A 刀片 Insert

刀片識別系統 Turning Insert Identification System ..... A02－A03

車削用材質 Recommend Material Grades For Turning A04

各公司材質對照表 Grade Comparison Chart A05

正、負角斷削槽選擇 Selection Of Chip Breaker ..... A06－A09

材質推薦切削表 Recommended Cutting Condition A10

車刀刀片 Insert For Turning ..... A11－A45

NEW 切斷刀刀片 Grooving Off Insert ..... A46－A47

槽刀刀片 Shallow Grooving Insert ..... A48－A50

插槽刀片識別系統 Slotting Insert Identification System A51

NEW 插槽刀片 Slotting Insert A52

快鑽刀片 Insert For Drilling ..... A53－A55

ＣＢＮ立方氮化硼刀片 Cubic Boron Nitride Insert ..... A56－A57

ＰＣＤ聚晶金剛石刀片 Poly Crystalling Diamond Insert ..... A58－A59

牙刀片識別系統 Threading Insert Identification System A60

牙刀刀片 Threading Insert ..... A64－A66

刀片識別系統

Turning Insert Identification System

C	N	M	G
1	2	3	4

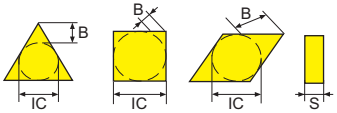
1 刀片形狀 Insert Shape | 2 離隙角 Relief Angle | 3 精度記號 Tolerance | 4 孔溝記號 Insert Hole

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°		82°
K	55°		55°
C	80°	菱形	80°
D	55°		55°
E	75°		75°
M	86°		86°
V	35°		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 10 切邊狀況及排屑槽 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		公制切削刃長度 Metric Cutting Edge Length							英制切削刃長度 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	–	–	–	–	–	–	–

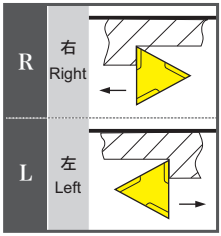
6 刀片厚度 Insert Thickness

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



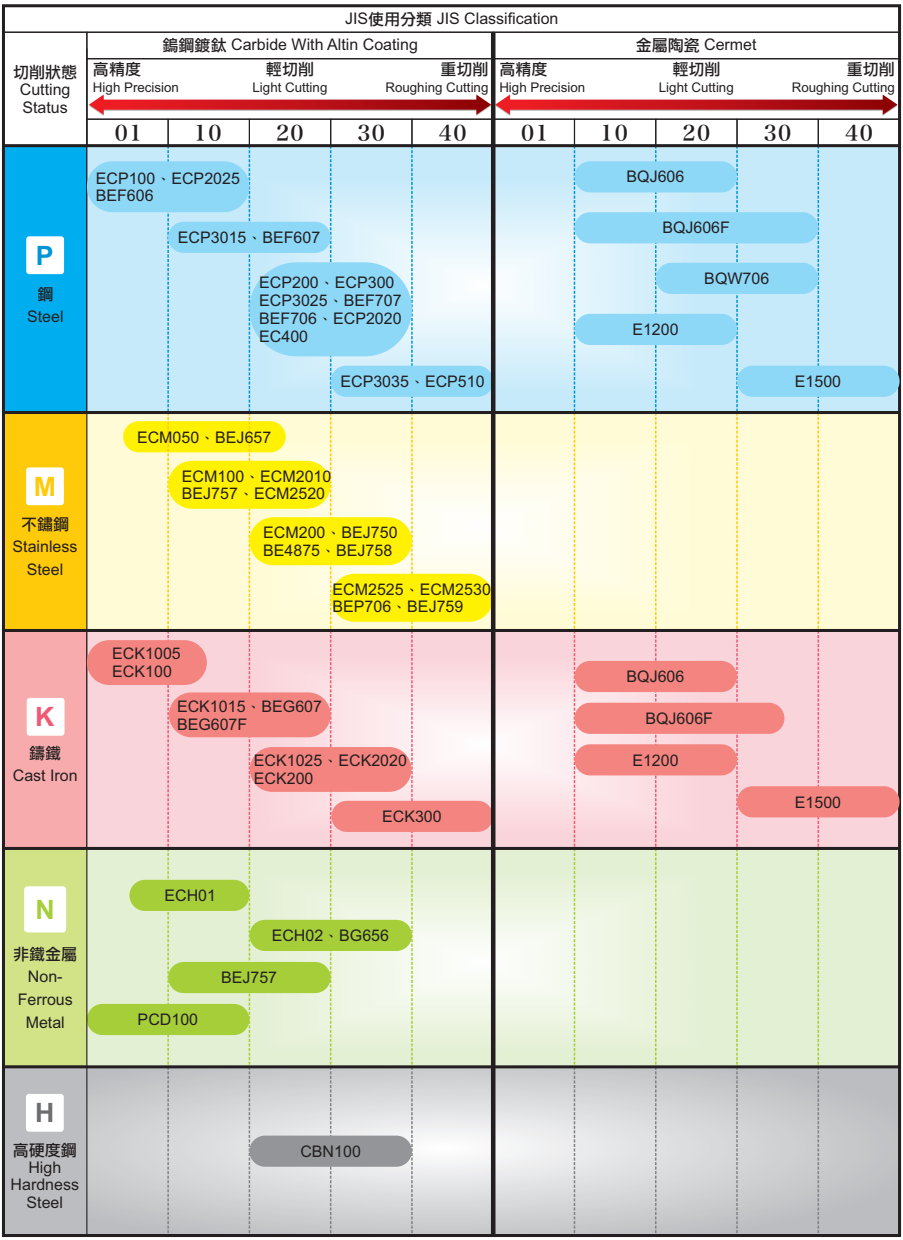
9 10

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



各公司材質對照表

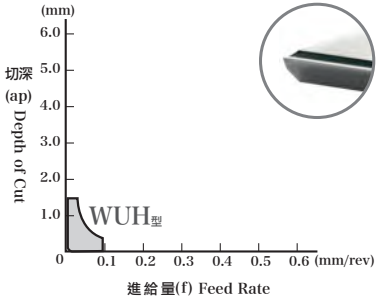
Grade Comparison Chart

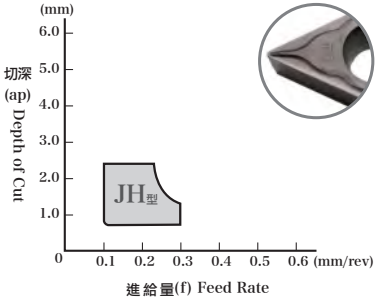
※ 用途 Application：車削 Turning

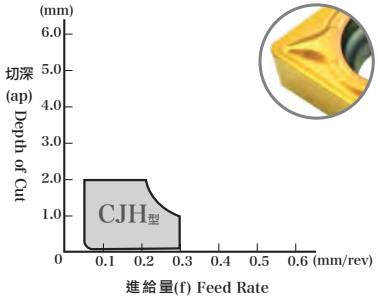
加工件 Work Material	級別 Grade	益 詮 Echain	住友電工 Sumitomo	三菱綜合材料 Mitsubishi	泰珂洛 Tungaloy	京 瓷 Kyocera
P 鋼 Steel	P05	ECP100、ECP2005、BEF606	AC8015P	UE6105	T9105	CA5505
	P10	ECP3015、BEF607	AC8015P	UE6110	T9115	CA5515
	P20	ECP3025、ECP200、ECP2020、BEF706	AC8025P AC820P	UE6020	T9125	CA5525
	P30	ECP300、BEF707、EC400	AC8035P AC830P	UE6035	T9135	CA5535
	P40	ECP510、ECP3035	AC8035P	UE6035	T9135	PR660
M 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
K 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
N 非鐵金屬 Non-Ferrous Metal		BEJ757、ECH01、ECH205、BG656	H1	H1		
H 高硬度鋼 High Hardness Steel		CBN100				
金屬陶瓷 Cermet		BQJ606、BQJ606F、BQJ706、E1500、E1200	T1500A T2500Z	NX2525	NS9530	TN60

