

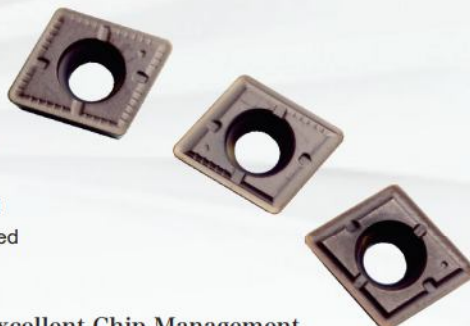
WDXT 系列

WDXT series Characteristics and Applications

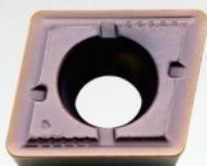
■ 受力均衡設計 Design Feature

加工時的切屑阻力通過中心刃和外周刃均衡分布，而且使相互的位置系統最佳化，可進行穩定的孔加工。

Cutting resistance during machining is balanced between central and peripheral inserts, and the relative position of each insert are potimised to provide stable drilling.



■ 優異的切屑處理 Excellent Chip Management



在切屑槽中央部份形成「切屑控制溝槽」，可有效控制切屑流出方向，按不同用途分開使用三個種類的斷屑槽，在各種各樣的被削材和加工條件下，明顯減少了切屑產生的問題。

A "chip control groove" in the centre of the breaker allows the direction of chip evacuation to be controlled.

Three separate purpose-designed breakers drastically reduce chip troubles with a variety of different work materials in a variety of different conditions.



L型

低速進給、切屑處理用。
Low Feed / Chip Management



G型

通用。
General Purpose



H型

刀尖強化型。
Strong Edge Type

■ 使用四個刀尖，降低成本

Economical, Four-Cornered Insert

中心刃、外周刃兼用刀片的设计，可使用內刃二個刀尖、外刃二個刀尖，共四個刀尖。 Inserts can be used in either central or peripheral positions, with two corners for each position- a total of four corners.



中心部刀片
Central Insert



外週部刀片
Peripheral Insert

■ 實現加工的多樣性

Versatile Tool for a Variety of a Machining Applications

刀體進行了特殊硬化表面處理，提高了耐久性，在擴孔、外徑車削、內徑擴孔等多種用途中可長時間穩定使用。

A special hard surface treatment gives added durability, allowing stable, long-term drilling in a variety of applications including hole widening, spot facing, external turning, and internal boring.



■ 採用新材質ACP300 / ACK300實現長壽命

New ACP300 / ACK300 Grades Extend Tool Life

材質推薦切屑表

Recommended Cutting Condition

被削材 Workpiece		刃徑 Diameter 12-22mm		
		V(2D / 3D)	V(4D)	f
P 鋼 Steel	軟鋼 Mild Steel (SS400)	100- 150 -200	100- 140 -200	0.05- 0.08 -0.10
	碳素鋼 Carbon Alloy Steel(S45C)	80- 120 -160	60- 80 -120	0.06- 0.11 -0.18
	合金鋼 Alloy Steel(SCM400)	80- 120 -160	80- 100 -100	0.06- 0.11 -0.17
M 不鏽鋼 Stainless Steel	不鏽鋼 Stainless Steel(SUS304)	90- 120 -150	80- 110 -140	0.06- 0.11 -0.18
K 鑄鐵 Cast	鑄鐵 Cast Iron(FC250)	90- 120 -150	110- 140 -160	0.09- 0.20 -0.32

●(V=m/min, f=mm/刀) (下限值-推薦-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(ft)×工具刃數(Z)×工具回轉速度(N)]

→使用快速鑽頭儘量由高壓中心出水，以增加刀片壽命及排屑良好。
Draining hi-pressure coolant thru spindle center while using the high speed drill will help extending inserts life and improving chip evacuation.

→使用在CNC車床時，刀具中心點及機械主軸中心儘量平行。
While using CNC lathe, the cutting center point must parallel the spindle center of the machine.

→CNC車床使用如須擴孔，刀片外刃必須和刀塔移動角度平行。
Hole widening by CNC lathe, the peripheral insert must parallel the moving angle tool turret.

