

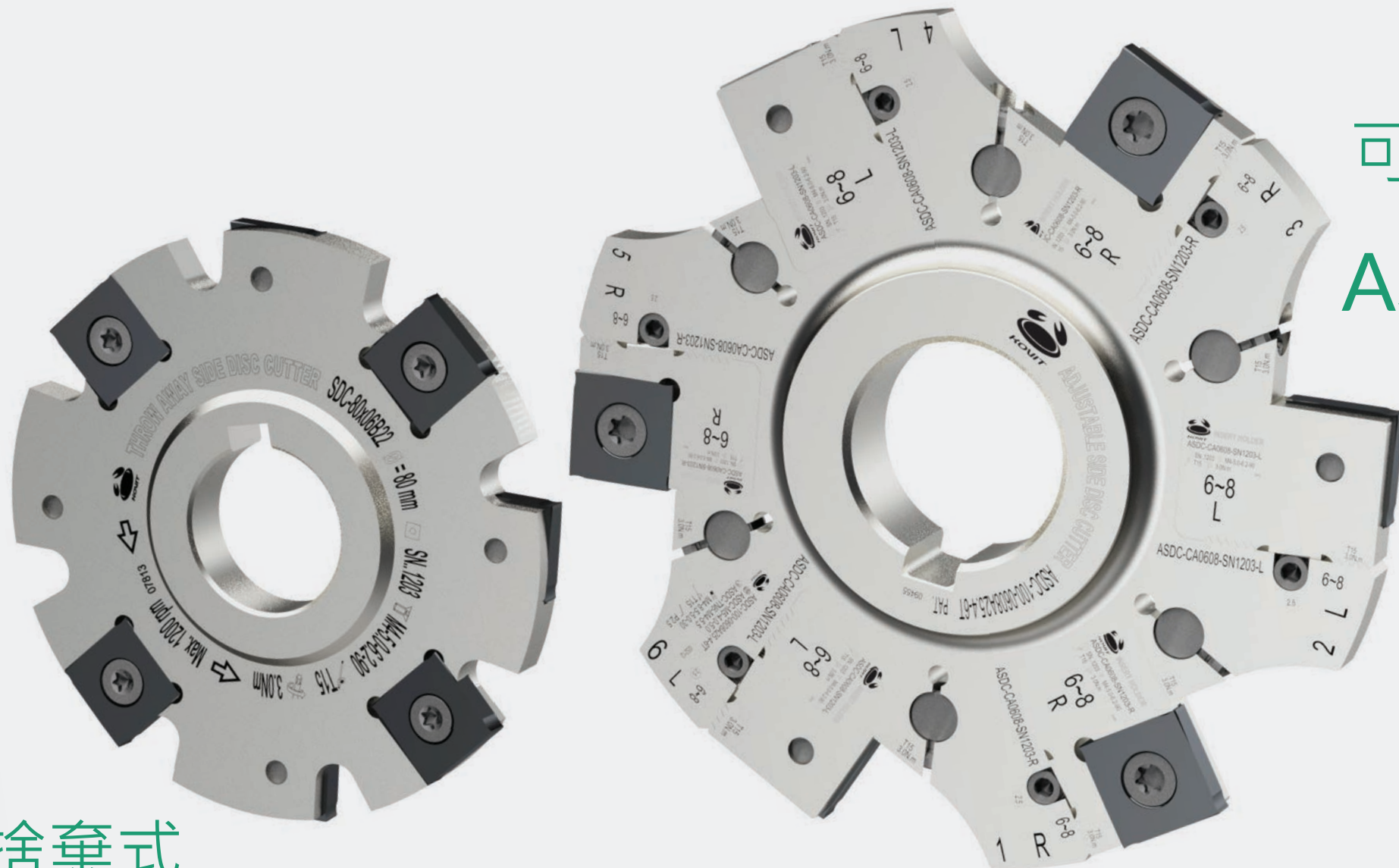
側銑刀系列

Side Disc Series



Cutting Edge Solution

可調式 ASDC

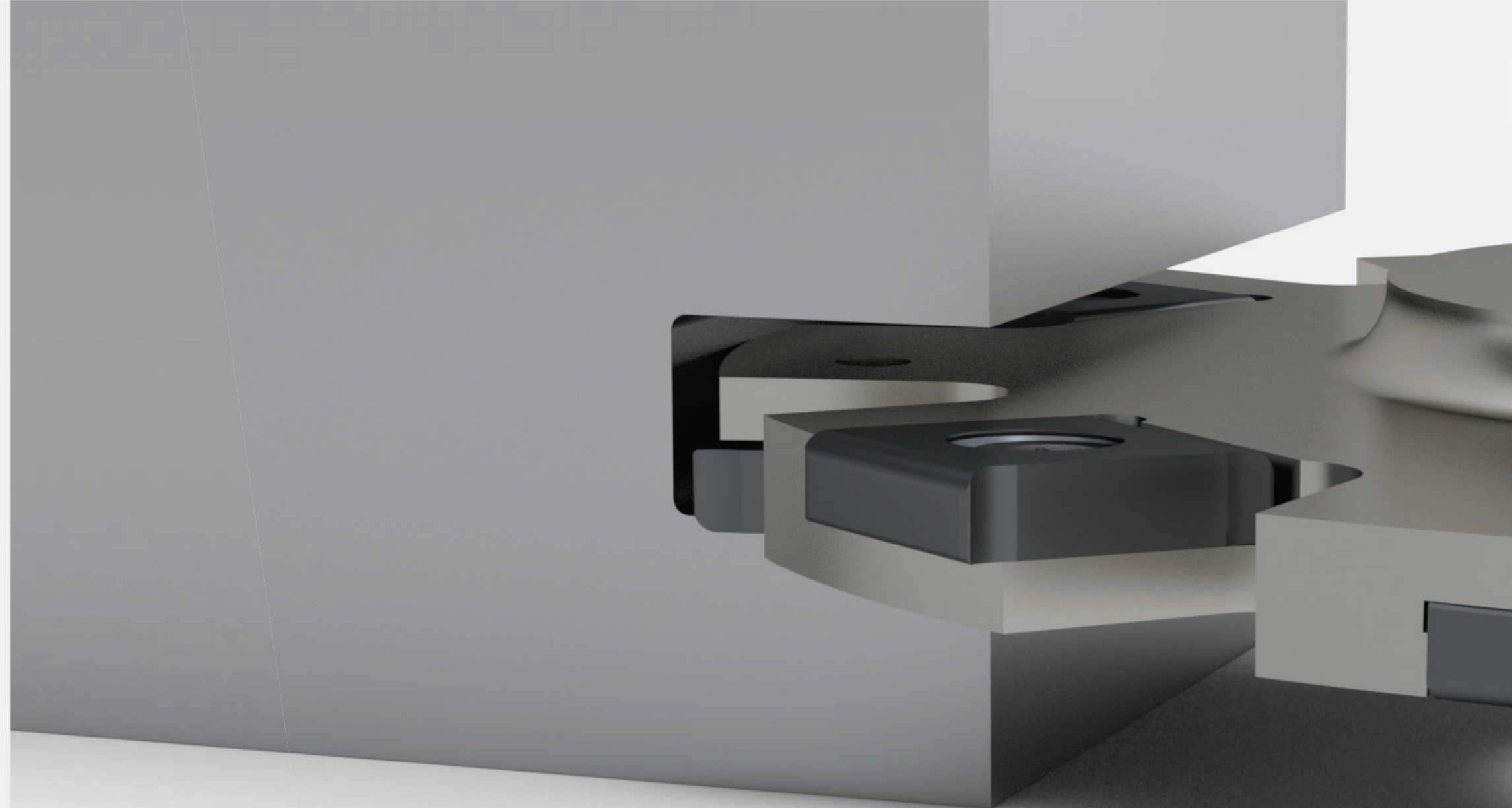


捨棄式

SDC

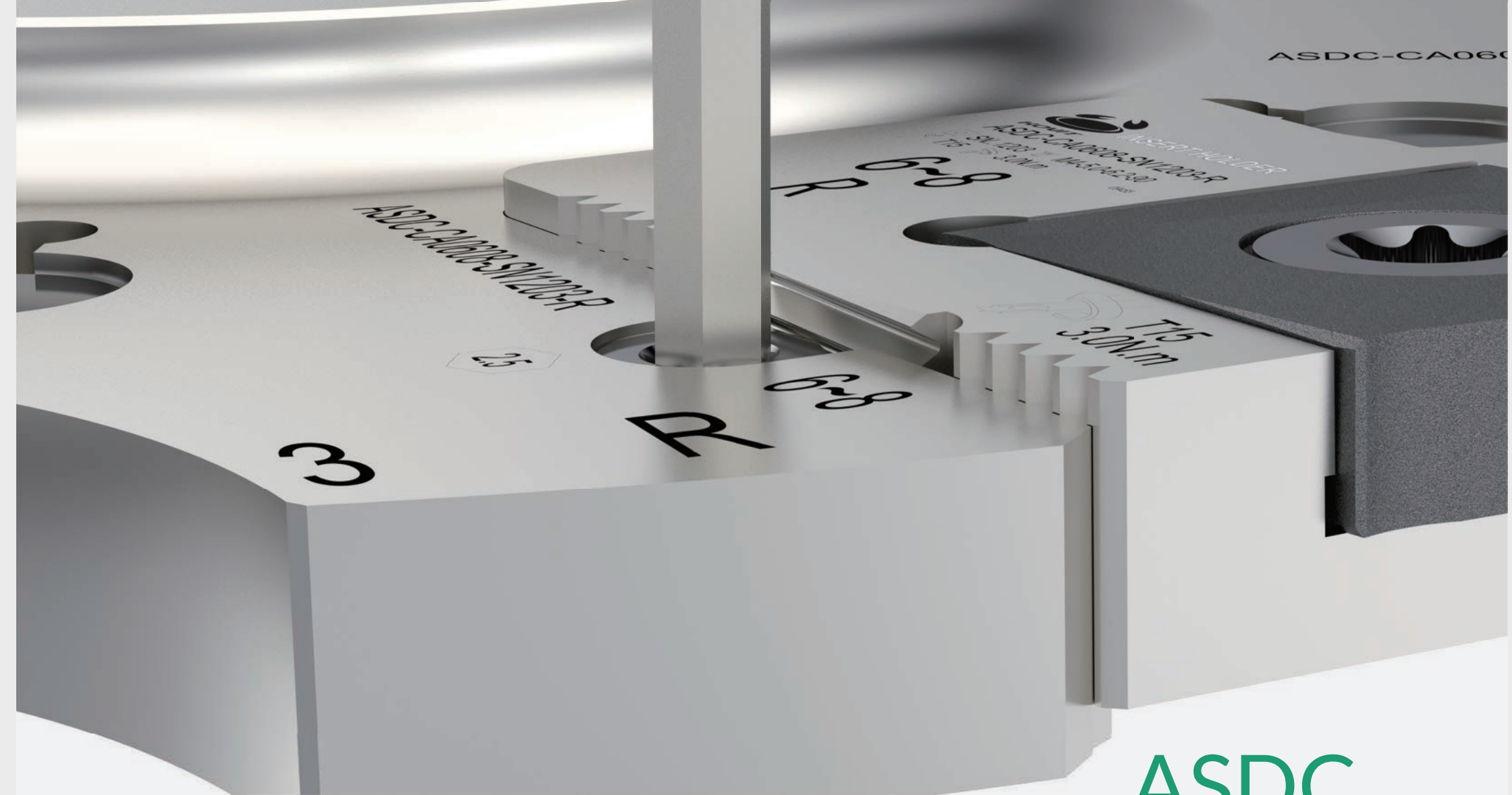


02- 側銑刀系列 Side Disc Cutter Series



穩定加工，效率倍增

Stable Cutting, Improve Efficiency



ASDC 可調式側銑刀

