

# Anchor<sup>®</sup>

深化技術  
先端應用

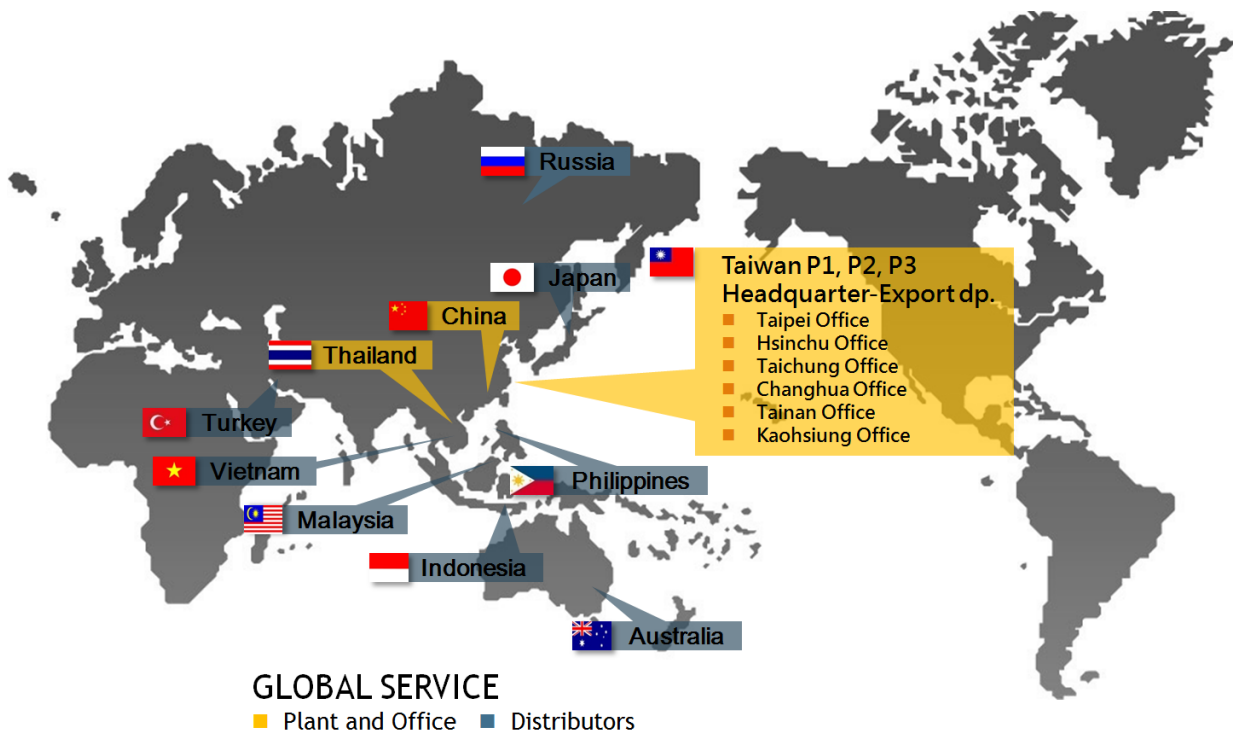
Fine Tech  
New Apps




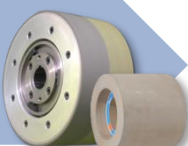

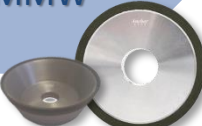
金屬切削刀具研磨砂輪型錄  
Grinding wheels for metal cutting tools

|  |    |
|--|----|
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鑽頭(Drills)、銑刀(Mills)研磨製程包含，(鎢)鋼條之切斷，鋼棒外徑研磨、刀具剖溝開槽及刀刃刃口研磨，部分刀具(micron tools)則有段差研磨的需求。

| 刀具製程                       | 砂輪種類   | 嘉寶規格   |
|----------------------------|--|--|
| 鋼條切斷加工<br>Cut-off          | 樹脂法鑽石精密切斷片<br>Precision cutting wheel          | BCW             |
| 鋼棒外徑研磨<br>Centerless Grind | 鑽石CBN無心砂輪、調整輪<br>Centerless and Control wheel  | BCG             |
| 鋼棒開槽<br>Flute              | 鑽石CBN開槽砂輪<br>Fluting wheel                     | BMW HBMW MMW   |
| 離隙角、刃口研磨<br>OD/Relief、Gash | 鑽石CBN離隙砂輪<br>Clearance and face grinding wheel | BMW HBMW MMW  |

