



K

快速鑽頭
Rapid Drill

快速鑽頭識別系統 Rapid Drill Identification System K02

S P G X 系列 SPGX Series

SPGX2D K07—K08

SPGX3D K09—K10

SPGX4D K11

E D X 系列 EDX Series

EDX2D K15

EDX3D K16

EDX4D K17

W C M X 系列 WCMX Series

WCMX2D K21

WCMX3D K22—K23

WCMX4D K24

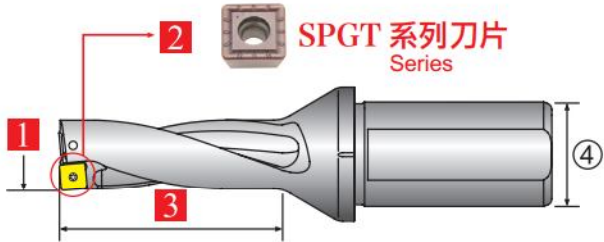
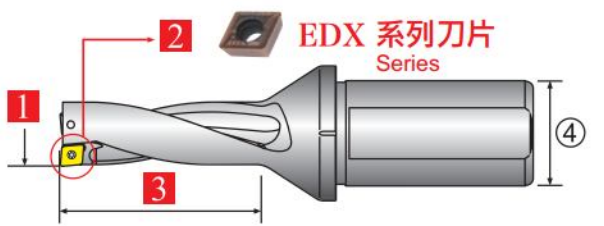
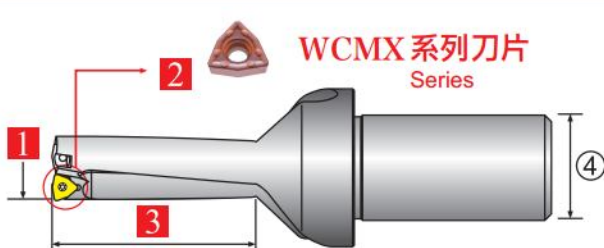
快速鑽頭識別系統

Rapid Drill Identification System

12.5 SPGX - 3D - 25

1	2	3	4
加工直徑 (Ø12.5mm)	快鑽系列 Rapid drill series	加工深度 Maximum depth	刀柄直徑 Shank diameter

2 刀片型號 Insert model No

快鑽系列 Rapid Drill Series	SPGX 系列 SPGX series 圖示 fig1
	EDX 系列 EDX series 圖示 fig2
	WCMX 系列 WCMX series 圖示 fig3
fig1. SPGX系列 / SPGX series	
 SPGT 系列刀片 Series	
fig2. EDX系列 / EDX series	
 EDX 系列刀片 Series	
fig3. WCMX系列 / WCMX series	
 WCMX 系列刀片 Series	

3 加工深度 Maximum depth

記號 Sign	註解 (mm) Description
2D	2X加工直徑 2XDimension
3D	3X加工直徑 3XDimension
4D	4X加工直徑 4XDimension

4 刀柄直徑 Shank diameter

柄 徑 (mm) Shank diameter
Ø 25
Ø 32
Ø 40

SPGX 系列

SPGX series

設計特色 Tool Design Feature



刀片特色 Insert Feature



超細TiAlN基納米塗層，添加耐磨和耐高溫的稀有元素，綜合性能顯著提升。
TiAlN coating with high temperature resistant elements.

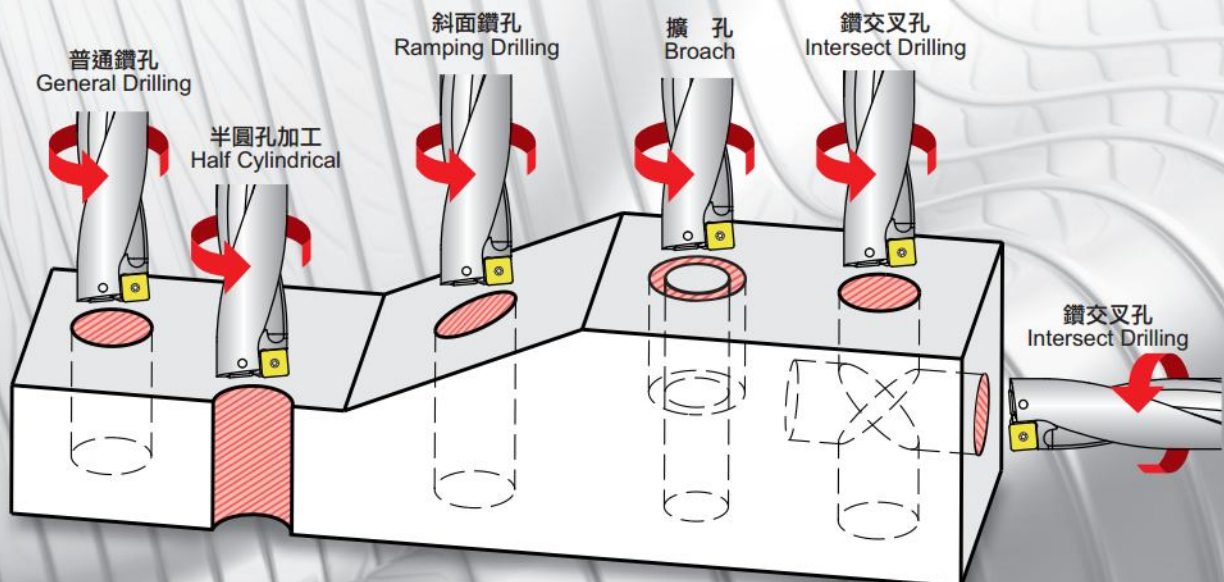
特殊的塗層處理技術，塗層和基體結合更牢固。
Treatment technology of special coating, the coating is more firmly bonded to the substrate

薄的PVD塗層，刃口鋒利。
Thin PVD coating make cutting edge sharp.

