

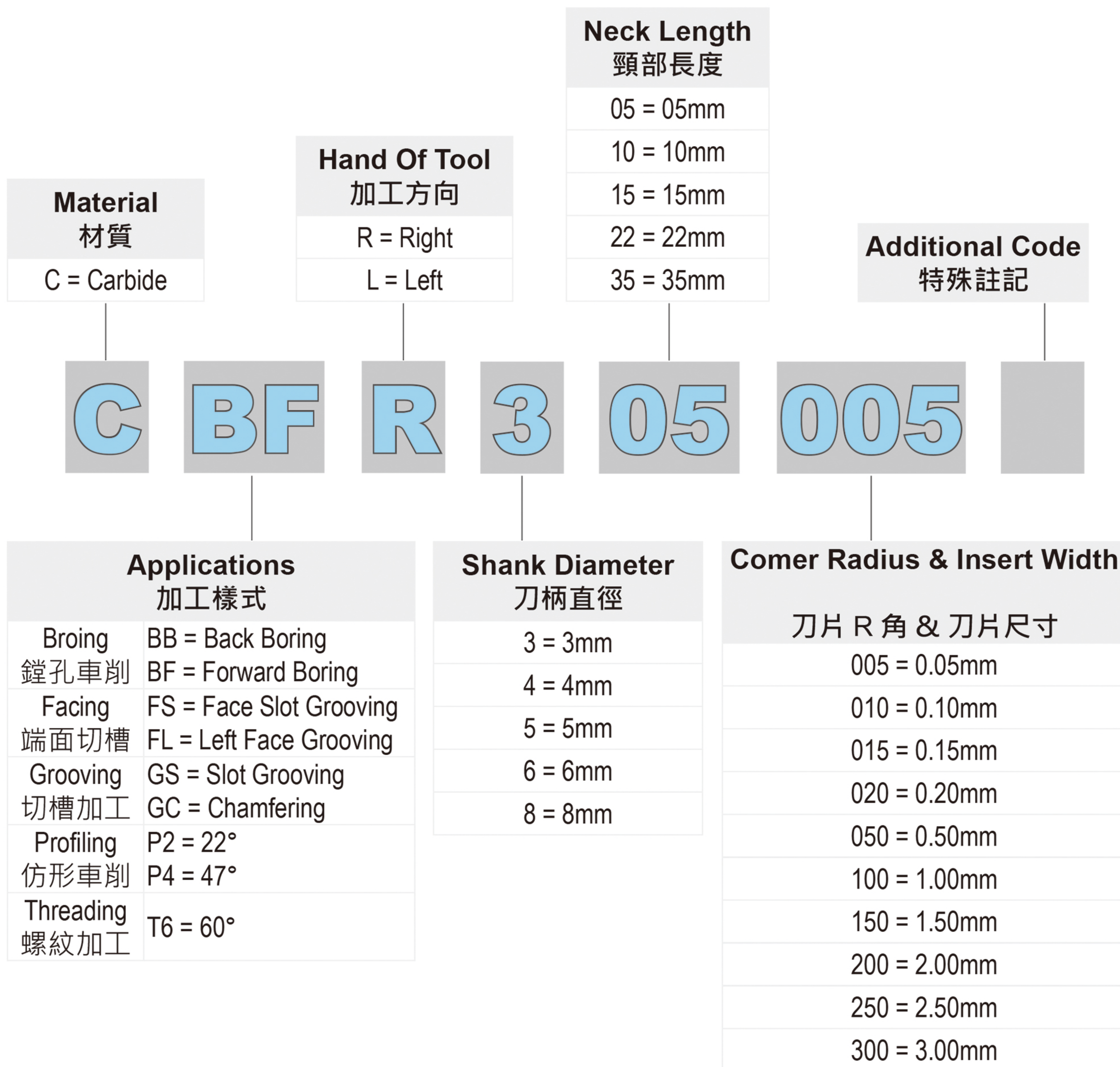
# SMALL BORING BAR SERIES





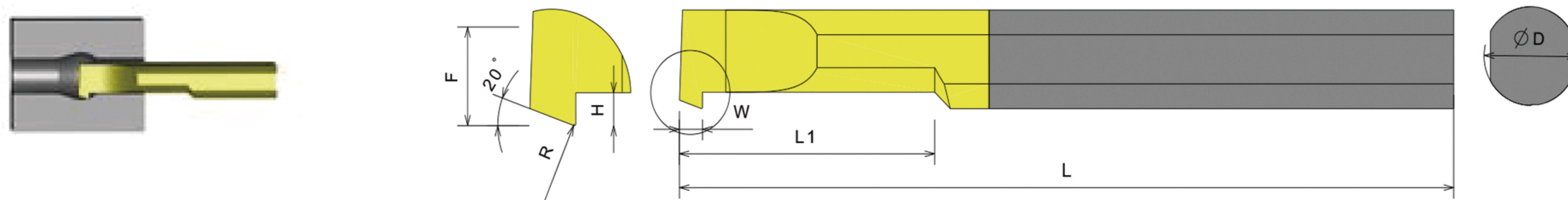
# Product Identification

## 微型刀規格表示



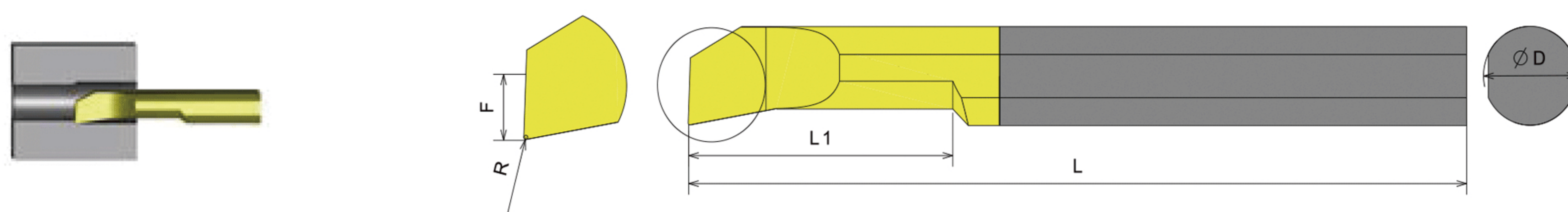


## CBBR Back Boring 背鏜孔車削



Ordering Code	D	L	L1	R	H	F
<b>CBBR4 15 015</b>	4	37	15	0.15	0.8	1.6
<b>CBBR5 22 020</b>	5	50	22	0.20	1.0	2.2