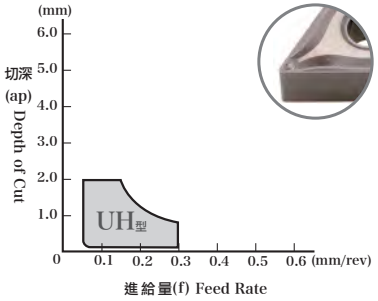
正角斷屑槽選擇

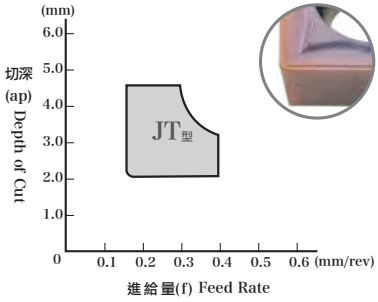
Selection Of Chip Breaker

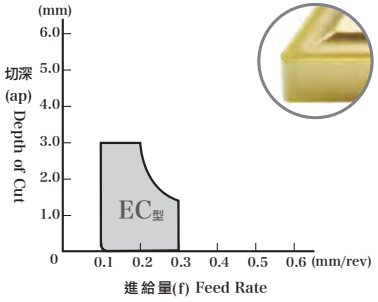


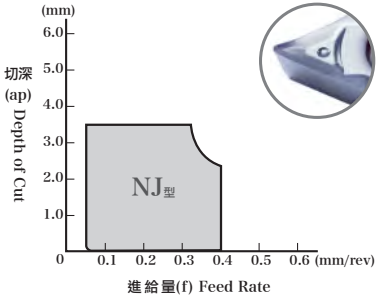


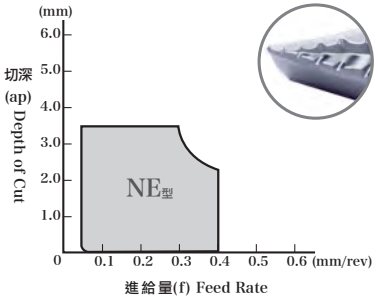


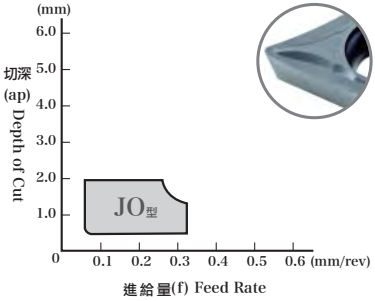


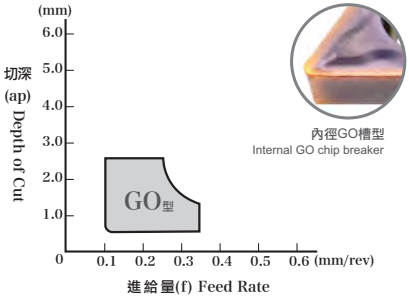






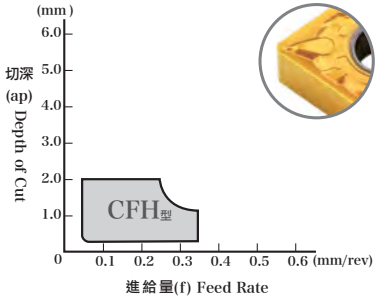


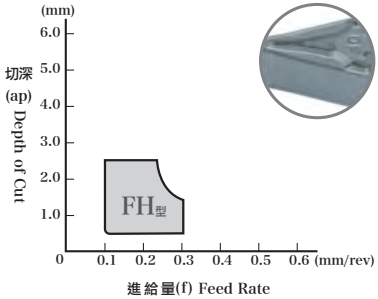

(mm)
6.0
5.0
4.0
3.0
2.0
1.0
0
切深
(ap)
Depth of Cut
JO型
0.1 0.2 0.3 0.4 0.5 0.6 (mm/rev)
進給量(f) Feed Rate

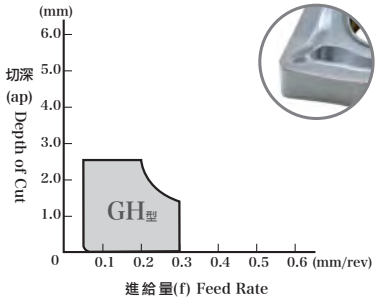

(mm)
6.0
5.0
4.0
3.0
2.0
1.0
0
切深
(ap)
Depth of Cut
GO型
內徑GO槽型
Internal GO chip breaker
0.1 0.2 0.3 0.4 0.5 0.6 (mm/rev)
進給量(f) Feed Rate

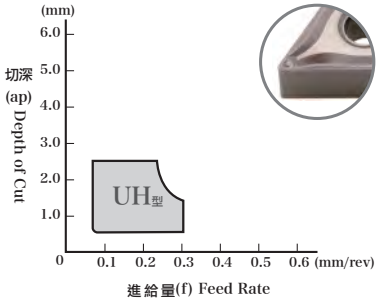
負角斷屑槽選擇

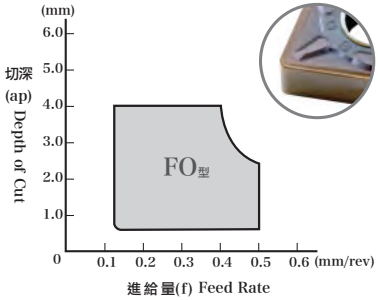
Selection Of Chip Breaker

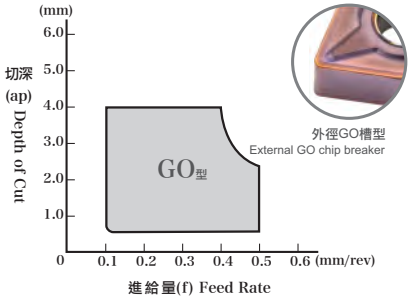


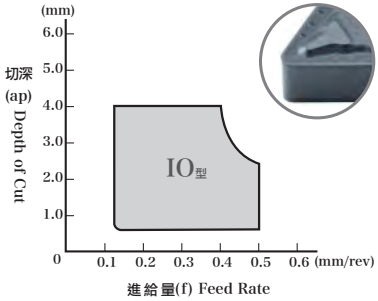


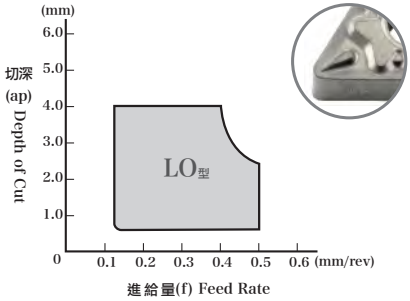


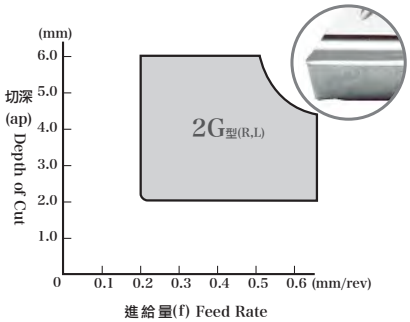


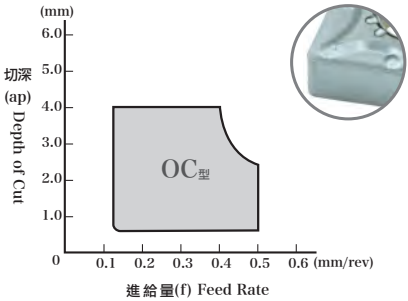









(mm)
6.0
5.0
4.0
3.0
2.0
1.0
0
切深
(ap)
Depth of Cut
2G型(R,L)
0.1 0.2 0.3 0.4 0.5 0.6 (mm/rev)
進給量(f) Feed Rate


(mm)
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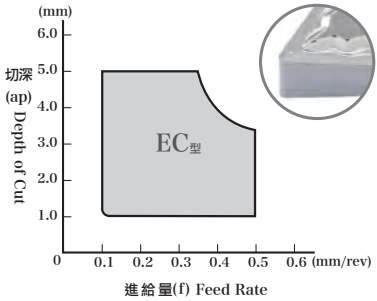
5.0
4.0
3.0
2.0
1.0
0
切深
(ap)
Depth of Cut
OC型
0.1 0.2 0.3 0.4 0.5 0.6 (mm/rev)
進給量(f) Feed Rate


(mm)
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5.0
4.0
3.0
2.0
1.0
0
切深
(ap)
Depth of Cut
EC型
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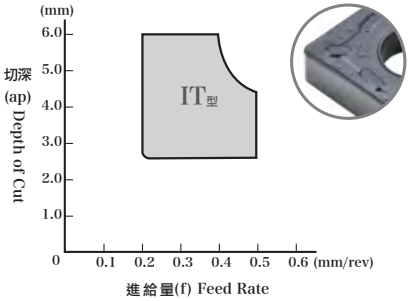
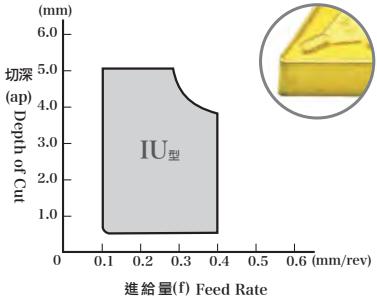
進給量(f) Feed Rate


(mm)
6.0
5.0
4.0
3.0
2.0
1.0
0
切深
(ap)
Depth of Cut
IT型
0.1 0.2 0.3 0.4 0.5 0.6 (mm/rev)
進給量(f) Feed Rate


(mm)
6.0
5.0
4.0
3.0
2.0
1.0
0
切深
(ap)
Depth of Cut
IU型
0.1 0.2 0.3 0.4 0.5 0.6 (mm/rev)
進給量(f) Feed Rate

