



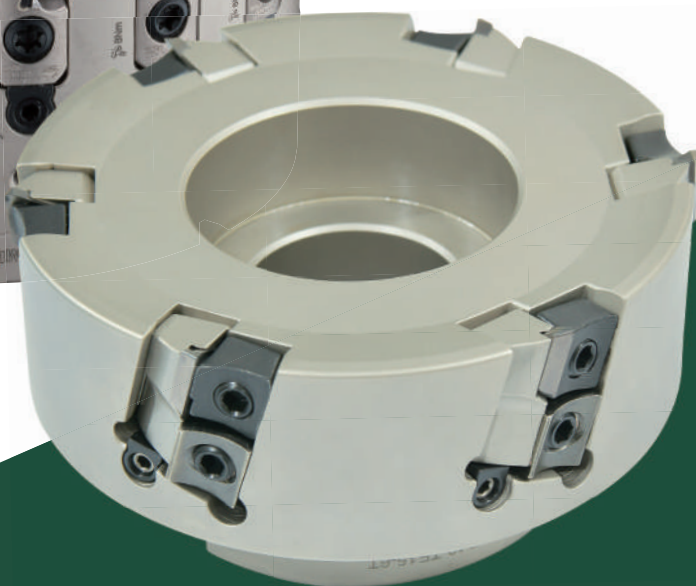
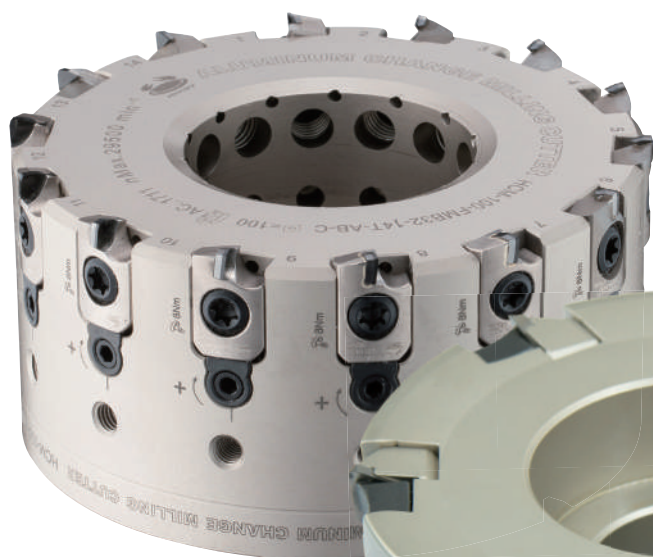
台灣專利證號 TW PAT. NO:
I573644

大陸專利證號 CN PAT. NO:
ZL201610285384.5

MICRO-ADJUSTMENT FINISH FACE MILL SERIES

微調精修面銑系列

No. 230831009



微調精修面銑刀系列 產品發展歷史

Micro-adjustment Finish Face Mill Development History



ACM 鋁合金替換式刀頭
ACM ALUMINUM
CHANGEABLE MILLING CUTTER



SCM 合金鋼替換式刀頭
SCM ALLOY STEEL
CHANGEABLE MILLING CUTTER

年度
Year

2005-2010

2010-2015



影片
Video



HCM 鋁合金密齒型替換式刀頭
HCM ALUMINUM
CHANGEABLE MILLING CUTTER



HCM 鋁合金密齒型替換式刀頭 (出水型)
HCM ALUMINUM
CHANGEABLE MILLING CUTTER (COOLANT TYPE)

2015-2020

2020-2023

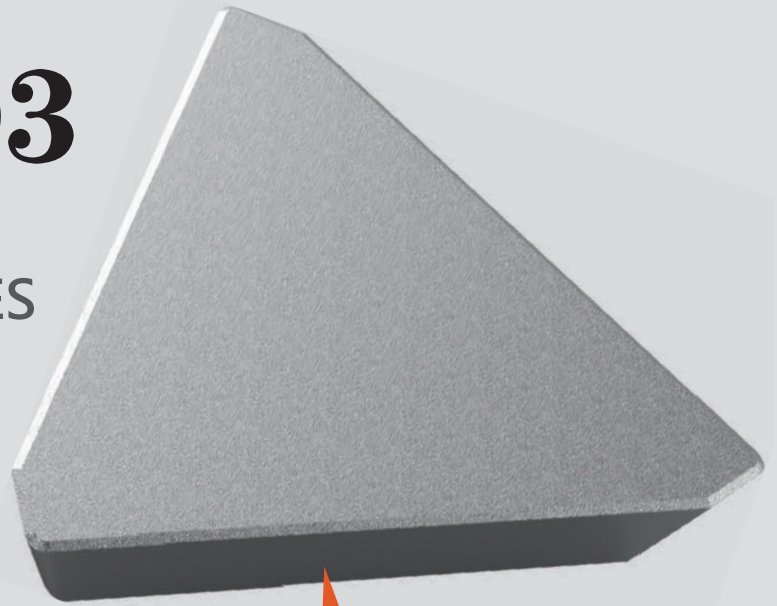


ATP 可調式三角刀片面銑刀具
ATP ADJUSTABLE
INDEXABLE FACE MILLING CUTTER

TEEN1503

刀片系列

MILLING INSERTS SERIES



金屬陶瓷刀片
Cermet Insert

- 可軸向調整 +1mm
- 刀具直徑 50~160mm
- Ra : 0.456 μ m
- Axial-side Adjustment:
+1mm
- Cutting Diameter:
50-160mm
- Ra : 0.456 μ m

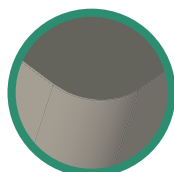
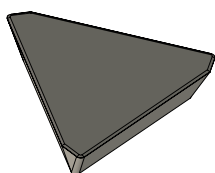




