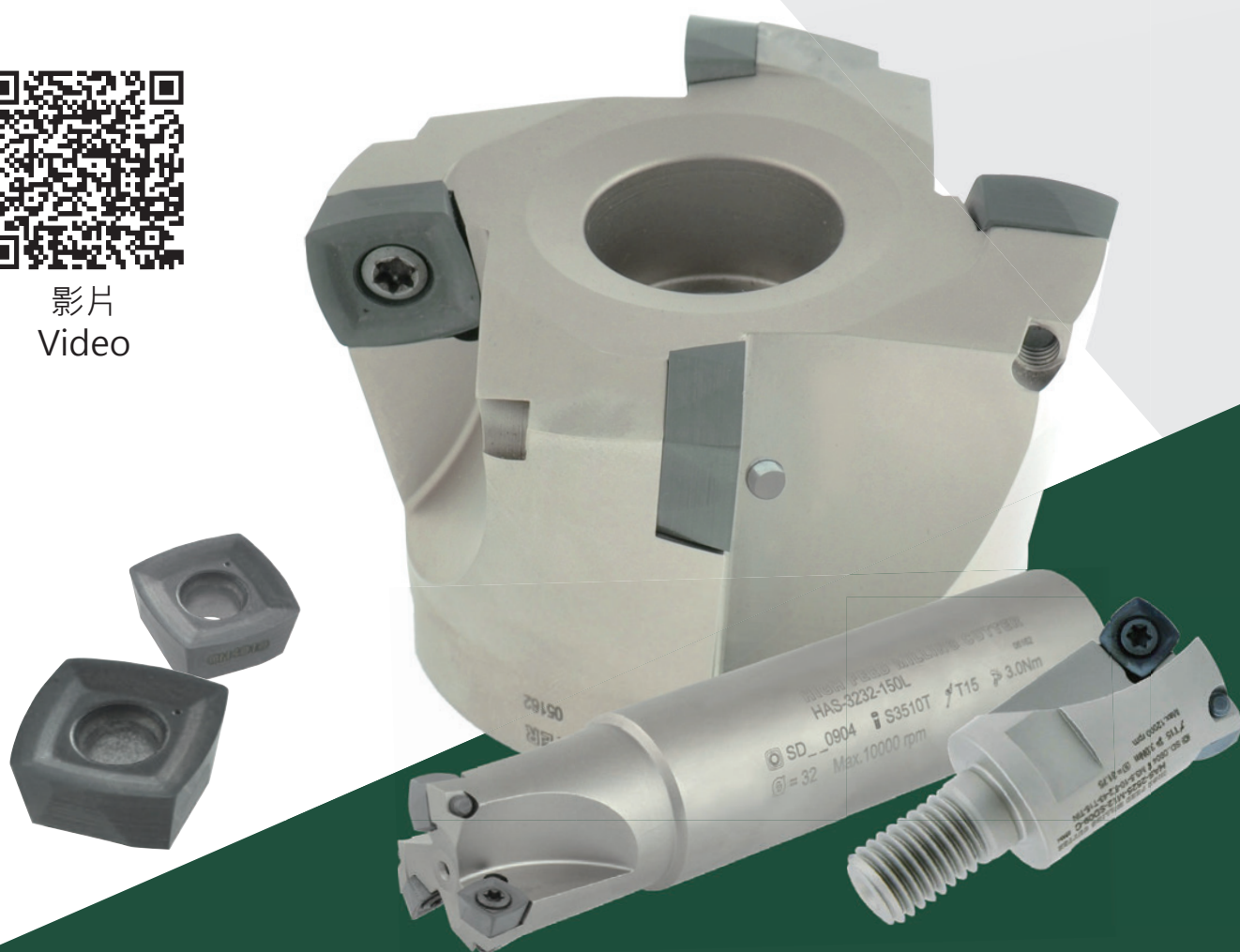


HIGH FEED MILLING CUTTER SERIES

大進給切削系列



影片
Video

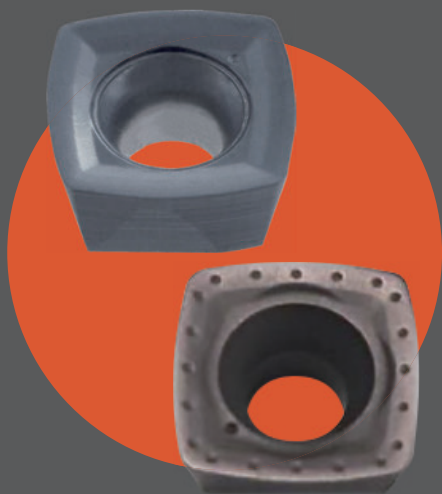


HAS/HGP 特點

Features of HAS/HGP

刀具樣式：直柄、鎖牙式、殼形三種
使用刀片：SDMT、SDET

Tool Styles: Straight shank, Screw-on type, and Shell type.
Compatible Inserts: SDMT, SDET.



