

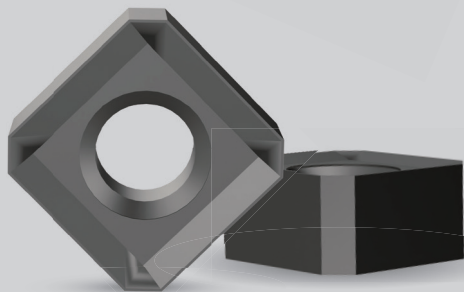
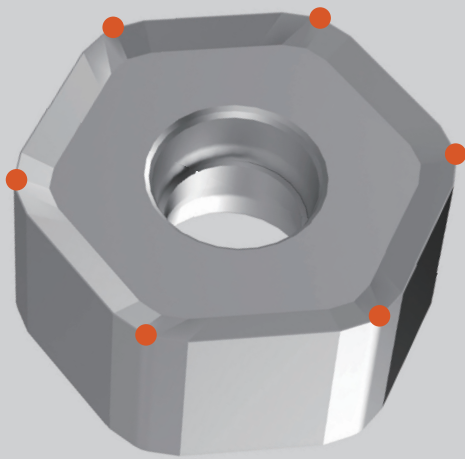


NEGATIVE RAKE ANGLE INSERT SERIES

負角刀片系列

No. 230717006





- SN../8刃、HN/12刃，
低刀具成本。
- 修光刃設計降低粗糙度。
- 切刃倒角縮小工件毛邊。
- SN../8 cutting edge、
HN/12 cutting edge,
effective cost-saving.
- The design of wiper
inserts decrease
roughness.
- Chamfering cutting
edges make workpiece's
burrs smaller.



負角刀片選用 NEGATIVE INSERTS APPLICATION

| 負角刀片 Negative Insert | 加工類型 Machining Type | 銑削方式 Cutting Method | 切削深度 Ap | 加工材質 Machining Materials |
|-------------------------|------------------------|--|------------|-----------------------------|
| SN..12 | 粗加工 Roughing | 面銑、肩銑 Face milling, Shoulder milling | 1~3 | P K |
| HN..06 | 中精加工 Semi-finishing | 面銑 Face milling | 0.5~2.5 | P M K N |
| LN..03 | 粗加工 Roughing | 高進給銑削 High feed milling | 1 | P K H |

| ISO 分類 | P | 合金鋼 Alloyed Steels | ○ | ○ | | | | | | | | | | | | 切削狀態 Cutting Condition : | |
|-------------|------------------------|--------------------------------------|--------|--------|--------|--------|--------|----|--------|--|---|-----------------|------|------|------|--------------------------|---|
| | M | 不鏽鋼 Stainless Steels | ○ | ○ | ○ | ○ | | | | | | | | | | | <ul style="list-style-type: none"> ● 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. | 鍍層超微粒 Layer Coated micro grain | CHF | | | | | HF | | | | 尺寸 (mm) Size | | | | 圖形 Drawing | |
| | | | RM1125 | OM4025 | OM5035 | RM4025 | RM3130 | | OM5005 | | | | d | i | s | | r |
| | | | | | | | | | | | | | | | | | |
| | HNGX0604ANEN-M01 | | | ● | ● | | | | | | | | 10.5 | - | 5.2 | - | |
| | HNGX0604ANFN-F01 | | | | | | | | ● | | | | 10.5 | - | 5.2 | - | |
| | LNMU0303ZER-MJ | | ● | | | | | | | | | | 6 | 11.9 | 4.3 | 1.2 | |
| | | | | | | | | | | | | | | | | | |
| | SNMU1206ANEN-M01 | | | | | ● | ● | | | | | | 12.7 | - | 6.35 | - | |
| | | | | | | | | | | | | | | | | | |

LN_03 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) |
|------------------------------|---------------|-------------------|--------------------|
| P 合金鋼 Alloyed Steels | RM1125 | 150(100~200) | 0.7(0.5~1.2) |
| K 鑄鐵 Cast Iron | RM1125 | 150(80~250) | 0.7(0.5~1.2) |

