

多功能單牙鑽銑牙刀

MULTIPURPOSE THREADING MILLS

- 鑽、倒角、螺紋讓您一次完成!

Completing once for drilling, threading and chamfering.

- 提供ISO螺紋M0.8~M10.0

ISO Thread for M0.8~M10.0

- 讓您省掉繁雜的換刀時間!

Saving time of switching tools.

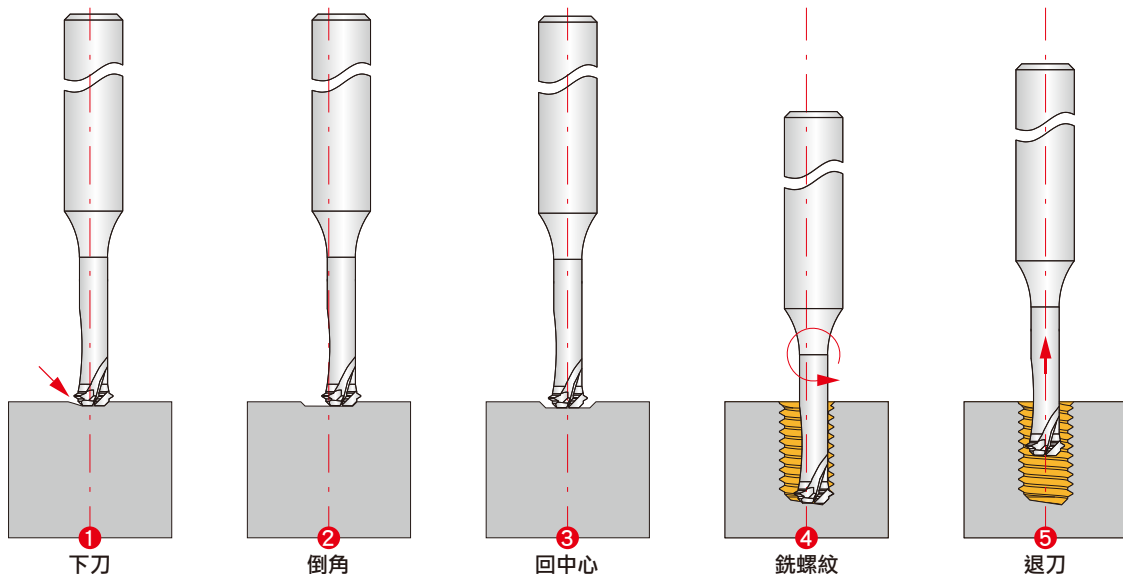
- 高效率 · 高精度!

Precise · Efficiency.

M0.8 - 10.0



加工方式：



切削實例

Size / 尺寸規格表

MSHIA & MSHIDA 鎢鋼多功能單牙鑽銑牙刀

螺紋 Thread	螺距 Pitch	d1	L2	L	D	倒角 Chamfer	牙數 Teeth	刃數 Flute	鋁用訂購編號 Coated Order No.	鋼用訂購編號 Uncoated Order No.
M0.8	0.20	0.60	2.4	50	4	0.10	1	1	MSHIA100604-020	MSHIDA100604-020A
M0.9	0.225	0.66	2.7	50	4	0.12	1	1	MSHIA100604-022	MSHIDA100604-022A
M1.0	0.25	0.73	3.0	50	4	0.15	1	1	MSHIA100704-025	MSHIDA100704-025A
M1.2	0.25	0.92	3.6	50	4	0.15	1	1	MSHIA100904-025	MSHIDA100904-025A
M1.4	0.30	1.05	4.2	50	4	0.19	1	1	MSHIA101004-030	MSHIDA101004-030A
M1.6	0.35	1.21	4.8	50	4	0.22	1	1	MSHIA101204-035	MSHIDA101204-035A
M2.0	0.40	1.55	6.0	50	4	0.25	1	2	MSHIA201504-040	MSHIDA201504-040A
M2.5	0.45	2.00	7.5	50	4	0.29	1	2	MSHIA202004-045	MSHIDA202004-045A
M3.0	0.50	2.44	9.0	60	6	0.33	1	2	MSHIA202406-050	MSHIDA202406-050A
M4.0	0.70	3.20	12.0	60	6	0.45	1	2	MSHIA203206-070	MSHIDA203206-070A
M5.0	0.80	4.00	15.0	60	6	0.53	1	2	MSHIA204006-080	MSHIDA204006-080A
M6.0	1.00	4.85	18.0	75	6	0.65	2	3	MSHIA304806-100	MSHIDA304806-100A
M8.0	1.25	6.50	24.0	75	8	0.80	2	3	MSHIA306508-125	MSHIDA306508-125A
M10.0	1.50	7.90	30.0	75	8	1.00	2	3	MSHIA307908-150	MSHIDA307908-150A

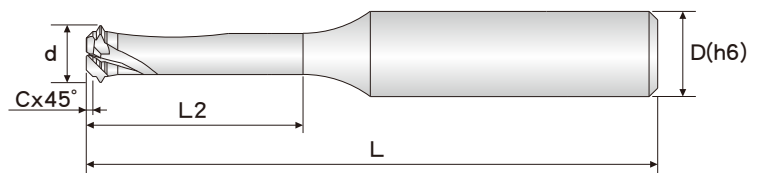


Table / 切削條件表

CMTéc

材質 Material Group	加工材質 Material	硬度 Hardness	MSHIA		MSHIDA		
			切削速度 Vc (m/min)	每刃進給量 fz (mm)	切削速度 Vc (m/min)	每刃進給量 fz (mm)	
P	碳素鋼 Carbon Steels	S35C,S45C,S50C	HRC<20	-	-	65~200	0.008~0.01
	合金鋼 Alloy Steels	SCM,SKT,SKD	HRC20~30	-	-	65~185	0.005~0.008
	合金鋼 Alloy Steels	SCM,SKT,SKD	HRC30~45	-	-	65~160	0.004~0.005
M	不銹鋼 Stainless Steels	SUS304	HRC<30	-	-	50~100	0.004~0.008
K	鑄鐵 Cast Iron	FC,FCD	HRC<30	-	-	40~110	0.004~0.008
N	鋁合金 Aluminum Alloys	Al 5052 / 6061 / 7075	-	60~120	0.007~0.08	-	-

※ 刀具「切入進給量」建議採取低於「螺紋切削時進給量」60%。
 ※ At tools entry, set the Feed (mm) to 60% lower than the threading Feed.

- 當加工聲音尖銳時，請調降主軸轉速(S) (10~40%)。When the sound is piercing, please lower the spindle speed(S) (10~40%).
- 當機台震動太大時，請調降進給速度(F) (10~40%)。When the machine is vibrating, please decrease the feed rate(F) (10~40%).
- 當主軸負載太大時，請調降進給速度(F) (10~40%)。When the spindle load is high, please decrease the feed rate(F) (10~40%).
- 以上數據為建議值，適當的條件仍需視機台狀況，夾治具品質，潤滑冷卻系統...等而改變。
 These are recommended values which depend on the condition of the machine, fixture, lubricating & cooling systems... etc. They may have to be adapted.