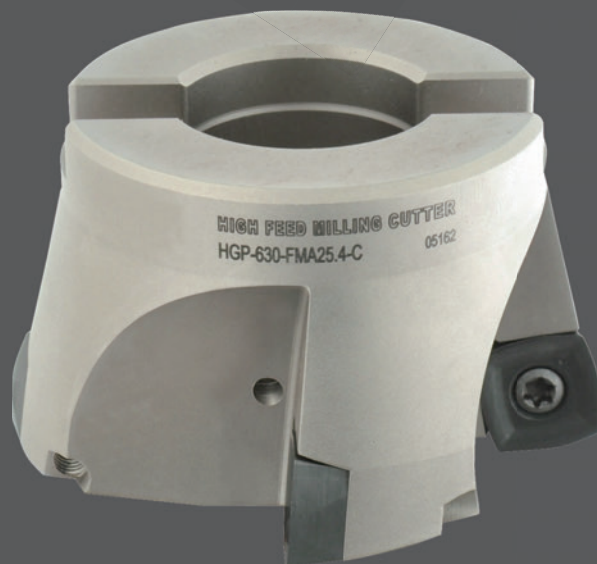
- SDET- 研磨級刀口較為鋒利
- SDMT-M 級刀片，刀口設計兼具強度與壽命
- 刀片可用四個刀口，有效降低成本
- SDET – Ground-grade inserts offer a sharper cutting edge.
- SDMT – M-grade inserts feature an edge design that balances strength and tool life.
- Each insert provides four usable cutting edges, effectively reducing cost.