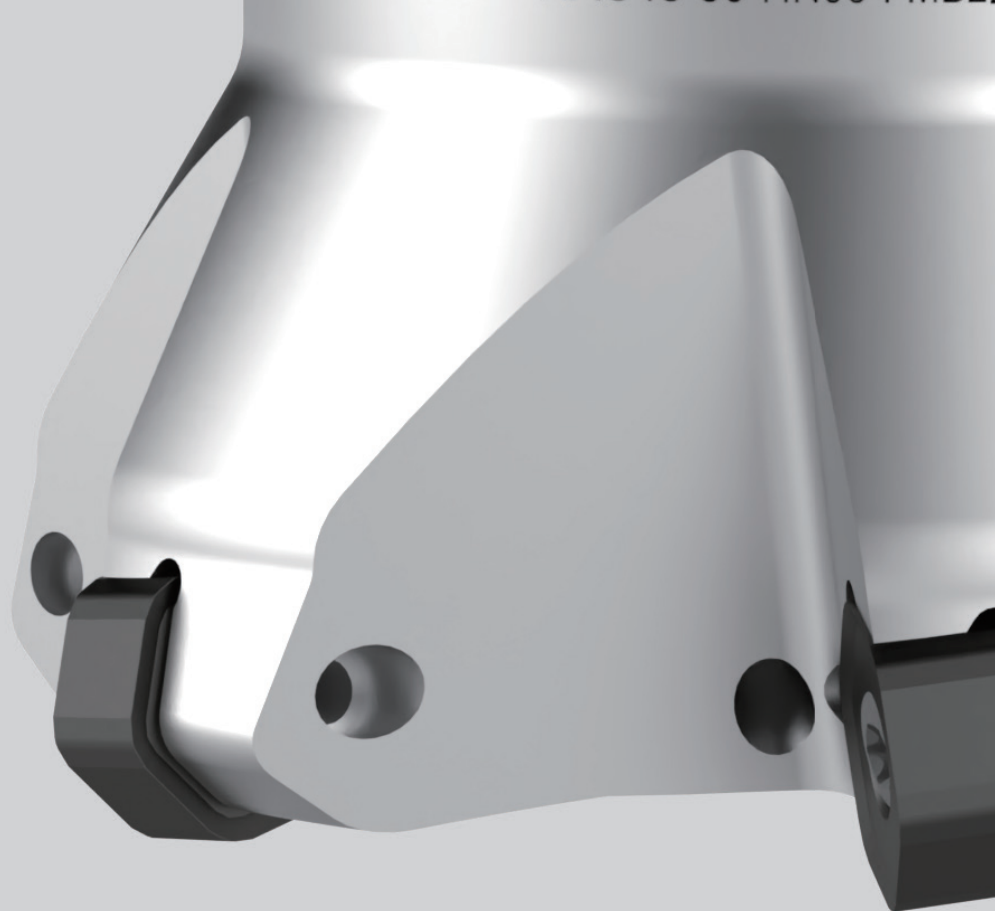
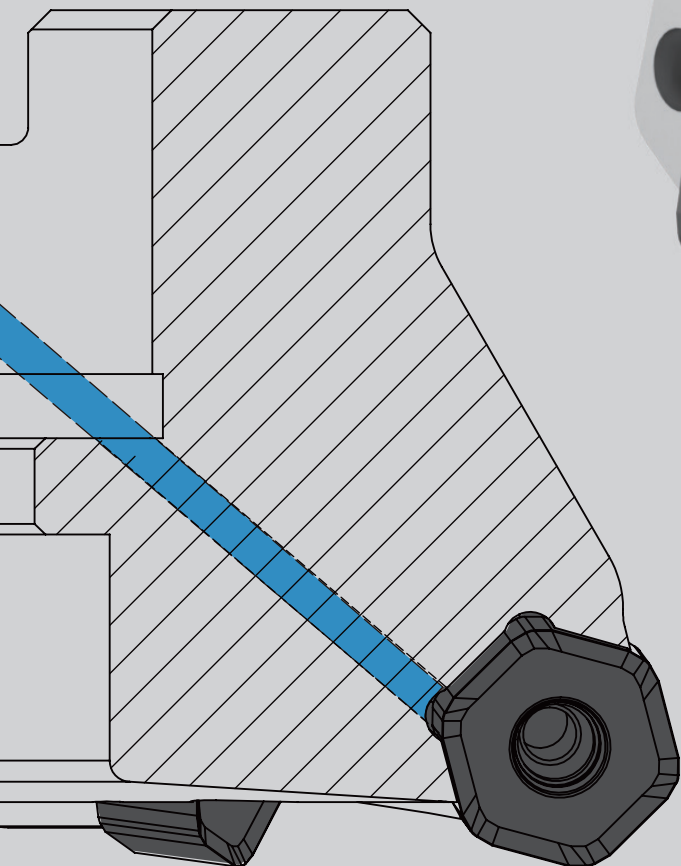
HN_06 切削條件數據表 Cutting Parameter

