

# A 刀片 Insert



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# 刀片識別系統

Turning Insert Identification System

**C** **N** **M** **G**  
1 2 3 4

1 刀片形狀  
Insert Shape

2 離隙角  
Relief Angle

3 精度記號  
Tolerance

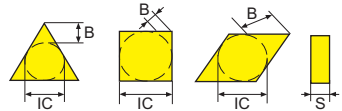
4 孔溝記號  
Insert Hole

## 1 刀片形狀 Insert Shape

記號 Symbol	刀片形狀 Insert Shape	角度 Angle
R	圓形	—
S	90° 正方形	90°
T	60° 正三角形	60°
L	90° 長方形	90°
A	85° 平行四邊形	85°
B	82° 平行四邊形	82°
K	55° 平行四邊形	55°
C	80° 菱形	80°
D	55° 菱形	55°
E	75° 菱形	75°
M	86° 菱形	86°
V	35° 菱形	35°
H	120° 正六角形	120°
O	135° 正八角形	135°
P	108° 正五角形	108°
W	80° 桃形	80°

## 2 離隙角 Relief Angle

記號 Symbol	離隙角度 Relief Angle	記號 Symbol	離隙角度 Relief Angle
A	3°	F	25°
B	5°	G	30°
C	7°	N	0°
D	15°	P	11°
E	20°		



## 3 精度記號 Tolerance

記號 Symbol	內接圓公差"IC" Inscribed Circle Tolerance		刀尖高度公差"B" Corner Height Tolerance		厚度公差"S" Thickness Tolerance	
	in	mm	in	mm	in	mm
C	±0.010	±0.025	±0.0005	±0.013	±0.001	±0.025
H	±0.005	±0.013	±0.0005	±0.013	±0.001	±0.025
E	±0.010	±0.025	±0.0010	±0.025	±0.001	±0.025
G	±0.010	±0.025	±0.0010	±0.025	±0.005	±0.13
M	±0.005	±0.05-±0.15	±0.005	±0.08-±0.02	±0.005	±0.13
U	±0.005	±0.08-±0.25	±0.005	±0.13-±0.38	±0.005	±0.13

## 4 孔溝記號 Insert Hole

記號 Symbol	孔溝記號 Insert Hole	記號 Symbol	孔溝記號 Insert Hole	記號 Symbol	孔溝記號 Insert Hole	記號 Symbol	孔溝記號 Insert Hole
N		M		Q		C	
R		G		U		J	
F		W		B			
A		T		H			

# 12 04 08 - □ □ □

5                  6                  7                  8                  9                  10

 5 尺寸  
 Size

 6 刀片厚度  
 Insert Thickness

 7 刀尖半徑  
 Corner Radius

 8 刀片方向  
 Feed Direction

 9 切邊狀況及排屑槽  
 10 Cutting Edge Condition  
 & Chip Control

**5** 尺寸 Size 切刃長和內接圓記號 Cutting Edge Length, Diameter Of IC

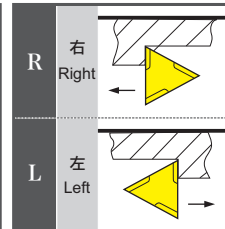
內接圓 IC		公制切刃長度 Metric Cutting Edge Length							英制切刃長度 Inch Cutting Edge Length
in	mm	(R)	(S)	(T)	(C)	(D)	(V)	(W)	
5/32	3.97	03	03	06	—	04	—	—	1.2 (5)
3/16	4.76	04	04	08	04	05	08	—	1.5 (6)
7/23	5.56	05	05	09	05	06	09	03	1.8 (7)
0.236	6.00	06	—	—	—	—	—	—	—
1/4	6.35	06	06	11	06	07	11	04	2
5/16	7.94	07	07	13	08	09	13	05	2.5
0.315	8.00	08	—	—	—	—	—	—	—
3/8	9.525	09	09	16	09	11	16	06	3
0.394	10.00	10	—	—	—	—	—	—	—
1/16	11.11	11	11	19	11	13	19	07	3.5
0.472	12.00	12	—	—	—	—	—	—	—
1/2	12.70	12	12	22	12	15	22	08	4
9/16	14.29	14	14	24	14	17	24	09	4.5
5/8	15.875	15	15	27	16	19	27	10	5
0.630	16.00	16	—	—	—	—	—	—	—
11/16	17.46	17	17	30	17	21	30	11	5.5
3/4	19.05	19	19	33	19	23	33	13	6
0.787	20.00	20	—	—	—	—	—	—	—
7/8	22.22	22	22	38	22	27	38	15	7
0.984	25.00	25	—	—	—	—	—	—	—
1	25.40	25	25	44	25	31	44	17	8
1-1/4	31.75	31	31	54	32	38	54	21	10
1.260	32.00	32	—	—	—	—	—	—	—

**6** 刀片厚度 Insert Thickness

記號 Symbol	英制 in	記號 Symbol	公制 mm
0.5 (1)	1/32	—	0.79
1 (2)	1/16	01	1.59
1.2	5/64	T1	1.98
1.5 (3)	3/32	02	2.38
2	1/8	03	3.18
2.5	5/32	T3	3.97
3	3/16	04	4.76
3.5	7/32	05	5.56
4	1/4	06	6.35
5	5/16	07	7.94
6	3/8	09	9.52
7	7/16	11	11.11
8	1/2	12	12.70

**7** 刀尖半徑 Corner Radius

記號 Symbol	英制 in	記號 Symbol	公制 mm
0	.004	01	0.1
0.5	.008	02	0.2
1	1/64	04	0.4
2	1/32	08	0.8
3	3/64	12	1.2
4	1/16	16	1.6
5	5/64	20	2.0
6	3/32	24	2.4
7	7/64	28	2.8
8	1/8	32	3.2
圓型刀片英制 round insert (in)			— 00
圓型刀片公制 round insert (mm)			— M0

**8** 刀片方向 Feed Direction

**9 10**

 切邊狀況及排屑槽  
 Cutting Edge Condition  
 & Chip Control

※ 英制尺寸: ( ) 符號為小尺寸刀片    ※ Inch size: ( ) Symbol for small size insert

# 車削用材質

Recommend Material Grades For Turning

切削狀態 Cutting Status		JIS使用分類 JIS Classification																			
		鎢鋼鍍鈦 Carbide With Altin Coating					金屬陶瓷 Cermet														
		高精度 High Precision		輕切削 Light Cutting		重切削 Roughing Cutting	高精度 High Precision		輕切削 Light Cutting		重切削 Roughing Cutting										
		01	10	20	30	40	01	10	20	30	40										
<b>P</b> 鋼 Steel		ECP100 - ECP2025 BEF606			ECP3015 - BEF607		ECP200 - ECP300 ECP3025 - BEF707 BEF706 - ECP2020 EC400			ECP3025 - ECP510		BQJ606		BQJ606F		BCW706		E1200		E1500	
<b>M</b> 不鏽鋼 Stainless Steel		ECM050 - BEJ657		ECM100 - ECM2010 BEJ757 - ECM2520			ECM200 - BEJ750 BE4875 - BEJ758		ECM2525 - ECM2530 BEP706 - BEJ759												
<b>K</b> 鑄鐵 Cast Iron		ECK1005 ECK100		ECK1015 - BEG607 BEG607F			ECK1025 - ECK2020 ECK200			ECK300		BQJ606		BQJ606F		E1200		E1500			
<b>N</b> 非鐵金屬 Non-Ferrous Metal		ECH01		ECH02 - BG656			BEJ757		PCD100												
<b>H</b> 高硬度鋼 High Hardness Steel		CBN100																			

# 各公司材質對照表

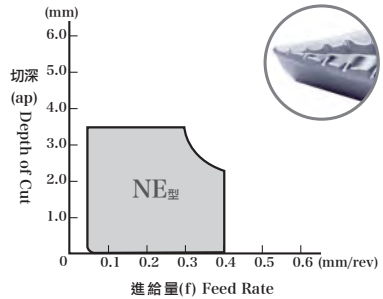
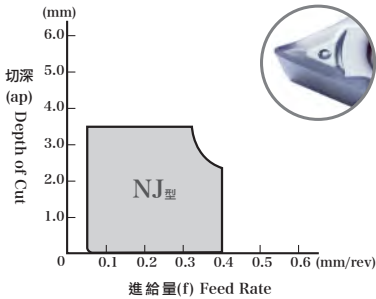
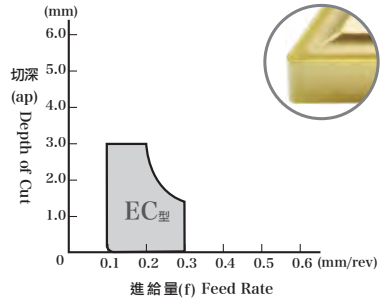
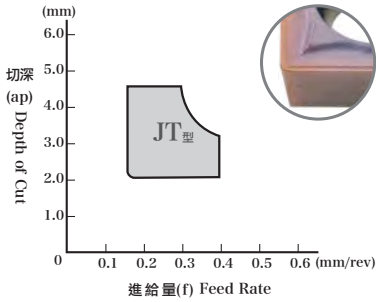
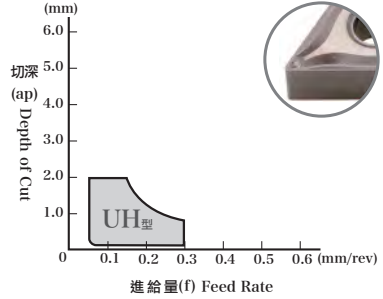
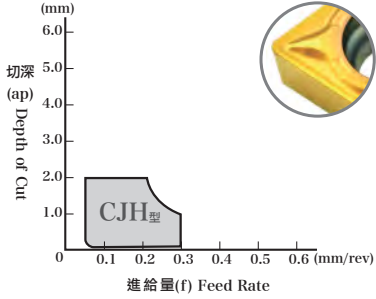
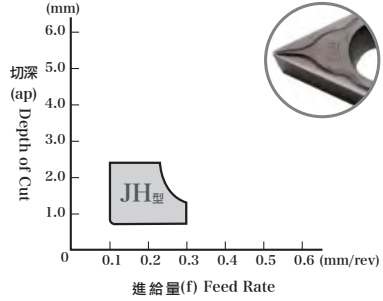
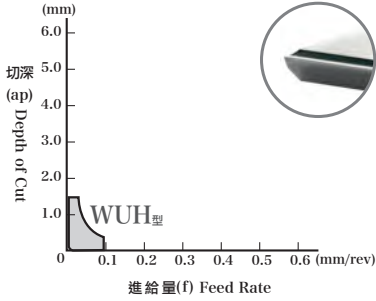
Grade Comparison Chart

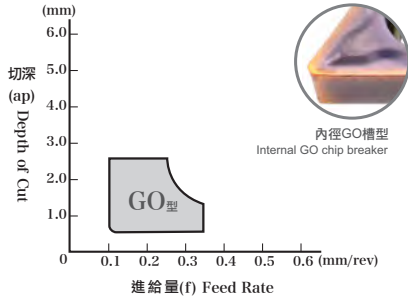
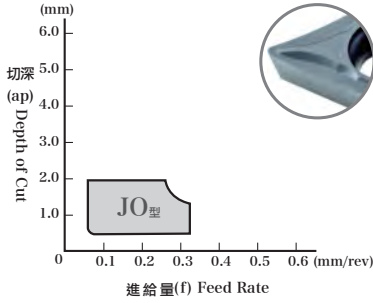
※ 用途 Application : 車削 Turning