- 中心出水
- 耐腐蝕性佳
- Through-center coolant
- Excellent corrosion resistance



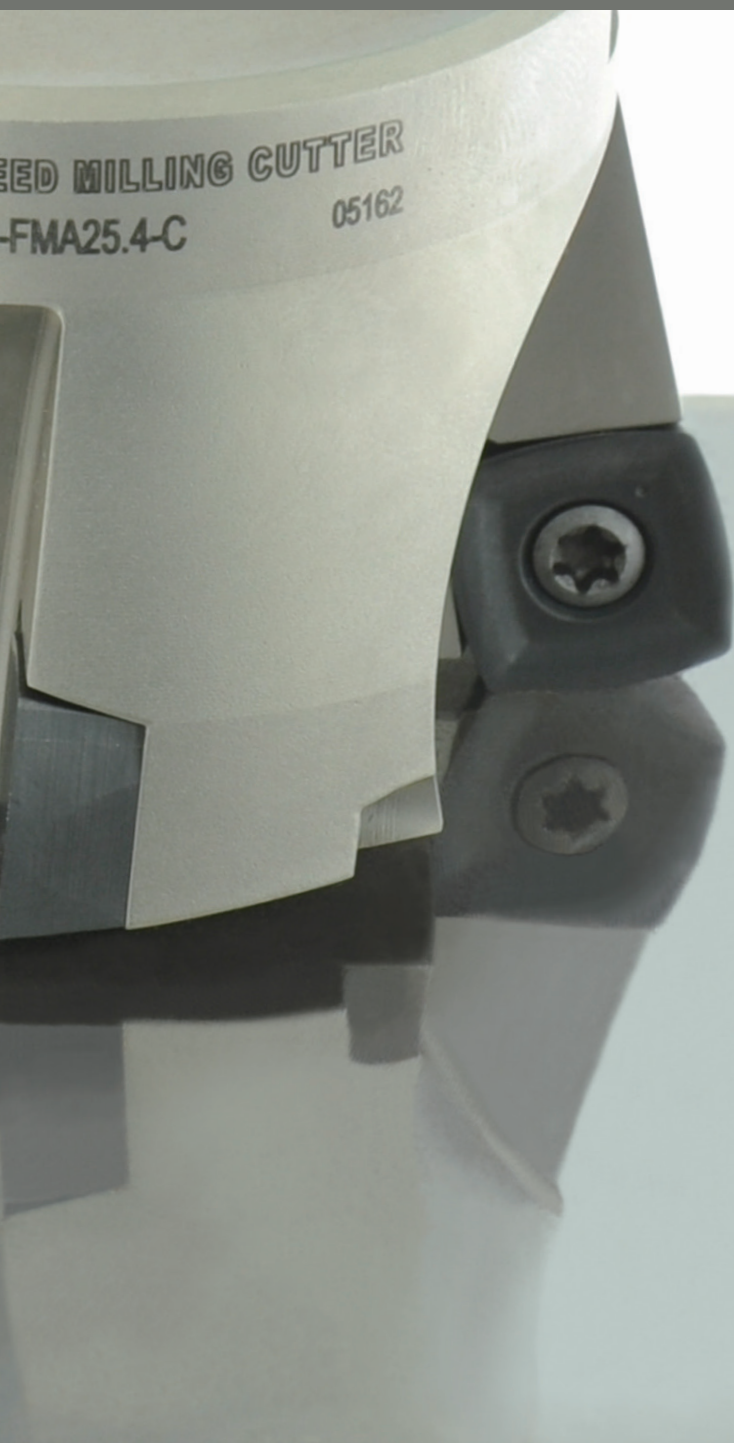
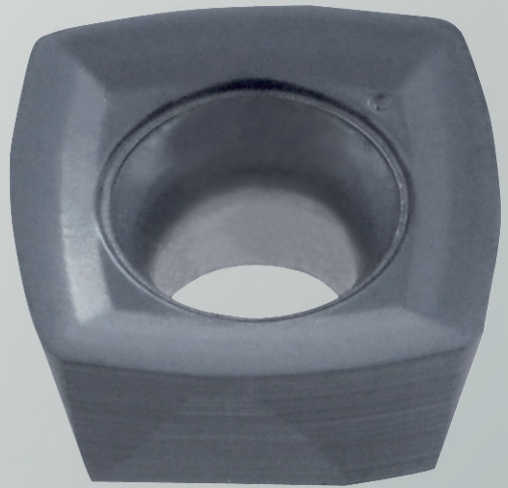
- 中心出水
- 特殊表面處理
- Through-center coolant
- Special surface treatment



HAS/HGP

大進給切削刀具

HIGH FEED
MILLING CUTTER



切削力以軸向為主
與圓形刀片刀具相比較
刀片及刀具的使用壽命較長

The cutting force is exerted
in the axial direction.

Compare with cutters using
round inserts, cutters using
square inserts are more
durable.

