

# Anchor<sup>®</sup>

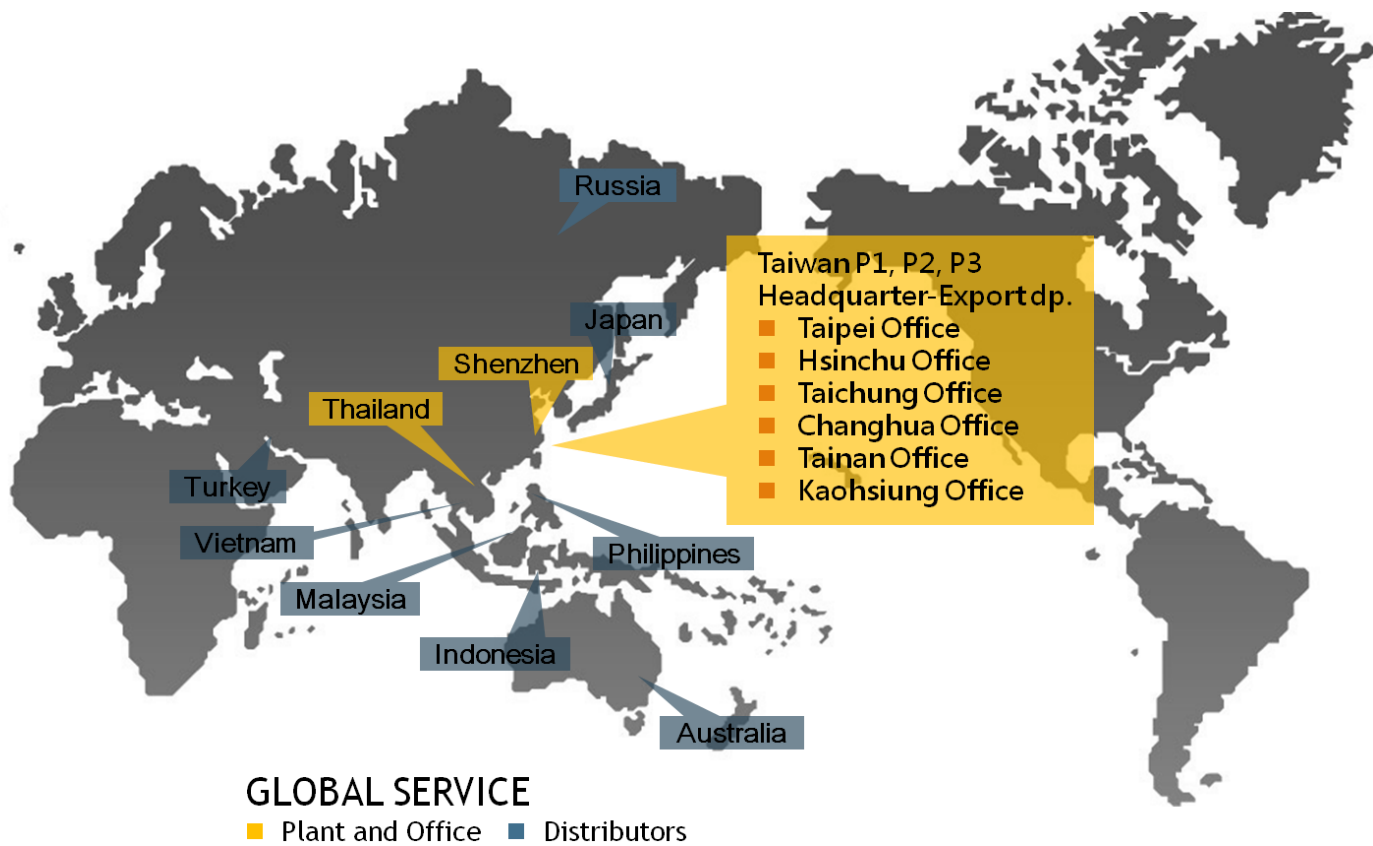
深化技术  
先端应用

Fine Tech  
New Apps



金属切削刀具研磨砂轮型录  
Grinding wheels for metal cutting tools


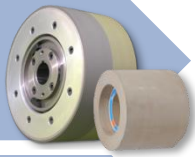


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钻头(Drills)、铣刀(Mills)研磨制程包含，(硬质合金)钢棒之切断，钢棒外径研磨、刀具剖沟开槽及刀刃刃口研磨，部分刀具(micron tools)则有段差研磨的需求。

| 刀具制程                       | 砂轮種類  | 嘉宝規格   |
|----------------------------|---|--|
| 钢棒切断加工<br>Cut-off          | 树脂法金刚石精密切断片<br>Precision cutting wheel          | BCW             |
| 钢棒外径研磨<br>Centerless Grind | 金刚石CBN無心砂轮、调整轮<br>Centerless and Control wheel  | BCG             |
| 钢棒开槽<br>Flute              | 金刚石CBN开槽砂轮<br>Fluting wheel                     | BMW HBMW MMW   |
| 离隙角、刃口研磨<br>OD/Relief、Gash | 金刚石CBN离隙砂轮<br>Clearance and face grinding wheel | BMW HBMW MMW  |

