



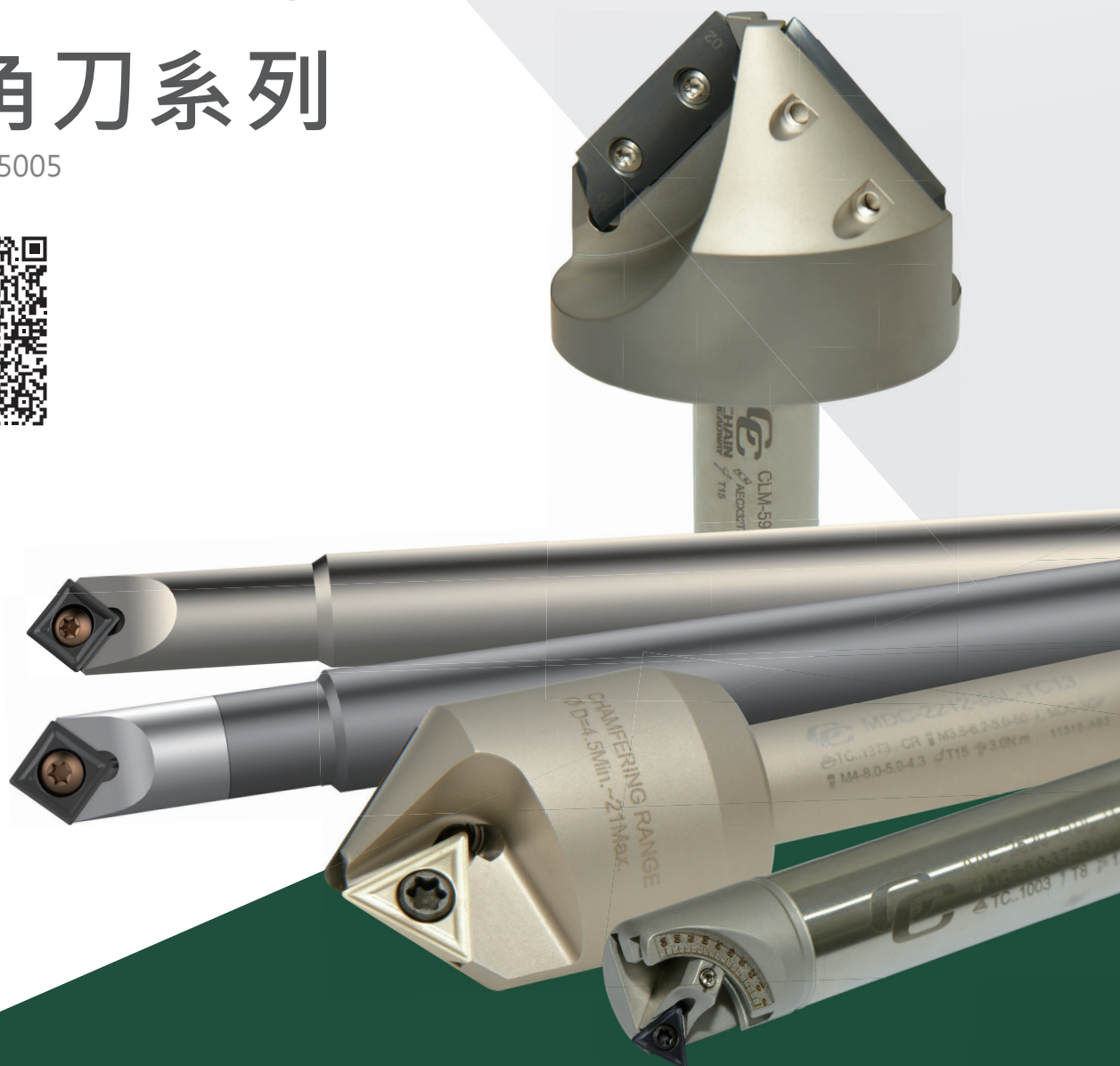
CHAMFERING CUTTER SERIES

倒角刀系列

No. 250325005



影片
Video



倒角刀系列 產品發展歷史

Chamfering Cutter Development History





LC 刀片_倒C角R角
LC INSERT-CHAMFER AND RADIUS

銑削刀片 Milling Insert
LC1245-CH
LC1260-CH



M405 內外倒角刀
M405 INNER-OUTER CHAMFER MILLING CUTTER

2015-2020

2020-2024



MDC 多軸鑽床倒角刀
MDC MULTI-AXIS CHAMFERING CUTTER



MSP 小徑倒角刀
MSP MINI-CHAMFERING END MILL



CMSP 碳化鎢鋼小徑倒角刀
CMSP CARBIDE STEEL MINI-CHAMFERING END MILL



AAC 可調式倒角刀
AAC ADJUSTABLE ANGLE CHAMFERING CUTTER



TSP 45°倒角刀
TSP 45° INDEXABLE SPOT & CHAMFER MILLING CUTTER



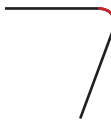
CLM 長刃型倒角刀
CLM LONG EDGE CHAMFERING CUTTER



AAC 小徑可調式倒角刀
AAC ADJUSTABLE ANGLE MINI-CHAMFERING CUTTER

刀片刃口介紹

Cutting Edge Introduction

刃口規格 Cutting Edge Spec.	形狀 Shape	特性 Feature
FR CR	FR 	適用於一般低碳鋼切削 Suitable for general low-carbon steel cutting.
MR	MR 	適用於不鏽鋼、鈦合金切削 Suitable for stainless steel and titanium alloy cutting.
AR	AR 	適用於合金鋼、中高碳鋼即調質後鋼材切削 Suitable for alloy steel, medium to high carbon steel, and tempered steel cutting.

塗層介紹

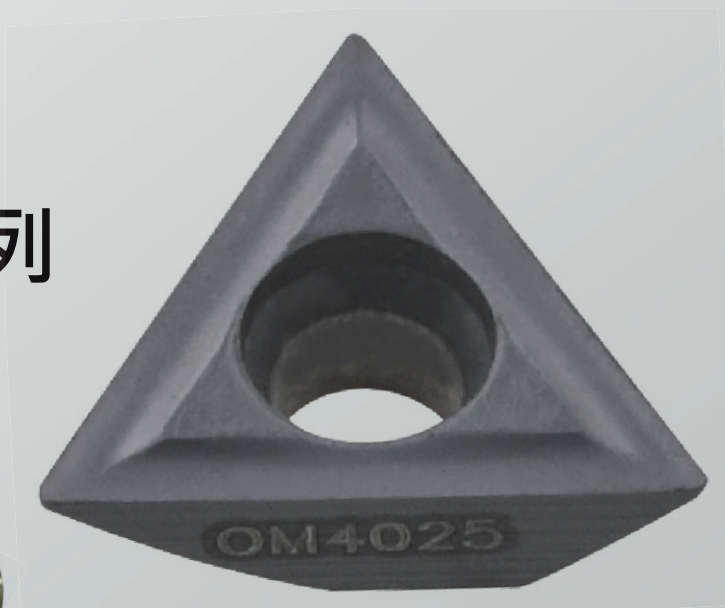
Coating Introduction

材質 Grade	塗層類型 Coating Type	顏色 Color	加工特點 Feature
OM4025	PVD-AlTiN	黑紫色 Black-purple	1. 低應力 2. 塗層光滑細緻 3. 結合力優越 4. 適合高速乾式切削 1. Low stress. 2. Smooth and fine coating. 3. Superior adhesion. 4. Suitable for high-speed dry cutting.
OM4010	PVD-AlCrTi+SiC	黑灰色 Black-grey	1. 耐高溫氧化 2. 超級耐磨 HV3500 3. 納米多層結構超優結合力 4. 適合熱處理預硬鋼材料 1. High-temperature oxidation resistance. 2. Extremely wear-resistant HV3500. 3. Nano multilayer structure with excellent adhesion. 4. Suitable for heat-treated pre-hardened steel.
OM5035	PVD-AlCrN	淡金色 Light gold	1. 奈米複合膜 2. 高抗氧化溫度 3. 表面低親和力 4. 適用於不銹鋼及鈦合金加工 1. Nano composite coating. 2. High oxidation resistance temperature. 3. Low surface affinity 4. Suitable for stainless steel and titanium alloy machining.
OM5005	無 None	無 None	1. 表面拋光光滑細緻 2. 適用於鋁合金、銅合金加工。 1. Polished surface with fine smoothness. 2. Suitable for aluminum alloy and copper alloy machining.
OM5060	PECVD	彩虹色 Rainbow	1. 抗沾黏 2. 低磨擦係數 3. 有效改善排屑 4. 適用於鋁合金、銅合金加工。 1. Anti-adhesion. 2. Low friction coefficient. 3. Effectively improves chip evacuation. 4. Suitable for aluminum alloy and copper alloy machining.

