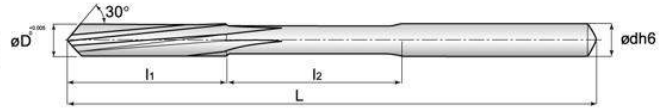




全鎢鋼絞刀 Solid Carbide Reamers (Straight Shank)



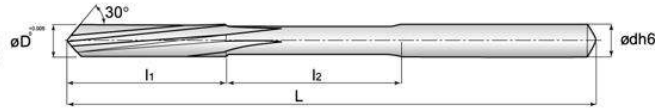
High Speed Cutting
& High Hard Cutting



Micro Diameter

| Type No. 型號 | Shank Dia 柄徑 | Flute Length 刃長 l ₁ | O. A. L. 全長 L | Effective Length 有效長 l ₂ | Flute No. 刃數 |
|----------------|-----------------|-----------------------------------|------------------|--|-----------------|
| SCR020 | 2.0 | 11 | 49 | 24 | 4 |
| SCR021 | 2.1 | 11 | 49 | 24 | 4 |
| SCR022 | 2.2 | 12 | 53 | 26 | 4 |
| SCR023 | 2.3 | 12 | 53 | 26 | 4 |
| SCR024 | 2.4 | 14 | 57 | 28 | 4 |
| SCR025 | 2.5 | 14 | 57 | 28 | 4 |
| SCR026 | 2.6 | 14 | 57 | 28 | 4 |
| SCR027 | 2.7 | 15 | 61 | 32 | 4 |
| SCR028 | 2.8 | 15 | 61 | 32 | 4 |
| SCR029 | 2.9 | 15 | 61 | 32 | 4 |
| SCR030 | 3.0 | 15 | 61 | 32 | 4 |
| SCR031 | 3.1 | 16 | 65 | 35 | 4 |
| SCR032 | 3.2 | 16 | 65 | 35 | 4 |
| SCR033 | 3.3 | 16 | 65 | 35 | 4 |
| SCR034 | 3.4 | 18 | 70 | 40 | 4 |
| SCR035 | 3.5 | 18 | 70 | 40 | 4 |
| SCR036 | 3.6 | 18 | 70 | 40 | 4 |
| SCR037 | 3.7 | 18 | 70 | 40 | 4 |
| SCR038 | 3.8 | 19 | 75 | 43 | 4 |
| SCR039 | 3.9 | 19 | 75 | 43 | 4 |
| SCR040 | 4.0 | 19 | 75 | 43 | 4 |
| SCR041 | 4.1 | 19 | 75 | 43 | 4 |
| SCR042 | 4.2 | 19 | 75 | 43 | 4 |
| SCR043 | 4.3 | 21 | 80 | 47 | 4 |
| SCR044 | 4.4 | 21 | 80 | 47 | 4 |
| SCR045 | 4.5 | 21 | 80 | 47 | 4 |
| SCR046 | 4.6 | 21 | 80 | 47 | 4 |
| SCR047 | 4.7 | 21 | 80 | 47 | 4 |
| SCR048 | 4.8 | 23 | 86 | 52 | 4 |
| SCR049 | 4.9 | 23 | 86 | 52 | 4 |
| SCR050 | 5.0 | 23 | 86 | 52 | 4 |
| SCR051 | 5.1 | 23 | 86 | 52 | 4 |
| SCR052 | 5.2 | 23 | 86 | 52 | 4 |
| SCR053 | 5.3 | 23 | 86 | 52 | 4 |

| 被削材 | | 炭素鋼・高硬度合金鋼 (SKD, SUS) | | 鋁合金 | |
|-----|-----------|-----------------------|-------------|--------------------|-------------|
| | | 切削速度: 5 - 9 m/min | | 切削速度: 10 - 20m/min | |
| 刃徑 | 預留削除量 | 回轉數 (rpm) | 進給 (mm/min) | 回轉數 (rpm) | 進給 (mm/min) |
| | | 2 | 0.1 - 0.2 | 1000 | 0.1 - 0.2 |
| 4 | 0.1 - 0.2 | 500 | 0.1 - 0.2 | 1400 | 0.2 - 0.3 |
| 6 | 0.2 - 0.3 | 340 | 0.2 - 0.3 | 950 | 0.2 - 0.3 |
| 8 | 0.2 - 0.3 | 250 | 0.2 - 0.3 | 720 | 0.3 - 0.4 |
| 10 | 0.2 - 0.3 | 190 | 0.2 - 0.3 | 570 | 0.3 - 0.4 |
| 12 | 0.2 - 0.3 | 160 | 0.2 - 0.3 | 480 | 0.4 - 0.5 |