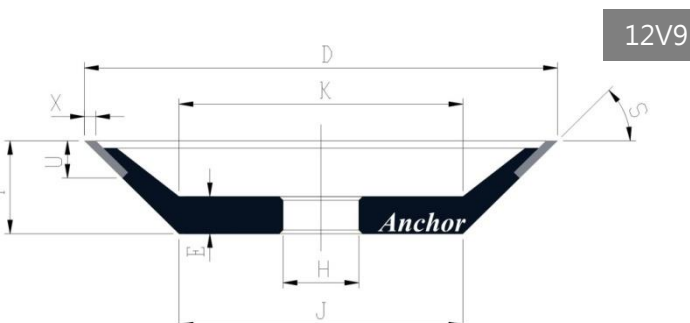
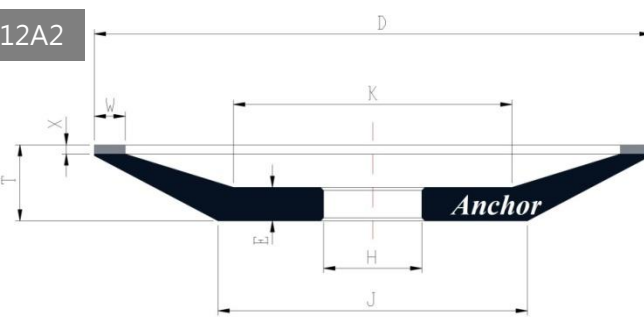
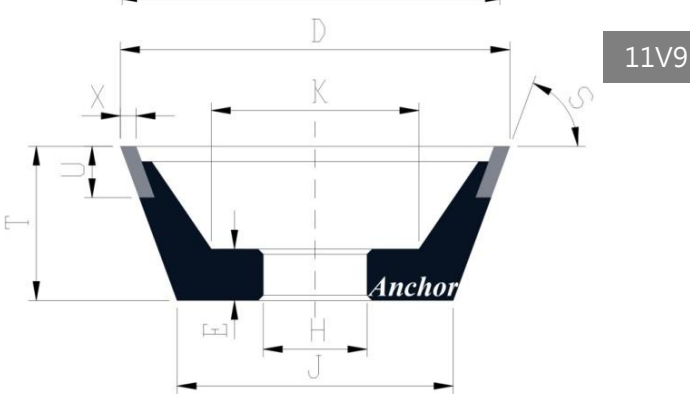
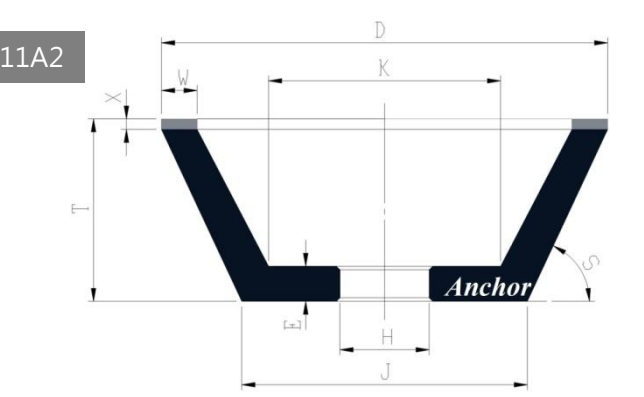
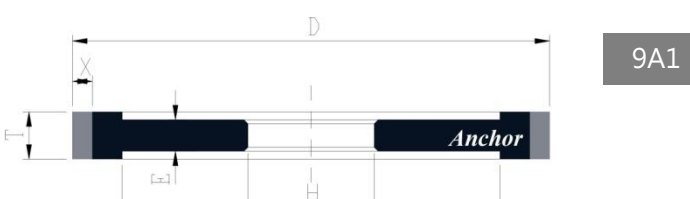
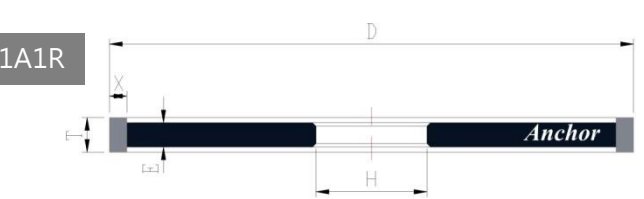
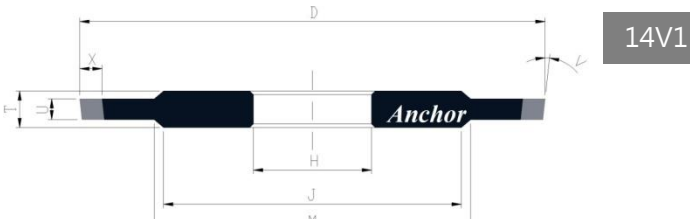
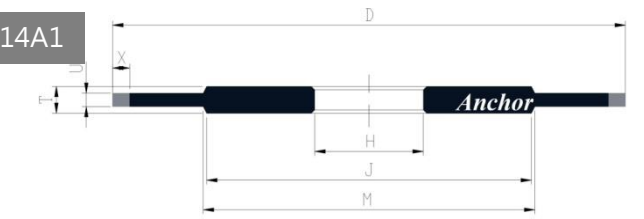
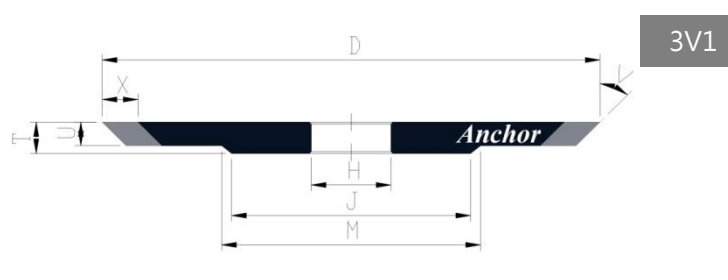
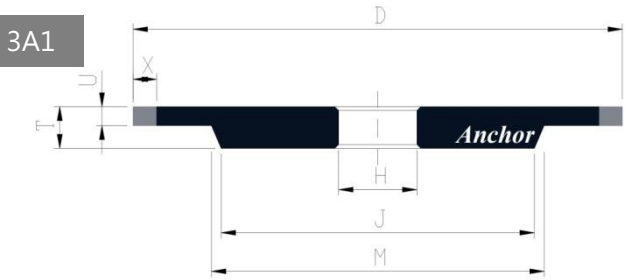
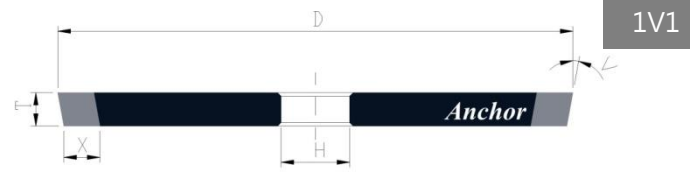
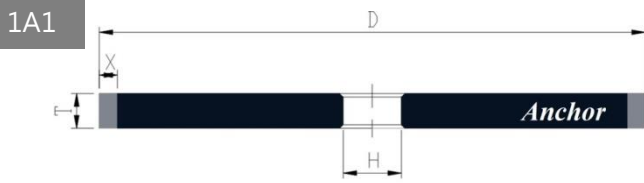