AAC

可調式倒角刀系列

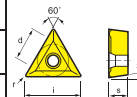
ADJUSTABLE ANGLE
CHAMFERING CUTTER
SERIES



AAC ADJUSTABLE ANGLE CHAMFERING CUTTER SERIES

Adjustable Angle Chamfering Cutter Insert

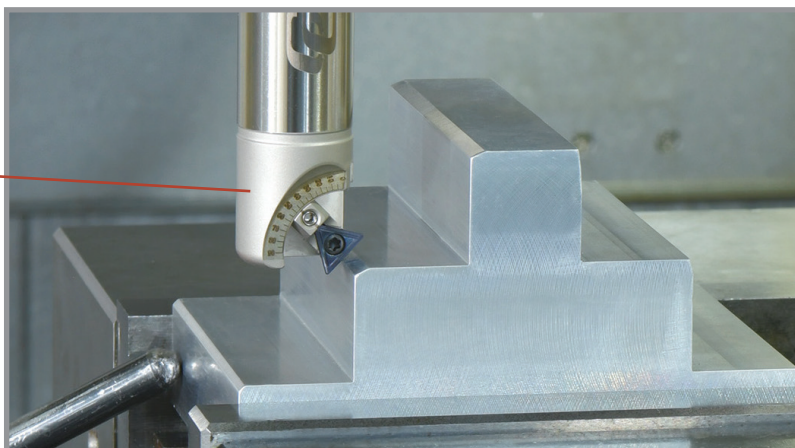


ISO 分類	P	合金鋼 Alloyed Steels	○	○											切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting				
	M	不鏽鋼 Stainless Steels	○	○	○														
	K	鑄鐵 Cast Iron	○	○															
	N	鋁及鋁合金 Aluminum&Al							■	■									
	S	高溫合金 Refractory Alloys			○														
	H	高硬度材 Hard Material	○																
形狀 Shape	規格 Spec.	鍍層超微粒 Layer coated micro grain						超微粒硬質合金 Micro grain cemented carbide						尺寸 (mm)				圖形 Drawing	
		CHF						HF						Size					
		OM4010	OM4025	OM5035					OM5005	OM5060					d	i	s		r
	★	TCEX100304E-FR	●	●					●	●					5.8	10	3.18	0.4	
		TCEX100304E-AR	●	●											5.8	10	3.18	0.4	
	NEW	TCEX100304E-MR			●										5.8	10	3.18	0.4	

★ 推薦 Recommended

- MR 鈦合金專用
- 規格末編碼帶 FR 刀片為銳角刀片

- MR: Applicable to Titanium
- Suffix FR model designates a sharp cutting edge insert.



AAC 可調式倒角刀系列

AAC ADJUSTABLE ANGLE CHAMFERING CUTTER SERIES

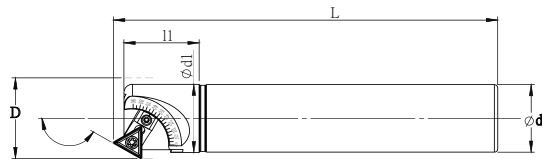


AAC 小徑可調式倒角刀

AAC Adjustable Angle Mini-Chamfering Cutter



可自行調整 0° ~90°倒角應用
Adjustable chamfer angle from 0° to 90°



特點 Feature

- 較小刀具有效防止倒角角度干涉
- 倒角角度 0° ~90°的角度調整
- 可利用旋轉刀片座調整角度
- 手動旋轉刀片座與刀具上的刻度線與標點對齊，可在 0° ~90°的範圍內調整倒角角度
- Smaller size cutter prevent interference
- Flexible to adjust the chamfering angle from 0° ~90°
- Align the scale mark between insert seat and cutter body to set up 0° to 90° manually

規格 Spec.	L	l ₁	D	d	d ₁	θ	功能 Function	刀片 Insert	重量 (KGS) Weight
AAC-2520-110L-TC10	110	22	23.88	20	20.2	0° ~90°	倒角 Chamfering	TCEX1003	0.3

配件表 Accessories

刀片座 Insert Seat	圓柱壓固銷 Pin	刀片座鎖固螺絲 Insert Seat Fixed Screw	扳手 Wrench	扭力值 Torque	刀片 Insert	刀片螺絲 Insert Screw	扳手 Wrench	扭力值 Torque
AAC-25-TC10	AAC-5-8.2L	AAC-M3-3L	PL1.5	5.0	TC..100304	M2.5-5.0-3.7-43	T8	1.2

TC_10 AAC 倒角刀切削條件數據表 Cutting Parameter

加工型態 Processing Type	被加工材質 Machining Materials	刀片材質 Materials	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)	最大倒角量 Ap(mm)
	P 合金鋼 Alloy Steels	OM4010	80~150	0.05~0.1	2mm
		OM4025	80~150	0.05~0.1	2mm
	M 不鏽鋼 Stainless Steels	OM4010	60~120	0.05~0.12	2mm
		OM4025	60~120	0.05~0.06	2mm
	K 鑄鐵 Cast Iron	OM4025	100~130	0.05~0.12	2mm
	N 鋁合金 Aluminum&Al	OM5005	150~300	0.05~0.12	2mm

AAC 可調式倒角刀系列

AAC ADJUSTABLE ANGLE CHAMFERING CUTTER SERIES

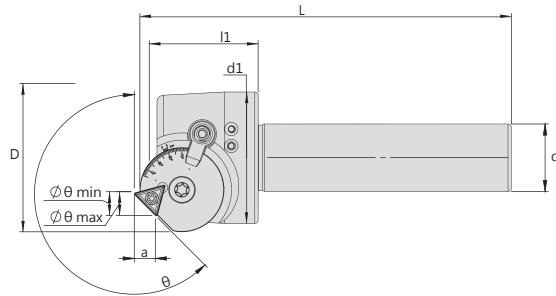


AAC 可調式倒角刀

AAC Adjustable Angle Chamfering Cutter

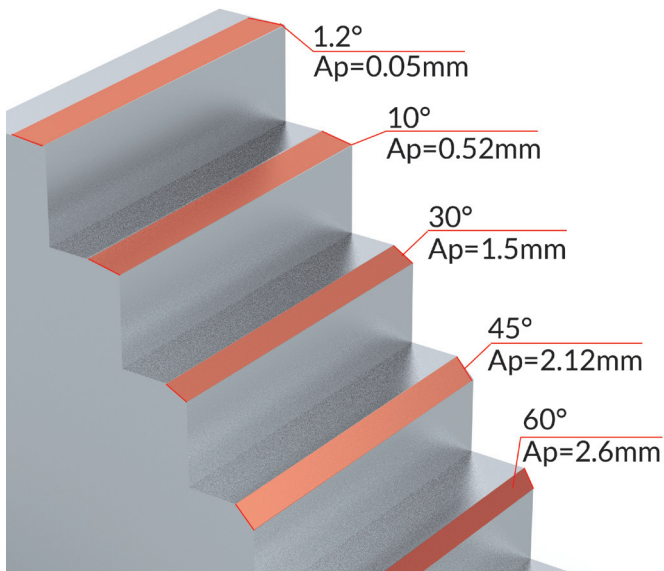


可自行調整 $0.1^{\circ} \sim 89.9^{\circ}$
倒角應用
Adjustable chamfer angle
from 0.1° to 89.9°



規格 Spec.	L	l1	D	d	d1	a	θ	刀片座 Insert Seat	刀片 Insert	重量 (KGS) Weight
AAC-4020-110L-TC10	105	30	41	20	39	0.005~9.29	$0.1^{\circ} \sim 89.9^{\circ}$	AAC-TC10	TC..1003	0.36

範例 Example



- 刀桿 Tool holder : BT40-LHC20-58
- 刀具 Cutter Tool : AAC-4020-110L-TC10
- 刀片 Insert : TCEX100304E-AR OM4025(1pcs)
- 工件材質 Material : S50C
- (V) : 100m/min
- (S) : 1600rpm
- (f) : 150mm/rev
- (F) : 0.06mm/min
- (Ap) : 3mm
- (Ae) : 2.12mm

AAC 可調式倒角刀系列

AAC ADJUSTABLE ANGLE CHAMFERING CUTTER SERIES



AAC 可調式倒角刀 (套裝一支組)

AAC Adjustable Angle Chamfering Cutter Set (1PC/Set)



