

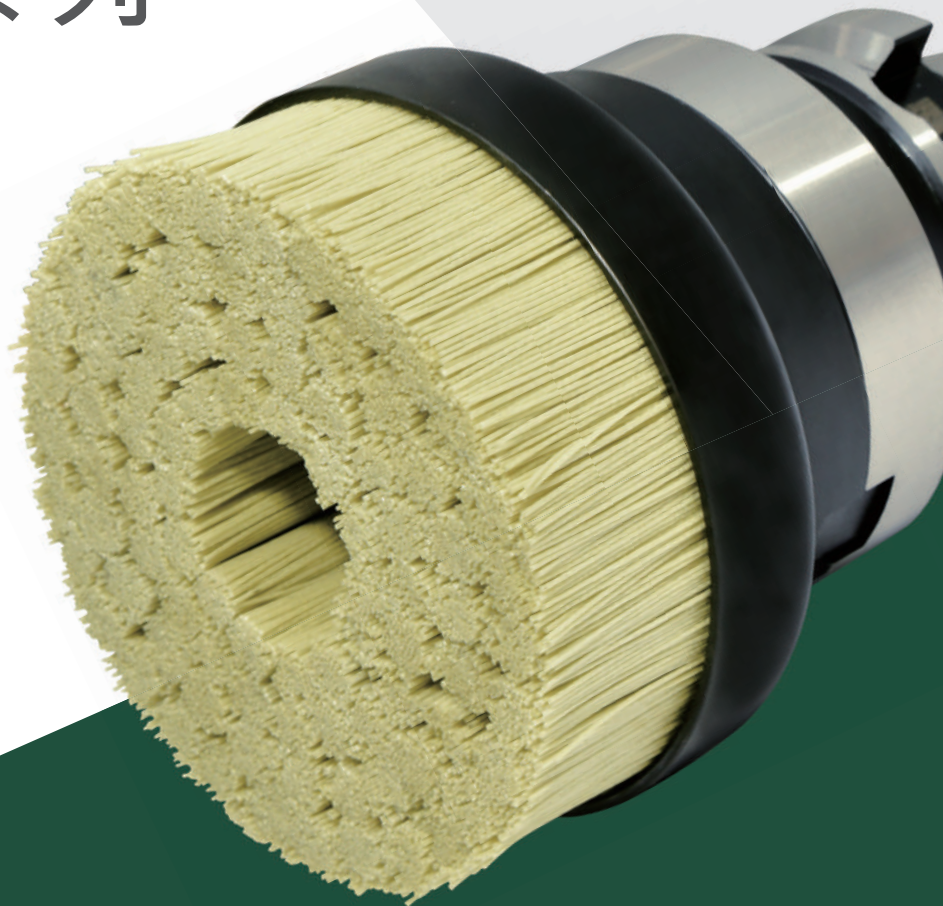


DEBURRING REMOVING MACHINING MARKS POLISHING

去毛刺系列

No. 230607004

- | 去除切削刀痕
- | 去除毛刺
- | 表面抛光



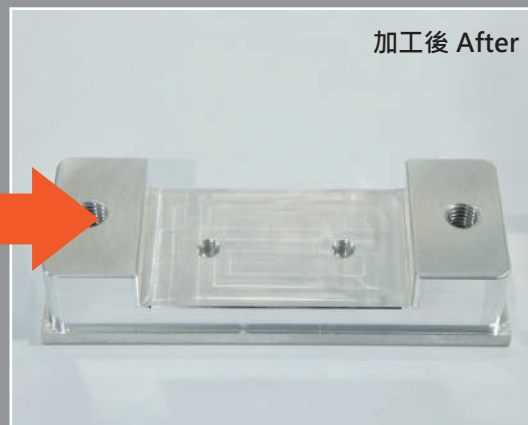
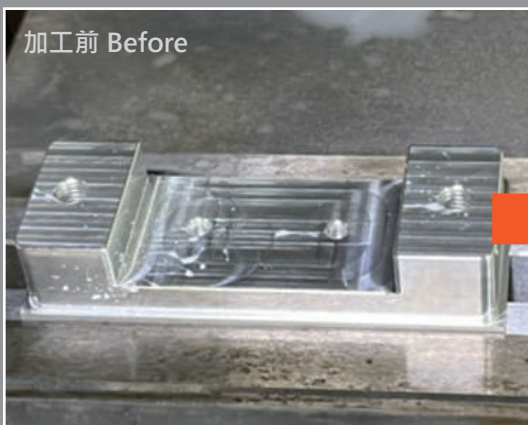
使用方法：

