

NEGATIVE RAKE ANGLE INSERT SERIES

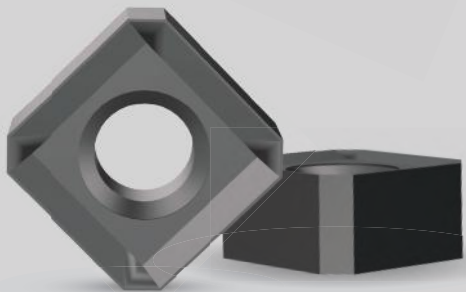
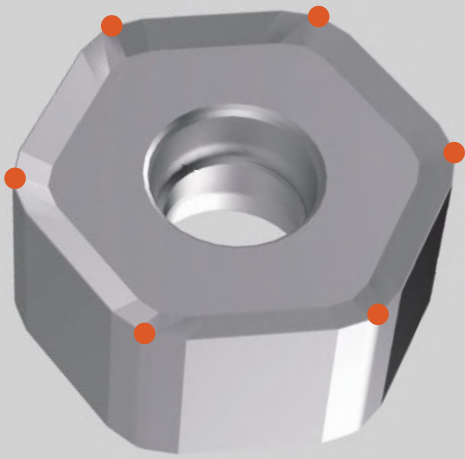
負角刀片系列

No. 240528004



影片
Video



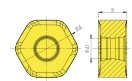
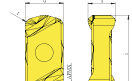
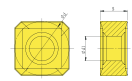


- SN../8刃、HN/12刃，低刀具成本。
- 修光刃設計降低粗糙度。
- 切刃倒角縮小工件毛邊。
- SN../8 cutting edge、HN/12 cutting edge, effective cost-saving.
- The design of wiper inserts decrease roughness.
- Chamfering cutting edges make workpiece's burrs smaller.



負角刀片選用 NEGATIVE INSERTS APPLICATION

負角刀片 Negative Insert	加工類型 Machining Type	銑削方式 Cutting Method	切削深度 Ap	加工材質 Machining Materials
SN..12	粗加工 Roughing	面銑、肩銑 Face milling, Shoulder milling	1~3	P K
HN..06	中精加工 Semi-finishing	面銑 Face milling	0.5~2.5	P M K N
LN..03	粗加工 Roughing	高進給銑削 High feed milling	1	P K H

ISO 分類	P	合金鋼 Alloyed Steels	○	○											切削狀態 Cutting Condition : ● 連續切削 Continuous Cutting ○ 一般切削 General Cutting ■ 斷續切削 Interrupted Cutting		
	M	不鏽鋼 Stainless Steels	○	○	○	○											
	K	鑄鐵 Cast Iron	○				○	○									
	N	鋁及鋁合金 Aluminum&Al									○						
	S	高溫合金 Refractory Alloys															
	H	高硬度材 Hard Material	○														
形狀 Shape	規格 Spec.	鍍層超微粒 Layer Coated micro grain						超微粒硬質合金 Micro grain cemented carbide				尺寸 (mm)				圖形 Drawing	
		CHF						HF				Size					
		RM1125	OM4025	OM5035	RM4025	RM3130		OM5005					d	i	s		r
	HNGX0604ANEN-M01		●	●									10.5	-	5.2	-	
	HNGX0604ANFN-F01							●					10.5	-	5.2	-	
	LNMU0303ZER-MJ	●											6	11.9	4.3	1.2	
	LNMU0303ZER-M01		●										6	11.9	4.3	1.2	
	SNMU1206ANEN-M01				●	●							12.7	-	6.35	-	
	SNMU1206ANEN-M03		●										12.7	-	6.35	-	

