



北平精密-銑刀研磨機

PEIPING-End Mill Grinder

專利號碼 Patent No:270874 / 209656 / 323366

PP-32D



■直插式研磨
不耐用

Insert grinding-short life



■搖擺式研磨
耐用

Wag grinding-long life

銑刀長度設定座
Setting of End Mill length



第二間隙角研磨處(逃隙角)
Grinding of second clearance angle

逃隙角調整器
Clearance angle adjuster

研磨把手
Grinding handle

齒面槽研磨處(插溝)
Grinding of slots

第一間隙角
研磨處(刀口)
Grinding of first
clearance angle

規格表 SPECIFICATIONS

項目 Model	PP-32D
研磨能力 Mill size	Ø12mm~Ø32mm
電源 Power	110V / 220V 50Hz / 60Hz
馬達轉速 R.P.M.OF moter	5300 R.P.M
標準配件 Standard Equipments	CBN砂輪(2只)CBN wheel: 2 pcs ER 筒夾(5只)Collect,12,16,20,25,32mm: 5 pcs 夾頭座(2組)Collect holder: 2 sets (2,4 刃flutes & 3,6 刃flutes) 六角扳手(1支)Hexagon wrench :1pc
重量 Weight	24 kgs
包裝尺寸 Packing size	33x25x22cm

* 型錄之規格如有變更，恕不另行通知。Specifications subject to change without notice.

操作方法 OPERATION:



①銑刀夾具組之定位:

將擋塊(NO.A)橫向移動至可將銑刀刀刃平行後取出，確認銑刀是否與夾具組平行(如圖)，平行後鎖緊，若沒有平行，則需再重新定位。

Set the mill cutter and collect holder

- Insert the mill cutter collect holder in the hole as picture.
- Move the damper (NO.A) and let the mill cutter is parallel to the collet holder (as drawing) then turn tight. If not parallel, please re-set.

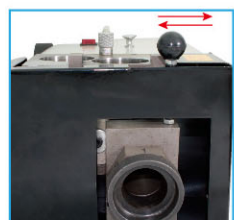


③中心靜點之離隙角研磨(開溝槽):

啟動馬達後，將夾具組放入圖示之研磨孔內，輕推至與砂輪接觸後，調整中心靜點旋鈕，可做2,3,4,6刃之過中心研磨。

Grinding point center angle(slot)

- Insert the mill cutter collect holder in the hole (as picture) and touch the wheel slowly.
- Adjust the point center angle adjustment to sharpen the point center angle.(can across grinding the center of 2,3,4,6 flutes).



②銑刀端面刀刃之研磨:

啟動馬達後，將夾具組放入圖示之研磨座，並輕推至與砂輪接觸後，將把手左右移動至無聲，再將夾具組取出轉180°或後90°，再依上述之步驟重覆研磨，即可完成端面刀刃之研磨。

Grinding point angle

- Turn on the power.
- Insert the mill cutter collect holder in the hole (as picture) to touch the wheel slowly.
- Move the grinding handle right-left to sharpen the mill cutter until the grinding voice disappear.
- Take out the mill cutter collect holder and turn 180° or 90°. And insert it in the hole to sharpen the other side with the same ways as above.



④銑刀端面之第二逃隙角之研磨:

啟動馬達後，將夾具組放入研磨孔內，輕推至與砂輪接觸後，並調整中心靜點旋鈕，可控制刀刃寬度。

Grinding second clearance angle

- Insert the mill cutter collect holder in the hole (as picture) and touch the wheel slowly.
- Adjust the point center angle adjustment to sharpen the second clearance angle.(it can control the width).