| 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) |
|-------------------------------|---------------|-------------------|--------------------|
| P 合金鋼 Alloyed Steels | OM4025 | 220(150~300) | 0.15(0.08~0.25) |
| M 不鏽鋼 Stainless Steels | OM5035 | 120(100~200) | 0.12(0.08~0.20) |
| K 鑄鐵 Cast Iron | OM4025 | 180(130~240) | 0.15(0.08~0.25) |
| N 鋁及鋁合金 Aluminium & Al | OM5005 | 400(300 - 1000) | 0.12(0,08 - 0,17) |

SN_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) |
|------------------------------|---------------|-------------------|--------------------|
| P 合金鋼 Alloyed Steels | RM4025 | 220(170~320) | 0.20(0.10~0.35) |
| K 鑄鐵 Cast Iron | RM3130 | 180(130~240) | 0.20(0.10~0.35) |

P K N

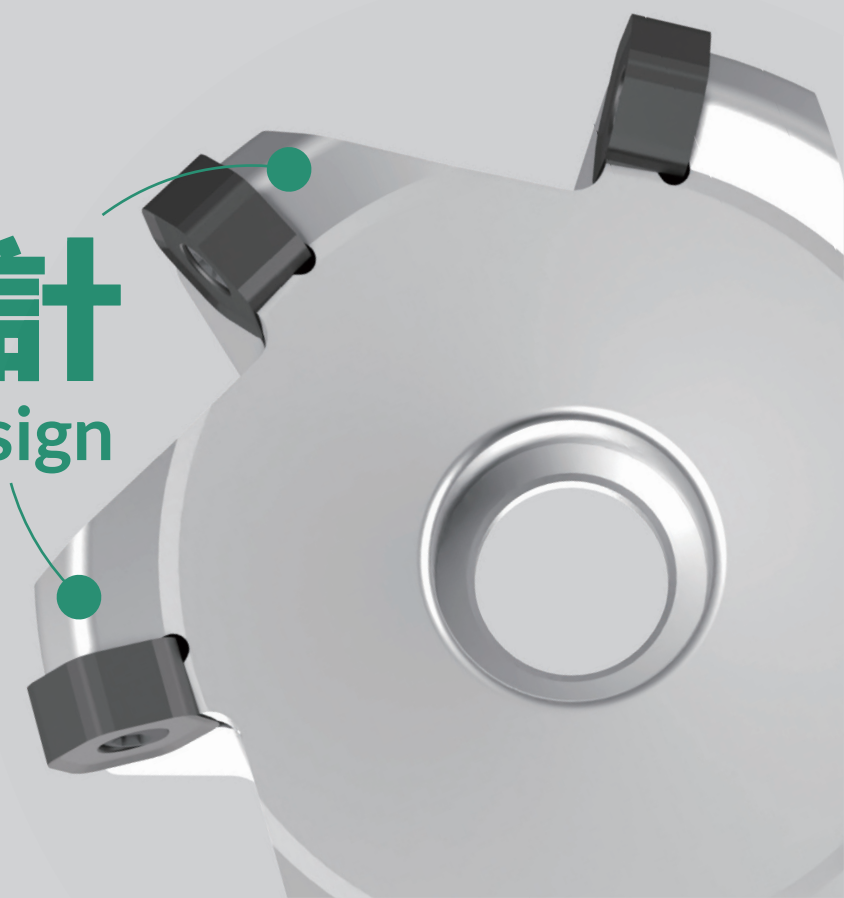


中心出水 Through Coolant

利於排屑與降溫
Faster Chip Removal &
Reduce Temperature

不等距設計 Non Equidistant Design

抑制切削加工造成震動
利於高穩定的加工
To decrease the vibration and
show high stability while machining



加工K類材質 最佳優化方案

Machining material: K (cast iron) The Improving Method

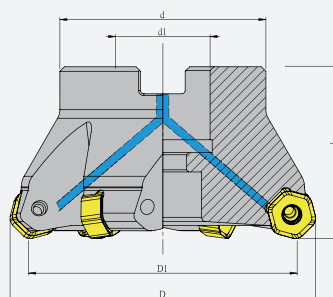
- 刀桿：BT50-FMB32-150
- 刀具：NAC45-100-HN06-FMB32-8T-C
- 刀片：HNGX0604ANEN-M01 OM4025
- 工件材質：鑄鐵K
- 乾式切削
- Cutter Arbor：BT50-FMB32-150
- Cutting Tools：NAC45-100-HN06-FMB32-8T-C