1. 因研磨路徑應完全大於工件，故選用研磨刷需大於工件加工徑。
2. 建議鑽石研磨刷下壓深度 A_p :0.5~2mm、轉速 S : 1000~4000 rpm，需搭配使用切削液冷卻。
3. 鑽石研磨刷的切削直徑在25%~45%，去毛刺效果最佳。
4. 去除邊緣的毛刺，如切削刀具銑削時主軸正轉，研磨刷轉向建議主軸逆轉使用。

Notice：

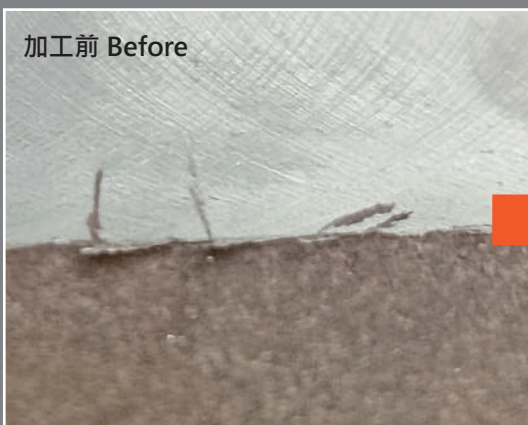
1. The diamond brush diameter must be larger than the workpiece diameter.
2. Recommend Parameter: A_p :0.5~2mm, S :1000~4000rpm
*Please machining with coolant fluid to cool down.
3. While deburring, please control A_e within 25%~45% to show perfect result.
4. If the spindle rotation is clockwise side while machining, please let the spindle rotation turn to counterclockwise side while do deburring, and vice versa.

去除切削刀痕 REMOVING MACHINING MARKS



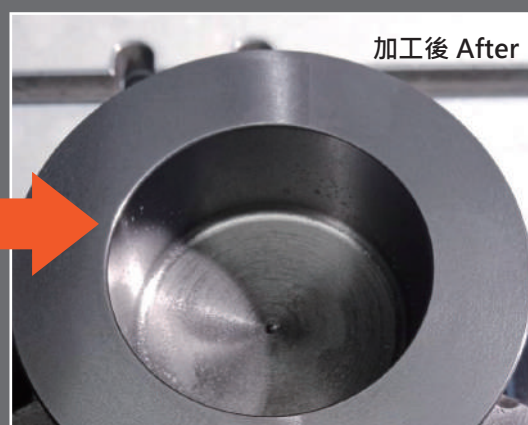
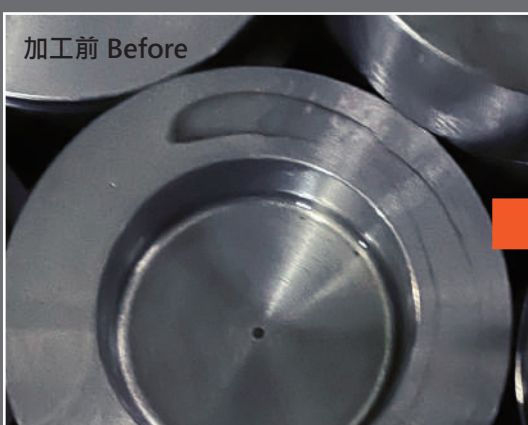
毛刷 Diamond Brush：
DMB100-32(#800/0.5D)
轉速 S ：3000
切深 A_p ：0.2mm
進給 F ：100
材質 Machining Materials：
鋁合金 Aluminum & Al