生产批号/ Lot No.

| 磨料<br>Abrasive | 粒度<br>Grit Size | 硬度<br>Hardness | 集中度<br>Concentration | 制法别<br>Bond | 形缘<br>Shape | 尺寸<br>Wheel size |
|----------------|-----------------|----------------|----------------------|-------------|-------------|------------------|
| SDC            | 120             | N              | 100                  | BMW         | 1A1         | D x T x H x X    |
|                |                 |                |                      |             | 1A1         |                  |
|                |                 |                |                      |             | 1V1         |                  |
|                |                 |                |                      |             | 3A1         |                  |
|                |                 |                |                      |             | 3V1         |                  |
|                |                 |                |                      |             | 14A1        |                  |
|                |                 |                |                      |             | 14V1        |                  |
|                |                 |                |                      |             | 开槽Flute     |                  |
|                |                 |                |                      |             |             | 75               |
|                |                 |                |                      |             |             | 100              |
|                |                 |                |                      |             |             | 125              |
|                |                 |                |                      |             |             | 150              |
|                |                 |                |                      |             |             | 外径Diameter / mm  |
|                |                 |                |                      |             |             | 3 - 16           |
|                |                 |                |                      |             |             | 厚度Thickness / mm |
|                |                 |                |                      |             | 1A1R        |                  |
|                |                 |                |                      |             | 切断          |                  |
|                |                 |                |                      |             | Cut-off     |                  |
|                |                 |                |                      |             | 1A1         |                  |
|                |                 |                |                      |             | 9A1         |                  |
|                |                 |                |                      |             | 无心研磨        |                  |
|                |                 |                |                      |             | Centerless  |                  |

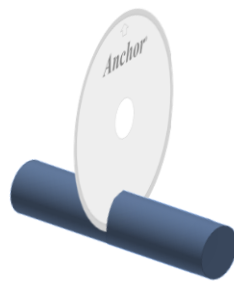
■ 其他形缘尺寸亦可订制，详细介绍请参阅官网钻石砂轮尺寸及形状标示。



应用于(硬质合金)钢棒材切割，嘉宝新一代的BCW树脂法切割片配方，经过不断地改良，表现出优异的切削性与寿命，具有相当高的性价比。

**产品特色：**

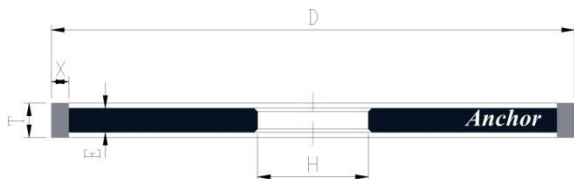
1. 优异切削力
2. 研磨寿命长
3. 加工精度高



钢棒切断制程示意图

标准品规格尺寸

1A1R



| 规格<br>Specification | 外径<br>D | 厚度<br>T | 孔径<br>H       | 基板<br>E | 钻石层<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        |