加工件 Work Material	級別 Grade	益詮 Echain	住友電工 Sumitomo	三菱綜合材料 Mitsubishi	泰珂洛 Tungaloy	京瓷 Kyocera
<b>P</b> 鋼 Steel	P05	ECP100、ECP2005、BEF606	AC8015P	UE6105	T9105	CA5505
	P10	ECP3015、BEF607	AC8015P	UE6110	T9115	CA5515
	P20	ECP3025、ECP200、ECP2020、BEF706	AC8025P AC820P	UE6020	T9125	CA5525
	P30	ECP300、BEF707、EC400	AC8035P AC830P	UE6035	T9135	CA5535
	P40	ECP510、ECP3035	AC8035P	UE6035	T9135	PR660
<b>M</b> 不鏽鋼 Stainless Steel	M10	ECM050、BEJ657、ECM2010	AC6020M	US7020	T9115 AH905	PR1305 PRP05
	M20	ECM100、ECM120、BEJ757、ECM2020、BEJ759	AC6020M	VP15F	A725	PR1310 CA6525 PR9915
	M30	BEJ750、ECM200、ECM2530、ECM2525、BE4875、BEJ758	AC6030M	US735	AH725	PR930 PR1125
	M40	BEP706、EM2625	AC6040M		SH730	PR660 PR1125
<b>K</b> 鑄鐵 Cast Iron	K05	ECK1005	AC4010K	MC5005	T5105 T5115	CA4505 CA4010
	K10	ECK1015、ECK150、ECK100、BEG607	AC4010K AC4015K	MC5015	T5115	CA4505 CA4015 CA4115
	K20	ECK1025、ECK300、ECK200、ECK2020	AC420K AC425K	MC5025	T5125 T9125	CA4515 CA4020 CA4115
<b>N</b> 非鐵金屬 Non-Ferrous Metal		BEJ757、ECH01、ECH205、BG656	H1	H1		
<b>H</b> 高硬度鋼 High Hardness Steel		CBN100				
金屬陶瓷 Cermet		BQJ606、BQJ606F、BQJ706、E1500、E1200	T1500A T2500Z	NX2525	NS9530	TN60

# 正角斷屑槽選擇

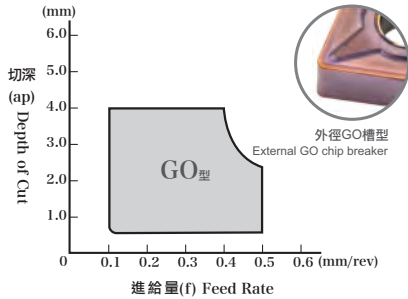
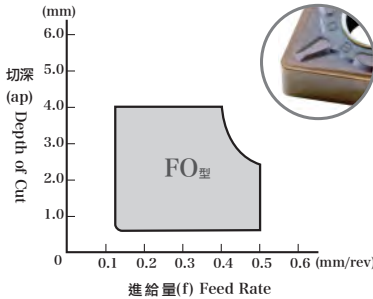
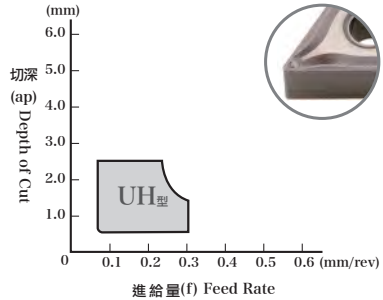
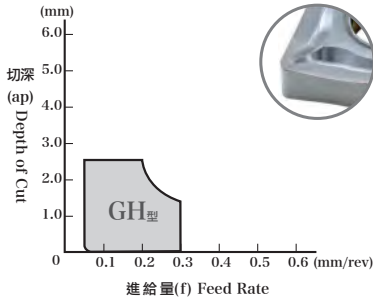
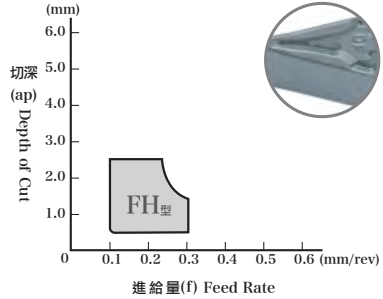
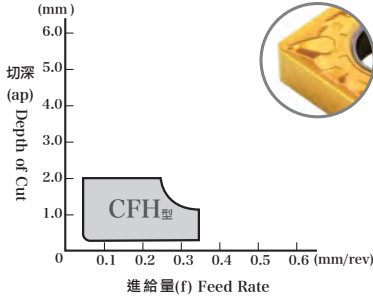
## Selection Of Chip Breaker

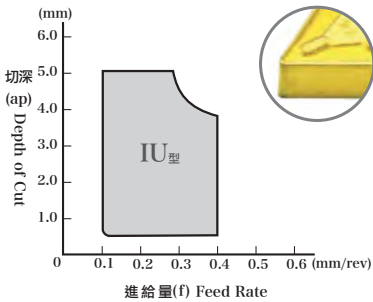
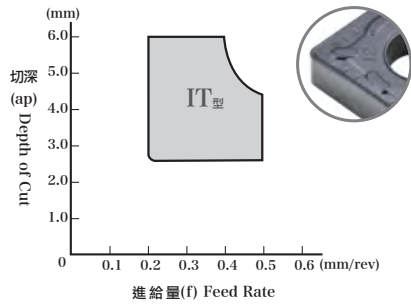
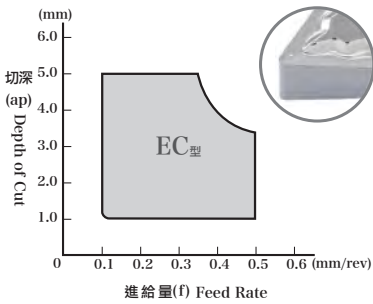
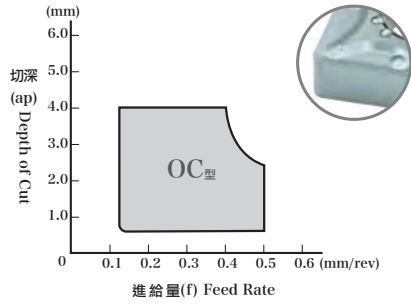
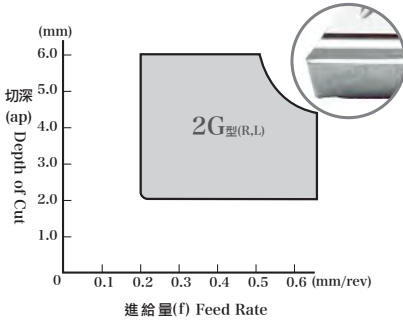
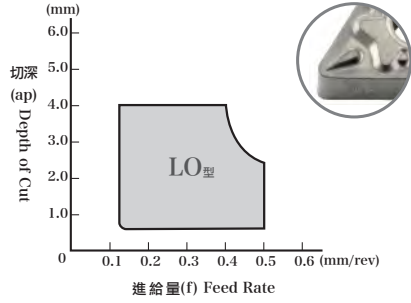
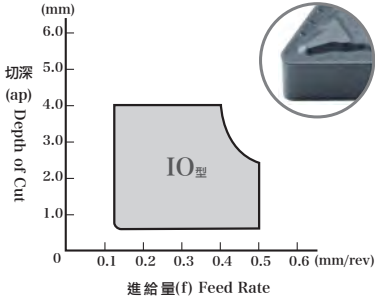




## 負角斷屑槽選擇

Selection Of Chip Breaker







# 材質推薦切削表

Recommended Cutting Condition

加工件 Work Material		進給 (f) Feed	切削速度 m/min(v) Cutting Speed	切深 (mm) Depth Of Cut
<b>P</b> 鋼 Steel	ECP2005 · ECP100 · BEF606	0.1~0.4	180~220	1.0m~3.0m
	ECP3015 · BEF607			
	ECP3025 · ECP300 · BEF707			
	ECP510			
<b>M</b> 不鏽鋼 Stainless Steel	ECM050 · BEJ657 · ECM2010	0.1~0.4	100~120	1.0m~3.0m
	ECM100 · ECM120 · ECM2010 · BECM2520 EJ757 · BEJ759		110~130	
	ECM200 · ECM2525 · ECM2530 · BE4875 · BEJ750 · BEJ758		140~160	
	BEP706 · EM2620 · EM2625		140~160	
<b>K</b> 鑄鐵 Cast Iron	ECK100 · ECK1005 · ECK1015 · ECK1025 ECK200 · ECK2020 · ECK300 · BEG607 · BEG607F	0.1~0.4	120~160	1.0m~4.0m
<b>N</b> 非鐵金屬 Non-Ferrous Metal	BEJ757 · ECH01 · ECH02 · BG656	0.1~0.4	200~300	200~350
	PCD100	0.02~0.2		200~350
<b>H</b> 高硬度鋼 High Hardness Steel	CBN100	0.03~0.2	50~120	0.03~0.5
<b>S</b> 金屬陶瓷 Cermet	BQJ606 · BQJ606F · BQW706 · E1200 · E1500	0.05~0.3	180~250	0.05~1.0

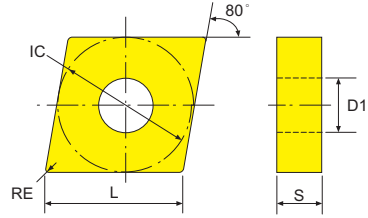
- (V=m/min · F=f/刃) (下限值-推薦值-上限值) (Min. - Optimum - Max.)
- 工具回轉速度(N)=[1000 × 切削速度(V)] ÷ [3.14 × 工具直徑(D)]
- 總進給(F)=[每刃進給(f) × 工具刀數(Z) × 工具回轉速度(N)]



# CN

## 尺寸 Dimension

切削刃長 L : 12.9 刀片厚度 S : 4.76  
 內接圓 IC : 12.7 螺釘孔徑 D1 : 5.16



- 標準庫存      \* 僅限中國地區銷售      ⊙ 僅限台灣地區銷售
- Standard Stocks      \* Sell in China only      ⊙ Sell in Taiwan only






◆ 材質介紹→參考A04頁  
 Grade Ref.Page-A04

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

◆ 斷削槽選擇→參考A06-A08頁  
 Chipbreaker Ref.Page-A06-A08

◆ 切削條件→參考A09頁  
 Cutting condition Ref.Page-A09

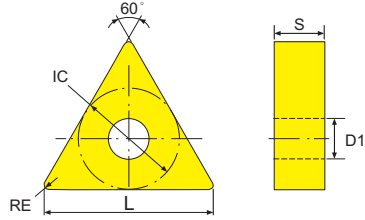
形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated														金屬陶瓷 Cermet				備註 Platinum Plating								
			EGP3015	EGP3035	EGP200	EGP300	EGP3025	BEF707	ECM100	ECM200	BE4875	BEJ750	BEJ706	BEJ750	BEJ758	ECM2020	ECK1005	ECJ100	ECJ200	ECJ300		BE6607	N	W35	BQJ606	BQJ706	E1500	BQJ505	BQJ605
IO中切削 Medium 	CNMG120404-IO	0.4				●	●	●													●								
	CNMG120408-IO	0.8			●	●	●			●								●	●										
	CNMG120412-IO	1.2			●	●	●												●										
RO中切削 Medium 	CNMG120404-RO	0.4																			●								
	CNMG120408-RO	0.8							●												●								
OC中切削 Medium 	CNMG120404-OC	0.4								●																			
	CNMG120408-OC	0.8								●																			
UH精切削 Finishing 	CNMG120404-UH	0.4																										●	
	CNMG120408-UH	0.8																										●	
VE中粗切削 Medium and roughing 	CNMG120404-VE	0.4																			●								
	CNMG120408-VE	0.8																				●							
	CNMG120412-VE	1.2																				●							



# TN

## 尺寸 Dimension

切削刃長 L : 16.5 刀片厚度 S : 4.76  
內接圓 IC : 9.525 螺釘孔徑 D1 : 3.81



- 標準庫存                      \* 僅限中國地區銷售                      ◎ 僅限台灣地區銷售
- Standard Stocks            \* Sell in China only                                      ◎ Sell in Taiwan only