範例 Example

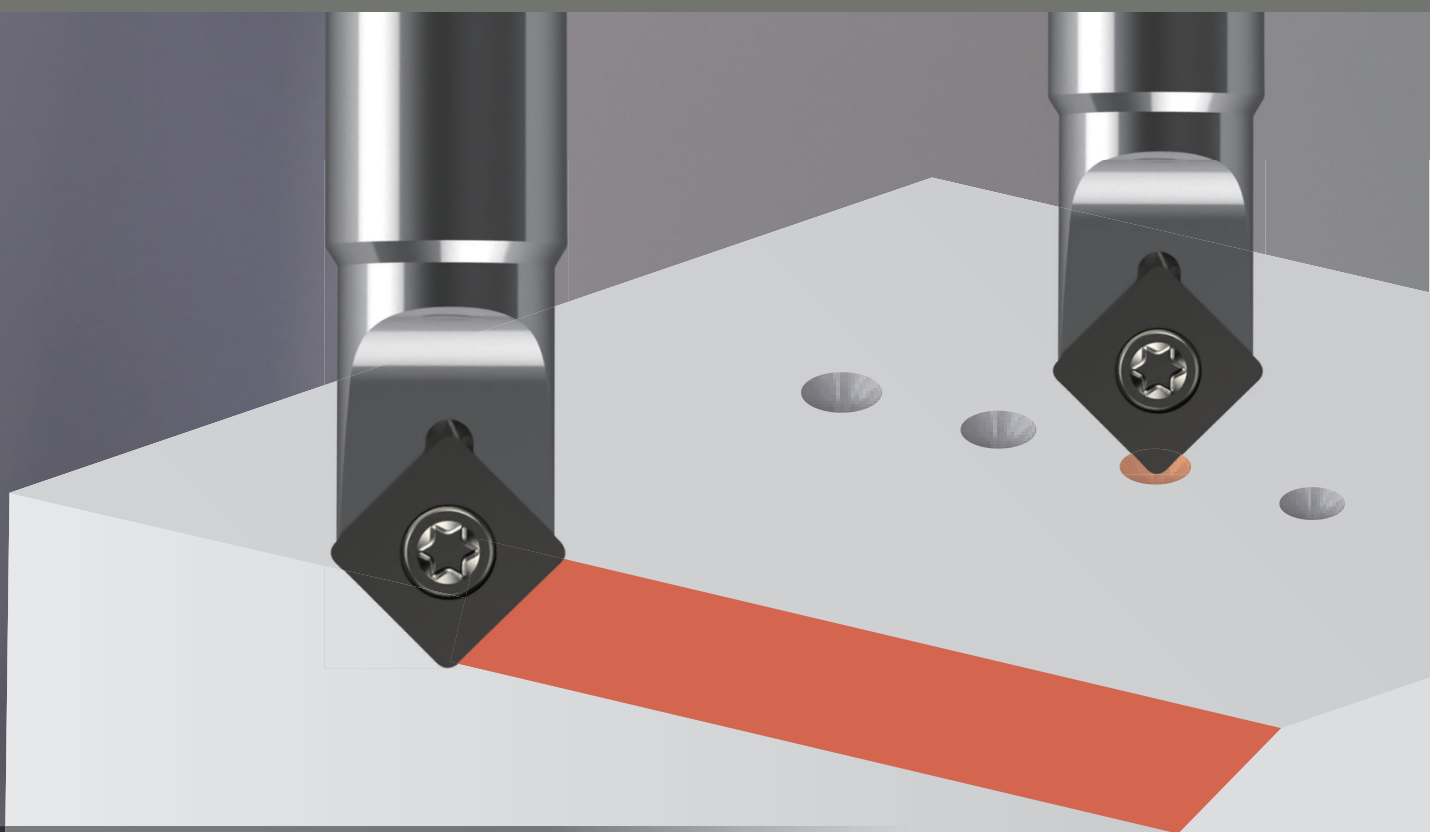


規格 Spec.	內容物 Contents				重量 (KGS) Weight
	刀具 Tools	刀片 Insert	扳手 Wrench	數位角度規 Digital Protractor	
AAC-4020-110L-TC10-SET	AAC-4020-110L	TCEX100304E-AR OM4025(1pcs)	T8 T10 T20 PL2.5 (1pcs)	LM-DP60 (1pcs)	-

TSP

45° 倒角刀

TSP 45° INDEXABLE SPOT
& CHAMFER MILLING
CUTTER



- 切深0.5-9mm
- Cutting Depth 0.5 - 9mm

- 內孔倒角範圍Ø1.5-Ø18.5mm
- Chamfer Range Ø1.5 - Ø18.5mm

TSP 45°倒角刀

TSP 45° INDEXABLE SPOT & CHAMFER MILLING CUTTER

NEW



TSP 45°倒角刀片

TSP 45° Indexable Spot & Chamfer Milling Cutter Insert



ISO 分類	P	合金鋼 Alloyed Steels	○	○									切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting					
	M	不鏽鋼 Stainless Steels		○														
	K	鑄鐵 Cast Iron	○															
	N	鋁及鋁合金 Aluminum&Al																
	S	高溫合金 Refractory Alloys																
	H	高硬度材 Hard Material																
形狀 Shape	規格 Spec.	鍍層超微粒 Layer coated micro grain								超微粒硬質合金 Micro grain cemented carbide				尺寸 (mm)				圖形 Drawing
		CHF								HF				Size				
		OM4025	OM5035											d	i	s	r	
	NEW	SPGT090408AZER-M01	●	●										9.8	-	4.3	0.8	
	NEW	SPGT140512AZER-M01	●	●										14.3	-	5.2	1.2	

NEW 新品 New Product

SP_09、14 切削條件數據表 Cutting Parameter

加工型態 Processing Type	被加工材質 Machining Materials	刀片材質 Materials	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)	切深 Ap(mm)
	P 合金鋼 Alloy Steels	OM4025	100~200	0.03~0.06	0.5~9
	M 不鏽鋼 Stainless Steels	OM5035	60~130	0.03~0.06	0.5~5
	K 鑄鐵 Cast Iron	OM4025	150~250	0.05~0.10	0.5~9

加工型態 Processing Type	被加工材質 Machining Materials	刀片材質 Materials	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)	切深 Ap(mm)
	P 合金鋼 Alloy Steels	OM4025	100~250	0.10~0.2	0.5~9
	M 不鏽鋼 Stainless Steels	OM5035	60~130	0.10~0.2	0.5~9
	K 鑄鐵 Cast Iron	OM4025	120~250	0.15~0.25	0.5~9



TSP 45°倒角刀

TSP 45° Indexable Spot & Chamfer Milling Cutter



Fig.1

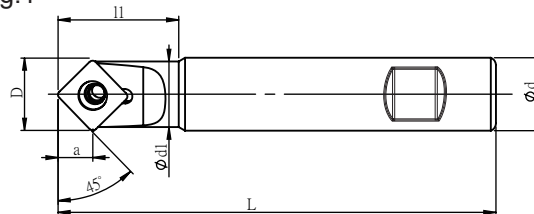
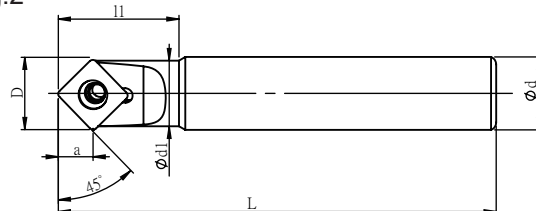


Fig.2

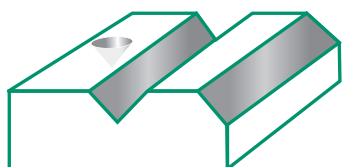


規格 Spec.	L	l ₁	D	d	d ₁	a	最大中心鑽深 / 孔直徑 Max. center drilling depth / diameter	刀片 Insert	Fig.	重量 (KGS) Weight
TSP-1316-SP09-110L	110	30	13.6	16	13	6.5	5mm/Φ12	SPGT0904	1	0.17
TSP-1820-SP14-130L	130	40	20	20	18	9.5	9mm/Φ19	SPGT1405	2	0.30

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SPGT0904	M4-8.0-5.0-43	T15	3.0
SPGT1405	M5-11-6.4-43	T20	5.0