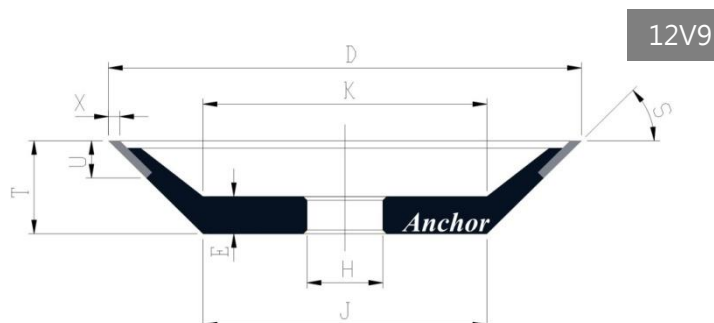
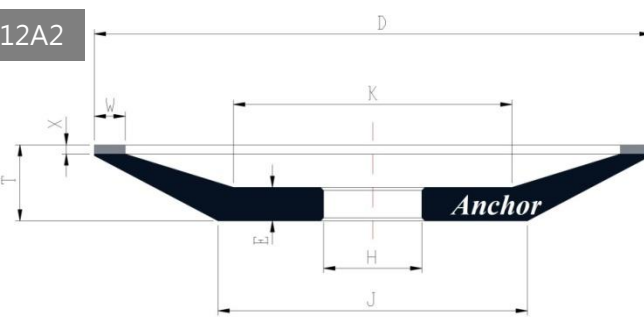
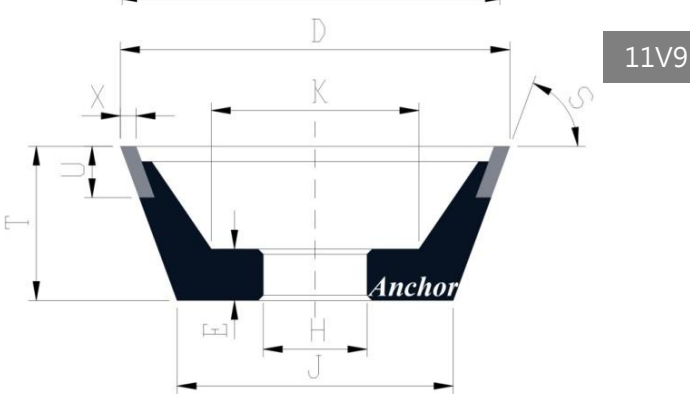
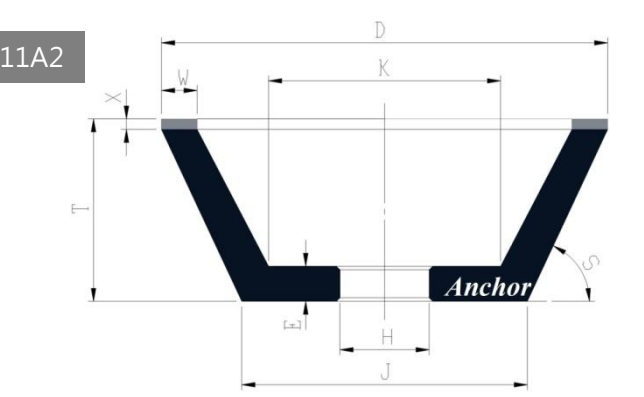
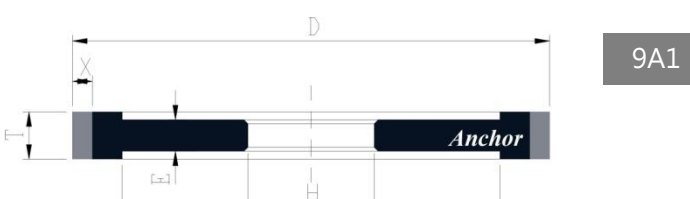
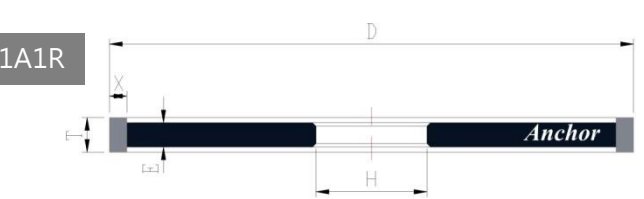
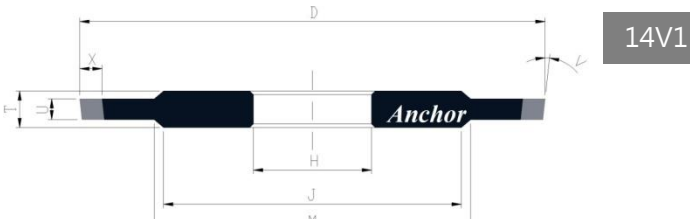
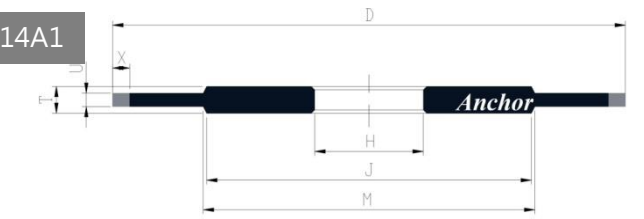
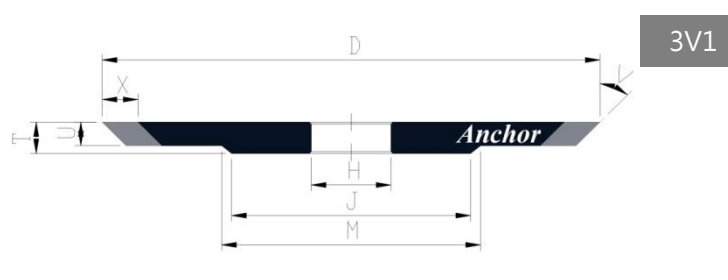
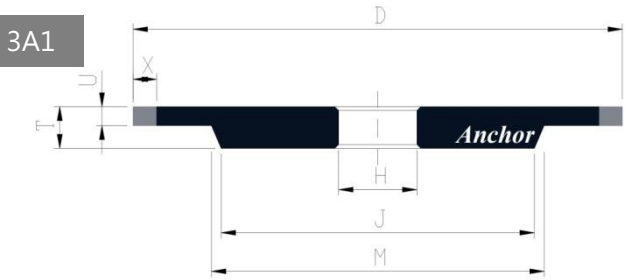
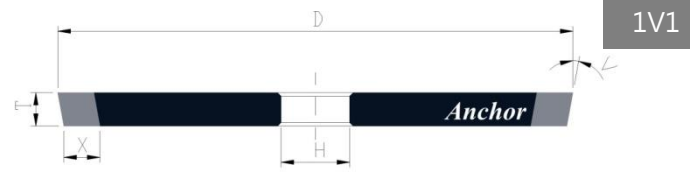
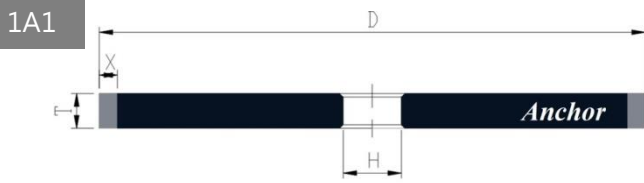




生產批號 / Lot No.

| 磨料<br>Abrasive               | 粒度<br>Grit Size   | 硬度<br>Hardness          | 集中度<br>Concentration         | 製法別<br>Bond                       | 形緣<br>Shape                              | 尺寸<br>Wheel size            |
|------------------------------|---|-------------------------|------------------------------|-----------------------------------|--|-----------------------------|
| SDC                          | 120   | N                       | 100                          | BMW                               | 1A1                                      | D x T x H x X               |
|                              |   |                         |                              |                                   | 1A1<br>1V1<br>3A1<br>3V1<br>14A1<br>14V1 |                             |
|                              | 粗 / Coarse<br>↑   |                         |                              |                                   | 開槽 Flute                                 | 75<br>100<br>125<br>150     |
| SD<br>SDC<br>適用鎢鋼<br>For T/C | 80<br>100<br>120<br>140   | 軟 / Soft<br>↑<br>N      | Low<br>↑<br>75<br>100<br>125 | BMW<br>HBMW<br>樹脂結合<br>Resin Bond | 11A2<br>12A2<br>11V9<br>12V9             | 外徑 Diameter / mm            |
| CBN<br>適用高速鋼<br>For HSS      | 200<br>230<br>325<br>500<br>600<br>800<br>1000<br>UP ↑<br>↓<br>細 / Fine | O<br>P<br>硬 / Hard<br>↓ | 150<br>↓<br>High             | MMW<br>金屬燒結<br>Metal Bond         | 刃角<br>OD Gash                            | 3 – 16<br>厚度 Thickness / mm |
|                              |   |                         |                              |                                   | 1A1R<br>切斷<br>Cut-off                    |                             |
|                              |   |                         |                              |                                   | 1A1<br>9A1<br>無心研磨<br>Centerless         |                             |

■ 其他形緣尺寸亦可訂製，詳細介紹請參閱官網鑽石砂輪尺寸及形狀標示。



應用於鎢鋼棒材切割，嘉寶新一代的BCW樹脂法切割片配方，經過不斷地改良，表現出優異的切削性與壽命，具有相當高的性價比。

### 產品特色：

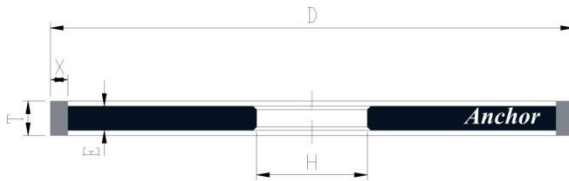
1. 優異切削力
2. 研磨壽命長
3. 加工精度高



鋼條切斷製程示意圖

### 標準品規格尺寸

#### 1A1R



| 規格<br>Specification | 外徑<br>D | 厚度<br>T | 孔徑<br>H       | 基板<br>E | 鑽石層<br>X |
|---------------------|---------|---------|---------------|---------|----------|
| ● SDC120P125BCW1A1R | 153     | 0.8     | 19.05 / 31.75 | 0.6     | 7.5      |
| ● SDC120P125BCW1A1R | 153     | 1       | 19.05 / 31.75 | 0.8     | 7.5      |
| ● SDC120P125BCW1A1R | 153     | 1.2     | 19.05 / 31.75 | 1       | 7.5      |
| SDC120N125BCW1A1R   | 158     | 0.8     | 19.05 / 31.75 | 0.7     | 10       |
| SDC120N125BCW1A1R   | 158     | 1       | 19.05 / 31.75 | 0.8     | 10       |
| SDC120N125BCW1A1R   | 158     | 1.2     | 19.05 / 31.75 | 1       | 10       |
| SDC120R125BCW1A1R   | 180     | 0.8     | 19.05 / 31.75 | 0.6     | 6        |
| SDC120R125BCW1A1R   | 180     | 1       | 19.05 / 31.75 | 0.8     | 6        |
| SDC120R125BCW1A1R   | 180     | 1.2     | 19.05 / 31.75 | 1       | 6        |
| SDC120N100BCW1A1R   | 200     | 0.8     | 19.05 / 31.75 | 0.6     | 6        |
| SDC120N100BCW1A1R   | 200     | 1       | 19.05 / 31.75 | 0.8     | 6        |
| SDC120N100BCW1A1R   | 200     | 1.2     | 19.05 / 31.75 | 1       | 6        |

