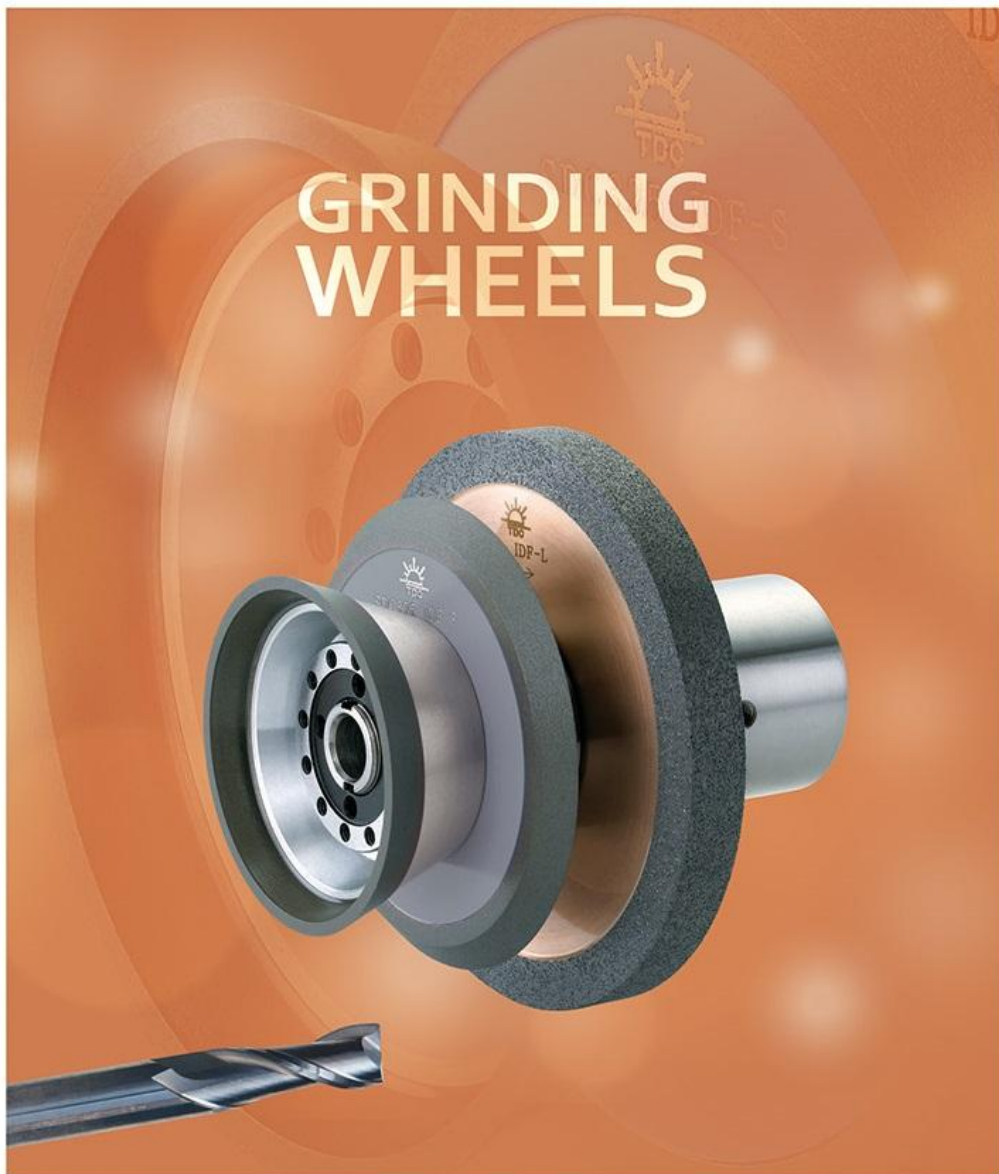


TDC

TAIWAN ASAHI DIAMOND

鎢鋼端銑刀研磨砂輪

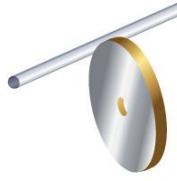
Grinding Wheels for Tungsten Carbide End Mills



台灣鑽石工業股份有限公司
Taiwan Asahi Diamond Industrial Co., Ltd.

