

牙刀片材料牌號

THREADING CARBIDE GRADES

EC400: AN ADVANCED PVD TiAlN COATED GRADE OVER A TOUGH WEAR-RESISTANT SUBMICRON SUBSTRATE FOR GENERAL PURPOSE MACHINING OF STEEL, STAINLESS STEEL, SUPER ALLOYS.

此材質在細顆粒，較韌，耐磨的硬質合金材料上，進行先進的PVD塗層，用於對鋼，不銹鋼和超級合金的一般加工。

EC300: SPECIAL MULTILAYER PVD COATING WITH A TOUGH. VERY FINE GRAIN SUBSTRATE. FOR MACHINING MOST STEEL, STAINLESS STEELS, CAST IRON. NON-FERROUS MATERIALS AND SUPER ALLOYS.

在超細顆粒，較韌的硬質合金上進行特殊的多層PVD塗層，可加工大部分鋼，不銹鋼，鑄鐵，非金屬材料和超級合金。

EC200: PVD TiAlN COATED OVER TOUGH SUBMICRON GRADE FOR MACHINING STEELS. HARDENED STEEL (HRC30 UP TO HRC56) AND HARDENED CAST IRON (HRC50-55)

在細顆粒，較韌的硬質合金上進行 PVD TiAlN塗層，適於加工鋼，硬化鋼 (HRC30-50) 和硬化鑄鐵(HRC50-55)

EC100: UNCOATED GRADE. FOR MACHINING CAST IRON, NON-FERROUS MATERIALS ALUMINUM AND SUPER ALLOYS

非塗層材質，適於加工鑄鐵，非金屬，鋁合金和超級金屬。

GRDAE 材質		P				M				K			N			S				H					
		P10	P20	P30	P40	M10	M20	M30	M40	K10	K20	K30	K40	N10	N20	N30	N40	S10	S20	S30	S40	H10	H20	H30	H40
COATED 塗層	EC400																								
	EC300																								
	EC200																								
UNCOATED 非塗層	EC100																								

根據螺旋角的墊片選擇

HELIX ANGLE ANVILS SELECTION

L	HOLDER TYPE 刀體類型	THREAD HELIX ANGLE / 螺旋角							
		4.5	3.5	2.5	1.5	0.5	0	-0.5	-1.5
16	ER/IL	ES16+4.5	ES16+3.5	ES16+2.5	ES16+1.5	ES16+0.5	ES16-0	ES16-0.5	ES16-1.5
	IR/EL	IS16+4.5	IS16+3.5	IS16+2.5	IS16+1.5	IS16+0.5	IS16-0	IS16-0.5	IS16-1.5
22	ER/IL	ES22+4.5	ES22+3.5	ES22+2.5	ES22+1.5	ES22+0.5	ES22-0	ES22-0.5	ES22-1.5
	IR/EL	IS22+4.5	IS22+3.5	IS22+2.5	IS22+1.5	IS22+0.5	IS22-0	IS22-0.5	IS22-1.5
27	ER/IL	ES27+4.5	ES27+3.5	ES27+2.5	ES27+1.5	ES27+0.5	ES27-0	ES27-0.5	ES27-1.5
	IR/EL	IS27+4.5	IS27+3.5	IS27+2.5	IS27+1.5	IS27+0.5	IS27-0	IS27-0.5	IS27-1.5

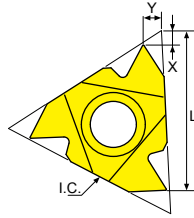
切削參數 MACHINE CONDITIONS

GRDAE 材質		P				M				K				N				S				H			
		P10	P20	P30	P40	M10	M20	M30	M40	K10	K20	K30	K40	N10	N20	N30	N40	S10	S20	S30	S40	H10	H20	H30	H40
COATED 塗層	EC400																								
	EC300																								
	EC200																								
UNCOATED 非塗層	EC100																								

ISO	MATERIAL 材料	HARDNESS 硬度 HB	COATED 塗層				UNCOATED 非塗層
			EC400	EC300	EC200	EC100	
			CUTTING SPEED M/Min 線速度				
P	NON -ALLOY STEEL FREE CUTTING STEEL 低碳鋼，易切鋼	130	120-200	110-180			
	LOW CARBON ALLOY STEEL 低碳合金鋼	200	110-180	100-170			
	HIGH CARBON ALLOY STEEL 高碳合金鋼	240	100-170	90160	100-150		
	TOOL STEEL CAST STEEL 工具鋼，鑄鋼	270	70120	60-110	60-100		
	HEATTREATEDSTEEL 熱處理鋼	400	50-90	50-90	50-90		
M	300 STAINLESS STEEL不銹鋼：(303, 304, 316)	200	70-140	70-130			
	400 STAINLESS STEEL不銹鋼：(420, 440)	240	80-120	80-130			
	17-4 PH, 15-5PH, 18-8 MO PH	400	50-110	50-100			
K	300 STAINLESS STEEL不銹鋼：(303, 304, 316)	200	70-140	70-130		80-120	
	400 STAINLESS STEEL不銹鋼：(420, 440)	240	80-120	80-130		90-130	
	17-4 PH, 15-5PH, 18-8 MO PH	400	50-110	50-100		80-130	
N	WROUGHT ALUMINUM (2024,6061,7075..) 鋁	80	100-400	70-130		100-300	
	CAST ALUMINUM 鑄鋁	90	150-400	80-130		100-250	
	COPPER ALLOYS: BRASS,BRONZE,COPPER SILICON 銅合金	100	80-180			60-150	
	NON METALIC：非金屬 Rubber, Polypropylene, Thermoplastics(PVC) FIBERGLASS), Polyamides			200-500	50-100		200-500
S	Pure 替他紐曼：99.0 Ti 純鈦			100-150	100-150		70-130
	ALPHA ALLOYS：Ti5AL 2.5Sn α 鈦合金			40-60	40-60		30-50
	BETA ALLOYS：Ti13V11Cr3Al α 鈦合金			30-50	30-50		25-40
	ALPHA-BETA ALLOYS：Ti6AL4V / α-β 鈦合金	350		30-50	30-50		25-40
	INCONEL，HASTELLOY，WASPALLOY， KOVAR 鎳基合金	300		20-40	20-40		20-30
	HIGH TEMPERATURE ALLOYS：IRON BASED：INCOLOY 高溫合金	270		30-60	20-35		20-40
H	HARDENED STEEL 超硬鋼	HRC56		30-50	25-45		
	HARD ENED CAST IRON 超硬鑄鐵	HRC50		25-35	25-40		