● 常備品 In stock。

■ 另有乾式切割配方及CBN配方適用HSS棒材切斷，其他規格尺寸亦可訂製，詳細介紹請參閱官網。

■ 帶基板切片，厚度最薄可達0.4mm。

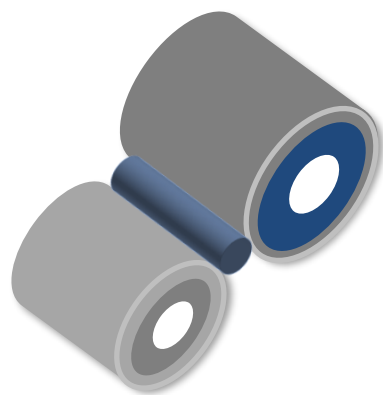
■ 無基板切片，厚度最薄可達0.2mm。

Unit : mm

應用於刀具棒材外徑研磨，嘉寶無心砂輪根據客戶使用機台類型與廠牌，均能客製化尺寸及法蘭心孔。粗細磨一體的設計，幫客戶降低研磨成本，提高生產效率。

### 產品特色：

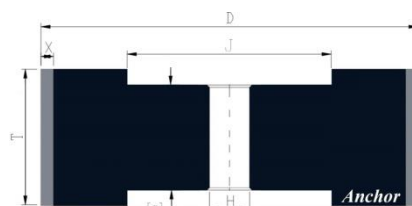
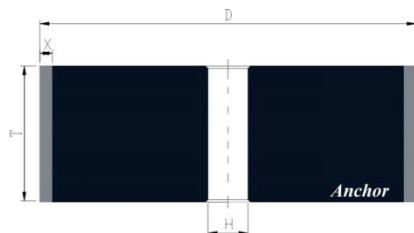
1. 高精度、高效率的圓棒外圓加工
2. 搭配各廠機台客製化設計
3. 搭配橡膠調整輪使用



鋼棒無心研磨示意圖

### 標準品規格尺寸

1A1、9A1



|  | 規格<br>Specification  | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 鑽石層<br>X |
|--|----------------------|---------|---------|---------|----------|
|  | SDC100N100BCG1A1     | 300     | 100     | 120     | 5, 10    |
|  | SDC140N100BCG9A1     | 300     | 150     | 120     | 5, 10    |
|  | SDC600N100BCG9A1     | 300     | 150     | 120     | 5, 10    |
|  | SDC80N100BCG9A1      | 450     | 205     | 228.6   | 5, 10    |
|  | SDC1000N100BCG9A1    | 450     | 205     | 228.6   | 5, 10    |
|  | CBN80/400N100BCG1A1  | 300     | 100     | 120     | 5, 10    |
|  | CBN140/400V100BCG9A1 | 400     | 205     | 228.6   | 5, 10    |
|  | CBN100/170V100BCG9A1 | 450     | 205     | 228.6   | 5, 10    |
|  | CBN100/170V100BCG9A1 | 500     | 205     | 304.8   | 5, 10    |

- SDC適用於鎢鋼(T/C)圓棒、CBN適用於HSS圓棒。
- 其他規格尺寸亦可訂製，詳細無心研磨砂輪介紹請參閱官網。

Unit : mm

### 研磨案例

|                 | 粗細磨適用粒度      |                            |
|-----------------|--------------|----------------------------|
| 粗磨 Pre-grinding | #100         | 極細目鑽石無心研磨鎢鋼棒面粗成功達Ra0.027um |
| 細磨 Finishing    | #325         |                            |
| 精磨 Polishing    | #1000 and up |                            |



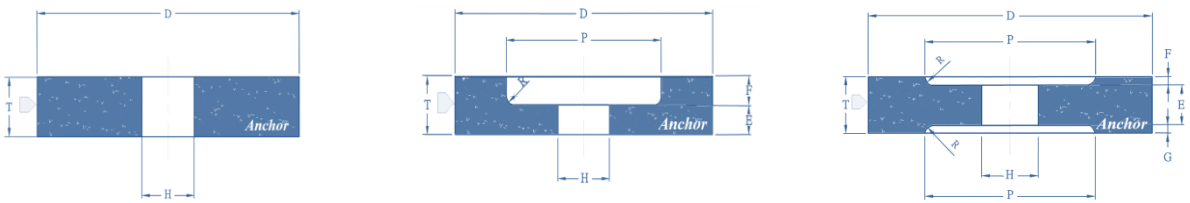
## 橡膠法調整輪

無心研磨調整輪通常為橡膠結合製法作成，主要的功用為：

1. 控制工作物的旋轉速度與進給速度。
2. 在研磨作業中提供工作物支撐力。
3. 控制工作物的直徑大小。

## 標準品規格尺寸

## 1A、5A、7A



| 規格<br>Specification | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 凹寬<br>P | 孔深<br>E | 凹深<br>F | 凹深<br>G |
|---------------------|---------|---------|---------|---------|---------|---------|---------|
| A150R0R1A           | 205     | 150     | 90      | -       | -       | -       | -       |
| A150R0R1A           | 255     | 205     | 111.2   | -       | -       | -       | -       |
| A150R0R5A           | 255     | 150     | 111.2   | 170     | 100     | -       | -       |
| A150R0R7A           | 305     | 205     | 127     | 200     | 110     | 75      | 20      |
| A150R0R7A           | 305     | 205     | 177.8   | 210     | 155     | 25      | 25      |



■ 其他規格尺寸亦可訂製。

Unit : mm

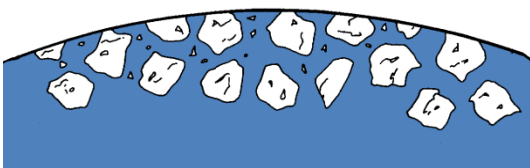
## 砂輪與調整輪尺寸搭配對照

| 砂輪外徑<br>Wheel diameter | 砂輪厚度<br>Wheel thickness | 調整輪外徑<br>Regulator diameter | 調整輪厚度<br>Regulator thickness |
|------------------------|-------------------------|-----------------------------|------------------------------|
| 300                    | 100 150                 | 205                         | 100 150                      |
| 350                    | 150 205                 | 205                         | 150 205                      |
| 400                    | 150 205                 | 255                         | 150 205                      |
| 450                    | 150 205                 | 255                         | 150 205                      |
| 500                    | 150 205                 | 305                         | 150 205                      |

Unit : mm

「修整」又稱為「修正」( Truing )—砂輪安裝後，為求與砂輪心軸同心，或將變形的砂輪磨面修平或者整形成所需要的特殊形狀與角度。如下圖一所示。

「修銳」( Dressing )—當砂輪表面相當平滑、磨料晶粒突出表面不多。如以此情況下之砂輪研磨，其砂輪會將其工作物燒焦或產生打滑現象。因此須將砂輪平滑表面或填塞的表面削去，即將包圍在磨料附近的結合劑、填塞物鐵屑等去除，使其磨料銳角能完全地露出砂輪表面，以產生研磨能力作用，稱之為修銳，如下圖二所示。



