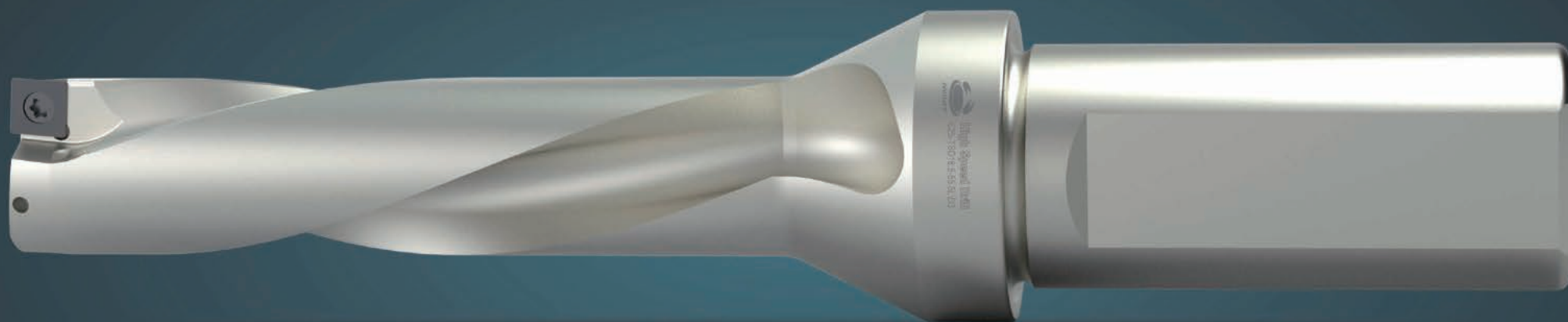




TSD 四角刀片快速鑽頭
Square Insert High Speed Drill

 **CHAIN
HEADWAY**
Cutting Edge Solution

長槽式設計增進了排屑能力

The long trough type design promoted the escape of chips ability.

特殊表面處理

Special Surface Finishing



中心出水
Water Hole

TSD特殊加工方式

TSP Special cutting method



斜面孔

Oblique Face



擴孔

Enlarge Hole



交叉孔

Cross Hole



半邊孔

Half Hole



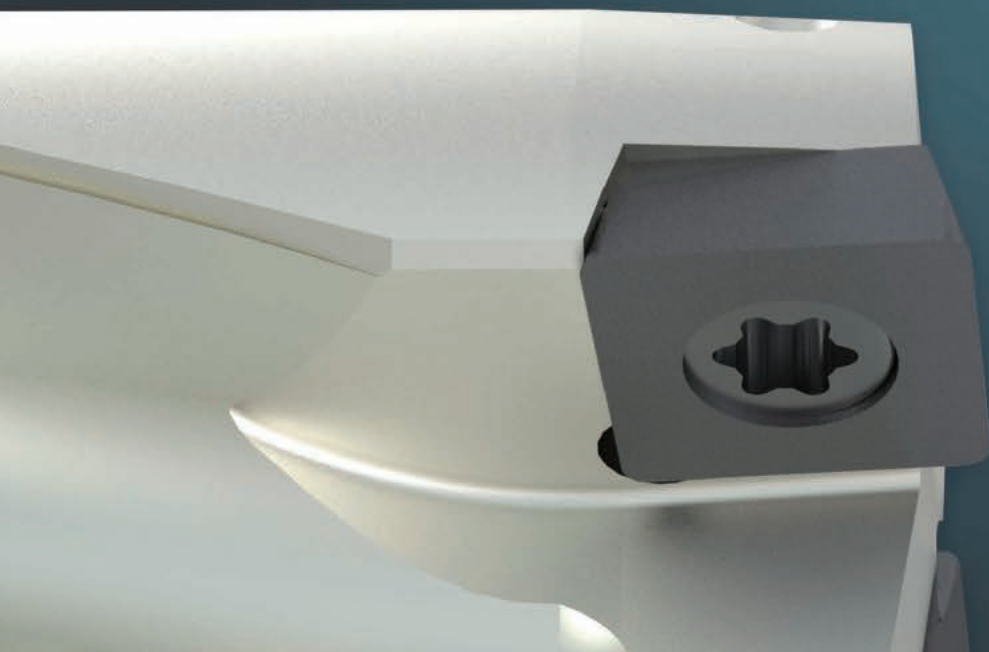
套孔

Target Drills



凹面孔

Concave Face



⚠ 注意事項 Tips



| 可用於粗加工除料或不規則表面鑽孔，無需預加工小孔，但表面傾斜角度不超過6度

Drilling irregular surface slope angle must be less than 6 degree.
Use exact drills directly. Don't use pilot.

| 在進刀和退刀時，降低進給率30%~50%

Reduce feed rate 30 to 50 percentage during enter and finish.



| 層板堆疊加工時，間隙應小於0.2mm

Drilling staked layer gap b/w the layer must be less than 0.2mm.

| 板材有變形及彎曲時，仍可進行加工作業

Be able to drill irregular bend layers.

