×200-C20	2	A	21	20	200	50		4						●
EMR-5R	20×160	2	A	20	20	160	50		5	RPMW 1003 MO RPMT 1003 MOE	Y-5R	M40090-55 M4×9 M35100-50 M3.5×10 (压板螺丝)	T15P T15		●
	20×160-C19	2	A	20	19	160	50		5						
	20×180	2	B	20	20	180	50	90	5						
	20×200	2	B	20	20	200	50	100	5						●
	21×160-C20	2	A	21	20	160	50		5						●
	21×200-C20	2	A	21	20	200	50		5						
	25×160	2	A	25	25	160	50		5						●
	25×160-C20	2	C	25	20	160	50		5						●
	25×160-C24	2	A	25	24	160	50		5						
	25×180	2	A	25	25	180	50		5						●
	25×200	2	A	25	25	200	75		5						●
	25×250	2	B	25	25	250	60	100	5						●
	25×300	2	B	25	25	300	60	160	5						
	25×200-C20	2	C	25	20	200	50		5						●
	25×200-C24	2	A	25	24	200	50		5						●
	25×250-C24	2	A	25	24	250	60		5						
	26×160-C25	2	A	26	25	160	50		5						
	26×200-C25	2	A	26	25	200	50		5						
	30×110-C20	2	D	30	20	110	40		5						●
	30×110-C19.05	2	D	30	19.05	110	40		5						●
	30×160-C25	2	C	30	25	160	50		5						●
	30×200-C25	3	C	30	25	200	60		5						●
	30×250-C25	2	C	30	25	250	60		5						●
	30×300-C25	2	C	30	25	300	60		5						
	30×300-C32	2	C	30	32	300	60		5						
	35×160-C32	2/3	C	35	32	160	50		5						●
	35×200-C32	2/3	C	35	32	200	50		5						●
	35×250-C32	2/3	C	35	32	250	60		5						●
	35×300-C32	3	C	35	32	300	60		5						●
	35×350-C32	3	C	35	32	350	60		5						●
	40×160-C32	3/4	C	40	32	160	50		5						
	40×200-C32	4	C	40	32	200	50		5						●
	40×250-C32	4	C	40	32	250	60		5						
	40×300-C32	4	C	40	32	300	60		5						
	40×350-C32	4	C	40	32	350	60		5						
	50×200-C32	4	C	50	32	200	60		5						
	50×250-C32	4	C	50	32	250	60		5						
	50×300-C32	4	C	50	32	300	60		5						
	50×350-C32	4	C	50	32	350	60		5						

可配用刀片 Inserts

型號 Cat.NO.	UP20M	NX252	UT20T	F7030	VP15TF	SH8020	SH8250	JC3535	NIT	NAT	UMS	DX25	KT9	H101	H102	KC25	PP30	PC35	刀片形狀 Insert shape	尺寸 Size(mm) D	S	排屑槽	品牌 Brand
RPMW1003MO	●	●	●																	10	3.18	无	MITSUBISHI 三菱
RPMT1003MOE				●	●															10	3.18	有	
RPMW1003MO						●	●													10	3.18	无	HITCHI 日立
RPMW0802MO								●	●	●	●	●	●							8	2.38	无	DIJET 戴杰
RPMW1003MO								●	●	●	●	●	●							10	3.18	无	

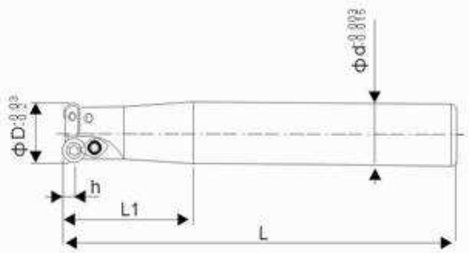
捨弃式刀具 圓鼻立銑刀

EMRW
圓鼻立銑刀
Corner Radius End Mill



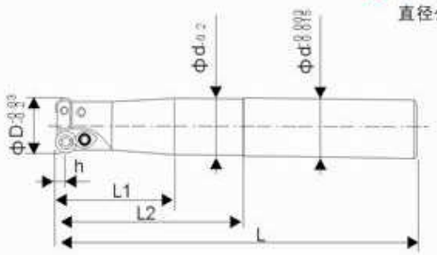
標準配件

刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支

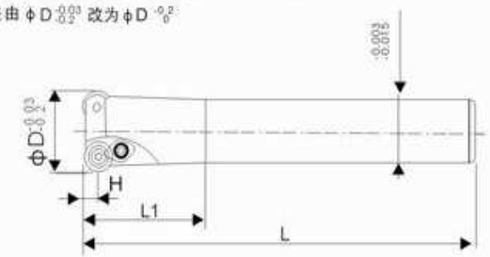


A型
A type

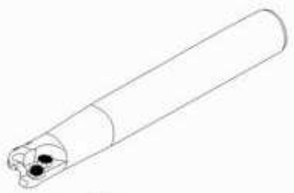
★ 当切削直径 ϕD = 刀片直径 × 2时，
直径公差由 ϕD $^{0.03}_{-0.2}$ 改为 ϕD $^{0}_{-0.2}$



B型
B type

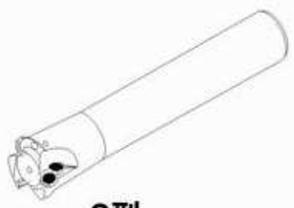


D型
D type



A型
A type

B型
B type



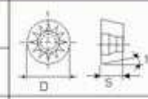
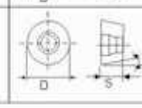
C型
C type

捨弃式刀具 圓鼻立銑刀

UNIT:MM

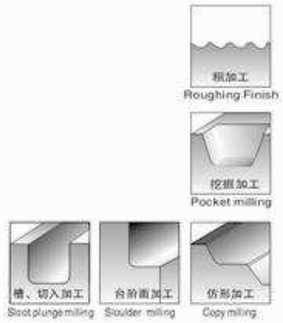
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Applicable Inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
EMRW-4R	12×120	1	A	12	12	120	40		4	RPMW08T2 MOE	Y-4R	M30070-45 M3×7	T8P T8		●
	13×120-C12	1	A	13	12	120	40		4						●
	16×120	2	A	16	16	120	40		4						
	16×120-C15	2	A	16	15	120	40		4						●
	16×160	2	A	16	16	160	40		4						●
	16×160-C15	2	A	16	15	160	40		4						●
	16×160-C15.6	2	A	16	15.6	160	40		4						
	16×180	2	B	16	16	180	40	90	4						
	16×180-C15.6	2	A	16	15.6	180	40		4						
	16×200	2	B	16	16	200	40	100	4						●
	16×200-C15	2	A	16	15	200	50		4						
	16×200-C15.6	2	A	16	15.6	200	50		4						
	17×120-C16	2	A	17	16	120	40		4						
	17×160-C16	2	A	17	16	160	40		4						●
	17×200-C16	2	A	17	16	200	40		4						●
	20×160	2	A	20	20	160	50		4						●
	20×160-C19	2	A	20	19	160	50		4						
	20×180	2	B	20	20	180	50	90	4						
	20×200	2	B	20	20	200	50	100	4						●
	20×200-C19	2	A	20	19	200	50		4						
	21×160-C20	2	A	21	20	160	50		4						●
	21×200-C20	2	A	21	20	200	50		4						
EMRW-6R	32×160-C25	2	C	32	25	160	50		6	RPMW 1204 MO	Y-6R	M40100-60 M4×10	T15P T15		●
	32×160	2	A	32	32	160	50		6						
	32×180-C25	2	C	32	25	180	60		6						
	32×180	2	A	32	32	180	60		6						
	32×200-C25	2	C	32	25	200	60		6						●
	32×200	2	A	32	32	200	80		6						●
	32×250-C25	2	C	32	25	250	60		6						
	32×250	2	A	32	32	250	100		6						
	32×300-C25	2	C	32	25	300	60		6						
	32×300	2	A	32	32	300	100		6						
	35×160-C32	3	C	35	32	160	50		6						●
	35×200-C32	3	C	35	32	200	60		6						●
	35×250-C32	3	C	35	32	250	60		6						●
	35×300-C32	3	C	35	32	300	60		6						●
	35×350-C32	3	C	35	32	350	60		6						
	40×160-C32	3	C	40	32	160	50		6						●
	40×200-C32	3	C	40	32	200	50		6						●
	40×250-C32	3	C	40	32	250	60		6						●
	40×300-C32	3	C	40	32	300	60		6						
	40×350-C32	3	C	40	32	350	60		6						
	50×200-C32	4	C	50	32	200	60		6						
	50×250-C32	4	C	50	32	250	60		6						
	50×300-C32	4	C	50	32	300	60		6						
	50×350-C32	4	C	50	32	350	60		6						

可配用刀片 Inserts

型號 Cat.NO.	F7030	F620	VP15TF	NX4545	UT20T	TN100M	PR510	PR660	PR730	KW10	H101	H102	KC25	PP30	Pc35	刀片形狀 Insert shape	尺寸 Size(mm) D	S	排屑槽	品牌 Brand
RPMT08T2MOE-JS	●	●	●														8	2.78	有	MITSUBISHI 三菱
1204MOE-JS	●		●														12	4.76	有	
RPMT1204MO							●	●	●	●							12	4.76	有	KYOCERA 京瓷
1204MO-H						●	●	●	●	●							12	4.76	有	
RPMW08T2MOE	●			●													8	2.78	无	MITSUBISHI 三菱
08T2MOT			●														8	2.78	无	
1204MOE	●	●		●	●												12	4.76	无	
1204MOT			●														12	4.76	无	