- Inserts：HNGX0604ANEN-M01 OM4025
- Workpiece Material：Cast Iron
- Dry Cutting

| 切削參數Cutting Parameters | 他牌 Other Brand | 正河源 Chain Headway |
|------------------------|----------------|-------------------|
| 轉速 S | 250 | 480 |
| 進給 F | 500 | 1200 |
| 切削速度 Vc | 150 | 150 |
| 進給 fz | 0.31 | 0.31 |
| 切深 Ap | 2 | 2 |
| 切寬 Ae | 80 | 80 |
| 加工壽命Machining Life | 15小時(hrs) | 21小時(hrs) |

加工效率提升140%，以及刀片壽命提升40%
Machining efficiency increases above 140%, and inserts' tool life increase by 40%



NAC 45度負角殼型銑刀 NAC 45°NEGATIVE ANGLE SHELL MILLING CUTTER



特點 Feature

- 採用負角刀片，刀片切削角數增加，降低成本
- 加工方式適合大量移除鐵削

- Negative insert with 12 cutting edges. Effective cost-saving.
- Ideal for a large area of cutting.

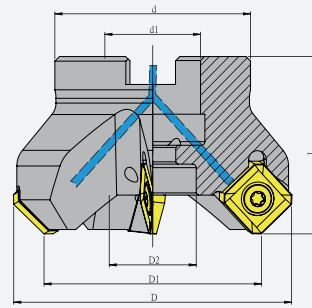
| 規格 Spec. | L | D | D1 | d | d1 | 刃數 Flutes | 刀片 Insert | 重量 (KGS) Weight |
|---------------------------|----|-----|-----|----|----|-----------|-----------|-----------------|
| NAC45-50-HN06-FMB22-5T-C | 40 | 57 | 50 | 45 | 22 | 5 | HN..0604 | 0.64 |
| NAC45-63-HN06-FMB22-6T-C | 40 | 72 | 63 | 48 | 22 | 6 | HN..0604 | 0.80 |
| NAC45-80-HN06-FMB27-7T-C | 50 | 87 | 80 | 55 | 27 | 7 | HN..0604 | 1.40 |
| NAC45-100-HN06-FMB32-8T-C | 50 | 107 | 100 | 73 | 32 | 8 | HN..0604 | 2.10 |

