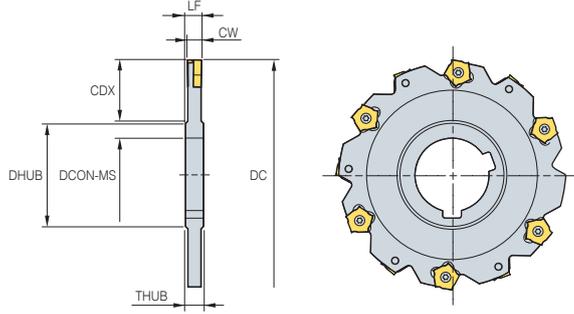


B 사이드 커터

SPP(M)



- 축방향 경사각 : -2°
- 반경방향 경사각 : -28°

형번	재고	CICT	DC	CW	CDX	DCON-MS	KWW	THUB	DHUB	인서트	스크류	렌치	
SPP	080-04	●	8	80	4	20	25.4(27)	6.35(7)	28.04(29.8)	8	PNEJ1223N	PTMA0403F	TW15S
(SPPM)	080-05	●	8	80	5	20	25.4(27)	6.35(7)	28.04(29.8)	8	PNEJ1230N	PTMA0404F	TW15S
	080-06		8	80	6	20	25.4(27)	6.35(7)	28.04(29.8)	8	PNEJ1235N	PTMA0405F	TW15S
	100-04		10	100	4	24	31.75(32)	7.94(8)	35.18(34.8)	8	PNEJ1223N	PTMA0403F	TW15S
	100-05	●	10	100	5	24	31.75(32)	7.94(8)	35.18(34.8)	8	PNEJ1230N	PTMA0404F	TW15S
	100-06	●	10	100	6	25	31.75(32)	7.94(8)	35.18(34.8)	8	PNEJ1235N	PTMA0405F	TW15S
	100-07		10	100	7	25	31.75(32)	7.94(8)	35.18(34.8)	10	PNEJ1240N	PTMA0406F	TW15S
	100-08		10	100	8	25	31.75(32)	7.94(8)	35.18(34.8)	10	PNEJ1245N	PTKA0407F	TW15S
	100-09		10	100	9	25	31.75(32)	7.94(8)	35.18(34.8)	12	PNEJ1250N	PTKA0408F	TW15S
	100-10		10	100	10	25	31.75(32)	7.94(8)	35.18(34.8)	12	PNEJ1255N	PTKA0409F	TW15S
	125-04		12	125	4	30	38.1(40)	9.53(10)	42.32(43.5)	8	PNEJ1223N	PTMA0403F	TW15S
	125-05		12	125	5	32	38.1(40)	9.53(10)	42.32(43.5)	8	PNEJ1230N	PTMA0404F	TW15S
	125-06	●	12	125	6	32	38.1(40)	9.53(10)	42.32(43.5)	8	PNEJ1235N	PTMA0405F	TW15S
	125-07	●	12	125	7	32	38.1(40)	9.53(10)	42.32(43.5)	10	PNEJ1240N	PTMA0406F	TW15S
	125-08	●	12	125	8	32	38.1(40)	9.53(10)	42.32(43.5)	10	PNEJ1245N	PTKA0407F	TW15S
	125-09		12	125	9	32	38.1(40)	9.53(10)	42.32(43.5)	12	PNEJ1250N	PTKA0408F	TW15S
	125-10		12	125	10	32	38.1(40)	9.53(10)	42.32(43.5)	12	PNEJ1255N	PTKA0409F	TW15S
	160-04		16	160	4	45	38.1(40)	9.53(10)	42.32(43.5)	8	PNEJ1223N	PTMA0403F	TW15S
	160-05		16	160	5	45	38.1(40)	9.53(10)	42.32(43.5)	8	PNEJ1230N	PTMA0404F	TW15S
	160-06		16	160	6	45	38.1(40)	9.53(10)	42.32(43.5)	8	PNEJ1235N	PTMA0405F	TW15S
	160-07		16	160	7	45	38.1(40)	9.53(10)	42.32(43.5)	10	PNEJ1240N	PTMA0406F	TW15S
	160-08	●	16	160	8	45	38.1(40)	9.53(10)	42.32(43.5)	10	PNEJ1245N	PTKA0407F	TW15S
	160-09		16	160	9	45	38.1(40)	9.53(10)	42.32(43.5)	12	PNEJ1250N	PTKA0408F	TW15S
	160-10	●	16	160	10	45	38.1(40)	9.53(10)	42.32(43.5)	12	PNEJ1255N	PTKA0409F	TW15S
	160-11		16	160	11	45	38.1(40)	9.53(10)	42.32(43.5)	14	PNEJ1260N	PTKA0410F	TW15S
	160-12		16	160	12	45	38.1(40)	9.53(10)	42.32(43.5)	14	PNEJ1265N	PTKA0411F	TW15S
	160-13		16	160	13	45	38.1(40)	9.53(10)	42.32(43.5)	16	PNEJ1270N	PTKA0412F	TW15S
	160-14		16	160	14	45	38.1(40)	9.53(10)	42.32(43.5)	16	PNEJ1275N	PTKA0413F	TW15S
	200-06		18	200	6	60	50.8(50)	12.7(12)	55.83(53.5)	8	PNEJ1235N	PTMA0405F	TW15S
	200-07		18	200	7	60	50.8(50)	12.7(12)	55.83(53.5)	10	PNEJ1240N	PTMA0406F	TW15S
	200-08	●	18	200	8	60	50.8(50)	12.7(12)	55.83(53.5)	10	PNEJ1245N	PTKA0407F	TW15S
	200-09		18	200	9	60	50.8(50)	12.7(12)	55.83(53.5)	12	PNEJ1250N	PTKA0408F	TW15S
	200-10	●	18	200	10	60	50.8(50)	12.7(12)	55.83(53.5)	12	PNEJ1255N	PTKA0409F	TW15S
	200-11		18	200	11	60	50.8(50)	12.7(12)	55.83(53.5)	14	PNEJ1260N	PTKA0410F	TW15S
	200-12		18	200	12	60	50.8(50)	12.7(12)	55.83(53.5)	14	PNEJ1265N	PTKA0411F	TW15S
	200-13		18	200	13	60	50.8(50)	12.7(12)	55.83(53.5)	16	PNEJ1270N	PTKA0412F	TW15S
	200-14		18	200	14	60	50.8(50)	12.7(12)	55.83(53.5)	16	PNEJ1275N	PTKA0413F	TW15S