細晶體的碳化鎢基硬質合金，具有高的硬度和較強的韌性。
High hardness and high toughness.

塗層後特殊的表面處理技術，去除有害應力的同時提高了表面光潔度。
High surface finishing.

鑽孔功能示意 Application



材質推薦切屑表

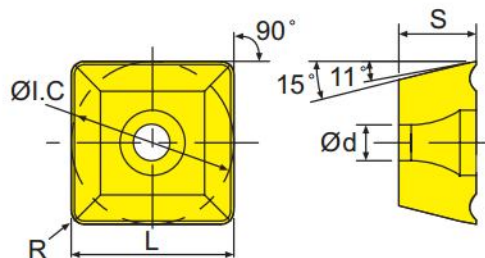
Recommended Cutting Condition

被削材 Workpiece		VC切削速度 VC Cuting Speed	加工直徑及進給量 Feed(aspect ratio=3D)(m/rev)depending on drill Dia.				
		(m/min)	12-16mm	17-23mm	24-29mm	30-42mm	43-60mm
P 鋼 Steel	合金鋼 碳素鋼 Alloy Steel vs Carbon Steel	50-100-150	0.04~0.08	0.04~0.08	0.04~0.08	0.04~0.08	0.04~0.08
			0.04~0.10	0.04~0.12	0.05~0.16	0.08~0.18	0.10~0.22
		50-100-160		0.04~0.10	0.04~0.12	0.04~0.14	0.04~0.14
			0.06~0.12	0.06~0.14	0.06~0.14	0.06~0.16	0.06~0.16
		30-70-120	0.04~0.10	0.06~0.12	0.08~0.16	0.08~0.18	0.08~0.22
			0.04~0.18	0.06~0.12	0.08~0.18	0.08~0.18	0.08~0.22
			0.04~0.12	0.06~0.14	0.08~0.17	0.08~0.17	0.08~0.20
		M 不鏽鋼 Stainless steel	40-90-150	0.04~0.10	0.04~0.12	0.04~0.12	0.04~0.12
0.06~0.14	0.06~0.16					0.06~0.20	
60-100-160	0.04~0.10		0.04~0.12	0.04~0.12	0.04~0.12	0.04~0.12	
				0.06~0.14	0.06~0.14	0.06~0.14	
K 鑄鐵 Cast	80-100-150	0.04~0.10	0.05~0.14	0.06~0.18	0.10~0.22	0.10~0.26	
			0.04~0.12	0.04~0.14	0.05~0.16	0.05~0.18	

SPGT

- 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

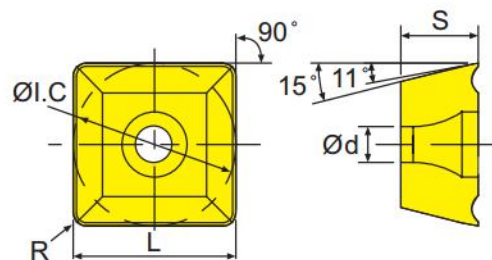


塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	半徑 R	切刃長 L	內切圓 I.C	厚度 S	孔徑 d	P M K							
							P				M			
							ECM100	ECM200	BE4875	BEJ706	BEJ750	BEJ757	BEJ758	ECK100
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								
RO中切削 Medium	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								

SPMT

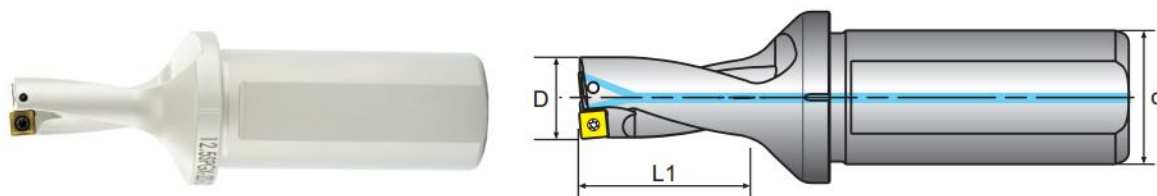
- 標準庫存 * 僅限中國地區銷售 ◎僅限台灣地區銷售
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Chipbreaker Ref.Page-A06-A08
- ◆切削條件→參考A09頁
Cutting condition Ref.Page-A09



塗層硬質合金 Carbide Coated

							P		P		M		K		N
							DF133	DF233	DF333	ECM200	BEJ750	BEP706	ECK200	BEG607	BEJ757
形狀 Shape	型號 Model No	半徑 R	切刃長 L	內切圓I.C	厚度 S	孔徑 d									
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				●					