◆ 材質介紹→參考A04頁  
Grade Ref. Page-A04

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

◆ 斷削槽選擇→參考A06-A08頁  
Chipbreaker Ref. Page-A06-A08

◆ 切削條件→參考A09頁  
Cutting condition Ref. Page-A09

形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated													金屬陶瓷 Cermet												
			P	P	M	K	N	W35	BQJ606	BQW706	E1500	鍍氮 TiAlN	鍍氮 TiAlN	鍍氮 TiAlN														
			EGP3015	EGP3035	EGP3000	EGP3025	BEF707	ECM100	ECM200	BE4875	BEF706	BEJ750	BEJ751	BEJ758	ECM2020	ECM1005	ECM200	ECM300	BE6607	BE6656	W35	BQJ606	BQW706	E1500	鍍氮 TiAlN	鍍氮 TiAlN	鍍氮 TiAlN	
中粗切削 Medium and roughing 	TNMA160404	0.4																	●	●								
	TNMA160408	0.8																	●	●								
中粗切削 Medium and roughing 	TNMG160408	0.8			●	●			●						●	●	●											
	CFH中輕切削 Mid and light cutting 	TNMG160404-CFH	0.4								●															●		
	TNMG160408-CFH	0.8									●															●		
FO中切削 Medium 	TNMG160404-FO	0.4						●	●			●	●	●					●									
	TNMG160408-FO	0.8						●	●			●	●	●					●									
	TNMG160412-FO	1.2																										
2G(L) 中切削 Medium 	TNMG160404L-2G	0.4																							●			
	2G(R) 中切削 Medium 	TNMG160404R-2G	0.4																						●			









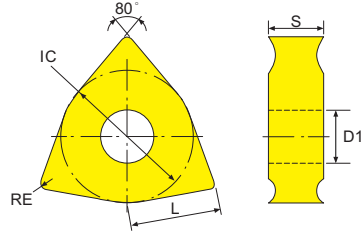


# WN

## 尺寸 Dimension

切削刃長 L : 8.7 刀片厚度 S : 4.76

內接圓 IC : 12.7 螺釘孔徑 D1 : 5.16



- 標準庫存
- \* 僅限中國地區銷售
- ◎ 僅限台灣地區銷售
- Standard Stocks
- \* Sell in China only
- ◎ Sell in Taiwan only

- ◆ 材質介紹→參考A04頁  
Grade Ref.Page-A04

- ◆ 斷屑槽選擇→參考A06-A08頁  
Chipbreaker Ref.Page-A06-A08

- ◆ 切削條件→參考A09頁  
Cutting condition Ref.Page-A09

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

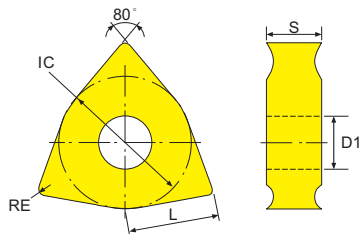
形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated													金屬陶瓷 Cermet																																
			ECB3015	ECB3025	ECB3035	ECB2100	ECB3000	ECB3025	BEF707	ECM1100	ECM200	BE4875	BEF706	BEJ750	BEJ757	BEJ758	ECM2020	ECB1005	ECB1100	ECB200	ECB300	BE6607	BE6656	W35	BQJ606	BQW706	E1500	High Speed Steel	Platinum	Parting																		
中粗切削 Medium and roughing	WNMA080404	0.4																				●																										
	WNMA080408	0.8																				●		●																								
中粗切削 Medium and roughing	WNMG080408	0.8		●	●	●	●				●											●		●	●																							
CFH中輕切削 Mid and light cutting	WNMG080404-CFH	0.4									●																																					
	WNMG080408-CFH	0.8									●																																					
DO中切削 Medium	WNMG080404-DO	0.4													●																																	
	WNMG080408-DO	0.8														●																																
FO中切削 Medium	WNMG080404-FO	0.4						●	●						●	●	●					●																										
	WNMG080408-FO	0.8							●	●						●	●	●					●																									
	WNMG080412-FO	1.2																					●																									
FT中粗切削 Medium and roughing	WNMG080404-FT	0.4							●	●													●																									
	WNMG080408-FT	0.8								●						●	●						●																									

## WN

## 尺寸 Dimension

切削刃長 L : 8.7 刀片厚度 S : 4.76

內接圓 IC : 12.7 螺釘孔徑 D1 : 5.16



- 標準庫存          \* 僅限中國地區銷售      ○ 僅限台灣地區銷售
- Standard Stocks      \* Sell in China only      ○ Sell in Taiwan only

 ◆ 材質介紹→參考A04頁  
 Grade Ref.Page-A04

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

 ◆ 斷屑槽選擇→參考A06-A08頁  
 Chipbreaker Ref.Page-A06-A08

 ◆ 切削條件→參考A09頁  
 Cutting condition Ref.Page-A09

形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated													金屬陶瓷 Cermet				備註 Minimum Parting						
			P			P			M			K			N		W35	BQJ606	BQJ608		E1500	BQJ606F	E1500			
			EGP3015	EGP3025	EGP3035	EGP3000	EGP200	EGP3035	EGP3000	EGP3025	BEF707	BEF607	ECM200	ECM100	BEJ750	BEJ758								ECM2020	ECK1005	ECK1100
	WNMG080404-GO	0.4																								
	WNMG080408-GO	0.8																								
	WNMG080404-IO	0.4			●	●	●													●						
	WNMG080408-IO	0.8			●	●	●														●	●	●			
	WNMG080404-RO	0.4								●												●				
	WNMG080408-RO	0.8								●													●			
	WNMG080404-VE	0.4																					●			
	WNMG080408-VE	0.8																						●		
	WNMG080404-OC	0.4				●	●																			
	WNMG080408-OC	0.8				●	●	●			●	●														

## 尺寸 Dimension

切削刃長 L : 6.5 刀片厚度 S : 4.76

內接圓 IC : 9.525 螺釘孔徑 D1 : 3.81

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated													金屬陶瓷 Cermet				備註 Minimum Parting						
			P			P			M			K			N		W35	BQJ606	BQJ608		E1500	BQJ606F	E1500			
			EGP3015	EGP3025	EGP3035	EGP200	EGP300	EGP3000	EGP3025	BEF707	BEF607	ECM100	ECM200	BEJ758	BEJ750	ECM2020								ECK1005	ECK1100	ECK200
	WNMG060408-FO	0.8																								

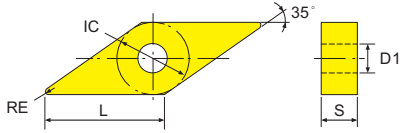




# VN

### 尺寸 Dimension

切削刃長 L : 16.6 刀片厚度 S : 4.76  
內接圓 IC : 9.525 螺釘孔徑 D1 : 3.81



- 標準庫存      \*僅限中國地區銷售      ⊙僅限台灣地區銷售
- Standard Stocks    \* Sell in China only      ⊙ Sell in Taiwan only

◆ 材質介紹→參考A04頁  
Grade Ref. Page-A04

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

◆ 斷屑槽選擇→參考A06-A08頁  
Chipbreaker Ref. Page-A06-A08

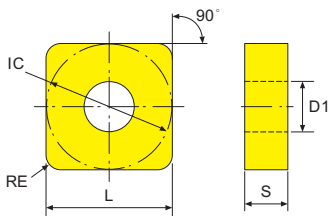
◆ 切削條件→參考A09頁  
Cutting condition Ref. Page-A09

形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated																	金屬陶瓷 Cermet													
			EGP3015	EGP3025	EGP3035	EGP2100	EGP3000	EGP3025	BEF707	ECM1100	ECM200	BE4875	BE1750	BE1706	BE1750	BE1758	ECM2020	ECM105	EC1100	EC200	EC300	BE6607	N	W35	BQJ606	BQJ706	BQJ506	BQJ606					
中輕切削 Mid and light cutting	VNMG160404	0.4			●						●									●													
CFH中輕切削 Mid and light cutting	VNMG160404-CFH	0.4										●																					
	VNMG160408-CFH	0.8										●																					
GO中切削 Medium	VNMG160404-GO	0.4													●●																		
	VNMG160408-GO	0.8														●●																	
IO中切削 Medium	VNMG160404-IO	0.4						●●●			●●									●													
	VNMG160408-IO	0.8						●●●			●										●												
RO中切削 Medium	VNMG160404-RO	0.4									●●										●												
	VNMG160408-RO	0.8									●											●											
OC中切削 Medium	VNMG160404-OC	0.4																		●													
	VNMG160408-OC	0.8																			●												
UH精切削 Finishing	VNMG160404-UH	0.4																														●	
	VNMG160408-UH	0.8																														●	

尺寸 Dimension

切削刃長 L : 12.7 刀片厚度 S : 4.76

內接圓 IC : 12.7 螺釘孔徑 D1 : 5.16



- 標準庫存                      \* 僅限中國地區銷售                      ◎僅限台灣地區銷售
- Standard Stocks                \* Sell in China only                      ◎Sell in Taiwan only

◆ 材質介紹→參考A04頁  
Grade Ref. Page-A04

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

◆ 斷削槽選擇→參考A06-A08頁  
Chipbreaker Ref. Page-A06-A08

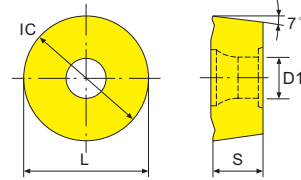
◆ 切削條件→參考A09頁  
Cutting condition Ref. Page-A09

形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated													金屬陶瓷 Cermet				
			P	P	M	M	K	K	N	N	W35	BQJ606	BQJ706	E1500	陶瓷 Titanium Parting BQJ016	陶瓷 Titanium Parting E1500				
<b>中粗切削</b> Medium and roughing	SNMA120408	0.8																		
	SNMA120412	1.2																		
<b>CFH中輕切削</b> Mid and light cutting	SNMG120408-CFH	0.8																		
<b>FO中切削</b> Medium	SNMG120408-FO	0.8																		
<b>FT中粗切削</b> Medium and roughing	SNMG120408-FT	0.8																		
<b>IO中切削</b> Medium	SNMG120408-IO	0.8				●	●													
	SNMG120412-IO	1.2				●														

# IRC

### 尺寸 Dimension

切削刃長 L : 8      刀片厚度 S : 3.18  
 內接圓 IC : 8      螺釘孔徑 D1 : 3.36



- 標準庫存      \* 僅限中國地區銷售      ◎ 僅限台灣地區銷售
- Standard Stocks      \* Sell in China only      ◎ Sell in Taiwan only




◆ 材質介紹→參考A04頁  
 Grade Ref.Page-A04

◆ 斷屑槽選擇→參考A06-A08頁  
 Chipbreaker Ref.Page-A06-A08

◆ 切削條件→參考A09頁  
 Cutting condition Ref.Page-A09

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet


形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated														金屬陶瓷 Cermet																		
			RE	EGP3015	EGP3025	EGP3035	EGP200	EGP300	EGP3025	BEF706	BEF707	ECM100	ECM200	BE4875	BEF706	BEJ750	BEJ757	ECM2020	ECM2021	ECK1005	ECK100	ECK200	ECK300	BE6607	BE6656	W35	BOJ606	BOJ706	E1500	BOJ509F	BOJ609F	Titanium Plating			
HH中粗切削 Medium and roughing 	RCKT0803MO-HH	4																															●		
UU中粗切削 Medium and roughing 	RCMT0803MO-UU	4													●					●															
EG精切削 Finishing 	RCGT0803MO-EG	4																																	

### 尺寸 Dimension

切削刃長 L : 10      刀片厚度 S : 3.97  
 內接圓 IC : 10      螺釘孔徑 D1 : 4.4

塗層硬質合金 Carbide Coated

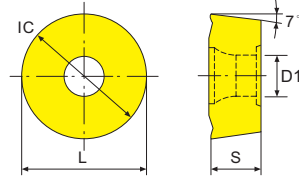
金屬陶瓷 Cermet

形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated														金屬陶瓷 Cermet																	
			RE	EGP3015	EGP3025	EGP3035	EGP200	EGP300	EGP3025	BEF706	BEF707	ECM100	ECM200	BE4875	BEF706	BEJ750	BEJ757	ECM2020	ECM2021	ECK1005	ECK100	ECK200	ECK300	BE6607	BE6656	W35	BOJ606	BOJ706	E1500	BOJ509F	BOJ609F	Titanium Plating		
粗切削 Roughing 	RCMT10T3MO	5																																

**RC**

尺寸 Dimension

切削刃長 L : 12      刀片厚度 S : 4.76  
 內接圓 IC : 12      螺釘孔徑 D1 : 4.4



- 標準庫存                      \* 僅限中國地區銷售                      ⊙ 僅限台灣地區銷售
- Standard Stocks              \* Sell in China only                              ⊙ Sell in Taiwan only