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
P 鋼 Steel	ECP2005、ECP100、BEF606	0.1～0.4	180～220	1.0m～3.0m
	ECP3015、BEF607			
	ECP3025、ECP300、BEF707			
	ECP510			
M 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	
K 鑄鐵 Cast Iron	ECK100、ECK1005、ECK1015、ECK1025 ECK200、ECK2020、ECK300、BEG607、BEG607F	0.1～0.4	120～160	1.0m～4.0m
N 非鐵金屬 Non-Ferrous Metal	BEJ757、ECH01、ECH02、BG656	0.1～0.4	200～350	1.0m～3.0m
	PCD100	0.02～0.2		
H 高硬度鋼 High Hardness Steel	CBN100	0.03～0.2	50～120	0.03～0.5
S 金屬陶瓷 Cermet	BQJ606、BQJ606F、BQW706、E1200、E1500	0.05～0.3	180～250	0.05～1.0

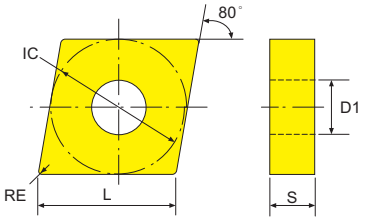
●(V=m/min，F=/刃) (下限值－推薦值－上限值) (Min.－Optimum－Max.)
●工具回轉速度(N)=[1000 x 切削速度(V)]÷[3. 14 x 工具直徑(D)]
●總進給(F)=[每刃進給(ft) x 工具刃數(Z) x 工具回轉速度(N)]

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



◆ 材質介紹→參考A04頁
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◆ 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

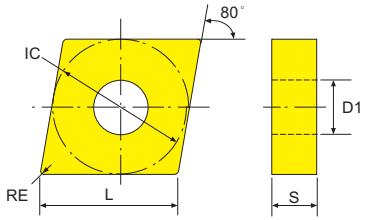
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																			金屬陶瓷 Cermet					
			P								P					M	K				N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
中粗切削 Medium and roughing	CNMA120408	0.8																		●		●		●						
	CNMA120412	1.2																		●		●								
中粗切削 Medium and roughing	CNMG120408	0.8						●				●	●		●							●	●							
CFH中輕切削 Mid and light cutting	CNMG120404-CFH	0.4												●																
	CNMG120408-CFH	0.8												●																
	CNMG120412-CFH	1.2												●																
DO中切削 Medium	CNMG120408-DO	0.8										●								●		●								
FO中切削 Medium	CNMG120404-FO	0.4								●					●	●	●							●						
	CNMG120408-FO	0.8								●	●				●	●	●	●						●						
	CNMG120412-FO	1.2														●														
FT中粗切削 Medium and roughing	CNMG120404-FT	0.4								●						●								●						
	CNMG120408-FT	0.8								●					●	●								●						
GO中切削 Medium	CNMG120408-GO	0.8														●														

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



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◆ 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

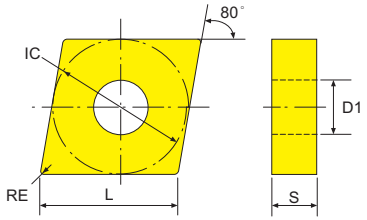
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																			金屬陶瓷 Cermet					
			P								P					M		K				N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
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 Finising	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																						●						

CN

尺寸 Dimension

切削刃長 L：16.1　　刀片厚度 S :6.35

內接圓 IC：15.875螺釘孔徑 D1 :6.35



◆ 材質介紹→參考A04頁
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◆ 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

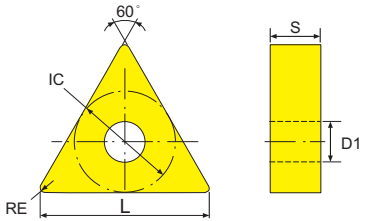
形狀 Shape	型號 Model No	刀尖半徑 RE	P								P						M	K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
IO中切削 Medium	CNMG160608-IO	0.8					●					●																		
	CNMG160612-IO	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



◆ 材質介紹→參考A04頁
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◆ 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	刀尖半徑 RE	塗層硬質合金 Carbide Coated																			金屬陶瓷 Cermet					
			P								P					M		K				N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
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																										●		

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

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◆ 切削條件→參考A09頁
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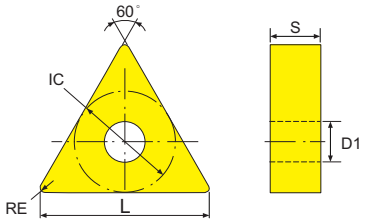


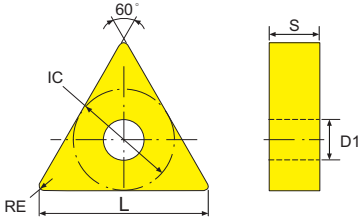
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																			金屬陶瓷 Cermet					
			P								P						M	K				N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
GS (L) 中粗切削 Medium and roughing	TNMG160408L-GS	0.8				●	●	●				●	●																	
GS (R) 中粗切削 Medium and roughing	TNMG160408R-GS	0.8	●		●																									
HO (L) 中切削 Medium	TNMG160404L-HO	0.4									●																			
	TNMG160404R-HO	0.4									●																			
HO(R) 中切削 Medium	TNMG160408L-HO	0.8									●																			
	TNMG160408R-HO	0.8									●																			
IE (L) 中粗切削 Medium and roughing	TNMG160404L-IE	0.4				●	●	●																						
	TNMG160404R-IE	0.4				●	●	●																						
IE (R) 中粗切削 Medium and roughing	TNMG160408L-IE	0.8				●	●	●				●	●										●							
	TNMG160408R-IE	0.8				●	●	●					●																	
IO中切削 Medium	TNMG160404-IO	0.4				●	●	●	●			●	●						●				●							
	TNMG160408-IO	0.8				●	●	●	●													●	●							

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



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

◆ 切削條件→參考A09頁
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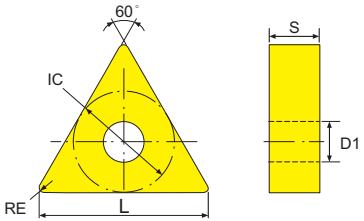
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					
			P								P					M	K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
LO精切削 Finishing	TNMG160404-LO	0.4																										●		
	TNMG160408-LO	0.8																										●		
OC中切削 Medium	TNMG160404-OC	0.4				●					●	●						●											
	TNMG160408-OC	0.8				●					●	●						●											
RO中切削 Medium	TNMG160404-RO	0.4								●													●						
	TNMG160408-RO	0.8								●													●						
VE中粗切削 Medium and roughing	TNMG160408-VE	0.8																					●						
BE(L) 中粗切削 Medium and roughing	TNMG160404L-BE	0.4							●				●		●												●		
	TNMG160404R-BE	0.4											●		●											●			●
BE(R) 中粗切削 Medium and roughing	TNMG160408L-BE	0.8												●	●														
	TNMG160408R-BE	0.8											●	●	●														●
GS中粗切削 Medium and roughing	TNMG160408L-GS	0.8				●	●	●	●		●	●						●											

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



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◆ 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	P ECP3015	P ECP3025	P ECP3035	P ECP100	P ECP200	P ECP300	P ECP3025	P BEF607	P BEF707	P ECM100	P ECM200	P BE4875	P BEP706	P BEJ750	P BEJ757	P BEJ758	P ECM2020	K ECK1005	K ECK100	K ECK200	K ECK300	K BEG607	N BG656	W35	BQJ606	BQW706	E1500	鍍鈦 Titanium Plating BQJ606F
GO中切削 Medium	TNMG160404-GO	0.4														●	●													
	TNMG160408-GO	0.8														●	●													
UH精切削 Finishing	TNMG160404-UH	0.4																												●
	TNMG160408-UH	0.8																												●
OW中粗切削 Medium and roughing	TNMG160412-OW	1.2																											●	

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 :5.16

塗層硬質合金 Carbide Coated　　金屬陶瓷 Cermet

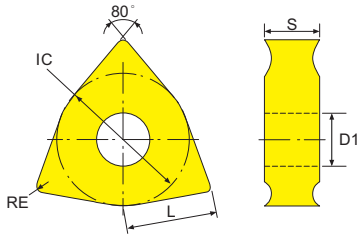
形狀 Shape	型號 Model No	刀尖半徑 RE	P ECP3015	P ECP3025	P ECP3035	P ECP100	P ECP200	P ECP300	P ECP3025	P BEF607	P BEF707	P ECM100	P ECM200	P BE4875	P BEP706	P BEJ750	P BEJ757	P BEJ758	P ECM2020	K ECK1005	K ECK100	K ECK200	K ECK300	K BEG607	N BG656	W35	BQJ606	BQW706	E1500	鍍鈦 Titanium Plating BQJ606F
FO中切削 Medium	TNMG220404-FO	0.4								●																				
	TNMG220408-FO	0.8					●			●	●																			
	TNMG220412-FO	1.2																						●						