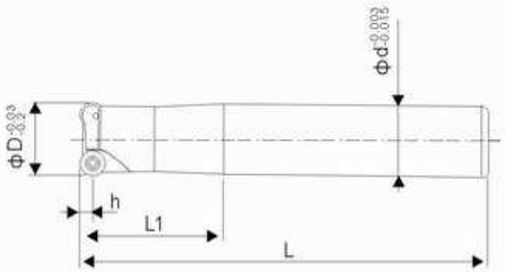
捨弃式刀具 圓鼻立銑刀

R200
圓鼻立銑刀
Corner Rodius End Mill

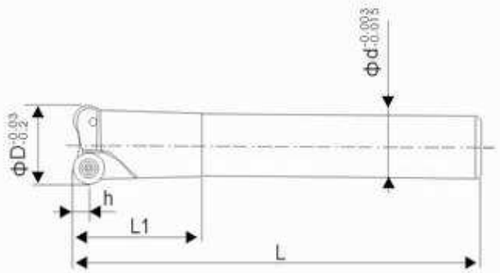


標準配件

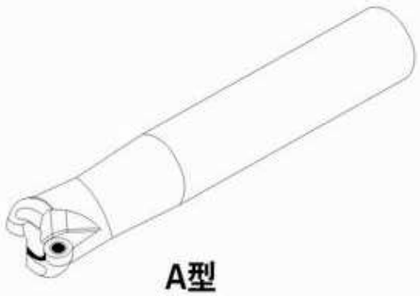
刀片螺絲		1套+2個
旗形扳手		1支



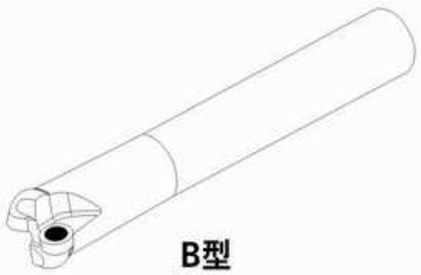
A型
A type



B型
B type



A型
A type



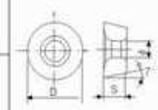
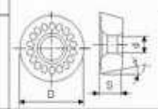
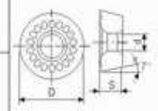
B型
B type

捨弃式刀具 圓鼻立銑刀

UNIT:MM

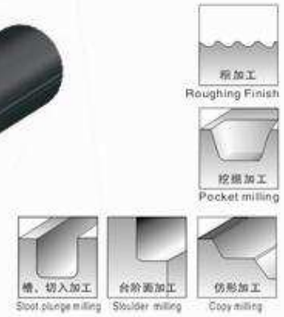
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	L	L1	h	適用刀片 Applicable Inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
R200-5R	20×160	2	A	20	20	160	50	5	RC□T 10T3 MO	M35085-60 M3.5×8.5	T15P T15		
	20×160-C19	2	A	20	19	160	50	5					
	20×200	2	A	20	20	200	50	5					
	21×160-C20	2	A	21	20	160	50	5					
	21×200-C20	2	A	21	20	200	50	5					
	25×160	2	A	25	25	160	50	5					
	25×180	2	A	25	25	180	50	5					
	25×150-C20	2	B	25	20	150	50	5					
	25×160-C20	2	B	25	20	160	50	5					●
	25×160-C24	2	A	25	24	160	50	5					●
	25×200	2	A	25	25	200	75	5					
	25×200-C20	2	B	25	20	200	50	5					
	25×200-C24	2	A	25	24	200	50	5					●
	26×200-C25	2	A	26	25	200	50	5					
R200-6R	32×160-C25	2	B	32	25	160	50	6	RC□T 1204 MO	M35100-60 M3.5×10			●
	32×160	2	A	32	32	160	50	6					
	32×200-C25	2	B	32	25	200	50	6					●
	32×200	2	A	32	32	200	80	6					
	32×250-C25	2	B	32	25	250	60	6					
	32×250	2	A	32	32	250	100	6					
	33×160-C32	2	A	33	32	160	40	6					
	33×200-C32	2	A	33	32	200	40	6					
	33×250-C32	2	A	33	32	250	40	6					
	40×160-C32	3	B	40	32	160	50	6					
	40×200-C32	3	B	40	32	200	50	6					
	40×250-C32	3	B	40	32	250	60	6					
	40×300-C32	3	B	40	32	300	60	6					
	40×350-C32	3	B	40	32	350	60	6					

可配用刀片 Inserts

型號 Cat.NO.	530	1205	2030	2040	3020	3040	4020	4030	4040	H10F	H13A	SM30	H101	H102	KC25	PP30	PC35	刀片形狀 Insert shape	尺寸 Size(mm) D	d	S	品牌 Brand
RCHT10T3MO-PL	●	●																	10	4.0	3.97	SANDVIK 山特維克
10T3MO-KL											●								10	4.0	3.97	
10T3MO-ML			●	●															10	4.0	3.97	
RCHT1204MO-PL	●	●																	12	4.0	4.76	
1204MO-KL											●								12	4.0	4.76	
1204MO-ML			●	●															12	4.0	4.76	
PCKT10T3MO-PM							●	●	●										10	4.0	3.97	SANDVIK 山特維克
10T3MO-KM					●	●													10	4.0	3.97	
10T3MO-WM	●									●		●							10	4.0	3.97	
10T3MO-MM			●	●															10	4.0	3.97	
RCKT1204MO-PM							●	●	●										12	4.0	4.76	
1204MO-KM					●	●													12	4.0	4.76	
1204MO-WM	●									●		●							12	4.0	4.76	
1204MO-MM			●	●															12	4.0	4.76	
RCKT10T3MO-PH							●	●	●										10	4.0	3.97	SANDVIK 山特維克
10T3MO-KH					●	●													10	4.0	3.97	
10T3MO-WH												●							10	4.0	3.97	
RCKT1204MO-PH							●	●	●										12	4.0	4.76	
1204MO-KH					●	●													12	4.0	4.76	
1204MO-WH												●							12	4.0	4.76	

捨弃式刀具 圓鼻立銑刀

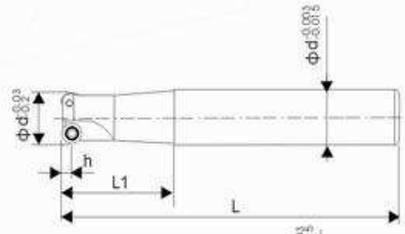
TRS
圓鼻立銑刀
Corner Radius End Mill

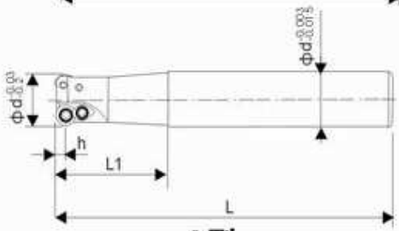


標準配件

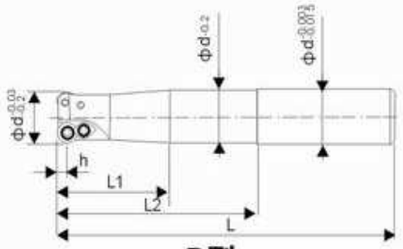
刀片螺絲		1套+2個
壓板螺絲		1套+2個
壓板		1個
旗形扳手		1支

★ 当切削直径 φD = 刀片直径 ×2时，
直径公差由 φD $^{0.03}_{-0.02}$ 改为 φD $^{0}_{-0.2}$

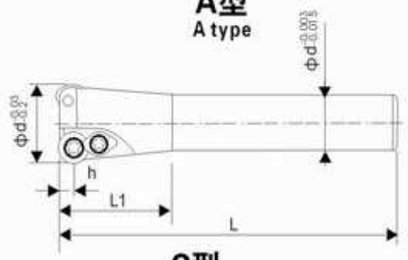




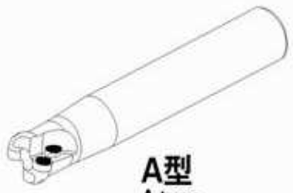
A型
A type



B型
B type



C型
C type



A型
A type

B型
B type

C型
C type

捨弃式刀具 圓鼻立銑刀

UNIT:MM

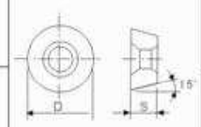
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
TRS-2.5R	8×80	1	A	8	8	80	30		2.5	RDMW 0501 MO		M18040-50 M1.8×4	T6P T6		●
	10×120	2	A	10	10	120	30		2.5						●
	12×120	2	A	12	12	120	30		2.5						●
TRS-3.5R	10×120	1	A	10	10	120	40		3.5	RDMW 0702 MO		M25060-55 M2.5×6	T8P T8		●
	12×120	1	A	12	12	120	40		3.5						●
	16×120	2	A	16	16	120	40		3.5						●
	16×160	2	A	16	16	160	40		3.5						
TRS-4R	12×120	1	A	12	12	120	40		3.5	RDMT 0802 MO	Y-4R	M30070-45 M3×7			●
	12×130	1	A	12	12	130	40		4						
	13×120-C12	1	A	13	12	120	40		4						
	16×120	2	A	16	16	120	40		4						●
	16×120-C15	2	A	16	15	120	40		4						
	16×160	2	A	16	16	160	40		4						●
	16×160-C15	2	A	16	15	160	40		4						
	16×160-C15.6	2	A	16	15.6	160	40		4						●
	16×180	2	B	16	16	180	40	90	4						
	16×180-C15.6	2	A	16	15.6	180	40		4						
	16×200	2	B	16	16	200	40	100	4						
	16×200-C15	2	B	16	15	200	50		4						
	17×120-C16	2	A	17	16	120	40		4						
	17×160-C16	2	A	17	16	160	40		4						
	17×200-C16	2	A	17	16	200	50		4						
	20×160	2	A	20	20	160	50		4						●
	20×160-C19	2	A	20	19	160	50		4						
	20×200	2	B	20	20	200	50	100	4						●
	20×200-C19	2	A	20	19	200	50		4						
	21×160-C20	2	A	21	20	160	50		4						
	21×200-C20	2	A	21	20	200	50		4						
TRS-5R	20×160	2	A	20	20	160	50		5	RDMT 10T3 MO	Y-5R	M40090-50 M4×9 (日立专用) M35100-50 M3.5×10 (压板螺丝)	T15P T15		●
	20×160-C19	2	A	20	19	160	50		5						
	20×200	2	B	20	20	200	50	100	5						
	21×160-C20	2	A	21	20	160	50		5						
	21×200-C20	2	A	21	20	200	50		5						
	25×160	2	A	25	25	160	50		5						●
	25×160-C20	2	C	25	20	160	50		5						
	25×160-C24	2	A	25	24	160	50		5						
	25×200	2	A	25	25	200	75		5						●
	25×200-C20	2	A	25	20	200	50		5						
	25×200-C24	2	A	25	24	200	50		5						●
	25×250-C24	2	A	25	24	250	50		5						
	25×250	2	B	25	25	250	60	110	5						●
	26×160-C25	2	A	26	25	160	50		5						
	26×200-C25	2	A	26	25	200	50		5						
	30×160-C25	2	C	30	25	160	50		5						●
	30×200-C25	2	C	30	25	200	60		5						●
	30×250-C25	2	C	30	25	250	60		5						●
	32×160-C25	3	C	32	25	160	50		5						
	32×160	3	A	32	32	160	50		5						
	32×200-C25	3	C	32	25	200	60		5						
	32×200	3	A	32	32	200	80		5						
	32×250-C25	3	C	32	25	250	60		5						
	32×250	3	A	32	32	250	100		5						
	32×300-C25	3	C	32	25	300	60		5						
	32×300	3	A	32	32	300	100		5						
	32×350	3	A	32	32	350	100		5						
	35×160-C32	3	C	35	32	160	50		5						●
	35×200-C32	3	C	35	32	200	50		5						●
	35×250-C32	3	C	35	32	250	60		5						●
	35×300-C32	3	C	35	32	300	60		5						
	40×160-C32	4	C	40	32	160	50		5						
	40×200-C32	4	C	40	32	200	50		5						
	40×250-C32	4	C	40	32	250	60		5						
	40×300-C32	4	C	40	32	300	60		5						
	40×350-C32	4	C	40	32	350	60		5						
TRS-6R	32×160-C25	2	C	32	25	160	50		6	RDMT 1204 MO	Y-6R	M40100-50 M4×10 (日立专用) M40090-50 M4×9 (压板螺丝)			
	32×160	2	A	32	32	160	50		6						
	32×200-C25	2	C	32	25	200	50		6						
	32×200	2	A	32	32	200	80		6						
	32×250-C25	2	C	32	25	250	60		6						
	32×250	2	A	32	32	250	60		6						
	32×300-C25	2	C	32	25	300	60		6						
	32×300	3	B	32	32	300	60	160	6						
	35×200-C32	3	C	35	32	200	60		6						
	35×250-C32	3	C	35	32	250	60		6						
	35×300-C32	3	C	35	32	300	60		6						