配件表 Accessories

| 螺絲 Screw | 扳手 Wrench | 扭力值 Torque(N.m) |
|----------------------|-----------|-----------------|
| M3-7.0-4.3-43-T9-TIN | T9 | 1.4Nm |

NAC 45度負角殼型銑刀

NAC 45°NEGATIVE ANGLE SHELL MILLING CUTTER



特點 Feature

- 採用負角刀片，刀片切削角數增加，降低成本
- 加工方式適合大量移除鐵削

- Negative insert with 8 cutting edges. Effective cost-saving.
- Ideal for a large area of cutting.

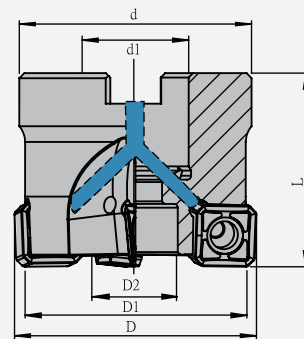
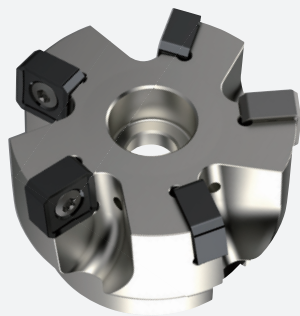
| 規格 Spec. | D1 | D | L | D2 | d | d1 | 刃數 Flutes | 刀片 Insert | 重量 (KGS) Weight |
|----------------------------|-----|-----|----|----|-----|----|-----------|-----------|-----------------|
| NAC45-50-SN12-FMB22-4T-C | 50 | 65 | 40 | 20 | 48 | 22 | 4 | SN..1206 | 0.57 |
| NAC45-63-SN12-FMB22-6T-C | 63 | 78 | 40 | 18 | 48 | 22 | 6 | SN..1206 | 0.78 |
| NAC45-80-SN12-FMB27-7T-C | 80 | 95 | 50 | 32 | 62 | 27 | 7 | SN..1206 | 1.39 |
| NAC45-100-SN12-FMB32-8T-C | 100 | 115 | 50 | 42 | 80 | 32 | 8 | SN..1206 | 1.76 |
| NAC45-125-SN12-FMB40-10T-C | 125 | 140 | 63 | 50 | 90 | 40 | 10 | SN..1206 | 3.5 |
| NAC45-160-SN12-FMB40-12T-C | 160 | 175 | 63 | 50 | 120 | 40 | 12 | SN..1206 | 6 |

配件表 Accessories

| 螺絲 Screw | 扳手 Wrench | 扭力值 Torque(N.m) |
|--------------------|-----------|-----------------|
| M4-10-6.6-R3.8-T15 | T15 | 3.0Nm |

NAC 88度負角殼型銑刀

NAC 88°NEGATIVE ANGLE SHELL MILLING CUTTER



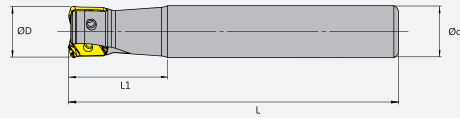
| 規格 Spec. | L | D | d | d1 | 刃數 Flutes | 刀片 Insert | 重量 (KGS) Weight |
|---------------------------|----|-----|----|----|-----------|-----------|-----------------|
| NAC88-50-SN12-FMB22-4T-C | 40 | 50 | 48 | 22 | 4 | SN..12 | - |
| NAC88-63-SN12-FMB22-5T-C | 40 | 63 | 48 | 22 | 5 | SN..12 | - |
| NAC88-80-SN12-FMB27-7T-C | 50 | 80 | 62 | 27 | 7 | SN..12 | - |
| NAC88-100-SN12-FMB32-8T-C | 50 | 100 | 80 | 32 | 8 | SN..12 | - |