<b>CBBR6 22 020</b>	6	50	22	0.20	1.8	2.8

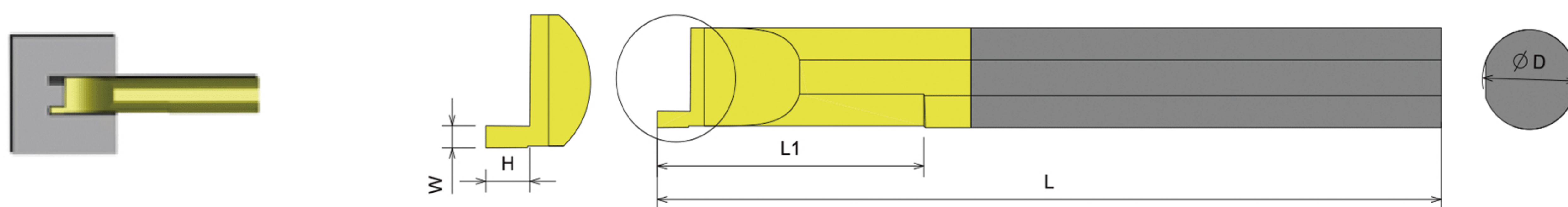
## CBFR Forward Boring 鏜孔車削



Ordering Code	D	L	L1	R	B	F
<b>CBFR3 10 005</b>	3	37	10	0.05	3.1	1.3
<b>CBFR3 10 020</b>	3	37	10	0.20	3.1	1.3
<b>CBFR4 15 020</b>	4	37	15	0.20	4.1	1.7
<b>CBFR5 22 020</b>	5	50	22	0.20	5.1	2.1
<b>CBFR6 22 020</b>	6	50	22	0.20	6.1	2.8

