SPEED TIGER

SOLID CARBIDE THREAD MILLS

TM

HIGH PERFORMANCE



TM Series INDEX索引

螺紋銑刀

Shape 刃部形狀	Flute 刃數	Type 刀型	Mode 品名	Photo 照片	Coating 塗層	Spec. 規格表	Cutting Condition 切削條件
Thread 螺紋	3~5	Thread Mill.ISO 2D ISO 2D 螺紋銑刀	TM		ZrN-A nACRo	170	201
Thread 螺紋	3~5	Thread Mill.ISO. 2D Coolant ISO 2D 螺紋銑刀/內冷	TMC			170	201
Thread 螺紋	3~5	Thread Mill.ISO.1.5D ISO1.5D 螺紋銑刀/有效	TMEL			171	201
Thread 螺紋	3~5	Thread Mill.ISO.1.5D Coolant ISO1.5D 螺紋銑刀 有效/內冷	TMCEL			171	201
Thread 螺紋	3~4	Thread Mill.ISO. 1.5D/2D/2.5D Chamfer ISO.1.5D/2D/2.5D 螺紋銑刀/倒角	TMCH			172	201
Thread 螺紋	3~4	Thread Mill.ISO. 1.5D/2D/2.5D Chamfer Coolant ISO.1.5D/2D/2.5D 螺紋銑刀/倒角/內冷	TMCHC			173	201
Thread 螺紋	3~4	3 Pitch Thread Mill.ISO. ISO. 3牙式螺紋銑刀	TM3ZT			174	202
Thread 螺紋	3	1 Pitch Miniature Thread Mill.ISO. ISO. 單牙微小徑螺紋銑刀	TMSM1ZT			175	202
Thread 螺紋	3~5	Internal / External Thread Mill 內外牙通用螺紋銑刀	TMPA			175	202
定製款螺紋銑刀 Customized Thread Mill							
Thread 螺紋	2	Thread Mill.ISO. Drill+ Chamfer ISO. 螺紋銑刀/鑽孔+倒角	TMCHD		-	176	-
Thread 螺紋	1~4	Full Profile Thread Mill.ISO ISO. 完整牙螺紋銑刀	TMFP		-	177	-

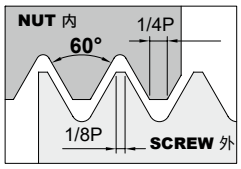
TM 螺紋銑刀系列

臺灣限定保固

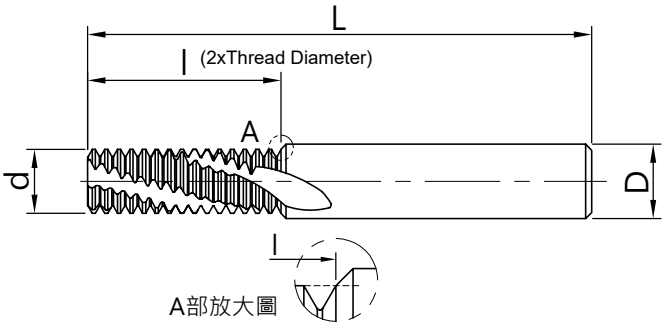
購買日起一年內斷刀保固，不限次數憑柄部更換正常磨耗除外。

TM - Thread Mill.ISO 2D
ISO 螺紋銑刀

ZrN-A nACRo 切削條件表 P201 Cutting Condition



ISO R262（DIN13）/6H

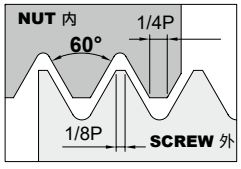




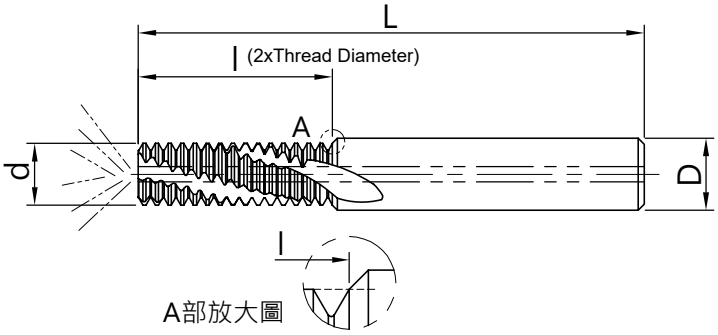
MODE	Thread Diameter	Pitch	Diameter	Thread Length	Full Length	Shank Diameter	No. of flutes	Coating		List Price
型號	M 螺紋	mm 螺距	d 刃徑	l 螺紋長度	L 全長	D 柄徑	z 刃數	ZrN-A	nACRo	最低售價
TM-M0305002303	M3	0.5	2.3	6.75	50	4	3	.03	.08	1870
TM-M0407003103	M4	0.7	3.1	8.75	50	4	3	.03	.08	1870
TM-M0508003803	M5	0.8	3.8	10.80	50	4	3	.03	.08	1870
TM-M0610004503	M6	1	4.5	13.50	65	6	3	.03	.08	2200
TM-M0812506004	M8	1.25	6	18.13	65	6	4	.03	.08	2200
TM-M1015007504	M10	1.5	7.5	21.75	80	8	4	.03	.08	2530
TM-M1217509504	M12	1.75	9.5	27.13	80	10	4	.03	.08	3080
TM-M1420010004	M14	2	10	31.00	80	10	4	.03	.08	3080
TM-M1620012005	M16	2	12	35.00	105	12	5	.03	.08	3630
TM-M2025016005	M20	2.5	16	43.75	105	16	5	.03	.08	4840
TM-M2430016005	M24	3	16	52.50	110	16	5	.03	.08	4840