去除毛刺 DEBURRING



毛刷 Diamond Brush：
DMB100-32-200
轉速 S ：2000
切寬 A_e ：100
進給 F ：800
材質 Machining Materials：
中碳鋼 Medium Carbon Steel

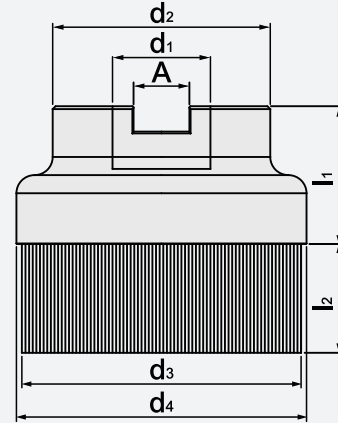
表面拋光 POLISHING



毛刷 Diamond Brush：
DMB80-27-200
轉速 S ：1800
切深 A_p ：0.2
進給 F ：200
材質 Machining Materials：
鑄鋼 Cast Iron

DMB 鑽石研磨刷

DMB DIAMOND BRUSH



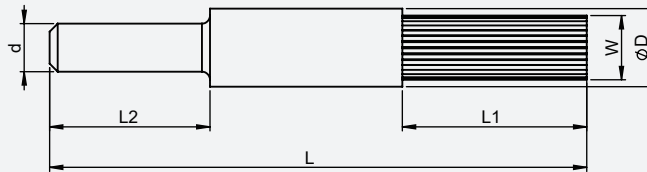
特點 Feature

- 依據不同需求選擇不同粒度研磨刷
粒度：#200、#400、#600、#800、#1000
 - 去除毛邊及達到拋光效果、刷毛具有強度高、回彈性好、耐疲勞。
 - 鑽石研磨刷可處理的最高硬度HRC 60°以內。
 - 鑽石研磨刷最高耐熱溫度180°以內。
- Choose different grit abrasive brushes according to different need
Granularity: #200, #400, #600, #800, #1000
 - Diamond brush has good wear resistance, bouncy, fatigue proof so it's perfect for deburring and polishing application.
 - Able to deal with workpiece within HRC60°.
 - Heat resistance within 180°

規格 Spec.	d1	d2	d3	d4	l1	l2	A
DMB50-22-S	FMB-22	50	47	50	30	30	10.4
DMB63-22-S	FMB-22	48	60	63	30	30	10.4
DMB80-27-S	FMB-27	60	77	80	38	30	12.4
DMB100-32-S	FMB-32	80	97	100	40	30	14.4

DMB 直柄鑽石研磨刷

DMB STRAIGHT SHANK DIAMOND BRUSH



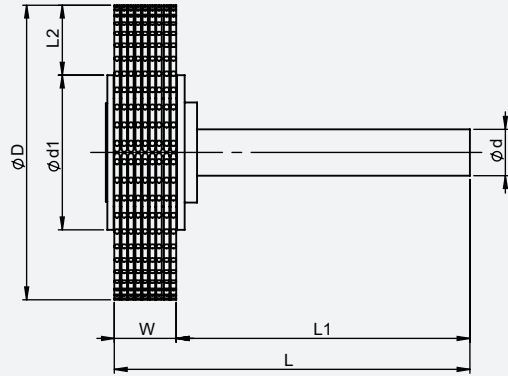
特點 Feature

- 粒度：#200
 - 去除毛邊及達到拋光效果、刷毛具有強度高、回彈性好、耐疲勞。
 - 鑽石研磨刷可處理的最高硬度HRC 60°以內。
 - 鑽石研磨刷最高耐熱溫度180°以內。
- Granularity: #200
 - Diamond brush has good wear resistance, bouncy, fatigue proof so it's perfect for deburring and polishing application.
 - Able to deal with workpiece within HRC60°.
 - Heat resistance within 180°