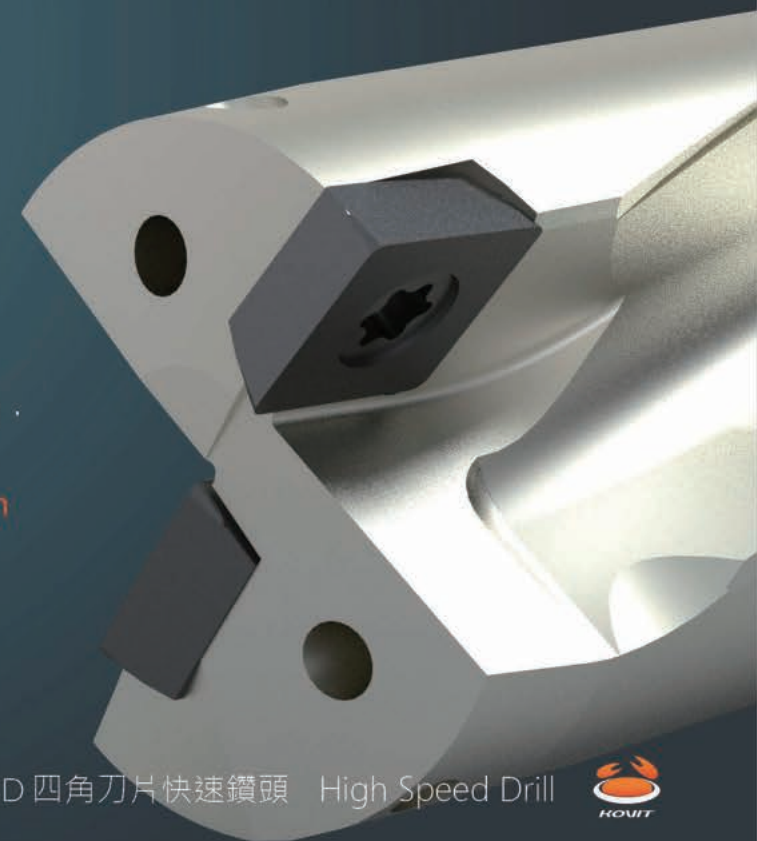
| 在進刀和退刀時，降低進給率30%~50%

Reduce feed rate 30 to 50 percentage during enter and finish.

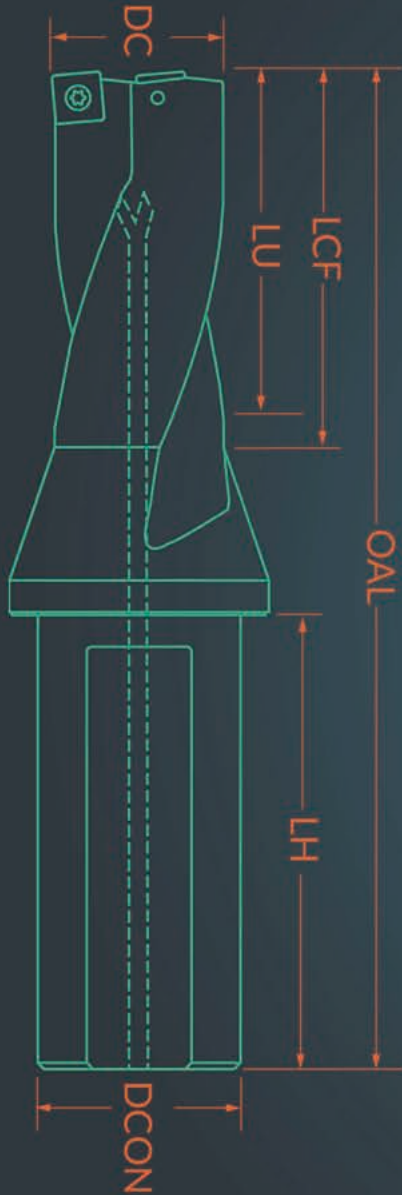


| 正確的使用切削液的壓力值，有助於鐵屑的排出，及降低刀具振動，和提高刀具壽命

Use the coolant with exact pressure provide you stable operation and improve cutter life.



Dx2



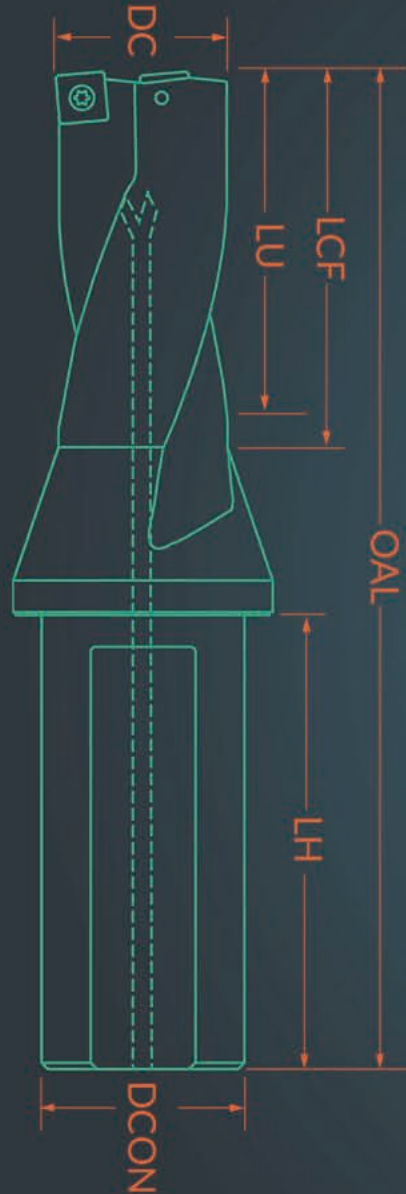
規格 Spec.	OAL	LH	LU	LCF	DC	DCON	刀片 Insert	重量 (KGS) Weight
C25-TSD13-26L	106	56	26	31	13	25	SP.0502	0.32
C25-TSD14-28L	108		28	33	14			0.33
C25-TSD15-30L	110		30	35	15			0.33
C25-TSD16-32L	114		32	37	16		SP.0602	0.34
C25-TSD17-34L	116		34	39	17			0.35
C25-TSD18-36L	118		36	41	18			0.36
C25-TSD19-38L	120		38	43	19			0.37
C25-TSD20-40L	122		40	45	20			0.38
C25-TSD21-42L	124		42	47	21			0.39
C25-TSD22-44L	126		44	49	22			0.60
C32-TSD23-46L	134	60	46	51	23	32	SP.07T3	0.61
C32-TSD24-48L	136		48	53	24			0.61
C32-TSD25-50L	138		50	55	25			0.64
C32-TSD26-52L	140		52	57	26			0.66
C32-TSD27-54L	142		54	59	27			0.67
C32-TSD28-56L	146		56	61	28		SP.0904	0.68
C32-TSD29-58L	148		58	63	29			0.72
C32-TSD30-60L	150		60	65	30			0.74