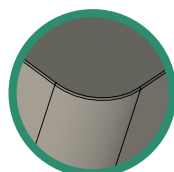
TEEN1503 刀片系列

TEEN1503 MILLING INSERTS

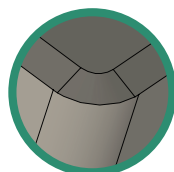
NEW



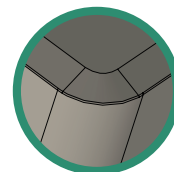
微量精加工
Micro Finish
Machining



一般精加工
General Finish
Machining



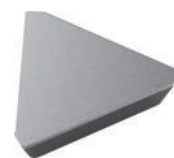
通用切削
General Cutting



強斷續切削
Strong Interrupted
Cutting



TEEN1503 刀片系列 TEEN1503 Milling Inserts Series



ISO 分類	P	合金鋼 Alloyed Steels	●	●	■	■														
	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.	瓷金 Cermet						瓷金鍍層 Cermet Coated		尺寸 (mm)				圖形 Drawing						
		HT						HT		Size										
		OM1205	OM1405	OM1205	OM1405	OM1205	OM1205	OM5435	OM5435	d	i	s	r							
	TEEN1503PEER1	●	●					●					9.22	-	3.18	-				
	TEEN1503PESR1			●	●				●				9.22	-	3.18	-				
	TEEN1503PEFR1					●							9.22	-	3.18	-				
	TEEN1503PETR1						●						9.22	-	3.18	-				

切削狀態 Cutting Condition:

- 連續切削 Continuous Cutting
- 一般切削 General Cutting
- 斷續切削 Interrupted Cutting

TE_1503 切削條件數據表 Cutting Parameter

被加工材質 Machining Materials	材質 Grade	規格 Spec.	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)
P 合金鋼 Alloyed Steels	OM1205	TEEN1503PEER1	140(100-220)	0.2(0.1-0.3)
		TEEN1503PESR1	140(100-220)	0.2(0.1-0.3)
	OM1405	TEEN1503PEER1	120(100-220)	0.15(0.1-0.3)
		TEEN1503PESR1	120(100-220)	0.15(0.1-0.3)
M 不鏽鋼 Stainless Steels	OM5435	TEEN1503PEER1	120(80-200)	0.2(0.1-0.3)
		TEEN1503PESR1	110(80-200)	0.15(0.1-0.3)
K 鑄鐵 Cast Iron	OM1205	TEEN1503PEFR1	160(100-220)	0.2(0.1-0.3)
		TEEN1503PETR1	150(100-220)	0.2(0.1-0.3)

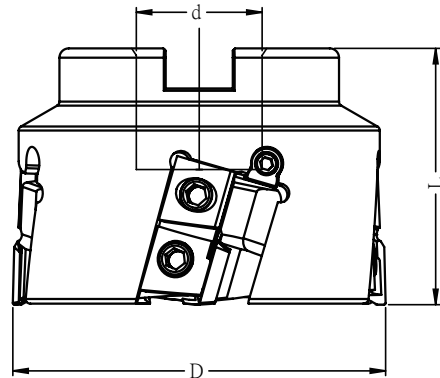
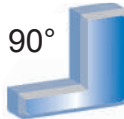
TEEN1503 刀片系列

TEEN1503 MILLING INSERTS



ATP 可調式三角刀片面銑刀具

ATP Adjustable Indexable Face Milling Cutter



特點 Feature

- 適用於各種材料的機械結構部件接觸面，高光面銑加工。
- 可進行高精度軸向調整 +1mm，使加工表面更細緻，表粗 Ra 可達 0.456 μ m。
- 刀片座定位設計，可防止高速旋轉切削時刀片座飛散，有效固定刀片座。
- 低切削阻力 16° 軸向大前角設計。
- Ideal for high surface roughness face milling, and suitable for varies materials of mechanical component contact surfaces.
- Be able to adjust the inserts height up to 1mm and achieve maximum Ra 0.456 μ m.
- Insert seat features a positioning design to secure the insert seat in place while cutting.
- Insert rake angle is 16°, which makes low resistance.

規格 Spec.	D	L	d	T	刀片 Insert	重量 (KGS) Weight
ATP-500-FMB22-TE15-3T	50	50	22	3	TE..1503	0.5
ATP-630-FMB22-TE15-4T	63	50	22	4	TE..1503	0.7
ATP-800-FMB27-TE15-4T	80	55	27	4	TE..1503	1.2
ATP-1000-FMB32-TE15-5T	100	55	32	5	TE..1503	2.1
ATP-1250-FMB40-TE15-6T	125	63	40	6	TE..1503	3.6
ATP-1600-FMB40-TE15-8T	160	63	40	8	TE..1503	6.8

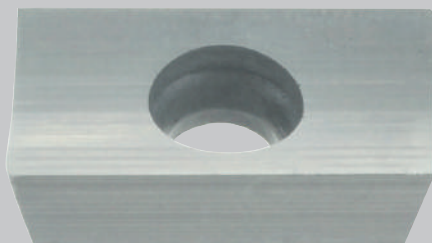
配件表 Accessories

刀片 Insert	刀片座 Insert Seat	壓板螺絲 Clamp Screw	刀片壓板 Insert Clamp	刀座壓板 Insert SeatClamp	扳手 Wrench	調整螺絲 Adjusting Screw	調整楔塊 Wedge
TEEN1503	ATP-1630-TE15	GCS816-3	GSC-08	GSC-01	PL4、PL2.5	M5-0.5P-LH-RH-17-P2.5	HCM-AW-8L