功能 Function



倒角 chamfering
中心鑽 center drilling

內孔倒角範圍 Inner Chamfering Range

Min.		Max.
1.5	SP..0904	12.5
2.5	SP..1405	18.5

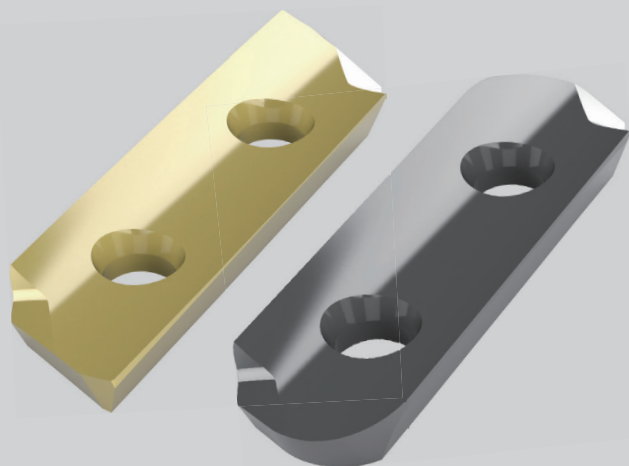
外倒角距離 Outer Chamfering Range

	-Z Max.
SP..0904	Max. 5mm
SP..1405	Max. 9mm

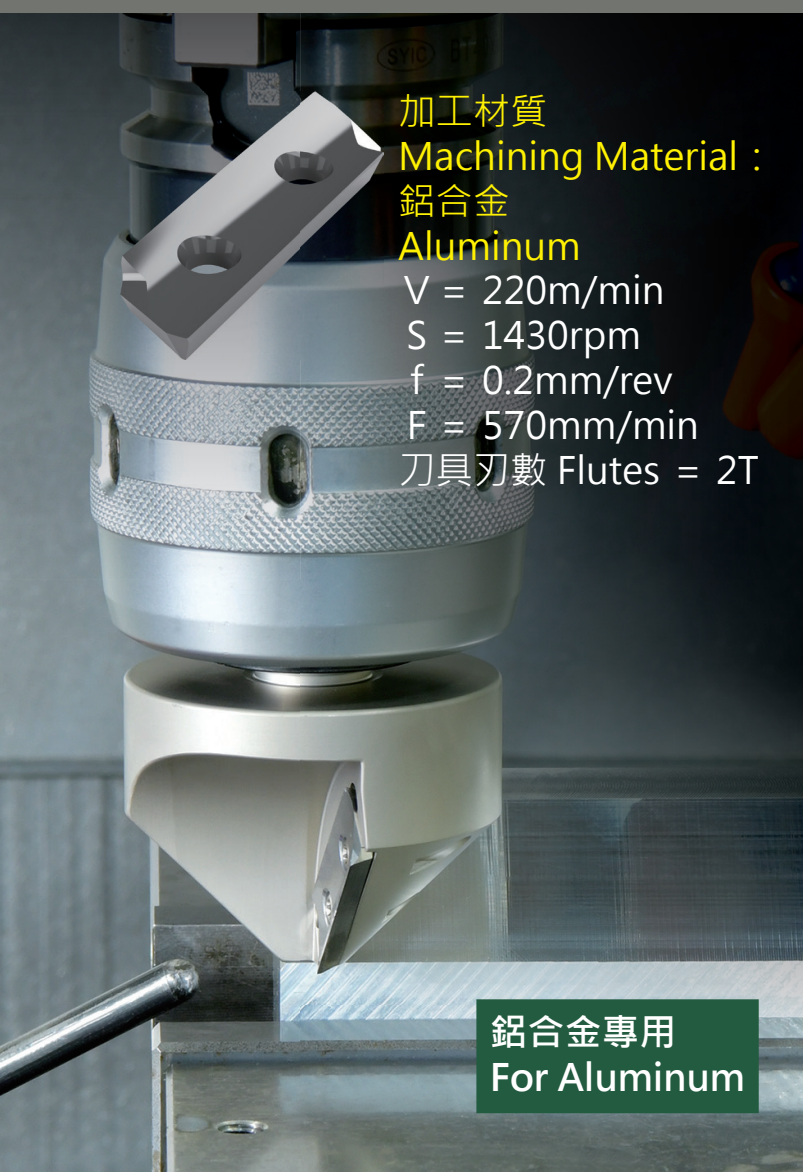
CLM

長刃型倒角刀

LONG EDGE
CHAMFERING CUTTER

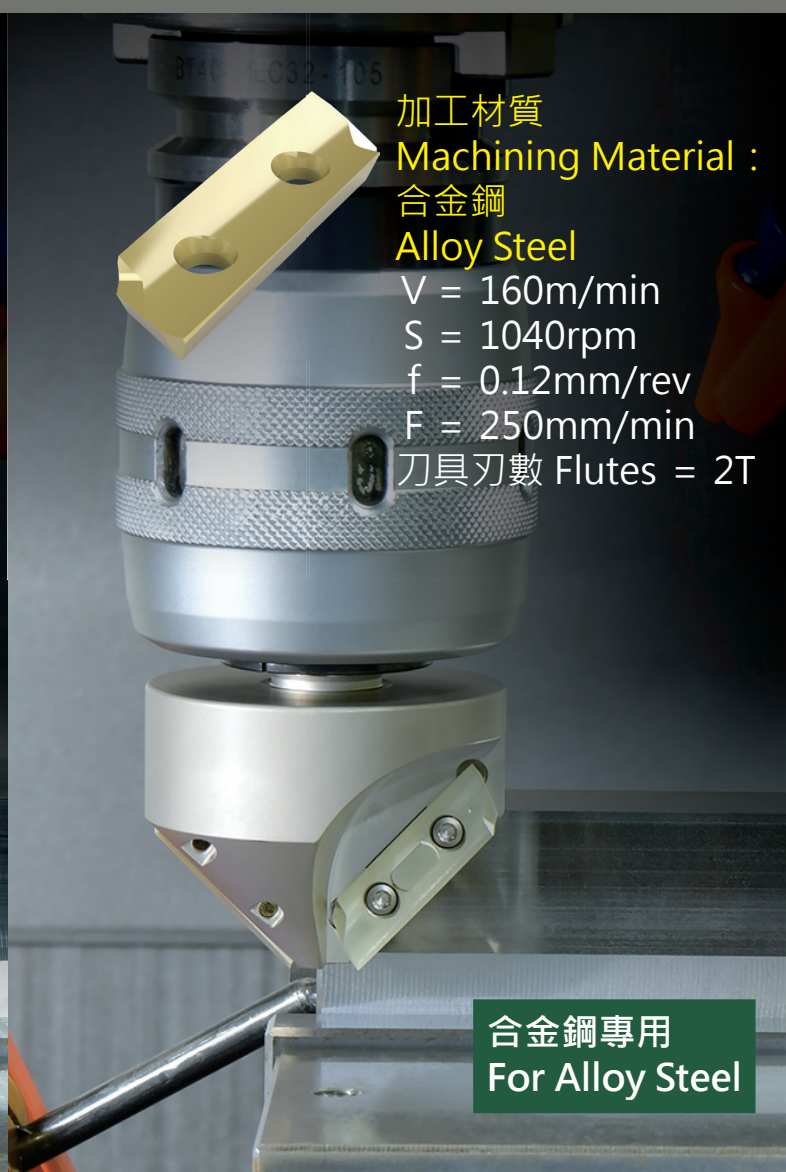


32mm



加工材質
Machining Material :
鋁合金
Aluminum
V = 220m/min
S = 1430rpm
f = 0.2mm/rev
F = 570mm/min
刀具刃數 Flutes = 2T

鋁合金專用
For Aluminum

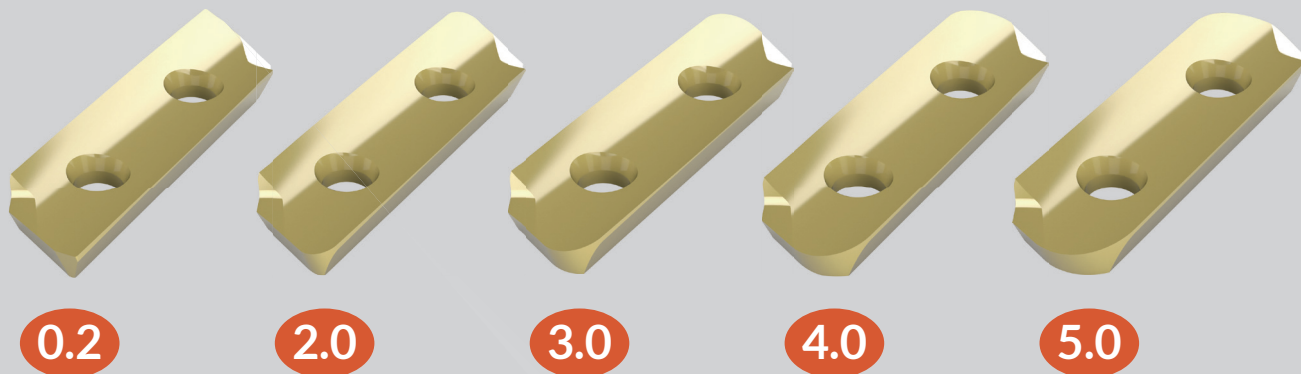


加工材質
Machining Material :
合金鋼
Alloy Steel
V = 160m/min
S = 1040rpm
f = 0.12mm/rev
F = 250mm/min
刀具刃數 Flutes = 2T

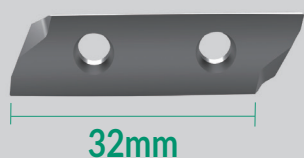
合金鋼專用
For Alloy Steel

AECX32T3 長刃型颶風刀片

AECX32T3 LONG EDGE MILLING INSERT



5 種刀尖圓弧半徑 Five Kinds of Cutting-Edge Radius



鋁合金專用
For Aluminum



合金鋼專用
For Alloy Steel

材質 Grade	塗層類型 Coating Type	顏色 Color	特點 Feature	刃口形式 Profile
OM5035	PVD-AlCrN	淡金色 Light Gold	• 奈米複合膜 • 高抗氧化溫度 • 表面低親和力 • 適用於不銹鋼及鈦合金加工 • Nano-composite film • High resistance to oxidation temperature • Low surface affinity • Suitable for processing stainless steel and titanium alloys	
OM5005	UN-COATING	無 None	• 適用於鋁合金、銅合金加工 • Suitable for aluminum alloys and copper alloys	
OM5060	PECVD	彩虹色 Rainbow Colors	• 抗沾黏 • 低磨擦係數 • 有效改善排屑 • 適用於鋁合金、銅合金加工 • Anti-adhesion • Low friction coefficient • Effectively improves chip evacuation • Suitable for aluminum alloys and copper alloys	

- ▶ 提供 30mm 大切深需求，並設計 5 種刀尖 R 角，提高切削應用彈性。
- ▶ 刀片採全周研磨及表面拋光，大幅改善加工黏屑問題，並提供特殊 PVD 鍍膜，提高耐磨性及抗熱性。
- ▶ 鋒利切削刃、曲線斷屑槽，使排屑更順暢。
- ▶ 30mm long edge cutting size with 5 kinds of radius designed to offer different application needs.
- ▶ The insert is fully ground and polished, reducing chip adhesion, with a PVD coating for enhanced wear and heat resistance.
- ▶ The sharp cutting edge ensures excellent surface roughness, while the curved chip breaker enables smooth chip removal.

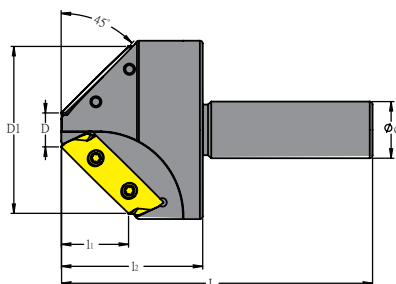
CLM 長刃型倒角刀

CLM LONG EDGE CHAMFERING CUTTER



CLM 長刃型倒角刀片

CLM Long Edge Chamfering Cutter



內孔倒角範圍
Inner Chamfering Range

Min		Max
13	r=0.2	58
15	r=2.0	58
17.5	r=3.0	58
19.5	r=4.0	58
21.5	r=5.0	58

規格 Spec.	L	D	D1	d	l1	l2	功能 Features	刀片 Insert	重量 (KGS) Weight
CLM-5920-110L-AE32	110	12	59	20	23.7	50	倒角 Chamfering	AECX32T302ER-F01	0.7
CLM-5932-110L-AE32	110	12	59	32	23.7	50	倒角 Chamfering	AECX32T302ER-F01	0.9

- 註：如需底部加工功能，刀具本體需局部微調修改。

- Note : If bottom machining is required, the tool body will need partial adjustments or modifications.