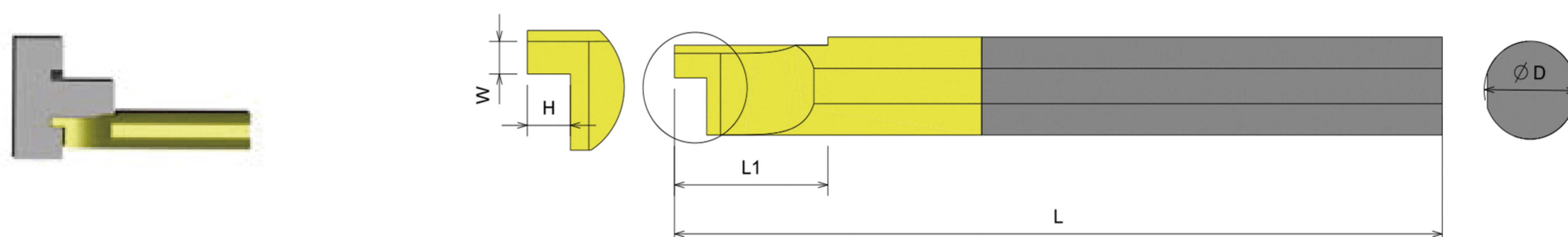


## CFSR Face Slot Grooving 端面切槽



Ordering Code	D	L	L1	W	H	F
<b>CFSR4 15 075</b>	4	37	15	0.75	1.0	1.95
<b>CFSR4 15 100</b>	4	37	15	1.00	1.0	1.95
<b>CFSR5 22 075</b>	5	50	22	0.75	1.2	2.45
<b>CFSR5 22 100</b>	5	50	22	1.00	1.2	2.45
<b>CFSR5 22 150</b>	5	50	22	1.50	1.2	2.45
<b>CFSR6 22 100</b>	6	50	22	1.00	1.4	2.95
<b>CFSR6 22 150</b>	6	50	22	1.50	1.4	2.95
<b>CFSR6 22 200</b>	6	50	22	2.00	1.4	2.95