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP.0502	M2-4.3-2.7-60-T6-TIN	T6	0.6
SP.0602	M2.2-5.2-3.1-60-T7-TIN	T7	0.9
SP.07T3	M2.5-6.33-3.5-48-T8-TIN	T8	1.2
SP.0904	M3.5-8.4-5.0-60-T10-TIN	T10	2.0



Dx2

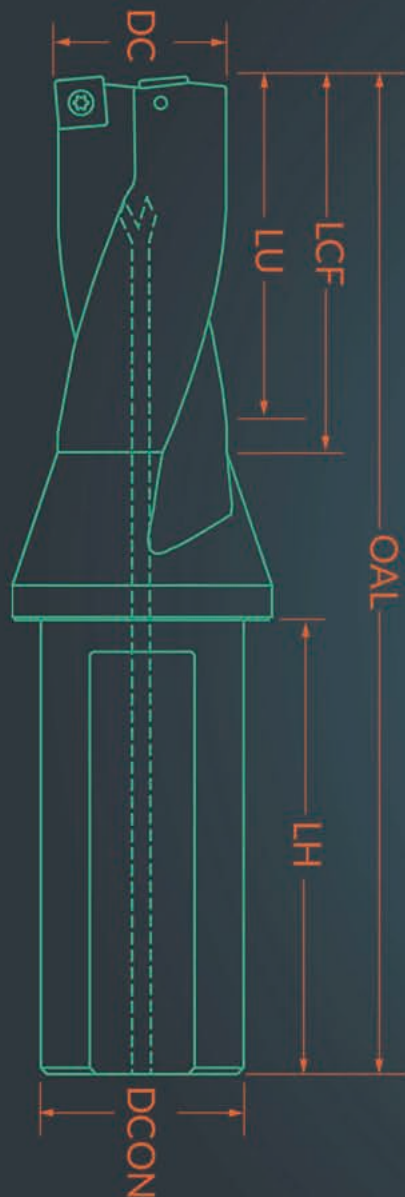


規格 Spec.	OAL	LH	LU	LCF	DC	DCON	刀片 Insert	重量 (KGS) Weight
C32-TSD31-62L	152	60	62	67	31	32	SP..0904	0.76
C32-TSD32-64L	154		64	69	32			0.78
C32-TSD33-66L	156		66	71	33			0.80
C32-TSD34-68L	158		68	73	34		SP..1104	0.82
C32-TSD35-70L	160		70	75	35			0.84
C32-TSD36-72L	162		72	77	36			0.86
C32-TSD37-74L	164		74	79	37			0.88
C32-TSD38-76L	166		76	81	38			0.93
C32-TSD39-78L	168		78	83	39			0.94
C40-TSD40-80L	184	70	80	85	40	40	SP..1405	1.40
C40-TSD41-82L	186		82	87	41			1.38
C40-TSD42-84L	188		84	89	42		SP..1405	1.42
C40-TSD43-86L	190		86	91	43			1.44
C40-TSD44-88L	192		88	93	44			1.51
C40-TSD45-90L	194		90	95	45			1.57
C40-TSD46-92L	196		92	97	46			1.61
C40-TSD47-94L	198		94	99	47			1.66
C40-TSD48-96L	200		96	101	48			1.71
C40-TSD49-98L	202		98	103	49			1.77
C40-TSD50-100L	204		100	102	50			1.81

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP..0904	M3.5-8.4-5.0-60-T10-TIN	T10	2.0
SP..1104	M4-9.35-5.65-60-T15-TIN	T15	3.0
SP..1405	M5-12.8-7.0-60-T20-TIN	T20	5.0