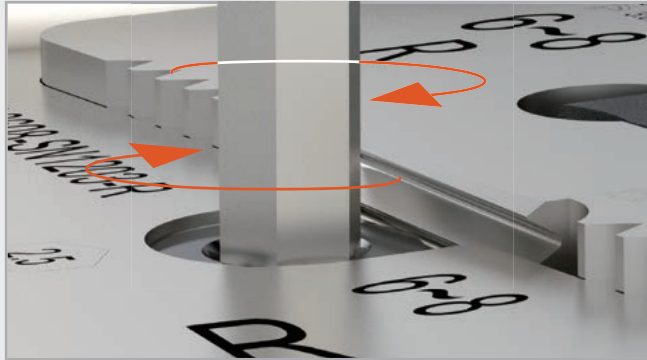
PAT.NO
M574526(TW)
ZL 2018 2 1953076.6(CN)



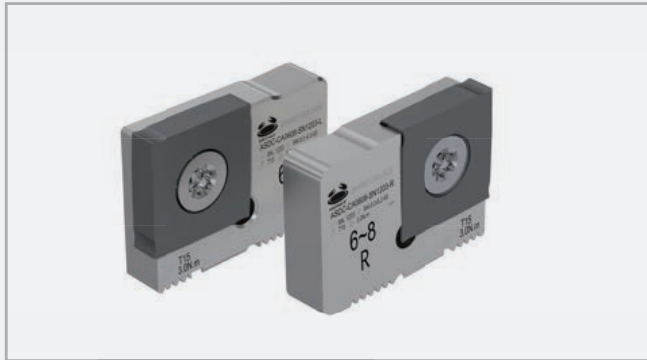
04- 側銑刀系列 Side Disc Cutter Series

ASDC可調式側銑刀特色/優點

ASDC Adjustable Side Disc Cutter Features / Advantage



利用調整螺絲來進行切槽尺寸的調整
Use the lock adjustable screw to fine-tune the groove size.