SP_06/SD_09.12 切削條件數據表 Cutting Parameter

SP.0603

被加工材質 Machining Materials	面銑 Facing			開槽 Slotting			插銑 Plunging		
	切削速度 Speed	每刃進給 Feed	切深 D.O.C.	切削速度 Speed	每刃進給 Feed	切深 D.O.C.	切削速度 Speed	每刃進給 Feed	切寬 W.O.C.
	V _c (m/min)	h _m (mm)	a _p max (mm)	V _c (m/min)	h _m (mm)	a _p max (mm)	V _c (m/min)	f max (mm)	a _e max (mm)
P 低合金鋼 Low-Alloy Steels	107-235	0.2-0.8	0.9	107-235	0.2-0.6	0.9	107-235	0.04-0.15	3
	合金鋼 Alloyed Steels	75-160	0.2-0.8	0.9	75-160	0.2-0.6	0.9	0.04-0.1	3
M 不鏽鋼 Stainless Steels	115-265	0.15-0.8	0.9	115-265	0.15-0.6	0.9	115-265	0.04-0.12	3
	析出硬化系 Precipitation-Hardening	50-150	0.15-0.8	0.9	50-150	0.15-0.6	0.9	0.04-0.12	3
K 鑄鐵 Cast Iron	152-335	0.2-0.8	0.9	152-335	0.2-0.6	0.9	152-335	0.04-0.12	3
N 鋁及鋁合金 Aluminum&Al	-	-	-	-	-	-	-	-	-
S 高溫合金 Refractory Alloys	25-60	0.15-0.5	0.9	25-60	0.1-0.4	0.9	25-60	0.04-0.08	3
H 高硬度材質 Hard Material	35-100	0.2-0.5	0.9	35-100	0.2-0.4	0.9	35-100	0.04-0.08	3

SD.0904

被加工材質 Machining Materials	面銑 Facing			開槽 Slotting			插銑 Plunging		
	切削速度 Speed	每刃進給 Feed	切深 D.O.C.	切削速度 Speed	每刃進給 Feed	切深 D.O.C.	切削速度 Speed	每刃進給 Feed	切寬 W.O.C.
	V _c (m/min)	h _m (mm)	a _p max (mm)	V _c (m/min)	h _m (mm)	a _p max (mm)	V _c (m/min)	f max (mm)	a _e max (mm)
P 低合金鋼 Low-Alloy Steels	120-235	0.3-2.0	1.5	120-235	0.3-1.5	1.5	120-235	0.1-0.2	6.0
	合金鋼 Alloyed Steels	70-160	0.3-2.0	1.5	70-160	0.3-1.5	1.5	0.1-0.16	6.0
M 不鏽鋼 Stainless Steels	115-265	0.2-1.0	1.5	115-265	0.2-0.8	1.5	115-265	0.12-0.16	6.0
	析出硬化系 Precipitation-Hardening	50-100	0.02-0.6	1.5	50-100	0.1-0.4	1.5	0.05-0.08	6.0
K 鑄鐵 Cast Iron	150-395	0.3-2.0	1.5	150-395	0.3-1.5	1.5	150-395	0.1-0.2	6.0
N 鋁及鋁合金 Aluminum&Al	400-1000	0.3-1.5	1.5	400-1000	0.3-1.0	1.5	400-1000	0.1-0.3	6.0
S 高溫合金 Refractory Alloys	25-60	0.2-0.8	1.5	25-60	0.1-0.5	1.5	25-60	0.05-0.1	6.0
H 高硬度材質 Hard Material	35-100	0.3-1.0	1.5	35-100	0.3-0.8	1.5	35-100	0.08-0.12	6.0

SD.1205

被加工材質 Machining Materials	面銑 Facing			開槽 Slotting			插銑 Plunging		
	切削速度 Speed	每刃進給 Feed	切深 D.O.C.	切削速度 Speed	每刃進給 Feed	切深 D.O.C.	切削速度 Speed	每刃進給 Feed	切寬 W.O.C.
	V _c (m/min)	h _m (mm)	a _p max (mm)	V _c (m/min)	h _m (mm)	a _p max (mm)	V _c (m/min)	f max (mm)	a _e max (mm)
P 低合金鋼 Low-Alloy Steels	120-235	0.3-3.0	2.5	120-235	0.3-2.0	2.0	120-235	0.1-0.25	9.0
	合金鋼 Alloyed Steels	70-160	0.3-3.0	2.5	70-160	0.3-2.0	2.0	0.1-0.18	9.0
M 不鏽鋼 Stainless Steels	115-265	0.2-1.2	2.5	115-265	0.2-1.0	2.0	115-265	0.12-0.13	9.0
	析出硬化系 Precipitation-Hardening	50-100	0.02-0.7	2.5	50-100	0.1-0.6	2.0	0.05-0.1	9.0
K 鑄鐵 Cast Iron	150-395	0.3-3.0	2.5	150-395	0.3-2.0	2.0	150-395	0.1-0.25	9.0
N 鋁及鋁合金 Aluminum&Al	400-1000	0.3-1.5	2.5	400-1000	0.3-1.5	2.0	400-1000	0.1-0.4	9.0
S 高溫合金 Refractory Alloys	25-60	0.2-1.0	2.5	25-60	0.1-0.7	2.0	25-60	0.05-0.12	9.0
H 高硬度材質 Hard Material	35-100	0.3-1.5	2.5	35-100	0.3-1.0	2.0	35-100	0.08-0.15	9.0