● 常备品 In stock。

■ 另有干式切割配方及CBN配方适用HSS棒材切断，其他规格尺寸亦可订制，详细介绍请参阅官网。

■ 带基板切片，厚度最薄可达0.4mm。

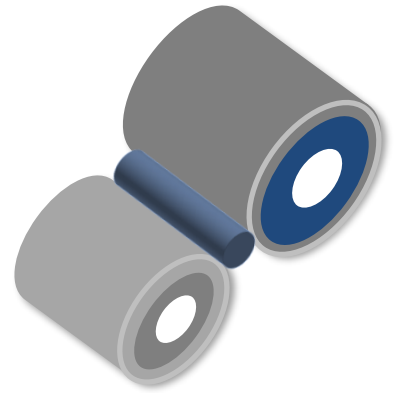
■ 无基板切片，厚度最薄可达0.2mm。

Unit : mm

应用于刀具棒材外径研磨，嘉宝无心砂轮根据客户使用机台类型与厂牌，均能客制化尺寸及法兰心孔。粗细磨一体的设计，帮客户降低研磨成本，提高生产效率。

### 产品特点：

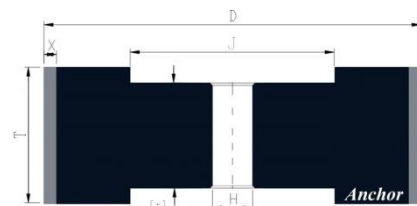
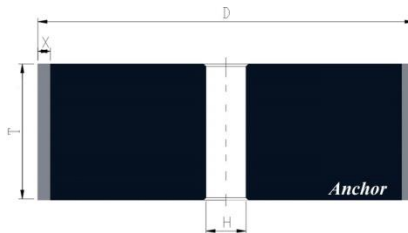
1. 高精度、高效率的圆棒外圆加工
2. 搭配各厂机台客制化设计
3. 搭配橡胶调整轮使用



钢棒无心研磨示意图

### 标准品规格尺寸

1A1、9A1



| 规格<br>Specification  | 外径<br>D | 厚度<br>T | 孔径<br>H | 钻石层<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适用于硬质合金(T/C)圆棒、CBN适用于HSS圆棒。

Unit : mm

■ 其他规格尺寸亦可订制，详细无心研磨砂轮介绍请参阅官网。

### 研磨案例

|                | 粗细磨适用粒度      |                             |
|----------------|--------------|-----------------------------|
| 粗磨Pre-grinding | #100         | 极细目金刚石无心研磨钨钢棒面粗成功达Ra0.027um |
| 细磨Finishing    | #325         |                             |
| 精磨Polishing    | #1000 and up |                             |



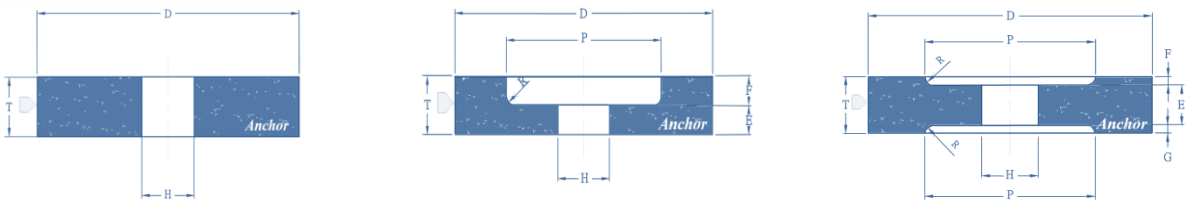
橡胶法调整轮

无心研磨调整轮通常为橡胶结合制法作成，主要的功用為：

- 1.控制工作物的旋转速度与进给速度。
- 2.在研磨作业中提供工作物支撑力。
- 3.控制工作物的直径大小。

标准品规格尺寸

1A、5A、7A



| 规格<br>Specification | 外径<br>D | 厚度<br>T | 孔径<br>H | 凹宽<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      |



■ 其他规格尺寸亦可订制。

Unit : mm

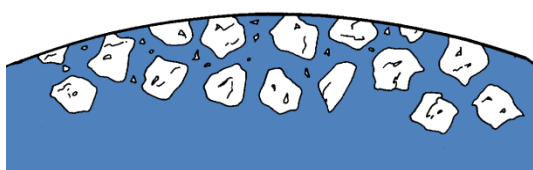
砂轮与调整轮尺寸搭配对照

| 砂轮外径<br>Wheel diameter | 砂轮厚度<br>Wheel thickness | 调整轮外径<br>Regulator diameter | 调整轮厚度<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」又称为「修正」(Truing)——砂轮安装后，为求与砂轮心轴同心，或将变形的砂轮磨面修平或者整形成所需要的特殊形状与角度。如下图一所示。

「修锐」(Dressing)——当砂轮表面相当平滑、磨料晶粒突出表面不多。如以此情况下之砂轮研磨，其砂轮会将其工作物烧焦或产生打滑现象。因此须将砂轮平滑表面或堵塞的表面削去，即将包围在磨料附近的结合剂、堵塞物铁屑等去除，使其磨料锐角能完全地露出砂轮表面，以产生研磨能力作用，称之为修锐，如下图二所示。



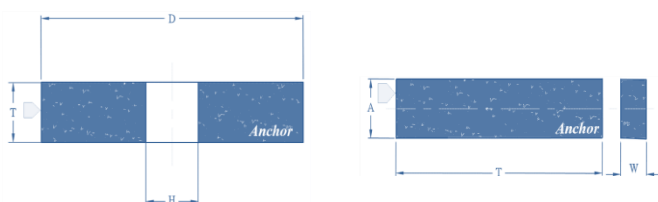
图一 修整Truing



图二 修锐Dressing

## 标准品规格尺寸

### 1A、砂条-RT






| 规格<br>Specification | 外径<br>D | 厚度<br>T | 孔径<br>H | 被修整砂轮粒度<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           |
| 砂条- RT              | T       | A       | W       | -                        |
| ● WA220H5V-RT       | 100     | 18      | 8       | Dressing stick           |