TMC - Thread Mill.ISO. 2D Coolant
ISO 螺紋銑刀/內冷

ZrN-A nACRo 切削條件表 P201 Cutting Condition



ISO R262（DIN13）/6H



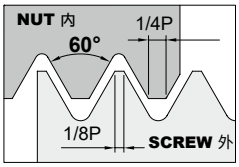


MODE	Thread Diameter	Pitch	Diameter	Thread Length	Full Length	Shank Diameter	No. of flutes	Coating		List Price
型號	M 螺紋	mm 螺距	d 刃徑	l 螺紋長度	L 全長	D 柄徑	z 刃數	ZrN-A	nACRo	最低售價
TMC-M0610004503	M6	1	4.5	13.50	65	6	3	.03	.08	2530
TMC-M0812506004	M8	1.25	6	18.13	65	6	4	.03	.08	2530
TMC-M1015007504	M10	1.5	7.5	21.75	80	8	4	.03	.08	2970
TMC-M1217509504	M12	1.75	9.5	27.13	80	10	4	.03	.08	3520
TMC-M1420010004	M14	2	10	31.00	80	10	4	.03	.08	3520
TMC-M1620012005	M16	2	12	35.00	105	12	5	.03	.08	4180
TMC-M2025016005	M20	2.5	16	43.75	105	16	5	.03	.08	5610
TMC-M2430016005	M24	3	16	52.50	110	16	5	.03	.08	5610

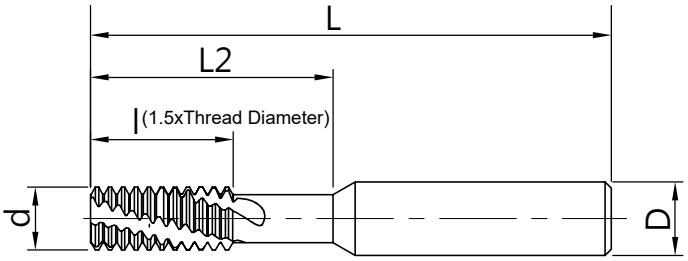
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TMEL - Thread Mill.ISO.1.5D
ISO 螺紋銑刀/有效

ZrN-A nACRo 切削條件表 P201 Cutting Condition



ISO R262（DIN13）/6H

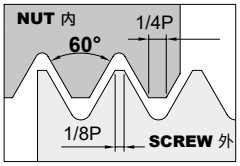




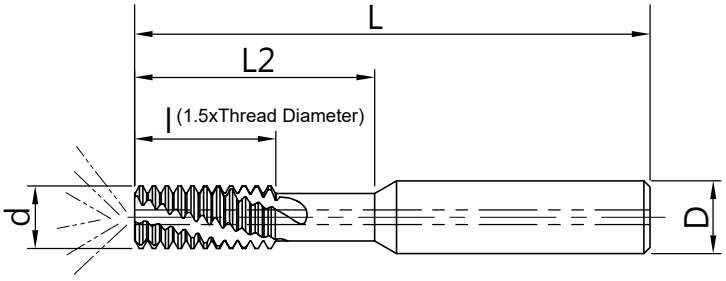
MODE	Thread Diameter	Pitch	Diameter	Thread Length	Full Length	Shank Diameter	No. of flutes	Effective Length	Coating		List Price
型號	M 螺紋	mm 螺距	d 刃徑	l 螺紋長度	L 全長	D 柄徑	z 刃數	L2 有效長度	ZrN-A	nACRo	最低售價
TMEL-M0305002303	M3	0.5	2.3	5.0	50	4	3	9.0	.03	.08	1980
TMEL-M0407003103	M4	0.7	3.1	7.0	50	4	3	12.0	.03	.08	1980
TMEL-M0508003803	M5	0.8	3.8	8.0	50	4	3	15.0	.03	.08	1980
TMEL-M0610004503	M6	1	4.5	10.0	65	6	3	18.0	.03	.08	2310
TMEL-M0812506004	M8	1.25	6	13.8	65	6	4	24.0	.03	.08	2420
TMEL-M1015007504	M10	1.5	7.5	16.5	80	8	4	30.0	.03	.08	2750
TMEL-M1217509504	M12	1.75	9.5	19.3	105	10	4	36.0	.03	.08	3300
TMEL-M1420010004	M14	2	10	24.0	105	10	4	42.0	.03	.08	3300
TMEL-M1620012005	M16	2	12	26.0	105	12	5	48.0	.03	.08	3960