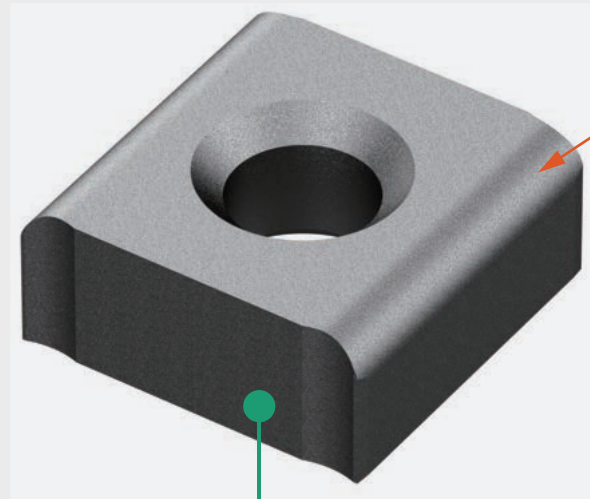
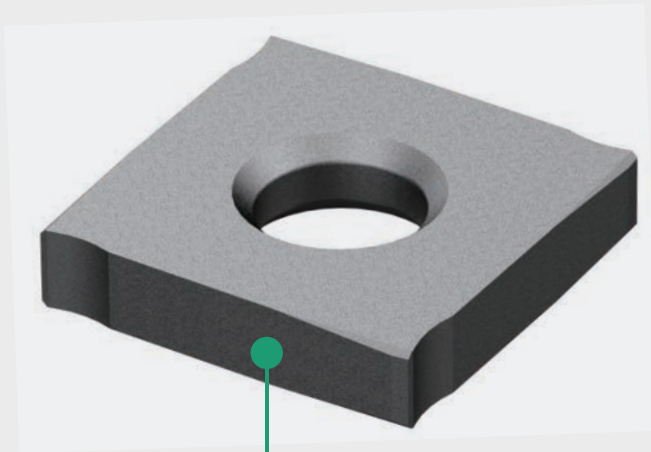
刀片座排齒設計，可增加接合穩定性
Insert seat tooth design for added stability.



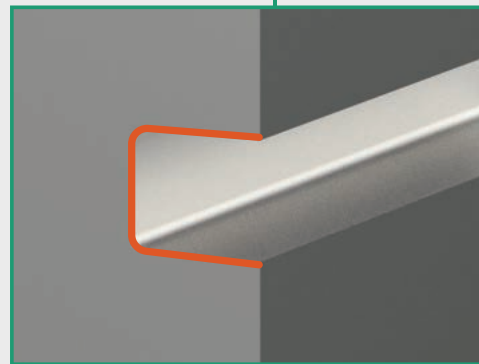
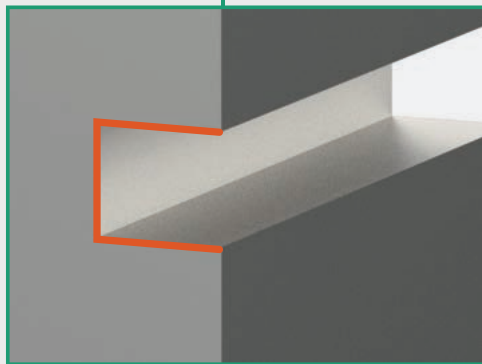
微調尺寸6~8mm (微調行程2mm)
Adjustable size 6~8mm. (Adjustable range 2mm)

研磨級刀片，尺寸種類齊全

Grinding insert, Complete range of sizes



R角



可量身打造
不同R角需求
Customized R angle
is available



側銑刀比較表

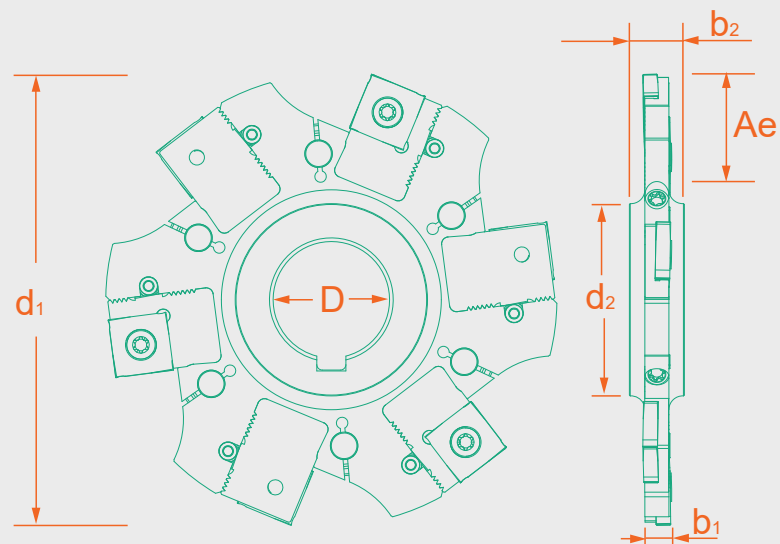
Side Disc Cutter Overview

	ASDC 可調式側銑刀 Adjustable Side Disc Cutter	SDC 捨棄式側銑刀 Supplemental Side Disc Cutter	GDC 捨棄式側銑刀 Supplemental Side Disc Cutter	焊刃式側銑刀 Welding Edge Side Disc Cutter
可調整加工尺寸 Adjustable Cutting Size	++	-	-	-
可替換刀片 Indexable Insert	++	++	++	-
便利性 Convenience	++	++	++	-
加工材質選用 Cutting Material Selection	++	++	++	○