- 常备品 In stock。
- 其他规格尺寸亦可订制。

Unit : mm

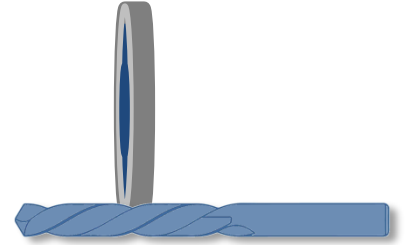
嘉宝金属切削刀具研磨砂轮，依客户加工需求及刀具类型，提供全系列相对应产品，特殊配方设计可使砂轮具备良好的保持力与切削力。

|  | 制法别<br>Bond type   | 产品特色<br>Products characteristics  |
|--|--|---|
|    | <p><b>MMW</b><br/>(Metal bonds)</p> <p><b>效率型</b></p>      | <p>极优异切削性与散热性，适合大量深切缓进使用。<br/>适合砂轮金刚石层厚度8mm(含以上)加工使用。<br/>适用加工部位：强力开槽FLUTE。</p>     |
|   | <p><b>HBMW</b><br/>(Polyimide bonds)</p> <p><b>耐用型</b></p> | <p>优异产品切削力与形状保持力，砂轮耐用性佳。<br/>适合砂轮金刚石层厚度6mm(含以上)加工使用。<br/>适用加工部位：强力开槽FLUTE。</p>      |
|  | <p><b>BMW</b><br/>(Resin bonds)</p> <p><b>经济型</b></p>      | <p>良好切削性能表现与产品售价实惠。<br/>金刚石层厚度6mm以下较小尺寸加工使用。<br/>适用加工部位：开槽FLUTE、OD/RELIEF、GASH。</p> |

好切、耐磨、低负载

产品特点：

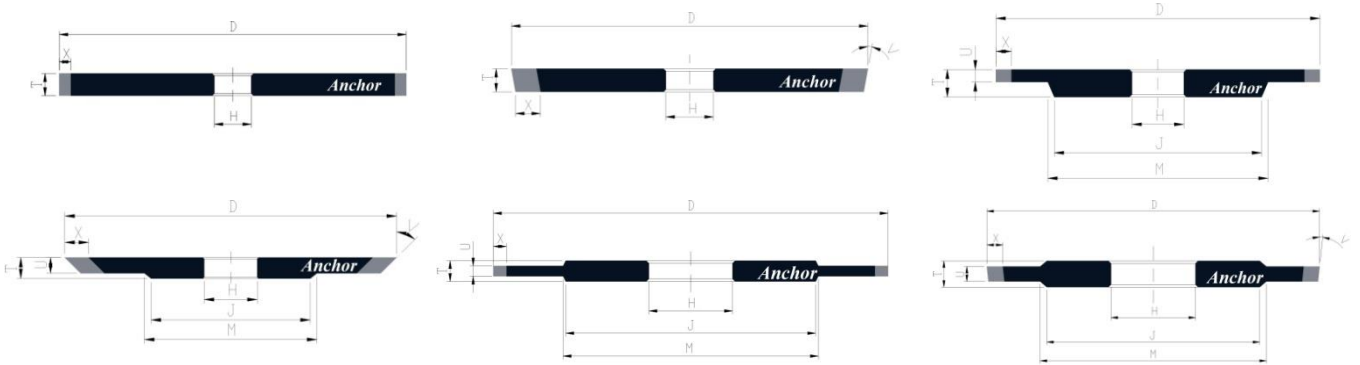
1. 极优异切削性与散热性，适合大量深切缓进使用。
2. 适合砂轮钻石层厚度8mm(含以上)加工使用。
3. 建议加工部位：FLUTE。



开槽研磨示意图

标准品规格尺寸

1A1、1V1、3A1、3V1、14A1、14V1



| 规格<br>Specification | 外径<br>D | 厚度<br>T | 孔径<br>H | 钻石层<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适用于硬质合金(T/C)圆棒、另有CBN配方适用于HSS圆棒。

■ 其他规格尺寸及V形角度亦可订制。



| 规格<br>Specification | 外径<br>D | 厚度<br>T | 孔径<br>H | 端部<br>U | 钻石层<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适用于硬质合金(T/C)圆棒、另有CBN配方适用于HSS圆棒。

■ 其他规格尺寸及V形角度亦可订制。

Qw值乃透过砂轮切深(Ae)及横送速度(Vt)等参数，计算出单位时间内工件的移除量，做为评估砂轮切削效率的参考值。

Qw值计算方式Calculation of Qw value

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

Vt = 横移速度 / Traverse speed  
 Ae = 砂轮切深 / Infeed  
 Vc = 建议砂轮转速/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 |

  横送速度起始值 Vf start value     
   横送速度潜力值 Vf optimization potential     
 阅览方向 Reading Direction

MMW案例分享与Qw值Qw values for MMW

| 砂轮转速Vc      | Qw 值mm <sup>3</sup> /s       |                          |
|-------------|------------------------------|--------------------------|
|             | 标准区间<br>Standard performance | 高效率区间<br>Highperformance |
| 15 – 25 m/s | 3 – 6                        | 7 - 10                   |