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench
AECX32T3	M4-8.0-5.2-43-T15	T15

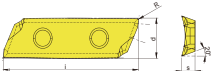
CLM 長刃型倒角刀

CLM LONG EDGE CHAMFERING CUTTER



AECX32T3 長刃型颶風刀片

AECX32T3 Long Edge Milling Insert

ISO 分類	P	合金鋼 Alloyed Steels						切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels									
	K	鑄鐵 Cast Iron									
	N	鋁及鋁合金 Aluminum&Al	●	●							
	S	高溫合金 Refractory Alloys									
	H	高硬度材 Hard Material									
形狀 Shape	規格 Spec.	超微粒硬質合金 Micro grain carbide alloy				尺寸 (mm)				圖形 Drawing	
		HF				Size					
		OM5005	OM5060	OM5035		d	i	s	r		
	NEW	AECX32T302ER-F01	●	●	●		11.9	37	3.97	0.2	
	NEW	AECX32T320ER-F01	●	●	●		11.9	37	3.97	2	
	NEW	AECX32T330ER-F01	●	●	●		11.9	37	3.97	3	
	NEW	AECX32T340ER-F01	●	●	●		11.9	37	3.97	4	
	NEW	AECX32T350ER-F01	●	●	●		11.9	37	3.97	5	

AECX32_ 銑削 切削條件數據表 Milling Cutting Parameter

被加工材質 Machining Materials		刀片材質 Materials	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)
P	合金鋼 Alloy Steels	OM5035	120~160	0.06~0.12
M	不鏽鋼 Stainless Steels	OM5035	60~130	0.06~0.10
N	鋁合金 Aluminum&Al	OM5005	500~1800	0.05~0.25
		OM5060	500~1800	0.05~0.25

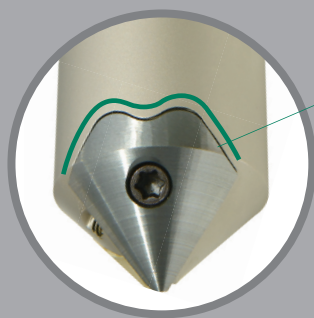
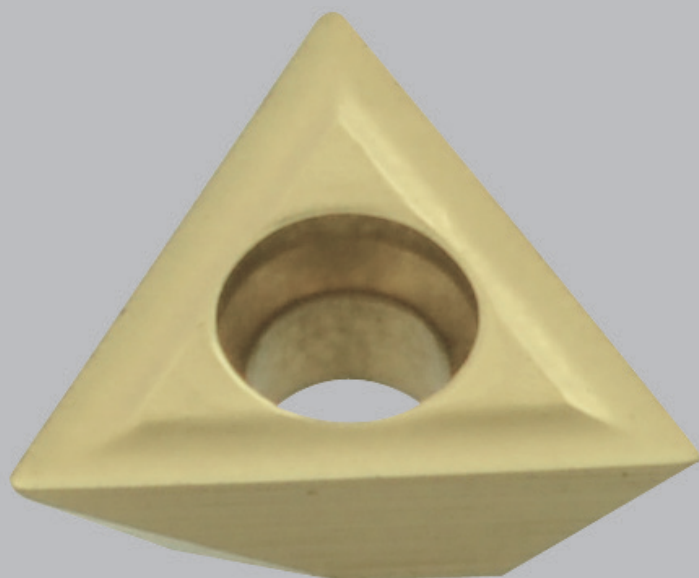
- 註：倒角切削參數直徑設定，建議中間值 D=25mm，再依實際情況微調。

Note: It is recommended to use a median value of D=25mm for the chamfering parameter diameter setting, and then adjust based on actual conditions.

MDC

多軸鑽床倒角刀

MULTI-AXIS
CHAMFERING CUTTER



鎢鋼支撐導塊

通過增加接觸面，來降低衝擊力。

Tungsten Steel Support Guide Pad

Increase contact surface to reduce the impact force while chamfering





MDC 多軸鑽床倒角刀

MDC MULTI-AXIS
CHAMFERING CUTTER

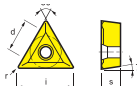
NEW



MDC 多軸鑽床倒角刀片

MDC Multi-Axis Chamfering Cutter Insert



ISO 分類	P	合金鋼 Alloyed Steels													切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting			
	M	不鏽鋼 Stainless Steels	○															
	K	鑄鐵 Cast Iron																
	N	鋁及鋁合金 Aluminum&Al																
	S	高溫合金 Refractory Alloys	○															
	H	高硬度材 Hard Material																
形狀 Shape	規格 Spec.	鍍層超微粒 Layer coated micro grain						超微粒硬質合金 Micro grain cemented carbide						尺寸 (mm)				圖形 Drawing
		CHF						HF						Size				
		OM5035													d	i	s	
	TCEX13T302E-CR	●												7.94	13.4	3.97	0.2	

★ 推薦 Recommended

- CR 鑽床倒角刀專用

- CR: Applicable to Deburring And Chamfering Cutter

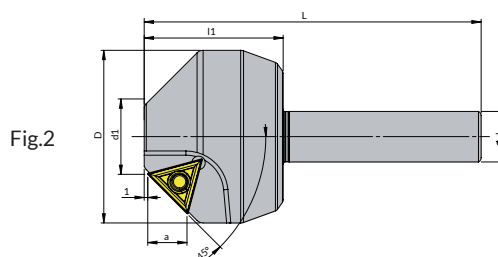
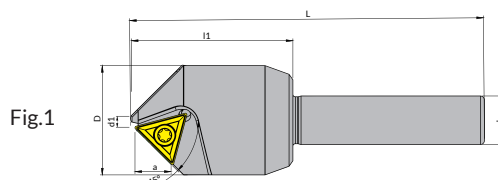
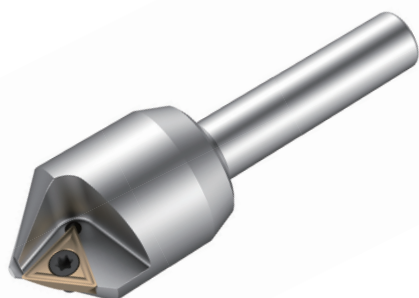
MDC 多軸鑽床倒角刀

MDC MULTI-AXIS CHAMFERING CUTTER



MDC 多軸鑽床倒角刀

MDC Multi-Axis Chamfering Cutter



特點 Feature

- 適用機台：鑽床、多軸鑽床、旋臂鑽床、氣動工具
- 萬用夾持柄徑 Ø12
- 刀片可提供出色的倒角表面

- Suitable Machines: Drilling Machine, Multi-Spindle Drilling Machine, Radial Drilling Machine, and Pneumatic Tool
- Shank diameter Ø12.
- Excellent chamfering surface.

規格 Spec.	L	l1	D	d	d1	a	內孔倒角範圍 Inner Chamfer Range	功能 Features	刀片 Insert	重量 (KGS) Weight	Fig
MDC-2212-85L-TC13	85	38	22	12	4	8	Ø4.5 - Ø21	倒角 Chamfering	TC..13T3..-CR	0.36	1
NEW MDC-3612-80L-TC13	80	33	41	12	19	8	Ø19 - Ø35	倒角 Chamfering	TC..13T3..-CR		2

規格 Spec.	內容物 Contents			
	刀具 Tool	刀片 Insert	螺絲 Screw	扳手 Wrench
MDC-2212-85L-TC13-SET	MDC-2212-85L-TC13	TC..13T3..-CR OM5035(2pcs)	M3.5-6.0-5.0-60 M4-8.0-5.0-43	T15

配件表 Accessories

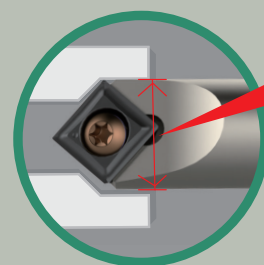
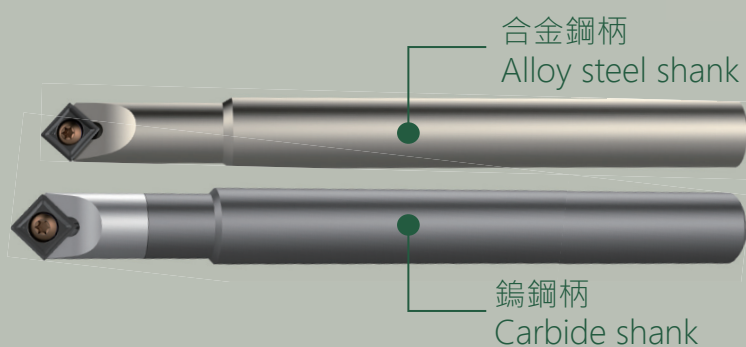
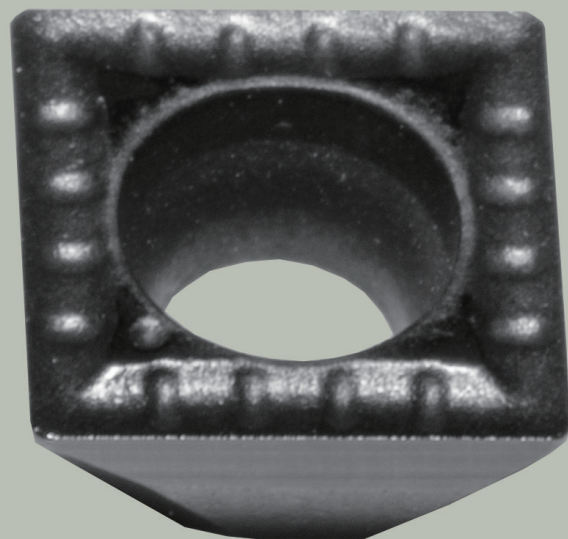
刀具 Tool	刀片 Insert	鎢鋼支撐導塊 Tungsten Steel Support Guide Pad	刀片螺絲 Insert Screw	導塊螺絲 Guide Pad Screw	扳手 Wrench
MDC-2212-85L-TC13	TC..13T3..-CR	MDC-SGP	M3.5-6.0-5.0-60	M4-8.0-5.0-43	T15
MDC-3612-80L-TC13	TC..13T3..-CR	MDC-SGP-3612	M3.5-6.0-5.0-60	M4-8.0-5.0-43	T15

下孔徑 Hole Diameter Size	轉速 n(rpm)			
	鋼 Steel	不鏽鋼 Stainless Steel	鑄鐵 Cast Iron	鋁合金 Aluminum Alloy
Ø4.5	600	550	850	1150
Ø12	450	350	550	750
Ø16	350	250	450	550
Ø18	250	250	450	450
Ø30	250	250	450	450