++ 佳 Very good + 好 Good ○ 普通 Neutral - 不好 Bad

規格

Spec



ASDC 可調式側銑刀 Adjustable Side Disc Cutter

規格 Spec.	D	d ₁	d ₂	b ₁	b ₂	切寬 Ae	刃數 Teeth	刀片座 Insert Seat	刀片 Insert	重量 (KGS) Weight
ASDC-100-0608A25.4-6T-SN1203	25.4	100	41	6~8	12	25	6	ASDC-CA0608-SN1203-R ASDC-CA0608-SN1203-L	SN..1203	0.27
ASDC-100-0810A25.4-6T-SN1205	25.4	100	41	8~10	12	25	6	ASDC-CA0810-SN1205-R ASDC-CA0810-SN1205-L	SN..1205	-
ASDC-100-1012A25.4-6T-SN1207	25.4	100	41	10~12	12	25	6	ASDC-CA1012-SN1207-R ASDC-CA1012-SN1207-L	SN..1207	-
ASDC-100-1214A25.4-6T-SN1207	25.4	100	41	12~14	16	25	6	ASDC-CA1214-SN1207-R ASDC-CA1214-SN1207-L	SN..1207	-
ASDC-125-0608A25.4-8T-SN1203	25.4	125	41	6~8	12	25	8	ASDC-CA0608-SN1203-R ASDC-CA0608-SN1203-L	SN..1203	-
ASDC-125-0810A25.4-8T-SN1205	25.4	125	41	8~10	12	35	8	ASDC-CA0810-SN1205-R ASDC-CA0810-SN1205-L	SN..1205	-

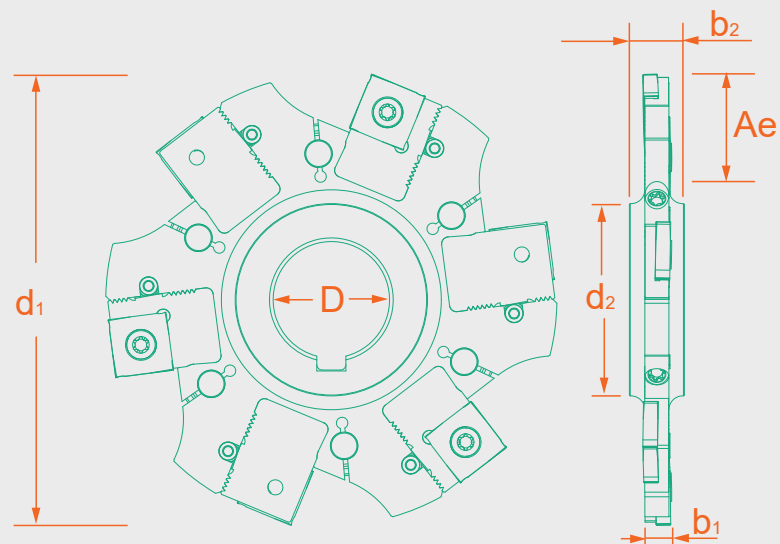
配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m



規格

Spec



ASDC 可調式側銑刀 Adjustable Side Disc Cutter

規格 Spec.	D	d ₁	d ₂	b ₁	b ₂	切寬 Ae	刃數 Teeth	刀片座 Insert Seat	刀片 Insert	重量 (KGS) Weight
ASDC-125-1012A25.4-8T-SN1207	25.4	125	41	10~12	12	35	8	ASDC-CA1012-SN1207-R ASDC-CA1012-SN1207-L	SN..1207	-
ASDC-125-1214A25.4-8T-SN1207	25.4	125	41	12~14	16	35	8	ASDC-CA1214-SN1207-R ASDC-CA1214-SN1207-L	SN..1207	-
ASDC-160-0608A25.4-10T-SN1203	25.4	160	41	6~8	12	45	10	ASDC-CA0608-SN1203-R ASDC-CA0608-SN1203-L	SN..1203	-
ASDC-160-0810A25.4-10T-SN1205	25.4	160	41	8~10	12	45	10	ASDC-CA0810-SN1205-R ASDC-CA0810-SN1205-L	SN..1205	-
ASDC-160-1012A25.4-10T-SN1207	25.4	160	41	10~12	12	45	10	ASDC-CA1012-SN1207-R ASDC-CA1012-SN1207-L	SN..1207	-
ASDC-160-1214A25.4-10T-SN1207	25.4	160	41	12~14	16	45	10	ASDC-CA1214-SN1207-R ASDC-CA1214-SN1207-L	SN..1207	-

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m

ASDC 可調式側銑刀配件表

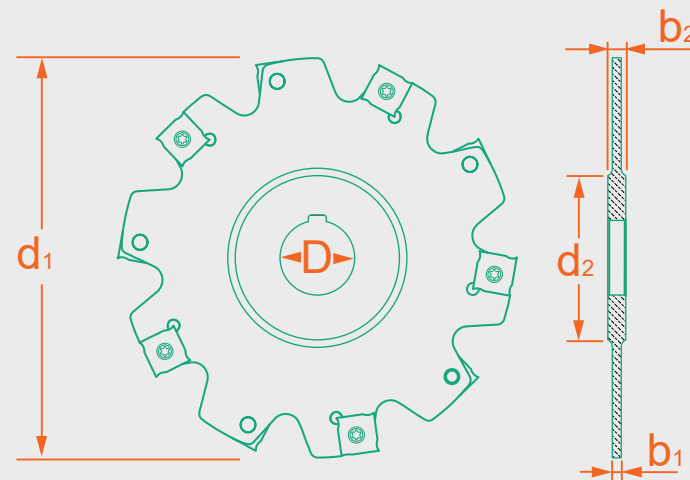
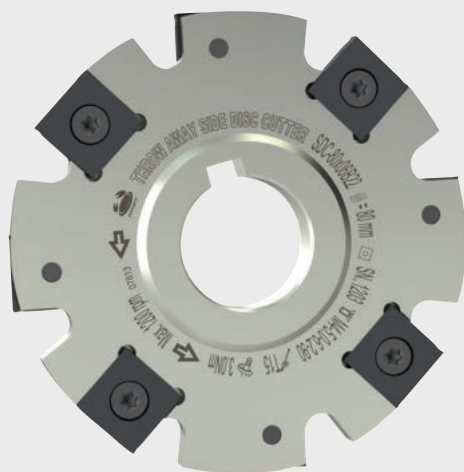
ASDC Adjustable Side Disc Cutter Accessories

圖示 Fig.	名稱 Name	規格 Spec.	功能 Function
	鎖固螺絲 Locking Screw	M4-8.5-5.0-30	鎖固刀片座 Lock The Insert Seat
	鎖固螺帽 Locking Screw	ASDC-TN6-M4-5.5	鎖固刀片座 Lock The Insert Seat
	刀片螺絲 Insert Screw	M4-5.0-6.2-90	固定刀片 Fix The Insert
	調整螺絲 Adjustable Screw	ASDC-M5-4.0-5.0	調整刀具尺寸 Adjust The Cutter Size
	扳手 Wrench	T15	鎖固刀片 Tighten The Insert
	扳手 Wrench	PL2.5	調整尺寸精度 Adjust The Size Accuracy