SPGX2D 新規格上市
New Specification Arrival



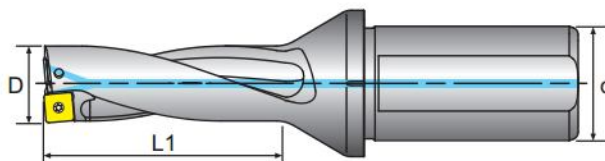
產品型號 Model No	在庫 Stock	寸法 Dimension(mm)			刀片 Insert	螺絲 Screw	旗型板手 Wrench	價格 Price
		D	L1 (Dx2)	d				
12.5SPGX-2D-25	●	12.5	25	25	SP□□0502	CS20	T-6	
13SPGX-2D-25	●	13	26	25				
13.5SPGX-2D-25	●	13.5	27	25				
14SPGX-2D-25	●	14	28	25				
14.5SPGX-2D-25	●	14.5	29	25				
15SPGX-2D-25	●	15	30	25				
15.5SPGX-2D-25	●	15.5	31	25				
16SPGX-2D-25	●	16	32	25	SP□□0602	CS22	T-7	
16.5SPGX-2D-25		16.5	33	25				
17SPGX-2D-25		17	34	25				
17.5SPGX-2D-25		17.5	35	25				
18SPGX-2D-25		18	36	25				
18.5SPGX-2D-25	●	18.5	37	25				
19SPGX-2D-25	●	19	38	25				
NEW 19.5SPGX-2D-25		19.5	39	25	SP□□07T3	CS25	T-8	
20SPGX-2D-32	●	20	40	32				
21SPGX-2D-32		21	42	32				
22SPGX-2D-32		22	44	32				
23SPGX-2D-32		23	46	32				
24SPGX-2D-32		24	48	32				
25SPGX-2D-32		25	50	32				
26SPGX-2D-32		26	52	32				

※ 請接下頁。 ※ Continued on next page.

產品型號 Model No	在庫 Stock	寸法 Dimension(mm)			刀片 Insert 	螺絲 Screw 	旗型板手 Wrench 	價格 Price
		D	L1 (Dx2)	d				
27SPGX-2D-32		27	54	32	SP□□0904	CS35	T-15	
28SPGX-2D-32	●	28	56	32				
29SPGX-2D-32		29	58	32				
30SPGX-2D-32	●	30	60	32				
31SPGX-2D-32		31	62	32				
NEW 31.5SPGX-2D-32		31.5	63	32				
32SPGX-2D-32		32	64	32				
33SPGX-2D-32		33	66	32				
34SPGX-2D-32		34	68	32	SP□□1104	CS40	T-15	
35SPGX-2D-32		35	70	32				
36SPGX-2D-32		36	72	32				
37SPGX-2D-32		37	74	32				
38SPGX-2D-32		38	76	32				
39SPGX-2D-32		39	78	32				
40SPGX-2D-32		40	80	32				
41SPGX-2D-32		41	82	32				
42SPGX-2D-32		42	84	32	SP□□1405	CS45	T-15	
43SPGX-2D-40		43	86	40				
44SPGX-2D-40		44	88	40				
45SPGX-2D-40		45	90	40				
46SPGX-2D-40		46	92	40				
47SPGX-2D-40		47	94	40				
48SPGX-2D-40		48	96	40				
49SPGX-2D-40		49	98	40				
50SPGX-2D-40		50	100	40				

●刀片資料：SP□□0502□□、SP□□0602□□、SP□□07T3□□、SP□□0904□□、SP□□1104□□、SP□□1405□□
 →參考A44、F12~F13、K05~06頁

●Insert Detail：SP□□0502□□、SP□□0602□□、SP□□07T3□□、SP□□0904□□、SP□□1104□□、
 SP□□1405□□→Ref.Page-A44、F12~F13、K05~06

SPGX3D 新規格上市
 New Specification Arrival


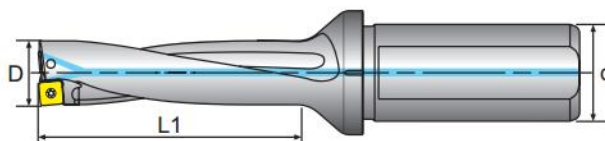
產品型號 Model No	在庫 Stock	寸法 Dimension(mm)			刀片 Insert	螺絲 Screw	旗型板手 Wrench	價格 Price
		D	L1 (Dx3)	d				
12.5SPGX-3D-25	●	12.5	37.5	25	SP□□0502	CS20	T-6	
13SPGX-3D-25	●	13	39	25				
13.5SPGX-3D-25		13.5	40.5	25				
14SPGX-3D-25	●	14	42	25				
14.5SPGX-3D-25		14.5	43.5	25				
15SPGX-3D-25	●	15	45	25				
15.5SPGX-3D-25	●	15.5	46.5	25	SP□□0602	CS22	T-7	
16SPGX-3D-25	●	16	48	25				
16.5SPGX-3D-25	●	16.5	49.5	25				
17SPGX-3D-25	●	17	51	25				
17.5SPGX-3D-25	●	17.5	52.5	25				
18SPGX-3D-25	●	18	54	25				
19SPGX-3D-25	●	19	57	25				
NEW 19.5SPGX-3D-25		19.5	58.5	25	SP□□07T3	CS25	T-8	
20SPGX-3D-32	●	20	60	32				
21SPGX-3D-32	●	21	63	32				
22SPGX-3D-32	●	22	66	32				
NEW 22.5SPGX-3D-32		22.5	67.5	32				
23SPGX-3D-32	●	23	69	32				
24SPGX-3D-32	●	24	72	32	SP□□07T3	CS25	T-8	
25SPGX-3D-32	●	25	75	32				
26SPGX-3D-32	●	26	78	32				
27SPGX-3D-32	●	27	81	32				

※ 請接下頁。 ※ Continued on next page.