ACM / SCM

替換式刀頭系列

CHANGEABLE MILLING CUTTER SERIES



SE..1204
SE..12T3



AP..1604



RP..1204



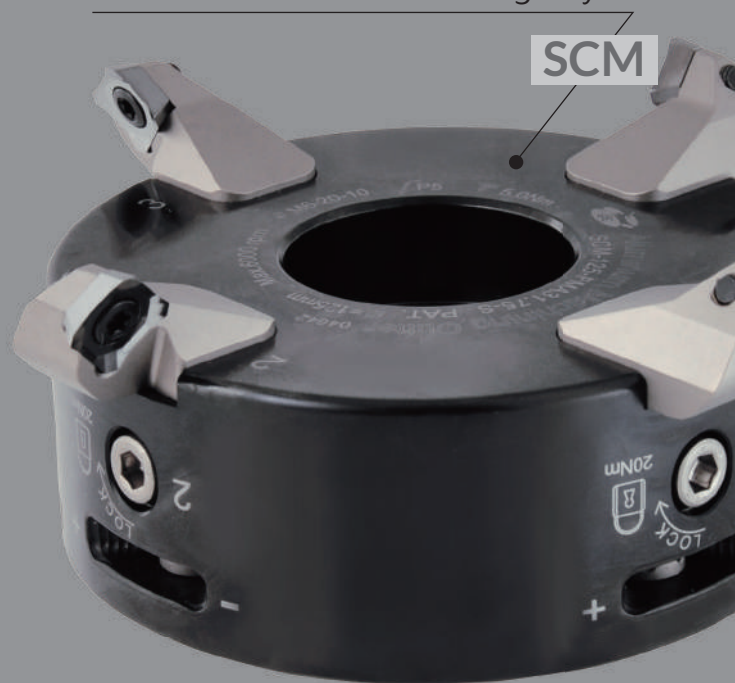
TE..1503

五種卡式刀座可替換

5 interchangeable cartridges are available.



特殊合金鋼材質，可提高剛性。
The alloy steel cutting head is anodized to increase the rigidity.



鋁合金材質，無電解鎳表面處理，可提高鋼性、增加耐磨性。

The aluminum alloy cutting head with electroless nickel surface treatment improve rigidity and increase wear resistance.



ACM / SCM 替換式刀頭系列

ACM / SCM CHANGEABLE MILLING CUTTER SERIES



ACM 鋁合金替換式刀頭刀片

ACM Aluminum Changeable Milling Cutter Insert

ISO 分類	P	合金鋼 Alloyed Steels													切削狀態 Cutting Condition :	
	M	不鏽鋼 Stainless Steels														● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting
	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.	聚晶鑽石 Polycrystalline diamond			超硬微粒 Ultra-hard microprogram					尺寸 (mm) Size				圖形 Drawing		
		DP			HF											
		PCD	PCD020	PCD100	GH1	GH05	OM5005	OM5060	RM5005	d	i	s	r			
	APEX1604PDFR-701											9.525	16.4	4.76	0.2	
	APEX1604PDFR-F01											9.525	16.4	4.76	-	
	APEX160400PDFR-F01											9.525	16.4	4.76	-	
	APEX160404PDFR-F01											9.525	16.4	4.76	0.4	
	APEX160408PDFR-F01											9.525	16.4	4.76	0.8	
	APGW160404PDFR-F01		●	●								9.525	16.5	4.76	-	
	APGW1604PDFR-F01		●	●								9.525	16.5	4.76	-	
	SEET13T3AGFN-F01											13.4	-	3.97	2.55	
	SEHT1204AFFN											12.7	-	4.76	-	
	SEGW120404AFFN-F01		●	●								12.7	-	4.76	-	
	SEGW1204AFFN-F01		●	●								12.7	-	4.76	-	
	RPET1204MOE-M01											12	-	4.76	6	

※ 相關 TEEN1503PEER1 刀片應用請參閱第 5 頁
The information related to insert TEEN1503PEER1, please refer to page.5.

ACM / SCM 替換式刀頭系列

ACM/SCM CHANGEABLE MILLING CUTTER SERIES



SCM 合金鋼替換式刀頭刀片

SCM Alloy Steel Changeable 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.	氮化硼 BN		鍍層超微粒 Layer coating ultra-micro					瓷金 Cermet		尺寸 (mm)				圖形 Drawing	
		BN		CHF					HF		Size					
		CBN250	CBN500	OM4010	OM4025	RM2140	RM4025	RM4130	OM1205	RM1205	d	i	s	r		
	APGW1604PDER	●										9.525	16.5	4.76	-	
	APGW1604PDFR	●										9.525	16.5	4.76	-	
	APGW1604PDTR	●										9.525	16.5	4.76	-	
	APGW1604PDSR	●										9.525	16.5	4.76	-	
	APKT160408-M01									●		9.525	16.3	4.76	0.8	
	SEGW1204AFSN	●										12.7	-	4.76	-	
	SEGW1204AFTN	●										12.7	-	4.76	-	
	SEGW1204AFEN	●										12.7	-	4.76	-	
	SEGW1204AFFN	●										12.7	-	4.76	-	
	★ SEHT1204AFEN-M01			●	●							12.7	-	4.76	Facet	
	SEKW1204AFN				●					●		12.7	-	4.76	-	
	SEMT13T3AGEN-M02					●	●									
	RPET1204MOE-M01			●	●							12	-	4.76	6	
	RPMT1204MON									●		12	-	4.76	6	