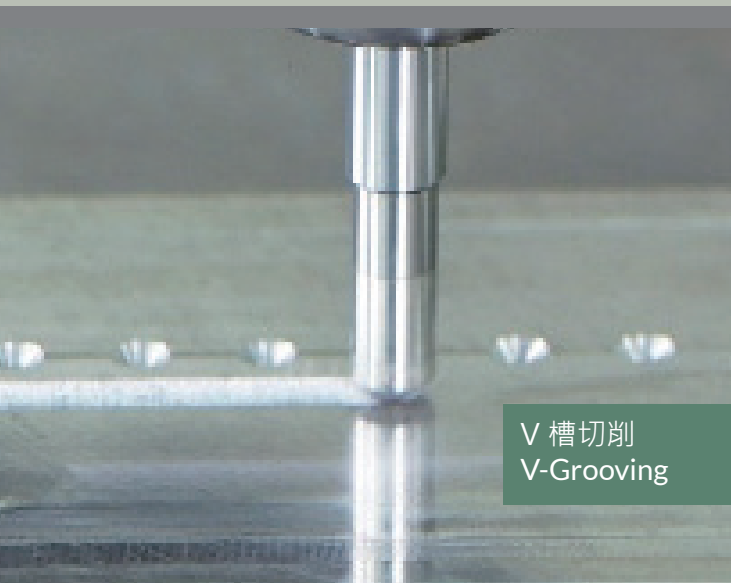
MSP/ CMSP

小徑倒角刀

MINI-CHAMFERING
END MILL



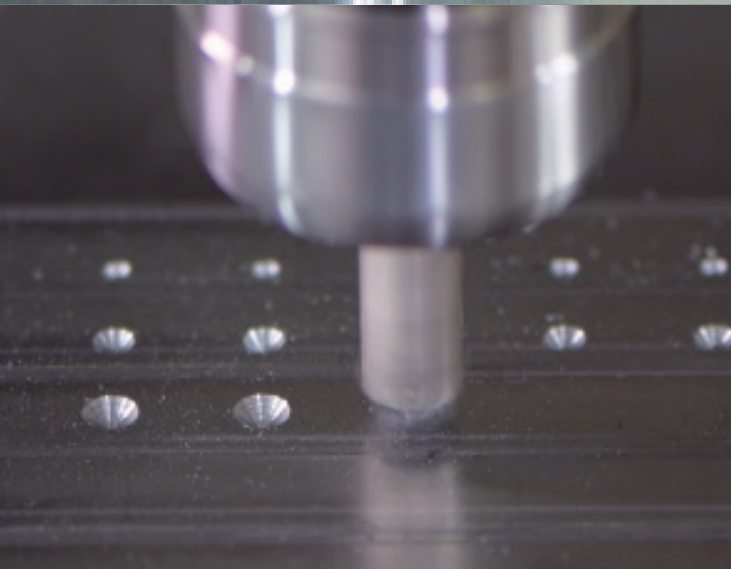
5.5 mm



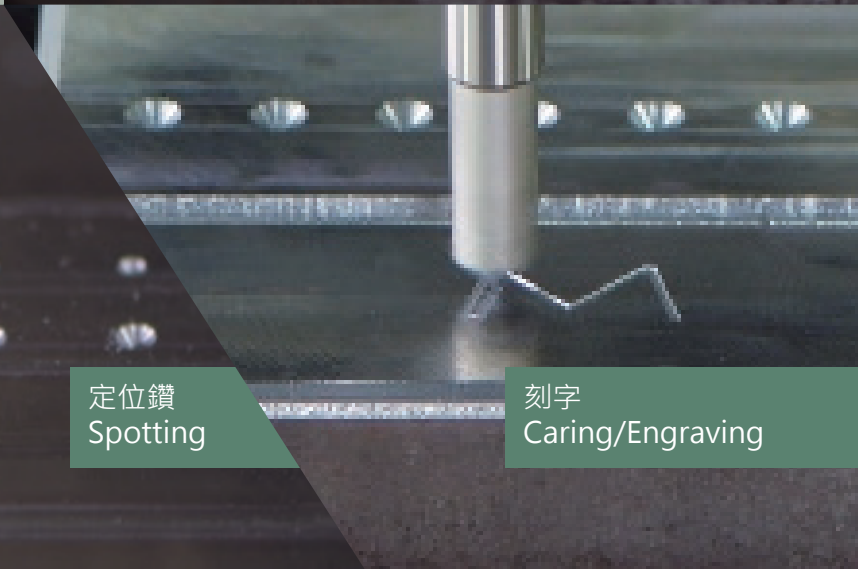
V 槽切削
V-Grooving



倒角
Chamfering



定位鑽
Spotting



刻字
Caring/Engraving

MSP/CMSP 小徑倒角刀

MSP/CMSP MINI-CHAMFERING END MILL

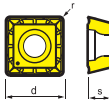
NEW



MSP/CMSP 小徑倒角刀片

MSP/CMSP MINI-Chamfering End Mill Insert



ISO 分類	P	合金鋼 Alloyed Steels	○	○										切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting				
	M	不鏽鋼 Stainless Steels		○														
	K	鑄鐵 Cast Iron		○														
	N	鋁及鋁合金 Aluminum&Al								■								
	S	高溫合金 Refractory Alloys																
	H	高硬度材 Hard Material																
形狀 Shape	規格 Spec.	鍍層超微粒 Layer coated micro grain							超微粒硬質合金 Micro grain cemented carbide				尺寸 (mm)				圖形 Drawing	
		CHF							HF				Size					
		OM4025	OM4125						OM5005					d	i	s		r
	NEW SBTG040204-F01	●	●						●					4.4	-	2	0.4	
	SBGT050202-F01	●	●						●					4.85	-	2	0.2	

NEW 新品 New Product

SB 04 05 切削條件數據表 Cutting Parameter

被加工材質 Machining Materials		刀片材質 Grade	切削速度 Vc(m/min)	進給率 (mm/rev)
P	低合金鋼 Low-Alloy Steels	OM4025	100~150	0.03~0.06
	合金鋼 Alloyed Steels	RM4125	100~150	0.03~0.06
M	不鏽鋼 Stainless Steels	OM4125	90~150	0.01~0.05
K	鑄鐵 Cast Iron	OM4025	70~130	0.05~0.10
		OM4125	70~130	0.05~0.10
N	鋁合金 Aluminum&Al	OM5005	400~750	0.05~0.12

主軸轉速 = (1000 × 切削速度) ÷ (3.14 × 刀具外徑)

$$\text{Spindle Speed} = (1000 \times \text{Cutting speed}) \div (3.14 \times \text{Cutter outer diameter}).$$
$$\text{床檯進給 (mm/min)} = \text{每刃進給} \times \text{刀具刃數} \times \text{主軸轉速}$$
$$\text{Feeding Speed (mm/min)} = \text{Feed per Flute} \times \text{Flutes} \times \text{Spindle speed.}$$

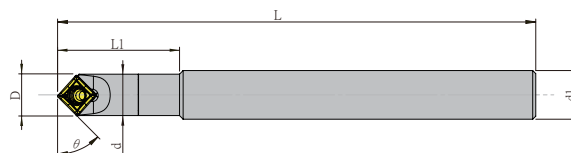
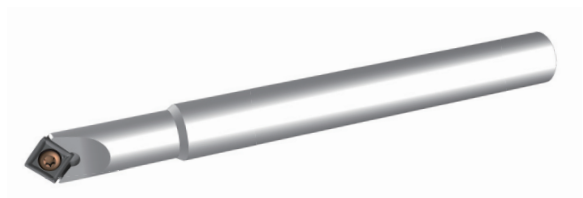
MSP/CMSP 小徑倒角刀

MSP/CMSP MINI-CHAMFERING END MILL



MSP 小徑倒角刀

MSP Mini-Chamfering End Mill



特點 Feature

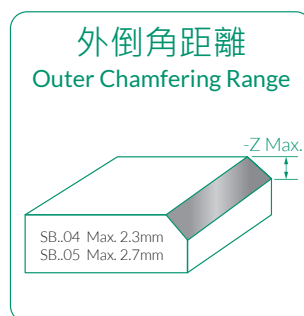
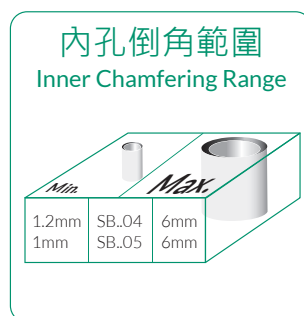
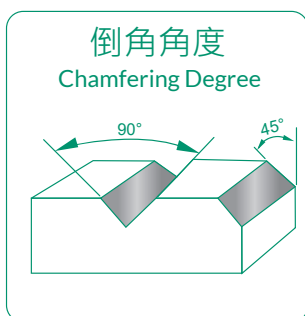
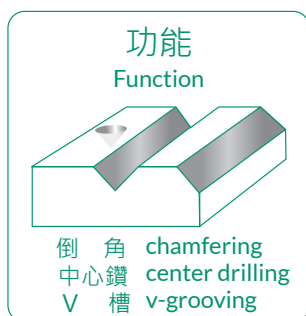
- 尺寸小 · 減少干涉

- The slim design reduces interference while machining.

規格 Spec.	D	d1	d	L1	L	θ	刀數 T	刀片 Insert	螺絲 Screw	扳手 Wrench
NEW MSP-0606-40L-SB04	6.5	6	5.5	15	40	45	1	SBGT040204	M2-4.3-2.7-60-T6-TIN	T6
MSP-0708-80L-SB05	7.2	8	6.8	20	80	45	1	SBGT050202	M2-4.3-2.7-60-T6-TIN	T6
NEW MSP-0710-90L-SB05	7.2	10	6.8	20	90	45	1	SBGT050202	M2-4.3-2.7-60-T6-TIN	T6

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench
SB..04	M2-4.3-2.7-60-T6-TIN	T6
SB..05	M2-4.3-2.7-60-T6-TIN	T6



MSP/CMSP 小徑倒角刀

MSP/CMSP MINI-CHAMFERING END MILL

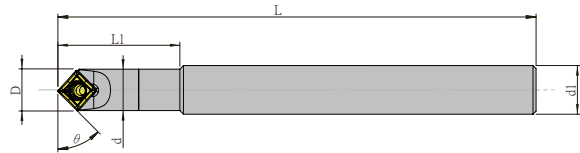


CMSP 碳化鎢鋼小徑倒角刀

CMSP Carbide Steel Mini-Chamfering End Mill



加長抗震
ANTI-VIBRATION



特點 Feature

- 尺寸小，減少干涉
- 使用碳化鎢鋼材質，增加剛性

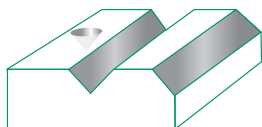
- The slim design reduces interference while machining.
- Made of tungsten carbide material for higher rigidity.