LN_03 切削條件數據表 Cutting Parameter

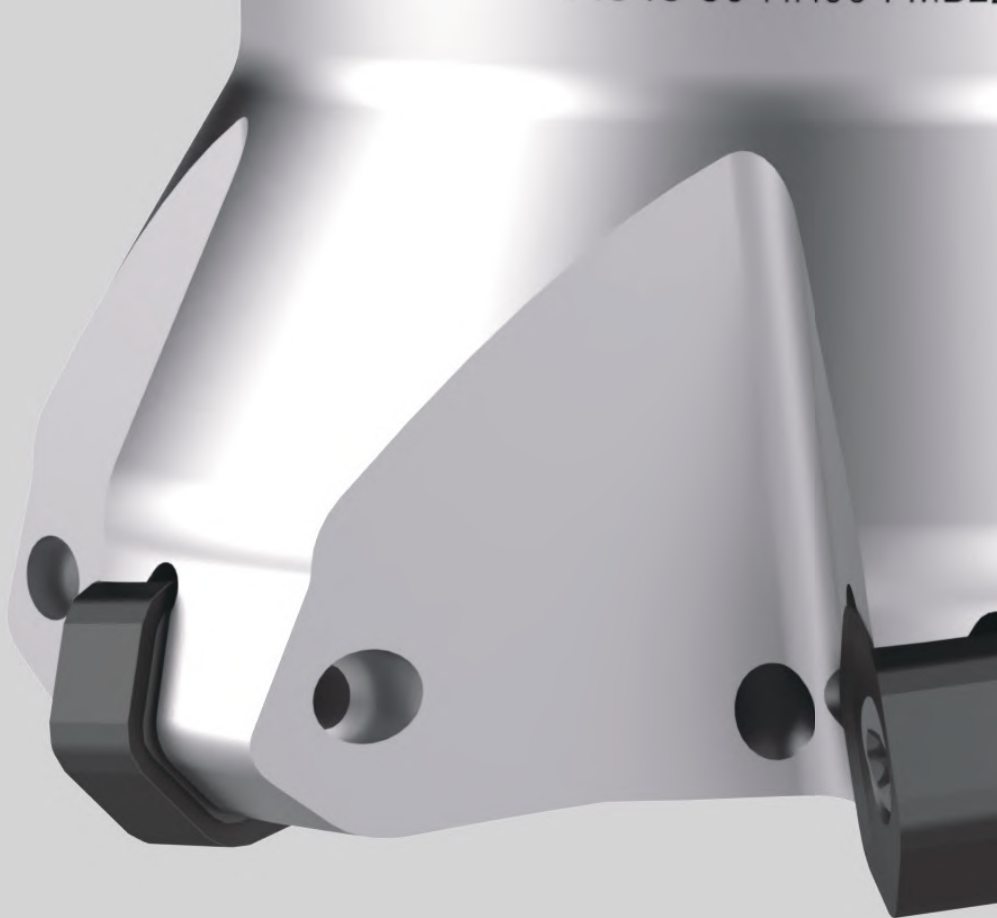
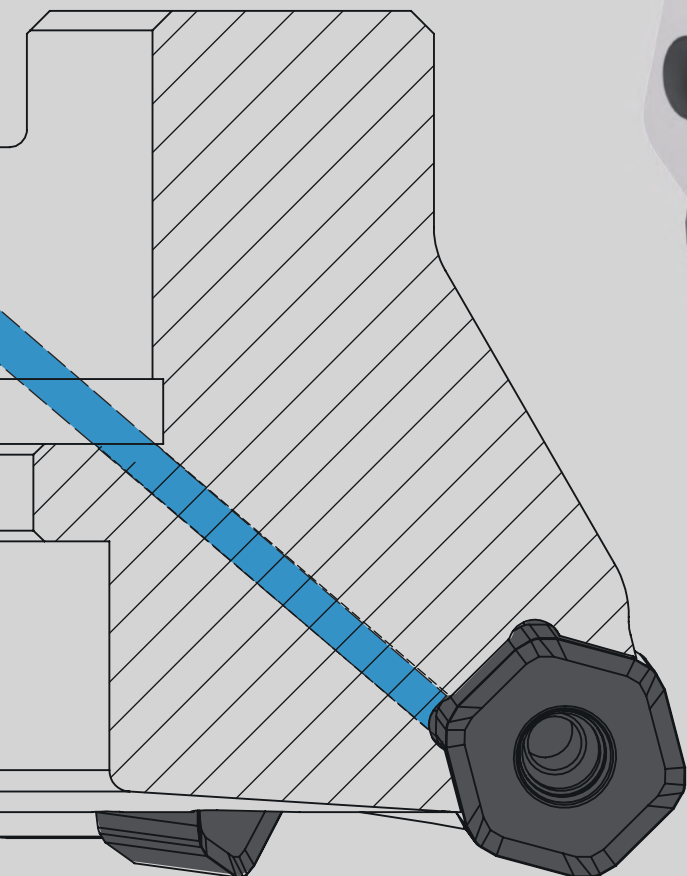
被加工材質 Machining Materials		刀片材質 Grade	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)
P	合金鋼 Alloyed Steels	RM1125	150(100~200)	0.7(0.5~1.2)
		OM4025		
K	鑄鐵 Cast Iron	RM1125	150(80~250)	0.7(0.5~1.2)