Dx2 點數



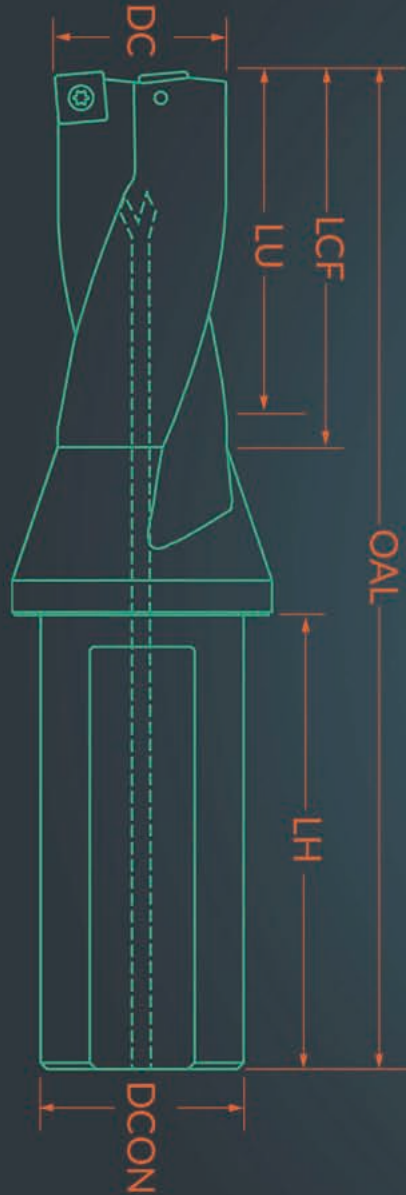
規格 Spec.	OAL	LH	LU	LCF	DC	DCON	刀片 Insert	重量 (KGS) Weight
C25-TSD13.5-27L	107	56	27	32	13.5	25	SP.0502	0.33
C25-TSD14.5-29L	109		29	34	14.5			0.33
C25-TSD15.5-31L	113		31	36	15.5		SP.0602	0.34
C25-TSD16.5-33L	115		33	38	16.5			0.35
C25-TSD17.5-35L	117		35	40	17.5			0.36
C25-TSD18.5-37L	119		37	42	18.5			0.36
C25-TSD19.5-39L	121		39	44	19.5			0.37
C25-TSD20.5-41L	123		41	46	20.5			0.38
C25-TSD21.5-43L	125		43	48	21.5			0.39

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP.0502	M2-4.3-2.7-60-T6-TIN	T6	0.6
SP.0602	M2.2-5.2-3.1-60-T7-TIN	T7	0.9



Dx3

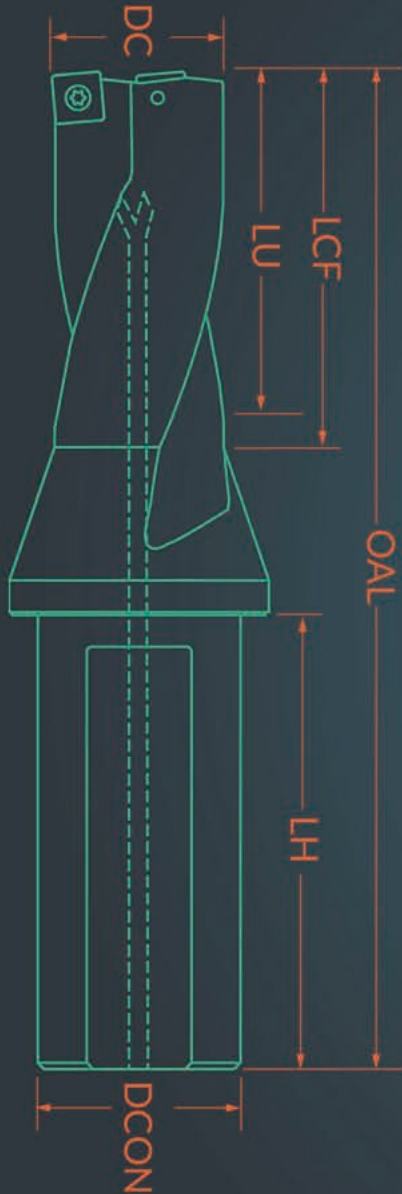


規格 Spec.	OAL	LH	LU	LCF	DC	DCON	刀片 Insert	重量 (KGS) Weight
C20-TSD13-39L	111	50	39	44	13	20	SP.0502	0.20
C20-TSD14-42L	114		42	47	14			0.18
C20-TSD15-45L	117		45	50	15			0.21
C25-TSD16-48L	130	56	48	53	16	25	SP.0602	0.31
C25-TSD17-51L	133		51	56	17			0.32
C25-TSD18-54L	136		54	59	18			0.34
C25-TSD19-57L	139		57	62	19			0.35
C25-TSD20-60L	142		60	65	20			0.37
C25-TSD21-63L	145		63	68	21			0.38
C25-TSD22-66L	148	60	66	71	22	32	SP.07T3	0.39
C25-TSD23-69L	157		69	74	23			-
C25-TSD24-72L	160		72	77	24			-
C25-TSD25-75L	163		75	80	25			-
C32-TSD23-69L	157		69	74	23			0.66
C32-TSD24-72L	160		72	77	24			0.67
C32-TSD25-75L	163		75	80	25			0.72
C32-TSD26-78L	166		78	83	26			0.73
C32-TSD27-81L	169		81	86	27			0.75
C32-TSD28-84L	174		84	89	28		SP.0904	0.78
C32-TSD29-87L	177		87	92	29			0.81
C32-TSD30-90L	180		90	95	30			0.83

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP.0502	M2-4.3-2.7-60-T6-TIN	T6	0.6
SP.0602	M2.2-5.2-3.1-60-T7-TIN	T7	0.9
SP.07T3	M2.5-6.33-3.5-48-T8-TIN	T8	1.2
SP.0904	M3.5-8.4-5.0-60-T10-TIN	T10	2.0