規格 Spec.	D	d1	d	L1	L	θ	刀數 T	刀片 Insert	螺絲 Screw	扳手 Wrench
NEW CMSP-0606-60L-SB04	6.5	6	5.5	20	60	45	1	SBGT040204	M2-4.3-2.7-60-T6-TIN	T6
CMSP-0708-100L-SB05	7.2	8	6.8	20	100	45	1	SBGT050202	M2-4.3-2.7-60-T6-TIN	T6
NEW CMSP-0710-120L-SB05	7.2	10	6.8	20	120	45	1	SBGT050202	M2-4.3-2.7-60-T6-TIN	T6

配件表 Accessories

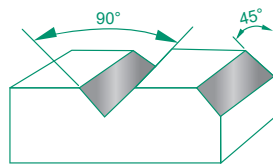
刀片 Insert	螺絲 Screw	扳手 Wrench
SB..04	M2-4.3-2.7-60-T6-TIN	T6
SB..05	M2-4.3-2.7-60-T6-TIN	T6

功能 Function

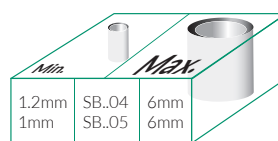


倒角 chamfering
中心鑽 center drilling
V 槽 v-grooving

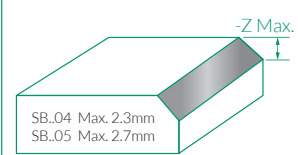
倒角角度 Chamfering Degree



內孔倒角範圍 Inner Chamfering Range



外倒角距離 Outer Chamfering Range



200L



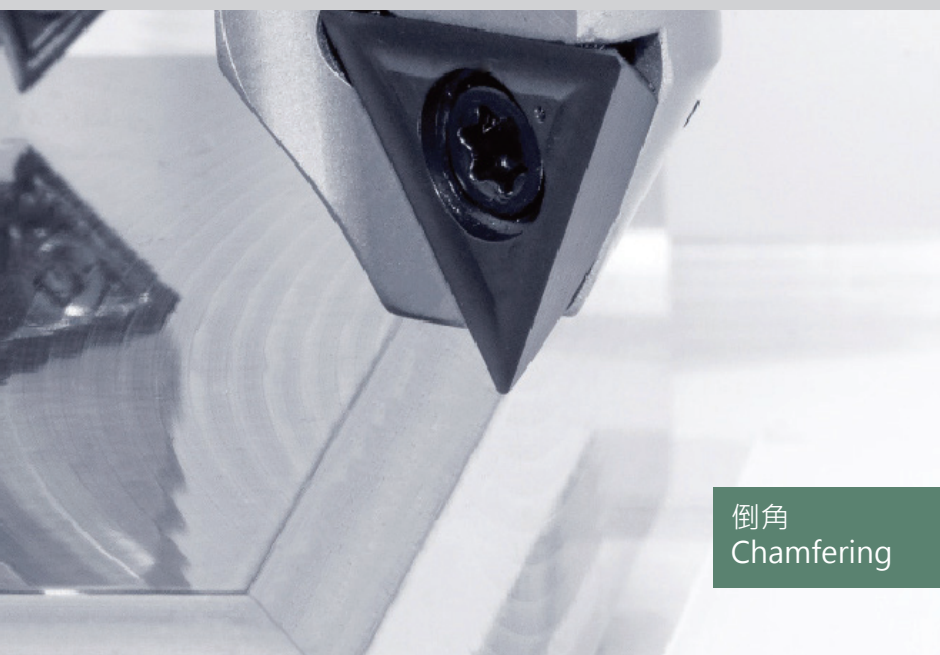
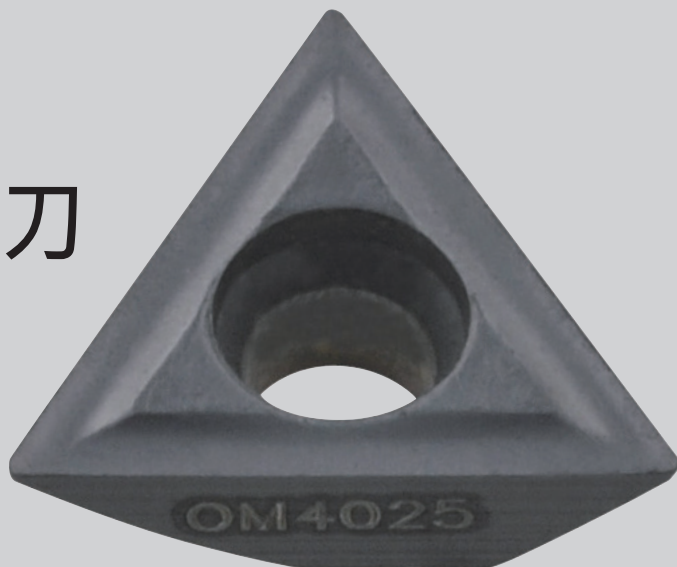
- 接單生產 120L-200L
- Make to order : 120L-200L.

SSP

30°、45°、60°倒角刀

30°、45°、60° CHAMFER
MILLING CUTTER

- 刀具及刀片特殊設計，於定位鑽及V槽切削時刀片可避免干涉。
- Clearance angle negates interference between the insert/cutting tool and the workpiece during v-grooving and spot-drilling.



倒角
Chamfering



V槽切削
V-grooving



定位鑽
Spotting



內孔倒角
Inner hole
chamfering



刻字
Carving

SSP 倒角刀系列

SSP CHAMFERING SERIES



SSP 倒角刀刀片

SSP Chamfer Milling Cutter Insert

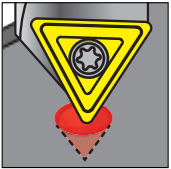
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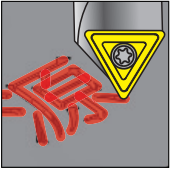
★ 推薦 Recommended NEW 新品 New Product

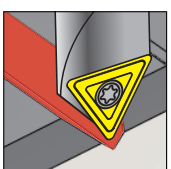
- MR 鈦合金專用
- TC..13 . 02R 角刀片為「倒角功能」專用
- TC..16 . 04R 角刀片為「倒角功能」專用
- 斷屑槽編碼 FR 刀片為銳角刀片

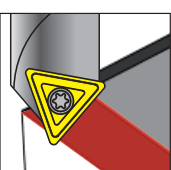
- MR: Applicable to Titanium
- TC..13 → 02 radius can only use for chamfering.
- TC..16 → 04 radius can only use for chamfering.
- FR model designates a sharp cutting edge insert.

TC_10.13.16 切削條件數據表 Cutting Parameter

加工型態 Processing Type	被加工材質 Machining Materials	刀片材質 Materials	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)	切深 Ap(mm)
	P 低合金鋼 Low-Alloy Steels	OM4010	220~290	0.05~0.12	1.0~11.0
		OM4025	220~260	0.03~0.06	0.5~3.0
	P 合金鋼 Alloy Steels	OM4010	80~150	0.05~0.12	1.0~11.0
		OM4025	100~150	0.03~0.06	0.5~3.0
	M 不鏽鋼 Stainless Steels	OM4010	90~200	0.05~0.12	1.0~11.0
		OM4025	90~180	0.01~0.05	0.5~3.0
	K 鑄鐵 Cast Iron	OM4025	70~130	0.05~0.12	1.0~11.0
	N 鋁合金 Aluminum&Al	OM5005	400~2000	0.06~0.08	0.5~3.0

加工型態 Processing Type	被加工材質 Machining Materials	刀片材質 Materials	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)	切深 Ap(mm)
	P 低合金鋼 Low-Alloy Steels	OM4010	220~290	0.01~0.03	0.05~1.0
		OM4025	220~260	0.01~0.03	0.05~1.0
	P 合金鋼 Alloy Steels	OM4010	80~150	0.01~0.03	0.05~1.0
		OM4025	100~150	0.01~0.03	0.05~1.0
	M 不鏽鋼 Stainless Steels	OM4010	90~200	0.01~0.03	0.05~1.0
		OM4025	90~180	0.01~0.03	0.05~1.0
	K 鑄鐵 Cast Iron	OM4025	70~130	0.03~0.06	0.05~2.0
	N 鋁合金 Aluminum&Al	OM5005	400~2000	0.03~0.06	0.05~3.0

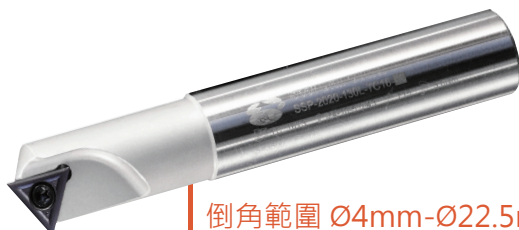
加工型態 Processing Type	被加工材質 Machining Materials	刀片材質 Materials	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)	切深 Ap(mm)
	P 低合金鋼 Low-Alloy Steels	OM4010	220~290	0.03~0.06	1.3~3.0
		OM4025	220~290	0.03~0.06	0.1~3.0
	P 合金鋼 Alloy Steels	OM4010	100~120	0.03~0.06	0.1~3.0
		OM4025	100~150	0.03~0.06	1.3~3.0
	M 不鏽鋼 Stainless Steels	OM4010	90~160	0.03~0.06	0.1~3.0
		OM4025	140~160	0.03~0.06	0.1~3.0
	K 鑄鐵 Cast Iron	OM4025	70~160	0.05~0.08	0.1~5.0
	N 鋁合金 Aluminum&Al	OM5005	400~1200	0.05~0.1	0.1~6.0

