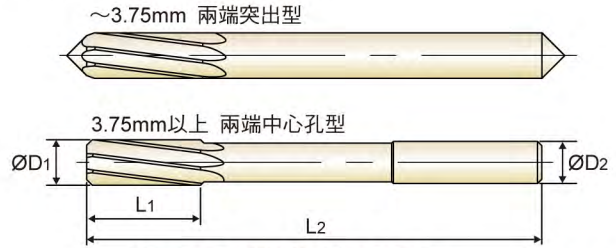




SPCR 直柄螺旋刃機械絞刀

Short Length · Spiral Flute Chucking Reamers



HSS-E即為HSSCo

單位：mm

| 刃徑 (D) | 刃長 (L ₁) | 柄徑 (D ₂) | 全長 (L ₂) | 刃數 (N) | 價(支)格 |
|-----------|-------------------------|-------------------------|-------------------------|-----------|--------|
| 2 | 11 | 2 | 49 | 4 | 290.00 |
| 2.2 | 11 | 2 | 49 | 4 | 310.00 |
| 2.5 | 14 | 2.5 | 57 | 4 | 290.00 |
| 2.6 | 14 | 2.5 | 57 | 4 | 310.00 |
| 2.8 | 14 | 2.5 | 57 | 4 | 325.00 |
| 3 | 15 | 3 | 61 | 4 | 310.00 |
| 3.1 | 15 | 3 | 61 | 4 | 325.00 |
| 3.2 | 15 | 3 | 61 | 4 | 325.00 |
| 3.5 | 15 | 3.5 | 61 | 4 | 325.00 |
| 3.6 | 15 | 3.5 | 61 | 6 | 325.00 |
| 3.7 | 15 | 3.5 | 61 | 6 | 325.00 |
| 4 | 19 | 4 | 75 | 6 | 485.00 |
| 4.3 | 19 | 4 | 75 | 6 | 505.00 |
| 4.5 | 21 | 4 | 80 | 6 | 565.00 |
| 4.6 | 21 | 4 | 80 | 6 | 530.00 |
| 5 | 23 | 5 | 86 | 6 | 540.00 |
| 5.5 | 26 | 5 | 93 | 6 | 580.00 |
| 5.6 | 26 | 5 | 93 | 6 | 525.00 |
| 6 | 26 | 6 | 93 | 6 | 560.00 |

| 刃徑 (D) | 刃長 (L ₁) | 柄徑 (D ₂) | 全長 (L ₂) | 刃數 (N) | 價(支)格 |
|-----------|-------------------------|-------------------------|-------------------------|-----------|----------|
| 6.5 | 26 | 6 | 93 | 6 | 580.00 |
| 7 | 31 | 6 | 109 | 6 | 640.00 |
| 7.2 | 31 | 6 | 109 | 6 | 625.00 |
| 8 | 33 | 8 | 117 | 6 | 670.00 |
| 8.5 | 33 | 8 | 117 | 6 | 730.00 |
| 9 | 36 | 8 | 125 | 6 | 765.00 |
| 9.5 | 36 | 8 | 125 | 6 | 905.00 |
| 10 | 38 | 10 | 133 | 6 | 920.00 |
| 10.5 | 38 | 10 | 133 | 6 | 900.00 |
| 11 | 41 | 10 | 142 | 6 | 1,105.00 |
| 12 | 44 | 10 | 151 | 6 | 1,180.00 |
| 13 | 44 | 10 | 151 | 6 | 1,235.00 |
| 14 | 47 | 12 | 160 | 8 | 1,260.00 |
| 15 | 50 | 12 | 162 | 8 | 1,350.00 |
| 16 | 55 | 12 | 170 | 8 | 1,460.00 |
| 17 | 54 | 12 | 175 | 8 | 1,615.00 |
| 18 | 56 | 12 | 182 | 8 | 1,680.00 |
| 19 | 58 | 16 | 189 | 8 | 1,820.00 |
| 20 | 60 | 16 | 195 | 8 | 1,900.00 |

SPCR · TCR · SPTCR 切削條件參考表

Recommended Cutting Condition

| 被削材 | 切削速度 | 進刀速度(mm/rev.) | | | |
|-------------------------------------|-------|---------------|-----------|-----------|-----------|
| | | 刃徑 | | | |
| | m/min | 2~4 | 5~8 | 9~12 | 13~20 |
| 鋼料 < 500 N/mm ² | 12~16 | 0.05~0.15 | 0.1 ~0.2 | 0.15~0.25 | 0.2 ~0.3 |
| 鋼料 500~700 N/mm ² | 10~12 | 0.05~0.15 | 0.1 ~0.2 | 0.15~0.25 | 0.2 ~0.3 |
| 鋼料 700~800 N/mm ² | 6~ 8 | 0.05~0.1 | 0.08~0.16 | 0.1 ~0.2 | 0.15~0.25 |
| 合金鋼 · 炭素鋼鑄件 < 500 N/mm ² | 6~10 | 0.05~0.1 | 0.08~0.16 | 0.1 ~0.2 | 0.15~0.25 |
| 合金鋼 · 炭素鋼鑄件 > 500 N/mm ² | 4~ 6 | 0.05~0.1 | 0.08~0.16 | 0.1 ~0.2 | 0.15~0.25 |
| 合金鋼 · 炭素鋼鍛件 | 4~ 6 | 0.03~0.08 | 0.06~0.1 | 0.08~0.15 | 0.1 ~0.2 |
| 鑄鐵 < 200HB | 12~14 | 0.05~0.15 | 0.01~0.2 | 0.15~0.25 | 0.2 ~0.3 |
| 鑄鐵 > 200HB | 10~12 | 0.05~0.1 | 0.08~0.16 | 0.1 ~0.2 | 0.15~0.25 |
| 鋁 · 鋁合金 | 16~20 | 0.1 ~0.2 | 0.15~0.25 | 0.2 ~0.3 | 0.25~0.4 |
| 鎂 · 鎂合金 | 10~16 | 0.1 ~0.2 | 0.15~0.25 | 0.2 ~0.3 | 0.25~0.4 |
| 銅 · 黃銅 | 16~18 | 0.1 ~0.2 | 0.15~0.25 | 0.2 ~0.3 | 0.25~0.4 |
| 不銹鋼 | 4~ 6 | 0.03~0.08 | 0.06~0.1 | 0.08~0.15 | 0.1 ~0.2 |
| 塑膠 | 8~12 | 0.1 ~0.2 | 0.2 ~0.3 | 0.3 ~0.4 | 0.4 ~0.5 |

絞刀刀具

REAMERS