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



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Cutting condition Ref.Page-A09

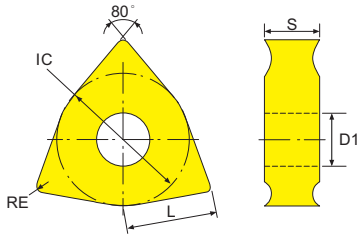
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																			金屬陶瓷 Cermet					
			P								P					M		K				N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
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



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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	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
			P									P						M		K					N					鍍鈦 Titanium Plating
GO中切削 Medium	WNMG080404-GO	0.4														●	●													
	WNMG080408-GO	0.8														●	●													
IO中切削 Medium	WNMG080404-IO	0.4				●	●	●														●								
	WNMG080408-IO	0.8				●	●	●	●												●	●	●							
RO中切削 Medium	WNMG080404-RO	0.4								●													●							
	WNMG080408-RO	0.8								●													●							
VE中粗切削 Medium and roughing	WNMG080404-VE	0.4																						●						
	WNMG080408-VE	0.8																						●						
OC中切削 Medium	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

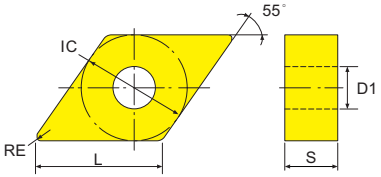
形狀 Shape	型號 Model No	刀尖半徑 RE	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
			P									P						M		K					N					鍍鈦 Titanium Plating
FO中切削 Medium	WNMG060408-FO	0.8									●																			

DN

尺寸 Dimension

切削刃長 L：15.5　刀片厚度 S :6.35

內接圓 IC：12.7　螺釘孔徑 D1 :5.16



◆ 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					
			P								P						M		K				N					鍍鈦 Titanium Plating
形狀 Shape	型號 Model No	刀尖半徑 RE	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
中粗切削 Medium and roughing	DNMG150604	0.4					●															●								
FO中切削 Medium	DNMG150604-FO	0.4																												
	DNMG150608-FO	0.8								●	●																			
	DNMG150612-FO	1.2								●																				
IO中切削 Medium	DNMG150608-IO	0.8				●	●	●																						
	DNMG150612-IO	1.2											●																	

尺寸 Dimension

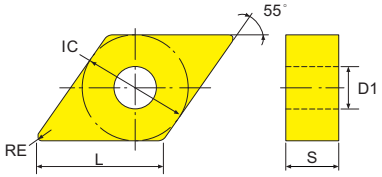
切削刃長 L：11.6　刀片厚度 S :4.76

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					
			P								P						M		K				N					鍍鈦 Titanium Plating
形狀 Shape	型號 Model No	刀尖半徑 RE	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
FO中切削 Medium	DNMG110404-FO	0.4									●																			
	DNMG110408-FO	0.8								●																				
IO中切削 Medium	DNMG110408-IO	0.8					●	●														●								

DN

尺寸 Dimension	
切削刃長 L：15.5	刀片厚度 S :4.76
內接圓 IC：12.7	螺釘孔徑 D1 :5.16



◆ 材質介紹→參考A04頁
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◆ 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

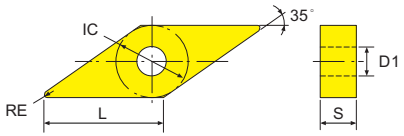
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																		金屬陶瓷 Cermet					
			P								P					M		K				N				鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
FO中切削 Medium	DNMG150404-FO	0.4							●						●														
	DNMG150408-FO	0.8							●						●									●					
	DNMG150412-FO	1.2							●							●								●					
IO中切削 Medium	DNMG150404-IO	0.4				●	●															●							
	DNMG150408-IO	0.8				●	●	●		●												●							
OC中切削 Medium	DNMG150404-OC	0.4											●																
	DNMG150408-OC	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



◆ 材質介紹→參考A04頁
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◆ 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

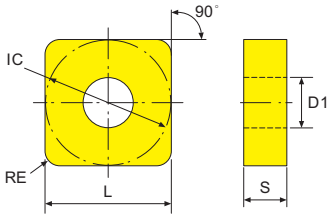
			塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					
			P								P					M		K					N					鍍鈦 Titanium Plating
形狀 Shape	型號 Model No	刀尖半徑 RE	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
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																												●

SN

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



◆ 材質介紹→參考A04頁
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◆ 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

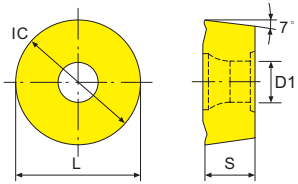
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					
			P								P					M		K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
中粗切削 Medium and roughing	SNMA120408	0.8																				●								
	SNMA120412	1.2																				●		●						
CFH中輕切削 Mid and light cutting	SNMG120408-CFH	0.8												●																
FO中切削 Medium	SNMG120408-FO	0.8													●									●						
FT中粗切削 Medium and roughing	SNMG120408-FT	0.8													●	●								●						
IO中切削 Medium	SNMG120408-IO	0.8					●	●														●								
	SNMG120412-IO	1.2					●															●								

RC

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



◆ 材質介紹→參考A04頁
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◆ 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				
			P								P						M		K					N					鍍鈦 Titanium Plating
形狀 Shape	型號 Model No	刀尖半徑 RE	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF706	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	ECM2021	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
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

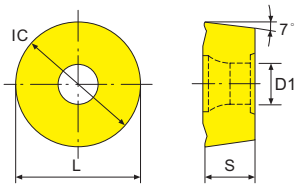
切削刃長 L：10　　刀片厚度 S：3.97

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				
			P								P						M		K					N					鍍鈦 Titanium Plating
形狀 Shape	型號 Model No	刀尖半徑 RE	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF706	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	ECM2021	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
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



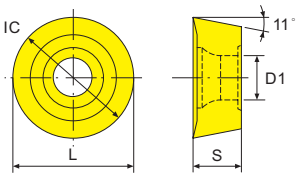
◆ 材質介紹→參考A04頁
Grade Ref.Page-A04

◆ 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				
			P							P					M		K				N					
形狀 Shape	型號 Model No	刀尖半徑 RE	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF706	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F 鍍鈦 Titanum Plating
粗切削 Roughing	RCMT1204MO	6								●					●															

RP



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 D1：4.1

◆ 材質介紹→參考A04頁
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◆ 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	P ECP3015	P ECP3025	P ECP3035	P ECP100	P ECP200	P ECP300	P ECP3025	P BEF607	P BEF707	P ECM100	P ECM200	P BE4875	P BEP706	P BEJ750	P BEJ757	M ECM2010	M ECM2020	K ECK1005	K ECK100	K ECK200	K ECK300	K BEG607	N BG656	W35	BQJ606	BQW706	E1500	鍍鈦 Titanium Plating BQJ606F
HH中粗切削 Medium and roughing	RPMX10T3MO-HH	5										●	●																	

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 D1：4.36

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	P ECP3015	P ECP3025	P ECP3035	P ECP100	P ECP200	P ECP300	P ECP3025	P BEF607	P BEF707	P ECM100	P ECM200	P BE4875	P BEP706	P BEJ750	P BEJ757	M ECM2010	M ECM2020	K ECK1005	K ECK100	K ECK200	K ECK300	K BEG607	N BG656	W35	BQJ606	BQW706	E1500	鍍鈦 Titanium Plating BQJ606F
HH中粗切削 Medium and roughing	RPMX1204MO-HH	6					●					●	●																	

尺寸 Dimension

切削刃長 L：16　　刀片厚度 S：4.76

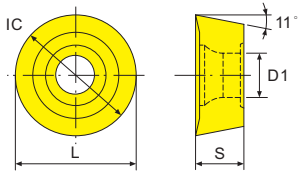
內接圓 IC：16　　螺釘孔徑 D1：4.9

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	P ECP3015	P ECP3025	P ECP3035	P ECP100	P ECP200	P ECP300	P ECP3025	P BEF607	P BEF707	P ECM100	P ECM200	P BE4875	P BEP706	P BEJ750	P BEJ757	M ECM2010	M ECM2020	K ECK1005	K ECK100	K ECK200	K ECK300	K BEG607	N BG656	W35	BQJ606	BQW706	E1500	鍍鈦 Titanium Plating BQJ606F
HH中粗切削 Medium and roughing	RPMT1604MO-HH	8					●					●	●					●	●											

RP

尺寸 Dimension	
切削刃長 L：16	刀片厚度 S：6.35
內接圓 IC：16	螺釘孔徑 D1：4.9



◆ 材質介紹→參考A04頁
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◆ 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