TMCEL - Thread Mill.ISO.1.5D Coolant
ISO 螺紋銑刀/有效/內冷

ZrN-A nACRo 切削條件表 P201 Cutting Condition



ISO R262（DIN13）/6H

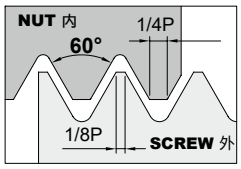




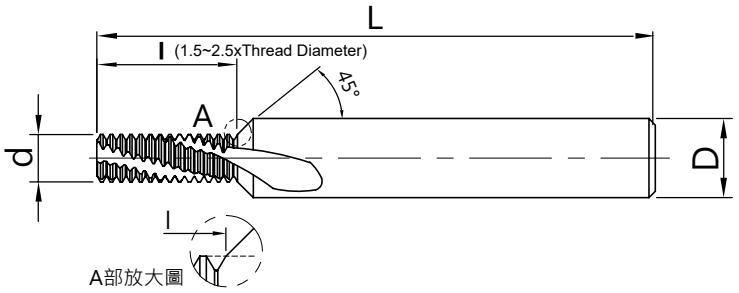
MODE	Thread Diameter	Pitch	Diameter	Thread Length	Full Length	Shank Diameter	No. of flutes	Effective Length	Coating		List Price
型號	M 螺紋	mm 螺距	d 刃徑	l 螺紋長度	L 全長	D 柄徑	z 刃數	L2 有效長度	ZrN-A	nACRo	最低售價
TMCEL-M0610004503	M6	1	4.5	10.0	65	6	3	18.0	.03	.08	2500
TMCEL-M0812506004	M8	1.25	6	13.8	65	6	4	24.0	.03	.08	2500
TMCEL-M1015007504	M10	1.5	7.5	16.5	80	8	4	30.0	.03	.08	2900
TMCEL-M1217509504	M12	1.75	9.5	19.3	105	10	4	36.0	.03	.08	3400
TMCEL-M1420010004	M14	2	10	24.0	105	10	4	42.0	.03	.08	3400
TMCEL-M1620012005	M16	2	12	26.0	105	12	5	48.0	.03	.08	4100

TMCH - Thread Mill.ISO.1.5D/2D/2.5D Chamfer
ISO 螺紋銑刀/倒角

ZrN-A nACRo 切削條件表 P201 Cutting Condition



ISO R262（DIN13）/6H



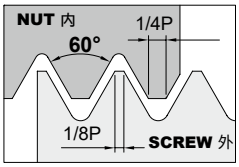


MODE	Thread Diameter	Pitch	Diameter	Thread Length	Full Length	Shank Diameter	No. of flutes	Coating		List Price
型號	M 螺紋	mm 螺距	d 刃徑	l 螺紋長度	L 全長	D 柄徑	z 刃數	ZrN-A	nACRo	最低售價
TMCH45-M0305002303(TL5.25)	M3 (1.5xD)	0.5	2.3	5.25	65	6	3	.03	.08	2530
TMCH45-M0305002303(TL6.75)	M3 (2xD)	0.5	2.3	6.75	65	6	3	.03	.08	2640
TMCH45-M0407003103(TL7.35)	M4 (1.5xD)	0.7	3.1	7.35	65	6	3	.03	.08	2530
TMCH45-M0407003103(TL8.75)	M4 (2xD)	0.7	3.1	8.75	65	6	3	.03	.08	2640
TMCH45-M0508003803(TL8.4)	M5 (1.5xD)	0.8	3.8	8.40	65	6	3	.03	.08	2530
TMCH45-M0508003803(TL10.8)	M5 (2xD)	0.8	3.8	10.80	65	6	3	.03	.08	2640
TMCH45-M0610004503(TL10.5)	M6 (1.5xD)	1	4.5	10.50	80	8	3	.03	.08	2970
TMCH45-M0610004503(TL13.5)	M6 (2xD)	1	4.5	13.50	80	8	3	.03	.08	3190
TMCH45-M0610004503(TL16.5)	M6 (2.5xD)	1	4.5	16.50	80	8	3	.03	.08	3300
TMCH45-M0812506004(TL14.38)	M8 (1.5xD)	1.25	6	14.38	80	10	4	.03	.08	3080
TMCH45-M0812506004(TL18.13)	M8 (2xD)	1.25	6	18.13	80	10	4	.03	.08	3190
TMCH45-M0812506004(TL21.88)	M8 (2.5xD)	1.25	6	21.88	80	10	4	.03	.08	3300
TMCH45-M1015007504(TL17.25)	M10 (1.5xD)	1.5	7.5	17.25	105	12	4	.03	.08	3520
TMCH45-M1015007504(TL21.75)	M10 (2xD)	1.5	7.5	21.75	105	12	4	.03	.08	3630
TMCH45-M1015007504(TL27.75)	M10 (2.5xD)	1.5	7.5	27.75	105	12	4	.03	.08	3850
TMCH45-M1217509504(TL20.13)	M12 (1.5xD)	1.75	9.5	20.13	105	14	4	.03	.08	4180
TMCH45-M1217509504(TL27.13)	M12 (2xD)	1.75	9.5	27.13	105	14	4	.03	.08	4400
TMCH45-M1217509504(TL32.38)	M12 (2.5xD)	1.75	9.5	32.38	105	14	4	.03	.08	4620

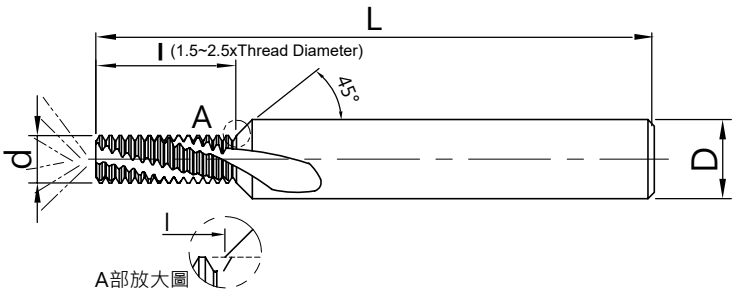
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TMCHC - Thread Mill.ISO.1.5D/2D/2.5D Chamfer Coolant
ISO 螺紋銑刀/倒角/內冷