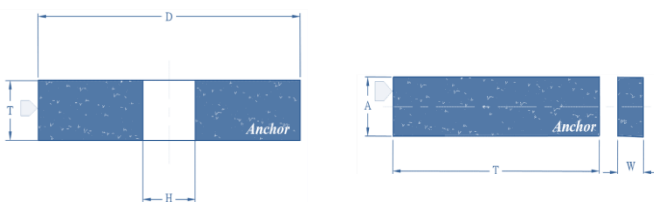
圖一 修整 Truing



圖二 修銳 Dressing

### 標準品規格尺寸

#### 1A、砂條-RT






| 規格<br>Specification | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 被修整砂輪粒度<br>for grit size |
|---------------------|---------|---------|---------|--------------------------|
| ● GC46J8V1A         | 180     | 13      | 31.75   | #80 and coarser          |
| ● GC80K5V1A         | 180     | 13      | 31.75   | #100 - #200              |
| ● GC120H5V1A        | 180     | 13      | 31.75   | #230 - #325              |
| ● GC220H5V1A        | 180     | 13      | 31.75   | #400 and finer           |
| ● GC400H8V1A        | 180     | 13      | 31.75   | #600 and finer           |
| WA220J8V1A          | 180     | 10      | 31.75   | #400 and finer           |
| 砂條 - RT             | T       | A       | W       | -                        |
| ● WA220H5V-RT       | 100     | 18      | 8       | Dressing stick           |



- 常備品 In stock。
- 其他規格尺寸亦可訂製。

Unit : mm

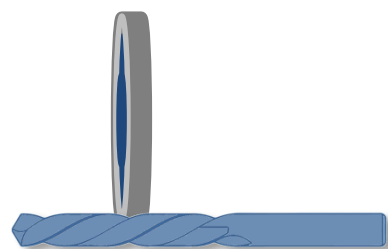
嘉寶金屬切削刀具研磨砂輪，依客戶加工需求及刀具類型，提供全系列相對應產品，特殊配方設計可使砂輪具備良好的保持力與切削力。

|  | 製法別<br>Bond type   | 產品特色<br>Products characteristics  |
|--|--|---|
|    | <p><b>MMW</b><br/>(Metal bonds)</p> <p><b>效率型</b></p>      | <p>極優異切削性與散熱性，適合大量深切緩進使用。<br/>適合砂輪鑽石層厚度8mm(含以上)加工使用。<br/>適用加工部位：FLUTE。</p>        |
|   | <p><b>HBMW</b><br/>(Polyimide bonds)</p> <p><b>耐用型</b></p> | <p>優異產品切削力與形狀保持力，砂輪耐用性佳。<br/>適合砂輪鑽石層厚度6mm(含以上)加工使用。<br/>適用加工部位：FLUTE。</p>         |
|  | <p><b>BMW</b><br/>(Resin bonds)</p> <p><b>經濟型</b></p>      | <p>良好切削性能表現與產品售價實惠。<br/>鑽石層厚度6mm 以下較小尺寸加工使用。<br/>適用加工部位：FLUTE、OD/RELIEF、GASH。</p> |

好切、耐磨、低負載

產品特色：

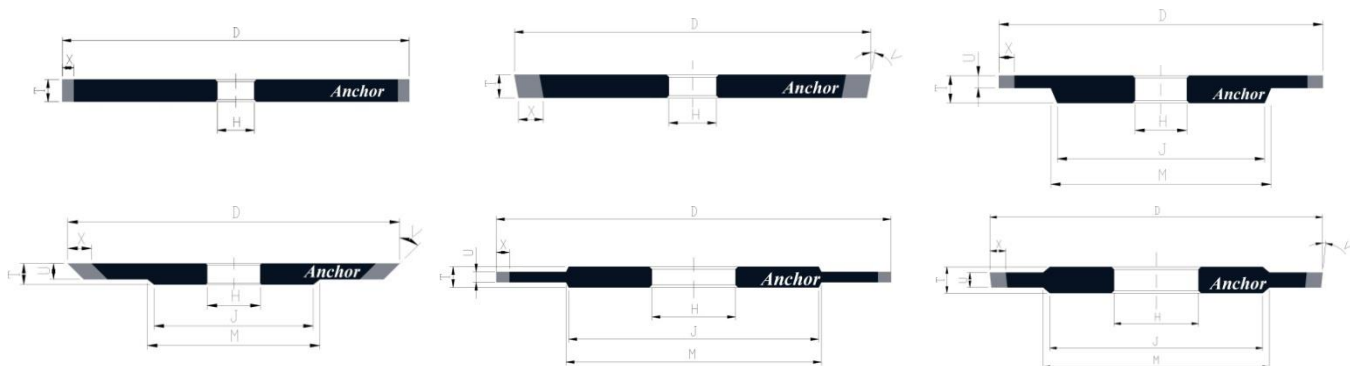
1. 極優異切削性與散熱性，適合大量深切緩進使用。
2. 適合砂輪鑽石層厚度8mm(含以上)加工使用。
3. 建議加工部位：FLUTE。



開槽研磨示意圖

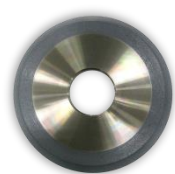
標準品規格尺寸

1A1、1V1、3A1、3V1、14A1、14V1



| 規格<br>Specification | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 鑽石層<br>X | 角度<br>V |
|---------------------|---------|---------|---------|----------|---------|
| SD270N125MMW 1A1    | 75      | 6       | 31.75   | 6        | -       |
| SD270N125MMW 1A1    | 75      | 6       | 31.75   | 8        | -       |
| SD270N125MMW 1A1    | 75      | 8       | 20      | 10       | -       |
| SD270N125MMW 1A1    | 75      | 10      | 20      | 10       | -       |
| SD270N125MMW 1A1    | 75      | 12      | 20      | 10       | -       |
| SD270N125MMW 1A1    | 100     | 8       | 20      | 6        | -       |
| SD270N125MMW 1A1    | 100     | 8       | 20      | 8        | -       |
| SD270N125MMW 1A1    | 100     | 10      | 20      | 8        | -       |
| SD270N125MMW 1A1    | 100     | 10      | 31.75   | 10       | -       |
| SD270N125MMW 1A1    | 100     | 12      | 20      | 10       | -       |

