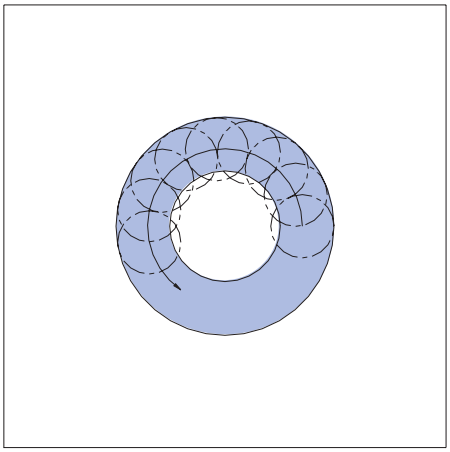
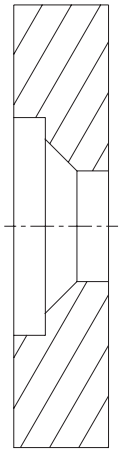
成型灌嘴刀 • NOZZLE-SEAT MILLING CUTTER

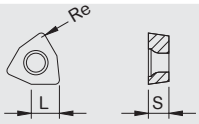
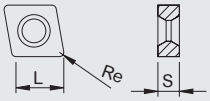
模座灌嘴加工在銑床以銑刀作圓弧切削，加工難度高，因此我們設計成型灌嘴刀，第一把成型粗銑刀，第二把內徑修面刀，快速，精確平坦。





發明專利
TAIWAN PATENT 140472

Order No.	Part No.	Insert
99605-100R	SL40-100NR	N9GX05T308 x 7, NS-30072 NK-T9
99605-100F	SL40-100NF	CNHU 160608 NC40 x 7, NS-50120 NK-T15

Insert	NC40	圖 形	尺 寸		
			L	S	Re
N9GX05T308	●(碳.鋼.合金鋼)		5	3.97	0.8
CNHU1606R08NC40	●(碳.鋼.合金鋼)		16	4.76	0.8

加工方式

1. 99605-100R　　轉速S200(150~250)　　進給0.025~0.05/rev
2. 99605-100F
   a.加工孔徑時　　轉速S70　　快速進給200mm/min到孔底
   b.加工孔底平面時轉速到位後快速退回　　轉速S70　　進給0.01mm/rev加工到深度