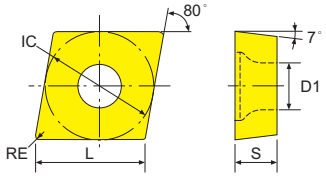
			塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet				
			P								P						M	K					N				鍍鈦 Titanium Plating
形狀 Shape	型號 Model No	刀尖半徑 RE	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	ECM2010	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
HH中粗切削 Medium and roughing	RPMT1606MO-HH	8					●					●	●																	

CC

尺寸 Dimension

切削刃長 L：6.4　　刀片厚度 S：2.38

內接圓 IC：6.35　　螺釘孔徑 D1：2.8



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◆ 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

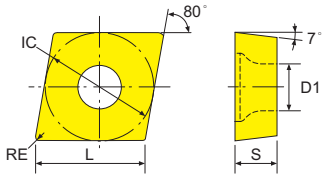
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet				
			P								P					M	K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
JO中切削 Medium	CCMT060204-JO	0.4				●	●	●				●	●	●					●			●		●						
	CCMT060208-JO	0.8					●	●					●	●					●			●		●						
GO中切削 Medium	CCMT060204-GO	0.4														●	●													
	CCMT060208-GO	0.8														●	●													
EC精切削 Finishing	CCMT060204-EC	0.4													●	●	●													
	CCMT060208-EC	0.8															●													
NE鋁切削 Aluminum	CCGT060202-NE	0.2															●													
	CCGT060204-NE	0.4															●													
CJH中輕切削 Mid and light cutting	CCMT060204-CJH	0.4												●		●												●		
	CCMT060208-CJH	0.8												●																

CC

尺寸 Dimension

切削刃長 L：9.7　　刀片厚度 S :3.97

內接圓 IC：9.525　螺釘孔徑 D1 :4.4



◆ 材質介紹→參考A04頁
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◆ 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

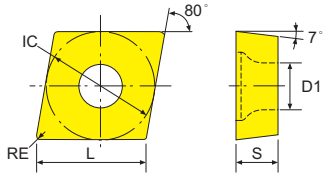
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					
			P								P					M		K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
CJH中輕切削 Mid and light cutting	CCMT09T304-CJH	0.4												●														●		
	CCMT09T308-CJH	0.8												●														●		
JO中切削 Medium	CCMT09T304-JO	0.4				●	●	●	●	●		●	●									●		●						
	CCMT09T308-JO	0.8				●	●	●				●	●						●	●		●		●						
JT中切削 Medium	CCMT09T304-JT	0.4									●																			
	CCMT09T308-JT	0.8									●													●						
GO中切削 Medium	CCMT09T304-GO	0.4														●	●													
	CCMT09T308-GO	0.8														●	●													
EC精切削 Finishing	CCMT09T304-EC	0.4														●														
	CCMT09T308-EC	0.8														●														
NE鋁切削 Aluminum	CCGT09T304-NE	0.4															●								●					

CC

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 :5.5



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◆ 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	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					
			P								P					M		K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
NE鋁切削 Aluminum	CCGT120404-NE	0.4															●													
	CCGT120408-NE	0.8															●													

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 :5.56

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					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
GO中切削 Medium	CCMT120404-GO	0.4														●														
	CCMT120408-GO	0.8																												
JO中切削 Medium	CCMT120404-JO	0.4				●					●	●																		
	CCMT120408-JO	0.8				●					●	●							●											

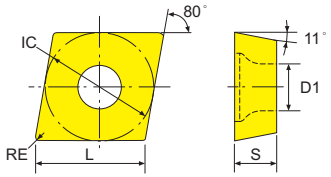
形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	塗層硬質合金 Carbide Coated									金屬陶瓷 Cermet
							P									
							ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	BEF607	BEF707	AC530U	T1500A
精切削 Finishing	CCET03X104L	0.4	3.55	3.5	1.4	1.8										●
	CCET04X104L	0.4	4.37	4.3	1.8	2.3										●
	CCET03X104L-FY	0.4	3.55	3.5	1.4	1.9	●									
	CCET04X104L-FY	0.4	4.37	4.3	1.8	2.3	●									

CP

尺寸 Dimension

切削刃長 L：9.7　　刀片厚度 S :3.18

內接圓 IC：9.525　螺釘孔徑 D1 :4.4



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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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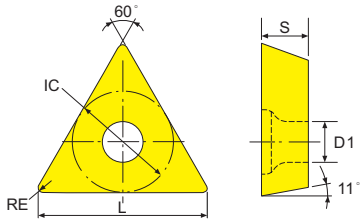
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					
			P								P						M	K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
中粗切削 Medium and roughing	CPMT090308	0.8										●	●						●											
HI中粗切削 Medium and roughing	CPMT090304-HI	0.4					●	●											●											
	CPMT090308-HI	0.8					●	●				●							●											
HS中粗切削 Medium and roughing	CPMT090304-HS	0.4										●	●																	
	CPMT090308-HS	0.8					●	●				●	●						●			●								

TP

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



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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	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet				
			P								P						M		K				N				鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
精切削 Finishing	TPGH090202L	0.2																									●			
	TPGH090204L	0.4																									●			
	TPGT090204L	0.4																									●			
精切削 Finishing	TPGT090204-SV	0.4										●	●																	

尺寸 Dimension

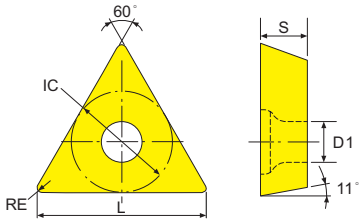
切削刃長 L：11　　刀片厚度 S：3.18

內接圓 IC：6.35　　螺釘孔徑 D1：3.4

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				鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
精切削 Finish	TPGH110302L	0.2																									●			
	TPGH110304L	0.4																									●			
	TPGT110304L-U	0.4																											●	

TP

尺寸 Dimension	
切削刃長 L：11	刀片厚度 S :3.18
內接圓 IC：6.35	螺釘孔徑 D1 :3.4



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◆ 斷削槽選擇→參考A06-A08頁
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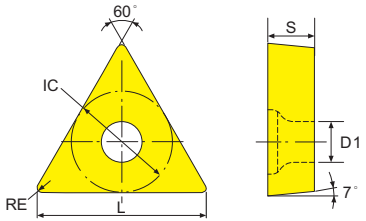
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																			金屬陶瓷 Cermet					鍍鈦 Titanium Plating
			P								P						M	K				N					
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
EV中切削 Medium	TPMT110304N-EV	0.4				●	●				●	●					●			●									
	TPMT110308N-EV	0.8				●					●	●					●			●									

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



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◆ 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	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					
			P								P					M		K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	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

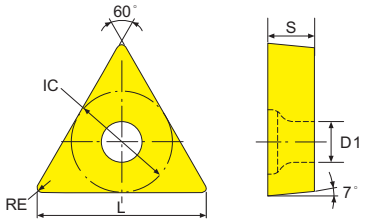
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					
			P								P					M		K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
NE鋁切削 Aluminum	TCGT090204-NE	0.4															●													

TC

尺寸 Dimension

切削刃長 L：11　　刀片厚度 S：2.38

內接圓 IC：6.35　　螺釘孔徑 D1：2.8



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◆ 斷削槽選擇→參考A06-A08頁
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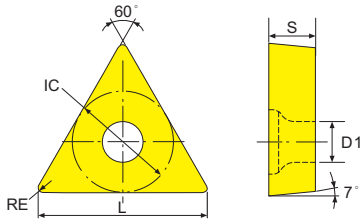
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					
			P							P					M		K				N							
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	BEF607	BEF707	ECM100	ECM200	BE4875	BEF706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BEJ757	BG656	W35	BQJ606	BQW706	E1500	BQJ606F 鍍鈦 Titanium Plating
NE鋁切削 Aluminum	TCGT110204-NE	0.4														●										●					
CJH中輕切削 Mid and light cutting	TCMT110204-CJH	0.4											●																		
	TCMT110208-CJH	0.8											●																		
GO中切削 Medium	TCMT110204-GO	0.4													●	●		●						●							
	TCMT110208-GO	0.8													●	●		●						●							
JO中切削 Medium	TCMT110204-JO	0.4				●	●			●	●		●	●				●			●		●								
	TCMT110208-JO	0.8				●	●			●	●		●								●										

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



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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	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					鍍鈦 Titanium Plating
			P							P					M		K					N						
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BEJ757	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
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

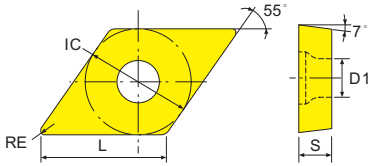
切削刃長 L：22　　刀片厚度 S：4.76

內接圓 IC：12.7　螺釘孔徑 D1：5.5

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					鍍鈦 Titanium Plating
			P							P					M		K					N						
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BEJ757	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
輕切削 Light cutting	TCMT220408	0.8										●																		