HN_06 切削條件數據表 Cutting Parameter

被加工材質 Machining Materials		刀片材質 Grade	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)
P	合金鋼 Alloyed Steels	OM4025	220(150~300)	0.15(0.08~0.25)
M	不鏽鋼 Stainless Steels	OM5035	120(100~200)	0.12(0.08~0.20)
K	鑄鐵 Cast Iron	OM4025	180(130~240)	0.15(0.08~0.25)
N	鋁及鋁合金 Aluminium & Al	OM5005	400(300 - 1000)	0.12(0.08 - 0.17)

SN_12 切削條件數據表 Cutting Parameter

被加工材質 Machining Materials		刀片材質 Grade	切削速度 Vc(m/min)	每刃進給 fz(mm/rev)
P	合金鋼 Alloyed Steels	RM4025	220(170~320)	0.20(0.10~0.35)
		OM4025		
K	鑄鐵 Cast Iron	RM3130	180(130~240)	0.20(0.10~0.35)



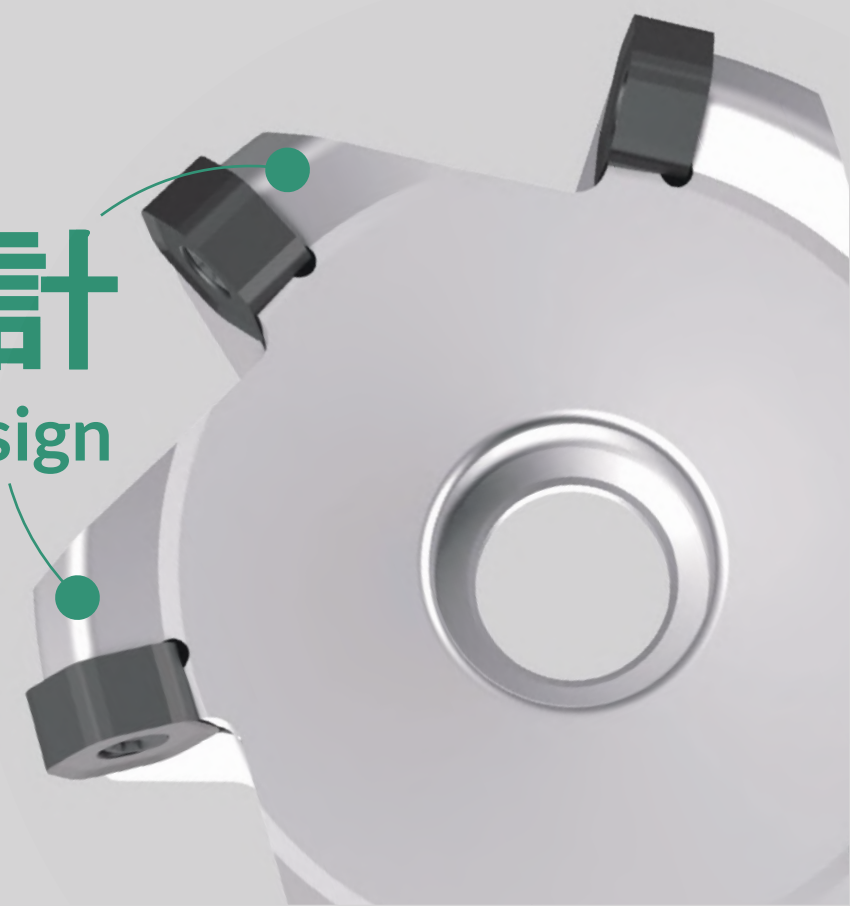
中心出水 Through Coolant

利於排屑與降溫
Faster Chip Removal &
Reduce Temperature

不等距設計

Non Equidistant Design

抑制切削加工造成震動
利於高穩定的加工
To decrease the vibration and
show high stability while machining