★ 推薦 Recommended

ACM / SCM 替換式刀頭系列

ACM/SCM CHANGEABLE MILLING CUTTER SERIES



ACM / SCM 替換式刀頭刀片

ACM/SCM Changeable Milling Cutter Insert

AP_16 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)	每刃進給 fz(mm/rev)	切深 Ap(mm)
P 低合金鋼 Low-Alloy Steels	OM4025	120~300	0.15~0.40	3.0~8.0
	OM4025N	120~300	0.15~0.40	3.0~8.0
	RM4130	60~300	0.10~0.25	3.0~8.0
合金鋼 Alloyed Steels	OM4025	80~180	0.15~0.35	3.0~8.0
	RM4130	60~300	0.10~0.25	3.0~8.0
	RM1205	100~330	0.08~0.30	3.0~8.0
M 不鏽鋼 Stainless Steels	OM4025	120~160	0.15~0.35	3.0~8.0
	RM4130	120~160	0.10~0.25	3.0~8.0
K 鑄鐵 Cast Iron	OM4025	160~250	0.15~0.30	3.0~8.0
	RM3130	160~250	0.15~0.30	3.0~8.0
N 鋁合金 Aluminum&Al	OM5005	400~1000	0.04~0.20	3.0~8.0
	OM5060	400~1000	0.04~0.20	3.0~8.0
	RM5005	400~1000	0.04~0.20	3.0~8.0
	GH05	300~800	0.04~0.20	3.0~8.0
	PCD100	1200~2000	0.04~0.20	0.5~1.0
H 高硬度材 Hard Material	CBN250	80~120	0.03~0.15	0.1~0.3

SE_12 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)	每刃進給 fz(mm/rev)	切深 Ap(mm)
P 低合金鋼 Low-Alloy Steels	OM4010	260~320	0.20~0.45	1.0~3.0
	OM4025	220~260	0.20~0.45	1.0~3.0
	RM4025	220~260	0.20~0.45	1.0~3.0
合金鋼 Alloyed Steels	OM1205	100~195	0.05~0.15	1.0~2.0
	OM4010	130~250	0.20~0.35	1.0~3.0
	OM4025	100~195	0.20~0.35	1.0~3.0
	RM4025	100~195	0.20~0.35	1.0~3.0
M 不鏽鋼 Stainless Steels	OM4010	180~220	0.10~0.30	1.0~2.0
	OM4025	140~180	0.10~0.30	1.0~2.0
	RM2140	130~250	0.10~0.30	1.0~2.0
	RM535	70~180	0.08~0.29	1.0~2.0
析出硬化系 Precipitation-Hardening	OM4010	90~120	0.15~0.20	0.2~1.0
	OM4025	70~85	0.15~0.20	0.2~1.0
K 鑄鐵 Cast Iron	OM4010	160~300	0.12~0.35	1.0~3.0
	OM4025	180~300	0.15~0.35	1.0~3.0
	CBN500	700~1500	0.06~0.10	0.1~0.2
N 鋁合金 Aluminum&Al	OM5060	500~850	0.15~0.35	3.6~6.0
	GH1	275~450	0.15~0.35	3.0~6.0
	PCD100	1000~2000	0.06~0.10	0.05~0.1
H 高硬度材 Hard Material	CBN250	80~120	0.03~0.15	0.1~0.3

ACM / SCM 替換式刀頭系列

ACM/SCM CHANGEABLE MILLING CUTTER SERIES



ACM / SCM 替換式刀頭刀片

ACM/SCM Changeable Milling Cutter Insert

RP_12 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)	每刃進給 fz(mm/rev)	切深 Ap(mm)	
P 低合金鋼 Low-Alloy Steels	OM4010	220~300	0.08~0.16	0.1~6.0	
	OM4025	180~220	0.08~0.16	0.1~6.0	
	RM4130	200~240	0.08~0.16	0.1~6.0	
	合金鋼 Alloyed Steel	OM4010	100~200	0.08~0.16	0.1~6.0
		OM4025	120~140	0.08~0.16	0.1~6.0
		RM4130	140~160	0.08~0.16	0.1~6.0
M 不鏽鋼 Stainless Steels	OM4010	80~140	0.08~0.14	0.1~3.0	
	RM4130	100~140	0.08~0.14	0.1~3.0	
K 鑄鐵 Cast Iron	OM4025	220~350	0.08~0.25	0.1~6.0	
N 鋁合金 Aluminum&Al	OM5005	700~1000	0.06~0.12	0.1~6.0	

TE_1503 切削條件數據表 Cutting Parameter

被加工材質 Machining Materials	材質 Grade	規格 Spec.	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)
P 合金鋼 Alloyed Steels	OM1205	TEEN1503PEER1	140(100-220)	0.2(0.1-0.3)
		TEEN1503PESR1	140(100-220)	0.2(0.1-0.3)
	OM1405	TEEN1503PEER1	120(100-220)	0.15(0.1-0.3)
		TEEN1503PESR1	120(100-220)	0.15(0.1-0.3)
M 不鏽鋼 Stainless Steels	OM5435	TEEN1503PEER1	120(80-200)	0.2(0.1-0.3)
		TEEN1503PESR1	110(80-200)	0.15(0.1-0.3)
K 鑄鐵 Cast Iron	OM1205	TEEN1503PEFR1	160(100-220)	0.2(0.1-0.3)
		TEEN1503PETR1	150(100-220)	0.2(0.1-0.3)

主軸轉速 = (1000 × 切削速度) ÷ (3.14 × 刀具外徑)
Spindle Speed = (1000 × Cutting speed) ÷ (3.14 × Cutter outer diameter).

床檯進給 (mm/min) = 每刃進給 × 刀具刃數 × 主軸轉速
Feeding Speed (mm/min) = Feed per Flutes × Flutes × Spindle speed.