적용인서트 B16

() 메트릭 사이즈, ● : 재고 관리 형번

적용아버

커터형번	NC용 아버		
	BT30	BT40	BT50
SPP 080-04~06	BT30-SCA25.4-60	BT40-SCA25.4-75/120	BT50-SCA25.4-90/135
100-04~10	-	BT40-SCA31.75-105	BT50-SCA31.75-90/135
125-04~09	-	-	BT50-SCA38.1-90/135
160-04~14	-	-	BT50-SCA38.1-90/135
200-06~14	-	-	-
SPPM 080-04~06	-	BT40-SCA27.75/120	BT50-SCA27.90/135
100-04~10	-	BT40-SCA32-105	BT50-SCA32.90/135
125-04~09	-	-	BT50-SCA40-90/135
160-04~14	-	-	BT50-SCA40-90/135
200-06~14	-	-	-

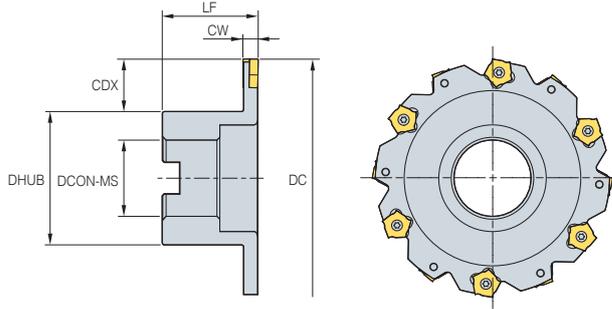
추천절삭조건

피삭재	절삭조건		재종
	vc(m/min)	fz(mm/t)	
P	190~310	0.10~0.25	NCM325 PC3700 A30
	160~270	0.10~0.30	
	60~100	0.10~0.25	
M	90~150	0.10~0.25	PC9530
K	140~230	0.10~0.35	PC6100 G10E
	50~90	0.10~0.40	

커터 표기 예)



SPB(M)