加工K類材質
最佳優化方案

Machining material: K (cast iron)
The Improving Method

- 刀桿：BT50-FMB32-150
- 刀具：NAC45-100-HN06-FMB32-8T-C
- 刀片：HNGX0604ANEN-M01 OM4025
- 工件材質：鑄鐵K
- 乾式切削
- Cutter Arbor：BT50-FMB32-150
- Cutting Tools：NAC45-100-HN06-FMB32-8T-C
- Inserts：HNGX0604ANEN-M01 OM4025
- Workpiece Material：Cast Iron
- Dry Cutting

切削參數Cutting Parameters	他牌 Other Brand	正河源 Chain Headway
轉速 S	250	480
進給 F	500	1200
切削速度 Vc	78.5	150
進給 fz	0.25	0.31
切深 Ap	2	2
切寬 Ae	80	80
加工壽命Machining Life	15小時(hrs)	21小時(hrs)

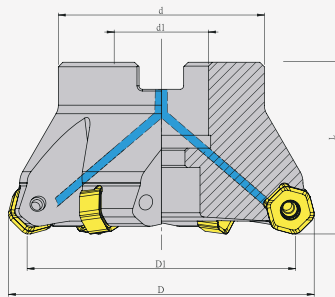
加工效率提升140%，以及刀片壽命提升40%

Machining efficiency increases above 140%, and inserts' tool life increase by 40%



NAC 45度負角殼型銑刀

NAC 45°NEGATIVE ANGLE SHELL MILLING CUTTER



特點 Feature

- 採用負角刀片，刀片切削角數增加，降低成本
- 加工方式適合大量移除鐵削

- Negative insert with 12 cutting edges. Effective cost-saving.
- Ideal for a large area of cutting.

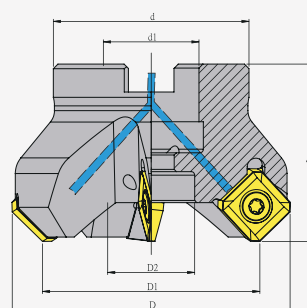
規格 Spec.	L	D	D1	d	d1	刃數 Flutes	刀片 Insert	重量 (KGS) Weight
NAC45-50-HN06-FMB22-5T-C	40	57	50	45	22	5	HN..0604	0.64
NAC45-63-HN06-FMB22-6T-C	40	72	63	48	22	6	HN..0604	0.80
NAC45-80-HN06-FMB27-7T-C	50	87	80	55	27	7	HN..0604	1.40
NAC45-100-HN06-FMB32-8T-C	50	107	100	73	32	8	HN..0604	2.10
NAC45-125-HN06-FMB40-10T-C	63	133	125	90	40	10	HN..0604	4.22

配件表 Accessories

螺絲 Screw 	扳手 Wrench 	扭力值 Torque(N.m)
M3-7.0-4.3-43-T9-TIN	T9	1.4Nm

NAC 45度負角殼型銑刀

NAC 45°NEGATIVE ANGLE SHELL MILLING CUTTER



特點 Feature

- 採用負角刀片，刀片切削角數增加，降低成本
- 加工方式適合大量移除鐵削

- Negative insert with 8 cutting edges. Effective cost-saving.
- Ideal for a large area of cutting.

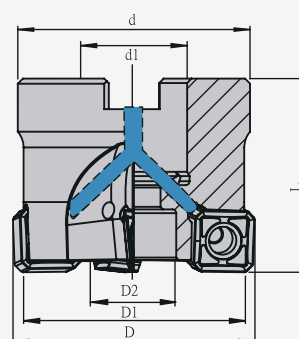
規格 Spec.	D1	D	L	D2	d	d1	刃數 Flutes	刀片 Insert	重量 (KGS) Weight
NAC45-50-SN12-FMB22-4T-C	50	65	40	20	48	22	4	SN..1206	0.57
NAC45-63-SN12-FMB22-6T-C	63	78	40	18	48	22	6	SN..1206	0.78
NAC45-80-SN12-FMB27-7T-C	80	95	50	32	62	27	7	SN..1206	1.39
NAC45-100-SN12-FMB32-8T-C	100	115	50	42	80	32	8	SN..1206	1.76
NAC45-125-SN12-FMB40-10T-C	125	140	63	50	90	40	10	SN..1206	3.5
NAC45-160-SN12-FMB40-12T-C	160	175	63	50	120	40	12	SN..1206	6