◆ 材質介紹→參考A04頁  
 Grade Ref.Page-A04

◆ 斷屑槽選擇→參考A06-A08頁  
 Chipbreaker Ref.Page-A06-A08

◆ 切削條件→參考A09頁  
 Cutting condition Ref.Page-A09

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

形狀 Shape	型號 Model No	RE	刀片 半徑	塗層硬質合金 Carbide Coated																金屬陶瓷 Cermet													
				P	P	M	K	N	W35	BQJ606	BQJ706	E1500	BQJ506	備註 Titanium Plating																			
粗切削 Roughing	RCMT1204MO	6		EGP3015	EGP3025	EGP3035	ECP200	ECP300	EGP3025	BEP706	BEP707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK1100	ECK200	ECK300	BEG607	B6666	W35	BQJ606	BQJ706	E1500	BQJ506	備註 Titanium Plating		

















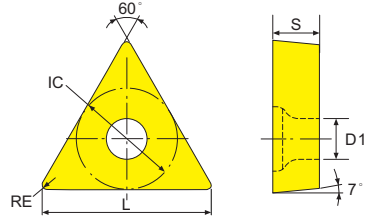




# TC

## 尺寸 Dimension

切削刃長 L : 9.6    刀片厚度 S : 2.38  
內接圓 IC : 5.56    螺釘孔徑 D1 : 2.8



- 標準庫存                      \*僅限中國地區銷售                      ⊙僅限台灣地區銷售
- Standard Stocks            \*Sell in China only                              ⊙Sell in Taiwan only



◆ 材質介紹→參考A04頁  
Grade Ref. Page-A04

◆ 斷削槽選擇→參考A06-A08頁  
Chipbreaker Ref. Page-A06-A08

◆ 切削條件→參考A09頁  
Cutting condition Ref. Page-A09

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet


形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated															金屬陶瓷 Cermet													
			RE	FCP3015	FCP3025	FCP3035	FCP200	FCP300	FCP3025	BEF607	BEF707	FCM100	ECM200	BE4875	BEF706	BEJ750	BEJ757	BEJ758	ECM2020	ECM1005	ECM100	ECM200	ECM300	BE6607	BE6656	W35	BQJ606	BQJ706	E1500	Titanium Plating BQJ606F	
GO中切削 Medium 	TCMT090204-GO	0.4																													
	TCMT090208-GO	0.8																													
JO中切削 Medium 	TCMT090204-JO	0.4				●	●				●												●								
	TCMT090208-JO	0.8					●				●												●								

## 尺寸 Dimension

切削刃長 L : 9.6    刀片厚度 S : 2.38  
內接圓 IC : 5.56    螺釘孔徑 D1 : 2.5

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

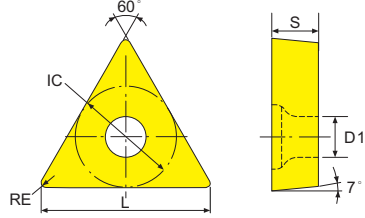
形狀 Shape	型號 Model No	RE	塗層硬質合金 Carbide Coated															金屬陶瓷 Cermet													
			RE	FCP3015	FCP3025	FCP3035	FCP200	FCP300	FCP3025	BEF607	BEF707	FCM100	ECM200	BE4875	BEF706	BEJ750	BEJ757	BEJ758	ECM2020	ECM1005	ECM100	ECM200	ECM300	BE6607	BE6656	W35	BQJ606	BQJ706	E1500	Titanium Plating BQJ606F	
NE鋁切削 Aluminum 	TCGT090204-NE	0.4																													



# TC

## 尺寸 Dimension

切削刃長 L : 16.5    刀片厚度 S : 3.97  
 內接圓 IC : 9.525    螺釘孔徑 D1 : 4.4



- 標準庫存                      \* 僅限中國地區銷售                      ◎ 僅限台灣地區銷售
- Standard Stocks            \* Sell in China only                                      ◎ Sell in Taiwan only

◆ 材質介紹→參考A04頁  
 Grade Ref. Page-A04

◆ 斷屑槽選擇→參考A06-A08頁  
 Chipbreaker Ref. Page-A06-A08

◆ 切削條件→參考A09頁  
 Cutting condition Ref. Page-A09

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated												金屬陶瓷 Cermet					
			P	P	M	K	N	WS	BQ	ET	TP	TP	TP	TP	TP					
HH中粗切削 Medium and roughing	TCMT16T304-HH	0.4	●	●																
CJH中輕切削 Mid and light cutting	TCMT16T304-CJH	0.4			●															
GO中切削 Medium	TCMT16T304-GO	0.4					●													
	TCMT16T308-GO	0.8					●													
JO中切削 Medium	TCMT16T304-JO	0.4	●	●	●	●	●	●												
	TCMT16T308-JO	0.8	●	●	●	●	●		●		●									
NE鋁切削 Aluminum	TCGT16T304-NE	0.4														●				
	TCGT16T308-NE	0.8														●				

## 尺寸 Dimension

切削刃長 L : 22    刀片厚度 S : 4.76  
 內接圓 IC : 12.7    螺釘孔徑 D1 : 5.5

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated												金屬陶瓷 Cermet						
			P	P	M	K	N	WS	BQ	ET	TP	TP	TP	TP							
輕切削 Light cutting	TCMT220408	0.8			●																

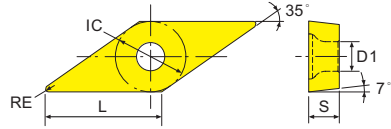






# VC

尺寸 Dimension	
切削刃長 L : 16.5	刀片厚度 S : 4.76
內接圓 IC : 9.525 螺釘孔徑 D1 : 4.4	



- 標準庫存      \* 僅限中國地區銷售      ⊙ 僅限台灣地區銷售
- Standard Stocks      \* Sell in China only      ⊙ Sell in Taiwan only






◆ 材質介紹→參考A04頁  
Grade Ref.Page-A04

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

◆ 斷削槽選擇→參考A06-A08頁  
Chipbreaker Ref.Page-A06-A08

◆ 切削條件→參考A09頁  
Cutting condition Ref.Page-A09

形狀 Shape	型號 Model No	RE	刀尖半徑																Titanium Plating																	
			EGP3015	EGP3025	EGP3035	EGP2100	EGP3000	EGP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BE750	BE706	BE757	BE758	ECM2020	ECK105	ECK100	ECK200	ECK300	BE6607	B6666	W35	BQJ606	BQJ706	BQJ906	E1500	ET1500						
中輕切削 Mid and light cutting 	VCMT160404	0.4				●									●●									●												
EC中輕切削 Mid and light cutting 	VCMT160404-EC	0.4				●																														
EK中切削 Medium 	VCMT160404-EK	0.4							●●															●												
	VCMT160408-EK	0.8							●●															●		●										
GO中切削 Medium 	VCMT160404-GO	0.4																																		
	VCMT160408-GO	0.8																																		
NE銼切削 Aluminum 	VCGT160402-NE	0.2																																		
	VCGT160404-NE	0.4																																		
	VCGT160408-NE	0.8																																		
	VCGT160412-NE	1.2																																		









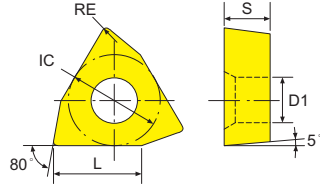


**WB**

尺寸 Dimension

切削刃長 L : 3.2 刀片厚度 S : 1.59

內接圓 IC : 3.97 螺釘孔徑 D1 : 2.2



- 標準庫存                      \* 僅限中國地區銷售                      ◎ 僅限台灣地區銷售
- Standard Stocks            \* Sell in China only                                      ◎ Sell in Taiwan only