規格 Spec.	D	d	W	L1	L2	L
DMB-10-06-200	10	6	8	23	20	67
DMB-12-06-200	12	6	10	23	20	67
DMB-16-06-200	16	6	13	23	20	67
DMB-19-06-200	19	6	16	23	20	70
DMB-22-06-200	22	6	19	23	24	76
DMB-25-06-200	25	6	23	23	25	81

DMB 直柄T型鑽石研磨刷

DMB FLAT SHANK DIAMOND BRUSH



特點 Feature

- 粒度 : #200
- 去除毛邊及達到拋光效果、刷毛具有強度高、回彈性好、耐疲勞。
- 鑽石研磨刷可處理的最高硬度HRC 60°以內。
- 鑽石研磨刷最高耐熱溫度180°以內。

- Granularity: #200
- Diamond brush has good wear resistance, bouncy, fatigue proof so it's perfect for deburring and polishing application.
- Able to deal with workpiece within HRC60°.
- Heat resistance within 180°

規格 Spec.	d	d1	D	W	l1	L2	L
DMB-25.4-06T-200	6	13	25.4	8	38	6.2	46
DMB-38.1-06T-200	6	26	38.1	8	38	6.1	46
DMB-38.1-09T-200	6	20	38.1	8	38	9.1	46
DMB-38.1-12T-200	6	13	38.1	8	38	12.6	46
DMB-50.8-07T-200	6	35	50.8	8	38	7.9	46
DMB-50.8-12T-200	6	26	50.8	8	38	12.4	46
DMB-50.8-15T-200	6	20	50.8	8	38	15.4	46
DMB-63.5-09T-200	6	45	63.5	8	38	9.3	46
DMB-63.5-14T-200	6	35	63.5	8	38	14.3	46

※粒度#400 #600 #800 #1000接單生產

※Granularity: #400 #600 #800 #1000 made to order

使用毛刷前
BEFORE

使用毛刷後
AFTER

使用研磨刷相比設備拋光，可節省50% 時間。

Compare with other devices, DMB diamond brush saves 50% time to do polishing.

適合加工材質：
鋁、銅、金屬、鎳基合金、鎢鋼 (超硬合金)、硬脆材料。

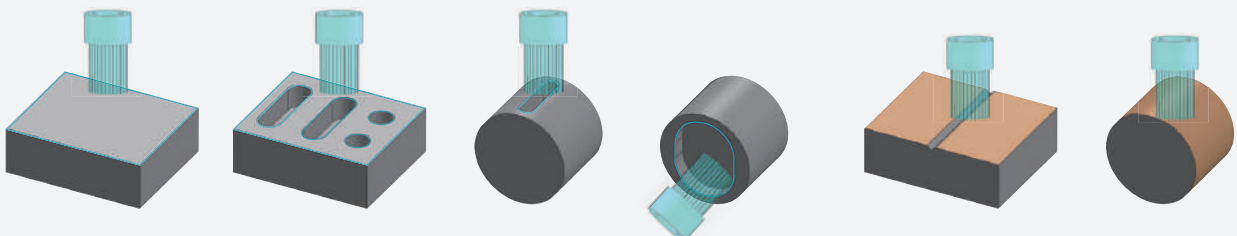
例：刀具鈍化、玻璃陶瓷、石英、鎳基合金和所有熱處理後之金屬的表面拋光。

Suitable Workpiece Materials :
Aluminum, copper, metal, nickel alloy, tungsten steel, hard and brittle materials.
e.g. Polishing for honing tools, glass-ceramic, quartz, nickel alloys, and heat-treated metals surfaces.