寸法 Dimension(mm)								價格 Price
產品型號 Model No	在庫 Stock	D	L1 (Dx3)	d				
28SPGX-3D-32	●	28	84	32	SP□□0904	CS35	T-15	
29SPGX-3D-32	●	29	87	32				
30SPGX-3D-32	●	30	90	32				
31SPGX-3D-32	●	31	93	32				
32SPGX-3D-32	●	32	96	32				
33SPGX-3D-32	●	33	99	32				
34SPGX-3D-32	●	34	102	32	SP□□1104	CS40	T-15	
35SPGX-3D-32	●	35	105	32				
36SPGX-3D-32	●	36	108	32				
37SPGX-3D-32	●	37	111	32				
38SPGX-3D-32	●	38	114	32				
39SPGX-3D-32	●	39	117	32				
40SPGX-3D-32	●	40	120	32				
41SPGX-3D-32	●	41	123	32				
42SPGX-3D-32	●	42	126	32	SP□□1405	CS45		
43SPGX-3D-40	●	43	129	40				
44SPGX-3D-40		44	132	40				
45SPGX-3D-40		45	135	40				
46SPGX-3D-40	●	46	138	40				
47SPGX-3D-40		47	141	40				
48SPGX-3D-40	●	48	144	40				
49SPGX-3D-40		49	147	40				
50SPGX-3D-40		50	150	40				

●刀片資料：SP□□0502□□、SP□□0602□□、SP□□07T3□□、SP□□0904□□、SP□□1104□□、SP□□1405□□
 →參考A44、F12~F13、K05~06頁

●Insert Detail：SP□□0502□□、SP□□0602□□、SP□□07T3□□、SP□□0904□□、SP□□1104□□、
 SP□□1405□□→Ref.Page-A44、F12~F13、K05~06

SPGX4D


		寸法 Dimension(mm)			刀片 Insert	螺絲 Screw	旗型板手 Wrench	價格 Price
產品型號 Model No	在庫 Stock	D	L1 (Dx4)	d				
13SPGX-4D-25		13	52	25	SP□□0502	CS20	T-6	
13.5SPGX-4D-25		13.5	54	25				
14SPGX-4D-25		14	56	25				
14.5SPGX-4D-25		14.5	58	25				
15SPGX-4D-25		15	60	25				
15.5SPGX-4D-25		15.5	62	25				
16SPGX-4D-25		16	64	25	SP□□0602	CS22	T-7	
16.5SPGX-4D-25		16.5	66	25				
17SPGX-4D-25	●	17	68	25				
17.5SPGX-4D-25	●	17.5	70	25				
18SPGX-4D-25	●	18	72	25				
19SPGX-4D-25	●	19	76	25				
20SPGX-4D-32	●	20	80	32				
21SPGX-4D-32	●	21	84	32				
22SPGX-4D-32	●	22	88	32	SP□□07T3	CS25	T-8	
23SPGX-4D-32	●	23	92	32				
24SPGX-4D-32	●	24	96	32				
25SPGX-4D-32	●	25	100	32				
26SPGX-4D-32	●	26	104	32				
27SPGX-4D-32	●	27	108	32				
28SPGX-4D-32	●	28	112	32	SP□□0904	CS35	T-15	
29SPGX-4D-32	●	29	116	32				
30SPGX-4D-32	●	30	120	32				
31SPGX-4D-32	●	31	124	32				
32SPGX-4D-32	●	32	128	32				
33SPGX-4D-32	●	33	132	32				
34SPGX-4D-32	●	34	136	32	SP□□1104	CS40		
35SPGX-4D-32	●	35	140	32				
36SPGX-4D-32	●	36	144	32				
37SPGX-4D-32	●	37	148	32				
38SPGX-4D-32	●	38	152	32				
39SPGX-4D-32	●	39	156	32				
40SPGX-4D-32	●	40	160	32				

●刀片資料：SP□□0502□□、SP□□0602□□、SP□□07T3□□、SP□□0904□□、SP□□1104□□、SP□□1405□□
 →參考A44、F12~F13、K05~06頁

●Insert Detail：SP□□0502□□、SP□□0602□□、SP□□07T3□□、SP□□0904□□、SP□□1104□□、
 SP□□1405□□→Ref.Page-A44、F12~F13、K05~06

WDXT 特徵 用途

WDXT series Characteristics and Applications

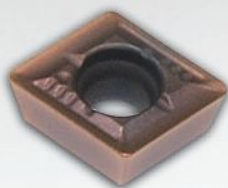
■ 受力均衡設計 Design Feature

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



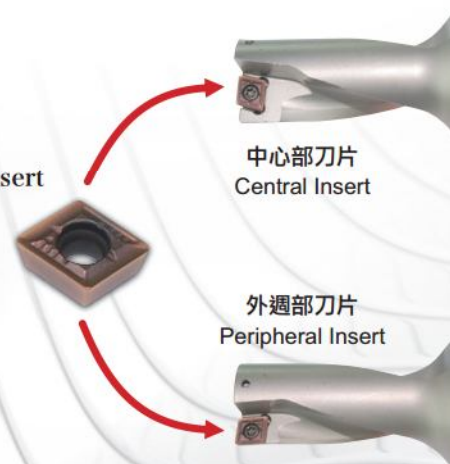
H型

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、外周刃兼用刀片的設計，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、內徑搪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/刃) (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 (f) × 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.