◆ 材質介紹→參考A04頁  
Grade Ref.Page-A04

◆ 斷削槽選擇→參考A06-A08頁  
Chipbreaker Ref.Page-A06-A08

◆ 切削條件→參考A09頁  
Cutting condition Ref.Page-A09

塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

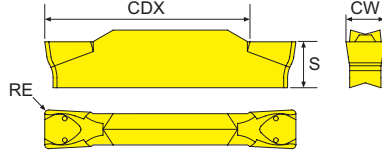
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated														金屬陶瓷 Cermet				TiAlN 塗層 Titanium Nitride																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			P	P	M	K	N	W35	BQJ606	BQJ706	E1500	BQJ506	BQJ606	BQJ706	E1500	BQJ506																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
精切削 Finishing 	WBGT060104L-U	0.4	ECR3015	ECR3025	ECR3035	ECR3045	ECR3055	ECR3065	ECR3075	ECR3085	ECR3095	ECR3105	ECR3115	ECR3125	ECR3135	ECR3145	ECR3155	ECR3165	ECR3175	ECR3185	ECR3195	ECR3205	ECR3215	ECR3225	ECR3235	ECR3245	ECR3255	ECR3265	ECR3275	ECR3285	ECR3295	ECR3305	ECR3315	ECR3325	ECR3335	ECR3345	ECR3355	ECR3365	ECR3375	ECR3385	ECR3395	ECR3405	ECR3415	ECR3425	ECR3435	ECR3445	ECR3455	ECR3465	ECR3475	ECR3485	ECR3495	ECR3505	ECR3515	ECR3525	ECR3535	ECR3545	ECR3555	ECR3565	ECR3575	ECR3585	ECR3595	ECR3605	ECR3615	ECR3625	ECR3635	ECR3645	ECR3655	ECR3665	ECR3675	ECR3685	ECR3695	ECR3705	ECR3715	ECR3725	ECR3735	ECR3745	ECR3755	ECR3765	ECR3775	ECR3785	ECR3795	ECR3805	ECR3815	ECR3825	ECR3835	ECR3845	ECR3855	ECR3865	ECR3875	ECR3885	ECR3895	ECR3905	ECR3915	ECR3925	ECR3935	ECR3945	ECR3955	ECR3965	ECR3975	ECR3985	ECR3995	ECR4005	ECR4015	ECR4025	ECR4035	ECR4045	ECR4055	ECR4065	ECR4075	ECR4085	ECR4095	ECR4105	ECR4115	ECR4125	ECR4135	ECR4145	ECR4155	ECR4165	ECR4175	ECR4185	ECR4195	ECR4205	ECR4215	ECR4225	ECR4235	ECR4245	ECR4255	ECR4265	ECR4275	ECR4285	ECR4295	ECR4305	ECR4315	ECR4325	ECR4335	ECR4345	ECR4355	ECR4365	ECR4375	ECR4385	ECR4395	ECR4405	ECR4415	ECR4425	ECR4435	ECR4445	ECR4455	ECR4465	ECR4475	ECR4485	ECR4495	ECR4505	ECR4515	ECR4525	ECR4535	ECR4545	ECR4555	ECR4565	ECR4575	ECR4585	ECR4595	ECR4605	ECR4615	ECR4625	ECR4635	ECR4645	ECR4655	ECR4665	ECR4675	ECR4685	ECR4695	ECR4705	ECR4715	ECR4725	ECR4735	ECR4745	ECR4755	ECR4765	ECR4775	ECR4785	ECR4795	ECR4805	ECR4815	ECR4825	ECR4835	ECR4845	ECR4855	ECR4865	ECR4875	ECR4885	ECR4895	ECR4905	ECR4915	ECR4925	ECR4935	ECR4945	ECR4955	ECR4965	ECR4975	ECR4985	ECR4995	ECR5005	ECR5015	ECR5025	ECR5035	ECR5045	ECR5055	ECR5065	ECR5075	ECR5085	ECR5095	ECR5105	ECR5115	ECR5125	ECR5135	ECR5145	ECR5155	ECR5165	ECR5175	ECR5185	ECR5195	ECR5205	ECR5215	ECR5225	ECR5235	ECR5245	ECR5255	ECR5265	ECR5275	ECR5285	ECR5295	ECR5305	ECR5315	ECR5325	ECR5335	ECR5345	ECR5355	ECR5365	ECR5375	ECR5385	ECR5395	ECR5405	ECR5415	ECR5425	ECR5435	ECR5445	ECR5455	ECR5465	ECR5475	ECR5485	ECR5495	ECR5505	ECR5515	ECR5525	ECR5535	ECR5545	ECR5555	ECR5565	ECR5575	ECR5585	ECR5595	ECR5605	ECR5615	ECR5625	ECR5635	ECR5645	ECR5655	ECR5665	ECR5675	ECR5685	ECR5695	ECR5705	ECR5715	ECR5725	ECR5735	ECR5745	ECR5755	ECR5765	ECR5775	ECR5785	ECR5795	ECR5805	ECR5815	ECR5825	ECR5835	ECR5845	ECR5855	ECR5865	ECR5875	ECR5885	ECR5895	ECR5905	ECR5915	ECR5925	ECR5935	ECR5945	ECR5955	ECR5965	ECR5975	ECR5985	ECR5995	ECR6005	ECR6015	ECR6025	ECR6035	ECR6045	ECR6055	ECR6065	ECR6075	ECR6085	ECR6095	ECR6105	ECR6115	ECR6125	ECR6135	ECR6145	ECR6155	ECR6165	ECR6175	ECR6185	ECR6195	ECR6205	ECR6215	ECR6225	ECR6235	ECR6245	ECR6255	ECR6265	ECR6275	ECR6285	ECR6295	ECR6305	ECR6315	ECR6325	ECR6335	ECR6345	ECR6355	ECR6365	ECR6375	ECR6385	ECR6395	ECR6405	ECR6415	ECR6425	ECR6435	ECR6445	ECR6455	ECR6465	ECR6475	ECR6485	ECR6495	ECR6505	ECR6515	ECR6525	ECR6535	ECR6545	ECR6555	ECR6565	ECR6575	ECR6585	ECR6595	ECR6605	ECR6615	ECR6625	ECR6635	ECR6645	ECR6655	ECR6665	ECR6675	ECR6685	ECR6695	ECR6705	ECR6715	ECR6725	ECR6735	ECR6745	ECR6755	ECR6765	ECR6775	ECR6785	ECR6795	ECR6805	ECR6815	ECR6825	ECR6835	ECR6845	ECR6855	ECR6865	ECR6875	ECR6885	ECR6895	ECR6905	ECR6915	ECR6925	ECR6935	ECR6945	ECR6955	ECR6965	ECR6975	ECR6985	ECR6995	ECR7005	ECR7015	ECR7025	ECR7035	ECR7045	ECR7055	ECR7065	ECR7075	ECR7085	ECR7095	ECR7105	ECR7115	ECR7125	ECR7135	ECR7145	ECR7155	ECR7165	ECR7175	ECR7185	ECR7195	ECR7205	ECR7215	ECR7225	ECR7235	ECR7245	ECR7255	ECR7265	ECR7275	ECR7285	ECR7295	ECR7305	ECR7315	ECR7325	ECR7335	ECR7345	ECR7355	ECR7365	ECR7375	ECR7385	ECR7395	ECR7405	ECR7415	ECR7425	ECR7435	ECR7445	ECR7455	ECR7465	ECR7475	ECR7485	ECR7495	ECR7505	ECR7515	ECR7525	ECR7535	ECR7545	ECR7555	ECR7565	ECR7575	ECR7585	ECR7595	ECR7605	ECR7615	ECR7625	ECR7635	ECR7645	ECR7655	ECR7665	ECR7675	ECR7685	ECR7695	ECR7705	ECR7715	ECR7725	ECR7735	ECR7745	ECR7755	ECR7765	ECR7775	ECR7785	ECR7795	ECR7805	ECR7815	ECR7825	ECR7835	ECR7845	ECR7855	ECR7865	ECR7875	ECR7885	ECR7895	ECR7905	ECR7915	ECR7925	ECR7935	ECR7945	ECR7955	ECR7965	ECR7975	ECR7985	ECR7995	ECR8005	ECR8015	ECR8025	ECR8035	ECR8045	ECR8055	ECR8065	ECR8075	ECR8085	ECR8095	ECR8105	ECR8115	ECR8125	ECR8135	ECR8145	ECR8155	ECR8165	ECR8175	ECR8185	ECR8195	ECR8205	ECR8215	ECR8225	ECR8235	ECR8245	ECR8255	ECR8265	ECR8275	ECR8285	ECR8295	ECR8305	ECR8315	ECR8325	ECR8335	ECR8345	ECR8355	ECR8365	ECR8375	ECR8385	ECR8395	ECR8405	ECR8415	ECR8425	ECR8435	ECR8445	ECR8455	ECR8465	ECR8475	ECR8485	ECR8495	ECR8505	ECR8515	ECR8525	ECR8535	ECR8545	ECR8555	ECR8565	ECR8575	ECR8585	ECR8595	ECR8605	ECR8615	ECR8625	ECR8635	ECR8645	ECR8655	ECR8665	ECR8675	ECR8685	ECR8695	ECR8705	ECR8715	ECR8725	ECR8735	ECR8745	ECR8755	ECR8765	ECR8775	ECR8785	ECR8795	ECR8805	ECR8815	ECR8825	ECR8835	ECR8845	ECR8855	ECR8865	ECR8875	ECR8885	ECR8895	ECR8905	ECR8915	ECR8925	ECR8935	ECR8945	ECR8955	ECR8965	ECR8975	ECR8985	ECR8995	ECR9005	ECR9015	ECR9025	ECR9035	ECR9045	ECR9055	ECR9065	ECR9075	ECR9085	ECR9095	ECR9105	ECR9115	ECR9125	ECR9135	ECR9145	ECR9155	ECR9165	ECR9175	ECR9185	ECR9195	ECR9205	ECR9215	ECR9225	ECR9235	ECR9245	ECR9255	ECR9265	ECR9275	ECR9285	ECR9295	ECR9305	ECR9315	ECR9325	ECR9335	ECR9345	ECR9355	ECR9365	ECR9375	ECR9385	ECR9395	ECR9405	ECR9415	ECR9425	ECR9435	ECR9445	ECR9455	ECR9465	ECR9475	ECR9485	ECR9495	ECR9505	ECR9515	ECR9525	ECR9535	ECR9545	ECR9555	ECR9565	ECR9575	ECR9585	ECR9595	ECR9605	ECR9615	ECR9625	ECR9635	ECR9645	ECR9655	ECR9665	ECR9675	ECR9685	ECR9695	ECR9705	ECR9715	ECR9725	ECR9735	ECR9745	ECR9755	ECR9765	ECR9775	ECR9785	ECR9795	ECR9805	ECR9815	ECR9825	ECR9835	ECR9845	ECR9855	ECR9865	ECR9875	ECR9885	ECR9895	ECR9905	ECR9915	ECR9925	ECR9935	ECR9945	ECR9955	ECR9965	ECR9975	ECR9985	ECR9995	ECR10005	ECR10015	ECR10025	ECR10035	ECR10045	ECR10055	ECR10065	ECR10075	ECR10085	ECR10095	ECR10105	ECR10115	ECR10125	ECR10135	ECR10145	ECR10155	ECR10165	ECR10175	ECR10185	ECR10195	ECR10205	ECR10215	ECR10225	ECR10235	ECR10245	ECR10255	ECR10265	ECR10275	ECR10285	ECR10295	ECR10305	ECR10315	ECR10325	ECR10335	ECR10345	ECR10355	ECR10365	ECR10375	ECR10385	ECR10395	ECR10405	ECR10415	ECR10425	ECR10435	ECR10445	ECR10455	ECR10465	ECR10475	ECR10485	ECR10495	ECR10505	ECR10515	ECR10525	ECR10535	ECR10545	ECR10555	ECR10565	ECR10575	ECR10585	ECR10595	ECR10605	ECR10615	ECR10625	ECR10635	ECR10645	ECR10655	ECR10665	ECR10675	ECR10685	ECR10695	ECR10705	ECR10715	ECR10725	ECR10735	ECR10745	ECR10755	ECR10765	ECR10775	ECR10785	ECR10795	ECR10805	ECR10815	ECR10825	ECR10835	ECR10845	ECR10855	ECR10865	ECR10875	ECR10885	ECR10895	ECR10905	ECR10915	ECR10925	ECR10935	ECR10945	ECR10955	ECR10965	ECR10975	ECR10985	ECR10995	ECR11005	ECR11015	ECR11025	ECR11035	ECR11045	ECR11055	ECR11065	ECR11075	ECR11085	ECR11095	ECR11105	ECR11115	ECR11125	ECR11135	ECR11145	ECR11155	ECR11165	ECR11175	ECR11185	ECR11195	ECR11205	ECR11215	ECR11225	ECR11235	ECR11245	ECR11255	ECR11265	ECR11275	ECR11285	ECR11295	ECR11305	ECR11315	ECR11325	ECR11335	ECR11345	ECR11355	ECR11365	ECR11375	ECR11385	ECR11395	ECR11405	ECR11415	ECR11425	ECR11435	ECR11445	ECR11455	ECR11465	ECR11475	ECR11485	ECR11495	ECR11505	ECR11515	ECR11525	ECR11535	ECR11545	ECR11555	ECR11565	ECR11575	ECR11585	ECR11595	ECR11605	ECR11615	ECR11625	ECR11635	ECR11645	ECR11655	ECR11665	ECR11675	ECR11685	ECR11695	ECR11705	ECR11715	ECR11725	ECR11735	ECR11745	ECR11755	ECR11765	ECR11775	ECR11785	ECR11795	ECR11805	ECR11815	ECR11825	ECR11835	ECR11845	ECR11855	ECR11865	ECR11875	ECR11885	ECR11895	ECR11905	ECR11915	ECR11925	ECR11935	ECR11945	ECR11955	ECR11965	ECR11975	ECR11985	ECR11995	ECR12005	ECR12015	ECR12025	ECR12035	ECR12045	ECR12055	ECR12065	ECR12075	ECR12085	ECR12095	ECR12105	ECR12115	ECR12125	ECR12135	ECR12145	ECR12155	ECR12165	ECR12175	ECR12185	ECR12195	ECR12205	ECR12215	ECR

# ECH

- 標準庫存      \* 僅限中國地區銷售      ⊙ 僅限台灣地區銷售
- Standard Stocks      \* Sell in China only      ⊙ Sell in Taiwan only





◆ 材質介紹→參考A04頁  
Grade Ref. Page-A04

◆ 切削條件→參考A09頁  
Cutting condition Ref. Page-A09



塗層硬質合金 Carbide Coated

金屬陶瓷 Cermet

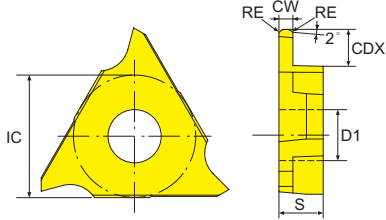
形狀 Shape	型號 Model No	刀片厚度 S±0.1	刀尖半徑 RE ±0.10	切削寬度 CW	最大加工 槽溝深度 CDX	塗層硬質合金 Carbide Coated						金屬陶瓷 Cermet							
						P		P		M	N	M35	B01606	B01706	B01806F				
						ECF200	BEF606	ECM200	ECM100	BEJ857	BEJ875					BEJ750	BEJ757		
切斷刀片 Grooving insert 	ECH200	4.59	0.2	2	17	●		●											
	ECH300	4.62	0.3	3	17	●		●											
	ECH400	4.7	0.4	4	22	●		●											
	ECH500	4.85	0.4	5	22	●		●											
切槽刀片 Grooving insert 	ECH150-OO	3.53	0.2	1.5	12						●								
	ECH200-OO-8R	4.4	0.2	2	14						●								
	ECH300-OO	4.8	0.3	3	17						●								
	ECH400-OO	4.7	0.4	4	22						●								
	ECH500-OO	4.85	0.4	5	22						●	●							
雙刃ECH 切斷刀片 Double-edge Grooving insert 	ECH200-OI	4.59	0.2	2	17						●								
	ECH250-OI	4.62	0.3	2.5	17	●													
	ECH300-OI	4.62	0.3	3	17	●					●	●						●	
	ECH300-OI-6R	4.62	0.3	3	17					●	●								
	ECH300-OI-15R	4.62	0.3	3	17						●	●							
	ECH400-OI	4.7	0.4	4	22	●				●	●	●							●
	ECH500-OI	4.85	0.4	5	22	●				●	●	●	●						
	ECH600-OI	5.1	0.8	6	22					●	●	●							
雙刃圓頭 切斷刀片 Double round edge grooving insert 	ECR300-OI	4.62	1.5	3	17						●	●							
	ECR400-OI	4.7	2	4	22						●	●							
	ECR500-OI	4.85	2.5	5	22					●	●	●							
	ECR600-OI	5.1	3	6	22					●	●	●							