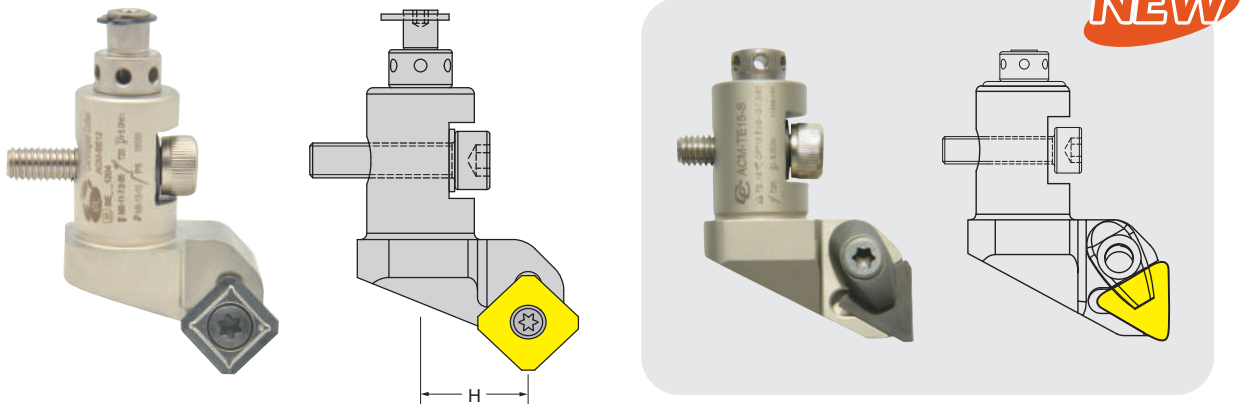
ACM / SCM 替換式刀頭系列

ACM/SCM CHANGEABLE MILLING CUTTER SERIES



ACM / SCM 替換式刀座

ACM/SCM Changeable Insert Seat



卡式刀座 Cartridges

規格 Spec.	H	刀片 Insert	重量 (KGS) Weight
ACM-SE12-S	-	SE..1204	0.11
● ACM-SE12-A-S	-3	SE..1204	0.11
● ACM-SE12-B-S	+3	SE..1204	0.11
● ACM-SE12-C-S	-2	SE..1204	0.11
● ACM-SE12-D-S	+2	SE..1204	0.11
● ACM-SE12-E-S	-1	SE..1204	0.11
● ACM-SE12-F-S	+1	SE..1204	0.11
ACM-SE12-L-S(左旋)	-	SE..1204	0.11
ACM-AP16-S	-	AP..1604	0.13
ACM-RP12-S	-	RP..1204	0.13
● ACM-SE12T3-S	-	SE..12T3	-
ACM-TE15-S	-	TE..15T3	-

● - 按訂單生產 -Make to order.

配件表 Accessories

刀片 Insert	螺絲 Screw	壓板 Clamp	扳手 Wrench	扭力值 (N.m) Torque
SE..1204	M5-11-7.0-55	-	T20	5.0
AP..1604	M4-10-5.7-60	-	T15	3.0
RP..1204	M4-10-5.0-43	-	T15	3.0
SE..12T3	M3.5-11.7-5.3-60	-	T15	3.0
TE..1503	M5-12-7.3-60	CPT15	T20	5.0

標準配件
Standard Accessories

調整螺絲 Adjust Screw	側固螺絲 Fixed Screw	G 型扣環 G-Type Ring	墊片 Shim	調整扳手 Adjust Wrench	PL 型扳手 PL-Type Wrench	PL 型扳手 PL-Type Wrench
AD-M6	M6-20	GTW-6.7	W-0.5	ADW-2	PL3	PL5

選配特別附件
Optional

彈簧鉗 Spring Pliers
F-26

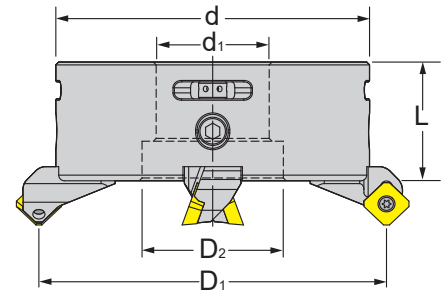
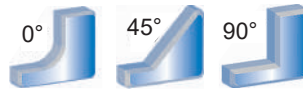
ACM / SCM 替換式刀頭系列

ACM/SCM CHANGEABLE MILLING CUTTER SERIES



ACM 鋁合金替換式刀頭

ACM Aluminum Changeable Milling Cutter



特點 Feature

- 刀具結合方式採取內包覆式，可降低切削高速迴轉所產生的風阻現象，進而提高切削效率
- 刀具與刀頭定位方式為方型緊配，利於刀具定位
- 利用精密電腦程式計算使其輕量化，減少刀具與刀頭重量
- 刀頭材料採用特殊鋁合金，可提高剛性

- Insert-embedded design reduce wind resistance, improve cutting efficiency.
- Close fit between insert holder and cutter. Insert holder can be well positioned.
- Light weight, reduced weight on insert holder and cutter.
- Made of specific aluminum alloy, enhanced high rigidity.

規格 Spec.	L	D ₁	D ₂	d	d ₁	刃數 Flutes		刀座 Insert Seat	螺絲 Screw	淨量 (KGS) Weight	重量 (KGS) Weight
						標準 Standard	選配 Option				
ACM-80-FMB22-S	42	80	18	66	22	4	-	ACM-SE12 ACM-AP16 ACM-RP12 ACM-SE12T3 ACM-TE15	SH-M6-20	0.62	2.60
ACM-80-FMA25.4-S	42	80	20	66	25.4	4	-		SH-M6-20	0.64	2.90
ACM-100-FMB22-S	42	100	18	86	22	4	-		SH-M6-25	-	2.86
ACM-100-FMA25.4-S	42	100	20	86	25.4	4	-		SH-M6-25	0.90	2.80
ACM-125-FMB32-S	42	125	42	111	32	4	-		SH-M6-25	-	3.62
ACM-125-FMA31.75-S	42	125	42	111	31.75	4	-		SH-M6-25	1.16	3.15
ACM-160-FMB40-S	42	160	50	146	40	4	4		SH-M6-25	1.74	3.79
ACM-160-FMA38.1-S	42	160	46	146	38.1	4	4		SH-M6-25	1.76	3.60
ACM-200-FS60F-S	45	200	60	186	60	4	4		SH-M6-25	2.52	6.62
ACM-200-FMA38.1-S	45	200	48	186	38.1	4	4		SH-M6-25	2.50	7.03
ACM-200-FMA47.625-S	45	200	47.625	186	47.625	4	4		SH-M6-25	2.56	6.44
ACM-250-FS60F-S	47	250	60	236	60	4	8		SH-M6-25	3.86	8.40
ACM-250-FMA38.1-S	47	250	48	236	38.1	4	8		SH-M6-25	4.06	8.26
ACM-250-FMA47.625-S	47	250	47.625	236	47.625	4	8		SH-M6-25	4.00	7.92
ACM-315-FS60F-S	47	315	60	301	60	4	12		SH-M6-25	6.32	10.35
ACM-315-FMA38.1-S	47	315	48	301	38.1	4	12		SH-M6-25	-	10.24
ACM-315-FMA47.625-S	47	315	47.625	301	47.62	4	12		SH-M6-25	6.32	10.80
ACM-400-FMA47.625	47	400	47.625	386	47.625	4	12		SH-M6-25	10.10	21.76