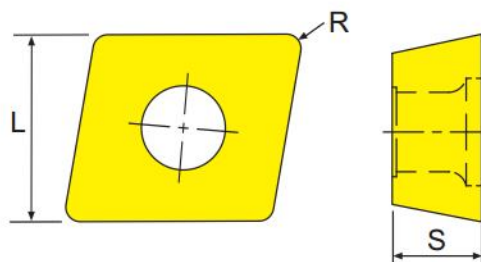
WDXT

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◆ 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

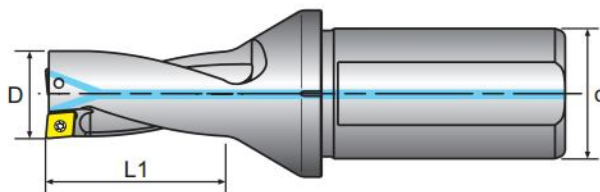
◆ 切削條件→參考A09頁
 Cutting condition Ref.Page-A09



塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	半徑R	L	S	塗層硬質合金 Carbide Coated							
					P	P	P	K	K	P	P	K
					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								

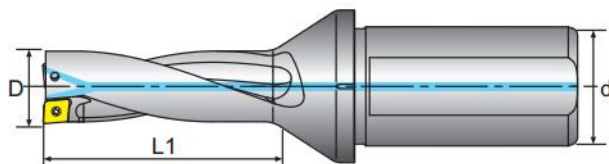
EDX2D 新規格上市
New Specification Arrival



寸法 Dimension(mm)					刀片 Insert	螺絲 Screw	旗型板手 Wrench	價格 Price
產品型號 Model No	在庫 Stock	D	L1 (Dx2)	d				
13EDX-2D-25	●	13	26	25	WD□□042004	CS18	T-6	
13.5EDX-2D-25	●	13.5	27	25				
14EDX-2D-25	●	14	28	25				
14.5EDX-2D-25	●	14.5	29	25				
15EDX-2D-25	●	15	30	25				
15.5EDX-2D-25	●	15.5	31	25	WD□□052504	CS20		
16EDX-2D-25	●	16	32	25				
16.5EDX-2D-25	●	16.5	33	25				
17EDX-2D-25	●	17	34	25				
17.5EDX-2D-25		17.5	35	25				
18EDX-2D-25	●	18	36	25				
19EDX-2D-25		19	38	25	WD□□063006	CS22	T-7	
22.5EDX-2D-32	●	22.5	45	32				

●刀片資料：WD□□042004□□、WD□□052504□□、WD□□063006□□→參考A45、K14頁

●Insert Detail：WD□□042004□□、WD□□052504□□、WD□□063006□□→Ref. Page-A45、K14

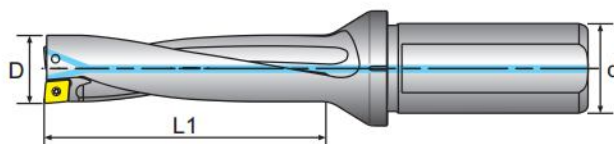
EDX3D **新規格上市**
 New Specification Arrival


產品型號 Model No	在庫 Stock	寸法 Dimension(mm)			刀片 Insert 	螺絲 Screw 	旗型板手 Wrench 	價格 Price
		D	L1 (Dx3)	d				
12.5EDX-3D-25	●	12.5	37.5	25	WD□□042004	CS18	T-6	
13EDX-3D-25	●	13	39	25				
13.5EDX-3D-25	●	13.5	40.5	25				
14EDX-3D-25	●	14	42	25				
14.5EDX-3D-25	●	14.5	43.5	25				
15EDX-3D-25	●	15	45	25				
15.5EDX-3D-25	●	15.5	46.5	25	WD□□052504	CS20	T-6	
16EDX-3D-25	●	16	48	25				
16.5EDX-3D-25	●	16.5	49.5	25				
17EDX-3D-25	●	17	51	25				
17.5EDX-3D-25	●	17.5	52.5	25				
18EDX-3D-25	●	18	54	25				
18.5EDX-3D-25	●	18.5	55.5	25	WD□□063006	CS22	T-7	
19EDX-3D-25	●	19	57	25				
19.5EDX-3D-25	●	19.5	58.5	25				
20EDX-3D-32	●	20	60	32				
20.5EDX-3D-32	●	20.5	61.5	32				
21EDX-3D-32	●	21	63	32				
21.5EDX-3D-32	●	21.5	64.5	32	WD□□073506	CS25	T-8	
22EDX-3D-32	●	22	66	32				
NEW 23EDX-3D-32	●	23	69	32				
NEW 24EDX-3D-32	●	24	72	32				
NEW 25EDX-3D-32	●	25	75	32				
NEW 26EDX-3D-32	●	26	78	32				
NEW 27EDX-3D-32	●	27	81	32	WD□□094008	CS35	T-15	
NEW 28EDX-3D-32	●	28	84	32				
NEW 29EDX-3D-32	●	29	87	32				
NEW 30EDX-3D-32	●	30	90	32				

●刀片資料：WD□□042004□□、WD□□052504□□、WD□□063006□□→參考A45、K14頁

●Insert Detail：WD□□042004□□、WD□□052504□□、WD□□063006□□→Ref.Page-A45、K14

EDX4D



寸法 Dimension(mm)					刀片 Insert 	螺絲 Screw 	旗型板手 Wrench 	價格 Price
產品型號 Model No	在庫 Stock	D	L1 (Dx4)	d				
13EDX-4D-25	●	13	52	25	WD□□042004	CS18	T-6	
13.5EDX-4D-25	●	13.5	54	25				
14EDX-4D-25	●	14	56	25				
14.5EDX-4D-25	●	14.5	58	25				
15EDX-4D-25	●	15	60	25				
15.5EDX-4D-25	●	15.5	62	25	WD□□052504	CS20		
16EDX-4D-25	●	16	64	25				
16.5EDX-4D-25	●	16.5	66	25				
17EDX-4D-25	●	17	68	25				
17.5EDX-4D-25	●	17.5	70	25				
18EDX-4D-25	●	18	72	25				
19.5EDX-4D-25	●	19.5	78	25	WD□□063006	CS22	T-7	

