



SSP M405

倒角刀系列
Chamfering Series



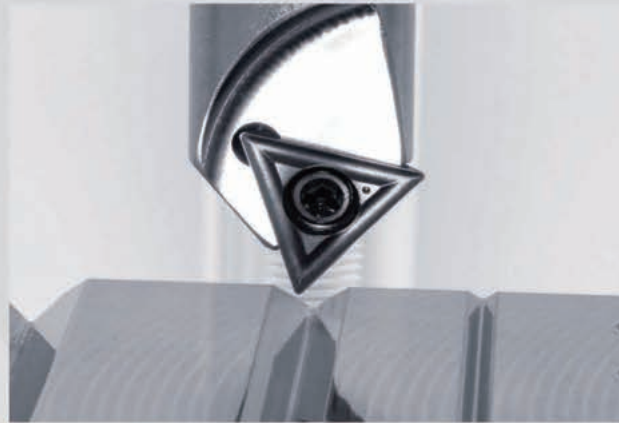


- 可做倒角，V 槽切削，45°定位倒角刀亦可做刻字及當定位鑽使用
- 刀具及刀片特殊設計，於定位鑽及 V 槽切削時刀片可避免干涉
- 使用一般銑床、CNC 銑床、CNC 車床
- Chamfering, v-grooving, the 45° spot drill can be used for carving and spotting.
- Clearance angle negates interference between the insert/cutting tool and the workpiece during v-grooving and spotting.
- Could be applied on milling machine, CNC milling machine and CNC lathe.

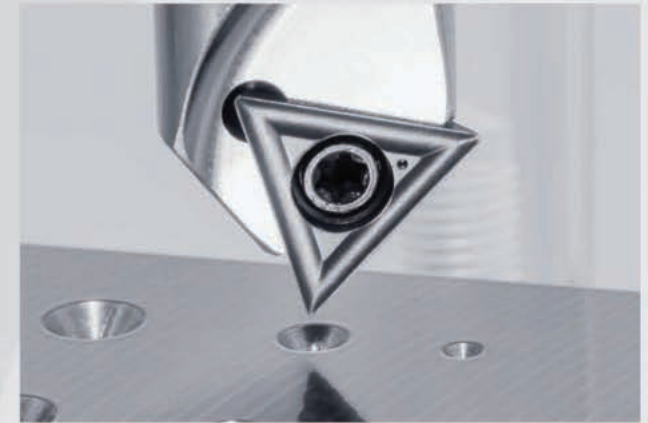
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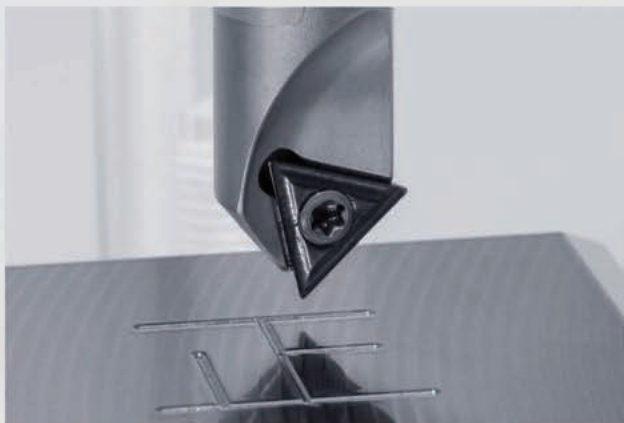
內孔倒角
Inner hole chamfering



V 槽切削
V-grooving






定位鑽
Spotting



刻字
Carving/Engraving

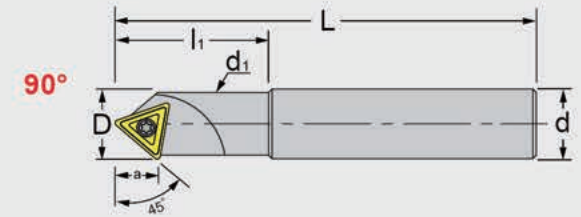


倒角
Chamfering

加工種類 Cutting Type		倒角刀類型 Cutter Type	 SSP 45°	 SSP 30°	 SSP 60°
		1	定位鑽加工 (Spotting)		✓
2	刻字加工 (Carving/Engraving)		✓		
3	V 型槽加工 (V-grooving)		✓		
4	內孔倒角加工 (Inner hole chamfering)		✓	✓	✓
5	外邊倒角加工 (Outer hole chamfering)		✓	✓	✓
6	加工件角度 90° (90 degree chamfering)		✓		
7	加工件角度 120° (120 degree chamfering)			✓	
8	加工件角度 60° (60 degree chamfering)				✓