DC

尺寸 Dimension	
切削刃長 L：7.8	刀片厚度 S :2.38
內接圓 IC：6.35	螺釘孔徑 D1 :2.8



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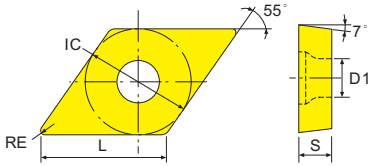
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet				
			P								P				M		K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
CJH中輕切削 Mid and light cutting	DCMT070204-CJH	0.4												●														●		
	DCMT070208-CJH	0.8												●														●		
GO中切削 Medium	DCMT070204-GO	0.4														●	●													
	DCMT070208-GO	0.8														●	●													
JH中輕切削 Mid and light cutting	DCMT070204-JH	0.4														●														
	DCMT070208-JH	0.8																												●
JO中切削 Medium	DCMT070204-JO	0.4				●	●			●	●										●									
	DCMT070208-JO	0.8				●	●			●	●										●									
NE鋁切削 Aluminum	DCGT070202-NE	0.2															●								●					
	DCGT070204-NE	0.4															●								●					
UH精切削 Finishing	DCGT070202-UH	0.2																										●		
	DCGT070204-UH	0.4																										●		

DC

尺寸 Dimension

切削刃長 L：11.6　刀片厚度 S :3.97

內接圓 IC：9.525　螺釘孔徑 D1 :4.4



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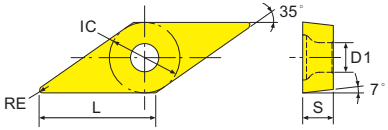
			塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet				
			P								P					M		K					N				鍍鈦 Titanium Plating
形狀 Shape	型號 Model No	刀尖半徑 RE	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
CJH中輕切削 Mid and light cutting	DCMT11T304-CJH	0.4												●														●		
	DCMT11T308-CJH	0.8												●																
GO中切削 Medium	DCMT11T304-GO	0.4														●	●													
	DCMT11T308-GO	0.8														●	●													
JH中輕切削 Mid and light cutting	DCMT11T304-JH	0.4																												●
	DCMT11T308-JH	0.8																												
JO中切削 Medium	DCMT11T304-JO	0.4				●	●	●			●	●										●		●						
	DCMT11T308-JO	0.8					●	●			●	●										●								
NE鋁切削 Aluminum	DCGT11T304-NE	0.4															●													
	DCGT11T308-NE	0.8															●													
UH精切削 Finishing	DCGT11T302-UH	0.2																									●		●
	DCGT11T304-UH	0.4																									●		●
	DCGT11T308-UH	0.8																									●		●

VC

尺寸 Dimension

切削刃長 L：11　　刀片厚度 S :3.18

內接圓 IC：6.35　螺釘孔徑 D1 :2.8



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◆ 切削條件→參考A09頁
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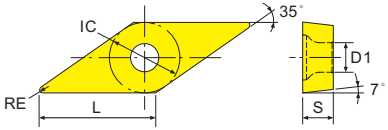
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet					
			P								P					M		K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ759	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
NE鋁切削 Aluminum	VCGT110302-NE	0.2															●								●					
	VCGT110304-NE	0.4															●													
EC中輕切削 Mid and light cutting	VCGT110304R-EC	0.4										●	●					●	●											
UH精切削 Finishing	VCGT110302-UH	0.2																												●
	VCGT110304-UH	0.4																												●
HH中輕切削 Mid and light cutting	VCMT110304-HH	0.4				●	●					●	●									●								

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



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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

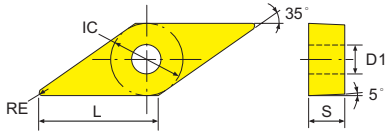
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																			金屬陶瓷 Cermet					
			P								P					M		K				N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
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鋁切削 Aluminum	VCGT160402-NE	0.2														●													
	VCGT160404-NE	0.4														●													
	VCGT160408-NE	0.8														●													
	VCGT160412-NE	1.2														●													

VB

尺寸 Dimension

切削刃長 L：11　　刀片厚度 S :3.18

內接圓 IC：6.35　螺釘孔徑 D1 :2.8



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◆ 斷削槽選擇→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　　金屬陶瓷 Cermet

形狀 Shape	型號 Model No	刀尖半徑 RE	P								P				M			K				N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
GO中切削 Medium	VBMT110304-GO	0.4														●	●													
	VBMT110308-GO	0.8								●						●	●													

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

塗層硬質合金 Carbide Coated　　金屬陶瓷 Cermet

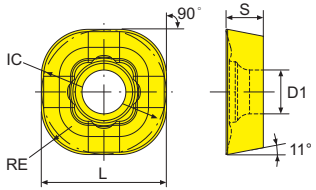
形狀 Shape	型號 Model No	刀尖半徑 RE	P								P				M			K				N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
中輕切削 Mid and light cutting	VBMT160404	0.4				●	●					●										●								
	VBMT160408	0.8					●						●									●								
GH中切削 Medium	VBMT160404-GH	0.4														●														
	VBMT160408-GH	0.8														●														
EC精切削 Finishing	VBMT160404-EC	0.4														●														
	VBMT160408-EC	0.8														●														

SP

尺寸 Dimension

切削刃長 L：8　　刀片厚度 S：2.38

內接圓 IC：8　　螺釘孔徑 D1：2.8



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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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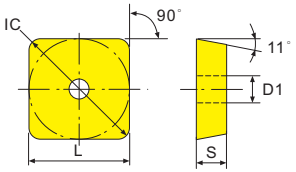
塗層硬質合金 Carbide Coated　　金屬陶瓷 Cermet

形狀 Shape	型號 Model No	刀尖半徑 RE	P ECP3015	P ECP3025	P ECP3035	P ECP100	P ECP200	P ECP300	P ECP3025	P BEF607	P BEF707	P ECM100	P ECM200	P BE4875	P BEP706	P BEJ750	P BEJ757	P BEJ758	M ECM2020	K ECK1005	K ECK100	K ECK200	K ECK300	K BEG607	N BG656	W35	BQJ606	BQW706	E1500	鍍鈦 Titanum Plating BQJ606F
中切削 Medium	SPMX080230-MM	3										●	●																	

尺寸 Dimension

切削刃長 L：12.7　　刀片厚度 S：3.18

內接圓 IC：12.7



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	P ECP3015	P ECP3025	P ECP3035	P ECP100	P ECP200	P ECP300	P ECP3025	P BEF607	P BEF707	P ECM100	P ECM200	P BE4875	P BEP706	P BEJ750	P BEJ757	P BEJ758	M ECM2020	K ECK1005	K ECK100	K ECK200	K ECK300	K BEG607	N BG656	W35	BQJ606	BQW706	E1500	鍍鈦 Titanum Plating BQJ606F
	SPUN120308	0.8					●	●				●			●	●			●											

尺寸 Dimension

切削刃長 L：15.875 刀片厚度 S：4.76

內接圓 IC：15.875

塗層硬質合金 Carbide Coated　　金屬陶瓷 Cermet

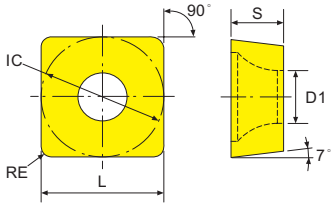
形狀 Shape	型號 Model No	刀尖半徑 RE	P ECP3015	P ECP3025	P ECP3035	P ECP100	P ECP200	P ECP300	P ECP3025	P BEF607	P BEF707	P ECM100	P ECM200	P BE4875	P BEP706	P BEJ750	P BEJ757	P BEJ758	M ECM2020	K ECK1005	K ECK100	K ECK200	K ECK300	K BEG607	N BG656	W35	BQJ606	BQW706	E1500	鍍鈦 Titanum Plating BQJ606F
	SPKN1504EDTR-F3	0.4										●	●																	

SC

尺寸 Dimension

切削刃長 L：9.525　刀片厚度 S：3.97

內接圓 IC：9.525　螺釘孔徑 D1：4.4



◆ 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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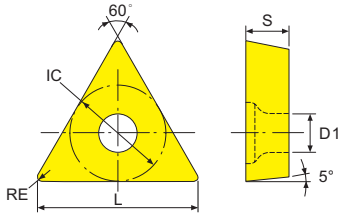
形狀 Shape	型號 Model No	刀尖半徑 RE	塗層硬質合金 Carbide Coated																					金屬陶瓷 Cermet					
			P								P					M		K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
CJH中輕切削 Mid and light cutting	SCMT09T304-CJH	0.4												●																
	SCMT09T308-CJH	0.8												●																
JT粗切削 Roughing	SCMT09T304-JT	0.4														●	●							●						●
	SCMT09T308-JT	0.8															●													
JO中切削 Medium	SCMT09T304-JO	0.4				●	●					●										●								
	SCMT09T308-JO	0.8						●				●										●								
HH中輕切削 Mid and light cutting	SCMT09T304-HH	0.4				●					●	●							●											