WDXT

●標準庫存

●Standard Stocks

◎僅限台灣地區銷售

◎Sell in Taiwan only

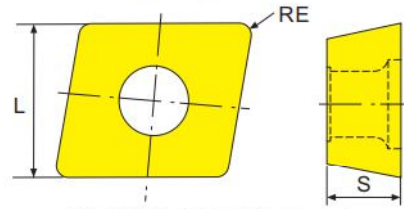
*僅限中國地區銷售

*Sell in China 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

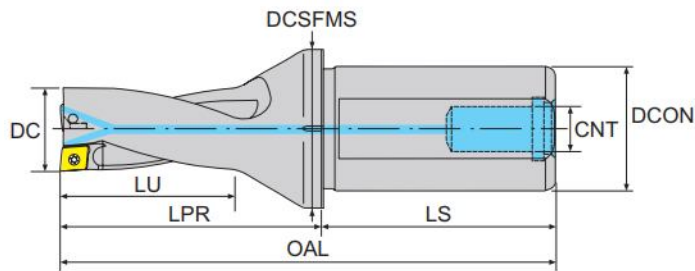
◆切削條件→參考A09頁
Cutting condition Ref. Page-A09



塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長度 L	刀片厚度 S	塗層硬質合金 Carbide Coated								
					P	M	K	M	P	M	K	N	
					ACP100	ACP200	ACP300	ACK300	ACK200	ACZ350	ACZ330	DL1500	
	WDXT042004-G	0.4	4.2	2			●	●					●
	WDXT042004-H	0.4	4.2	2			●	●					
	WDXT052504-G	0.4	5	2.5			●	●					●
	WDXT052504-H	0.4	5	2.5			●	●					
	WDXT063006-G	0.6	6	3			●	●					●
	WDXT073506-G	0.6	7.5	3.5			●	●					●
	WDXT094008-G	0.8	9.6	4			●	●					●
	WDXT125012-G	1.2	12.4	5			●	●					
	WDXT156012-G	1.2	15.2	6			●	●					

EDX2D



新規格上市
New Specification Arrival

寸法 Dimension(mm)

產品型號 Model No	在庫 Stock	寸法 Dimension(mm)											價格 Price
		切削直徑 DC	工作懸伸長度 LPR	柄部直徑 DCON	可使用長度 LU	刀柄長度 LS	全長 OAL	接觸面直徑 DCS FMS	冷卻液入口螺紋尺寸 CNT	刀片 Insert	螺絲 Screw	旗型板手 Wrench	
13EDX-2D-25	●	13	42	25	26	56	98	32	PT 1/4-19	WD□□ 042004	CS18	T-6	
13.5EDX-2D-25	●	13.5	43	25	27	56	99	32	PT 1/4-19				
14EDX-2D-25	●	14	44	25	28	56	100	32	PT 1/4-19				
14.5EDX-2D-25	●	14.5	45	25	29	56	101	32	PT 1/4-19				
15EDX-2D-25	●	15	46	25	30	56	102	32	PT 1/4-19				
15.5EDX-2D-25	●	15.5	47	25	31	56	103	32	PT 1/4-19	WD□□ 052504	CS20	T-6	
16EDX-2D-25	●	16	48	25	32	56	104	32	PT 1/4-19				
16.5EDX-2D-25	●	16.5	49	25	33	56	105	32	PT 1/4-19				
17EDX-2D-25	●	17	50	25	34	56	106	32	PT 1/4-19				
17.5EDX-2D-25		17.5	53	25	35	56	109	32	PT 1/4-19				
18EDX-2D-25	●	18	54	25	36	56	110	32	PT 1/4-19	WD□□ 063006	CS22	T-7	
19EDX-2D-25		19	56	25	38	56	112	32	PT 1/4-19				
NEW 20EDX-2D-32	●	20	59	32	40	60	119	41	PT 1/4-19				
NEW 21EDX-2D-32	●	21	61	32	42	60	121	41	PT 1/4-19				
NEW 22EDX-2D-32	●	22	63	32	44	60	123	41	PT 1/4-19				
22.5EDX-2D-32	●	22.5	64	32	45	60	124	41	PT 1/4-19	WD□□ 073506	CS25	T-8	
NEW 23EDX-2D-32	●	23	68	32	46	60	128	41	PT 1/4-19				
NEW 24EDX-2D-32	●	24	70	32	48	60	130	41	PT 1/4-19				
NEW 25EDX-2D-32	●	25	72	32	50	60	132	41	PT 1/4-19				