EC

- 標準庫存 \* 僅限中國地區銷售
- Standard Stocks \* Sell in China only
- ◎ 僅限台灣地區銷售
- ◎ Sell in Taiwan only

◆ 材質介紹→參考A04頁  
Grade Ref. Page-A04


◆ 切削條件→參考A09頁  
Cutting condition Ref. Page-A09



塗層硬質合金  
Carbide Coated  
氮化矽  
Cermet

形狀 Shape	型號 Model No	刀尖半徑 RE	內接圓 IC	最大加工 槽溝深度 CDX	切削寬度 CW±0.05	刀片厚度 S	螺釘孔徑 D1	塗層硬質合金 Carbide Coated		氮化矽 Cermet
								P ECM120	M BEJ750	
	EC16R100-R005	0.05	9.525	2	1	3.18	4.4	●	●	●
	EC16R125-R02	0.2	9.525	2	1.25	3.18	4.4	●	●	●
	EC16R145-R02	0.2	9.525	2	1.45	3.18	4.4	●	●	
	EC16R150-R02	0.2	9.525	2	1.5	3.18	4.4	●	●	●
	EC16R175-R02	0.2	9.525	2	1.75	3.18	4.4	●	●	●
	EC16R185-R02	0.2	9.525	2.5	1.85	3.18	4.4		●	
	EC16R200-R02	0.2	9.525	2.5	2	3.18	4.4	●	●	●
	EC16R250-R02	0.2	9.525	2.5	2.5	3.18	4.4		●	
	EC16R300-R02	0.2	9.525	3	3	3.18	4.4	●	●	●
	EC22R100-R01	0.1	12.7	2	1	4.76	5.5	●	●	●
	EC22R125-R02	0.2	12.7	2	1.25	4.76	5.5	●	●	●
	EC22R130-R02	0.2	12.7	2	1.3	4.76	5.5		●	●
	EC22R140-R02	0.2	12.7	2	1.4	4.76	5.5		●	●
	EC22R145-R02	0.2	12.7	2	1.45	4.76	5.5		●	●
	EC22R150-R02	0.2	12.7	3.5	1.5	4.76	5.5	●	●	●
	EC22R175-R02	0.2	12.7	3.5	1.75	4.76	5.5	●	●	●
	EC22R185-R02	0.2	12.7	3.5	1.85	4.76	5.5		●	●
	EC22R200-R02	0.2	12.7	3.5	2	4.76	5.5	●	●	●
	EC22R230-R02	0.2	12.7	3.5	2.3	4.76	5.5	●	●	●

※ 請接下頁。 ※ Continued on next page.

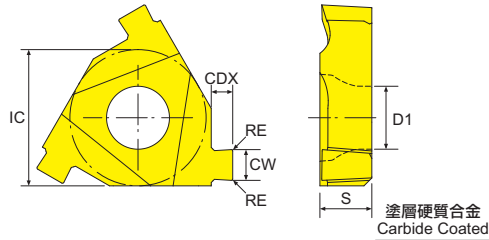
形狀 Shape	型號 Model No	刀尖半徑 RE	內接圓 IC	最大加工 槽溝深度 CDX	切削寬度 CW±0.05	刀片厚度 S	螺釘孔徑 D1	塗層硬質合金 Carbide Coated		
								Cermet		E1200
								P	M	
								ECM120	BEJ750	
	EC22R250-R03	0.3	12.7	4	2.5	4.76	5.5	●	●	●
	EC22R280-R03	0.3	12.7	4	2.8	4.76	5.5		●	●
	EC22R300-R03	0.3	12.7	4	3	4.76	5.5	●	●	●
	EC22R350-R03	0.3	12.7	5	3.5	4.76	5.5		●	●
	EC22R400-R04	0.4	12.7	5	4	4.76	5.5	●	●	●
	EC16R100R	0.5	9.525	2	1	3.18	4.4	●	●	
	EC16R150R	0.75	9.525	2	1.5	3.18	4.4	●	●	
	EC16R200R	1	9.525	2.5	2	3.18	4.4	●	●	
	EC16R300R	1.5	9.525	3	3	3.18	4.4		●	
	EC22R100R	0.5	12.7	2	1	4.76	5.5	●	●	●
	EC22R125R	0.625	12.7	2	1.25	4.76	5.5	●	●	●
	EC22R150R	0.75	12.7	3.5	1.5	4.76	5.5	●	●	●
	EC22R170R	0.85	12.7	3.5	1.7	4.76	5.5	●	●	●
	EC22R200R	1	12.7	3.5	2	4.76	5.5	●	●	●
	EC22R250R	1.25	12.7	4	2.5	4.76	5.5	●	●	●
	EC22R300R	1.5	12.7	4	3	4.76	5.5	●	●	●
	EC22R350R	1.75	12.7	5	3.5	4.76	5.5	●		●
	EC22R400R	2	12.7	5	4	4.76	5.5	●	●	●


## ER\_T / IR\_T

- 標準庫存                      \* 僅限中國地區銷售                      ◎ 僅限台灣地區銷售
- Standard Stocks                \* Sell in China only                                      ◎ Sell in Taiwan only

◆ 材質介紹→參考A04頁  
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◆ 切削條件→參考A09頁  
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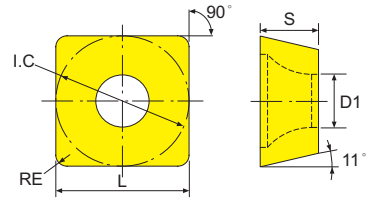


形狀 Shape	型號 Model No	刀尖半徑 RE	內接圓 IC	最大加工 槽溝深度 CDX	切削寬度 CW ±0.05	刀片厚度 S	螺釘孔徑 D1	P M	
								ECM120	
	16IR080-R01T120	0.1	9.525	1.2	0.8	3.63	4	●	
	16IR100-R01T150	0.1	9.525	1.5	1	3.63	4	●	
	16IR110-R01T150	0.1	9.525	1.5	1.1	3.63	4	●	
	16IR120-R01T180	0.1	9.525	1.8	1.2	3.63	4	●	
	16IR130-R01T180	0.1	9.525	1.8	1.3	3.63	4	●	
	16IR140-R01T200	0.1	9.525	2	1.4	3.63	4	●	
	16IR160-R01T200	0.1	9.525	2	1.6	3.63	4	●	
	16IR180-R01T200	0.1	9.525	2	1.8	3.63	4	●	
	16IR185-R01T200	0.1	9.525	2	1.85	3.63	4	●	
	16IR200-R01T200	0.1	9.525	2	2	3.63	4	●	
	16IR220-R01T200	0.1	9.525	2	2.2	3.63	4	●	
	16IR240-R01T200	0.1	9.525	2	2.4	3.63	4	●	
	16IR250-R01T200	0.1	9.525	2	2.5	3.63	4	●	



# SPMT

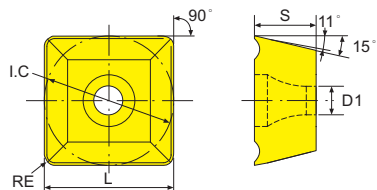
- 標準庫存      \*僅限中國地區銷售      ⊙僅限台灣地區銷售
- Standard Stocks      \*Sell in China only      ⊙Sell in Taiwan only
- ◆材質介紹→參考A04頁  
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塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	塗層硬質合金 Carbide Coated							
							P	P	M	K	N			
GO中切削 Medium 	SPMT050204-GO	0.4	5	5	2.38	2.2		●						
	SPMT060204-GO	0.4	6	6	2.38	2.6		●						
	SPMT07T308-GO	0.8	7.94	7.94	3.97	2.8		●						
	SPMT090408-GO	0.8	9.8	9.8	4.3	4.2		●						
	SPMT110408-GO	0.8	11.5	11.5	4.76	4.4		●						
	SPMT140512-GO	1.2	14.3	14.3	5.2	5.75		●						

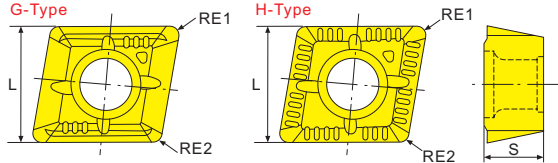
# SPGT



塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	塗層硬質合金 Carbide Coated							
							P	M	K					
RO中切削 Medium 	SPGT050204-RO	0.4	5	5	2.38	2.2		●						
	SPGT060204-RO	0.4	6	6	2.38	2.6		●						
	SPGT07T308-RO	0.8	7.94	7.94	3.97	2.8		●						
	SPGT090408-RO	0.8	9.8	9.8	4.3	4.2		●						
	SPGT110408-RO	0.8	11.5	11.5	4.76	4.4		●						
	SPGT140512-RO	1.2	14.3	14.3	5.2	5.75		●						

# WDXT



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◆材質介紹→參考A04頁  
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◆切削條件→參考A09頁  
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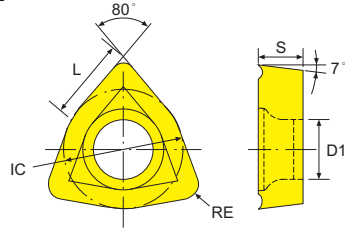
塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	刀尖半徑 RE 1	刀尖半徑 RE 2	切削刃長 L	刀片厚度 S	塗層硬質合金 Carbide Coated									
						P	M	K	M	P	M	N			
						ACP100	ACP200	ACP300	ACK300	ACK310	ACK200	ACK350	ACK330	DL1500	
G-Type 	WDXT042004-G	0.4	0.4	4.2	2			●	●						●
	WDXT042004-H	0.4	0.4	4.2	2			●	●						
	WDXT052504-G	0.4	0.4	5	2.5			●	●						●
	WDXT052504-H	0.4	0.4	5	2.5			●	●						
H-Type 	WDXT063006-G	0.6	0.6	6	3			●	●						●
	WDXT073506-G	0.6	0.6	7.5	3.5			●	●						●
	WDXT094008-G	0.8	0.8	9.6	4			●	●						●
	WDXT125012-G	1.2	1.2	12.4	5			●	●						
	WDXT156012-G	1.2	1.2	15.2	6			●	●						

# WCMX / WCMT / WCKT

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- Standard Stocks      \* Sell in China only      ⊙Sell in Taiwan only

- ◆材質介紹→參考A04頁  
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- ◆斷屑槽選擇→參考A06-A08頁  
Chipbreaker Ref. Page-A06-A08
- ◆切削條件→參考A09頁  
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塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	塗層硬質合金 Carbide Coated									
							P	P	M	K	K	M	P	P	K	N
							ECM100	EDM2020	BEJ750	ACK200	ACK300	ACZ10	ACZ30	ACZ50	HI	BSG56
	WCMX030208FN	0.8	3.8	5.56	2.38	2.8								●		
	WCMX040208FN	0.8	4.3	6.35	2.38	3.1								●		
	WCMT050308FN	0.8	5.4	7.94	3.18	3.2						●	●			
	WCMT06T308FN	0.8	6.5	9.525	3.97	3.7								●		
	WCMT080412FN	1.2	8.7	12.7	4.76	4.3								●		
	WCMX030208R	0.8	3.8	5.56	2.38	2.8			●							
	WCMX040208R	0.8	4.3	6.35	2.38	3.1			●							
	WCMX050308R	0.8	5.4	7.94	3.18	3.2			●							
	WCMX06T308R	0.8	6.5	9.525	3.97	3.7			●							
	WCMX080412R	1.2	8.7	12.7	4.76	4.3			●							
	WCMX06T308R-53	0.8	6.5	9.525	3.97	3.7	●									
	WCMX080412R-53	1.2	8.7	12.7	4.76	4.3	●									
	WCMX030208FN	0.8	3.8	5.56	2.38	2.8	●									
	WCMX040208FN	0.8	4.3	6.35	2.38	3.1	●									
	WCMX050308FN	0.8	5.4	7.94	3.18	3.2	●									
EC鋁切削 Aluminum 	WCKT030208-EC	0.8	3.8	5.56	2.38	2.8										●
	WCKT040208-EC	0.8	4.3	6.35	2.38	3.1										●
	WCKT050308-EC	0.8	5.4	7.94	3.18	3.2										●
	WCKT06T308-EC	0.8	6.5	9.525	3.97	3.7										●
	WCKT080408-EC	0.8	8.7	12.7	4.76	4.3										●