●刀片資料：WD□□042004□□、WD□□052504□□、WD□□063006□□→參考A45、K14頁

●Insert Detail：WD□□042004□□、WD□□052504□□、WD□□063006□□→Ref.Page-A45、K14

WCMX 系列

WCMX series

設計特色 Tool Design Feature



刀片替換快速，排屑良好。

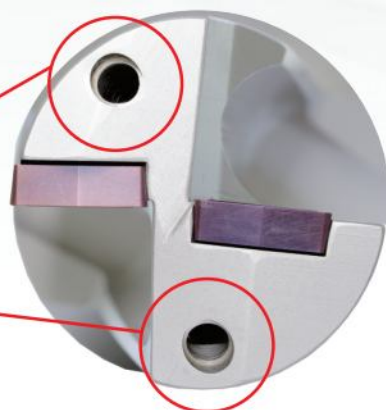
Changing insert is simple and effective, improving chip evacuation.

節省加工時間，比一般快速鑽頭快。

The processing time is short and better than ordinary rapid drill.

使用高壓式中心出水快速鑽頭，以增加刀片壽命。

Draining hi-pressure coolant thru spindle center while using the high speed drill will extend inserts life.



操作注意事項 Important Cautions

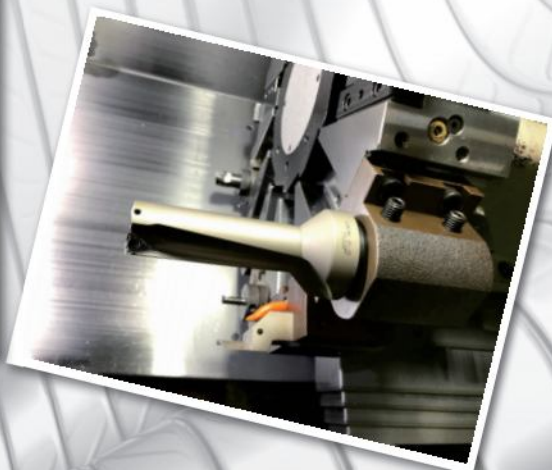


在使用CNC車床時，刀具中心點及機械主軸中心盡量平行。

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 mobilng angle tool turret.



材質推薦切屑表

Recommended Cutting Condition

被削材 Workpiece			刃徑 Diameter				
			12-14.5mm	15-22.5mm	23-34mm	35-48mm	49-60mm
P 鋼 Steel	軟鋼 Mild Steel (SS400)	$V_{(2D/3D)}$	100- 150 -200	100- 150 -200	100- 150 -200	100- 150 -200	100- 150 -200
		$V_{(4D)}$	100- 140 -200	100- 140 -200	100- 140 -200	100- 140 -200	100- 140 -200
		f	0.04- 0.06 -0.10	0.04- 0.07 -0.10	0.04- 0.08 -0.10	0.04- 0.10 -0.12	0.04- 0.08 -0.10
	碳素鋼 Carbon Alloy Steel (S45C)	$V_{(2D/3D)}$	60- 100 -160	60- 100 -160	60- 100 -160	60- 100 -160	60- 100 -160
		$V_{(4D)}$	60- 80 -120	60- 80 -120	60- 80 -120	60- 80 -120	60- 80 -120
		f	0.04- 0.06 -0.10	0.04- 0.09 -0.12	0.08- 0.12 -0.14	0.08- 0.15 -0.18	0.04- 0.12 -0.14
	合金鋼 Alloy Steel (SCM400)	$V_{(2D/3D)}$	80- 120 -160	80- 120 -160	80- 120 -160	80- 120 -160	80- 120 -160
		$V_{(4D)}$	80- 100 -120	80- 100 -120	80- 100 -120	80- 100 -120	80- 100 -120
		f	0.04- 0.06 -0.10	0.06- 0.08 -0.10	0.04- 0.09 -0.12	0.06- 0.10 -0.14	0.06- 0.09 -0.12
M 不鏽鋼 Stainless steel	不鏽鋼 Stainless Steel (SUS304)	$V_{(2D/3D)}$	80- 100 -120	80- 100 -120	80- 100 -120	100- 150 -200	80- 100 -120
		$V_{(4D)}$	80- 110 -140	80- 110 -140	80- 110 -140	100- 140 -200	80- 110 -140
		f	0.04- 0.07 -0.10	0.04- 0.07 -0.10	0.04- 0.08 -0.10	0.04- 0.10 -0.12	0.04- 0.08 -0.10
K 鑄鐵 Cast	鑄鐵 Cast Iron (FC250)	$V_{(2D/3D)}$	80- 120 -160	80- 120 -160	80- 100 -120	80- 120 -160	80- 120 -160
		$V_{(4D)}$	110- 140 -160	110- 140 -160	80- 110 -140	110- 140 -160	110- 140 -160
		f	0.04- 0.07 -0.10	0.06- 0.07 -0.10	0.04- 0.10 -0.12	0.06- 0.10 -0.14	0.06- 0.10 -0.14

● (V=m/min. f=mm/刃) (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 (f) × 工具刀數 (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。

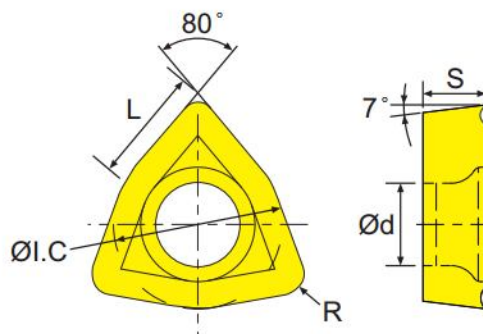
While using CNC lathe, the cutting center point must parallel the spindle center of the machine.