捨弃式刀具 圓鼻立銑刀

UNIT:MM

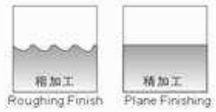
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Circular Cushin	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
TRS-6R	35×350-C32	3	C	35	32	350	60		6	RDMT 1204 MO	Y-6R	M40100-50 M4×10 (日立专用) M40090-50 M4×9 (压板螺丝)	T15P T15		
	40×160-C32	3	C	40	32	160	50		6						
	40×200-C32	3	C	40	32	200	60		6						●
	40×250-C32	3	C	40	32	250	60		6						●
	40×300-C32	3	C	40	32	300	60		6						
	40×350-C32	3	C	40	32	350	60		6						
	50×200-C32	4	C	50	32	200	60		6						
	50×250-C32	4	C	50	32	250	60		6						
	50×300-C32	4	C	50	32	300	60		6						
	50×350-C32	4	C	50	32	350	60		6						
TRS-8R	50×200-C32	3	C	50	32	200	60		8	RDMT 1604 MO	Y-8R	M50120-60 M5×12	T20P T20		
	50×250-C32	3	C	50	32	250	60		8						
	50×300-C32	3	C	50	32	300	60		8						
	50×350-C32	3	C	50	32	350	60		8						

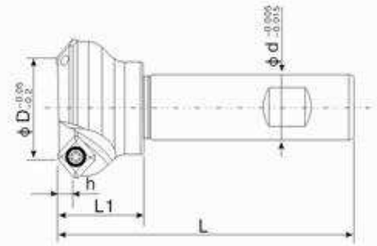
可配用刀片 Inserts

型號 Cat.NO.	CY100H	CY15	CY25	CY150	CY250	GF30	TB6005	TB6020	TB6045	TB6060	PTH08M	WH10	H101	H102	KC25	PP30	PC35	刀片形狀 Insert shape	尺寸 Size(mm) D	S	排屑槽	品牌 Brand
RDMW0501MOEN					●						●								5	1.59	无	HITCHI 日立
RDMW0702MOEN					●						●								7	2.38	无	
RDHW0802MOTN				●	●	●			●	●									8	2.38	无	
10T3MOTN				●	●	●			●										10	3.97	无	
1204MOTN				●	●	●			●										12	4.76	无	
1604MOTN				●	●	●			●										16	4.76	无	
RDMT0802MOTN			●	●	●	●	●	●	●	●									8	2.38	有	
0802MOEN	●											●							8	2.38	有	
10T3MOTN			●	●	●	●	●	●	●	●									10	3.97	有	
10T3MOEN	●											●							10	3.97	有	
1204MOTN					●	●	●	●	●	●									12	4.76	有	
1204MOEN												●							12	4.76	有	

捨弃式刀具 立銑刀

KM 立銑刀 End Mill





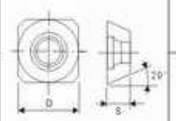
標準配件

刀片螺絲		1套+2個
旗形扳手		1支

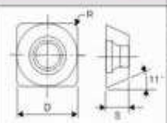
UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	尺寸 Size D	d	L	L1	h	適用刀片 Applicable Inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
KM09	20×120	2	20	20	120		5	SPMW0903□□	M40100-60 M4×10	T15P T15		
	25×150-C20	2	25	20	150		5					
	30×150-C20	3	30	20	150		5					
KM12	32×120-C20	3	32	20	120	35	6	SEEX1204	M50110-38 M5×11	T20P T20		●
	32×120-C25	3	32	25	120	35	6					●
	40×120-C20	3	40	20	120	35	6					●
	40×120-C25	3	40	25	120	35	6					●
	40×120-C32	3	40	32	120	35	6					●

可配用刀片 Inserts

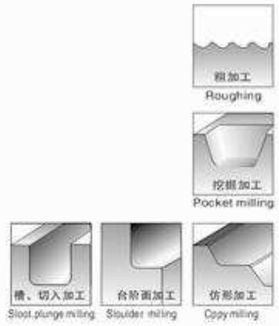
型号 Cat.NO.	WAP25	WAP35	WTP35	WXP45	WPM	WXM35	WAK15	WAK25	WKM	WK10	NCM325	PC3525	PC9530	PC6510	PC230	CN30	H01	刀片形狀 Insert shape	尺寸 Size(mm) D	S	排屑槽	品牌 Brand
SEHI1204AFN		●	●	●		●				●									12.7	4.76	有	WALTER 瓦雨特
1204AFN-K88										●									12.7	4.76	有	
SEHW1204AFN	●	●	●		●	●	●	●	●										12.7	4.76	无	
SECA1204AFSN											●	●							12.7	4.76	无	KORLOY
1204AFTN													●		●	●			12.7	4.76	无	
1204AFFN														●					12.7	4.76	无	
1204AFEN											●								12.7	4.76	无	
SEHI1204AFFN-M																	●		12.7	4.76	无	

可配用刀片 Inserts

型号 Cat.NO.	F620	UP20M	NX2525	NX4545	UTi20T	HTi10	刀片形狀 Insert shape	尺寸 Size(mm) D	S	R	排屑槽	品牌 Brand
SPMW090304		●	●	●	●	●		9.525	3.18	0.4	无	MTS(BISHII 興)
090308		●	●	●	●	●		9.525	3.18	0.8	无	

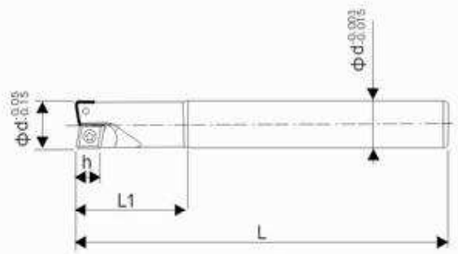
捨弃式刀具 鑽銑刀

TJU
鑽銑刀
Borer mill

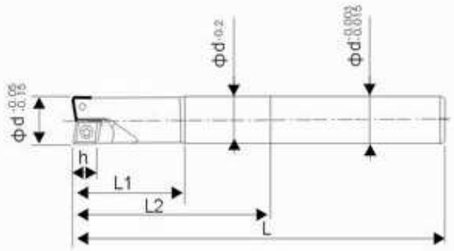


標準配件

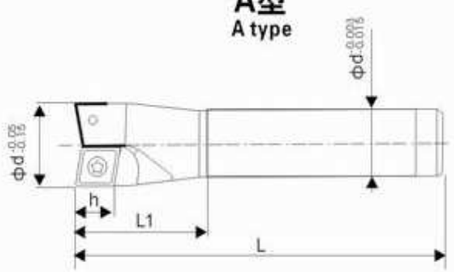
刀片螺絲		1套+2個
旗形扳手		1支



A型
A type



B型
B type



C型
C type

A型
A type

B型
B type

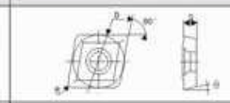
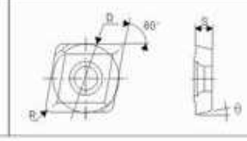
C型
C type