Dx3



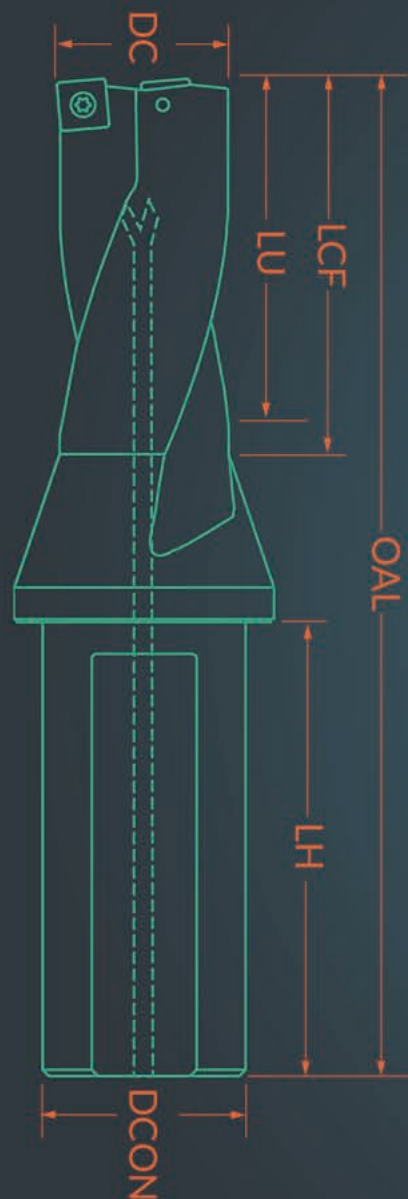
規格 Spec.	OAL	LH	LU	LCF	DC	DCON	刀片 Insert	重量 (KGS) Weight
C32-TSD31-93L	186	60	93	98	31	32	SP..0904	0.88
C32-TSD32-96L	186		96	101	32			0.90
C32-TSD33-99L	189		99	104	33			0.93
C32-TSD34-102L	192		102	107	34		SP..1104	0.98
C32-TSD35-105L	195		105	110	35			0.99
C32-TSD36-108L	198		108	113	36			1.09
C32-TSD37-111L	201		111	116	37			1.08
C32-TSD38-114L	204		114	119	38			1.12
C32-TSD39-117L	207		117	122	39			1.22
C40-TSD40-120L	224	70	120	125	40	40	SP..1405	1.74
C40-TSD41-123L	227		123	128	41			1.79
C40-TSD42-126L	230		126	131	42			1.62
C40-TSD43-129L	233		129	134	43			1.70
C40-TSD44-132L	236		132	137	44			1.75
C40-TSD45-135L	239		135	140	45			1.84
C40-TSD46-138L	242		138	143	46			1.92
C40-TSD47-141L	245		141	146	47			1.97
C40-TSD48-144L	248		144	149	48			2.06
C40-TSD49-147L	251		147	152	49			2.12
C40-TSD50-150L	254		150	155	50			2.22

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP..0904	M3.5-8.4-5.0-60-T10-TIN	T10	2.0
SP..1104	M4-9.35-5.65-60-T15-TIN	T15	3.0
SP..1405	M5-12.8-7.0-60-T20-TIN	T20	5.0