- SDC適用於鎢鋼(T/C)圓棒、另有CBN配方適用於HSS圓棒。
- 其他規格尺寸及V形角度亦可訂製。



| 規格<br>Specification | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 端部<br>U | 鑽石層<br>X | 角度<br>V |
|---------------------|---------|---------|---------|---------|----------|---------|
| SD270N125MMW 1A1    | 125     | 6       | 20      | -       | 8        | -       |
| SD270N125MMW 1A1    | 125     | 6       | 20      | -       | 10       | -       |
| SD270N125MMW 1A1    | 125     | 8       | 20      | -       | 8        | -       |
| SD270N125MMW 1A1    | 125     | 10      | 20      | -       | 10       | -       |
| SD270N125MMW 1A1    | 125     | 12      | 20      | -       | 10       | -       |
| SD270N125MMW 1A1    | 125     | 16      | 20      | -       | 10       | -       |
| SD270N125MMW 1A1    | 150     | 8       | 20      | -       | 10       | -       |
| SD270N125MMW 1A1    | 150     | 10      | 20      | -       | 10       | -       |
| SD270N125MMW 1A1    | 150     | 12      | 20      | -       | 10       | -       |
| SD270N125MMW 1V1    | 75      | 10      | 20      | -       | 6        | 30°     |
| SD270N125MMW 1V1    | 100     | 6       | 20      | -       | 6        | 20°     |
| SD270N125MMW 1V1    | 100     | 10      | 20      | -       | 6        | 30°     |
| SD270N125MMW 1V1    | 125     | 6       | 20      | -       | 10       | 10°     |
| SD270N125MMW 1V1    | 125     | 10      | 20      | -       | 10       | 10°     |
| SD270N125MMW 1V1    | 125     | 10      | 20      | -       | 10       | 20°     |
| SD270N125MMW 1V1    | 125     | 12      | 20      | -       | 10       | 10°     |
| SD270N125MMW 1V1    | 150     | 8       | 20      | -       | 10       | 10°     |
| SD270N125MMW 1V1    | 150     | 10      | 20      | -       | 10       | 10°     |
| SD270N125MMW 1V1    | 150     | 10      | 20      | -       | 10       | 45°     |
| SD270N125MMW 3A1    | 125     | 8       | 20      | 5       | 10       | -       |
| SD270N125MMW 3A1    | 150     | 8       | 20      | 5       | 8        | -       |
| SD270N125MMW 3A1    | 150     | 8       | 20      | 6       | 10       | -       |
| SD270N125MMW 3A1    | 150     | 8       | 40      | 5       | 8        | -       |
| SD270N125MMW 3A1    | 150     | 8       | 40      | 6       | 10       | -       |
| SD270N125MMW 3A1    | 150     | 8       | 50      | 5       | 8        | -       |
| SD270N125MMW 3A1    | 150     | 8       | 50      | 6       | 10       | -       |
| SD270N125MMW 3V1    | 75      | 12      | 20      | 10      | 6        | 30°     |
| SD270N125MMW 3V1    | 100     | 6       | 20      | 3       | 10       | 60°     |
| SD270N125MMW 14A1   | 100     | 10      | 20      | 8       | 10       | -       |
| SD270N125MMW 14A1   | 125     | 8       | 20      | 5       | 10       | -       |

- SDC適用於鎢鋼(T/C)圓棒、另有CBN配方適用於HSS圓棒。
- 其他規格尺寸及V形角度亦可訂製。

$Q_w$ 值乃透過砂輪切深(Ae)及橫送速度(vt)等參數，計算出單位時間內工件的移除量，做為評估砂輪切削效率的參考值。

$Q_w$ 值計算方式 Calculation of  $Q_w$  value

$$Q_w = \frac{Ae \times Vt}{60}$$

Vt = 橫移速度 / Traverse speed  
 Ae = 砂輪切深 / Infeed  
 Vc = 建議砂輪轉速 / Recommend wheel speed

|         |     | Vt (mm/min) |     |     |     |     |     |     |     |      |      |      |      |      |
|---------|-----|-------------|-----|-----|-----|-----|-----|-----|-----|------|------|------|------|------|
|         |     | 30          | 40  | 50  | 60  | 70  | 80  | 90  | 100 | 120  | 140  | 160  | 180  | 200  |
| Ae (mm) | 2.6 | 1.3         | 1.7 | 2.2 | 2.6 | 3.0 | 3.5 | 3.9 | 4.3 | 5.2  | 6.1  | 6.9  | 7.8  | 8.7  |
|         | 2.8 | 1.4         | 1.9 | 2.3 | 2.8 | 3.3 | 3.7 | 4.2 | 4.7 | 5.6  | 6.5  | 7.5  | 8.4  | 9.3  |
|         | 3.0 | 1.5         | 2.0 | 2.5 | 3.0 | 3.5 | 4.0 | 4.5 | 5.0 | 6.0  | 7.0  | 8.0  | 9.0  | 10.0 |
|         | 3.2 | 1.6         | 2.1 | 2.7 | 3.2 | 3.7 | 4.3 | 4.8 | 5.3 | 6.4  | 7.5  | 8.5  | 9.6  | 10.7 |
|         | 3.4 | 1.7         | 2.3 | 2.8 | 3.4 | 4.0 | 4.5 | 5.1 | 5.7 | 6.8  | 7.9  | 9.1  | 10.2 | 11.3 |
|         | 3.6 | 1.8         | 2.4 | 3.0 | 3.6 | 4.2 | 4.8 | 5.4 | 6.0 | 7.2  | 8.4  | 9.6  | 10.8 | 12.0 |
|         | 3.8 | 1.9         | 2.5 | 3.2 | 3.8 | 4.4 | 5.1 | 5.7 | 6.3 | 7.6  | 8.9  | 10.1 | 11.4 | 12.7 |
|         | 4.0 | 2.0         | 2.7 | 3.3 | 4.0 | 4.7 | 5.3 | 6.0 | 6.7 | 8.0  | 9.3  | 10.7 | 12.0 | 13.3 |
|         | 4.2 | 2.1         | 2.8 | 3.5 | 4.2 | 4.9 | 5.6 | 6.3 | 7.0 | 8.4  | 9.8  | 11.2 | 12.6 | 14.0 |
|         | 4.4 | 2.2         | 2.9 | 3.7 | 4.4 | 5.1 | 5.9 | 6.6 | 7.3 | 8.8  | 10.3 | 11.7 | 13.2 | 14.7 |
|         | 4.6 | 2.3         | 3.1 | 3.8 | 4.6 | 5.4 | 6.1 | 6.9 | 7.7 | 9.2  | 10.7 | 12.3 | 13.8 | 15.3 |
|         | 4.8 | 2.4         | 3.2 | 4.0 | 4.8 | 5.6 | 6.4 | 7.2 | 8.0 | 9.6  | 11.2 | 12.8 | 14.4 | 16.0 |
|         | 5.0 | 2.5         | 3.3 | 4.2 | 5.0 | 5.8 | 6.7 | 7.5 | 8.3 | 10.0 | 11.7 | 13.3 | 15.0 | 16.7 |

橫送速度起始值  
Vf start value

橫送速度潛力值  
Vf optimization potential

閱覽方向  
Reading Direction

MMW建議參數與 $Q_w$ 值 Recommended  $Q_w$  values for MMW

| 砂輪轉速 Vc     | $Q_w$ 值 $mm^3/s$             |                           |
|-------------|------------------------------|---------------------------|
|             | 標準區間<br>Standard performance | 高效率區間<br>High performance |
| 15 – 25 m/s | 3 – 6                        | 7 - 10                    |

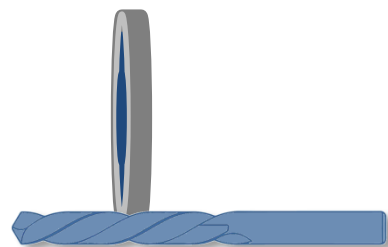
研磨案例分享 Case study

|      |  |      |                |
|------|--|------|----------------|
| 砂輪規格 | SD270N125MMW1A110  | 工件材質 | T/C            |
| 砂輪尺寸 | 100X10X31.75X10  | 砂輪轉速 | 21 – 22.5 m/s  |
| 機台廠牌 | ANCA   | 砂輪切深 | 3 mm           |
| 橫送速度 | 100 mm/min   | 修整頻率 | 800 pcs / time |
| 測試結果 | $QW = 3 \times 100 / 60 = 5$<br>優勢：切削力表現佳、機台負載穩定、產量加工成本明顯降低。 |      |                |