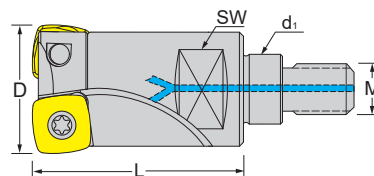
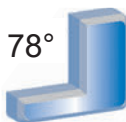
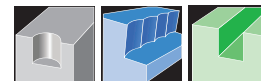
主軸轉速 = (1000 × 切削速度) ÷ (3.14 × 刀具外徑) Spindle Speed = (1000 × Cutting speed) ÷ (3.14 × Cutter outer diameter).

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.

大進給切削系列 HIGH FEED MILLING CUTTER SERIES



HAS 鎖牙式大進給切削刀具 HAS Screw-On High Speed Milling Cutter



特點 Feature

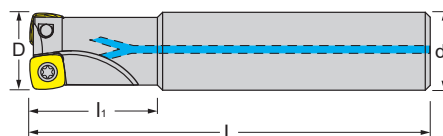
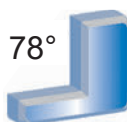
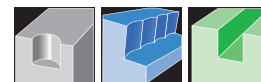
- 切削力以軸向為主，與圓形刀片刀具相比較，刀片及刀具的使用壽命較長
- 可大進給切削工件，減少加工時間
- 刀片可使用四個刃口，有效降低成本

- The cutting force is exerted in the axial direction. Compare with cutters using round inserts, cutters using square inserts are more durable.
- Available for high feeding cutting, and is able to shorten processing time.
- There are 4 edges usable on each insert, effective cost-saving.

規格 Spec.	L	D	d ₁	M	SW	鎖固力 (N.m)	刃數 Flutes	刀片 Insert	重量 (KGS) Weight
HAS-1616-M8-SP06-C	25	16	8.5	8	10	25	2	SP..0603	0.04
HAS-2020-M10-SP06-C	35	20	10.5	10	15	40	3	SP..0603	0.07
HAS-2525-M12-SP06-C	35	25	12.5	12	19	60	4	SP..0603	0.10
HAS-3232-M16-SP06-C	43	32	17	16	26	80	5	SP..0603	0.22
HAS-2525-M12-SD09-C	35	25	12.5	12	19	60	2	SD..0904	0.08
HAS-3232-M16-SD09-C	43	32	17	16	26	80	3	SD..0904	0.19
HAS-4040-M16-SD09-C	50	40	17	16	30	80	4	SD..0904	0.39



HAS 直柄式大進給切削刀具 HAS Straight Shank High Speed Milling Cutter



特點 Feature

- 切削力以軸向為主，與圓形刀片刀具相比較，刀片及刀具的使用壽命較長
- 可大進給切削工件，減少加工時間
- 刀片可使用四個刃口，有效降低成本

- The cutting force is exerted in the axial direction. Compare with cutters using round inserts, cutters using square inserts are more durable.
- Available for high feeding cutting, and is able to shorten processing time.
- There are 4 edges usable on each insert, effective cost-saving.