IR 刀片

IR INSERT



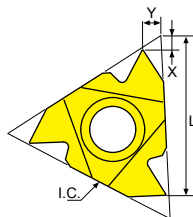
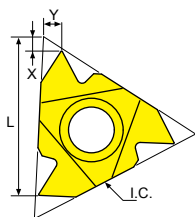
產品型號 Model No.	庫存 Stock	尺寸 Dimension (mm)			
	EC400	牙距 Pitch (mm)	X	Y	I.C.
06IR A60	●	0.5~1.5	0.5	0.6	4.00
06IR 0.5 ISO	●	0.5	0.8	0.4	4.00
06IR 0.75 ISO	●	0.75	0.7	0.4	4.00
06IR 1.00 ISO	●	1.0	0.7	0.5	4.00
06IR 1.25 ISO	●	1.25	0.7	0.6	4.00
08IR A60	●	0.5~1.5	0.5	0.6	5.00
08IR 0.5 ISO	●	0.5	0.8	0.4	5.00
08IR 0.75 ISO	●	0.75	0.7	0.4	5.00
08IR 1.00 ISO	●	1.0	0.7	0.5	5.00
08IR 1.25 ISO	●	1.25	0.7	0.6	5.00
08IR 1.75 ISO	●	1.75	0.7	0.7	5.00

◆ 另有其他規格，歡迎來電洽詢！

◆ We could provide inserts for other specifications, please contact us !

ER / IR 刀片

ER / IR INSERT



產品型號 Model No.	庫存 Stock	尺寸 Dimension (mm)			
	EC400	牙距 Pitch (mm)	X	Y	I.C.
11ER/IR A60	●	0.5~1.5	0.8	0.9	6.35
11ER/IR A55	●	0.5~1.5	0.8	0.9	6.35
11ER/IR 0.5 ISO	●	0.5	0.6	0.4	6.35
11ER/IR 0.75 ISO	●	0.75	0.6	0.6	6.35
11ER/IR 1.0 ISO	●	1.0	0.7	0.7	6.35
11ER/IR 1.25 ISO	●	1.25	0.8	0.9	6.35
11ER/IR 1.50 ISO	●	1.5	0.8	1.0	6.35
11ER/IR 2.00 ISO	●	2.0	0.8	1.1	6.35
16ER/IR A55	●	0.5~1.5	0.8	0.9	9.525
16ER/IR A60	●	0.5~1.5	0.8	0.9	9.525
16ER/IR AG55	●	0.5~3.0	1.2	1.7	9.525
16ER/IR AG60	●	0.5~3.0	1.2	1.7	9.525
16ER/IR G55	●	1.75~3.0	1.2	1.7	9.525
16ER/IR G60	●	1.75~3.0	1.2	1.7	9.525
16ER/IR 0.35 ISO	●	0.35	0.8	0.4	9.525
16ER/IR 0.4 ISO	●	0.4	0.8	0.4	9.525
16ER/IR 0.45 ISO	●	0.45	0.8	0.4	9.525
16ER/IR 0.5 ISO	●	0.5	0.6	0.4	9.525
16ER/IR 0.6 ISO	●	0.6	0.6	0.6	9.525
16ER/IR 0.7 ISO	●	0.7	0.6	0.6	9.525
16ER/IR 0.75 ISO	●	0.75	0.6	0.6	9.525
16ER/IR 0.8 ISO	●	0.8	0.6	0.6	9.525
16ER/IR 1.0 ISO	●	1.0	0.7	0.7	9.525
16ER/IR 1.25 ISO	●	1.25	0.8	0.9	9.525
16ER/IR 1.5 ISO	●	1.5	0.8	1.0	9.525
16ER/IR 1.75 ISO	●	1.75	0.9	1.2	9.525
16ER/IR 2.0 ISO	●	2.0	1.0	1.3	9.525
16ER/IR 2.5 ISO	●	2.5	1.1	1.5	9.525
16ER/IR 3.0 ISO	●	3.0	1.2	1.5	9.525

◆ 另有其他規格，歡迎來電洽詢！

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