加工型態 Processing Type	被加工材質 Machining Materials	刀片材質 Materials	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)	切深 Ap(mm)
	P 低合金鋼 Low-Alloy Steels	OM4010	220~290	0.05~0.12	1.0~11.0
		OM4025	220~260	0.05~0.12	0.5~3.0
	P 合金鋼 Alloy Steels	OM4010	100~150	0.03~0.1	1.0~11.0
		OM4025	100~150	0.03~0.1	0.5~3.0
	M 不鏽鋼 Stainless Steels	OM4010	90~180	0.05~0.12	1.0~11.0
		OM4025	140~180	0.03~0.06	0.5~3.0
	K 鑄鐵 Cast Iron	OM4025	70~120	0.05~0.12	1.0~11.0
	N 鋁合金 Aluminum&Al	OM5005	400~750	0.05~0.12	0.5~3.0

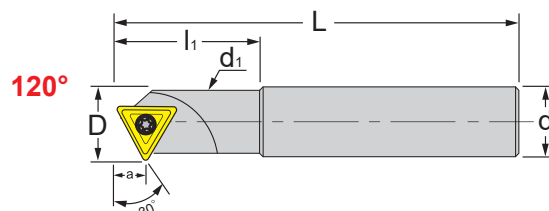


SSP 30°倒角刀

SSP 30° Indexable Chamfer Milling Cutter



倒角範圍 Ø4mm-Ø22.5mm
Chamfer Range Ø4 - Ø22.5mm

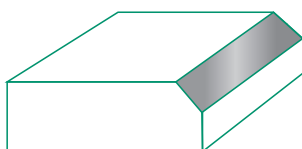


規格 Spec.	L	l ₁	D	d	d ₁	a	功能 Function	刀片 Insert	重量 (KGS) Weight
SSP-1212-105L-TC10-30	105	26	13.8	12	11.8	4.6	倒角 Chamfering	TC..1003	0.12
SSP-1616-110L-TC13-30	110	30	19.2	16	14	6.5	倒角 Chamfering	TC..13T3	0.18
SSP-2020-130L-TC16-30	130	50	22.5	20	19	7.6	倒角 Chamfering	TC..16T3	0.32

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
TC..1003	M2.5-5.0-3.7-43	T8	1.2
TC..13T3	M3.5-8.0-5.0-60	T15	3.0
TC..16T3	M4-10-5.0-43	T15	3.0

功能 Function



倒 角 chamfering

內孔倒角範圍 Inner Chamfering Range

Min.		Max.
4	TC..1003	13.8
4	TC..13T3	19.2
8	TC..16T3	22.5

外倒角距離 Outer Chamfering Range

-Z Max.
TC..1003 Max. 4.9mm
TC..13T3 Max. 6.4mm
TC..16T3 Max. 6.3mm

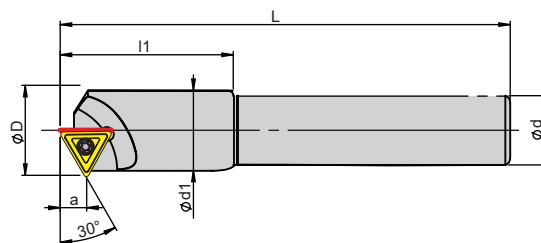


SSP 30°倒角刀

SSP 30° Indexable Chamfer Milling Cutter



倒角範圍 Ø1mm-Ø25mm
Chamfer Range Ø1 - Ø25mm

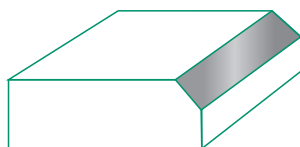


規格 Spec.	L	l ₁	D	d	d ₁	a	功能 Function	刀片 Insert	重量 (KGS) Weight
SSP-1512-105L-TC10-30	105	26	16	12	14.6	4.7	倒角 Chamfering	TC..1003	0.14
SSP-2116-110L-TC13-30	110	30	22.3	16	20	6.5	倒角 Chamfering	TC..13T3	0.2
SSP-2520-130L-TC16-30	130	50	26	20	23	7.6	倒角 Chamfering	TC..16T3	0.36

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
TC..1003	M2.5-5.0-3.7-43	T8	1.2
TC..13T3	M3.5-8.0-5.0-60	T15	3.0
TC..16T3	M4-10-5.0-43	T15	3.0

功能 Function

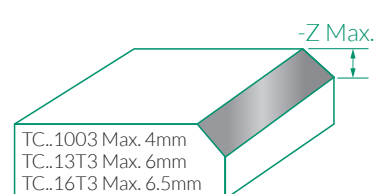


倒 角 chamfering

內孔倒角範圍 Inner Chamfering Range

Min.		Max.
1	TC..1003	15
1	TC..13T3	20
2	TC..16T3	25

外倒角距離 Outer Chamfering Range



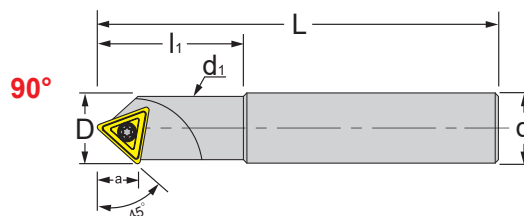


SSP 45°定位倒角刀

SSP 45° Indexable Spot & Chamfer Milling Cutter



倒角範圍 Ø1mm-Ø21mm
Chamfer Range Ø1mm-Ø21mm



規格 Spec.	L	l ₁	D	d	d ₁	a	功能 Function	刀片 Insert	重量 (KGS) Weight
SSP-1212-105L	105	26	13.4	12	11.8	6.05	倒角 / 定位 (04R 角) Chamfering/Spotting	TC..1003	0.12
SSP-1616-110L	110	30	19.2	16	14	9.7	倒角 / 定位 (04R 角) Chamfering/Spotting	TC..13T3	0.18
SSP-2012-100L	100	35	22.5	12	19	11.3	倒角 / 定位 (08R 角) Chamfering/Spotting	TC..16T3	0.16
SSP-2020-130L	130	50	22.5	20	19	11.3	倒角 / 定位 (08R 角) Chamfering/Spotting	TC..16T3	0.31

配件表 Accessories

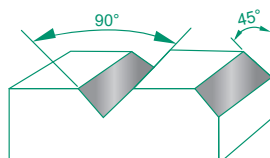
刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
TC..1003	M2.5-5.0-3.7-43	T8	1.2
TC..13T3	M3.5-8.0-5.0-60	T15	3.0
TC..16T3	M4-10-5.0-43	T15	3.0

功能 Function



倒角 chamfering
中心鑽 center drilling
V 槽 v-grooving

倒角角度 Chamfering Degree



內孔倒角範圍 Inner Chamfering Range

Min		Max
1	TC..1003	12
1	TC..13T3	18
1.7	TC..16T3	21

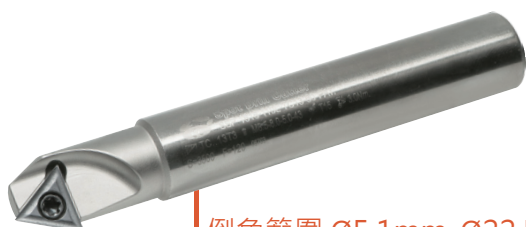
外倒角距離 Outer Chamfering Range

	-Z Max.
TC..1003	Max. 6mm
TC..13T3	Max. 8.5mm
TC..16T3	Max. 9.5mm

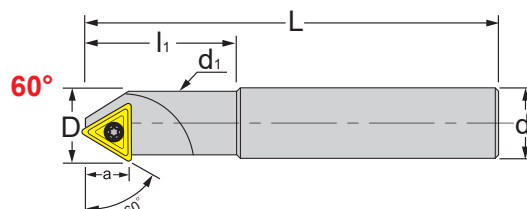


SSP 60°倒角刀

SSP 60° Indexable Chamfer Milling Cutter



倒角範圍 Ø5.1mm-Ø22.5mm
Chamfer Range Ø5.1 - Ø22.5mm

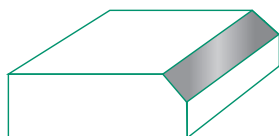


規格 Spec.	L	l ₁	D	d	d ₁	a	功能 Function	刀片 Insert	重量 (KGS) Weight
SSP-1212-105L-TC10-60	105	26	13.8	12	11.8	8.5	倒角 Chamfering	TC..1003	0.12
SSP-1616-110L-TC13-60	110	30	19.2	16	14	11.16	倒角 Chamfering	TC..13T3	0.18
SSP-2020-130L-TC16-60	130	50	22.5	20	19	11.83	倒角 Chamfering	TC..16T3	0.32

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
TC..1003	M2.5-5.0-3.7-43	T8	1.2
TC..13T3	M3.5-8.0-5.0-60	T15	3.0
TC..16T3	M4-10-5.0-43	T15	3.0

功能 Function



倒 角 chamfering

內孔倒角範圍 Inner Chamfering Range

Min.		Max.
5.1	TC..1003	13.8
7	TC..13T3	19.2
9	TC..16T3	22.5

外倒角距離 Outer Chamfering Range

-Z Max.
TC..1003 Max. 8.5mm
TC..13T3 Max. 11.1mm
TC..16T3 Max. 11.8mm

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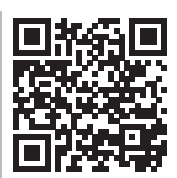
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