捨弃式刀具 鑽銑刀

UNIT:MM

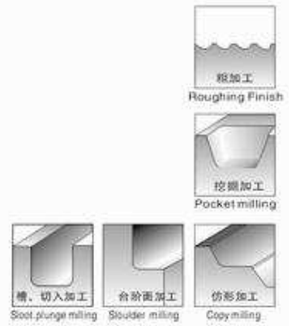
型號 Cat.NO.	規格 Spec	刃數 No of flutes	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Applicable Inserts		螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
TJU	10×120	1	A	10	10	120	30		6	CCMT060204		M25060-55 M2.5×6	T8P T8		●
	10×130	1	A	10	10	130	30		6						
	11×120-C10	1	A	11	10	120	30		6						
	12×120	1	A	12	12	120	40		6	—	CPMT080204Z				●
	12×130	1	A	12	12	130	40		6						
	13×120-C12	1	A	13	12	120	40		6						●
	13×130-C12	1	A	13	12	130	40		6						
	16×120	2	A	16	16	120	40		6	CCMT060204	CPMT080204Z	M25060-55 M2.5×6			●
	16×160	2	A	16	16	160	40		6						●
	16×180	2	B	16	16	180	40	90	6						●
	16×160-C15	2	A	16	15	160	40		6						
	16×200	2	B	16	16	200	40	100	6						●
	17×160-C16	2	A	17	16	160	40		6						●
	17×180-C16	2	A	17	16	180	40		6						
	17×200-C16	2	A	17	16	200	40		6						●
	20×120	2	A	20	20	120	40		6	CCMT060204	CPMT090204Z	M25060-55/M35080-50 M2.5×6/M3.5×8	T8P/T15P T8/T15		●
	20×160	2	A	20	20	160	50		6						●
	20×200	2	B	20	20	200	50	100	6						●
	21×160-C20	2	A	21	20	160	40		6						●
	21×200-C20	2	A	21	20	200	50		6						●
	25×160	2	A	25	25	160	50		9	CPMT090308	CPMT120308Z	M40090-50 M4×9	T15P T15		●
	25×200	2	A	25	25	200	75		9						●
	25×250	2	B	25	25	250	60	110	9						●
	26×160-C25	2	A	26	25	160	50		9						
	26×200-C25	2	A	26	25	200	60		9						●
	26×250-C25	2	A	26	25	250	60		9						
	32×160	2	A	32	32	160	60		12	CPMT120408	CPMT160408Z	M50120-60 M5×12	T20P T20		●
	32×200	2	A	32	32	200	80		12						●
	32×250	2	A	32	32	250	115		12						●
	32×300	2	B	32	32	300	60	160	12						●
	32×350	2	B	32	32	350	60	160	12						
	33×160-C32	2	A	33	32	160	50		12						●
	33×200-C32	2	A	33	32	200	60		12						
	33×250-C32	2	A	33	32	250	80		12						●
	33×300-C32	2	A	33	32	300	80		12						
	33×350-C32	2	A	33	32	350	80		12						
	40×200-C32	2	C	40	32	200	60		12	CPMT160408	CPMT190408Z	M60120-60 M6×12 M50120-60 M5×12	T20P/T30P T20/T30		●
	40×250-C32	2	C	40	32	250	80		12						●
	40×300-C32	2	C	40	32	300	80		12						
	40×350-C32	2	C	40	32	350	80		12						

可配用刀片 Inserts

型號 Cat.NO.	CY250	HT844	GX30	EX40	WH10	WH20	刀片形狀 Insert shape	尺寸 Size(mm) D	S	θ	R	品牌
CCMT060204	●	●		●	●			6.35	2.38	7	0.4	HTACHI(日立)
CPMT090308	●	●		●	●	●		9.525	3.18	11	0.8	
120408	●	●	●	●	●			12.7	4.76	11	0.8	
120403	●							12.7	4.76	11	3.0	
CPMT080204Z	●	●		●	●			7.94	2.38	11	0.4	
090204Z	●	●		●	●			9.525	2.38	11	0.4	
120308Z	●							12.7	3.18	11	0.8	
160408Z	●	●		●	●			15.875	4.76	11	0.8	
160408Z	●							15.875	4.76	11	3.0	
190408Z	●							19.05	4.76	11	0.8	

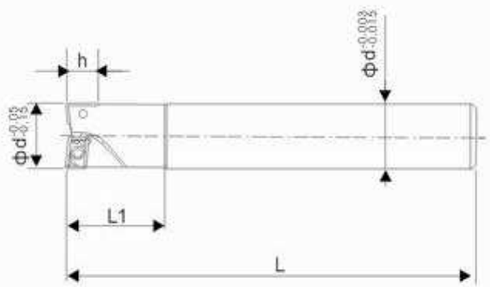
捨弃式刀具 鑽銑刀

ASJ-2P
鑽銑刀
Drillng And Mlling Cutter

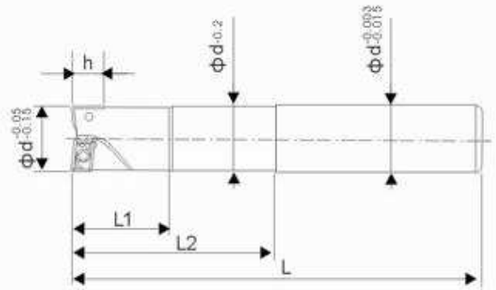


標準配件

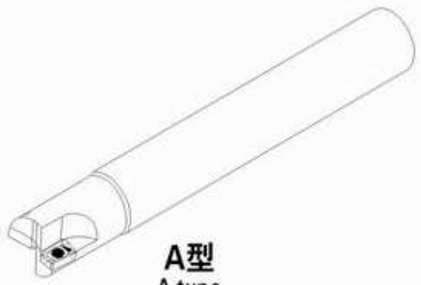
刀片螺絲		1套+2個
旗形扳手		1支



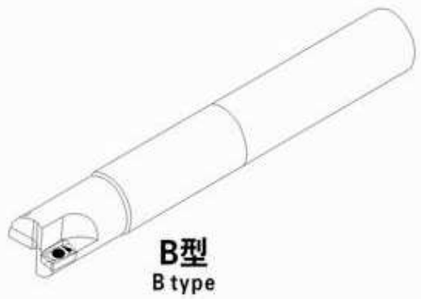
A型
A type



B型
B type



A型
A type



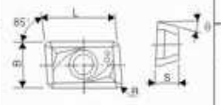
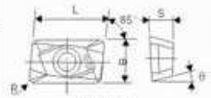
B型
B type

捨弃式刀具 鑽銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No. of flutes	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Applicable inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
ASJ	16×120	2	A	16	16	120	33		9	ADMT080308L APMT090208R	M25060-55/M20050-60 M2.5×6/M2×5	T8P/T6P T8/T6		
	16×160	2	A	16	16	160	40		9					
	16×200	2	B	16	16	200	40	100	9					
	17×120-C16	2	A	17	16	120	33		9					
	17×160-C16	2	A	17	16	160	40		9					●
	17×200-C16	2	A	17	16	200	40		9					
	20×120	2	A	20	20	120	40		10	ADMT1003□□L ACMT1003□□R	M25065-55 M2.5×6.5	T8P T8		
	20×160	2	A	20	20	160	50		10					
	20×200	2	B	20	20	200	50	100	10					
	21×120-C20	2	A	21	20	120	35		10					
	21×160-C20	2	A	21	20	160	35		10					●
	21×200-C20	2	A	21	20	200	35		10					●
	25×160	2	A	25	25	160	50		13	ADMT12T3□□L APMT12T3□□R	M30075-55 M3×7.5	T10P T10		●
	25×200	2	A	25	25	200	75		13					
	25×250	2	B	25	25	250	60	110	13					
	26×160-C25	2	A	26	25	160	50		13					●
	26×200-C25	2	A	26	25	200	50		13					●
	26×250-C25	2	A	26	25	250	50		13					●
	26×300-C25	2	A	26	25	300	50		13					
	32×160	2	A	32	32	160	50		15.5	APMT1604□□L APMT1504□□R	M40090-55 M4×9	T15P T15		
	32×200	2	A	32	32	200	80		15.5					
	32×250	2	A	32	32	250	115		15.5					
	32×300	2	A	32	32	300	120		15.5					
	33×160-C32	2	A	33	32	160	50		15.5					
	33×200-C32	2	A	33	32	200	50		15.5					
	33×250-C32	2	A	33	32	250	50		15.5					
	33×300-C32	2	A	33	32	300	50		15.5					

可配用刀片 Inserts

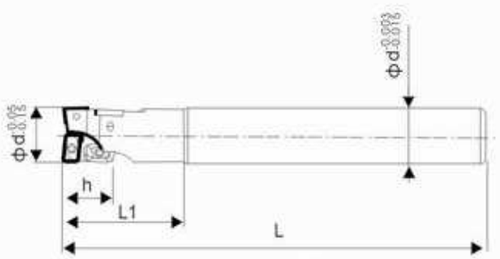
型號 Cat.NO.	對應刃徑 Flute diameter	CY250	GF30	CY100H	刀片形狀 Insert shape	尺寸 Size(mm) L	B	S	θ	R	品牌 Brand
ADMT080308L	16	●	●	●	 底刃	7.8	6.2	3.0	15	0.8	HTACHI(日本)
100308L	20	●	●	●		10.4	6.35	3.18	15	0.8	
100320L	20	●	●	●		10.4	6.35	3.18	15	2.0	
12T308L	25	●	●	●		12.6	7.93	3.9	15	0.8	
12T320L	25	●	●	●		12.6	7.93	3.9	15	2.0	
12T330L	25	●	●	●		12.6	7.93	3.9	15	3.0	
APMT160408L	32	●	●	●		16.45	9.53	4.76	11	0.8	
160430L	32	●	●	●		16.45	9.53	4.76	11	3.0	
170408L	35	●	●	●		17.6	9.53	4.76	11	0.8	
170430L	35	●	●	●		17.6	9.53	4.76	11	3.0	
190508L	40	●	●	●		19.6	10	5.0	11	0.8	
190530L	40	●	●	●		19.6	10	5.0	11	3.0	
250508L	50	●	●	●		25.4	11	5.5	11	0.8	
250530L	50	●	●	●		25.4	11	5.5	11	3.0	
APMT090208R	16	●	●	●	 外周刃	9.1	5.1	2.6	11	0.8	
ACMT100308R	20	●	●	●		10.1	6.35	3.4	7	0.8	
100320R	20	●	●	●		10.1	6.35	3.4	7	2.0	
APMT12T308R	25	●	●	●		13.14	7.93	3.9	11	0.8	
12T320R	25	●	●	●		13.14	7.93	3.9	11	2.0	
12T330R	25	●	●	●		13.14	7.93	3.9	11	3.0	
150408R	25	●	●	●		15.88	9.53	4.76	11	0.8	
150430R	32-25	●	●	●		15.88	9.53	4.76	11	3.0	