Micro Diameter

| Type No. 型號 | Shank Dia 柄徑 | Flute Length 刃長 l ₁ | O. A. L. 全長 L | Effective Length 有效長 l ₂ | Flute No. 刃數 |
|----------------|-----------------|-----------------------------------|------------------|--|-----------------|
| SCR054 | 5.4 | 26 | 93 | 57 | 4 |
| SCR055 | 5.5 | 26 | 93 | 57 | 4 |
| SCR056 | 5.6 | 26 | 93 | 57 | 4 |
| SCR057 | 5.7 | 26 | 93 | 57 | 4 |
| SCR058 | 5.8 | 26 | 93 | 57 | 4 |
| SCR059 | 5.9 | 26 | 93 | 57 | 4 |
| SCR060 | 6.0 | 26 | 93 | 57 | 6 |
| SCR061 | 6.1 | 28 | 101 | 63 | 6 |
| SCR062 | 6.2 | 28 | 101 | 63 | 6 |
| SCR063 | 6.3 | 28 | 101 | 63 | 6 |
| SCR064 | 6.4 | 28 | 101 | 63 | 6 |
| SCR065 | 6.5 | 28 | 101 | 63 | 6 |
| SCR066 | 6.6 | 31 | 110 | 69 | 6 |
| SCR067 | 6.7 | 31 | 110 | 69 | 6 |
| SCR068 | 6.8 | 31 | 110 | 69 | 6 |
| SCR069 | 6.9 | 31 | 110 | 69 | 6 |
| SCR070 | 7.0 | 31 | 110 | 69 | 6 |
| SCR071 | 7.1 | 31 | 110 | 69 | 6 |
| SCR072 | 7.2 | 31 | 110 | 69 | 6 |
| SCR073 | 7.3 | 31 | 110 | 69 | 6 |
| SCR074 | 7.4 | 31 | 110 | 69 | 6 |
| SCR075 | 7.5 | 31 | 110 | 69 | 6 |
| SCR076 | 7.6 | 31 | 110 | 69 | 6 |
| SCR078 | 7.8 | 31 | 110 | 69 | 6 |
| SCR079 | 7.9 | 31 | 110 | 69 | 6 |
| SCR080 | 8.0 | 31 | 110 | 69 | 6 |
| SCR085 | 8.5 | 31 | 110 | 69 | 6 |
| SCR090 | 9.0 | 33 | 110 | 69 | 6 |
| SCR095 | 9.5 | 33 | 110 | 69 | 6 |
| SCR100 | 10.0 | 36 | 110 | 69 | 6 |
| SCR110 | 11.0 | 41 | 142 | 95 | 6 |
| SCR120 | 12.0 | 44 | 151 | 105 | 6 |
| SCR130 | 13.0 | 44 | 151 | 105 | 6 |



High Speed Cutting
& High Hard Cutting

| 鑄鐵 (FC, FCD) | |
|-------------------|----------------|
| 切削速度: 9 - 12m/nin | |
| 回轉數 (rpm) | 進給 (mm/min) |
| 1800 | 0.2 - 0.3 |
| 940 | 0.2 - 0.3 |
| 630 | 0.2 - 0.3 |
| 470 | 0.3 - 0.4 |
| 380 | 0.3 - 0.4 |
| 300 | 0.3 - 0.5 |

● 螺旋刃 使用超微粒超硬合金 最適於高精度、高效率化

注1: 絞孔加工依使用機械及作業條件而其最佳切削條件亦隨之變動, 因此應適宜調整為要。

注2: 切削油請充分使用具有潤滑性之不水溶性切削油。