規格

Spec



SDC 捨棄式側銑刀 Supplemental Side Disc Cutter

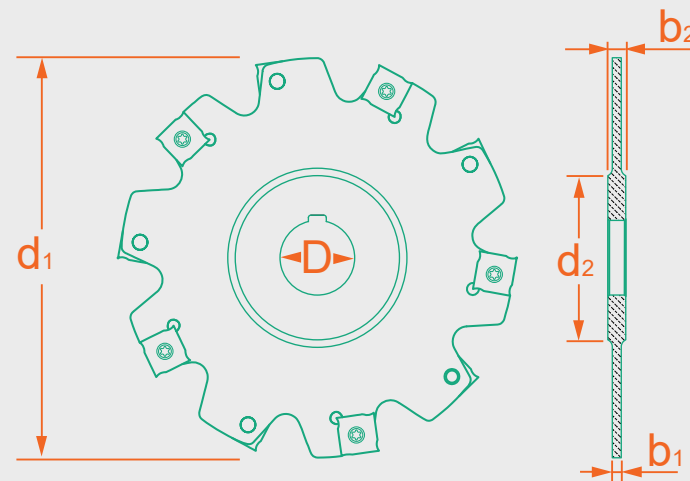
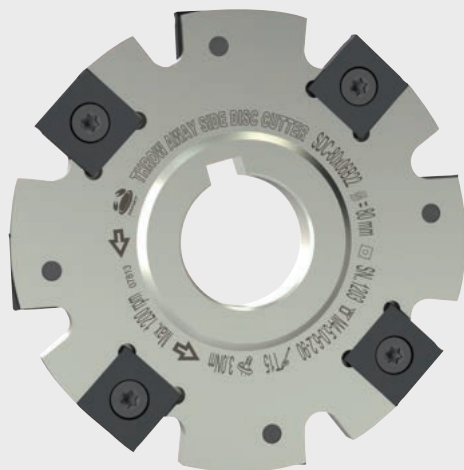
規格 Spec.	D	d1	d2	b1	b2	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
SDC-100×04A25.4	25.4	100	41	4	12	12	SN..1102	0.38
SDC-100×05A25.4	25.4	100	41	5	12	12	SN..1103	0.44
SDC-100×06A25.4	25.4	100	41	6	12	10	SN..1203	0.45
SDC-100×07A25.4	25.4	100	41	7	12	9	SN..1203	0.49
SDC-100×08A25.4	25.4	100	41	8	12	9	SN..1203	0.54
SDC-100×10A25.4	25.4	100	41	10	12	10	SN..1205	0.59
SDC-100×11A25.4	25.4	100	41	11	12	10	SN..1207	0.62
SDC-100×12A25.4	25.4	100	41	12	12	10	SN..1207	0.66
SDC-100×14A25.4	25.4	100	41	14	16	9	SN..1207	0.77

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1102	M3-3.5-5.0-90	T7	0.9 N.m
SN..1103	M3-4.3-5.0-90	T7	0.9 N.m
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m

規格

Spec



SDC 捨棄式側銑刀 Supplemental Side Disc Cutter

規格 Spec.	D	d ₁	d ₂	b ₁	b ₂	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
SDC-125×04A25.4	25.4	125	41	4	12	14	SN..1102	0.58
SDC-125×05A25.4	25.4	125	41	5	12	14	SN..1103	0.63
SDC-125×06A25.4	25.4	125	41	6	12	12	SN..1203	0.69
SDC-125×07A25.4	25.4	125	41	7	12	12	SN..1203	0.75
SDC-125×08A25.4	25.4	125	41	8	12	12	SN..1203	0.81
SDC-125×09A25.4	25.4	125	41	9	12	12	SN..1205	0.86
SDC-125×10A25.4	25.4	125	41	10	12	12	SN..1205	0.94
SDC-125×12A25.4	25.4	125	41	12	12	12	SN..1207	1.05
SDC-125×14A25.4	25.4	125	41	14	16	12	SN..1207	1.20
SDC-160×06A25.4	25.4	160	41	6	12	16	SN..1203	1.04
SDC-160×07A25.4	25.4	160	41	7	12	15	SN..1203	0.17
SDC-160×08A25.4	25.4	160	41	8	12	15	SN..1203	1.26
SDC-160×09A25.4	25.4	160	41	9	12	16	SN..1205	1.35
SDC-160×10A25.4	25.4	160	41	10	12	16	SN..1205	1.48
SDC-160×12A25.4	25.4	160	41	12	12	16	SN..1207	1.74
SDC-160×14A25.4	25.4	160	41	14	16	15	SN..1207	1.99

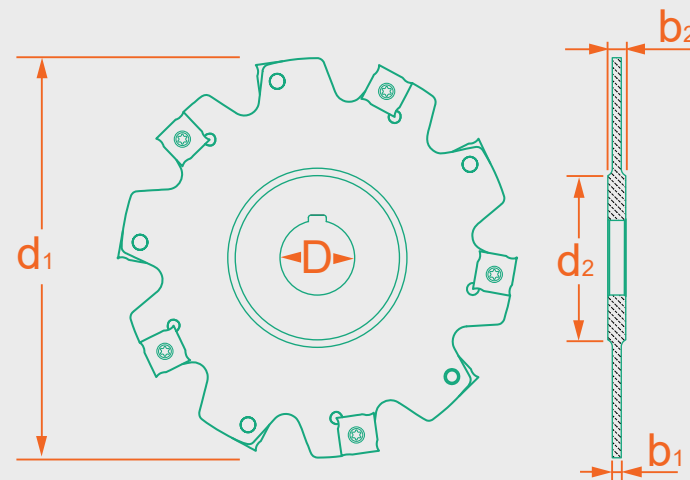
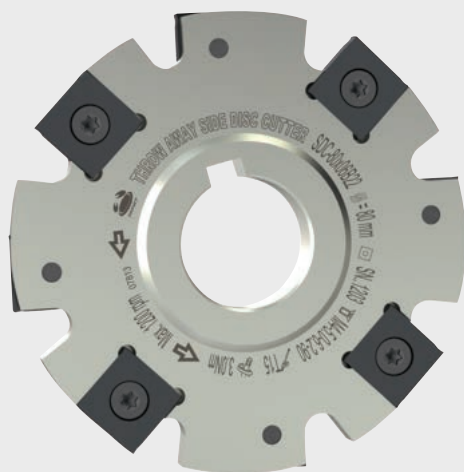
配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1102	M3-3.5-5.0-90	T7	0.9 N.m
SN..1103	M3-4.3-5.0-90	T7	0.9 N.m
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m