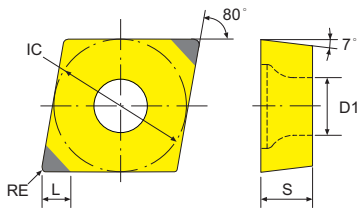
# CBN

- 標準庫存                      \* 僅限中國地區銷售                      ⊙ 僅限台灣地區銷售
- Standard Stocks            \* Sell in China only                                      ⊙ Sell in Taiwan only

◆ 材質介紹→參考A04頁  
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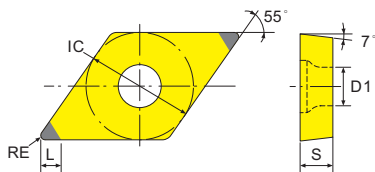
◆ 斷削槽選擇→參考A06-A08頁  
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◆ 切削條件→參考A09頁  
Cutting condition Ref. Page-A09



塗層硬質合金  
Carbide Coated

形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	CBN100
	CCGW060202-2C	0.2	2.5	6.35	2.38	2.8	●
	CCGW060204-2C	0.4	2.5	6.35	2.38	2.8	●
	CCGW09T302-2C	0.2	2.5	9.525	3.97	4.4	●
	CCGW09T304-2C	0.4	2.5	9.525	3.97	4.4	●
	CNGA120404-2C	0.4	2.5	12.7	4.76	5.16	●
	CNGA120408-2C	0.8	2.4	12.7	4.76	5.16	●
	CNGA120412-2C	1.2	2.3	12.7	4.76	5.16	●



塗層硬質合金  
Carbide Coated

形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	CBN100
	DCGW070202-2C	0.2	2.6	6.35	2.38	2.8	●
	DCGW070204-2C	0.4	2.5	6.35	2.38	2.8	●
	DCGW11T304-2C	0.4	2.5	9.525	3.97	4.4	●
	DCGW11T308-2C	0.8	2.1	9.525	3.97	4.4	●

# CBN

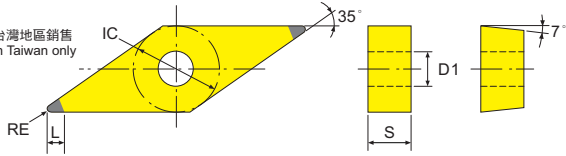
- 標準庫存      \*僅限中國地區銷售
- Standard Stocks      \*Sell in China only

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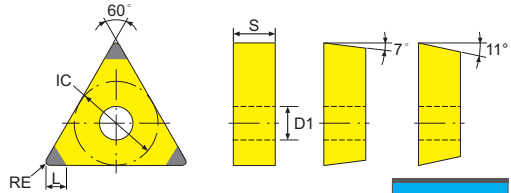
- ◆材質介紹→參考A04頁  
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- ◆斷削槽選擇→參考A06-A08頁  
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- ◆切削條件→參考A09頁  
Cutting condition Ref. Page-A09



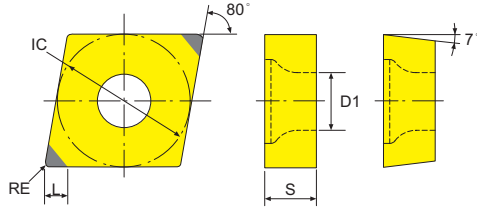
形狀 Shape	型號 Model No						D1	CBN100
		刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑		
	VCGW160404-2C	0.4	3.3	9.525	4.76	4.4	●	
	VCGW160408-2C	0.8	2.8	9.525	4.76	4.4	●	
	VNGA160404-2C	0.4	2.8	9.525	4.76	3.81	●	
	VNGA160408-2C	0.8	2.5	9.525	4.76	3.81	●	



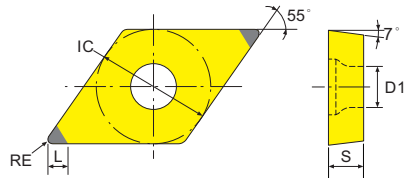
形狀 Shape	型號 Model No						D1	CBN100
		刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑		
	TBGT060104-3C	0.4	6.3	3.97	1.59	2.2	●	
	TNGA160404-3C	0.4	2.5	9.525	4.76	3.81	●	
	TNGA160408-3C	0.8	2.2	9.525	4.76	3.81	●	
	TPGW080204-3C	0.4	2.5	4.76	2.38	2.4	●	
	TPGW110304-1C	0.4	2.6	6.35	3.18	3.4	●	
	TPGW110302-3C	0.2	2.6	6.35	3.18	3.4	●	
	TPGW110304-3C	0.4	2.5	6.35	3.18	3.4	●	
	TPGW11T308-3C	0.8	2.2	6.35	3.18	3.4	●	
	TCGW090204-3C	0.4	2.5	5.56	2.38	2.5	●	
	TCGW110204-3C	0.4	2.5	6.35	2.38	3.8	●	

# PCD

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- ◆材質介紹→參考A04頁  
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形狀 Shape	型號 Model No	PCD100					PCD100
		刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	
	CCMT060202-1P	0.2	2.5	6.35	2.38	2.8	●
	CCMT060204-1P	0.4	2.5	6.35	2.38	2.8	●
	CCMT09T302-1P	0.2	2.5	9.525	3.97	4.4	
	CCMT09T304-1P	0.4	2.5	9.525	3.97	4.4	●
	CCMT09T308-1P	0.8	2.5	9.525	3.97	4.4	●
	CNMA120402-1P	0.2	2.5	12.7	4.76	5.16	
	CNMA120404-1P	0.4	2.5	12.7	4.76	5.16	●



形狀 Shape	型號 Model No	PCD100					PCD100
		刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	
	DCMT070202-1P	0.2	2.7	6.35	2.38	2.8	●
	DCMT070204-1P	0.4	2.5	6.35	2.38	2.8	●
	DCMT11T302-1P	0.2	2.7	9.525	3.97	4.4	●
	DCMT11T304-1P	0.4	2.5	9.525	3.97	4.4	●
	DCMT11T308-1P	0.8	2.5	9.525	3.97	4.4	●

# PCD

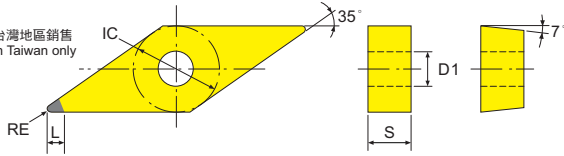
- 標準庫存      \* 僅限中國地區銷售
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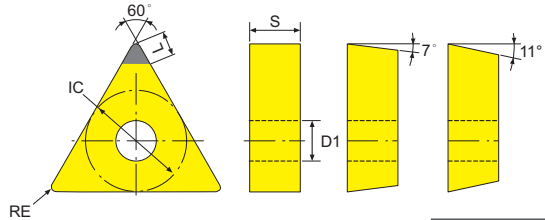
◆ 材質介紹→參考A04頁  
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◆ 斷削槽選擇→參考A06-A08頁  
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◆ 切削條件→參考A09頁  
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形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	PCD100
	VCMT160402-1P	0.2	3.3	9.525	4.76	4.4	●
	VCMT160404-1P	0.4	2.8	9.525	4.76	4.4	●
	VNGA160402-1P	0.2	3.3	9.525	4.76	3.81	
	VNGA160404-1P	0.4	2.8	9.525	4.76	3.81	



形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	PCD100
	TCMT110202-1P	0.2	2.5	6.35	2.38	2.8	●
	TCMT110204-1P	0.4	2.5	6.35	2.38	2.8	●
	TNMA160402-1P	0.2	2.4	9.525	4.76	3.81	●
	TNMA160404-1P	0.4	2.3	9.525	4.76	3.81	●
	TPMT110302-1P	0.2	2.6	6.35	3.18	3.4	●
	TPMT110304-1P	0.4	2.5	6.35	3.18	3.4	●

# 牙刀片識別系統

Threading Insert Identification System

# 16

1

1 刀片長度  
Insert Size

# E

2

2 刀片型式  
Insert Type

# R - 1.5

2

2 刀片方向  
Insert Direction

3

3 牙距  
Pitch

# ISO

4

4 牙刀標準  
Thread Standard

## 1 刀片長度 Insert Size

記號 Symbol	內接圓 IC
06	4
08	5
11	6.35
16	9.525
22	12.7
27	15.875

## 2 刀片型式 Insert Type、刀片方向 Insert Direction

外徑 External		內徑 Internal	
記號 Symbol	方向 Direction	記號 Symbol	方向 Direction
ER	右手刀片 Right Hand Insert	IR	右手刀片 Right Hand Insert
IR	左手刀片 Left Hand Insert	ER	左手刀片 Left Hand Insert

## 3 牙距 Pitch

完整資料 Full Profile	
公制 (mm)	英制 (TPI)
0.35~6.0	72.4

部份簡介 Partial Profile		
代碼 Code	公制 (mm)	英制 (TPI)
A	0.5~1.5	48~16
AG	0.5~3.0	48~8
G	1.75~3.0	14~8
N	3.5~5.0	7~5
Q	5.5~6.0	48~4

## 4 牙刀標準 Thread Standard

記號 Symbol	完整資料 Full Profile	記號 Symbol	完整資料 Full Profile
60°	公制螺紋 Partial profile 60°	UN	統一螺紋60° American UN
55°	惠式螺紋 Partial profile 55°	W	BSW：英制粗牙螺紋55° BSP：英製平行管螺紋55° Whitworth for BSW, BSP
ISO	ISO Metric	NPT	60° 錐型管螺紋 60° Taper pipe thread
ACME	29° T型牙 29° T Type thread	BSPT	55° 錐型管螺紋 55° Taper pipe thread
		TR	30° T型牙 30° T Type thread



# 牙刀片材料牌號

## Threading Carbide Grades

### EC400

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、不鏽鋼和難切削材超級合金的一般加工。  
 An advanced PVD TiAlN coated grade over a tough wear-resistant submicron substrate for general purpose machining of steel、stainless steel、super alloys.

### BEJ758

在細顆粒較韌的硬質合金上進行PVD TiAlN塗層，適用於加工鋼、硬化鋼 (HRC30-50) 和硬化鑄鐵 (HRC50-55)。  
 PVD TiAlN coated over tough submicron grade for machining steel, hardened steel (HRC30 up to HRC56) and hardened cast iron (HRC50-55).

### ECM2520

在細顆粒較韌的硬質合金上進行PVD TiAlN塗層，適用於加工鋼、硬化鋼 (HRC30-50) 和硬化鑄鐵 (HRC50-55)。  
 PVD TiAlN coated over tough submicron grade for machining steel, hardened steel (HRC30 up to HRC56) and hardened cast iron (HRC50-55).

### ECM2525

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、不鏽鋼和難切削材的一般加工。  
 An advanced PVD TiAlN coated grade over a tough wear-resistant submicron substrate for general purpose machining of steel、stainless steel、super alloys.