TB

尺寸 Dimension

切削刃長 L：6.4　　刀片厚度 S：1.59

內接圓 IC：3.97　　螺釘孔徑 D1：2.2



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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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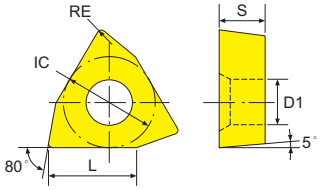
塗層硬質合金 Carbide Coated　　金屬陶瓷 Cermet

形狀 Shape	型號 Model No	刀尖半徑 RE	P								P					M		K					N					鍍鈦 Titanium Plating
			ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ657	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
精切削 Finishing	TBGH060102L	0.2															●										●			
	TBGH060104L	0.4															●										●			
精切削 Finishing	TBGT060102L-U	0.2																											●	
	TBGT060104L-U	0.4																											●	

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



◆ 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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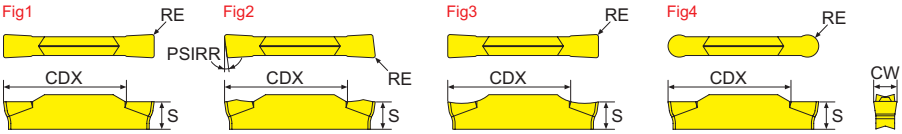
			塗層硬質合金 Carbide Coated																				金屬陶瓷 Cermet				
			P								P						M	K					N				鍍鈦 Titanium Plating
形狀 Shape	型號 Model No	刀尖半徑 RE	ECP3015	ECP3025	ECP3035	ECP100	ECP200	ECP300	ECP3025	BEF607	BEF707	ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECM2020	ECK1005	ECK100	ECK200	ECK300	BEG607	BG656	W35	BQJ606	BQW706	E1500	BQJ606F
精切削 Finishing	WBGT060104L-U	0.4																								●			●	

ECH 新規格上市 New Specification Arrival



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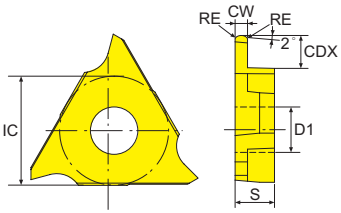
形狀 Shape	型號 Model No	圖解 Fig	刀片厚度 S±0.1	刀尖半徑 RE ±0.10	切削寬度 CW	最大加工槽滿深度 CDX	右側主偏角 PSIRR	塗層硬質合金 Carbide Coated										金屬陶瓷 Cermet			
								P		P				M			N				
								ECP200	BEF606	ECM200	ECM100	ECM2020	ECM2010	BG756	BEJ857	BEF4875	BEJ750	BEJ767	W35	BQJ606	BQW706	BQJ6060F
	ECH200	1	4.59	0.2	2	17	–	●			●											
	ECH300	1	4.62	0.3	3	17	–	●		●	●											
	ECH400	1	4.7	0.4	4	22	–	●			●											
	ECH500	1	4.85	0.4	5	22	–	●			●											
NEW	ECH300-MM-6R	2	4.62	0.2	3	17	6					●	●									
	ECH150-OO	1	3.53	0.2	1.5	12	–										●					
	ECH200-OO-8R	2	4.4	0.2	2	14	8											●				
	ECH300-OO	1	4.8	0.3	3	17	–										●					
	ECH400-OO	1	4.7	0.4	4	22	–										●					
	ECH500-OO	1	4.85	0.4	5	22	–									●	●					
	ECH200-OI	1	4.59	0.2	2	17	–										●					
	ECH300-OI	1	4.62	0.3	3	17	–		●							●	●	●				●
	ECH300-OI-6R	2	4.62	0.3	3	17	6								●	●						
	ECH300-OI-15R	2	4.62	0.3	3	17	15									●		●				
	ECH400-OI	1	4.7	0.4	4	22	–		●						●		●	●				●
	ECH500-OI	1	4.85	0.4	5	22	–		●						●		●	●				
	ECH600-OI	1	5.1	0.8	6	22	–								●		●	●				

※ 請接下頁。 ※ Continued on next page.

形狀 Shape	型號 Model No	圖解 Fig	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	右側主偏角 PSIRR	塗層硬質合金 Carbide Coated										金屬陶瓷 Cermet			
								P		P					M		N				
								ECP200	BEF606	ECM200	ECM100	ECM2020	ECM2010	BG756	BEJ857	BEF4875	BEJ750	BEJ767	W35	BQJ606	BQW706	BQJ6060F
NEW	ECH300-SG	3	4.62	0.3	3	17	–					●	●									
圓頭切斷刀片 Round edge grooving insert	ECR300-OI	4	4.62	1.5	3	17	–									●	●					
	ECR400-OI	4	4.7	2	4	22	–										●					
	ECR500-OI	4	4.85	2.5	5	22	–								●		●					
	ECR600-OI	4	5.1	3	6	22	–								●		●					

EC 新規格上市 New Specification Arrival



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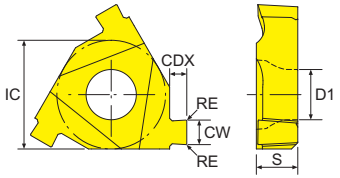
形狀 Shape	型號 Model No	刀尖半徑 RE	內接圓 IC	最大加工槽溝深度 CDX	切削寬度 CW±0.05	刀片厚度 S	螺釘孔徑 D1	塗層硬質合金 Carbide Coated P M ECM120	BEJ750	金屬陶瓷 Cermet E1200
	NEW EC16R090-R025	0.25	9.525	2	0.9	3.18	4.4	●		
	EC16R100-R005	0.05	9.525	2	1	3.18	4.4	●	●	●
	EC16R125-R02	0.2	9.525	2	1.25	3.18	4.4	●	●	●
	EC16R145-R02	0.2	9.525	2	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	●	●	●
	NEW EC22R075-R01	0.1	12.7	2	0.75	4.76	5.5	●	●	●
	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		●	●

※ 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 P ECM120	塗層硬質合金 Carbide Coated M BEJ750	金屬陶瓷 Cermet E1200
	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	●	●	●
	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



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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	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 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	●

插槽刀片識別系統

Slotting Insert Identification System

ADG04R100-WB -010

1 2 3 4 5 6 7 8

1 廠牌 Brand
2 螺絲孔 Screw Hole
3 刀片類型 Insert Type
4 加工直徑 Machining Diameter
5 進刀變換 Feed Type
6 切削寬度 Cutting Width
7 排屑槽造型 Chipbreaker Design
8 刀尖R角 Nose Radius

1 廠牌 Brand

記號 Symbol	名 稱 Name
A	益詮牌 ECHAIN Brand

2 螺絲孔 Screw Hole

記號 Symbol	樣 式 Type
S	單孔 Single Hole
D	雙孔 Double Hole

3 刀片類型 Insert Type

記號 Symbol	樣 式 Type
G	切槽刀 / 切斷刀 Single Hole
I	牙刀 Tooth Type
K	圓槽刀 Round Groove
X	前掃刀 / 後掃刀 R Front Insert / Rear Insert

4 加工直徑 Machining Diameter

記號 Symbol	加工直徑 Machining Diameter
04	4mm
06	6mm
08	8mm
12	12mm
16	16mm

5 進刀變換 Feed Type

記號 Symbol	方 向 Feature
R	右手刀 Right Hand
L	左手刀 Left Hand

6 切削寬度 Cutting Width

記號 Symbol	切削寬度 Cutting Widthr
100	1.0mm
150	1.5mm
200	2.0mm
250	2.5mm
300	3.0mm
350	3.5mm
400	4.0mm

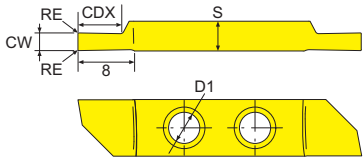
7 排屑槽造型 Chipbreaker Design

記號 Symbol	特 徵 Feature
GB	有排屑槽 With
WB	無排屑槽 With Chipoker

8 刀尖R角 Nose Tadius

記號 Symbol	尺 寸 Radus
—	R0
010	R0.1
020	R0.2

ADG



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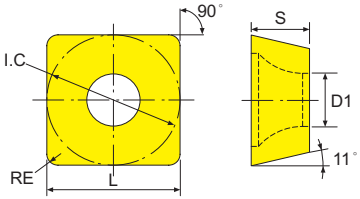
新品上市 New Arrival