● S- 為雙微調 S: dual micro-adjustment

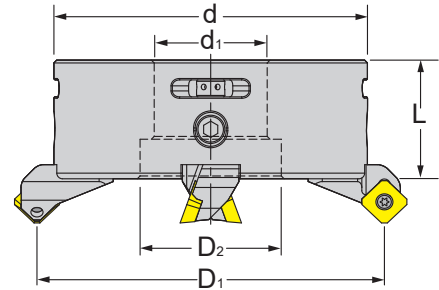
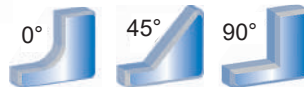
ACM / SCM 替換式刀頭系列

ACM/SCM CHANGEABLE MILLING CUTTER SERIES



SCM 合金鋼替換式刀頭

SCM Alloy Steel Changeable Milling Cutter



特點 Feature

- 刀具結合方式採取內包覆式，可降低切削高速迴轉所產生的風阻現象，進而提高切削效率
- 刀具與刀頭定位方式為方型緊配，利於刀具定位
- 利用精密電腦程式計算，減少刀具與刀頭重量輕量化
- 刀頭材料採用特殊合金鋼，可提高剛性
- Insert-embedded design, wind resistance can be reduced.
- Close fit between cartridge and cutter. Cartridge can be well positioned.
- Light weight, reduced weight on cartridge and cutter.
- Cutters are made of specific alloy steel, high rigidity.

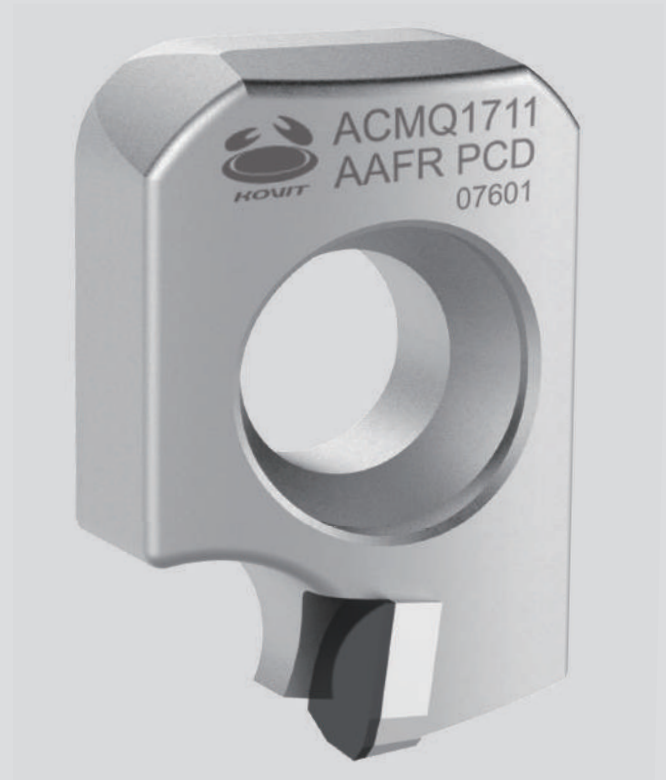
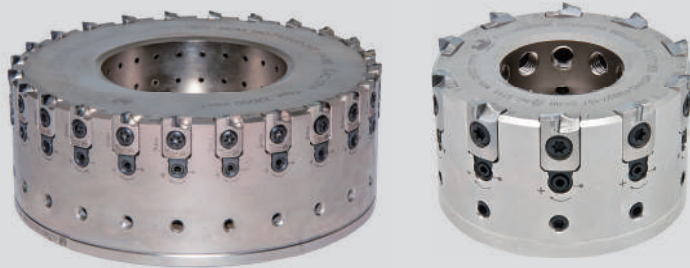
規格 Spec.	L	D ₁	D ₂	d	d ₁	刀數 Flutes		刀座 Insert Seat	螺絲 Screw	淨量 (KGS) Weight	重量 (KGS) Weight
						標準 Standard	選配 Option				
SCM-80-FMB22-S	42	80	18	66	22	4	-	ACM-SE12 ACM-AP16 ACM-RP12 ACM-SE12T3 ACM-TE15	SH-M6-20	1.06	2.96
SCM-80-FMA25.4-S	42	80	20	66	25.4	4	-		SH-M6-20	1.02	3.00
SCM-100-FMB22-S	42	100	18	86	22	4	-		SH-M6-25	1.76	3.72
SCM-100-FMA25.4-S	42	100	20	86	25.4	4	-		SH-M6-25	1.74	4.15
SCM-125-FMB32-S	42	125	42	111	32	4	-		SH-M6-25	2.60	4.56
SCM-125-FMA31.75-S	42	125	42	111	31.75	4	-		SH-M6-25	2.52	4.86
SCM-160-FMB40-S	42	160	50	146	40	4	4		SH-M6-25	4.12	6.09
SCM-160-FMA38.1-S	42	160	46	146	38.1	4	4		SH-M6-25	4.20	6.45
SCM-200-FS60F-S	45	200	60	186	60	4	4		SH-M6-25	6.06	10.50
SCM-200-FMA38.1-S	45	200	48	186	38.1	4	4		SH-M6-25	6.46	10.40
SCM-200-FMA47.625-S	45	200	47.625	186	47.625	4	4		SH-M6-25	6.43	14.60
SCM-250-FS60F-S	47	250	60	236	60	4	8		SH-M6-25	10.54	14.50
SCM-250-FMA38.1-S	47	250	48	236	38.1	4	8		SH-M6-25	10.98	14.70
SCM-250-FMA47.625-S	47	250	47.625	236	47.625	4	8		SH-M6-25	10.70	14.66