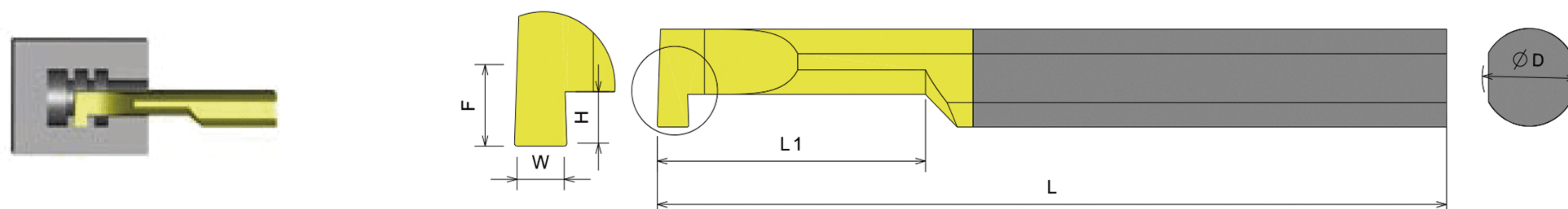
## CFLR Left Face Grooving 端面切槽



Ordering Code	D	L	L1	W	H	F
<b>CFLR4 15 075</b>	4	37	15	0.75	1.2	1.75
<b>CFLR4 15 100</b>	4	37	15	1.00	1.5	1.75
<b>CFLR5 22 075</b>	5	50	22	0.75	1.2	2.25
<b>CFLR5 22 100</b>	5	50	22	1.00	1.5	2.25
<b>CFLR5 22 150</b>	5	50	22	1.50	2.5	2.25
<b>CFLR6 22 100</b>	6	50	22	1.00	1.5	2.75
<b>CFLR6 22 150</b>	6	50	22	1.50	2.5	2.75
<b>CFLR6 22 200</b>	6	50	22	2.00	3.0	2.75
<b>CFLR8 22 250</b>	8	60	22	2.50	3.5	3.75

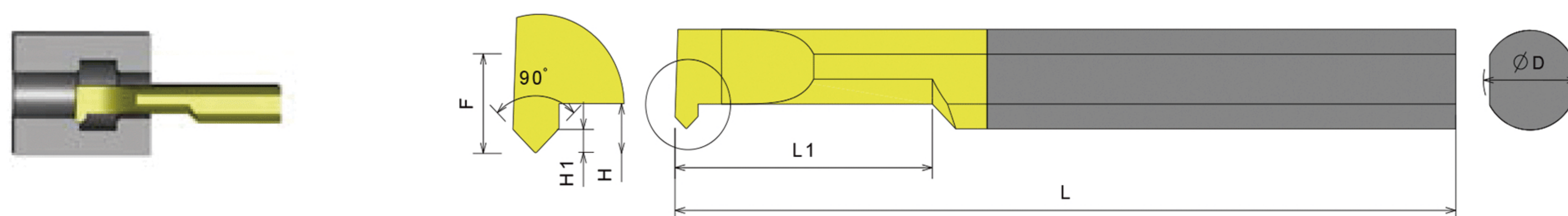


## CGSR Slot Grooving 切槽加工



Ordering Code	D	L	L1	W	H	F
<b>CGSR4 10 100</b>	4	37	10	1.00	1.0	1.7
<b>CGSR4 10 150</b>	4	37	10	1.50	1.0	1.7
<b>CGSR5 15 100</b>	5	50	15	1.00	1.2	2.3
<b>CGSR5 15 150</b>	5	50	15	1.50	1.2	2.3
<b>CGSR5 15 200</b>	5	50	15	2.00	1.2	2.3
<b>CGSR6 15 100</b>	6	50	15	1.00	1.4	2.8
<b>CGSR6 15 150</b>	6	50	15	1.50	1.4	2.8
<b>CGSR6 15 200</b>	6	50	15	2.00	1.4	2.8
<b>CGSR8 22 150</b>	8	60	22	1.50	2.0	3.8
<b>CGSR8 22 200</b>	8	60	22	2.00	2.0	3.8

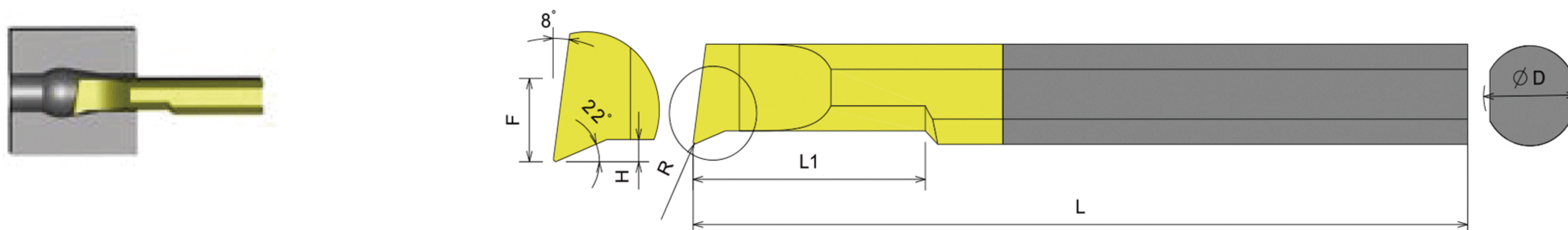
## CGCR Chamfering 倒角加工



Ordering Code	D	L	L1	H1	H	F
<b>CGCR3 10 020</b>	3	37	10	0.3	0.7	1.3
<b>CGCR4 15 020</b>	4	37	15	0.4	0.8	1.7
<b>CGCR5 15 020</b>	5	50	15	0.7	1.2	2.1
<b>CGCR6 15 020</b>	6	50	15	0.7	1.4	2.8