Dx3 點數

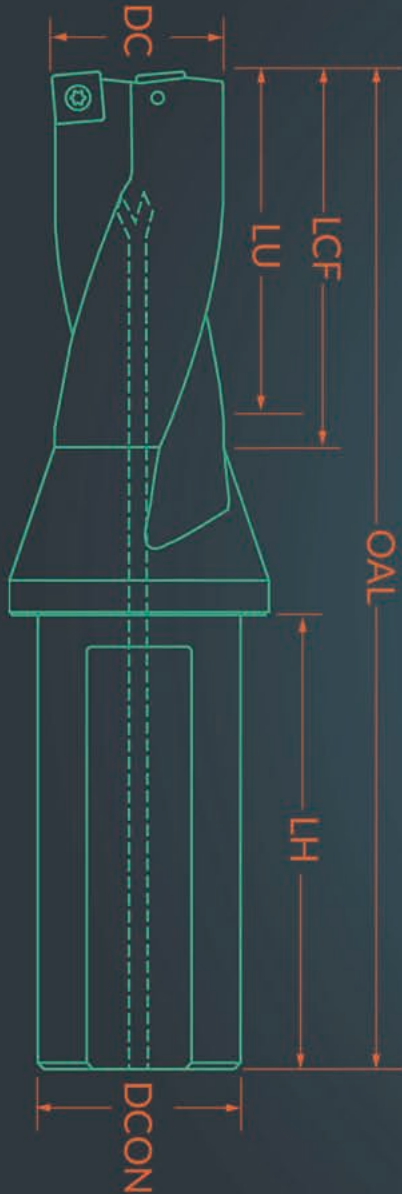


規格 Spec.	OAL	LH	LU	LCF	DC	DCON	刀片 Insert	重量 (KGS) Weight
C20-TSD13.5-40.5L	112.5	50	40.5	45.5	13.5	20	SP.0502	0.18
C20-TSD14.5-43.5L	115.5		43.5	48.5	14.5			0.21
C25-TSD15.5-46.5L	128.5	56	46.5	51.5	15.5	25	SP.0602	0.32
C25-TSD16.5-49.5L	131.5		49.5	54.5	16.5			0.33
C25-TSD17.5-52.5L	134.5		52.5	57.5	17.5			0.33
C25-TSD18.5-55.5L	137.5		55.5	60.5	18.5			0.35
C25-TSD19.5-58.5L	140.5		58.5	63.5	19.5			0.38
C25-TSD20.5-61.5L	143.5		61.5	66.5	20.5			0.38
C25-TSD21.5-64.5L	146.5		64.5	69.5	21.5			0.40
C32-TSD22.5-67.5L	155.5	60	67.5	72.5	22.5	32	SP.07T3	0.65
C32-TSD23.5-70.5L	158.5		70.5	75.5	23.5			0.66
C32-TSD24.5-73.5L	161.5		73.5	78.5	24.5			0.71
C32-TSD25.5-76.5L	164.5		76.5	81.5	25.5			0.72
C32-TSD26.5-79.5L	167.5		79.5	84.5	26.5			0.75
C32-TSD27.5-82.5L	170.5		82.5	87.5	27.5			0.76
C32-TSD28.5-85.5L	175.5		85.5	90.5	28.5		SP.0904	0.80
C32-TSD29.5-88.5L	178.5		88.5	93.5	29.5			0.82
C32-TSD30.5-91.5L	181.5		91.5	96.5	30.5			0.87
C32-TSD31.5-94.5L	184.5		94.5	99.5	31.5			0.89
C32-TSD32.5-97.5L	187.5		97.5	102.5	32.5			0.92
C32-TSD33.5-100.5L	190.5		100.5	105.5	33.5			0.96

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP.0502	M2-4.3-2.7-60-T6-TIN	T6	0.6
SP.0602	M2.2-5.2-3.1-60-T7-TIN	T7	0.9
SP.07T3	M2.5-6.33-3.5-48-T8-TIN	T8	1.2
SP.0904	M3.5-8.4-5.0-60-T10-TIN	T10	2.0

Dx4



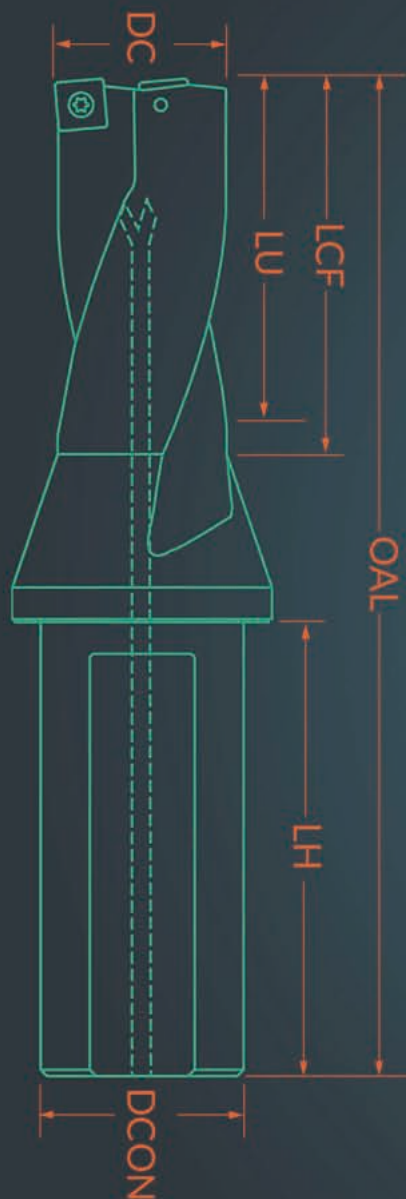
規格 Spec.	OAL	LH	LU	LCF	DC	DCON	刀片 Insert	重量 (KGS) Weight
C25-TSD13-52L	132	56	52	57	13	25	SP.0502	0.34
C25-TSD14-56L	136		56	61	14			0.34
C25-TSD15-60L	140		60	65	15			0.36
C25-TSD16-64L	146		64	69	16		SP.0602	0.37
C25-TSD17-68L	150		68	73	17			0.38
C25-TSD18-72L	154		72	77	18			0.40
C25-TSD19-76L	158		76	81	19			0.41
C25-TSD20-80L	162		80	85	20			0.43
C25-TSD21-84L	166		84	89	21		0.45	
C25-TSD22-88L	170		88	93	22		SP.07T3	0.67
C32-TSD23-92L	180	60	92	97	23	32		0.69
C32-TSD24-96L	184		96	101	24			0.71
C32-TSD25-100L	188		100	105	25			0.74
C32-TSD26-104L	192		104	109	26			0.77
C32-TSD27-108L	196		108	113	27			0.81
C32-TSD28-112L	202		112	117	28	SP.0904		0.86
C32-TSD29-116L	206		116	121	29		0.88	
C32-TSD30-120L	210		120	125	30		0.94	

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP.0502	M2-4.3-2.7-60-T6-TIN	T6	0.6
SP.0602	M2.2-5.2-3.1-60-T7-TIN	T7	0.9
SP.07T3	M2.5-6.33-3.5-48-T8-TIN	T8	1.2
SP.0904	M3.5-8.4-5.0-60-T10-TIN	T10	2.0