■Qw值设定应综合考虑工件尺寸、机台效率、研削液等因素，务必审慎评估且注意砂轮使用安全。

研磨案例分享 Case study

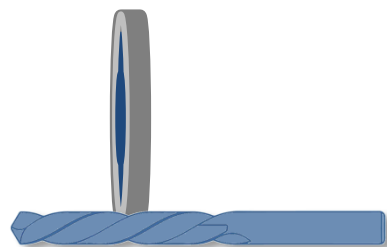
|      |   |      |               |
|------|---|------|---------------|
| 砂轮规格 | SD270N125MMW1A110                                   | 工件材质 | T/C           |
| 砂轮尺寸 | 100X10X31.75X10                                     | 砂轮转速 | 21 – 22.5 m/s |
| 机台厂牌 | ANCA  | 砂轮切深 | 3 mm          |
| 横送速度 | 100 mm/min  | 修整频率 | 800 pcs/time  |
| 测试结果 | QW = 3 X 100/60 = 5<br>优势：切削力表现佳、机台负载稳定、产量加工成本明显降低。 |      |               |

■ 此为客案例，非建议参数，特别参数及需求请标示于技术调查表。

## 大进给、低负载

### 产品特点:

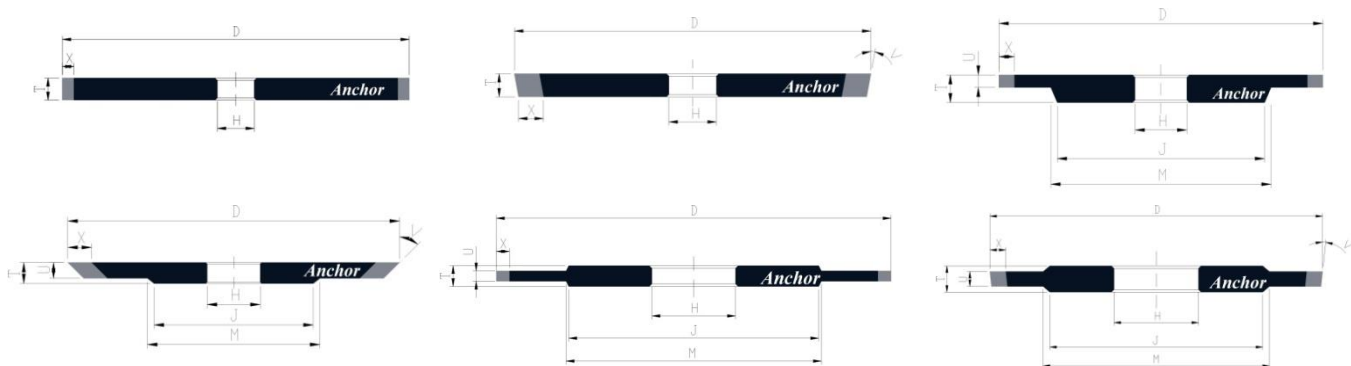
1. 优异的切削力与耐用性，形状保持度佳。
2. 适合砂轮钻石层厚度6mm(含以上)加工使用。
3. 建议加工部位：FLUTE。



开槽研磨示意图


### 标准品规格尺寸

1A1、1V1、3A1、3V1、14A1、14V1



| 规格<br>Specification | 外径<br>D | 厚度<br>T | 孔径<br>H | 钻石层<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适用于硬质合金(T/C)圆棒、另有CBN配方适用于HSS圆棒。
- 其他规格尺寸及v形角度亦可订制。



| 规格<br>Specification | 外径<br>D | 厚度<br>T | 孔径<br>H | 端部<br>U | 钻石层<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适用于硬质合金(T/C)圆棒、另有CBN配方适用于HSS圆棒。

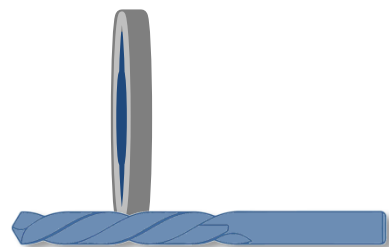
■ 其他规格尺寸及v形角度亦可订制。



## 经济实惠、效果佳

### 产品特点：

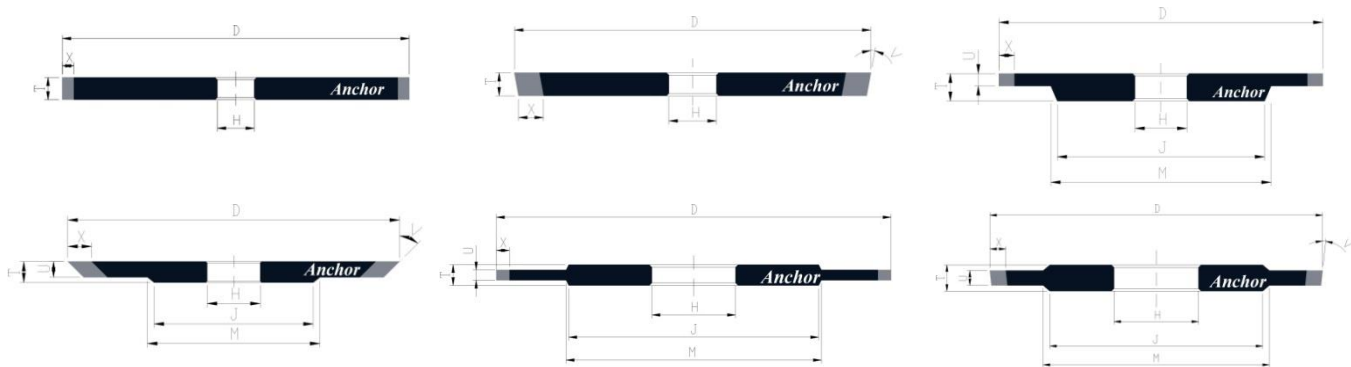
1. 良好切削效能表现，价格实惠。
2. 适合砂轮钻石层厚度6mm以下较小尺寸加工。
3. 建议加工部位：FLUTE。



