

CEFC MEFCD

NEW- 多功能鎢鋼倒角銑刀系列
MULTIFUNCTIONAL CHAMFER CUTTER

切 削 實 例
CUT EXAMPLES



鋁合金Al6061加工

1

CEFC型號: 鋁合金專用倒角刀(AI5052, 6061, 7075)。
CEFC for aluminum alloy(5052, 6061, 7075) machining.



CEFC/ 1刃鋁用倒角銑刀

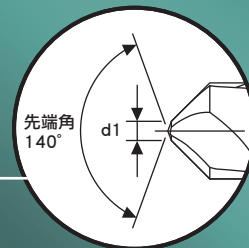
鋁, 銅合金, 塑膠軟材質之應用!

2

MEFCD型號: 高硬材質($\leq 50\text{HRC}$)專用倒角刀。
MEFCD for high hardness Steel($\leq 50\text{HRC}$) machining.

MEFCD/ 3刃高硬用倒角銑刀

碳素鋼, 合金鋼, 高硬鋼材之應用!



產品特色/ Features :

一把可倒角、定點、雕刻加工完美結合的多功能切削刀具。
A perfect multi-functional cutting tools in chamfering, spotting and engraving.

提供全長最長100mm, 適合各種精密模具深腔倒角加工用。
Maximum length with 100mm for any kind of mold machining.

提供常用倒角角度60 & 90°。
Chamfering for 60 & 90°.

切 削 實 例
CUT EXAMPLES



中碳鋼S45C加工

尺寸規格表 Size:

頂角 Tip Angle	刃徑 Diameter	MEFCD型號 先端徑 d1(Max)	全長 O.A.L.	柄徑 Shank Dia.	CEFC型號- 鋁用 訂購編號 Uncoated Order No.	MEFCD型號- 高硬用 訂購編號 Coated Order No.
60°	3	0.6	50	3	CEFC103060	MEFCD303060A
60°	4	0.8	50	4	CEFC104060	MEFCD304060A
60°	6	1.2	50	6	CEFC106060	MEFCD306060A
60°	8	1.6	60	8	CEFC108060	MEFCD308060A
60°	10	2.0	60	10	CEFC110060	MEFCD310060A
60°	12	2.4	60	12	CEFC112060	MEFCD312060A
90°	3	0.6	50	3	CEFC103090	MEFCD303090A
90°	4	0.8	50	4	CEFC104090	MEFCD304090A
90°	6	1.2	50	6	CEFC106090	MEFCD306090A
90°	8	1.6	60	8	CEFC108090	MEFCD308090A
90°	10	2.0	60	10	CEFC110090	MEFCD310090A
90°	12	2.4	60	12	CEFC112090	MEFCD312090A
60°	3	0.6	75	3	CEFCL103060	MEFCDL303060A
60°	4	0.8	75	4	CEFCL104060	MEFCDL304060A
60°	6	1.2	75	6	CEFCL106060	MEFCDL306060A
60°	8	1.6	100	8	CEFCL108060	MEFCDL308060A
60°	10	2.0	100	10	CEFCL110060	MEFCDL310060A
60°	12	2.4	100	12	CEFCL112060	MEFCDL312060A
90°	3	0.6	75	3	CEFCL103090	MEFCDL303090A
90°	4	0.8	75	4	CEFCL104090	MEFCDL304090A
90°	6	1.2	75	6	CEFCL106090	MEFCDL306090A
90°	8	1.6	100	8	CEFCL108090	MEFCDL308090A
90°	10	2.0	100	10	CEFCL110090	MEFCDL310090A
90°	12	2.4	100	12	CEFCL112090	MEFCDL312090A

CEFC型號- 切削條件表 Cutting Condition Table:

加工材質 Material	鋁合金 Aluminum Alloys					
加工方式 Cutting Mode	定點加工 Spotting		倒角加工 Chamfering		雕刻加工 Engraving	
切削速度 Vc	100~200m/min		100~200m/min		100~200m/min	
外徑 Diameter	S (rpm)	f (mm/rev)	S (rpm)	f (mm/rev)	S (rpm)	f (mm/rev)
3mm	11,000~21,000	0.01	11,000~21,000	0.01~0.04	11,000~21,000	0.01~0.02
4mm	8,000~16,000	0.01	8,000~16,000	0.01~0.04	8,000~16,000	0.01~0.03
6mm	5,000~11,000	0.02	5,000~11,000	0.02~0.07	5,000~11,000	0.02~0.04
8mm	4,000~8,000	0.03	4,000~8,000	0.02~0.10	4,000~8,000	0.03~0.06
10mm	3,200~6,400	0.03	3,200~6,400	0.02~0.15	3,200~6,400	0.03~0.06
12mm	2,700~5,300	0.04	2,700~5,300	0.02~0.14	2,700~5,300	0.04~0.08
16mm	2,000~4,000	0.05	2,000~4,000	0.02~0.14	2,000~4,000	0.05~0.10

MEFCD型號- 切削條件表 Cutting Condition Table:

加工材質 Material	合金鋼 Alloy Steels (HRC20~50)					
加工方式 Cutting Mode	定點加工 Spotting		倒角加工 Chamfering		雕刻加工 Engraving	
切削速度 Vc	90~150m/min		90~150m/min		90~150m/min	
外徑 Diameter	S (rpm)	f (mm/rev)	S (rpm)	f (mm/rev)	S (rpm)	f (mm/rev)
3mm	9,550~15,920	0.01	9,550~15,920	0.03~0.06	9,550~15,920	0.02~0.04
4mm	7,170~11,940	0.02	7,170~11,940	0.03~0.06	7,170~11,940	0.02~0.04
6mm	4,780~7,960	0.02	4,780~7,960	0.05~0.10	4,780~7,960	0.03~0.08
8mm	3,580~5,970	0.03	3,580~5,970	0.10~0.20	3,580~5,970	0.03~0.08
10mm	2,870~4,780	0.05	2,870~4,780	0.15~0.30	2,870~4,780	0.05~0.13
12mm	2,390~3,980	0.07	2,390~3,980	0.20~0.35	2,390~3,980	0.10~0.15
16mm	1,790~2,990	0.08	1,790~2,990	0.20~0.35	1,790~2,990	0.10~0.15