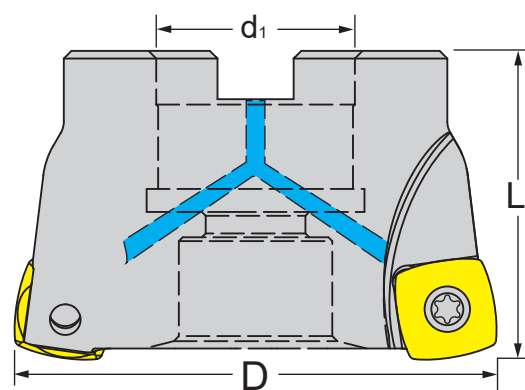
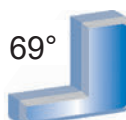
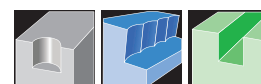
規格 Spec.	L	l ₁	D	d ₁	刃數 Flutes	刀片 Insert	重量 (KGS) Weight
HAS-1616-120L-C	120	25	16	16	2	SP..0603	0.15
HAS-2020-120L-C	120	32	20	20	3	SP..0603	0.24
HAS-2525-150L-C	150	40	25	25	4	SP..0603	0.49
HAS-3232-150L-C	150	40	32	32	5	SP..0603	0.83
HAS-2525-120L-C	120	35	25	25	2	SD..0904	0.42
HAS-2625-120L-C	120	35	26	25	2	SD..0904	0.44
HAS-3232-130L-C	130	40	32	32	3	SD..0904	0.74
HAS-3332-130L-C	130	40	33	32	3	SD..0904	0.76
HAS-4032-170L-C	170	50	40	32	4	SD..0904	1.10

配件表 Accessories

刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SP..0603	M2.5-6.3-3.7-43-T8-TIN	T8	1.2
SD..0904	M3.5-10-5.2-43-T15-TIN	T15	3.0



HGP 殼型式大進給切削刀具 HGP Shell High Speed Milling Cutter



特點 Feature

- 切削力以軸向為主，與圓形刀片刀具相比較，刀片及刀具的使用壽命較長
- 可大進給切削工件，減少加工時間
- 刀片可使用四個刃口，有效降低成本

- The cutting force is exerted in the axial direction. Compare with cutters using round inserts, cutters using square inserts are more durable.
- Available for high feeding cutting, and is able to shorten processing time.
- There are 4 edges usable on each insert, effective cost-saving.

規格 Spec.	L	D	d ₁	刃數 Flutes	刀片 Insert	重量 (KGS) Weight
HGP-500-FMB22-C	40	50	22	4	SD..1205	0.37
HGP-500-FMA25.4-C	40	50	25.4	4	SD..1205	0.38
HGP-630-FMB22-C	40	63	22	4	SD..1205	0.54
HGP-630-FMA25.4-C	40	63	25.4	4	SD..1205	0.66
HGP-800-FMB27-C	50	80	27	5	SD..1205	1.03
HGP-800-FMA31.75-C	50	80	31.75	5	SD..1205	1.04
HGP-1000-FMB32-C	50	100	32	6	SD..1205	1.54
HGP-1000-FMA31.75-C	50	100	31.75	6	SD..1205	1.54
HGP-1250-FMB40-C	63	125	40	8	SD..1205	3.38
HGP-1250-FMA38.1-C	63	125	38.1	8	SD..1205	3.37

配件表 Accessories

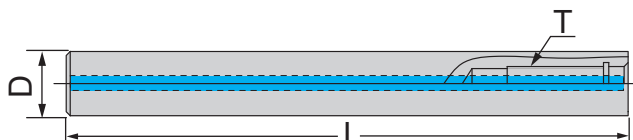
刀片 Insert	螺絲 Screw	扳手 Wrench	扭力值 (N.m) Torque
SD..1205	M4-13-5.2-43-T15-TIN	T15	3.0



大進給切削系列 HIGH FEED MILLING CUTTER SERIES



直柄 C/M 螺紋鎖固式鎢鋼延長桿 C/M STRAIGHT TUNGSTEN CARBIDE EXTENSION SHANK



特點 Feature

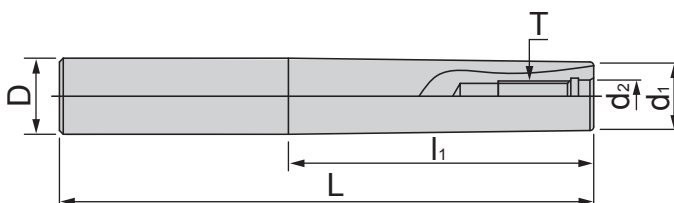
- 整支通孔，利於出水及抗震

- Through-hole design for better water coolant and anti-vibration.