加工流程 Processing Flow

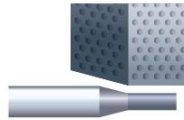
切斷 Cutter



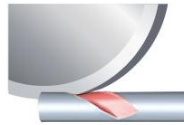
外周 Centerless



段差 Cylindrical



開溝 Flute



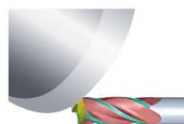
外周刃 Clearance



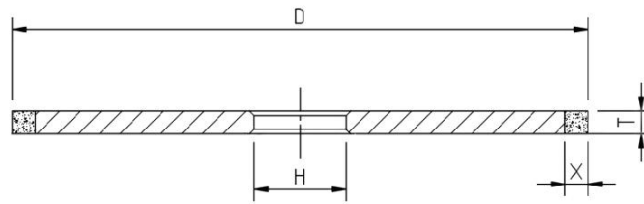
底槽 Gash



底刃 Face



切斷 CUTTER



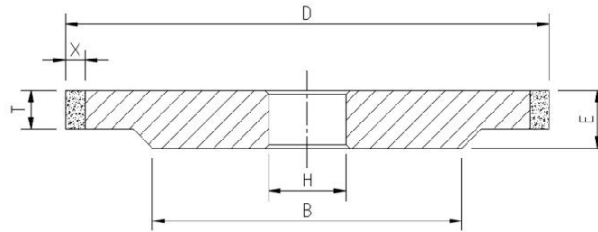
AD-2A (1A1R)

(unit : mm)

D	T	X	H
125	0.5	3	22
125	0.5	3	19.05
125	1	5	19.05
125	1.5	5	19.05
125	2	5	19.05
128	0.5	2	40
150	0.6	6	19.05
150	1	7	19.05
150	1.2	7	19.05
150	1.5	7	19.05
150	2	7	19.05
200	1	7	19.05
200	1.2	7	22
200	1.2	7	19.05
200	1.5	7	19.05
200	2	7	19.05

可依據需求製作各種訂製規格
Customised grinding tools can be manufactured on request.

切斷 CUTTER



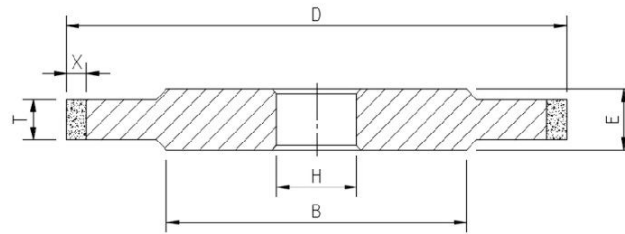
AD-3B (3A1)

(unit : mm)

D	T	X	E	B	H
125	0.6	5	6	100	40
125	1	5	6	100	40
125	1.5	5	6	100	40
125	2	5	6	100	40
200	0.6	6	6	140	60
200	1	6	6	140	60
200	1.5	6	6	140	60
200	2	6	6	140	60

可依據需求製作各種訂製規格
Customised grinding tools can be manufactured on request.

切斷 CUTTER



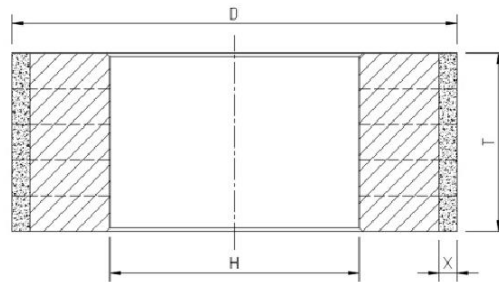
AD-3C (14A1)

(unit : mm)

D	T	X	E	B	H
150	0.5	3	7	80	31.75
150	1	5	7	80	31.75
150	1.5	5	7	80	31.75
150	2	5	7	80	31.75
175	0.5	3	8	110	31.75
175	0.7	5	8	110	31.75
175	1.5	5	8	110	31.75
175	2	5	8	110	31.75

可依據需求製作各種訂製規格
Customised grinding tools can be manufactured on request.

外周 CENTERLESS



AD-3S (1A1)

(unit : mm)

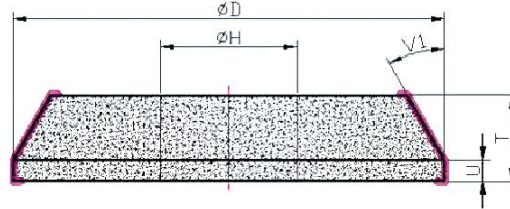
D	T	X	H
300	100	5	120
300	150	5	120
350	100	5	127
350	150	5	127
400	150	5	203.2
400	200	5	203.2
450	205	5	250

可依據需求製作各種訂製規格
Customised grinding tools can be manufactured on request.