## 大進給、低負載

### 產品特色:

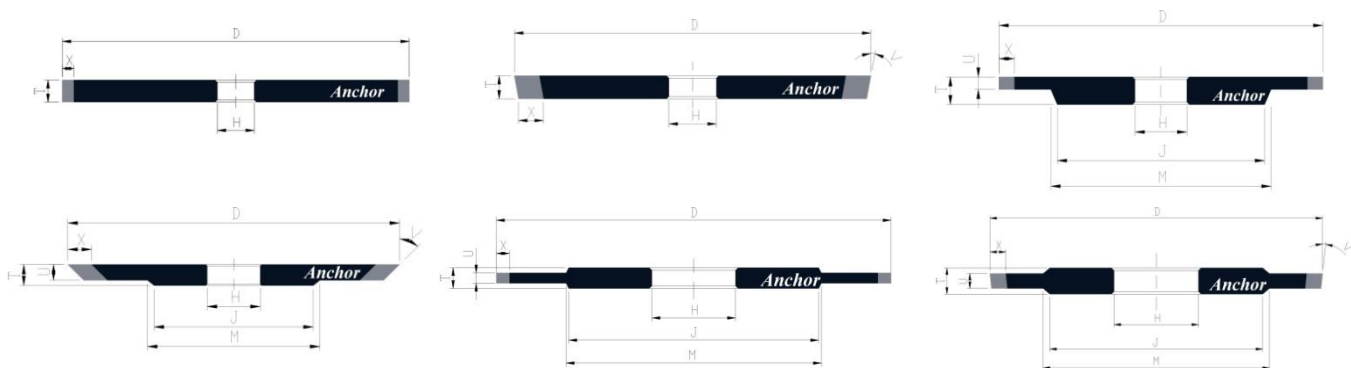
1. 優異的切削力與耐用性，形狀保持度佳。
2. 適合砂輪鑽石層厚度6mm(含以上)加工使用。
3. 建議加工部位：FLUTE。



開槽研磨示意圖

### 標準品規格尺寸

1A1、1V1、3A1、3V1、14A1、14V1



| 規格<br>Specification | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 鑽石層<br>X | 角度<br>V |
|---------------------|---------|---------|---------|----------|---------|
| SDC270N125HBMW 1A1  | 75      | 6       | 20      | 6        | -       |
| SDC270N125HBMW 1A1  | 75      | 6       | 20      | 10       | -       |
| SDC270N125HBMW 1A1  | 75      | 8       | 20      | 10       | -       |
| SDC270N125HBMW 1A1  | 75      | 10      | 20      | 10       | -       |
| SDC270N125HBMW 1A1  | 100     | 6       | 20      | 6        | -       |
| SDC270N125HBMW 1A1  | 100     | 8       | 20      | 6        | -       |
| SDC270N125HBMW 1A1  | 100     | 10      | 20      | 10       | -       |
| SDC270N125HBMW 1A1  | 100     | 10      | 31.75   | 10       | -       |
| SDC270N125HBMW 1A1  | 100     | 12      | 20      | 10       | -       |
| SDC270N125HBMW 1A1  | 100     | 15      | 20      | 10       | -       |
| SDC270N125HBMW 1A1  | 125     | 8       | 20      | 6        | -       |
| SDC270N125HBMW 1A1  | 125     | 8       | 20      | 8        | -       |
| SDC270N125HBMW 1A1  | 125     | 8       | 20      | 10       | -       |

- SDC適用於鎢鋼(T/C)圓棒、另有CBN配方適用於HSS圓棒。
- 其他規格尺寸及V形角度亦可訂製。



| 規格<br>Specification | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 端部<br>U | 鑽石層<br>X | 角度<br>V |
|---------------------|---------|---------|---------|---------|----------|---------|
| SDC270N125HBMW 1A1  | 125     | 10      | 20      | -       | 8        | -       |
| SDC270N125HBMW 1A1  | 125     | 10      | 20      | -       | 10       | -       |
| SDC270N125HBMW 1A1  | 125     | 12      | 20      | -       | 10       | -       |
| SDC270N125HBMW 1A1  | 125     | 15      | 20      | -       | 10       | -       |
| SDC270N125HBMW 1A1  | 150     | 8       | 20      | -       | 6        | -       |
| SDC270N125HBMW 1A1  | 150     | 10      | 20      | -       | 10       | -       |
| SDC270N125HBMW 1A1  | 150     | 10      | 31.75   | -       | 10       | -       |
| SDC270N125HBMW 1A1  | 150     | 16      | 20      | -       | 10       | -       |
| SDC270N125HBMW 1V1  | 75      | 8       | 20      | -       | 6        | 20°     |
| SDC270N125HBMW 1V1  | 100     | 6       | 20      | -       | 10       | 20°     |
| SDC270N125HBMW 1V1  | 100     | 8       | 20      | -       | 6        | 15°     |
| SDC270N125HBMW 1V1  | 100     | 10      | 20      | -       | 10       | 10°     |
| SDC270N125HBMW 1V1  | 100     | 12      | 20      | -       | 10       | 10°     |
| SDC270N125HBMW 1V1  | 125     | 6       | 20      | -       | 10       | 15°     |
| SDC270N125HBMW 1V1  | 125     | 8       | 20      | -       | 10       | 45°     |
| SDC270N125HBMW 1V1  | 125     | 10      | 20      | -       | 6        | 10°     |
| SDC270N125HBMW 1V1  | 125     | 10      | 20      | -       | 10       | 20°     |
| SDC270N125HBMW 1V1  | 125     | 16      | 20      | -       | 10       | 20°     |
| SDC270N125HBMW 1V1  | 150     | 6       | 20      | -       | 10       | 10°     |
| SDC270N125HBMW 1V1  | 150     | 8       | 20      | -       | 10       | 10°     |
| SDC270N125HBMW 1V1  | 150     | 10      | 20      | -       | 10       | 10°     |
| SDC270N125HBMW 1V1  | 150     | 12      | 20      | -       | 10       | 10°     |
| SDC270N125HBMW 3A1  | 125     | 6       | 20      | 3       | 6        | -       |
| SDC400N125HBMW 3A1  | 125     | 6       | 20      | 2       | 10       | -       |
| SDC270N125HBMW 3V1  | 125     | 8       | 20      | 5       | 10       | 10°     |
| SDC270N125HBMW 3V1  | 125     | 8       | 20      | 5       | 10       | 45°     |
| SDC270N125HBMW 14A1 | 150     | 15      | 31.75   | 13      | 10       | -       |

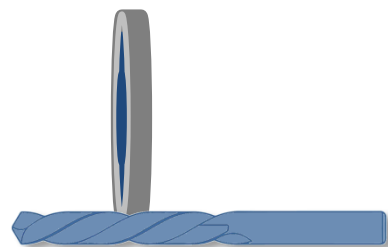
- SDC適用於鎢鋼(T/C)圓棒、另有CBN配方適用於HSS圓棒。
- 其他規格尺寸及v形角度亦可訂製。



## 經濟實惠、效果佳

### 產品特色：

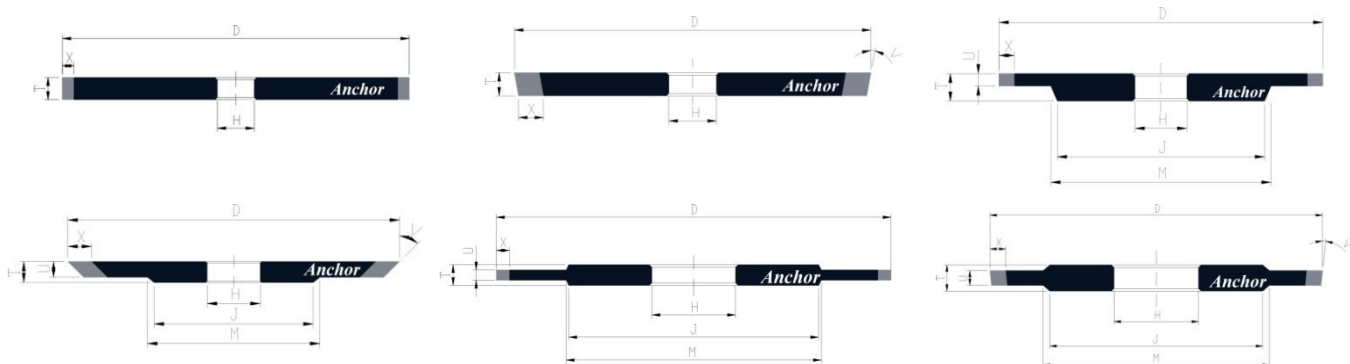
1. 良好切削效能表現，價格實惠。
2. 適合砂輪鑽石層厚度6mm以下較小尺寸加工。
3. 建議加工部位：FLUTE。