开槽研磨示意图

### 标准品规格尺寸

1A1、1V1、3A1、3V1、14A1、14V1



| 规格<br>Specification | 外径<br>D | 厚度<br>T | 孔径<br>H | 钻石层<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适用于硬质合金(T/C)圆棒、另有CBN配方适用于HSS圆棒。
- 其他规格尺寸及v形角度亦可订制。



| 规格<br>Specification | 外径<br>D | 厚度<br>T | 孔径<br>H | 端部<br>U | 钻石层<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适用于硬质合金(T/C)圆棒、另有CBN配方适用于HSS圆棒。

■ 其他规格尺寸及V形角度亦可订制。

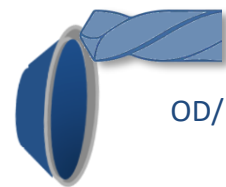
## 经济实惠、保持度良好

### 产品特点：

1. 耐磨寿命佳，价格实惠。
2. 建议加工部位：OD/Relief、Gash。



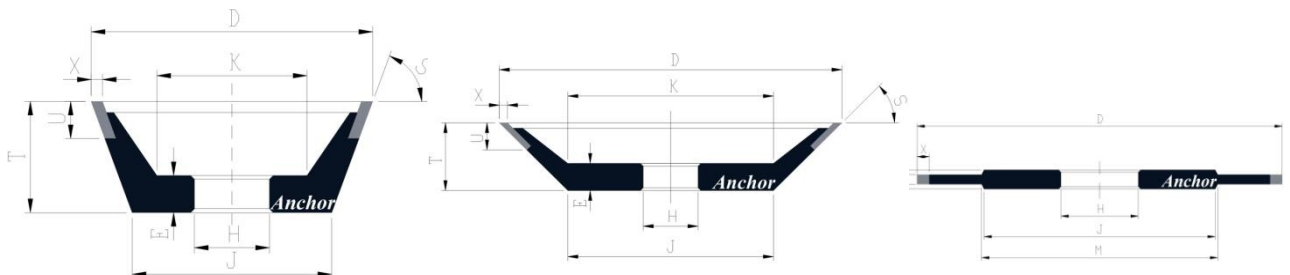
Gash



OD/Relief

### 标准品规格尺寸

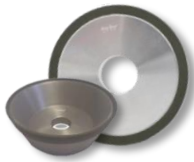

11V9、12V9、14A1



| 规格<br>Specification | 外径<br>D | 厚度<br>T | 孔径<br>H | 端部<br>U | 钻石层<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适用于硬质合金(T/C)圆棒、另有CBN配方适用于HSS圆棒。

■ 其他规格尺寸及V形角度亦可订制。

| 规格<br>Specification   |                    | 外径<br>D | 厚度<br>T | 孔径<br>H | 端部<br>U | 钻石层<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>亦可订制 | SDC325N125HBMW11V9 | 75      | 32      | 20      | 10      | 4        | 70°     |
|   | SDC325N125HBMW11V9 | 95      | 30      | 20      | 10      | 4        | 70°     |
|   | SDC325N125HBMW11V9 | 80      | 40      | 20      | 10      | 4        | 80°     |
|   | SDC325N125HBMW11V9 | 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适用于硬质合金(T/C)圆棒、另有CBN配方适用于HSS圆棒。

■ 其他规格尺寸及V形角度亦可订制。

金属切削刀具砂轮专用技术调查表  
Technical data sheet



|              |  |              |  |                  |  |
|--------------|--|--------------|--|------------------|--|
| 客户名称<br>Name |  | 填表日期<br>Date |  | 成品图号<br>Draw No. |  |
|--------------|--|--------------|--|------------------|--|

现用砂轮信息 Present Brand

|                                      |             |                |             |
|--------------------------------------|-------------|----------------|-------------|
| 规格尺寸<br>Specification and wheel size | 单价<br>Price | 用量/月<br>Amount | 厂牌<br>Brand |
|                                      |             |                |             |
|                                      |             |                |             |

现用砂轮使用状态及改善要求 Current status

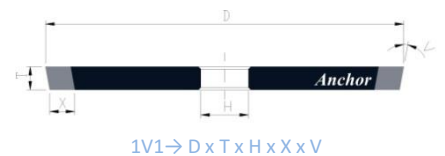
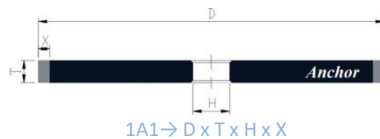
|  |  |  |  |
|--|--|--|--|
|  |  |  |  |
|--|--|--|--|