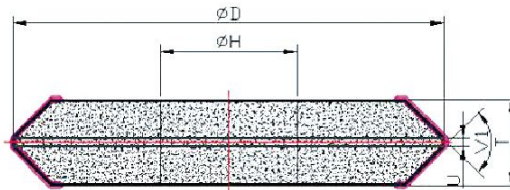
段差 CYLINDRICAL

砂輪形狀 Shape

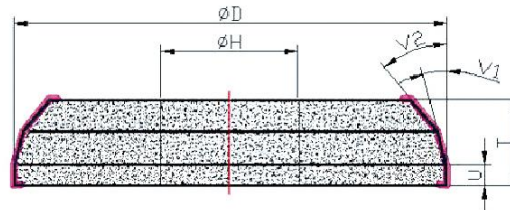
AD-11C (1V1)
V-型砂輪 (外周斜角)
V-Type (OD Beveling)



AD-11D (1EE1)
V-型砂輪 (雙面斜角)
V-Type (OD beveling-Both Side)



AD-3E (14J1)
成型砂輪
Forming Wheel



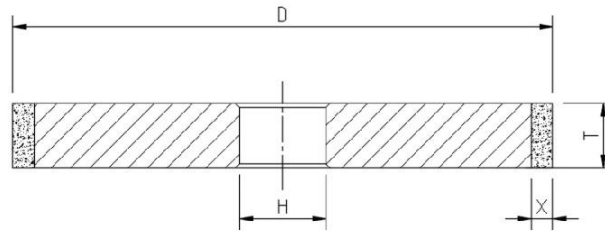
工具製程能力 Ability

(unit : μm)

鑽石粒度 Mesh Size #80~#270								
鑽石粒度 Mesh Size	#80	#100	#120	#140	#170	#200	#230	#270
尖端R最小尺寸 Radius Value (Min)	500	400	360	300	250	200	180	160
輪廓度最小公差 Profile Tolerance (Min)	± 50	± 40	± 35	± 30	± 25	± 25	± 25	± 20

台金偏擺精度 Run Out		
產品類型 Type	外徑 OD	側面 Side
砂輪 (現況) Currently	20	10

開溝 FLUTE



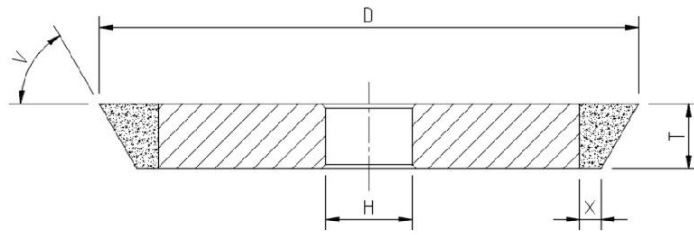
AD-3A (1A1)

(unit : mm)

D	T	X	X
100	4	10	20
100	6	10	20
100	8	10	20
100	10	10	20
100	12	10	20
100	14	10	20
100	16	10	20
125	4	10	20
125	6	10	20
125	8	10	20
125	10	10	20
125	12	10	20
125	14	10	20
125	16	10	20
150	4	10	20
150	6	10	20
150	8	10	20
150	10	10	20
150	12	10	20
150	14	10	20
150	16	10	20

可依據需求製作各種訂製規格
Customised grinding tools can be manufactured on request.

開溝 FLUTE



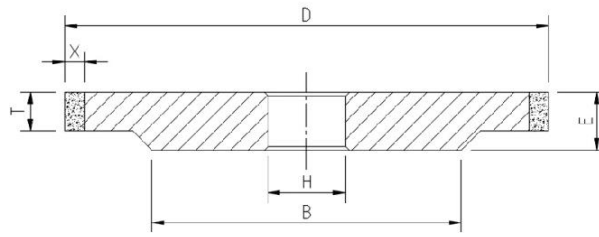
AD-11C (1B1)

(unit : mm)

D	T	V	X	H
100	4	75	10	20
100	6	75	10	20
100	8	75	10	20
100	10	75	10	20
100	12	75	10	20
100	14	75	10	20
100	16	75	10	20
125	4	75	10	20
125	6	75	10	20
125	8	75	10	20
125	10	75	10	20
125	12	75	10	20
125	14	75	10	20
125	16	75	10	20
150	4	75	10	20
150	6	75	10	20
150	8	75	10	20
150	10	75	10	20
150	12	75	10	20
150	14	75	10	20
150	16	75	10	20

可依據需求製作各種訂製規格
Customised grinding tools can be manufactured on request.