去除切削刀痕 Tool Marks Removal

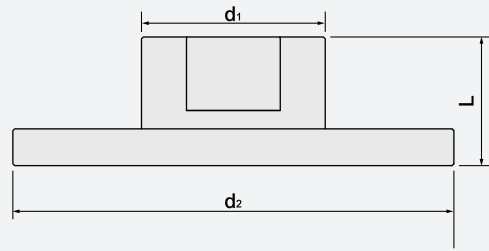
表面拋光 Polishing

去除毛刺 Deburring



DDB 鑽石整修板

DDB DIAMOND DRESSING BOARD

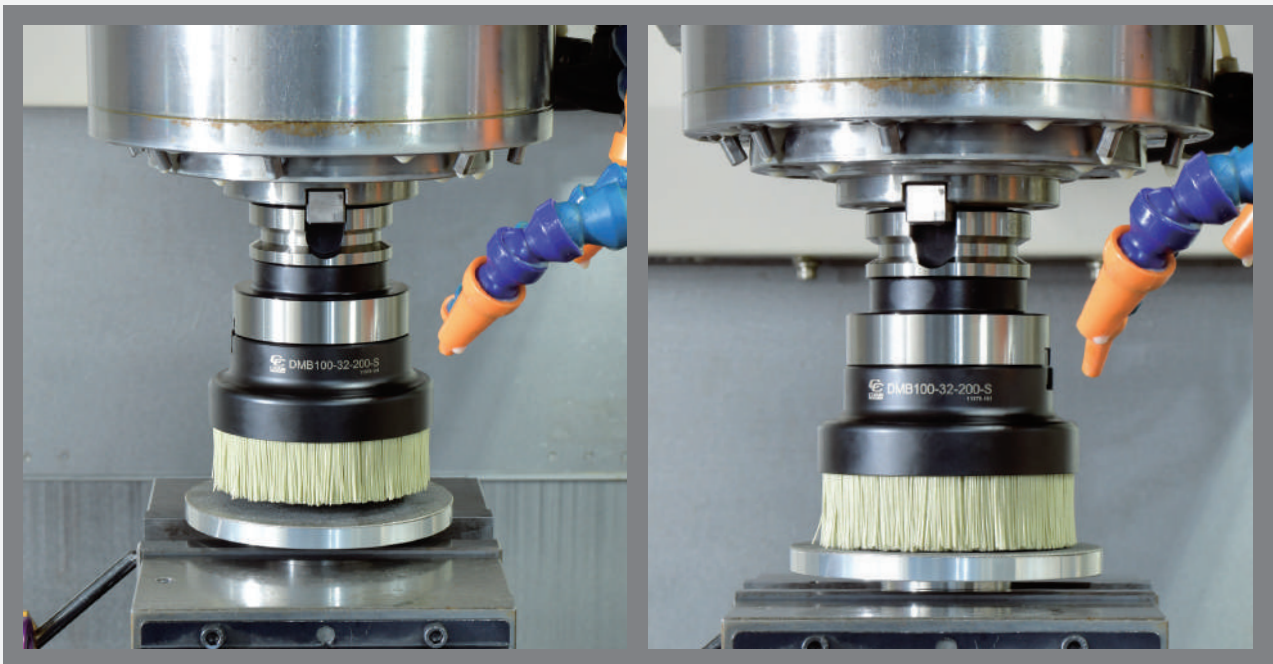


特點 Feature

- 加工後的毛刷若受損或磨耗，可用鑽石整修板，去除磨損毛刷，即可接續使用。
- We can use the diamond refurbish board to remove the damaged brush after machining.

規格 Spec.	L	d1	d2	重量 (KGS) Weight
DDB120	35	50	120	0.54

- 修砂時建議將研磨刷設定轉速 S=2000rpm 切深 AP=0.5mm 將研磨刷整平停留秒數 30 秒
- While repairing diamond brush, recommend setting: rotation speed S=2000rpm, depth of cut AP=0.5mm. Remember not to move the brush, finish setting the data and just hold on for 30 seconds.



- 修砂時建議將研磨刷設定轉速 S=2000rpm 切深 AP=0.5mm 將研磨刷整平停留秒數 30 秒
- While repairing diamond brush, recommend setting: rotation speed S=2000rpm, depth of cut AP=0.5mm. Remember not to move the brush, finish setting the data and just hold on for 30 seconds.



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