工件物信息 Workpiece

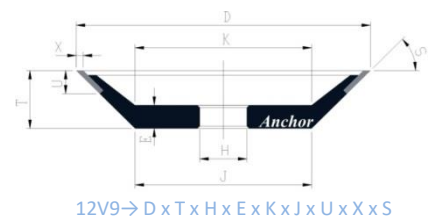
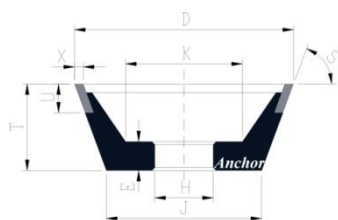
机械及研磨条件 Machine and parameter

|                         |  |                        |  |
|-------------------------|--|------------------------|--|
| 工件名称<br>Work piece      |  | 厂牌型号<br>Machine brand  |  |
| 工件材质<br>Material        | <input type="radio"/> 硬质合金 <input type="radio"/> 高速钢   | 砂轮转速<br>Wheel speed    | m/s <span style="margin-left: 100px;">RPM</span>   |
| 工件硬度<br>Hardness        | HRC/HRA  | 进给速度<br>Feed rate      | V= <span style="margin-left: 100px;">mm/min</span>   |
| 工件<br>研磨尺寸<br>Dimension | 刀径 Flutediameter   | 进刀方式<br>In-feed method | 一次进刀 Once <span style="margin-left: 100px;">mm</span>  |
|                         | 刀长 Flute length  |                        | 两次进刀 Twice <span style="margin-left: 10px;">粗 Coarse</span> <span style="margin-left: 10px;">mm</span> |
|                         | Shank Length <span style="margin-left: 100px;">Diameter</span>   |                        | <span style="margin-left: 10px;">细 Fine</span> <span style="margin-left: 10px;">mm</span>              |
| 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 |                        |  |

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



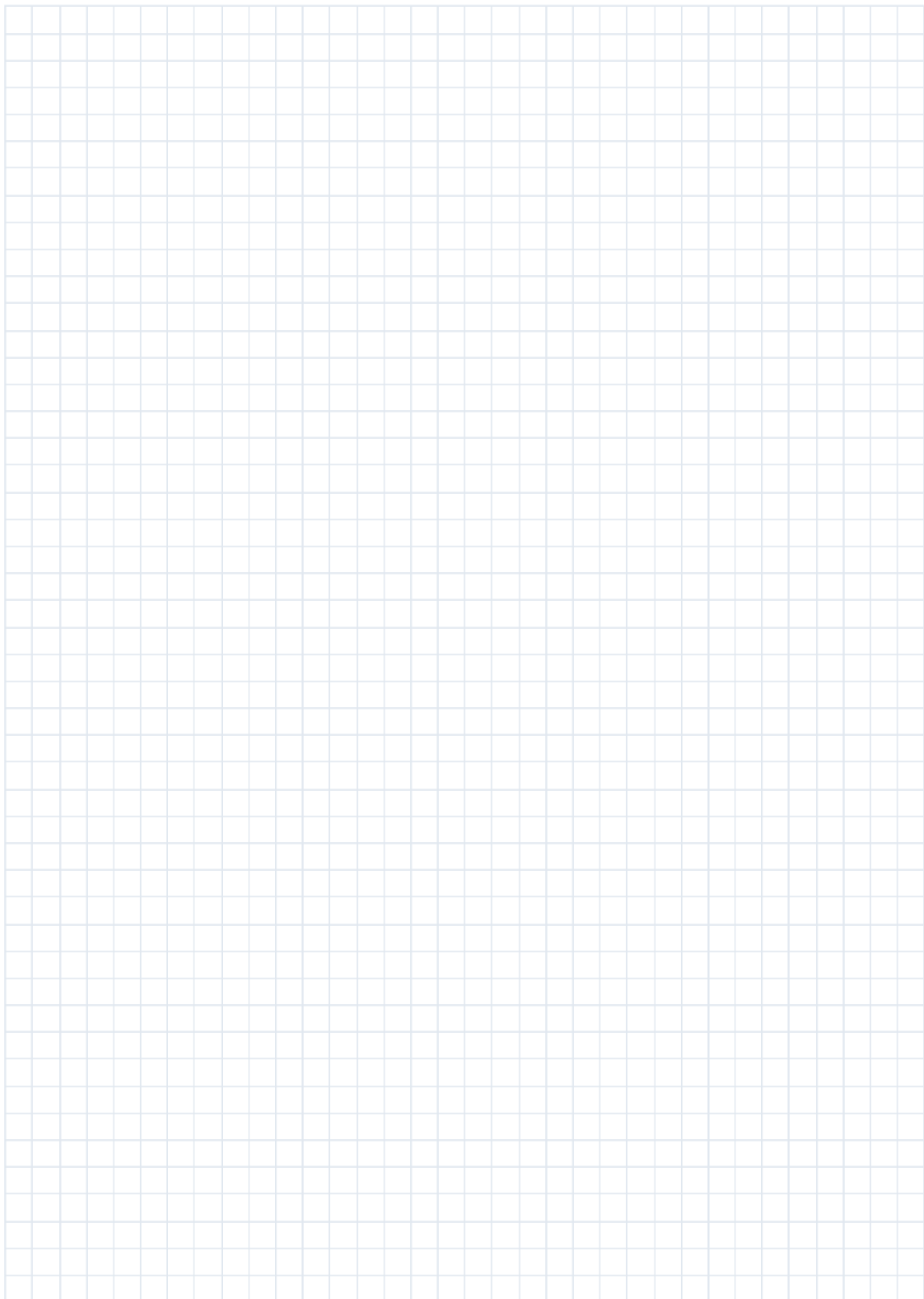
砂轮型缘尺寸  
Type of wheel



■ 亦可在线填写询价系统。

立即前往 →  
Inquiry online

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

A large grid area for data entry, consisting of approximately 30 columns and 40 rows of small squares. The grid is empty and occupies the majority of the page below the header.