配件表 Accessories

螺絲 Screw 	扳手 Wrench 	扭力值 Torque(N.m)
M4-10-6.6-R3.8-T15	T15	3.0Nm

NAC 88度負角殼型銑刀

NAC 88°NEGATIVE ANGLE SHELL MILLING CUTTER



規格 Spec.	L	D	d	d1	刃數 Flutes	刀片 Insert	重量 (KGS) Weight
NAC88-50-SN12-FMB22-4T-C	40	50	48	22	4	SN..12	-
NAC88-63-SN12-FMB22-5T-C	40	63	48	22	5	SN..12	-
NAC88-80-SN12-FMB27-7T-C	50	80	62	27	7	SN..12	-
NAC88-100-SN12-FMB32-8T-C	50	100	80	32	8	SN..12	-

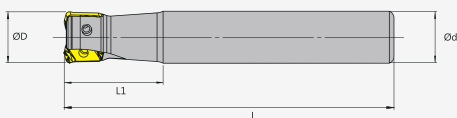
配件表 Accessories

螺絲 Screw 	扳手 Wrench 	扭力值 Torque(N.m)
M4-10-6.6-R3.8-T15	T15	3.0Nm



NHF 高進給直柄銑刀

NHF HIGH FEED MILLING END MILL

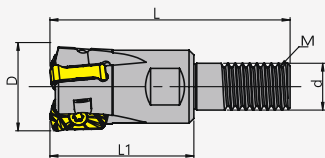
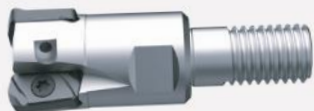


規格 Spec.	L	l ₁	D	d	刃數 Flutes	刀片 Insert	重量 (KGS) Weight
NHF-1516LN03-150L	150	30	15	16	2	LNMU0303	-
NHF-1616LN03-150L	150	40	16	16	2		-
NHF-1716LN03-150L	150	30	17	16	2		-
NHF-2020LN03-150L	150	40	20	20	3		-
NHF-2120LN03-150L	150	50	21	20	3		-
NHF-2525LN03-150L	150	60	25	25	4		-
NHF-2625LN03-150L	150	60	26	25	4		-
NHF-2625LN03-200L	200	60	26	25	4		-
NHF-3232LN03-150L	150	45	32	32	5		-
NHF-3532LN03-220L	220	60	35	32	5		-



NHF 高進給鎖牙銑刀

NHF HIGH FEED SCREW-ON MILLING END MILL

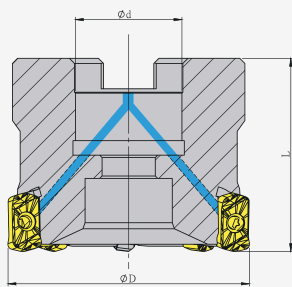


規格 Spec.	L	l ₁	D	d	M	刃數 Flutes	刀片 Insert	重量 (KGS) Weight
NHF-17M08-LN03	43	26	17	8.5	M08	2	LNMU0303	-
NHF-21M10-LN03	49	30	21	8.5	M10	3		-
NHF-26M12-LN03	57	35	26	8.5	M12	4		-
NHF-35M16-LN03	66	43	35	8.5	M16	4		-



NHF 高進給殼型銑刀

NHF HIGH FEED FACE MILLING CUTTER



規格 Spec.	D	d	L	刃數 Flutes	重量 (KGS) Weight
NHF-40-FMB16-LN03-C	40	16	40	6	-
NHF-50-FMB22-LN03-C	50	22	50	8	-

配件表 Accessories

螺絲 Screw	扳手 Wrench	扭力值 Torque(N.m)
M2.5-6.45-3.7-43	T8	1.2Nm



正河源股份有限公司
CHAIN HEADWAY CO., LTD.

☎ 電話 TEL /
+886-4-26265252

☎ 傳真 FAX /
+886-4-26267941

📍 地址 Address /
436037台灣台中市清水區五權路232號
No. 232, Wuquan Rd., Qingshui Dist., Taichung City 436037, Taiwan

🌐 網址 Website /
www.chain-headway.com



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