捨弃式刀具 鑽銑刀

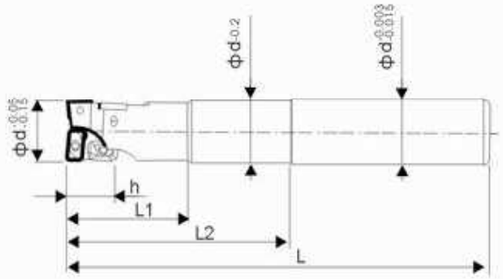
ASJ-4P
钻铣刀
Drilng And Mlling Cutter

标准配件

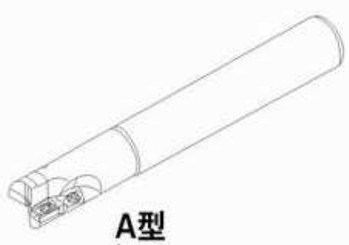
刀片螺丝		1套+2个
旗形扳手		1支



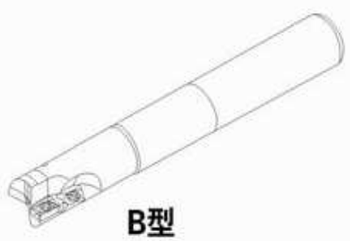
A型
A type



B型
B type



A型
A type



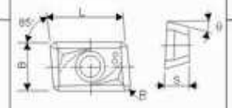
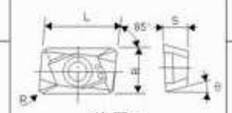
B型
B type

捨弃式刀具 鑽銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	L	L1	L2	h	適用刀片 Applicable inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
ASJ-4P	16×120	4	A	16	16	120	40		16	ADMT080308L APMT090208R	M25060-55/M20050-60 M2.5×6/M2×5	T8P/T6P T8/T6		
	16×160	4	A	16	16	160	40		16					
	16×200	4	B	16	16	200	40	100	16					
	17×120-C16	4	A	17	16	120	40		16					
	17×160-C16	4	A	17	16	160	40		16					
	17×200-C16	4	A	17	16	200	40		16					
	20×120	4	A	20	20	120	40		20	ADMT1003□□L ACMT1003□□R	M25065-55 M2.5×6.5	T8P T8		
	20×160	4	A	20	20	160	50		20					
	20×200	4	B	20	20	200	50	100	20					
	21×120-C20	4	A	21	20	120	35		20					
	21×160-C20	4	A	21	20	160	35		20					
	21×200-C20	4	A	21	20	200	35		20					
	25×160	4	A	25	25	160	50		25	ADMT12T3□□L APMT12T3□□R	M30075-55 M3×7.5	T10P T10		
	25×200	4	A	25	25	200	75		25					
	25×250	4	B	25	25	250	60	110	25					
	26×160-C25	4	A	26	25	160	50		25					
	26×200-C25	4	A	26	25	200	50		25					
	26×250-C25	4	A	26	25	250	50		25					
	26×300-C25	4	A	26	25	300	50		25					
	32×160	4	A	32	32	160	50		32	APMT1604□□L APMT1504□□R	M40090-55 M4×9	T15P T15		
	32×200	4	A	32	32	200	80		32					
	32×250	4	A	32	32	250	115		32					
	32×300	4	A	32	32	300	120		32					
	33×160-C32	4	A	33	32	160	60		32					
	33×200-C32	4	A	33	32	200	60		32					
	33×250-C32	4	A	33	32	250	60		32					
	33×300-C32	4	A	33	32	300	60		32					

可配用刀片 Inserts

型號 Cat.NO.	對應刃徑 Flute diameter	CY250	GF30	CY100H	刀片形狀 Insert shape	尺寸 Size(mm) L	B	S	θ	R	品牌 Brand
ADMT080308L	16	●	●	●	 底刃	7.8	6.2	3.0	15	0.8	HTACHI(日立)
100308L	20	●	●	●		10.4	6.35	3.18	15	0.8	
100320L	20	●	●	●		10.4	6.35	3.18	15	2.0	
12T308L	25	●	●	●		12.6	7.93	3.9	15	0.8	
12T320L	25	●	●	●		12.6	7.93	3.9	15	2.0	
12T330L	25	●	●	●		12.6	7.93	3.9	15	3.0	
APMT160408L	32	●	●	●		16.45	9.53	4.76	11	0.8	
160430L	32	●	●	●		16.45	9.53	4.76	11	3.0	
170408L	35	●	●	●		17.6	9.53	4.76	11	0.8	
170430L	35	●	●	●		17.6	9.53	4.76	11	3.0	
190508L	40	●	●	●		19.6	10	5.0	11	0.8	
190530L	40	●	●	●		19.6	10	5.0	11	3.0	
250508L	50	●	●	●		25.4	11	5.5	11	0.8	
250530L	50	●	●	●		25.4	11	5.5	11	3.0	
APMT090208R	16	●	●	●	 外周刃	9.1	5.1	2.6	11	0.8	
ACMT100308R	20	●	●	●		10.1	6.35	3.4	7	0.8	
100320R	20	●	●	●		10.1	6.35	3.4	7	2.0	
APMT12T308R	25	●	●	●		13.14	7.93	3.9	11	0.8	
12T320R	25	●	●	●		13.14	7.93	3.9	11	2.0	
12T330R	25	●	●	●		13.14	7.93	3.9	11	3.0	
150408R	25	●	●	●		15.88	9.53	4.76	11	0.8	
150430R	32-25	●	●	●		15.88	9.53	4.76	11	3.0	

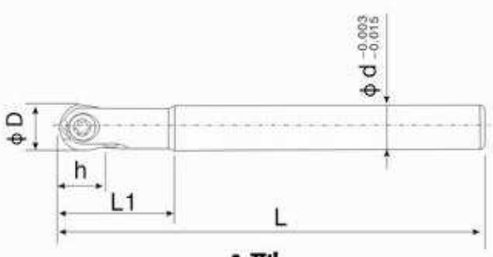
捨弃式刀具 球形精銑刀

T2139
球形精銑刀
Precision Ball End Mill

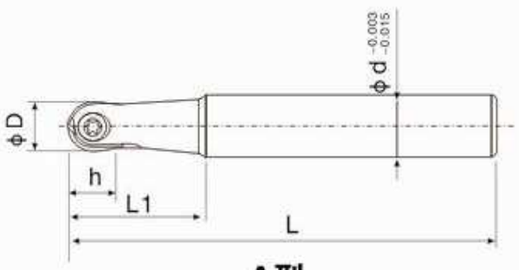
仿形加工
Copy milling

標準配件

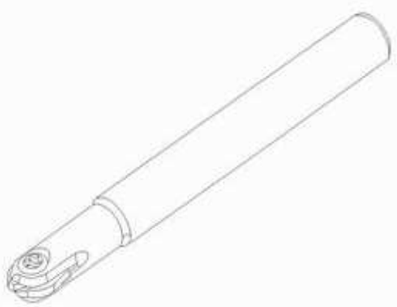
刀片螺絲		1套
旗形扳手		1支



A型
A type



A型
A type



A型
A type

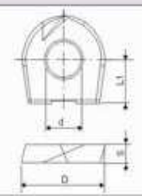
B型
B type

捨弃式刀具 球形精銑刀

UNIT:MM

型號 Cat.NO.	規格 Spec	刃數 No.of flutes	樣式 Manner	尺寸 Size D	d	L	L1	h	適用刀片 Applicable inserts	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
T2139-4R	110-C8	1	B	8	8	110	25	5	P320□-D08	M30070-60-4R	T8P T8		●
	110-C10	1	B	8	10	110	25	5					●
	140-C12	1	B	8	12	140	55	5					●
T2139-5R	130-C10	1	A	10	10	130	30	7	P320□-D 10	M40090-60-5R	T15P T15		●
	130-C12	1	A	10	12	130	30	7					●
	160-C10	1	A	10	10	160	30	7					●
	160-C12	1	B	10	12	160	30	7					●
T2139-6R	130-C12	1	A	12	12	130	32	8	P320□-D 12	M50090-60-6R	T20P T20		●
	160-C12	1	A	12	12	160	32	8					●
	160-C16	1	B	12	16	160	60	8					●
T2139-8R	160-C16	1	A	16	16	160	65	10	P320□-D16	M50130-60-8R			●
	200-C16	1	A	16	16	200	65	10					●
	200-C20	1	B	16	20	200	65	10					●
T2139-10R	160-C20	1	A	20	20	160	45	12.5	P320□-D 20	M50165-60-10R			●
	200-C20	1	A	20	20	200	76	12.5					●
	250-C25	1	B	20	25	250	120	12.5					●
T2139-12.5R	160-C25	1	A	25	25	160	45	15	P320□-D 25	M60210-60-12.5R	T30P T30		
	200-C25	1	A	25	25	200	76	15					●
	200-C32	1	B	25	32	200	98	15					
	250-C32	1	B	25	32	250	120	15					
T2139-15R	200-C32	1	B	30	32	200	80	18	P320□-D 30	M80250-60-15R/16R			
	250-C40	1	B	30	40	250	120	18					
T2139-16R	200-C32	1	A	32	32	200	80	19	P320□-D 32				
	250-C40	1	B	32	40	250	120	19					

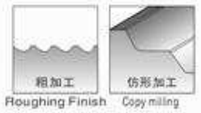
可配用刀片 Inserts

型號 Cat.NO.	WTA61	WAP25	WAP35	WXM35	WAK15	Nx2525	WXH15	WCB50	WCB80	刀片形狀 Insert shape	尺寸 Size(mm) D	d	L1	S	品牌 Brand
P320□-D08	●	●	●	●	●	●	●	●	●		8	3	4	2.0	瓦尔特
-D10	●	●	●	●	●	●	●	●	●		10	4	5	2.5	
-D12	●	●	●	●	●	●	●	●	●		12	5	6	2.5	
-D16	●	●	●	●	●	●	●	●	●		16	5	6	3.0	
-D20	●	●	●	●	●	●	●	●	●		20	5	6	3.0	
-D25	●	●	●	●	●	●	●				25	6	9	4.0	
-D30	●	●	●	●	●		●				30	8	10	5.0	
-D32	●	●	●	●	●		●				32	8	10	5.0	