規格

Spec



SDC 捨棄式側銑刀 Supplemental Side Disc Cutter

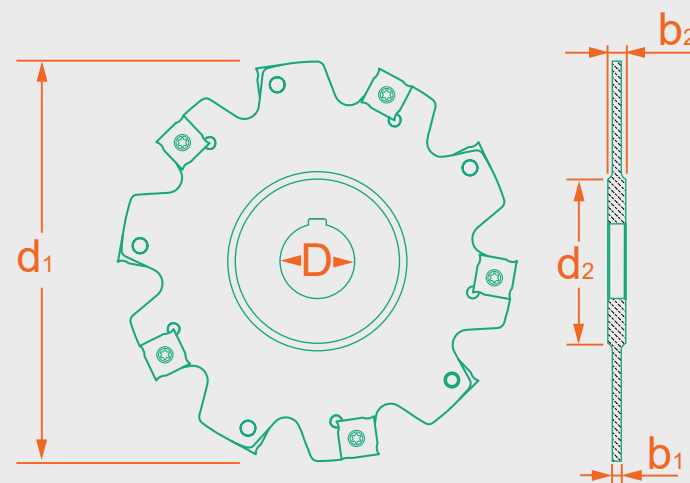
規格 Spec.	D	d ₁	d ₂	b ₁	b ₂	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
SDC-63×04B22	22	63	34	4	8	8	SN..1102	0.27
SDC-63×05B22	22	63	34	5	8	8	SN..1103	0.28
SDC-63×06B22	22	63	34	6	8	6	SN..1203	0.28
SDC-80×04B22	22	80	34	4	8	10	SN..1102	0.31
SDC-80×05B22	22	80	34	5	8	10	SN..1103	0.33
SDC-80×06B22	22	80	34	6	8	8	SN..1203	0.35
SDC-100×04B27	27	100	41	4	12	12	SN..1102	0.38
SDC-100×05B27	27	100	41	5	12	12	SN..1103	0.44
SDC-100×06B27	27	100	41	6	12	10	SN..1203	0.45
SDC-100×07B27	27	100	41	7	12	9	SN..1203	0.49
SDC-100×08B27	27	100	41	8	12	9	SN..1203	0.54
SDC-100×10B27	27	100	41	10	12	10	SN..1205	0.59
SDC-100×12B27	27	100	41	12	12	10	SN..1207	0.70
SDC-100×14B27	27	100	41	14	12	9	SN..1207	0.70

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1102	M3-3.5-5.0-90	T7	0.9 N.m
SN..1103	M3-4.3-5.0-90	T7	0.9 N.m
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m

規格

Spec



SDC 捨棄式側銑刀 Supplemental Side Disc Cutter

規格 Spec.	D	d ₁	d ₂	b ₁	b ₂	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
SDC-125×04B32	32	125	47	4	12	14	SN..1102	0.58
SDC-125×05B32	32	125	47	5	12	14	SN..1103	0.63
SDC-125×06B32	32	125	47	6	12	12	SN..1203	0.69
SDC-125×07B32	32	125	47	7	12	12	SN..1203	0.75
SDC-125×08B32	32	125	47	8	12	12	SN..1203	0.81
SDC-125×09B32	32	125	47	9	12	12	SN..1205	0.86
SDC-125×10B32	32	125	47	10	12	12	SN..1205	0.94
SDC-125×12B32	32	125	47	12	12	12	SN..1207	1.05
SDC-125×14B32	32	125	47	14	12	12	SN..1207	1.20

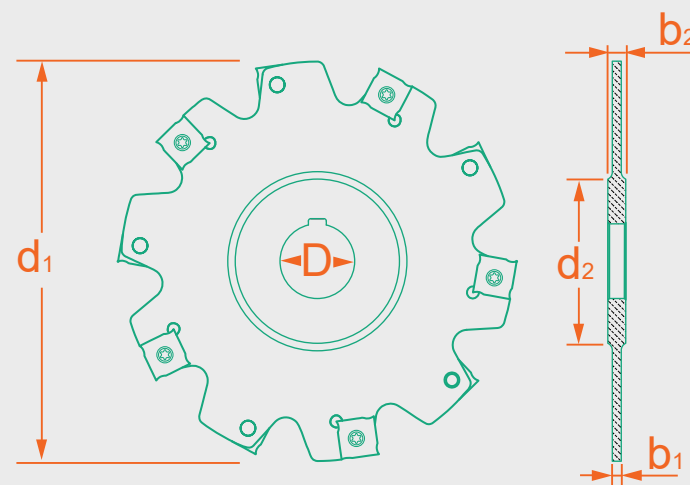
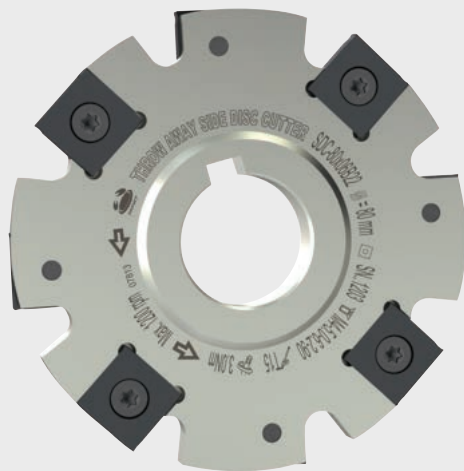
配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1102	M3-3.5-5.0-90	T7	0.9 N.m
SN..1103	M3-4.3-5.0-90	T7	0.9 N.m
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m



規格

Spec



SDC 捨棄式側銑刀 Supplemental Side Disc Cutter

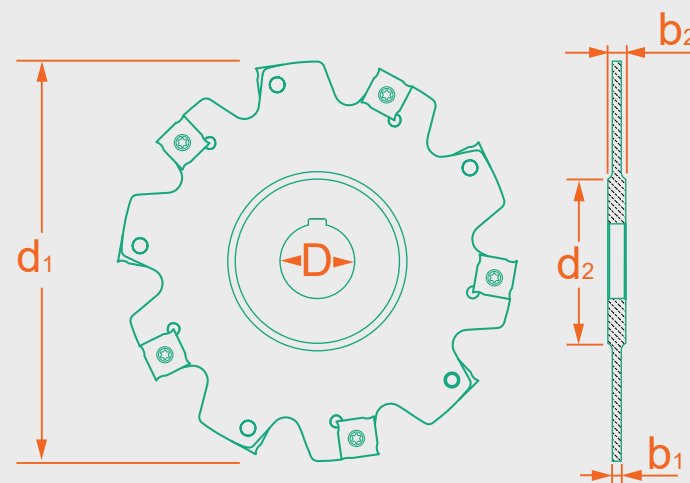
規格 Spec.	D	d ₁	d ₂	b ₁	b ₂	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
SDC-160×06B40	40	160	55	6	12	16	SN..1203	1.04
SDC-160×07B40	40	160	55	7	12	15	SN..1203	0.17
SDC-160×08B40	40	160	55	8	12	15	SN..1203	1.26
SDC-160×09B40	40	160	55	9	12	16	SN..1205	1.35
SDC-160×10B40	40	160	55	10	12	16	SN..1205	1.48
SDC-160×12B40	40	160	55	12	12	16	SN..1207	1.74
SDC-160×14B40	40	160	55	14	12	15	SN..1207	1.99