● S- 為雙微調 S: dual micro-adjustment

HCM

鋁合金密齒型 替換式刀頭系列

ALUMINUM CHANGEABLE
MILLING CUTTER SERIES



- 輕量化鋁合金本體
- 刀座 V 槽定位設計，讓加工更穩定
- 軸向動平衡及出水結構設計
- 可進行 μ 級調整

- Light-weight aluminum body.
- V-groove positioning for superior stability.
- Axial dynamic balance and through-hole coolant system.
- Adjustable for micrometer.



HCM 刀片座

HCM Insert Seat

聚晶
PCD

立方
氮化硼
CBN

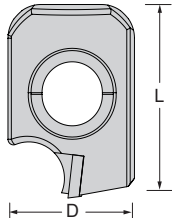


Fig.1

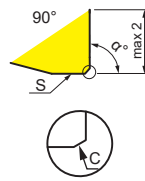


Fig.2

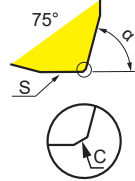
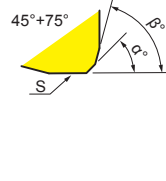


Fig.3

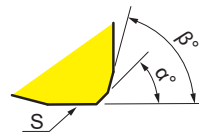
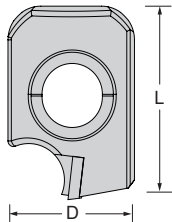


適合刀具 Cutting Tool	規格 Spec.	聚晶鑽石 Polycrystalline Diamond		立方氮化硼 CBN		尺寸 (mm)						最大切深 Cutting Max.	Fig.
		DP		CBN		Size						mm	
		PCD		CBN250		L	D	α°	β°	S	C	AP	
HCM	ACMQ1711PAFR	●		●		17	11	90°	-	1.2	0.15	2	1
	ACMQ1711EAFR	●		●		17	11	75°	-	1.2	0.15	2	2
	ACMQ1711AAFR	●		●		17	11	45°	75°	1.2	-	1.13	3

※ 如有特殊角度需求，請與我司聯繫 Please contact us for specific angle requirements.

聚晶
PCD

立方
氮化硼
CBN



修光刃刀片 Wiper inserts:

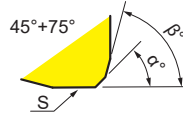
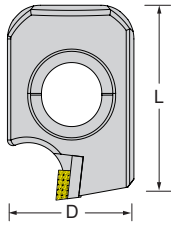
適合刀具 Cutting Tool	規格 Spec.	聚晶鑽石 Polycrystalline Diamond		立方氮化硼 CBN		尺寸 (mm)						最大切深 Cutting Max.
		DP		CBN		Size						mm
		PCD		CBN250		L	D	α°	β°	r	C	AP
HCM	ACMQ1711AAFR-R300	●		●		17	11	45°	75°	300	-	2
	ACMQ1711AAFR-R500	●		●		17	11	45°	75°	500	-	1.13

※ 如有特殊角度需求，請與我司聯繫 Please contact us for specific angle requirements.

HCM 鋁合金密齒型替換式刀頭系列

HCM ALUMINUM CHANGEABLE MILLING CUTTER SERIES

單晶
MD



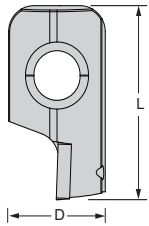
單晶刀片 Monocrystalline Diamond Insert:

適合刀具 Cutting Tool	規格 Spec.	單晶鑽石 Single crystal diamond				尺寸 (mm)						最大切深 Cutting Max.
		MD				Size						mm
		MD100				L	D	α°	β°	S	C	AP
HCM	ACMQ1711ACFR	●				17	11	45°	75°	1.2	-	1.13



HCM 捨棄式刀片座

HCM Indexable Insert Seat



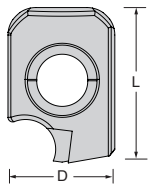
規格 Spec.	L	D	刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque	重量 (KGS) Weight
ACMQ1711-TB06	22.13	11	TB..0601	M2-5.0-2.7-60	T6	0.6	0.02

※ 可自行搭配刀片材質 Can collocation insert material.



HCM 刀片基座

HCM Insert Base Seat



規格 Spec.	L	D	重量 (KGS) Weight
ACMQ1711-AS	17	11	0.02

※ 可用於刀頭配重或自行焊接各項材質 Can be used for weight or self-welding head of the material.