→ 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.

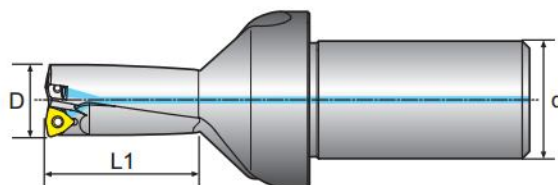
WCMX

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- ◆ 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

							P	P _M	K		K _M	P	P _M	K _N
							ECM100	BEJ750	ACK200	ACK300	ACZ310	ACZ330	ACZ350	H1
形狀 Shape	型號 Model No	半徑R	L	I.C	S	d								
	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	●	●						

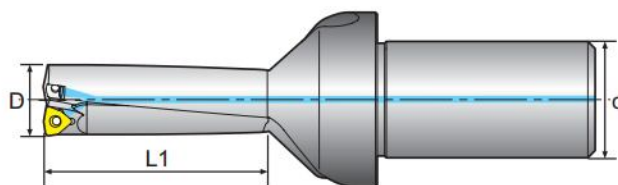
WCMX2D


產品型號 Model No	在庫 Stock	寸法 Dimension(mm)			刀片 Insert	螺絲 Screw	旗型板手 Wrench	價格 Price
		D	L1(Dx2)	d				
15WCMX-2D-25	●	15	30	25	WC□□ 0302□□	CS25	T-8	
16WCMX-2D-25	●	16	32	25				
17WCMX-2D-25	●	17	34	25				
18WCMX-2D-25	●	18	36	25				
19WCMX-2D-25	●	19	38	25				
20WCMX-2D-32	●	20	40	32	WC□□ 0402□□	CS25	T-8	
21WCMX-2D-32	●	21	42	32				
22WCMX-2D-32	●	22	44	32				
23WCMX-2D-32	●	23	46	32				
24WCMX-2D-32	●	24	48	32				
25WCMX-2D-32	●	25	50	32	WC□□ 0503□□	CS30	T-10	
26WCMX-2D-32	●	26	52	32				
27WCMX-2D-32	●	27	54	32				
28WCMX-2D-32	●	28	56	32				
29WCMX-2D-32	●	29	58	32				
30WCMX-2D-32	●	30	60	32	WC□□ 06T03□□	CS35W	T-10	
31WCMX-2D-32	●	31	62	32				
32WCMX-2D-32	●	32	64	32				
33WCMX-2D-32	●	33	66	32				
34WCMX-2D-32	●	34	68	32				
35WCMX-2D-32	●	35	70	32				
36WCMX-2D-32	●	36	72	32				
37WCMX-2D-32	●	37	74	32				
38WCMX-2D-32	●	38	76	32				
39WCMX-2D-32	●	39	78	32				
40WCMX-2D-32	●	40	80	32				
41WCMX-2D-32	●	41	82	32				
42WCMX-2D-32	●	42	84	32				
43WCMX-2D-40	●	43	86	40	WC□□ 0804□□	CS40	T-15	
44WCMX-2D-40	●	44	88	40				
45WCMX-2D-40	●	45	90	40				
46WCMX-2D-40	●	46	92	40				
47WCMX-2D-40	●	47	94	40				
48WCMX-2D-40	●	48	96	40				
49WCMX-2D-40	●	49	98	40				
50WCMX-2D-40	●	50	100	40				

●刀片資料：WC□□0302□□、WC□□0402□□、WC□□0503□□、WC□□06T3□□、WC□□0804□□→參考A46、K20頁

●Insert Detail：WC□□0302□□、WC□□0402□□、WC□□0503□□、WC□□06T3□□、WC□□0804□□→Ref.Page-A46、K20

WCMX3D

新規格上市
New Specification Arrival


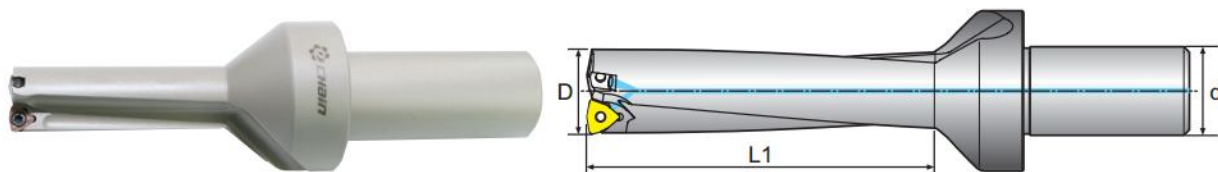
寸法 Dimension(mm)								價格 Price	
產品型號 Model No	在庫 Stock	D	L1(Dx3)	d					
15WCMX-3D-25	●	15	45	25	WC□□ 0302□□	CS25048	T-8		
16WCMX-3D-25	●	16	48	25					
NEW 16.5WCMX-3D-25	●	16.5	49.5	25					
17WCMX-3D-25	●	17	51	25					
18WCMX-3D-25	●	18	54	25					
NEW 18.5WCMX-3D-25	●	18.5	55.5	25					
19WCMX-3D-25	●	19	57	25					
NEW 19.5WCMX-3D-32	●	19.5	58.5	32					
20WCMX-3D-32	●	20	60	32	WC□□ 0402□□	CS25			
20.5WCMX-3D-32	●	20.5	61.5	32					
21WCMX-3D-32	●	21	63	32					
NEW 21.5WCMX-3D-32	●	21.5	64.5	32					
22WCMX-3D-32	●	22	66	32					
NEW 22.5WCMX-3D-32	●	22.5	67.5	32					
23WCMX-3D-32	●	23	69	32					
NEW 23.5WCMX-3D-32	●	23.5	70.5	32					
24WCMX-3D-32	●	24	72	32					
NEW 24.5WCMX-3D-32	●	24.5	73.5	32					
25WCMX-3D-32	●	25	75	32	WC□□ 0503□□	CS30	T-10		
NEW 25.5WCMX-3D-32	●	25.5	76.5	32					
26WCMX-3D-32	●	26	78	32					
27WCMX-3D-32	●	27	81	32					
28WCMX-3D-32	●	28	84	32					
NEW 28.5WCMX-3D-32	●	28.5	85.5	32					
29WCMX-3D-32	●	29	87	32					
30WCMX-3D-32	●	30	90	32					
31WCMX-3D-32	●	31	93	32	WC□□ 06T3□□	CS35W			
32WCMX-3D-32	●	32	96	32					