Dx4

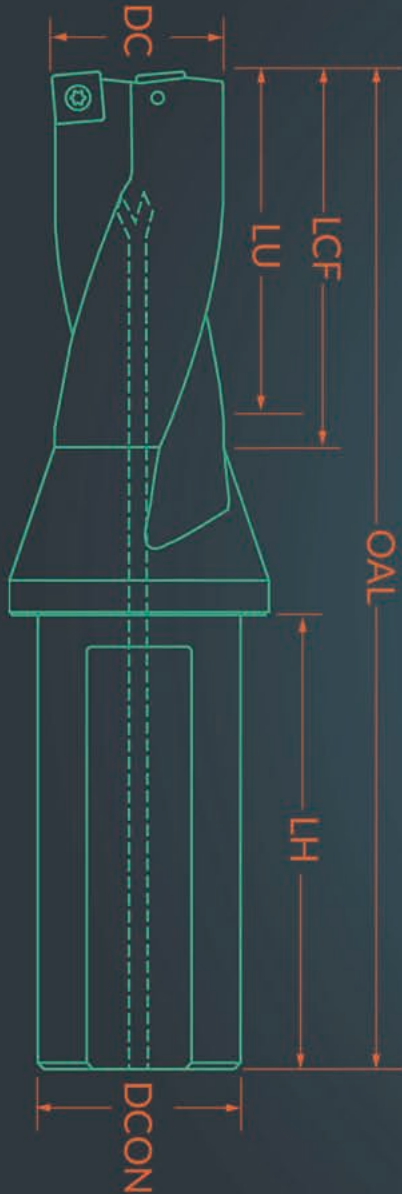


規格 Spec.	OAL	LH	LU	LCF	DC	DCON	刀片 Insert	重量 (KGS) Weight
C32-TSD31-124L	214	60	124	129	31	32	SP.0904	0.96
C32-TSD32-128L	218		128	133	32			1.01
C32-TSD33-132L	222		132	137	33			1.06
C32-TSD34-136L	226		136	141	34		SP.1104	1.07
C32-TSD35-140L	230		140	145	35			1.12
C32-TSD36-144L	234		144	149	36			1.15
C32-TSD37-148L	238		148	153	37			1.21
C32-TSD38-152L	242		152	157	38			1.24
C32-TSD39-156L	246		156	161	39			1.33
C40-TSD40-160L	264	70	160	165	40	40	SP.1405	1.80
C40-TSD41-164L	268		164	169	41			1.81
C40-TSD42-168L	272		168	173	42			1.83
C40-TSD43-172L	276		172	177	43			1.93
C40-TSD44-176L	280		176	181	44			2.00
C40-TSD45-180L	284		180	185	45			2.13
C40-TSD46-184L	288		184	189	46			2.20
C40-TSD47-188L	292		188	193	47			2.28
C40-TSD48-192L	296		192	197	48			2.38
C40-TSD49-196L	300		196	201	49			2.48
C40-TSD50-200L	304		200	205	50			2.61

配件表 Accessories

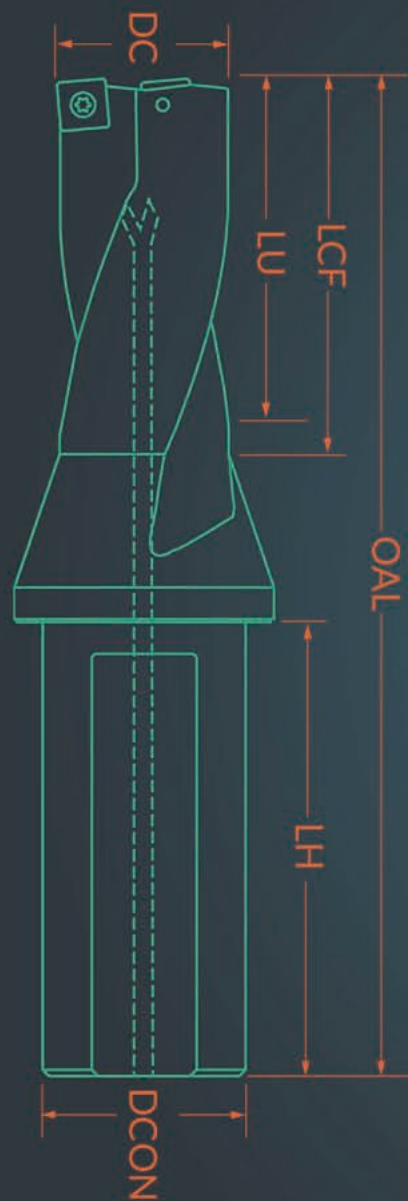
刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP.0904	M3.5-8.4-5.0-60-T10-TIN	T10	2.0
SP.1104	M4-9.35-5.65-60-T15-TIN	T15	3.0
SP.1405	M5-12.8-7.0-60-T20-TIN	T20	5.0

Dx5



規格 Spec.	OAL	LH	LU	LCF	DC	DCON	刀片 Insert	重量 (KGS) Weight	
C25-TSD16-80L	162	56	80	85	16	25	SP..0602	0.38	
C25-TSD17-85L	167		85	90	17			0.40	
C25-TSD18-90L	172		90	95	18			0.42	
C25-TSD19-95L	177		95	100	19			0.44	
C25-TSD20-100L	182		100	105	20			0.46	
C25-TSD21-105L	187		105	110	21			0.49	
C25-TSD22-110L	192			110	115		22		0.50
C32-TSD23-115L	203	60	115	120	23	32	SP..07T3	0.75	
C32-TSD24-120L	208		120	125	24			0.77	
C32-TSD25-125L	213		125	130	25			0.80	
C32-TSD26-130L	218		130	135	26			0.83	
C32-TSD27-135L	223		135	140	27			0.87	
C32-TSD28-140L	230		140	145	28		SP..0904	0.93	
C32-TSD29-145L	235		145	150	29			0.97	
C32-TSD30-150L	240		150	155	30			1.01	
C32-TSD31-155L	245		155	160	31			1.06	
C32-TSD32-160L	250		160	165	32			1.11	
C32-TSD33-165L	255		165	170	33			1.17	
C32-TSD34-170L	260		170	175	34		SP..1104	1.20	
C32-TSD35-175L	265		175	180	35			1.26	
C32-TSD36-180L	270		180	185	36			1.31	
C32-TSD37-185L	275		185	190	37			1.36	
C32-TSD38-190L	280		190	195	38			1.45	
C32-TSD39-195L	285		195	200	39			1.51	
C40-TSD40-200L	304	70	200	205	40	40		2.20	
C40-TSD41-205L	309		205	210	41			2.40	