塗層硬質合金
Carbide Coated

形狀 Shape		型號 Model No	刀尖半徑 RE	最大加工槽溝深度 CDX	切削寬度 CW	刀片厚度 S	螺釘孔徑 D1	P M ECM120
	NEW	ADG04R100-WB	—	2	1	4.2	4.4	
	NEW	ADG04R100-WB-010	0.1	2	1	4.2	4.4	
	NEW	ADG06R150-WB	—	3	1.5	4.2	4.4	
	NEW	ADG06R150-WB-010	0.1	3	1.5	4.2	4.4	
	NEW	ADG06R150-WB-020	0.2	3	1.5	4.2	4.4	
	NEW	ADG08R200-WB	—	4	2	4.2	4.4	
	NEW	ADG08R200-WB-010	0.1	4	2	4.2	4.4	●
	NEW	ADG08R200-WB-020	0.2	4	2	4.2	4.4	
	NEW	ADG12R250-WB-010	0.1	6	2.5	4.2	4.4	
	NEW	ADG12R250-WB-020	0.2	6	2.5	4.2	4.4	
	NEW	ADG16R300-WB-010	0.1	8	3	4.2	4.4	
	NEW	ADG16R300-WB-020	0.2	8	3	4.2	4.4	●
	NEW	ADG16R400-WB	—	8	4	4.2	4.4	

SPMT



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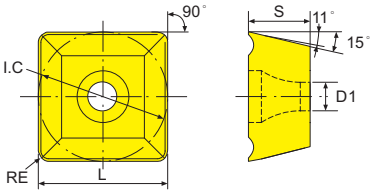
塗層硬質合金 Carbide Coated

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	P			P/M			K		N
							ECP3015	ECP3025	ECP3035	ECM200	BEJ750	BEP706	ECK200	BEG607	BEJ757
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				●					

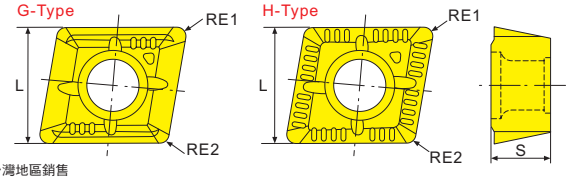
SPGT



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	P				P/M			K			
							ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECK100	ECK200	ECK300	BEG607
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



●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

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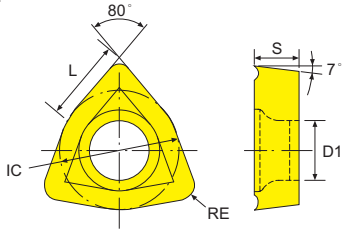
形狀 Shape	型號 Model No	刀尖半徑 RE 1	刀尖半徑 RE 2	切削刃長 L	刀片厚度 S	塗層硬質合金 Carbide Coated								
						P		P/M	K		K/M	P	P/M	N
						ACP100	ACP200	ACP300	ACK300	ACK310	ACK200	ACZ350	ACZ330	DL1500
＊◎ G-Type	WDXT042004-G	0.4	0.4	4.2	2			●	●					●
	WDXT042004-H	0.4	0.4	4.2	2			●	●					
	WDXT052504-G	0.4	0.4	5	2.5			●	●					●
	WDXT052504-H	0.4	0.4	5	2.5			●	●					
	WDXT063006-G	0.6	0.6	6	3			●	●					●
＊◎ H-Type	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



●標準庫存 ＊僅限中國地區銷售 ◎僅限台灣地區銷售
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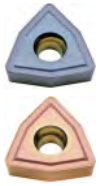
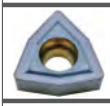
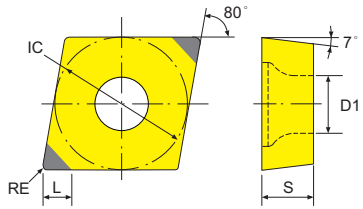
塗層硬質合金 Carbide Coated

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	P ECM100	P/M ECM2020	P/M BEJ750	K ACK200	K ACK300	K/M ACZ310	P ACZ330	P/M ACZ350	K/N H1	N BG656
＊◎	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	●									
	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



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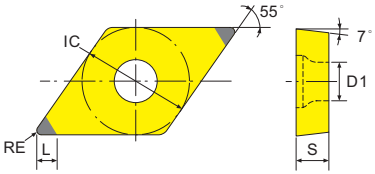
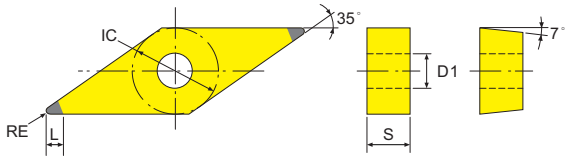
形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	塗層硬質合金 Carbide Coated CBN100
	CCGW060202-2C	0.2	2.5	6.35	2.38	2.8	●
	CCGW060204-2C	0.4	2.5	6.35	2.38	2.8	●
	CCGW09T302-2C	0.2	2.5	9.525	3.97	4.4	●
	CCGW09T304-2C	0.4	2.5	9.525	3.97	4.4	●
	CNGA120404-2C	0.4	2.5	12.7	4.76	5.16	●
	CNGA120408-2C	0.8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



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 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



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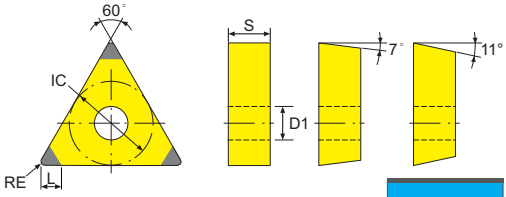
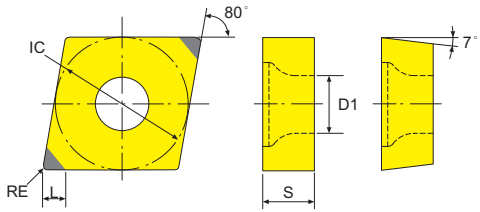
形狀 Shape	型號 Model No	刀尖半徑 RE	切削刃長 L	內接圓 IC	刀片厚度 S	螺釘孔徑 D1	CBN100
	VCGW160404-2C	0.4	3.3	9.525	4.76	4.4	●
	VCGW160408-2C	0.8	2.8	9.525	4.76	4.4	●
	VNGA160404-2C	0.4	2.8	9.525	4.76	3.81	●
	VNGA160408-2C	0.8	2.5	9.525	4.76	3.81	●



形狀 Shape	型號 Model No	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
	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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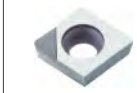
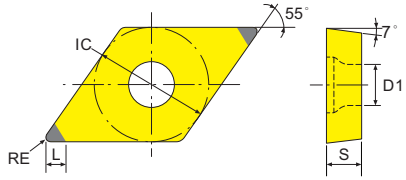
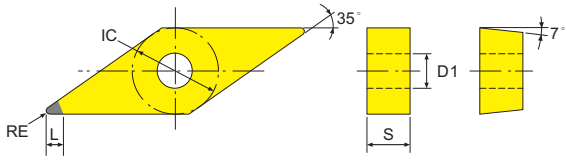
Cutting condition Ref.Page-A09

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
	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	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
	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

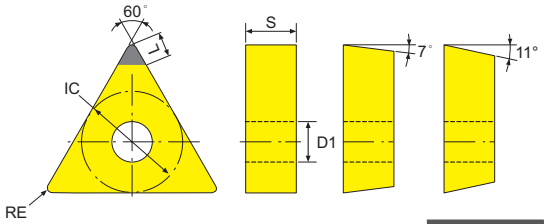


◆ 材質介紹→參考A04頁
Grade Ref.Page-A04

◆ 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

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	E	R	- 1.5	ISO
1	2	2	3	4
1 刀片長度 Insert Size	2 刀片型式 Insert Type	2 刀片方向 Insert Direction	3 牙 距 Pitch	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

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

3 牙 距 Pitch

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

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 Grdae		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 Prcessing Material	刀片材質 & 加工條件(Vc) Inseret Material & Processing Condition			
	ECM2520	ECM2525 / ECM2530	BEJ758	EC400
P 鋼 Steel	Vc：70～140	Vc：60～120	Vc：70～110	Vc：50～100
M 不鏽鋼 Stainless Steel	Vc：60～120	Vc：50～100	Vc：40～90	Vc：40～80
K 鑄 鐵 Cast Iron	Vc：70～140	Vc：60～120	Vc：70～110	Vc：50～100
S 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

●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
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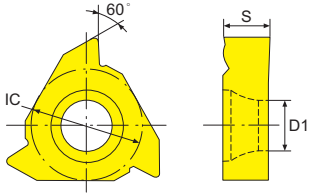
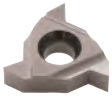
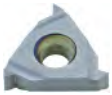
Chipbreaker Ref.Page-A06-A08

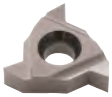
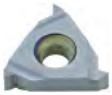
◆ 切削條件→參考A09頁
Cutting condition Ref.Page-A09



形狀 Shape	型號 Model No	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
	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	●			

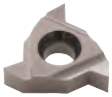
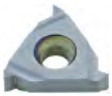
※ 請接下頁。 ※ Continued on next page.

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 EC400	BEJ758	M 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	P EC400	P BEJ758	M ECM2520	M 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	●			