SSP-45°



規格 Spec.	L	l1	D	d	d1	a	功能 Function	刀片 Insert	重量 (KGS) Weight
SSP-1212-105L	105	26	13.8	12	11.8	6.05	倒角 定位 (04R 角)	TC..1003	0.31
SSP-1616-110L	110	30	19.2	16	14	9.7	倒角 定位 (04R 角)	TC..13T3	0.18
SSP-2012-100L	100	35	22.5	12	19	11.3	倒角 定位 (08R 角)	TC..16T3	0.14
SSP-2020-130L	130	50	22.5	20	19	11.3	倒角 定位 (08R 角)	TC..16T3	0.31

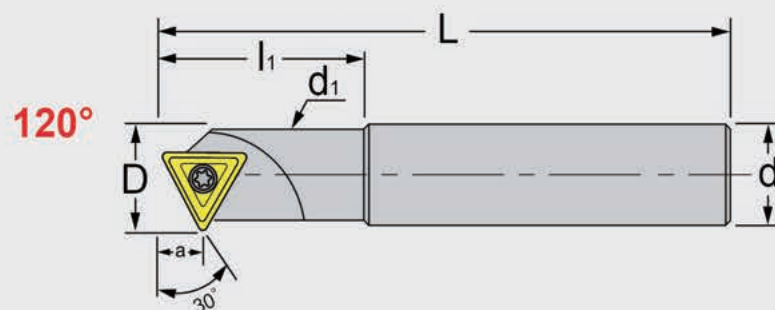
配件表 Accessories

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

適用產業類別 Applicable Industry



SSP-30°



規格 Spec.	L	l1	D	d	d1	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	TC..1003	0.12
SSP-1616-110L-TC13-30	110	30	19.2	16	14	6.5	倒角	TC..13T3	0.18
SSP-2020-130L-TC16-30	130	50	22.5	20	19	7.6	倒角	TC..16T3	0.32

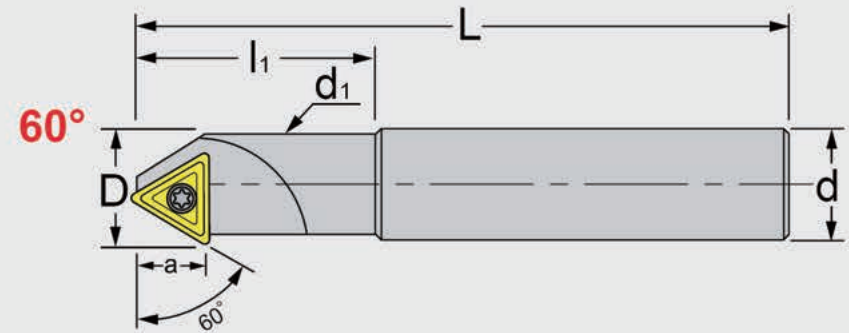
配件表 Accessories

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

適用產業類別 Applicable Industry



SSP-60°



規格 Spec.	L	l1	D	d	d1	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	TC..1003	0.12
SSP-1616-110L-TC13-60	110	30	19.2	16	14	11.16	倒角	TC..13T3	0.18
SSP-2020-130L-TC16-60	130	50	22.5	20	19	11.83	倒角	TC..16T3	0.32







配件表 Accessories

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

適用產業類別 Applicable Industry



SSP 倒角刀 SSP DRILL CUTTER

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) Size				圖形 Drawing
		CHF						HF						d	i	s	r	
		OM4010	OM4025					OM5005										
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	○															
	TCEX100304E-FR							●					5.8	10	3.18	0.4		
	TCEX100304E-AR	●	●										5.8	10	3.18	0.4		
	TCEX13T302E-FR							●					7.94	13.4	3.97	0.2		
	TCEX13T304E-FR							●					7.94	13.4	3.97	0.4		
	TCEX13T302E-AR	●	●										7.94	13.4	3.97	0.2		
	TCEX13T304E-AR	●	●										7.94	13.4	3.97	0.4		
	TCMX16T304E-FR							●					9.52	16.5	3.97	0.4		
	TCMX16T308E-FR							●					9.52	16.5	3.97	0.8		
	TCMX16T304E-AR	●	●										9.52	16.5	3.97	0.4		
	TCMX16T308E-AR	●	●										9.52	16.5	3.97	0.8		

★ TC..10、TC..13、0.2R 角刀片為「倒角功能」專用 TC..10、TC..13、0.2mm chamfering radius.
 ★ TC..16、0.2R 角刀片為「倒角功能」專用 TC..16、0.4mm chamfering radius.

※ 規格末編碼帶 FR 刀片為銳角刀片 Suffix FR model designates a sharp cutting edge insert.