ZrN-A nACRo 切削條件表 P201 Cutting Condition



ISO R262（DIN13）/6H

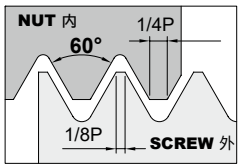




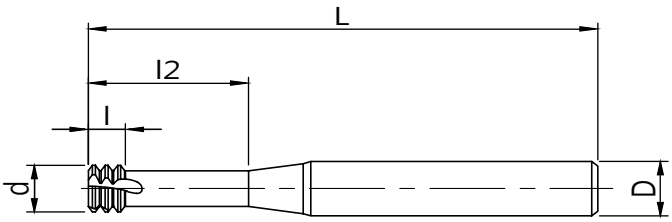
MODE	Thread Diameter	Pitch	Diameter	Thread Length	Full Length	Shank Diameter	No. of flutes	Coating		List Price
型號	M 螺紋	mm 螺距	d 刃徑	l 螺紋長度	L 全長	D 柄徑	z 刃數	ZrN-A	nACRo	最低售價
TMCHC45-M0508003803(TL8.4)	M5 (1.5xD)	0.8	3.8	8.40	65	6	3	.03	.08	2970
TMCHC45-M0508003803(TL10.8)	M5 (2xD)	0.8	3.8	10.80	65	6	3	.03	.08	3080
TMCHC45-M0610004503(TL10.5)	M6 (1.5xD)	1	4.5	10.50	80	8	3	.03	.08	3520
TMCHC45-M0610004503(TL13.5)	M6 (2xD)	1	4.5	13.50	80	8	3	.03	.08	3630
TMCHC45-M0610004503(TL16.5)	M6 (2.5xD)	1	4.5	16.50	80	8	3	.03	.08	3740
TMCHC45-M0812506004(TL14.38)	M8 (1.5xD)	1.25	6	14.38	80	10	4	.03	.08	3520
TMCHC45-M0812506004(TL18.13)	M8 (2xD)	1.25	6	18.13	80	10	4	.03	.08	3630
TMCHC45-M0812506004(TL21.88)	M8 (2.5xD)	1.25	6	21.88	80	10	4	.03	.08	3850
TMCHC45-M1015007504(TL17.25)	M10 (1.5xD)	1.5	7.5	17.25	105	12	4	.03	.08	4070
TMCHC45-M1015007504(TL21.75)	M10 (2xD)	1.5	7.5	21.75	105	12	4	.03	.08	4290
TMCHC45-M1015007504(TL27.75)	M10 (2.5xD)	1.5	7.5	27.75	105	12	4	.03	.08	4400
TMCHC45-M1217509504(TL20.13)	M12 (1.5xD)	1.75	9.5	20.13	105	14	4	.03	.08	4840
TMCHC45-M1217509504(TL27.13)	M12 (2xD)	1.75	9.5	27.13	105	14	4	.03	.08	5060
TMCHC45-M1217509504(TL32.38)	M12 (2.5xD)	1.75	9.5	32.38	105	14	4	.03	.08	5280

TM3ZT - 3 Pitch Thread Mill.ISO.
ISO 3牙式螺紋銑刀

ZrN-A nACRo 切削條件表 P202 Cutting Condition



ISO R262（DIN13）/6H



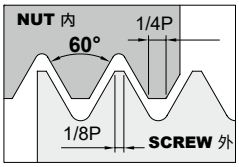


MODE	Thread Diameter	Pitch	Diameter	Thread Length	Full Length	Shank Diameter	No. of flutes	Effective Lengh	Coating		List Price
型號	M 螺紋	mm 螺距	d 刃徑	l 螺紋長度	L 全長	D 柄徑	z 刃數	L2 有效長度	ZrN-A	nACRo	最低售價
TM3ZT-M01603501203(EL3.2)	M1.6	0.35	1.2	1.05	50	4	3	3.2	.03	.08	1400
TM3ZT-M01603501203(EL4.8)	M1.6	0.35	1.2	1.05	50	4	3	4.8	.03	.08	1420
TM3ZT-M02004001523(EL4)	M2	0.4	1.52	1.20	50	4	3	4.0	.03	.08	1350
TM3ZT-M02004001523(EL6)	M2	0.4	1.52	1.20	50	4	3	6.0	.03	.08	1260
TM3ZT-M02204501603(EL4.4)	M2.2	0.45	1.6	1.35	50	4	3	4.4	.03	.08	1220
TM3ZT-M02204501603(EL6.6)	M2.2	0.45	1.6	1.35	50	4	3	6.6	.03	.08	1260
TM3ZT-M02504501903(EL5)	M2.5	0.45	1.9	1.35	50	4	3	5.0	.03	.08	1220
TM3ZT-M02504501903(EL7.5)	M2.5	0.45	1.9	1.35	50	4	3	7.5	.03	.08	1260
TM3ZT-M03005002303(EL6)	M3	0.5	2.3	1.50	50	4	3	6.0	.03	.08	1260
TM3ZT-M03005002303(EL9)	M3	0.5	2.3	1.50	50	4	3	9.0	.03	.08	1300
TM3ZT-M04007003103(EL8)	M4	0.7	3.1	2.10	50	4	3	8.0	.03	.08	1290
TM3ZT-M04007003103(EL12)	M4	0.7	3.1	2.10	50	4	3	12.0	.03	.08	1340
TM3ZT-M05008003803(EL10)	M5	0.8	3.8	2.40	50	4	3	10.0	.03	.08	1320
TM3ZT-M05008003803(EL15)	M5	0.8	3.8	2.40	50	4	3	15.0	.03	.08	1380
TM3ZT-M06010004504(EL12)	M6	1	4.5	3.00	50	6	4	12.0	.03	.08	1520
TM3ZT-M06010004504(EL18)	M6	1	4.5	3.00	60	6	4	18.0	.03	.08	1600
TM3ZT-M08012506004(EL16)	M8	1.25	6	3.75	60	6	4	16.0	.03	.08	1520
TM3ZT-M08012506004(EL24)	M8	1.25	6	3.75	60	6	4	24.0	.03	.08	1600
TM3ZT-M10015007504(EL20)	M10	1.5	7.5	4.50	60	8	4	20.0	.03	.08	1880
TM3ZT-M10015007504(EL30)	M10	1.5	7.5	4.50	75	8	4	30.0	.03	.08	1980
TM3ZT-M12017509504(EL24)	M12	1.75	9.5	5.25	75	10	4	24.0	.03	.08	2120
TM3ZT-M12017509504(EL36)	M12	1.75	9.5	5.25	100	10	4	36.0	.03	.08	2200