- 축방향 경사각 : -2°
- 반경방향 경사각 : 28°

형 번	재고		CICT	DC	CW	CDX	DHUB	DCON-MS	KWW	LF	인서트	스크류	렌치
	R	L											
SPB			8	80	4	18	40	25.4(27)	9.5(12.4)	6(7)	PNEJ1223N	PTMA0403F	TW15S
(SPBM)			8	80	5	18	40	25.4(27)	9.5(12.4)	6(7)	PNEJ1230N	PTMA0404F	TW15S
			8	80	6	18	40	25.4(27)	9.5(12.4)	6(7)	PNEJ1235N	PTMA0405F	TW15S
			10	100	4	21	54	31.75(32)	12.7(14.4)	8(8)	PNEJ1223N	PTMA0403F	TW15S
			10	100	5	21	54	31.75(32)	12.7(14.4)	8(8)	PNEJ1230N	PTMA0404F	TW15S
			10	100	6	21	54	31.75(32)	12.7(14.4)	8(8)	PNEJ1235N	PTMA0405F	TW15S
			10	100	7	21	54	31.75(32)	12.7(14.4)	8(8)	PNEJ1240N	PTMA0406F	TW15S
			10	100	8	21	54	31.75(32)	12.7(14.4)	8(8)	PNEJ1245N	PTMA0407F	TW15S
			10	100	9	21	54	31.75(32)	12.7(14.4)	8(8)	PNEJ1250N	PTMA0408F	TW15S
			10	100	10	21	54	31.75(32)	12.7(14.4)	8(8)	PNEJ1255N	PTMA0409F	TW15S
			12	125	4	25	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1223N	PTMA0403F	TW15S
			12	125	5	25	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1230N	PTMA0404F	TW15S
			12	125	6	25	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1235N	PTMA0405F	TW15S
			12	125	7	25	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1240N	PTMA0406F	TW15S
			12	125	8	25	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1245N	PTKA0407F	TW15S
			12	125	9	25	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1250N	PTKA0408F	TW15S
			12	125	10	25	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1255N	PTKA0409F	TW15S
			16	160	4	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1223N	PTMA0403F	TW15S
			16	160	5	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1230N	PTMA0404F	TW15S
			16	160	6	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1235N	PTMA0405F	TW15S
			16	160	7	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1240N	PTMA0406F	TW15S
			16	160	8	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1245N	PTKA0407F	TW15S
			16	160	9	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1250N	PTKA0408F	TW15S
			16	160	10	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1255N	PTKA0409F	TW15S
			16	160	11	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1260N	PTKA0410F	TW15S
			16	160	12	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1265N	PTKA0411F	TW15S
			16	160	13	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1270N	PTKA0412F	TW15S
			16	160	14	43	70	38.1(40)	15.9(16.4)	10(9)	PNEJ1275N	PTKA0413F	TW15S
			18	200	6	53	90	50.8(40)	19(16.4)	11(9)	PNEJ1235N	PTMA0405F	TW15S
			18	200	7	53	90	50.8(40)	19(16.4)	11(9)	PNEJ1240N	PTMA0406F	TW15S
			18	200	8	53	90	50.8(40)	19(16.4)	11(9)	PNEJ1245N	PTKA0407F	TW15S
			18	200	9	53	90	50.8(40)	19(16.4)	11(9)	PNEJ1250N	PTKA0408F	TW15S
			18	200	10	53	90	50.8(40)	19(16.4)	11(9)	PNEJ1255N	PTKA0409F	TW15S
			18	200	11	53	90	50.8(40)	19(16.4)	11(9)	PNEJ1260N	PTKA0410F	TW15S
			18	200	12	53	90	50.8(40)	19(16.4)	11(9)	PNEJ1265N	PTKA0411F	TW15S
			18	200	13	53	90	50.8(40)	19(16.4)	11(9)	PNEJ1270N	PTKA0412F	TW15S
			18	200	14	53	90	50.8(40)	19(16.4)	11(9)	PNEJ1275N	PTKA0413F	TW15S

적용인서트 B16

() 메트릭 사이즈, ● 재고 관리 형번

조립시 주의사항

- ▶ 인서트의 칩브레이커가 커터의 칩 포켓을 향하도록 하여 체결
- ▶ 인서트를 커터내의 인서트 안착부에 완전히 밀착한 후 손으로 누른 상태에서 스크류를 체결
- ▶ 인서트 조립시 틈새 발생되면 가공시 제품 성능저하의 원인 발생

추천절삭조건

피삭재	절삭조건		재 종
	vc(m/min)	fz(mm/t)	
P	190~310	0.10~0.25	NCM325 PC3700 A30
	160~270	0.10~0.30	
	60~100	0.10~0.25	
M	90~150	0.10~0.25	PC9530
K	140~230	0.10~0.35	PC6100 G10E
		0.10~0.40	