開槽研磨示意圖


### 標準品規格尺寸

1A1、1V1、3A1、3V1、14A1、14V1



| 規格<br>Specification | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 鑽石層<br>X | 角度<br>V |
|---------------------|---------|---------|---------|----------|---------|
| SDC270N125BMW 1A1   | 75      | 4       | 20      | 5        | -       |
| SDC270N125BMW 1A1   | 75      | 4       | 20      | 6        | -       |
| SDC270N125BMW 1A1   | 75      | 6       | 20      | 8        | -       |
| SDC270N125BMW 1A1   | 100     | 6       | 20      | 5        | -       |
| SDC270N125BMW 1A1   | 100     | 6       | 20      | 6        | -       |
| SDC270N125BMW 1A1   | 100     | 6       | 20      | 8        | -       |
| SDC270N125BMW 1A1   | 100     | 6       | 20      | 10       | -       |
| SDC270N125BMW 1A1   | 125     | 5       | 20      | 6        | -       |
| SDC270N125BMW 1A1   | 125     | 6       | 20      | 6        | -       |
| SDC270N125BMW 1A1   | 125     | 8       | 20      | 10       | -       |
| SDC270N125BMW 1A1   | 150     | 10      | 31.75   | 6        | -       |
| SDC270N125BMW 1A1   | 150     | 10      | 20      | 10       | -       |

- SDC適用於鎢鋼(T/C)圓棒、另有CBN配方適用於HSS圓棒。
- 其他規格尺寸及v形角度亦可訂製。



| 規格<br>Specification | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 端部<br>U | 鑽石層<br>X | 角度<br>V |
|---------------------|---------|---------|---------|---------|----------|---------|
| SDC270N125BMW 1V1   | 75      | 6       | 20      | -       | 8        | 30°     |
| SDC270N125BMW 1V1   | 75      | 6       | 20      | -       | 8        | 35°     |
| SDC270N125BMW 1V1   | 75      | 6       | 20      | -       | 8        | 40°     |
| SDC270N125BMW 1V1   | 75      | 6       | 20      | -       | 10       | 10°     |
| SDC270N125BMW 1V1   | 100     | 6       | 20      | -       | 8        | 45°     |
| SDC270N125BMW 1V1   | 100     | 6       | 20      | -       | 10       | 15°     |
| SDC270N125BMW 1V1   | 100     | 6       | 20      | -       | 10       | 20°     |
| SDC270N125BMW 1V1   | 100     | 6       | 20      | -       | 10       | 30°     |
| SDC270N125BMW 1V1   | 100     | 6       | 20      | -       | 10       | 45°     |
| SDC270N125BMW 1V1   | 100     | 6       | 20      | -       | 10       | 60°     |
| SDC270N125BMW 1V1   | 125     | 6       | 20      | -       | 10       | 15°     |
| SDC270N125BMW 1V1   | 125     | 6       | 31.75   | -       | 10       | 45°     |
| SDC270N125BMW 1V1   | 150     | 8       | 20      | -       | 10       | 15°     |
| SDC270N125BMW 3A1   | 75      | 8       | 20      | 6       | 6        | -       |
| SDC270N125BMW 3A1   | 100     | 6       | 20      | 3       | 6        | -       |
| SDC270N125BMW 3A1   | 100     | 6       | 20      | 4       | 8        | -       |
| SDC270N125BMW 3A1   | 125     | 8       | 20      | 4       | 8        | -       |
| SDC270N125BMW 3A1   | 125     | 8       | 20      | 6       | 10       | -       |
| SDC270N125BMW 3A1   | 150     | 8       | 20      | 4       | 8        | -       |
| SDC270N125BMW 3A1   | 150     | 12      | 20      | 6       | 10       | -       |
| SDC270N125BMW 3V1   | 75      | 8       | 20      | 4       | 4        | 45°     |
| SDC270N125BMW 3V1   | 75      | 8       | 20      | 4       | 6        | 30°     |
| SDC270N125BMW 3V1   | 100     | 6       | 20      | 3       | 8        | 30°     |
| SDC270N125BMW 3V1   | 100     | 6       | 20      | 4       | 8        | 30°     |
| SDC270N125BMW 3V1   | 100     | 8       | 20      | 5       | 10       | 15°     |
| SDC270N125BMW 3V1   | 125     | 6       | 20      | 4       | 8        | 45°     |
| SDC270N125BMW 3V1   | 125     | 8       | 20      | 6       | 8        | 45°     |
| SDC270N125BMW 3V1   | 150     | 6       | 20      | 3       | 6        | 30°     |
| SDC270N125BMW 3V1   | 150     | 6       | 20      | 4       | 10       | 10°     |

- SDC適用於鎢鋼(T/C)圓棒、另有CBN配方適用於HSS圓棒。
- 其他規格尺寸及V形角度亦可訂製。

## 經濟實惠、保持度良好

### 產品特色：

1. 耐磨壽命佳，價格實惠。
2. 建議加工部位：OD/Relief、Gash。



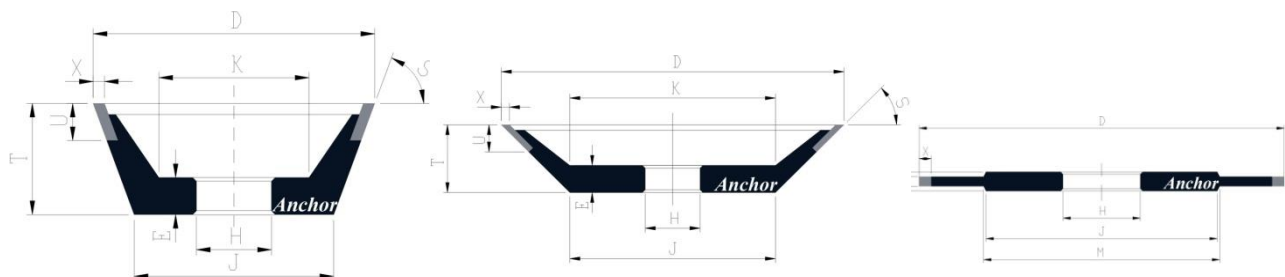
Gash



OD/Relief

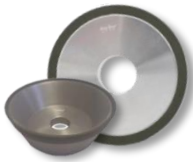

### 標準品規格尺寸

11V9、12V9、14A1



| 規格<br>Specification | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 端部<br>U | 鑽石層<br>X |
|---------------------|---------|---------|---------|---------|----------|
| SDC325N100BMW 14A1  | 75      | 10      | 20      | 2       | 5        |
| SDC325N100BMW 14A1  | 75      | 10      | 20      | 3       | 5        |
| SDC325N100BMW 14A1  | 75      | 6       | 20      | 4       | 6        |
| SDC325N100BMW 14A1  | 100     | 10      | 20      | 2       | 5        |
| SDC325N100BMW 14A1  | 100     | 10      | 20      | 3       | 6        |
| SDC325N100BMW 14A1  | 100     | 8       | 20      | 4       | 10       |
| SDC325N100BMW 14A1  | 125     | 10      | 20      | 3       | 5        |
| SDC325N100BMW 14A1  | 125     | 10      | 20      | 4       | 6        |
| SDC325N100BMW 14A1  | 125     | 10      | 31.75   | 6       | 5        |
| SDC325N100BMW 14A1  | 125     | 8       | 20      | 4       | 10       |
| SDC325N100BMW 14A1  | 150     | 6       | 20      | 3       | 8        |
| SDC325N100BMW 14A1  | 150     | 10      | 20      | 4       | 8        |