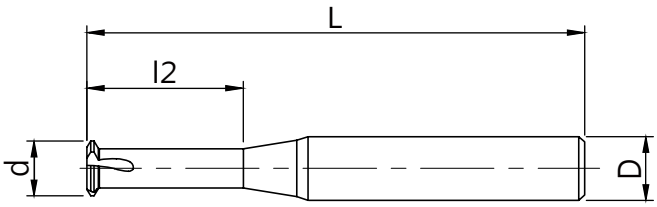
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TMSM1ZT - 1 Pitch Miniature Thread Mill.ISO.
ISO 單牙式微小徑螺紋銑刀

ZrN-A nACRo 切削條件表 P202 Cutting Condition



ISO R262（DIN13）/6H

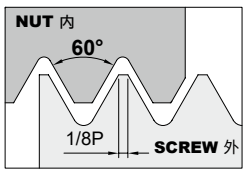


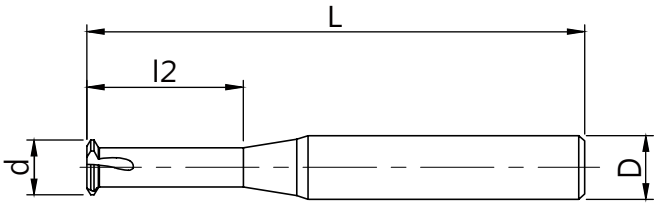


MODE	Thread Diameter	Pitch	Diameter	Full Length	Shank Diameter	No. of flutes	Effective Length	Coating		List Price
型號	M 螺紋	mm 螺距	d 刃徑	L 全長	D 柄徑	z 刃數	L2 有效長度	ZrN-A	nACRo	最低售價
TMSM1ZT-M01002500723	M1.0	0.25	0.72	50	4	3	3.1	.03	.08	1170
TMSM1ZT-M01202500903	M1.2	0.25	0.9	50	4	3	3.7	.03	.08	1170
TMSM1ZT-M01403001053	M1.4	0.3	1.05	50	4	3	4.3	.03	.08	1170
TMSM1ZT-M01603501203	M1.6	0.35	1.2	50	4	3	5.0	.03	.08	1120
TMSM1ZT-M02004001523	M2	0.4	1.52	50	4	3	6.2	.03	.08	1120
TMSM1ZT-M02204501603	M2.2	0.45	1.6	50	4	3	6.8	.03	.08	1120
TMSM1ZT-M02504501903	M2.5	0.45	1.9	50	4	3	7.8	.03	.08	1120
TMSM1ZT-M03005002303	M3	0.5	2.3	50	4	3	9.3	.03	.08	1120