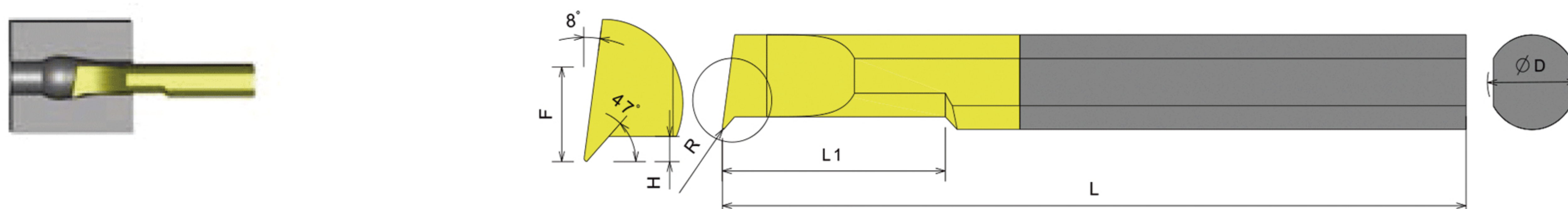


## CP2R 22° Profiling 仿形車削



Ordering Code	D	L	L1	R	H	F
CP2R3 10 020	3	37	10	0.20	0.7	1.3
CP2R4 15 020	4	37	15	0.20	0.8	1.7
CP2R5 15 020	5	50	15	0.20	1.2	2.1
CP2R6 15 020	6	50	15	0.20	1.4	2.8

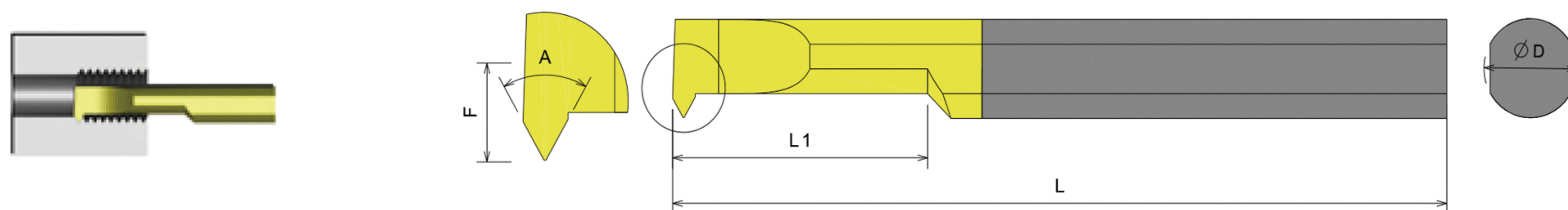
## CP4R 47° Profiling 仿形車削



Ordering Code	D	L	L1	R	H	F
CP4R4 15 020	4	37	15	0.20	0.8	1.8
CP4R5 15 020	5	50	15	0.20	1.0	2.3
CP4R6 15 020	6	50	15	0.20	1.4	2.8