SSP 倒角刀切削數據 SSP Chamfering Tool Cutting Data

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>定位鑽加工 Spotting</p>	P 低合金鋼 Low-Alloy Steels	OM4010	220~290	0.05~0.12	0.5~3.0
		OM4025	220~260	0.03~0.06	0.5~3.0
	M 合金鋼 Alloy Steels	OM4010	80~150	0.05~0.12	0.5~3.0
		OM4025	100~150	0.03~0.06	0.5~3.0
	K 不鏽鋼 Stainless Steels	OM4010	90~200	0.05~0.12	0.5~3.0
		OM4025	90~180	0.01~0.05	0.5~3.0
	N 鑄鐵 Cast Iron	OM4025	70~130	0.05~0.12	0.5~3.0
	N 鋁合金 Aluminum&Al	OM5005	400~2000	0.06~0.08	0.5~5.0

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>刻字加工 Carving/Engraving</p>	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
	M 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
	K 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
	N 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)
 V 型槽加工 V-Grooving	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)
 倒角加工 Chamfer	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





M405 內外倒角刀

多刃數的設計可增加進給率

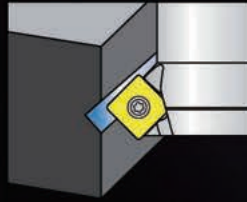
倒角時，較不易起毛邊，並可作
上下倒角加工

Multi-edge for high feeding rate.

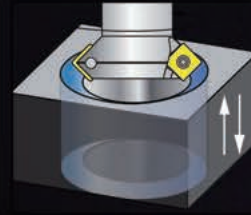
Free of burrs when chamfering.
Available for up and down
chamfering.