捨弃式刀具

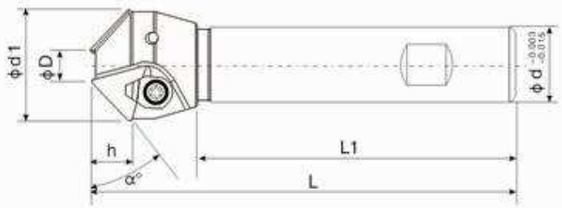
倒角刀

CPC
倒角刀
Chamfer End Mill



標準配件

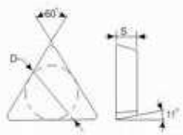
螺絲		1套+2個
壓板		1個
旗形扳手		1支



UNIT:MM

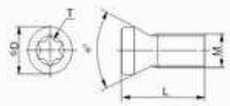
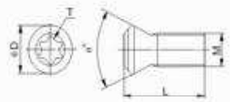
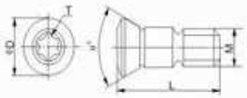
型號 Cat.NO.	規格 Spec	刃數 No.of flutes	尺寸 Size α°	D	d1	d	L	h	L1	適用刀片 Applicable inserts	壓板 Clamp piece	螺釘 Clamp Screw	扳手 Wrench	價格 Price	庫存 Stock
CPC05	45X120-C16	1	45	5	18.5	16	120	7	95	TPMT110204		M25060-55 M2.5x6	T8P/T8		
CPC10	30X120-C20	2	30	10	34.4	20	120	7	90	TP□N160300(□□)	YM4	M40100-60 M4x10	T15P T15		●
	30X120-C25	2	30	10	34.4	25	120	7	90						●
	45X120-C20	1	45	10	29.7	20	120	10	90						●
	45X120-C25	1	45	10	29.7	25	120	10	90						
	60X120-C20	1	60	10	23.5	20	120	12	90						
	60X120-C25	1	60	10	23.5	25	120	12	90						●
CPC20	45X160-C20	2	45	20	47.1	20	160	14	120	TPMN22040(□□)	YS-20	M50110-38 M5x11	T20P T20		
	45X160-C25	2	45	20	47.1	25	160	14	120						●
	60X160-C25	1	60	20	33.8	25	160	12	120	TP□N160300(□□)	YM4	M40100-60 M4x10	T15P/T15		

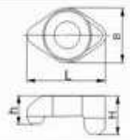
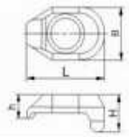
可配用刀片Inserts

型號 Cat.NO.	CY100H	CY15	CY25	HC844	CH550	EX35	EX40	WH10	PJ20	PP20	刀片形狀 Insert shape	尺寸 Size(mm) D	S	品牌 Brand
TPMT110204				●	●	●		●				6.35	2.38	HITACHI(日立)
TPGN160308					●									
TPMN160304					●	●		●				9.525	3.18	
TPMN160308		●	●	●	●	●	●	●						
TPMN160304TN					●									
TPMN160308TN					●	●								
TPMN220404					●	●								
TPMN220408	●			●	●	●		●						
TPMN220408Y			●											
TPMN220412	●				●	●		●				12.7	4.76	
TPMN220404TN					●									
TPMN220408TN					●	●								
TPMN220412TN					●									

捨弃式刀具

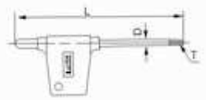
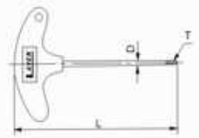
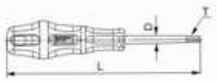
銑刀杆配件表 Millmatingpsrts

形狀 Shape	型號 Cat.No	尺寸 Size M	ΦD	L	0°	T
	M18040-50	M1.8	2.5	4	50	T6
	M20050-60	M2	3.2	5	60	T6
	M25060-55	M2.5	3.5	6	55	T8
	M25065-55	M2.5	3.5	6.5	55	T8
	M30075-55	M3	4.2	7.5	55	T10
	M35085-60	M3.5	5.3	8.5	60	T15
	M35100-60	M3.5	5.3	10	60	T15
	M40090-50	M4	5	9	50	T15
	M30070-45	M3	4	7	45	T8
	M30070-55	M3	4.3	7	55	T10
	M35080-50	M3.5	5.1	8	50	T15
	M35100-50	M3.5	5.4	10	50	T15
	M40090-55	M4	5.8	9	55	T15
	M40100-60	M4	5.8	10	60	T15
	M50110-38	M5	6.6	11	38	T20
	M50115-60	M5	7	11.5	60	T20
	M50120-60	M5	7.4	12	60	T20
	M30070-60-4R	M3	4.2	7	60	T8
	M40090-60-5R	M4	5.7	9	60	T15
	M50090-60-6R	M5	6.7	9	60	T20
	M50130-60-8R	M5	7.4	13	60	T20
	M50165-60-10R	M5	8	16.5	60	T20
	M60210-60-12.5R	M6	11	21	60	T30
	M80250-60-15R/16R	M8	12.8	25	60	T30

形狀 Shape	型號 Cat.No	尺寸 Size B	L	H	h
	Y-4R	6	9.1	4.8	3.3
	Y-5R	7.5	10	5.8	4.5
	Y-6R	8.5	12.65	6.0	4.5
	Y-8R	9.8	15	6.45	5.3
	YM-4	9	13.4	5.65	3.4
	YM-5	10.2	15.15	8	4.6
	YS-15	7.5	11.6	5.3	3.4
	YS-20	9.43	18.1	8.2	5.8

捨弃式刀具

銑刀杆配件表 Millmatingpsrts

形狀 Shape	型號 Cat.No	尺寸 ΦD	L	Size T
	T6P	2.5	75	T6
	T7P	2.5	75	T7
	T8P	3	85	T8
	T9P	3	85	T9
	T10P	3	85	T10
	T15P	4	90	T15
	T20P	4	90	T20
	T15T	5	120	T15
	T20T	5	120	T20
	T25T	5	120	T25
	T6I	2.5	115	T6
	T7I	2.5	115	T7
	T8I	3	160	T8
	T9I	3	160	T9
	T10I	3	160	T10
	T15I	5	180	T15
	T20I	5	180	T20
	T25I	5	190	T25
	T30I	6	200	T30

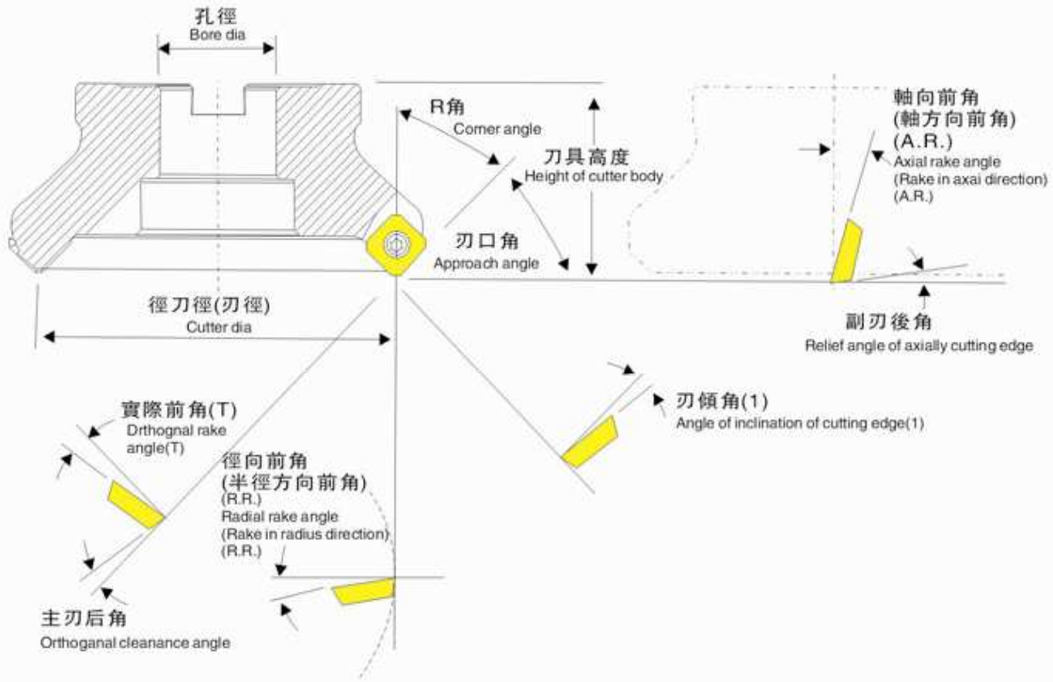
捨弃式刀具

銑削刀具各部分的名稱和刃尖角度的作用

Names of parts and roles for milling tools

銑削刀具各部分的名稱

Names of parts ofmilling tool body



實際前角和切削性能

Relation between Orthognal Rake and Performance

實際前角 True rake	鋒利度 Sharpness	切削動力 Cutting power	刃尖强度 Toughness of cutting edge	發熱 Heating	切屑排出性能 Chips ejectability	耐熔着性 Wdling resisstance
正(大) Positive(large)	好 Good	小 Small	弱 Weark	少 Low	差,有卷入刀具内的傾向. Bad.May be caught by cutter.	好 Good
負(小) Negative(small)	差 Bad	大 Large	强 Strong	多 High	好,切屑排出刀具外. Good.Ejected outside the cutter.	差 Bad

實際前角基本上由裝在刀具上的刀片的後角决定,刀片的後角越大,實際前角也越大.

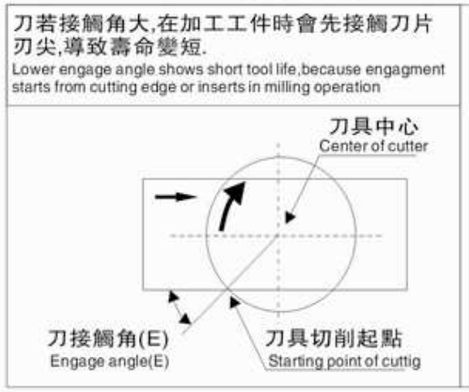
Effective rake angle is generally designed according toclerance If inserts used .The larger the clerance of an inserts is,the largr effective rake angle may be designed.