TMPA - Internal / External Thread Mill
通用款內外牙60度螺紋銑刀

ZrN-A nACRo 切削條件表 P202 Cutting Condition





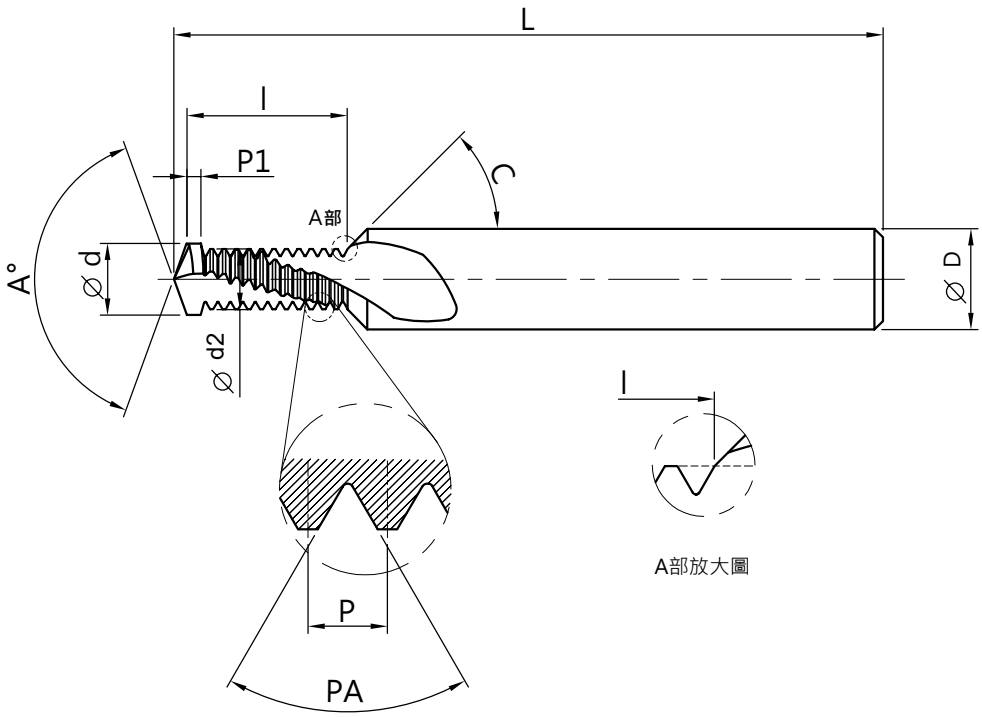


MODE	Pitch		Diameter	Thread Length	Full Length	Shank Diameter	No. of flutes	Effective Length	Coating		List Price
型號	mm	TPI	d 刃徑	l 螺紋長度	L 全長	D 柄徑	z 刃數	L2 有效長度	ZrN-A	nACRo	最低售價
TMPA60-035-0600195003	0.35-0.6	72-40	1.95	0.75	50	4	3	6.0	.03	.08	860
TMPA60-050-0770245003	0.5-0.8	48-32	2.45	0.75	50	4	3	7.7	.03	.08	860
TMPA60-050-1000315003	0.5-0.8	48-32	3.15	0.90	50	4	3	10.0	.03	.08	860
TMPA60-050-1200400003	0.5-1.0	48-24	4	1.05	50	4	3	12.0	.03	.08	860
TMPA60-050-1500470004	0.5-1.25	48-20	4.7	1.05	60	6	4	15.0	.03	.08	990
TMPA60-050-1800600004	0.5-1.25	48-20	6	1.20	60	6	4	18.0	.03	.08	1060
TMPA60-075-2400800004	0.75-1.5	32-16	8	1.20	60	8	4	24.0	.03	.08	1210
TMPA60-100-3001000005	1.0-2.5	24-10	10	1.35	75	10	5	30.0	.03	.08	1540
TMPA60-100-3601200005	1.0-2.5	24-10	12	1.35	100	12	5	36.0	.03	.08	1870

TMCHD - 2 Flutes Drill Thread Mill for Internal Threads
2刃鑽+銑+倒角多工能螺紋銑刀

訂製款
Customized





D = _____ C = _____

L = _____ l = _____

P = _____ P1 = _____

d = _____ d2 = _____

A = _____ PA = _____

M = _____
（螺紋尺寸）

Application 適用材質：

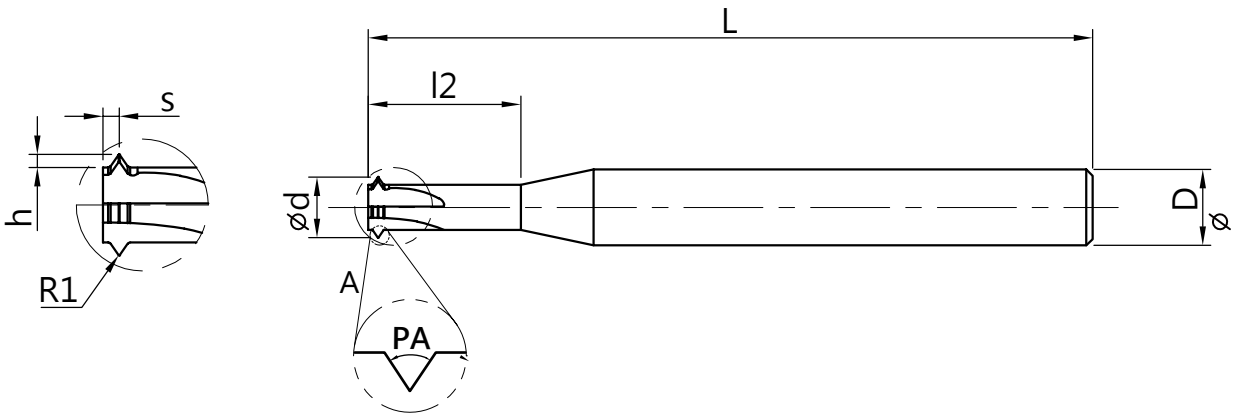
◎ Excellent 適合　○ Good 佳

Carbon steel, Alloy steel 炭素鋼 , 合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Cast iron 鑄鐵	Copper alloy 銅合金 , 銅	Aluminum alloy 鋁合金	Titanium alloy 鈦合金	Nickel/Inconel alloy 鎳基合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
							○		◎		

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TMFP - High Accuracy Full Profile Thread Mill
高精度全牙式螺紋銑刀

訂製款
Customized





D = _____ l2 = _____

L = _____ R1 = _____

S = _____ h = _____

d = _____ 刃數 = _____

PA = _____ M = _____ (螺紋尺寸)

☐ 無塗層 ☐ nACRo ☐ ZrN-A ☐ nACo

Application 適用材質：

◎ Excellent 適合 ○ Good 佳

Coating 塗層	Carbon steel, Alloy steel 炭素鋼，合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Cast iron 鑄鐵	Copper alloy 銅合金，銅	Aluminum alloy 鋁合金	Titanium alloy 鈦合金	Nickel/Inconel alloy 鎳基合金
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
nACRo	◎	◎	○				○	◎			○	○
ZrN-A	○	○					◎			○	○	○
nACo		◎	◎	◎	◎	○						

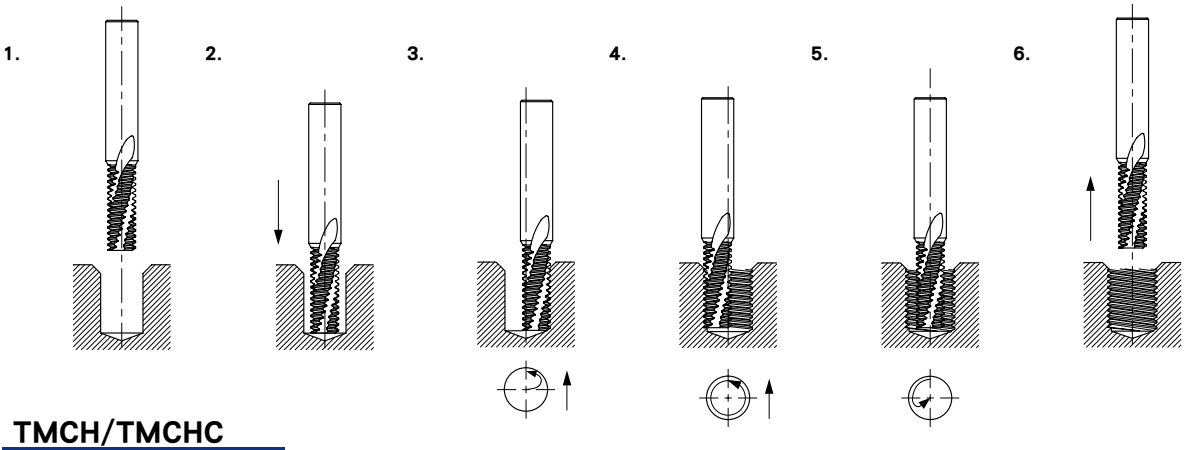
TM/TMC/TMEL/TMCEL/TMCH/TMCHC
TM/TMC/TMEL/TMCEL/TMCH/TMCHC 切削條件