配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP.0602	M2.2-5.2-3.1-60-T7-TIN	T7	0.9
SP.07T3	M2.5-6.33-3.5-48-T8-TIN	T8	1.2
SP.0904	M3.5-8.4-5.0-60-T10-TIN	T10	2.0
SP.1104	M4-9.35-5.65-60-T15-TIN	T15	3.0



015 - TSD 四角刀片快速鑽頭 High Speed Drill

Dx3 套裝

規格 Spec.	內容物 Contents							重 量 (KGS) Weight
	刀片 Insert	螺絲  Screw	扳手  Wrench	扭力值 (N.m) Torque	螺絲膏  Screw Cream	數量 Qty	Fig.	
C20-TSD13-39L-SET	SPGT050204-M02 RM4030(10 片)	M2-4.3-2.7-60-T6-TIN	T6K	0.6	CHMT-6020	1	1	0.70
C20-TSD14-42L-SET								0.75
C20-TSD15-45L-SET								0.80
C25-TSD16-48L-SET	SPGT060204-M02 RM4030(10 片)	M2.2-5.2-3.1-60-T7-TIN	T7K	0.9				0.85
C25-TSD17-51L-SET								0.85
C25-TSD18-54L-SET								0.89
C25-TSD19-57L-SET								0.94
C25-TSD20-60L-SET								0.94
C25-TSD21-63L-SET								-
C25-TSD22-66L-SET	SPGT07T308-M02 RM4030(10 片)	M2.5-6.33-3.5-48-T8-TIN	T8K	1.2			2	0.90
C32-TSD23-69L-SET								-
C32-TSD24-72L-SET								-
C32-TSD25-75L-SET								-
C32-TSD26-78L-SET								-
C32-TSD27-81L-SET								-
C32-TSD28-84L-SET	SPGT090408-M02 RM4030(10 片)	M3.5-8.4-5.0-60-T10-TIN	T10K	2.0				-
C32-TSD29-87L-SET								-
C32-TSD30-90L-SET								-
C32-TSD31-93L-SET								-
C32-TSD32-96L-SET								-
C32-TSD33-99L-SET								-

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	RM3130	RM4025	RM4030			RM5060							d	i	s	r	
	SPGT060204-M03			●	●										6	-	2.38	0.4		
	SPGT050204-M02					●			●						5	-	2.38	0.4		
	SPGT060204-M02					●			●						6	-	2.38	0.4		
	SPGT07T308-M02					●			●						7.94	-	3.97	0.8		
	SPGT090408-M02					●			●						9.8	-	4.3	0.8		
	SPGT110408-M02					●			●						11.5	-	4.76	0.8		
	SPGT140512-M02					●			●						14.3	-	5.2	1.2		
	SPMT050204-M01	●	●												5	-	2.38	0.4		
	SPMT060204-M01	●	●												6	-	2.38	0.4		
	SPMT07T308-M01	●	●												7.94	-	3.97	0.8		
	SPMT090408-M01	●	●												9.8	-	4.3	0.8		
	SPMT110408-M01	●	●												11.5	-	4.76	0.8		
	SPMT140512-M01	●	●												14.3	-	5.2	1.2		



SP_05.06.07.09.11.14 切削條件數據表

Cutting Conditions

被加工材質 Machining Materials		刀片材質 Grade	切削速度 Vc(m/min)	進給率 (mm/rev)				
				ø13-ø15	ø16-ø22	ø23-ø33	ø34-ø41	ø42-ø50
P	低合金鋼 Low-Alloy Steels	OM4010	180~300	0.06~0.12	0.06~0.10	0.06~0.12	0.12~0.24	0.12~0.25
		OM4025	160~250	0.06~0.12	0.06~0.10	0.06~0.12	0.12~0.24	0.12~0.25
		RM4030	180~260	0.06~0.12	0.06~0.10	0.06~0.12	0.12~0.24	0.12~0.25
	合金鋼 Alloyed Steels	OM4010	160~250	0.05~0.08	0.08~0.15	0.10~0.18	0.08~0.15	0.10~0.18
		OM4025	120~180	0.05~0.08	0.08~0.15	0.10~0.18	0.08~0.15	0.10~0.18
		RM4030	140~200	0.05~0.08	0.08~0.15	0.10~0.18	0.08~0.15	0.10~0.18
M	不鏽鋼 Stainless Steels	OM4010	160~220	0.05~0.10	0.06~0.12	0.08~0.15	0.10~0.17	0.12~0.20
		OM4025	120~180	0.05~0.10	0.06~0.12	0.08~0.15	0.10~0.17	0.12~0.20
		RM4030	120~180	0.05~0.10	0.06~0.12	0.08~0.15	0.10~0.17	0.12~0.20
K	鑄鐵 Cast Iron	OM4010	180~260	0.06~0.12	0.08~0.16	0.12~0.20	0.16~0.25	0.18~0.26
		OM4025	160~220	0.06~0.12	0.08~0.16	0.12~0.20	0.16~0.25	0.18~0.26
N	鋁合金 Aluminum&Al	RM5060	338~380	0.06~0.14	0.08~0.18	0.12~0.22	0.14~0.25	0.14~0.28



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