規格 Spec.	L	D	T	重量 (KGS) Weight
C10-M5-150-C	150	10	M5-0.8P	0.16
C12-M6-100-C	100	12	M6-1.0P	0.16
C12-M6-150-C	150	12	M6-1.0P	0.24
C16-M8-100-C	100	16	M8-1.25P	0.26
C16-M8-150-C	150	16	M8-1.25P	0.57
C16-M8-200-C	200	16	M8-1.25P	0.54
C20-M10-150-C	150	20	M10-1.5P	0.60
C20-M10-200-C	200	20	M10-1.5P	0.85
C25-M12-200-C	200	25	M12-1.75P	1.30
C25-M12-250-C	250	25	M12-1.75P	1.60



直柄 C/SOM 螺紋鎖固式合金鋼延長桿 C/SOM STRAIGHT ALLOY STEEL SCREW-ON EXTENSION SHANK



特點 Feature

- 材質：SNCM-21

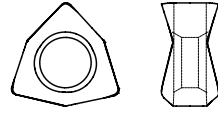
-Material : SNCM-21

規格 Spec.	L	l ₁	D	d ₁	d ₂	T	重量 (KGS) Weight
C12-SOM6-130	130	60	12	10	6.5	M6x1.0P	0.13
C16-SOM8-140	140	80	16	13	8.5	M8x1.25P	0.22
C16-SOM8-180	180	130	16	13	8.5	M8x1.25P	0.28
C20-SOM10-140	140	80	20	18	10.5	M10x1.5P	0.34
C20-SOM10-180	180	120	20	18	10.5	M10x1.5P	0.44
C25-SOM12-170	170	100	25	21	12.5	M12x1.75P	0.60
C25-SOM12-210	210	140	25	21	12.5	M12x1.75P	0.75

試刀案件一 Tool Trial Case 1

工件材質：不鏽鋼塑料模具鋼 SUS420J2 改良

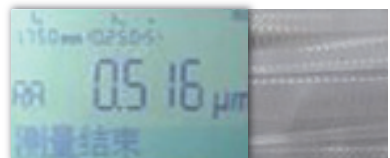
Workpiece Material: Modified SUS420J2 Stainless Steel for Plastic Mold Applications.

刀片 Insert	我司品牌： SDMT120508PDER-M04 RM4025 Our Brand： SDMT120508PDER-M04 RM4025 	他牌日系刀片： Wxxx Jxxx Other Brand (Japanese Brand) Insert： Wxxx Jxxx 
切削參數 Cutting Parameters	Vc=600 刀具直徑 Tool Diameter：63mm	Vc=500 刀具直徑 Tool Diameter：63mm
刀片壽命 Insert Life	3 個工件 3 Workpieces 	1 個工件 1 Workpieces
刀片切削角 Insert Cutting Angle	4	3x2=6
表面粗糙度 Surface Roughness	約 Ra:0.6um Approx. Ra 0.6 μm	粗糙 Relatively rough surface finish

壽命提升，有效減少停機時間，提高刀具利用率。

Extended tool life, effectively reducing downtime and increasing tool utilization.

試刀案件二 Tool Trial Case 2

刀桿 Tool Holder： SBT40-MLK32-105	刀具 Cutting Tool： HAS-3232-130L-C	刀片 Insert： SDMT090408EDER
切削數據 Cutting Parameters	RM4025	進口他牌 Imported Other Brand
間銑 - 材質 Slot Milling – Material： SUS304 S=1400 Vc=140 F=3360 f=0.80 Ap=1mm Ae=21mm 總切深 Total Depth of Cut：5mm 水冷 Water Cooling		
間銑 - 材質 Slot Milling – Material： SKD61 S=1800 Vc=180 F=4860 f=0.90 Ap=1mm Ae=21mm 總切深 Total Depth of Cut：35mm 風冷 Air Cooling		

表現與歐美品牌相當，性價比高。

Performance comparable to European and American brands, offering high cost-effectiveness.



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🌐 網址 Website /
www.chain-headway.com



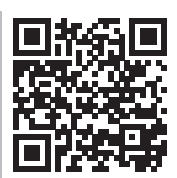
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Website(EN)



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