產 品 規格表 P170-173
Specification page

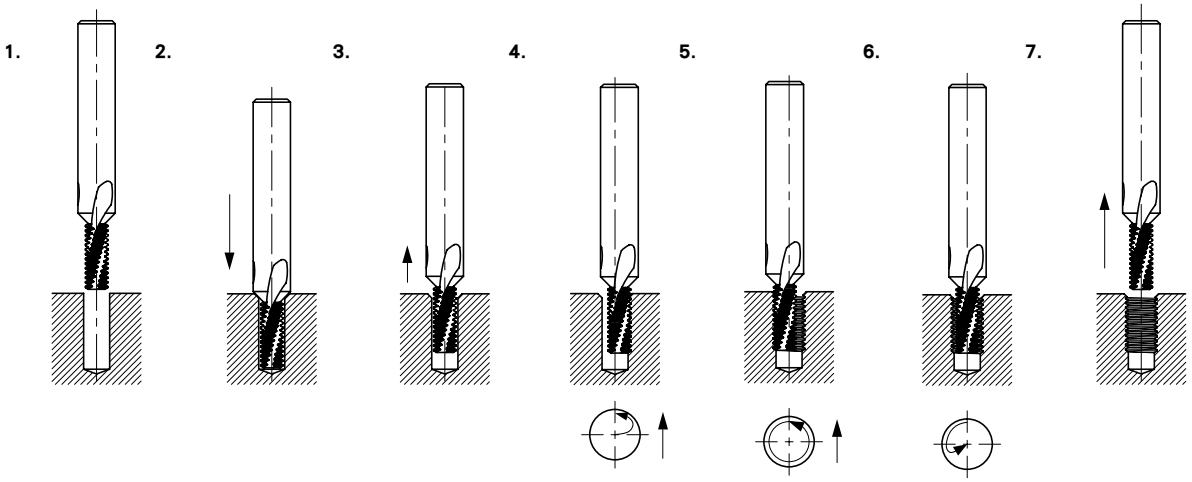
Work Material 被削材	SS400. AISI 1050. SCM等 一般構造鋼.碳素鋼. NON-ALLOYED STEELS ALLOY STEELS TOOL STEELS		AISI H13. AISI D2等 合金鋼.工具鋼 調質鋼 ALLOY STEELS HEAT RESISTANT STEELS		AISI 304 AISI 316等 沃斯田鐵、麻田 散鐵系 系列不銹鋼 STAINLESS STEELS		鑄鐵、球狀石墨鑄鐵 可延展性鑄鐵 FC250 等 CAST IRON		鋁鎂合金 鋁及鋁合金		特殊合金、 鈦及鈦合金 TITANUM ALLOYS	
HARDNESS 硬度	~30HRC		30~45HRC		~40HRC		≧240HB					
STRENGTH 抗拉強度	~1000 N/mm²		1000~1500 N/mm²		~950N/mm²						1300N/mm²	
Vc	50~220		30~100		50~140		60~140		80~280		15~80	
Diameter 直徑(mm)	fz (mm/z)		fz (mm/z)		fz (mm/z)		fz (mm/z)		fz (mm/z)		fz (mm/z)	
2	0.025	0.020	0.020	0.025	0.025	0.015	0.012	0.011	0.015	0.011	0.009	0.005
3	0.035	0.025	0.025	0.035	0.035	0.015	0.016	0.014	0.020	0.014	0.012	0.006
4	0.040	0.030	0.030	0.040	0.040	0.020	0.020	0.018	0.025	0.018	0.015	0.008
6	0.055	0.035	0.035	0.055	0.055	0.025	0.024	0.021	0.030	0.021	0.018	0.009
8	0.065	0.040	0.040	0.065	0.065	0.025	0.028	0.025	0.035	0.025	0.021	0.011
10	0.080	0.045	0.045	0.080	0.080	0.030	0.032	0.028	0.040	0.028	0.024	0.012
12	0.090	0.050	0.050	0.090	0.090	0.030	0.043	0.039	0.054	0.038	0.034	0.021
16	0.110	0.060	0.060	0.110	0.110	0.040	0.048	0.043	0.060	0.043	0.038	0.023
20	0.140	0.070	0.070	0.140	0.140	0.040	0.058	0.052	0.072	0.051	0.046	0.028
14	0.067	0.056	0.060	0.039	0.056	0.038	0.067	0.060	0.084	0.060	0.053	0.032
16	0.077	0.064	0.069	0.045	0.064	0.043	0.077	0.069	0.096	0.068	0.061	0.037
20	0.096	0.080	0.086	0.056	0.080	0.054	0.096	0.086	0.120	0.085	0.076	0.046