配件表 Accessories

| 螺絲 Screw | 扳手 Wrench | 扭力值 Torque(N.m) |
|--------------------|-----------|-----------------|
| M4-10-6.6-R3.8-T15 | T15 | 3.0Nm |



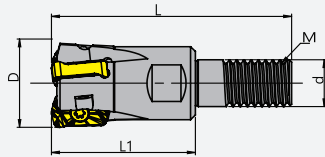
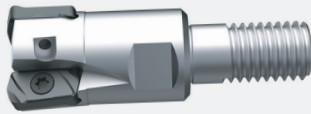
NHF 高進給直柄銑刀 NHF HIGH FEED MILLING END MILL



| 規格 Spec. | L | l ₁ | D | d | 刃數 Flutes | 刀片 Insert | 重量 (KGS) Weight |
|-------------------|-----|----------------|----|----|--------------|--------------|-----------------------|
| NHF-1516LN03-150L | 150 | 30 | 15 | 16 | 2 | LNMU0303 | - |
| NHF-1616LN03-150L | 150 | 40 | 16 | 16 | 2 | | - |
| NHF-1716LN03-150L | 150 | 30 | 17 | 16 | 2 | | - |
| NHF-2020LN03-150L | 150 | 40 | 20 | 20 | 3 | | - |
| NHF-2120LN03-150L | 150 | 50 | 21 | 20 | 3 | | - |
| NHF-2525LN03-150L | 150 | 60 | 25 | 25 | 4 | | - |
| NHF-2625LN03-150L | 150 | 60 | 26 | 25 | 4 | | - |
| NHF-2625LN03-200L | 200 | 60 | 26 | 25 | 4 | | - |
| NHF-3232LN03-150L | 150 | 45 | 32 | 32 | 5 | | - |
| NHF-3532LN03-220L | 220 | 60 | 35 | 32 | 5 | | - |



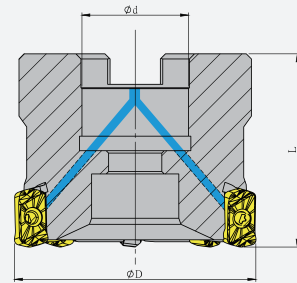
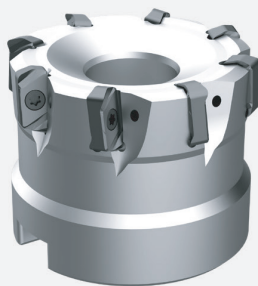
NHF 高進給鎖牙銑刀 NHF HIGH FEED SCREW-ON MILLING END MILL



| 規格 Spec. | L | l ₁ | D | d | M | 刃數 Flutes | 刀片 Insert | 重量 (KGS) Weight |
|----------------|----|----------------|----|-----|-----|--------------|--------------|-----------------------|
| NHF-17M08-LN03 | 43 | 26 | 17 | 8.5 | M08 | 2 | LNMU0303 | - |
| NHF-21M10-LN03 | 49 | 30 | 21 | 8.5 | M10 | 3 | | - |
| NHF-26M12-LN03 | 57 | 35 | 26 | 8.5 | M12 | 4 | | - |
| NHF-35M16-LN03 | 66 | 43 | 35 | 8.5 | M16 | 4 | | - |



NHF 高進給殼型銑刀 NHF HIGH FEED FACE MILLING CUTTER



| 規格 Spec. | D | d | L | 刃數 Flutes | 重量 (KGS) Weight |
|---------------------|----|----|----|--------------|-----------------------|
| NHF-40-FMB16-LN03-C | 40 | 16 | 40 | 6 | - |
| NHF-50-FMB22-LN03-C | 50 | 22 | 50 | 8 | - |

配件表 Accessories

| 螺絲 Screw | 扳手 Wrench | 扭力值 Torque(N.m) |
|------------------|-----------|-----------------|
| M2.5-6.45-3.7-43 | T8 | 1.2Nm |



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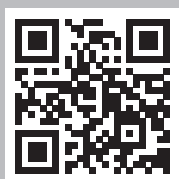
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