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1102	M3-3.5-5.0-90	T7	0.9 N.m
SN..1103	M3-4.3-5.0-90	T7	0.9 N.m
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m

規格

Spec



SDC 捨棄式側銑刀 Supplemental Side Disc Cutter

規格 Spec.	D	d ₁	d ₂	b ₁	b ₂	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
SDC-200×06B50	50	200	69	6	12	18	SN..1203	-
SDC-200×08B50	50	200	69	8	12	18	SN..1203	-
SDC-200×10B50	50	200	69	10	12	18	SN..1205	-
SDC-200×12B50	50	200	69	12	12	18	SN..1207	-
SDC-200×14B50	50	200	69	14	14	18	SN..1207	3.20
SDC-250×08B50	50	250	69	8	12	24	SN..1203	4.30
SDC-250×10B50	50	250	69	10	12	24	SN..1205	4.30
SDC-250×12B50	50	250	69	12	12	24	SN..1207	4.50
SDC-250×14B50	50	250	69	14	14	24	SN..1207	4.50

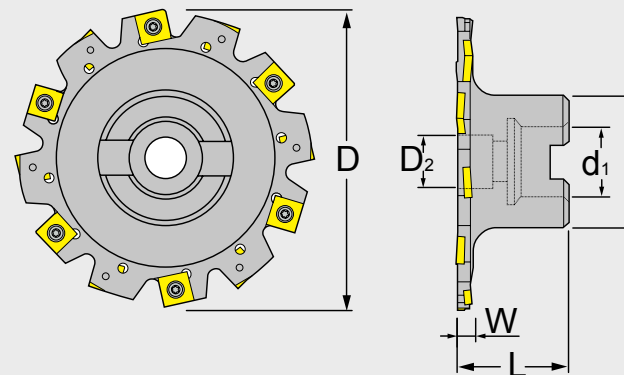
配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1102	M3-3.5-5.0-90	T7	0.9 N.m
SN..1103	M3-4.3-5.0-90	T7	0.9 N.m
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m



規格

Spec



GDC 捨棄式側銑刀
Supplemental Side Disc Cutter

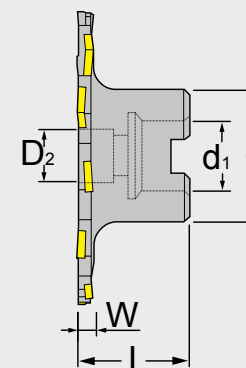
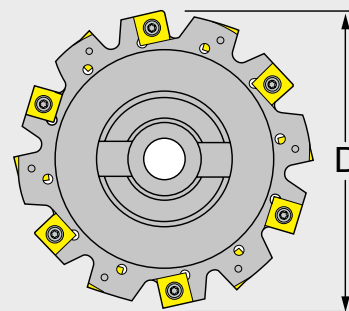
規格 Spec.	L	D	D2	d	d1	W	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
GDC-80×04B22	40	80	28	45	22	4	10	SN..1102	0.50
GDC-80×05B22	40	80	28	45	22	5	10	SN..1103	0.50
GDC-80×06B22	40	80	28	45	22	6	8	SN..1203	0.55
GDC-80×07B22	40	80	28	45	22	7	9	SN..1203	0.57
GDC-80×08B22	40	80	28	45	22	8	9	SN..1203	0.70
GDC-80×09B22	40	80	28	45	22	9	8	SN..1205	0.60
GDC-80×10B22	40	80	28	45	22	10	8	SN..1205	0.62
GDC-80×12B22	40	80	28	45	22	12	8	SN..1207	0.66
GDC-80×14B22	40	80	28	45	22	14	9	SN..1207	0.70

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1102	M3-3.5-5.0-90	T7	0.9 N.m
SN..1103	M3-4.3-5.0-90	T7	0.9 N.m
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m

規格

Spec



GDC 捨棄式側銑刀 Supplemental Side Disc Cutter

規格 Spec.	L	D	D2	d	d1	W	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
GDC-100×04B27	40	100	33	50	27	4	12	SN..1102	0.74
GDC-100×05B27	40	100	33	50	27	5	12	SN..1103	0.70
GDC-100×06B27	40	100	33	50	27	6	10	SN..1203	0.73
GDC-100×07B27	40	100	33	50	27	7	9	SN..1203	0.76
GDC-100×08B27	40	100	33	50	27	8	9	SN..1203	0.80
GDC-100×09B27	40	100	33	50	27	9	10	SN..1205	0.82
GDC-100×10B27	40	100	33	50	27	10	10	SN..1205	0.86
GDC-100×12B27	40	100	33	50	27	12	10	SN..1207	0.90
GDC-100×14B27	40	100	33	50	27	14	9	SN..1207	0.98

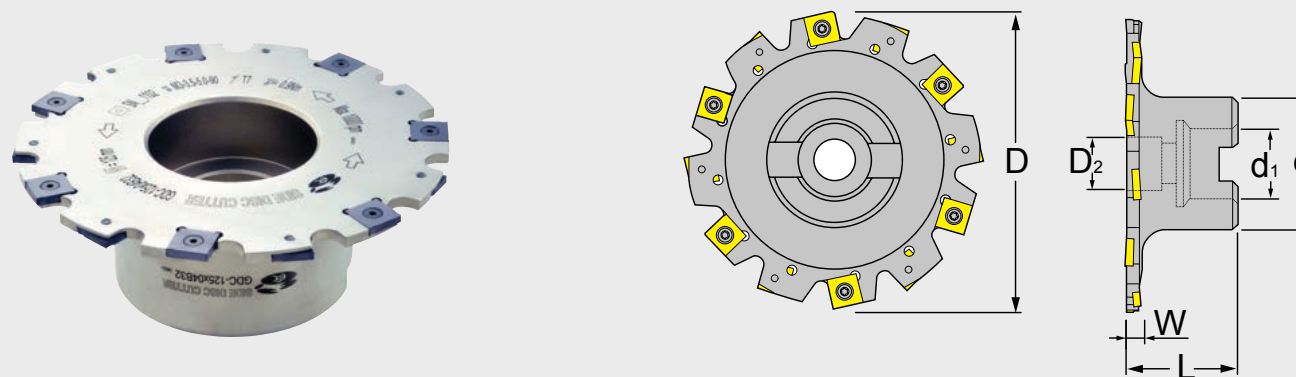
配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1102	M3-3.5-5.0-90	T7	0.9 N.m
SN..1103	M3-4.3-5.0-90	T7	0.9 N.m
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m