切削示範 Cutting Demonstration

TM/TMC/TMEL/TMCEL



TMCH/TMCHC



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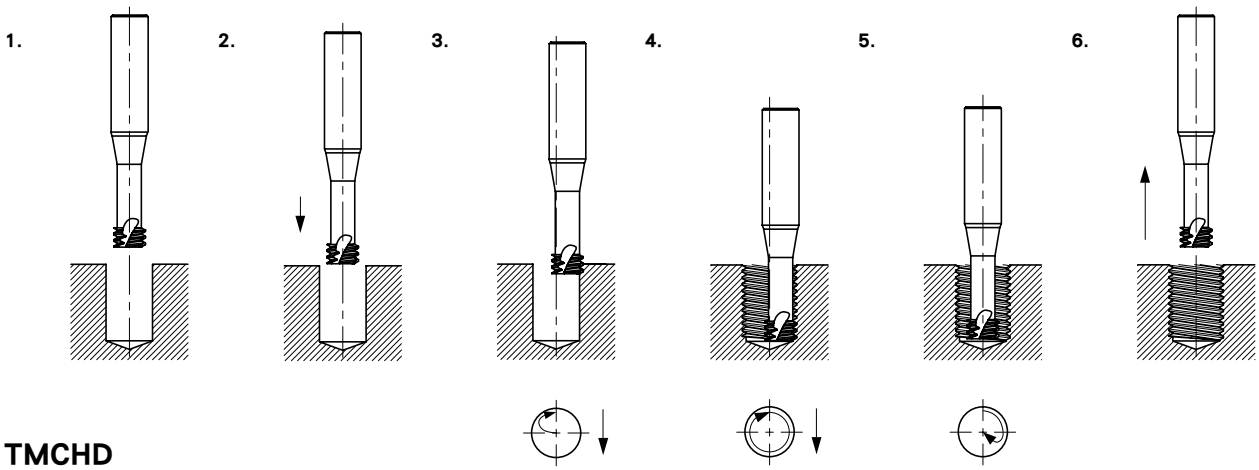
TM3ZT/TMSM/TMPA/TMCHD/TMFP Cutting Condition
TM3ZT/TMSM/TMPA/TMCHD/TMFP 切削條件

產 品 規格表 P174-175
Specification page

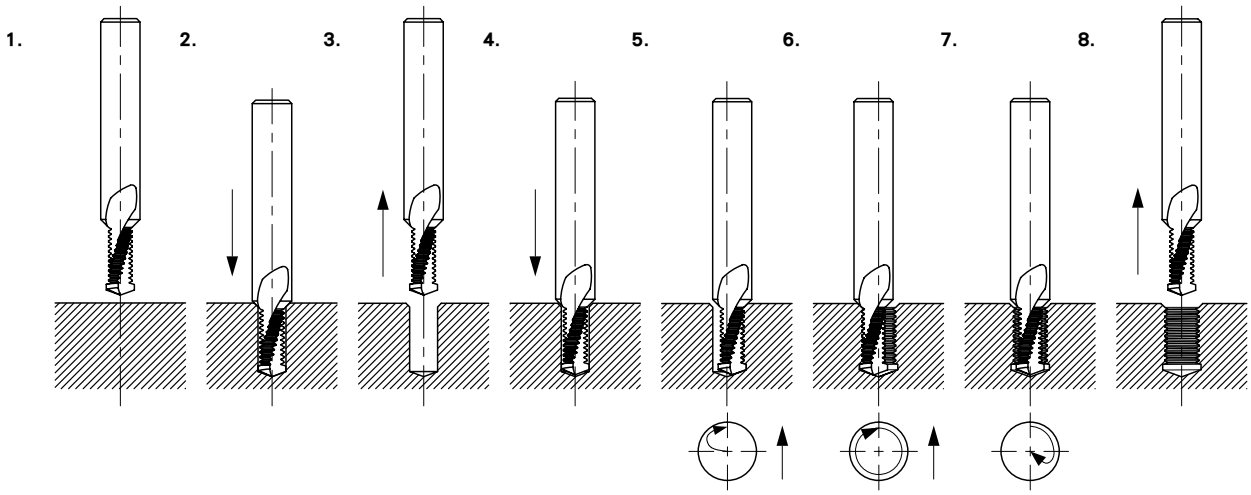
Work Material 被削材	SS400. AISI 1050. SCM等 一般構造鋼.碳素鋼. NON-ALLOYED STEELS ALLOY STEELS TOOL STEELS	AISI H13. AISI D2等 合金鋼.工具鋼 調質鋼 ALLOY STEELS HEAT RESISTANT STEELS	AISI 304 AISI 316等 沃斯田鐵、麻田散鐵系 系列不銹鋼 STAINLESS STEELS	鑄鐵、球狀石墨鑄鐵 可延展性鑄鐵 FC250等 CAST IRON	鋁鎂合金 鋁及鋁合金	特殊合金、 鈦及鈦合金 TITANUM ALLOYS
HARDNESS 硬度	~30HRC	30~45HRC	~40HRC	≧240HB		
STRENGTH 抗拉強度	~1000 N/mm²	1000~1500 N/mm²	~950N/mm²			1300N/mm²
Vc	50~220	30~100	50~140	60~140	80~280	15~80
Diameter 直徑(mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
1	0.025	0.020	0.020	0.025	0.030	0.020
1.5	0.035	0.030	0.030	0.035	0.040	0.020
2	0.040	0.040	0.040	0.040	0.045	0.025
3	0.055	0.045	0.045	0.055	0.060	0.030
4	0.065	0.050	0.050	0.065	0.075	0.035
5	0.080	0.055	0.055	0.080	0.090	0.045
6	0.095	0.060	0.060	0.095	0.105	0.050
8	0.130	0.075	0.075	0.130	0.130	0.055
10	0.145	0.090	0.090	0.145	0.145	0.060

切削示範 Cutting Demonstration

TM3ZT/TMSM1ZT/TMFP/TMPA



TMCHD



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