- SDC適用於鎢鋼(T/C)圓棒、另有CBN配方適用於HSS圓棒。
- 其他規格尺寸及V形角度亦可訂製。

| 規格<br>Specification   |                     | 外徑<br>D | 厚度<br>T | 孔徑<br>H | 端部<br>U | 鑽石層<br>X | 角度<br>V |
|---|---------------------|---------|---------|---------|---------|----------|---------|
|                           | SDC325N100BMW 11V9  | 75      | 25      | 20      | 7       | 3        | 70°     |
|   | SDC325N100BMW 11V9  | 75      | 30      | 20      | 8       | 4        | 70°     |
|   | SDC325N100BMW 11V9  | 75      | 30      | 20      | 10      | 4        | 70°     |
|   | SDC325N100BMW 11V9  | 75      | 32      | 20      | 10      | 5        | 70°     |
|   | SDC325N100BMW 11V9  | 100     | 35      | 20      | 8       | 3        | 70°     |
|   | SDC325N100BMW 11V9  | 100     | 35      | 31.75   | 10      | 3        | 70°     |
|   | SDC325N100BMW 11V9  | 100     | 35      | 20      | 10      | 4        | 70°     |
|   | SDC325N100BMW 11V9  | 100     | 35      | 20      | 10      | 5        | 70°     |
|   | SDC325N100BMW 11V9  | 100     | 35      | 20      | 12      | 4        | 70°     |
|   | SDC325N100BMW 11V9  | 100     | 35      | 31.75   | 12      | 5        | 70°     |
|   | SDC325N100BMW 11V9  | 125     | 40      | 20      | 10      | 3        | 70°     |
|   | SDC325N100BMW 11V9  | 125     | 45      | 31.75   | 10      | 4        | 70°     |
|   | SDC325N100BMW 12V9  | 75      | 20      | 20      | 6       | 3        | 45°     |
|   | SDC325N100BMW 12V9  | 75      | 20      | 20      | 10      | 3        | 45°     |
|   | SDC325N100BMW 12V9  | 100     | 20      | 20      | 6       | 3        | 45°     |
|   | SDC325N100BMW 12V9  | 100     | 30      | 20      | 8       | 3        | 45°     |
|   | SDC325N100BMW 12V9  | 100     | 22      | 20      | 8       | 5        | 45°     |
|   | SDC325N100BMW 12V9  | 100     | 35      | 20      | 10      | 3        | 45°     |
|   | SDC325N100BMW 12V9  | 100     | 20      | 20      | 9       | 7        | 45°     |
| SDC325N100BMW 12V9  | 125                 | 25      | 20      | 10      | 3       | 45°      |         |
| SDC325N100BMW 12V9  | 125                 | 25      | 20      | 10      | 5       | 45°      |         |
| SDC325N100BMW 12V9  | 125                 | 25      | 20      | 12      | 3       | 30°      |         |
| <br>HBMW<br>MMW<br>亦可訂製 | SDC325N125HBMW 11V9 | 75      | 32      | 20      | 10      | 4        | 70°     |
|   | SDC325N125HBMW 11V9 | 95      | 30      | 20      | 10      | 4        | 70°     |
|   | SDC325N125HBMW 11V9 | 80      | 40      | 20      | 10      | 4        | 80°     |
|   | SDC325N125HBMW 11V9 | 125     | 40      | 20      | 10      | 4        | 70°     |
|   | SD325N125MMW 11V9   | 75      | 30      | 20      | 8       | 3.5      | 70°     |
|   | SD325N125MMW 11V9   | 75      | 30      | 20      | 10      | 5        | 70°     |
|   | SD325N125MMW 12V9   | 125     | 16      | 31.75   | 8       | 3        | 30°     |

- SDC適用於鎢鋼(T/C)圓棒、另有CBN配方適用於HSS圓棒。
- 其他規格尺寸及V形角度亦可訂製。

金屬切削刀具砂輪專用技術調查表  
Technical data sheet



|              |  |              |  |                  |  |
|--------------|--|--------------|--|------------------|--|
| 客戶名稱<br>Name |  | 填表日期<br>Date |  | 成品圖號<br>Draw No. |  |
|--------------|--|--------------|--|------------------|--|

現用砂輪資訊 Present Brand

|                                      |             |                |             |
|--------------------------------------|-------------|----------------|-------------|
| 規格尺寸<br>Specification and wheel size | 單價<br>Price | 用量/月<br>Amount | 廠牌<br>Brand |
|                                      |             |                |             |
|                                      |             |                |             |

現用砂輪使用狀態及改善要求 Current status

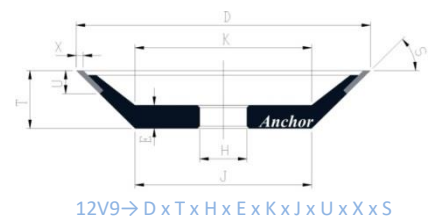
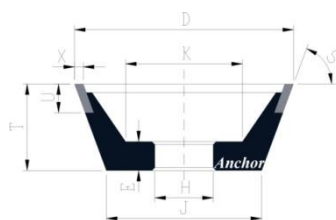
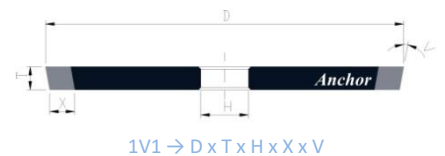
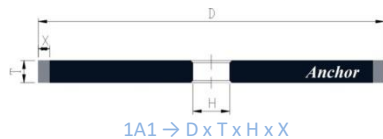
|  |  |  |  |
|--|--|--|--|
|  |  |  |  |
|--|--|--|--|

工件物資訊 Work piece

機械及研磨條件 Machine and parameter

|                         |  |                        |                                  |                |
|-------------------------|--|------------------------|----------------------------------|----------------|
| 工件名稱<br>Work piece      |  | 廠牌型號<br>Machine brand  |                                  |                |
| 工件材質<br>Material        | <input type="radio"/> 鎢鋼T/C <input type="radio"/> 高速鋼HSS   | 砂輪轉速<br>Wheel speed    | m/s                              | RPM            |
| 工件硬度<br>Hardness        | HRC/HRA  | 進給速度<br>Feed rate      | V=                               | mm/min         |
| 工件<br>研磨尺寸<br>Dimension | 刀徑 Flute diameter  | 進刀方式<br>In-feed method | 一次進刀 Once      mm                |                |
|                         | 刀長 Flute length  |                        | 兩次進刀 Twice      粗 Coarse      mm | 細 Fine      mm |
|                         | Shank Length      Diameter   |                        |                                  |                |
| 研磨部位<br>Process part    | <input type="radio"/> FLUTE <input type="radio"/> OD/RELIEF <input type="radio"/> TOP OD/RELIEF <input type="radio"/> GASH |                        |                                  |                |

請填入各部位尺寸 Please fill in size of each part)



砂輪型緣尺寸  
Type of wheel

■ 亦可線上填寫詢價系統。

立即前往 →  
Inquiry online

A large grid of graph paper, consisting of 20 columns and 30 rows of small squares, intended for technical drawing or data recording.

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