規格

Spec



GDC 捨棄式側銑刀 Supplemental Side Disc Cutter

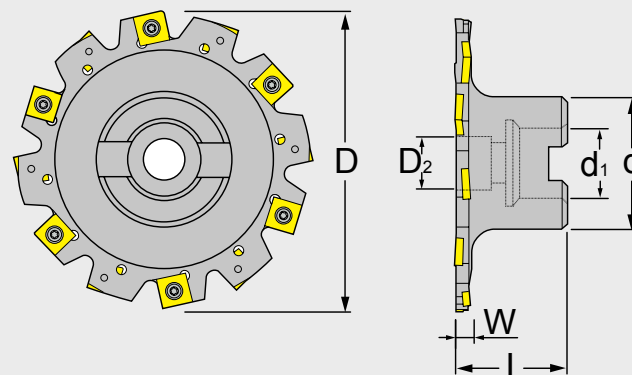
規格 Spec.	L	D	D2	d	d1	W	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
GDC-125×04B32	45	125	43	70	32	4	14	SN..1102	1.30
GDC-125×05B32	45	125	43	70	32	5	14	SN..1103	1.40
GDC-125×06B32	45	125	43	70	32	6	12	SN..1203	1.40
GDC-125×07B32	45	125	43	70	32	7	12	SN..1203	1.45
GDC-125×08B32	45	125	43	70	32	8	12	SN..1203	1.45
GDC-125×09B32	45	125	43	70	32	9	12	SN..1205	1.58
GDC-125×10B32	45	125	43	70	32	10	12	SN..1205	1.58
GDC-125×12B32	45	125	43	70	32	12	12	SN..1207	1.65
GDC-125×14B32	45	125	43	70	32	14	12	SN..1207	1.76

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1102	M3-3.5-5.0-90	T7	0.9 N.m
SN..1103	M3-4.3-5.0-90	T7	0.9 N.m
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m

規格

Spec



GDC 捨棄式側銑刀 Supplemental Side Disc Cutter

規格 Spec.	L	D	D ₂	d	d ₁	W	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
GDC-160×06B40	50	160	50	90	40	6	16	SN..1203	2.60
GDC-160×07B40	50	160	50	90	40	7	15	SN..1203	2.60
GDC-160×08B40	50	160	50	90	40	8	15	SN..1203	2.80
GDC-160×09B40	50	160	50	90	40	9	16	SN..1205	2.80
GDC-160×10B40	50	160	50	90	40	10	16	SN..1205	2.90
GDC-160×12B40	50	160	50	90	40	12	16	SN..1207	3.08
GDC-160×14B40	50	160	50	90	40	14	15	SN..1207	0.23

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SN..1102	M3-3.5-5.0-90	T7	0.9 N.m
SN..1103	M3-4.3-5.0-90	T7	0.9 N.m
SN..1203	M4-5.0-6.2-90	T15	3.0 N.m
SN..1205	M4-8.2-6.2-90	T15	3.0 N.m
SN..1207	M4-11-6.2-90-T15-TIN	T15	3.0 N.m



規格

Spec

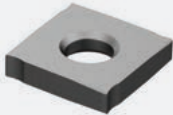
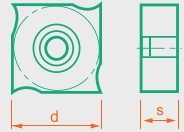
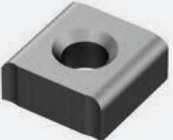
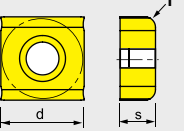


GDC 捨棄式側銑刀套裝組
Supplemental Side Disc Cutter Set

規格 Spec.	內容物 Contents				重量 (KGS) Weight
	刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque (N.m)	
GDC-100×08B27-SET	SNFX1203 OM4025(10片)	M4-5.0-6.2-90	T15K	3.0	0.80
GDC-100×10B27-SET	SNFX1205 OM4025(10片)	M4-8.2-6.2-90	T15K	3.0	0.86
GDC-100×12B27-SET	SNFX1207 OM4025(10片)	M4-11-6.2-90-T15-TIN	T15K	3.0	0.92
GDC-125×04B32-SET	SNFX1102 OM4025(20片)	M3-3.5-5.0-90	T7K	0.9	1.30
GDC-125×08B32-SET	SNFX1203 OM4025(20片)	M4-5.0-6.2-90	T15K	3.0	1.45
GDC-125×10B32-SET	SNFX1205 OM4025(20片)	M4-8.2-6.2-90	T15K	3.0	1.58
GDC-125×12B32-SET	SNFX1207 OM4025(20片)	M4-11-6.2-90-T15-TIN	T15K	3.0	1.65

適用刀片規格

Applicable Insert Spec

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 Form	規格 Spec.	鍍層超微粒 Layer Coating Ultra-micro				超硬微粒 Ultra-hard Microprogram				尺寸 (mm)				圖形 Drawing
		CHF				HF				Size				
		OM4010	OM4025			OM5005				d	i	s	r	
	SNFX1102	●	●			●				11	-	2.3	-	
	SNFX1103	●	●			●				11	-	2.7	-	
	SNFX1203	●	●			●				12.7	-	3.2	-	
	SNFX1205	●	●			●				12.7	-	5.4	-	
	SNFX1207	●	●			●				12.7	-	7	-	
倒 R 角設計 	SNFX120305	●	●			●				12.7	-	3.2	0.5	
	SNFX120310	●	●			●				12.7	-	3.2	1	
	SNFX120315	●	●			●				12.7	-	3.2	1.5	
	SNFX120505	●	●			●				12.7	-	5.4	0.5	
	SNFX120510	●	●			●				12.7	-	5.4	1	
	SNFX120515	●	●			●				12.7	-	5.4	1.5	
	SNFX120516	●	●			●				12.7	-	5.4	1.6	
	SNFX120705	●	●			●				12.7	-	7	0.5	
	SNFX120710	●	●			●				12.7	-	7	1	
	SNFX120715	●	●			●				12.7	-	7	1.5	



加工數據

Cutting Conditions

刀片類型 Insert 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)
SN..11 SN..12	P 合金鋼 Alloyed Steels	OM4010	90~250	0.08(0.06~0.12)
		OM4025	90~230	0.08(0.06~0.12)
	M 不鏽鋼 Stainless Steels	OM4010	55~110	0.06(0.06~0.12)
		OM4025	55~100	0.06(0.06~0.12)
	K 鑄鐵 Cast Iron	OM4025	110~275	0.08(0.06~0.12)
	N 鋁合金 Aluminum&Al	OM5005	500~700	0.15(0.15~0.17)



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