開溝 FLUTE



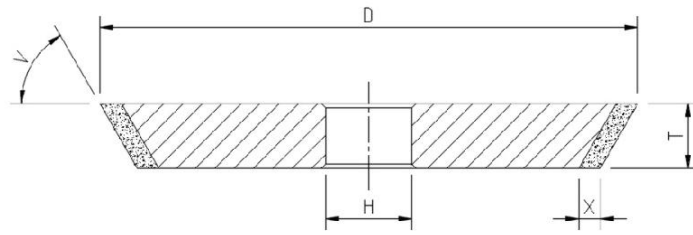
AD-3B (3A1)

(unit : mm)

D	T	X	E	B	H
100	0.6	3	10	80	20
125	0.6	3	10	100	20
150	0.6	3	10	120	20
100	0.8	5	10	80	20
125	0.8	5	10	100	20
150	0.8	5	10	120	20
100	1	5	10	80	20
125	1	5	10	100	20
150	1	5	10	120	20
100	1.5	8	10	80	20
125	1.5	8	10	100	20
150	1.5	8	10	120	20
100	2	8	10	80	20
125	2	8	10	100	20
150	2	8	10	120	20
100	2.5	10	10	80	20
125	2.5	10	10	100	20
150	2.5	10	10	120	20
100	3	10	10	80	20
125	3	10	10	100	20
150	3	10	10	120	20

可依據需求製作各種訂製規格
Customised grinding tools can be manufactured on request.

底槽 GASH



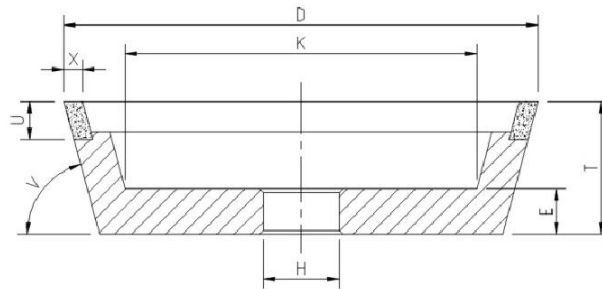
AD-11C (1V1)

(unit : mm)

D	T	V	X	H
100	4	75	10	20
100	6	75	10	20
100	8	75	10	20
100	10	75	10	20
100	12	75	10	20
100	14	75	10	20
100	16	75	10	20
125	4	75	10	20
125	6	75	10	20
125	8	75	10	20
125	10	75	10	20
125	12	75	10	20
125	14	75	10	20
125	16	75	10	20
150	4	75	10	20
150	6	75	10	20
150	8	75	10	20
150	10	75	10	20
150	12	75	10	20
150	14	75	10	20
150	16	75	10	20

可依據需求製作各種訂製規格
Customised grinding tools can be manufactured on request.

底刃 FACE



AD-6A (11V9 / 12V9)

(unit : mm)

D	X	U	V	T	K	E	H
75	3	6	70	30	50	10	20
90	3	6	70	30	50	10	20
100	3	6	70	30	50	10	20
100	3	10	45	25	55	10	20
125	3	10	45	25	75	10	20

可依據需求製作各種訂製規格
Customised grinding tools can be manufactured on request.

【鑽石砂輪周速度推薦】

Suggestion of Peripheral Speed for Diamond Wheel

對鑽石砂輪而言，由於磨料性質上的關係，如果將鑽石砂輪周速度一味地提高，未必效率會更好。鑽石砂輪的周速度是依其作業條件而異，對研磨效率有很大的影響。

Due to the abrasive, the efficiency of diamond wheel won't be better if peripheral speed is increased only. Peripheral speed of diamond wheel will be different according to its processing condition, and greatly influence the grinding efficiency.

開溝 Flute	外周刃 Clearance	底槽 Gash	底刃 Face
13-18 m/s	20-24 m/s	22-26 m/s	20-24 m/s

【鑽石砂輪修整條件推薦】

Suggestion of Dressing Condition for Diamond wheel

使用正確的修整條件，使得鑽石浮露性良好，可以讓砂輪性能發揮最大的使用效益。

The exposure of diamond could be good when it is under correct dressing condition, and it also could maximize the function of diamond wheel.

1. 砂輪粒度的選用與進刀量的設定：

Setting for mesh size and depth of cut :

鑽石砂輪粒度 (#) Mesh size	白色氧化鋁砂輪粒度 (#) White Aluminium	修整時的進刀量 (mm/pass) Depth of Cut
200	200	0.025
230	200	0.022
270	325	0.020
325	325	0.015
400	600	0.013
600	600	0.008
1000	1000	0.005
1500	1500	0.003
2000	2000	0.002

2. 白色氧化鋁 (WA) 砂輪和鑽石 (Dia) 砂輪的旋轉方向相同，轉速比約8 (WA) : 1 (Dia)。

The direction of rotation of white aluminium (WA) wheel and diamond (Dia) wheel is the same, the speed ratio is approximately 8 (WA) : 1 (Dia)

3. 左右通過修整方式。

Dressing through left and right side.

4. 濕式。

Wet grinding.