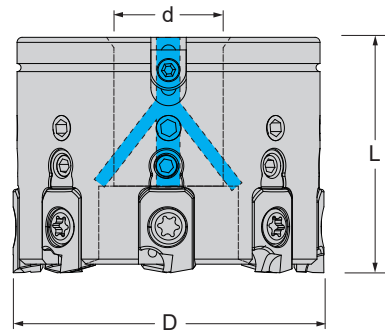
HCM 鋁合金密齒型替換式刀頭系列

HCM ALUMINUM CHANGEABLE MILLING CUTTER SERIES



HCM 鋁合金密齒型替換式刀頭

HCM Aluminum Changeable Milling Cutter

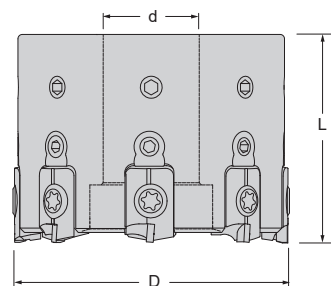


特點 Feature

- 輕量化鋁合金本體
- 刀座 V 槽定位設計 · 讓加工更穩定
- 可進行 μ 級調整
- 軸向動平衡及出水結構設計

- Lightweight aluminum body.
- V-groove positioning design and results to stable process.
- μ grade can be adjusted.
- Axial dynamic balance and through-tool coolant system.

規格 Spec.	D	L	d	刃數 T	建議最高轉速 Spindle speed max	淨重 (KGS) Weight	重量 (KGS) Weight
HCM-50-FMB16-6T-AB-C	50	48	16	6	max. 33000rpm	0.20	1.26
HCM-63-FMB22-8T-AB-C	63	48	22	8	max. 33000rpm	0.30	1.40
HCM-80-FMB27-10T-AB-C	80	50	27	10	max. 33000rpm	0.48	1.60
HCM-100-FMB32-14T-AB-C	100	50	32	14	max. 29500rpm	0.81	2.02
HCM-125-FMB40-18T-AB-C	125	63	40	18	max. 25500rpm	1.88	3.68



特點 Feature

- 輕量化鋁合金本體
- 刀座 V 槽定位設計 · 讓加工更穩定
- 可進行 μ 級調整

- Lightweight aluminum body.
- V-groove positioning design and results to stable process.
- μ grade can be adjusted.

規格 Spec.	D	L	d	刃數 T	建議最高轉速 Spindle speed max	淨重 (KGS) Weight	重量 (KGS) Weight
HCM-160-FMB40-24T	160	63	40	24	max. 22200rpm	2.48	6.65
HCM-200-FS60F-28T	200	63	60	28	max. 18100rpm	3.42	7.56
HCM-250-FS60F-36T	250	63	60	36	max. 14500rpm	6.50	10.58
HCM-315-FS60F-46T	315	80	60	46	max. 11500rpm	12.44	16.60
HCM-400-FS60F-58T	400	80	60	58	max. 9000rpm	20.76	28.22

HCM 鋁合金密齒型替換式刀頭系列

HCM ALUMINUM CHANGEABLE MILLING CUTTER SERIES

標準配件 Standard Accessories:

調整楔塊 Wedge Adjustment	牙套 Flutes Sleeve	刀片座螺絲 Insert Holder Screw	雙頭螺絲 Both Headed Screw	動平衡螺絲 Balance Screw
HCM-AW-8L	M8-1.25P-M5-0.8P-10L	M5-13.3-7.0-60-T25	M5-0.5P-LH-RH-17-P2.5	M5-0.8P-10L
TW 扭力起子 TW Torque Driver	50mm 起子頭 50mm Bits Torx	T 型扳手 T-type Wrench	L 型星型扳手 L-type Wrench	
TW-80-SB	BIT-T25-50L	PT2.5	T25	

切削數據表 Cutting Parameter

	材料 Materials	材料編號 Materials examples	抗拉強度 Strength (N/mm ²)	線速度 Vc(m/min)	每刃進給量 f(mm/rev)	
					Ap<1mm	Ap:1~2mm
N	鋁合金 (Aluminium)	鋁合金 (Al99)		max.6000	0.1~0.2mm/rev	0.05~0.1mm/rev
	鋁合金 (Aluminium) 7% 矽 (Si)	鑄造鋁合金 (AlSi7)				
	鋁合金 (Aluminium) 7-12% 矽 (Si)	鋁合金 (AlSi9) 鋁合金 (AlSi9Cu)				
	鋁合金 (Aluminium) 12% 矽 (Si)	鋁合金 (AlSi12) 鋁合金 (AlSi17)		max.2000		
	銅 (Copper) 非合金鋼 (unalloyed)	銅合金 (SE-Cu)	< 300	max.6000		
	銅 (Copper)	銅錫合金 (CuSn6)	> 300	max.2000		
	黃銅 (Brass) 青銅 (bronze) 紅銅 (red brass)	銅錫合金 (CuZn33) 銅合金 (CuAl9Mn3)	< 1.200			
	石墨 (Graphite)	-				
	塑料 (Plastic) 熱可塑性樹脂 (Thermoplastics)	尼龍 (PA), 塑膠 (PE), 聚碳酸酯 (PC), 聚苯乙烯 (PS), 聚氯乙烯 (PVC), 聚丙烯 (PP), 聚四氟乙烯 (PTFE), 聚甲醛 (POM), 聚甲基丙烯酸甲酯 PMMA				
塑料 (Plastic) 熱固性塑膠 (Thermoset plastics)	聚氨酯 (PU), 電木粉 (PF), 環氧樹脂 (EP), 聚酯樹脂 (UP), 塑膠 (VE), 氯丁橡膠 (CR)					
O	塑料 (Plastic matrix) 碳纖維複合材料 (CFRP/GFRP)	聚酯 (IMS), 高溫合金 (HTA)		Max.100~500	0.1~0.4mm/rev	0.1~0.2mm/rev
	塑料 (Plastic matrix) 碳纖維複合材料 (CFRP/GFRP)	玻璃纖維 (GMT-PP), 聚醚醚酮 (PEEK)				
	碳纖維複合材料 Carbon matrix 碳纖維強化碳基複合材料 carbon fibre reinforced (CFC)	碳纖維 (CF222, CF225, CF226, CF227, CF260)		Max. 100~300	0.1~0.2mm/rev	0.05~0.1mm/rev



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