材質 Grade		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
塗層素鋼 Coated	EC400																								
	BEJ758																								
	ECM2520																								
	ECM2525																								

## 根據螺旋角的墊片選擇

### Selection Base On Helix Angle Shim

L	刀體類型 Holder Type	建議導程角度 Recommended Lead Angle							
		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

## 牙刀切削參數

Machine Conditions

加工件材質 Processing Material	刀片材質 & 加工條件 (Vc) Inseret Material & Processing Condition			
	ECM2520	ECM2525 / ECM2530	BEJ758	EC400
<b>P</b> 鋼 Steel	Vc : 70~140	Vc : 60~120	Vc : 70~110	Vc : 50~100
<b>M</b> 不鏽鋼 Stainless Steel	Vc : 60~120	Vc : 50~100	Vc : 40~90	Vc : 40~80
<b>K</b> 鑄鐵 Cast Iron	Vc : 70~140	Vc : 60~120	Vc : 70~110	Vc : 50~100
<b>S</b> 難削材 Machining of Difficult-to- Cut Metals	Vc : 20~60	—	—	—

# 外徑公制螺紋加工進給切深參數

O.D Metric Threads

 每次加工切深 : mm  
 Cutting Depth / Time(mm)

螺距 Pitch (mm)	總切深 Depth (mm)	加工進給次數 Processing Number Of Times															
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
0.75	0.48	0.24	0.12	0.07	0.05												
1.00	0.64	0.25	0.15	0.11	0.08	0.05											
1.25	0.80	0.25	0.15	0.12	0.09	0.08	0.06	0.05									
1.50	0.92	0.28	0.15	0.12	0.10	0.09	0.07	0.06	0.05								
1.75	1.10	0.28	0.15	0.12	0.10	0.10	0.09	0.08	0.07	0.06	0.05						
2.00	1.26	0.30	0.16	0.13	0.10	0.09	0.09	0.08	0.07	0.07	0.06	0.06	0.05				
2.50	1.57	0.38	0.19	0.15	0.10	0.10	0.09	0.09	0.08	0.08	0.07	0.07	0.06	0.06	0.05		
3.00	1.87	0.40	0.22	0.15	0.13	0.12	0.10	0.10	0.09	0.09	0.08	0.08	0.07	0.07	0.06	0.06	0.05

# 內徑英制螺紋加工進給切深參數

I.D Inch Diameter Threads

 每次加工切深 : mm  
 Cutting Depth / Time(mm)

螺距 Pitch (inch)	總切深 Depth (mm)	加工進給次數 Processing Number Of Times															
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
8	2.00	0.40	0.25	0.19	0.16	0.14	0.12	0.11	0.10	0.09	0.08	0.07	0.07	0.06	0.06	0.05	0.05
9	1.78	0.38	0.20	0.13	0.12	0.11	0.10	0.10	0.09	0.09	0.08	0.08	0.07	0.07	0.06	0.05	0.05
10	1.60	0.38	0.20	0.15	0.12	0.10	0.09	0.09	0.08	0.08	0.07	0.07	0.06	0.06	0.05		
11	1.46	0.30	0.18	0.13	0.12	0.11	0.10	0.08	0.08	0.07	0.07	0.06	0.06	0.05	0.05		
12	1.34	0.30	0.18	0.13	0.12	0.11	0.10	0.09	0.08	0.07	0.06	0.05	0.05				
13	1.23	0.30	0.18	0.13	0.10	0.08	0.08	0.07	0.07	0.06	0.06	0.05	0.05				
14	1.15	0.28	0.15	0.12	0.10	0.10	0.09	0.08	0.07	0.06	0.05	0.05					
16	1.00	0.28	0.15	0.10	0.09	0.08	0.07	0.07	0.06	0.05	0.05						
18	0.89	0.26	0.15	0.12	0.10	0.08	0.07	0.06	0.05								
20	0.80	0.26	0.15	0.10	0.09	0.08	0.07	0.05									
24	0.67	0.25	0.19	0.12	0.06	0.05											
28	0.57	0.25	0.17	0.10	0.05												
32	0.50	0.24	0.14	0.07	0.05												

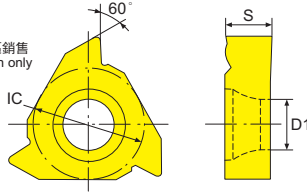
# ER / IR

- 標準庫存      \* 僅限中國地區銷售      ◎ 僅限台灣地區銷售
- Standard Stocks      \* Sell in China only      ◎ Sell in Taiwan only

- 另有其他規格，歡迎來電洽詢！
- We could provide inserts for other specifications, please contact us!


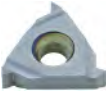
◆ 材質介紹→參考A04頁  
Grade Ref. Page-A04

◆ 切削條件→參考A09頁  
Cutting condition Ref. Page-A09



塗層硬質合金  
Carbide Coated

P		M	
EC400	BEJ758	ECM2520	ECM2525

形狀 Shape	型號 Model No	螺距(公制)	螺距(英制)	內接圓	刀片厚度	螺釘孔徑					
		Pitch(mm)	Pitch(inch)	IC	S	D1	EC400	BEJ758	ECM2520	ECM2525	
	06IR-0.5-ISO	0.5	—	4	1.85	2.32	●				
	06IR-0.75-ISO	0.75	—	4	1.85	2.32	●				
	06IR-1.0-ISO	1	—	4	1.85	2.32	●				
	06IR-27NPT	—	27	4	1.85	2.32	●				
	06IR-19W	—	19	4	1.85	2.32	●				
	06IR-28W	—	28	4	1.85	2.32	●				
	06IR-A55	0.5-1.25	—	4	1.85	2.32	●				
	06IR-A60	0.5-1.25	—	4	1.85	2.32	●				
	08IR-0.5-ISO	0.5	—	5	2.24	2.57	●				
	08IR-1.0-ISO	1	—	5	2.24	2.57	●				
08IR-1.5-ISO	1.5	—	5	2.24	2.57	●					
08IR-A60	0.5-1.5	—	5	2.24	2.57	●					
08IR-A55	0.5-1.5	—	5	2.24	2.57	●					
	11ER/IR-0.5-ISO	0.5	—	6.35	3.05	2.8	●				
	11ER/IR-0.75-ISO	0.75	—	6.35	3.05	2.8	●	●			
	11ER/IR-1.0-ISO	1	—	6.35	3.05	2.8	●	●	●	●	
	11ER/IR-1.25-ISO	1.25	—	6.35	3.05	2.8	●	●		●	
	11ER/IR-1.5-ISO	1.5	—	6.35	3.05	2.8	●	●		●	
	11IR-1.75-ISO	1.75	—	6.35	3.05	2.8	●		●	●	
	11IR-2.0-ISO	2	—	6.35	3.05	2.8	●	●			
	11IR-14BSPT	—	14	6.35	3.05	2.8	●	●			
	11IR-14NPT	—	14	6.35	3.05	2.8	●				
	11IR-14UN	—	14	6.35	3.05	2.8	●				
	11IR-16UN	—	16	6.35	3.05	2.8	●				
	11ER/IR-18UN	—	18	6.35	3.05	2.8	●				
	11ER/IR-14W	—	14	6.35	3.05	2.8	●	●			●
11ER/IR-19W	—	19	6.35	3.05	2.8	●					

※ 請接下頁。      ※ Continued on next page.

塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	螺距(公制) Pitch(mm)	螺距(英制) Pitch(inch)	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	P				M				
							EC400	BE1/58	ECM2520	ECM2525	ECM2520	ECM2525	ECM2520	ECM2525	
	11ER-28W	—	28	6.35	3.05	2.8	●								
	11ER/IR-A55	0.5-1.5	—	6.35	3.05	2.8	●								
	11ER/IR-A60	0.5-1.5	—	6.35	3.05	2.8	●	●							
	16ER/IR-12UN	—	12	9.525	3.52	4.4	●								
	16ER/IR-0.35-ISO	0.35	—	9.525	3.52	4.4	●								
	16ER/IR-0.4-ISO	0.4	—	9.525	3.52	4.4	●								
	16IR-0.45-ISO	0.45	—	9.525	3.52	4.4	●								
	16ER/IR-0.5-ISO	0.5	—	9.525	3.52	4.4	●								
	16ER-0.6-ISO	0.6	—	9.525	3.52	4.4	●								
	16ER/IR-0.7-ISO	0.7	—	9.525	3.52	4.4	●								
	16ER/IR-0.75-ISO	0.75	—	9.525	3.52	4.4	●								
	16ER/IR-0.8-ISO	0.8	—	9.525	3.52	4.4	●								
	16ER/IR-1.0-ISO	1	—	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER/IR-1.25-ISO	1.25	—	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER/IR-1.5-ISO	1.5	—	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER/IR-1.75-ISO	1.75	—	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER/IR-2.0-ISO	2	—	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER/IR-2.5-ISO	2.5	—	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER/IR-3.0-ISO	3	—	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16IR-8ACME	—	8	9.525	3.52	4.4	●								
	16ER-12ACME	—	12	9.525	3.52	4.4	●								
	16ER/IR-11BSPT	—	11	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER/IR-14BSPT	—	14	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER/IR-19BSPT	—	19	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER-28BSPT	—	28	9.525	3.52	4.4	●								
	16IR-8NPT	—	8	9.525	3.52	4.4	●	●							
	16ER/IR-11.5NPT	—	11.5	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER/IR-14NPT	—	14	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●
	16ER/IR-14NPT-(0.2R)	—	14	9.525	3.52	4.4	●								
	16ER/IR-18NPT	—	18	9.525	3.52	4.4	●	●	●	●	●	●	●	●	●

※ 請接下頁。 ※ Continued on next page.

塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	螺距(公制) Pitch(mm)	螺距(英制) Pitch(inch)	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	塗層硬質合金 Carbide Coated			
							P	M		
							EC400	BEJ758	ECM2520	ECM2525
	16ER/IR-8UN	—	8	9.525	3.52	4.4	●	●		
	16ER-10UN	—	10	9.525	3.52	4.4	●	●		
	16IR-11UN	—	11	9.525	3.52	4.4	●		●	●
	16ER-12WN	—	12	9.525	3.52	4.4				
	16ER/IR-14UN	—	14	9.525	3.52	4.4	●	●	●	
	16ER/IR-16UN	—	16	9.525	3.52	4.4	●	●	●	●
	16ER/IR-18UN	—	18	9.525	3.52	4.4	●	●	●	
	16ER/IR-20UN	—	20	9.525	3.52	4.4	●	●	●	●
	16ER/IR-24UN	—	24	9.525	3.52	4.4	●			
	16ER-28UN	—	28	9.525	3.52	4.4	●			
	16ER/IR-8W	—	8	9.525	3.52	4.4	●	●	●	●
	16ER-10W	—	10	9.525	3.52	4.4	●	●		
	16ER/IR-11W	—	11	9.525	3.52	4.4		●	●	●
	16ER/IR-12W	—	12	9.525	3.52	4.4	●	●		
	16ER/IR-14W	—	14	9.525	3.52	4.4	●	●	●	●
	16ER/IR-16W	—	16	9.525	3.52	4.4	●	●		
	16ER/IR-18W	—	18	9.525	3.52	4.4	●	●		
	16ER/IR-19W	—	19	9.525	3.52	4.4	●	●	●	●
	16ER/IR-A60	0.5-1.5	—	9.525	3.52	4.4	●	●		●
	16ER/IR-A55	0.5-1.5	—	9.525	3.52	4.4	●	●		●
	16ER/IR-AG55	0.5-3	—	9.525	3.52	4.4	●	●	●	●
	16ER/IR-AG60	0.5-3	—	9.525	3.52	4.4	●	●	●	●
	16ER/IR-G55	1.75-3	—	9.525	3.52	4.4	●	●	●	●
	16ER/IR-G60	1.75-3	—	9.525	3.52	4.4	●	●	●	●
	22ER-3.5-ISO	3.5	—	12.7	4.65	5.5	●			
	22ER/IR-4.0TR	—	4	12.7	4.65	5.5	●			
	22ER-4.5-ISO	4.5	—	12.7	4.65	5.5	●			
	22IR-5.0-ISO	5	—	12.7	4.65	5.5	●			
	22IR-7UN	—	7	12.7	4.65	5.5	●			
	22ER/IR-N55	3.5-5	—	12.7	4.65	5.5	●			
	22ER/IR-N60	3.5-5	—	12.7	4.65	5.5	●			