適用產業類別 Applicable Industry

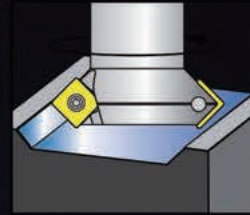




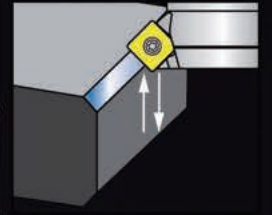
V 槽加工
V-Grooving



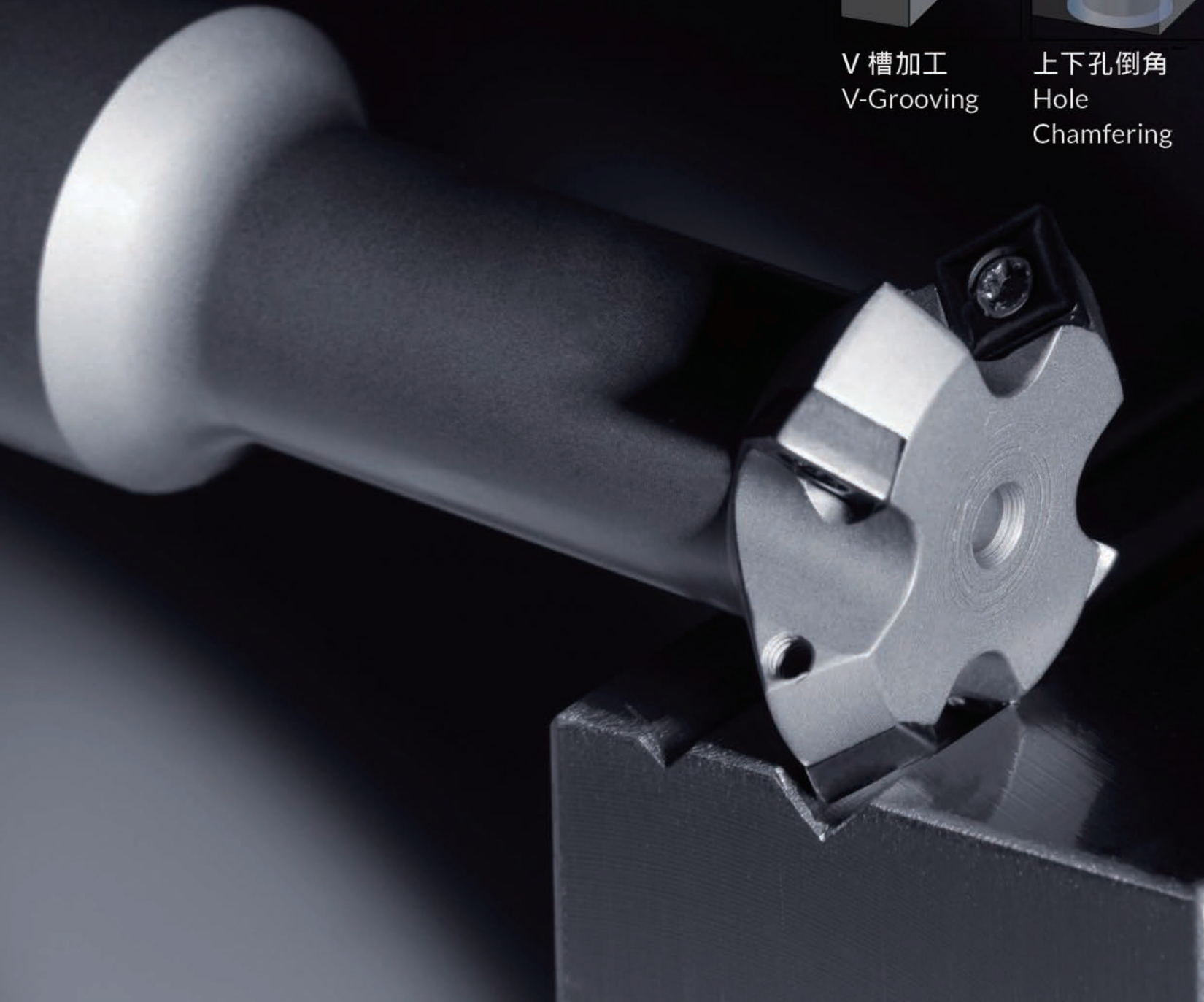
上下孔倒角
Hole
Chamfering

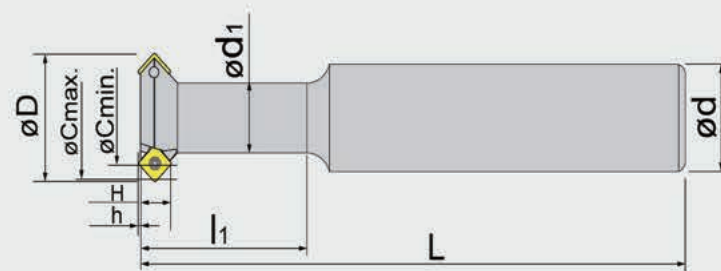


凹槽加工
Pocket
Machining



上下外邊倒角加工
Inner
Chamfering


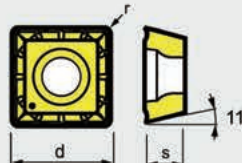

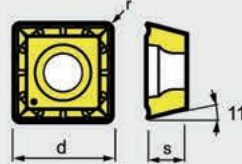




規格 Spec.	L	l1	ØD	Ød	Ød1	ØC		H	h	角度 Angle	刃數 Teeth	刀片 Insert	重量 (KGS) Weight
						Min.	Max.						
M405SP0545-091512-120-2T	120	20	15.7	12	8	9.9	15.3	6.57	0.12	45°	2	SP.0502	0.14
M405SP0545-131916-150-3T	150	30	19.7	16	12.8	13.6	19.3	6.66			3		0.26
M405SP0545-172320-150-4T		35	23.7	20	13	17.7	23.3	5.98			4		0.36
M405SP0745-202920-150-3T		40	29.9	25	20	17.2	20.3	29.6	10.4	0.15	3	0.38	
M405SP0745-273625-150-3T	36.9		27.5			36.3	10.1	0.2	3	0.58			
M405SP0745-344325-150-4T	43.9		34.5	43.5	10.1	0.2	4	0.60					
M405SP0745-415025-150-4T	50.9		41.2	50.3	10.4	0.12	4	0.66					

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 Torque
SP.0502	M2-4.3-2.7-60-T6-TIN	T6	0.6N.m
SP.07T3	M2.5-6.33-3.5-48-T8-TIN	T8	1.2N.m

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) Size				圖形 Drawing
		CHF						HF										
		RM3130	RM4025	RM4030				RM5060						d	i	s	r	
	SPGT050204-M02			●				●						5	-	2.38	0.4	
	SPGT07T308-M02			●				●						7.94	-	3.97	0.8	
	SPMT050204-M03	●	●											5	-	2.38	0.4	
	SPMT07T308-M03	●	●											7.94	-	3.97	0.8	



M405 倒角刀切削數據 M405 Chamfering Tool Cutting Data

被加工材質 Machining Materials		刀片材質 Grade	切削速度 Vc(m/min)	進給率 (mm/rev)	
				ø09-ø23	ø24-ø50
P	低合金鋼 Low-Alloy Steels	RM3130	120~220	0.06~0.12	0.06~0.12
		RM4025	120~220	0.06~0.12	0.06~0.12
		RM4030	180~260	0.06~0.12	0.06~0.12
	合金鋼 Alloyed Steels	RM3130	100~220	0.05~0.08	0.10~0.18
		RM4025	100~220	0.05~0.08	0.10~0.18
		RM4030	140~200	0.05~0.08	0.10~0.18
M	不鏽鋼 Stainless Steels	RM4025	90~160	0.06~0.10	0.06~0.12
		RM4030	120~180	0.05~0.10	0.08~0.15
K	鑄鐵 Cast Iron	RM3130	120~250	0.06~0.20	0.10~0.20
N	鋁合金 Aluminum&Al	RM5060	338~380	0.06~0.14	0.12~0.22

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



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