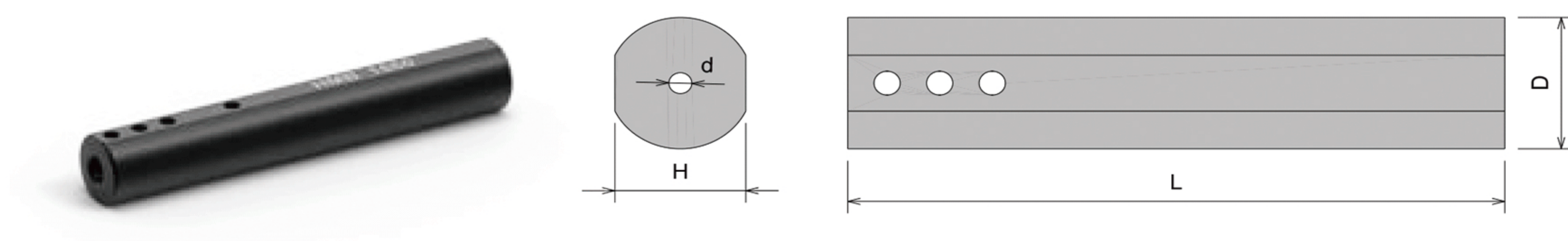


## CT6R 60° Threading 螺紋加工



Ordering Code	D	L	L1	Pitch(mm)	angle	F
<b>CT6R3 10 100</b>	3	37	10	0.8~1	60.0	1.4
<b>CT6R4 15 100</b>	4	37	15	0.8~1	60.0	1.8
<b>CT6R5 15 125</b>	5	50	15	1~1.25	60.0	2.3
<b>CT6R6 15 150</b>	6	50	15	0.5~1.5	60.0	2.6

## HMB Mini Boring Bar Sleeve 套筒



Ordering Code	D	L	d	H	Screw	Wrench
<b>HMB1603</b>	16	100	3.0	14	CS9-4004	LW020
<b>HMB2003</b>	20	100	3.0	18	CS9-4004	LW020
<b>HMB2203</b>	22	100	3.0	20	CS9-4004	LW020
<b>HMB1604</b>	16	100	4.0	14	CS9-4004	LW020
<b>HMB2004</b>	20	100	4.0	18	CS9-4004	LW020
<b>HMB2204</b>	22	100	4.0	20	CS9-4004	LW020
<b>HMB1605</b>	16	100	5.0	14	CS9-4004	LW020
<b>HMB2005</b>	20	100	5.0	18	CS9-4004	LW020
<b>HMB2205</b>	22	100	5.0	20	CS9-4004	LW020
<b>HMB1606</b>	16	100	6.0	14	CS9-4004	LW020
<b>HMB2006</b>	20	100	6.0	18	CS9-4004	LW020
<b>HMB2206</b>	22	100	6.0	20	CS9-4004	LW020



# Technical Data

## 切削參考數據

工件材料 Work Material	車削加工 Turning			切斷加工 Cut off		
	切削速度 Vc(m/min)	切削深度 a (mm)	進給 f(mm/rev)	切削速度 Vc(m/min)	切削寬度 b(mm)	進給 f(mm/rev)
快削鋼 Free Machining Carbon Steel	120-200	0.05-1.0 1.0-4.0	0.01-0.15 0.05-0.25	80-150	0.50-1.50 1.50-3.50	0.01-0.08 0.03-0.15
鋼 Steel <600N/mm <sup>2</sup>	80-160	0.05-1.0 1.0-4.0	0.01-0.15 0.05-0.25	70-120	0.50-1.50 1.50-3.50	0.01-0.06 0.03-0.12
鋼 Steel <800N/mm <sup>2</sup>	60-120	0.05-1.0 1.0-4.0	0.01-0.10 0.05-0.20	60-100	0.50-1.50 1.50-3.50	0.01-0.05 0.03-0.10
鋼 Steel >800N/mm <sup>2</sup>	50-100	0.05-1.0 1.0-3.0	0.01-0.08 0.05-0.15	40-80	0.50-1.50 1.50-3.50	0.01-0.04 0.03-0.08
不鏽鋼 Stainless Steel	60-120	0.05-1.0 1.0-3.0	0.01-0.08 0.05-0.15	60-100	0.50-1.50 1.50-3.50	0.01-0.04 0.03-0.08