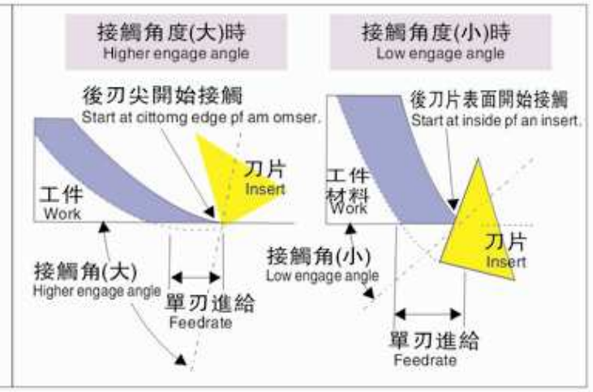
捨弃式刀具

刀徑和接觸角

Cutter dia.and engage angle

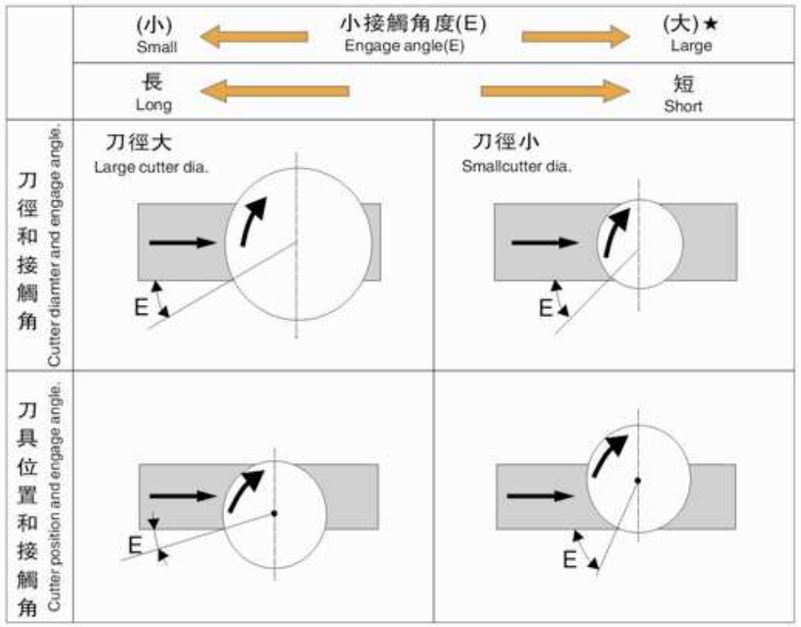
刀若接觸角大,在加工工件時會先接觸刀片刃尖,導致壽命變短.
Lower engage angle shows short tool life,because engagment starts from cutting edge or inserts in milling operation

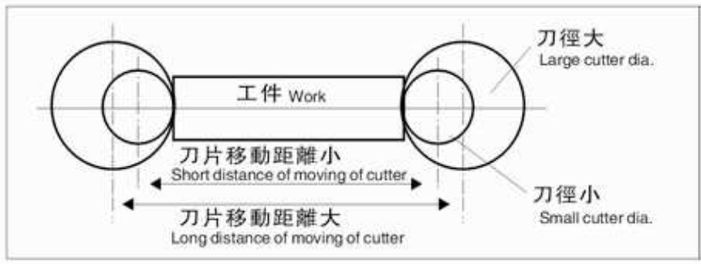




★刀徑比工件的寬度大30~50%左右可獲得好的結果.

Cutter bodies are recommend with diameter 30~50% biger than width of work pieces.





刀徑過大,刀具從接觸工作到離開工件的距離變大,效率降低.
Cutter with too large diamter shows lower machining efficiency,bacause talking cutter path longer.

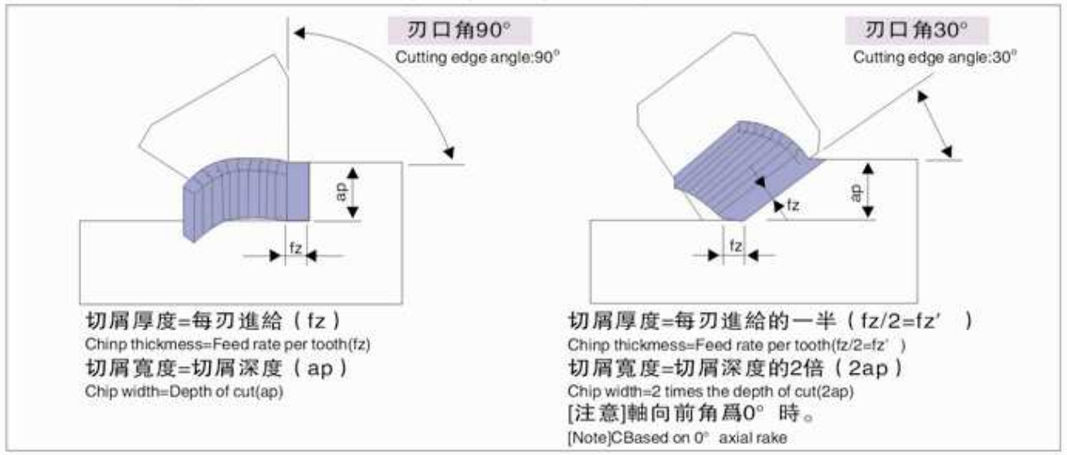
捨弃式刀具

銑削刀具各部分的名稱和刃尖角度的作用

Names of parts and roles for milling tools

刃口角和切削性能

Relation ship between cutting edge angle and performance.



切屑厚度=每刃進給（fz）
Chinp thickmess=Feed rate per tooth(fz)
切屑寬度=切屑深度（ap）
Chip width=Depth of cut(ap)

切屑厚度=每刃進給的一半（fz/2=fz'）
Chinp thickmess=Feed rate per tooth(fz/2=fz')
切屑寬度=切屑深度的2倍（2ap）
Chip width=2 times the depth of cut(2ap)
[注意]軸向前角爲0° 時。
[Note]CBased on 0° axial rake

刃口角和切削性能的變化

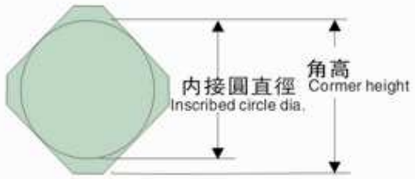
Relation ship between cutting edge angle and performance.

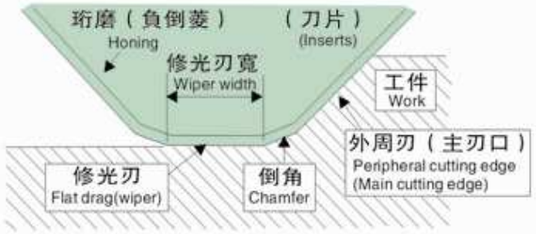
切削性能因素 Chutting performance facor	刃口角 Cutting edge angle				
	90°	75°	65°	45°	30°
切削形狀 Chips shape	厚而窄 Thick and narrow				薄而寬 Thin and broadl
★切屑厚度比較 Camparison of chips thickness	1	0.97	0.91	0.71	0.5
切削動力 Cutting power	小 Small	（取决于接觸工件的刃口長度） Depends on the cutting edge length that contacts.			大 Large
刀片摩擦程度 Inserts abrasion	高 Hight	（取决于刃口單位長度的切削厚度） Depends on chips thickness per unit length of cutting edge			低 Low
顫動 Vibration	不易產生 Not likey	（取决于刃口長度决定的吃刀量的差异） Depends on bite per unit length of cutting edge			易产生 Likely
有效切削深度 Effiective depth of cut	大 Large	（刀片塌陷的差异） Inserts falling difference			小 Small
振動 Vibration	易產生 Likely	（作用在主軸上的側向載荷的差异） Differrence in the load that is applied transvevsely against the spindle.			不易產生 Not likey
工件上的向下壓力 Work pressurizing force	小 Small	（加工薄板時，若刃口角小則會導致工作顫動） For thin plate,small cut-in angle causes work to chatter			小 Small
切屑排出 Chips flow	差 No good	（側向卷入） Caught horizontally	（向上排出） Ejected upward.		好 good

★假设刃口角为90° 时的切屑厚度为1时，相同进给速度下的切屑厚度比较。
★Comparison of chip thicknexx in vaious angles at a fixed feed rate(jf90° =1thick)

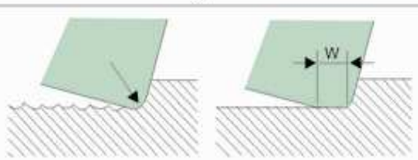
捨弃式刀具

銑削用刀片各部分的名稱和作用
Names of parts and roles milling inesrts



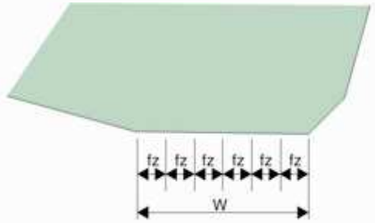


修光刃的作用　修光刃是精加工專用刀
Role of flat drag　The flat drag is a dedicated finishing cutter.



用R角刀片進行切削時，會產生鋸齒狀的進刀痕，而使用帶修光刃的刀片可加工出平滑的加工面。

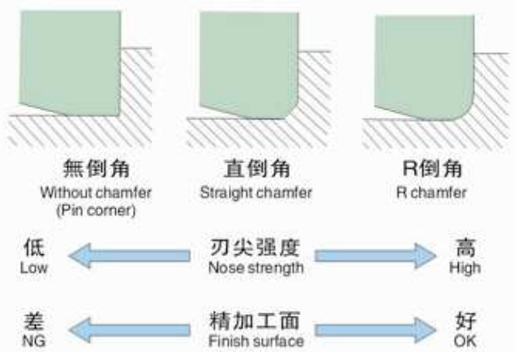
Set the width of flat drag(W)to the same or more size of feeding amount per rotatiom of the cutter.
E.g.
If cut with a corner R insert,cut surface is marked in wave form.But with a insert with a wiper,finish surface is flat.



用將修光刃的寬度（W）設定爲大于刀具每轉進給。
例如：
設刃數爲6，第刃進給爲fz,則有：W≥fzX6
這是由于根據刀片或刀具的精度安裝的刀片即使在高度上有一些差异，但衹需靠突出刀片的修光刃，就能加工出平坦的表面。
通常，修光刃的寬度設定爲1.1~2.0mm。

Set the width of flat drag(W)to the same or more size of feeding amount per rotatiom of the cutter.
E.g.
If cut feed per cutter of 6 flutes is fz,the proper width can be calculated asW≥fzX6
Even if the height of several inserts,each of which was reset according to the insert or flat finish surface.
Generally set the widet of a flat drag to 1.2 to2.0mm.