※ 請接下頁。 ※ Continued on next page.

產品型號 Model No	在庫 Stock	寸法 Dimension(mm)			刀片 Insert 	螺絲 Screw 	旗型板手 Wrench 	價格 Price
		D	L1(Dx3)	d				
33WCMX-3D-32	●	33	99	32	WC□□ 06T3□□	CS35W	T-10	
34WCMX-3D-32	●	34	102	32				
35WCMX-3D-32	●	35	105	32				
36WCMX-3D-32	●	36	108	32				
37WCMX-3D-32	●	37	111	32				
38WCMX-3D-32	●	38	114	32				
39WCMX-3D-32	●	39	117	32				
40WCMX-3D-32	●	40	120	32				
41WCMX-3D-32	●	41	123	32				
42WCMX-3D-32	●	42	126	32				
43WCMX-3D-40	●	43	129	40	WC□□ 0804□□	CS40	T-15	
44WCMX-3D-40	●	44	132	40				
45WCMX-3D-40	●	45	135	40				
46WCMX-3D-40	●	46	138	40				
47WCMX-3D-40	●	47	141	40				
48WCMX-3D-40	●	48	144	40				
49WCMX-3D-40	●	49	147	40				
50WCMX-3D-40	●	50	150	40				
51WCMX-3D-40	●	51	153	40				
52WCMX-3D-40	●	52	156	40				
53WCMX-3D-40	●	53	159	40				
54WCMX-3D-40	●	54	162	40				
55WCMX-3D-40	●	55	165	40				
56WCMX-3D-40	●	56	168	40				
57WCMX-3D-40	●	57	171	40				
58WCMX-3D-40	●	58	174	40				
59WCMX-3D-40	●	59	177	40				
60WCMX-3D-40	●	60	180	40				

●刀片資料：WC□□0302□□、WC□□0402□□、WC□□0503□□、WC□□06T3□□、WC□□0804□□→參考A46、K01頁
 ●Insert Detail：WC□□0302□□、WC□□0402□□、WC□□0503□□、WC□□06T3□□、WC□□0804□□→Ref.Page-A46、K20

WCMX4D



		寸法 Dimension(mm)			刀片 Insert	螺絲 Screw	旗型板手 Wrench	價格 Price	
產品型號 Model No	在庫 Stock	D	L1 (Dx4)	d					
17WCMX-4D-25	●	17	68	25	WC□□ 0302□□	CS25	T-8		
18WCMX-4D-25	●	18	72	25					
19WCMX-4D-25	●	19	76	25					
20WCMX-4D-32	●	20	80	32	WC□□ 0402□□				
21WCMX-4D-32	●	21	84	32					
22WCMX-4D-32	●	22	88	32					
23WCMX-4D-32	●	23	92	32					
24WCMX-4D-32	●	24	96	32					
25WCMX-4D-32	●	25	100	32	WC□□ 0503□□	CS30	T-10		
26WCMX-4D-32	●	26	104	32					
27WCMX-4D-32	●	27	108	32					
28WCMX-4D-32	●	28	112	32					
29WCMX-4D-32	●	29	116	32					
30WCMX-4D-32	●	30	120	32					
31WCMX-4D-32	●	31	124	32	WC□□ 06T3□□	CS35W			
32WCMX-4D-32	●	32	128	32					
33WCMX-4D-32	●	33	132	32					
34WCMX-4D-32	●	34	136	32					
35WCMX-4D-32	●	35	140	32					
36WCMX-4D-32	●	36	144	32					
37WCMX-4D-32	●	37	148	32					
38WCMX-4D-32	●	38	152	32					
39WCMX-4D-32	●	39	156	32					
40WCMX-4D-32	●	40	160	32					
41WCMX-4D-32	●	41	164	32					
42WCMX-4D-32	●	42	168	32					
43WCMX-4D-40		43	172	40	WC□□ 0804□□	CS40	T-15		
44WCMX-4D-40		44	176	40					
45WCMX-4D-40		45	180	40					

●刀片資料：WC□□0302□□、WC□□0402□□、WC□□0503□□、WC□□06T3□□、WC□□0804□□→參考A46、K20頁
 ●Insert Detail：WC□□0302□□、WC□□0402□□、WC□□0503□□、WC□□06T3□□、WC□□0804□□→Ref.Page-A46、K20