倒角的作用　倒角可具有防止刀片缺損和提高精加工面質量的效果。
Role of chamfer　Chamfering is made to protect the surface from chipping and also to minish the surface well.



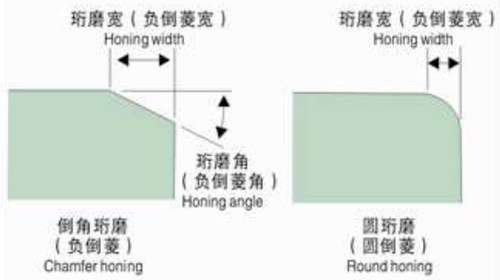
外周刃和修光刃的中間有被稱之爲倒角的副刃。
在直型中設定寬度0.5~1.0mm。
在R型中設定的R0.8~R1.2。

Set the an auxiliary cutting edge called chamfer between peripheral cutting edge and flat drag.
Set0.5to1.0mm width for straight type.
Set R 0.8 to R 1.2 for R type.

捨弃式刀具

銑削用刀片各部分的名稱和作用
Names of parts and roles for milling inserts

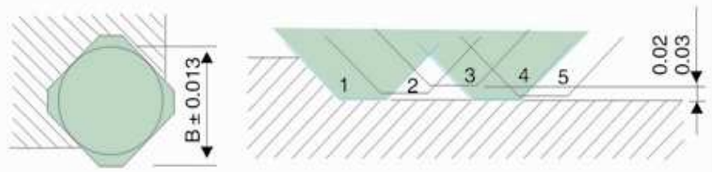
珩磨的作用　珩磨能提高刃尖的强度
Role of honing　By honing,xttenght of cutting edge is increased.



圆刃尖珩磨(负倒菱)分为倒角珩磨(角倒菱)和圆周珩磨(圆倒菱),在銑削用刀片中主要使用倒角珩磨(负倒菱)。
珩磨（角倒菱）角为15~25°，珩磨宽（负倒菱宽）为每刃进给的一半即0.1mm~0.2mm，但精加工用修光刃为0.3~0.1mm。
另外，用于铝及铸铁等容易熔着的工件材料的刀具通常不进行珩磨（负倒菱）。

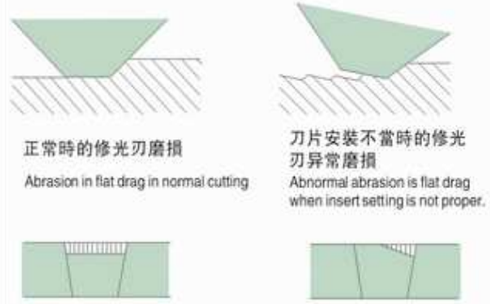
Nose honing can be divided into chamfer honing and round honing.
For milling insert,chamfer honing is mainly used.
A proper honing angle is 15 to 25° honing width is 0.1to 0.2mm that is almost one half of feed per 1 cutting. Incase of flat drag,which is for finsh cutting,set its honing angle to0.03 to0.1mm.
No honing angle is required for cutter that is used for cutting any material that is easily welding,like aluminium or cast irom.

角高和精面加工　珩從内接圓開始的角度(B)指刀片安裝到刀身後的刃尖高度。
Role of honing　(B)from the inscribed circle is the height of nose when the cutter body.



刀片安裝到刀身後的刃尖高度的高低(正面跳動)一般爲0.02mm~0.03mm，修光刃爲與工件接觸的所有刀片的約1/3。
若低于些數值,則加工面質量會變差。

The difference of nose height(front run-out) likely to occur when setting theinsert to the cutter body is 0.02 to 0.03mm.Number of insert,of which flat drag contacting the work is about one third of all the inserts.
If less than that,no good finish surface is obtained.



正常時的修光刃磨損
Abrasion in flat drag in normal cutting

刀片安裝不當時的修光刃异常磨損
Abnormal abrasion is flat drag when insert setting is not proper.

與工件精加工面接觸的刀片若發生傾斜，精加工面質量將變差。安裝刀片時務必采取吹氣等措施，以防灰塵等進入。
If the insert contacting the finish surface of a work is inclined,the finishing is not done well.
Carefully set the insert allowing nw dust to enter by the air blow or other.

捨弃式刀具

銑削加工切削條件的選擇方法
How to select cutting conditions for milling

●切削速度(Vc) Cutting Speed

$Vc=\frac{\pi xDxn}{1000}$ (m/min)

轉速(n)Revolution

$n=\frac{1000xVc}{\pi xD}$ (min−1)

Vc:切削速度 m/min cutting speed
D:刀徑 mm Cuter diameter
n:轉速 min^{-1} RPM
π: 圓周率 3.146 Circumference ratio

●進給速度(Vf)Feed rate

Vf=fzxZxn(mm/min)

每刃进给(fz)Feed rate per tooth

$fz=\frac{Vf}{Zxn}$ (mm/tooth)

Vf:进给速度 mm/min Feed rate
Z:刃數 Number of flutes
n:转速 min^{-1} RPM
fz:每刃进给 mm/tooth feed per tooth

●加工時間(Tc)

$Tc=\frac{L}{Vf}$ (min)

Tc:加工時間 min Cutting time
Vf:每分鐘的工作臺進給速度
Feed rate per minute of table
L:轉工作臺總進給長度(工作長度+銑刀直徑)mm
Overall table feed length(workpiece length+grinder dia.

●切削動力(Ne) Feed rate

$Ne=\frac{ap\ x\ ae\ x\ Vf\ x\ Ks}{60x10^6x\eta}$ (KW)

Ne:切削動力 kw
Cutting power(horsepower)
ae:切削寬度 mm
Cutting width
η:機械效率(0.6~0.8)
Mechanical effciency
Ap:切削深度 mm
Cutting depth
Vf:進給速度 mm/min
Feed rate
Ks:比切削阻力 kg/mm^2
Relative cutting resistance
(參照下表 Refer to the table below)

KS(比切削阻力) Specific cutting resistane

工作材料 Work Materials	被拉伸强度(N/mm^2)及硬度 Tensile stength(N/mm^2)or hardness	對于每刃進給的比切削阻力(N/mm^2)ks Ks:Specific cutting resistance(M/mm^2)forfeed tootj				
		0.1mm/tooth	0.2mm/tooth	0.3mm/tooth	0.4mm/tooth	0.1mm/tooth
軟鋼 Mild steels	520	2200	1950	1820	1700	1580
中碳鋼 Medium Steels	620	1980	1800	1730	1600	1570
硬鋼 Hard Steels	720	2520	2200	2040	1850	1740
工具鋼 Tool Steels	670	1980	1800	1730	1700	1600
	770	2030	1800	1750	1700	1580
鉻錳鋼 Chrome manganese Steels	770	2300	2000	1880	1750	1600
	630	2750	2300	2060	1800	1780
鉻鉬鋼 Chrome molybdenum Steels	730	2540	2250	2140	2000	1800
	600	2180	2000	1860	1800	1670
鎳鉻鉬鋼 Nickel chrome molybdenum Steels	940	2000	1800	1680	1600	1500
	352HB	2100	1900	1760	1700	1530
鑄鋼 Cast Steels	520	2800	2500	2320	2200	2040
硬質鑄鐵 Hard Cast Steels	46HRC	3000	2700	2500	2400	2200
米納鑄鐵 Meehanite Cast Steels	360	2180	2000	1750	1600	1470
灰鑄鐵 Gray Cast Steels	200HB	1750	1400	1240	1050	970
黃銅 Yellow copper	500	1150	950	800	700	630
輕合金(Al-Mg)Light Alloy(Al-Mg)	160	580	480	400	350	320
輕合金(Al-Si)Light Alloy(Al-Si)	200	700	600	490	450	390

捨弃式刀具

銑削加工時的故障及其原因、對策
Cutting condition formula(milling)and trouble shooting

<對策>
<Countermeasurs>
○ 效果好 Very Effective
● 有效果 Effective
▼ 效果相反 Not Effective
↑ 增加、增大 Increase,Make it Large
↓ 減小、減小 Reduce,Make it Small

故障項目 Troubles	刀片材料 Insert Grade: 使用韌性高的材料 Use Tough Grade	使用耐磨損性的高的材料 Use Abrasion Resistant Grade	使用金屬陶瓷 Use Cermet Material	使用塗層材料 Use coated Grade	刀具形狀 Tool Shape: 改變珩磨量 Change The Honing	改變前角 Change Rake	改變後角 Change Relief Angle	加厚刀片 Make Insert Thinker	加大刃角 Increase Corner R.	使用精密級刀片 Use Precision Class Insents	改變刃數 Use Inserts of Different Flute Number	安裝修刀刃 Attach Flat Drag	切削條件 Cutting Condition: 改變切削速度 Chang Cutting Speed	改變進給量 Chang The Feed Rate	改變切削深度 Chang Cut-in Amount	使用切削液 Splash Cutting Fluid	減小接觸角 Reduce The Engage Angle	
後隙面磨損(側面) Abraded ReliefSurface (Fland)		○		○	● ↓		↑ ●		●				● ↓					
前刀面磨損(月牙窪) Abraded RakeSurface (Crater)		●	●	●		↑ ●							● ↓	● ↓		●		
衝擊性崩裂 Shoch Chipping	○				↑ ○	● ↓	● ↓	●	●					● ↓		●		
熔着性崩裂 Welding Chipping	●		●	○	● ↓	↑ ●							↑ ○			○		
熱裂 Thermal Crack	●							●					● ↓			▼		
精加工面 Finish Suriace			○			↑ ●	↑ ●			○		○	↑ ●	● ↓	● ↓	○		
顫動 Chattering Vibration					● ↓	↑ ●	↑ ●				● ↓		● ↓	● ↓	● ↓			
精刃帶缺損毛刺 Edge Chipping Burr					● ↓	↑ ●	↑ ●		●		↑ ●			● ↓	● ↓		●	