

# R208TX 超微粒鎢鋼塗層NC機械鉸刀(高硬度用)

## NC Machine Reamers (High Hardness)

Designed with right helix and right cutting flutes with equal flute design, which is easy for regrinding.

Upward chip evacuation.

Application for reaming different steels below 62HRC, stainless steel, cast iron, copper...and etc.

Nano multilayer coating AITiSiN with superior wear resistance is suitable for high hardness materials reaming.

Accuracy tolerance: H7 (m5)  
0/+0.004mm

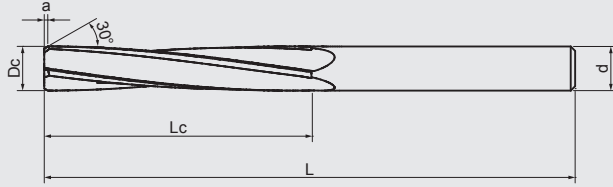
右螺旋右切刃設計，等分割刃設計，易修磨。

排屑方向往上。

適用切削於62HRC以下各種鋼鐵、不銹鋼及鑄鐵、銅...等材料鉸孔應用。

搭配AITiSiN奈米多層膜塗層，具有極佳的耐磨耗性，適合高硬度鉸孔加工用。

刃徑精度公差：H7 (m5)  
0/+0.004mm



**VHM Carbide**

**AITiSiN**

R  
8°

Steel  
Hardened Steel  
Cast Iron  
Stainless Steel

Through Hole

Blind Hole

孔徑配合尺寸容許範圍與鉸刀直徑公差範圍規範

尺寸區分(mm)	鉸刀直徑公差(mm)		孔的公差(mm)		研磨鉸刀直徑公差(mm)				
	以上	以下	m5(JIS)	H7(DIN 1420)	H7	H8	下限	中間值	上限
-	3		+0.002/+0.006	+0.004/+0.008	0/+0.010	0/+0.014	+0.004	+0.005	+0.006
3	6		+0.004/+0.009	+0.005/+0.010	0/+0.012	0/+0.018	+0.005	+0.007	+0.009
6	10		+0.006/+0.012	+0.006/+0.012	0/+0.015	0/+0.022	+0.007	+0.009	+0.011
10	18		+0.007/+0.015	+0.008/+0.015	0/+0.018	0/+0.027	+0.009	+0.011	+0.013
18	30		+0.008/+0.017	+0.009/+0.017	0/+0.021	0/+0.033	+0.011	+0.013	+0.015



- P
- H
- M
- K

### Standard Length

### Code No. R208TX-Dc

Dc mm	Tolerance mm	Lc mm	L mm	a mm	d h5	Z teeth	R208TX AITiSiN
2.97	0/+0.004	40	80	0.4	4	4	●
2.98	0/+0.004	40	80	0.4	4	4	●
2.99	0/+0.004	40	80	0.4	4	4	●
3	H7	40	80	0.4	4	4	●
3.01	0/+0.004	40	80	0.4	4	4	●
3.02	0/+0.004	40	80	0.4	4	4	●
3.03	0/+0.004	40	80	0.4	4	4	●
3.1	H7	40	80	0.4	4	4	●
3.2	H7	40	80	0.4	4	4	●
3.3	H7	40	80	0.4	4	4	●
3.4	H7	40	80	0.4	4	4	●
3.5	H7	40	80	0.4	4	4	●
3.6	H7	40	80	0.5	4	4	●
3.7	H7	40	80	0.5	4	4	●
3.8	H7	40	80	0.5	4	4	●
3.9	H7	40	80	0.5	4	4	●
3.97	0/+0.004	40	80	0.5	4	4	●
3.98	0/+0.004	40	80	0.5	4	4	●
3.99	0/+0.004	40	80	0.5	4	4	●
4	H7	40	80	0.5	4	4	●
4.01	0/+0.004	40	80	0.5	4	4	●
4.02	0/+0.004	40	80	0.5	4	4	●
4.03	0/+0.004	40	80	0.5	4	4	●
4.1	H7	40	80	0.5	6	4	●
4.2	H7	40	80	0.5	6	4	●
4.3	H7	40	80	0.5	6	4	●
4.4	H7	40	80	0.5	6	4	●
4.5	H7	40	80	0.5	6	4	●
4.6	H7	40	80	0.6	6	4	●
4.7	H7	40	80	0.6	6	4	●
4.8	H7	40	80	0.6	6	4	●
4.9	H7	40	80	0.6	6	4	●
4.97	0/+0.004	40	80	0.6	6	4	●
4.98	0/+0.004	40	80	0.6	6	4	●

鋼鐵用高效率立銑刀

鋼鐵、不銹鋼、難削材  
多用透立銑刀

鋁用立銑刀

通用、精加工立銑刀

圓頭、R角立銑刀

鑽頭

鉸刀

技術資料

Dc mm	Tolerance mm	Lc mm	L mm	a mm	d h5	Z teeth	R208TX AlTiSiN		
4.99	0/+0.004	40	80	0.6	6	4	●		
5	H7	40	80	0.6	6	4	●		
5.01	0/+0.004	40	80	0.6	6	4	●		
5.02	0/+0.004	40	80	0.6	6	4	●		
5.03	0/+0.004	40	80	0.6	6	4	●		
5.1	H7	50	100	0.6	6	4	●		
5.2	H7	50	100	0.6	6	4	●		
5.3	H7	50	100	0.6	6	4	●		
5.4	H7	50	100	0.6	6	4	●		
5.5	H7	50	100	0.6	6	4	●		
5.6	H7	50	100	0.6	6	4	●		
5.7	H7	50	100	0.6	6	4	●		
5.8	H7	50	100	0.6	6	4	●		
5.9	H7	50	100	0.6	6	4	●		
5.97	0/+0.004	50	100	0.6	6	4	●		
5.98	0/+0.004	50	100	0.6	6	4	●		
5.99	0/+0.004	50	100	0.6	6	4	●		
6	H7	50	100	0.6	6	4	●		
6.01	0/+0.004	50	100	0.6	6	4	●		
6.02	0/+0.004	50	100	0.6	6	4	●		
6.03	0/+0.004	50	100	0.6	6	4	●		
6.1	H7	50	100	0.8	8	4	●		
6.2	H7	50	100	0.8	8	4	●		
6.3	H7	50	100	0.8	8	4	●		
6.4	H7	50	100	0.8	8	4	●		
6.5	H7	50	100	0.8	8	4	●		
6.6	H7	50	100	0.8	8	4	●		
6.7	H7	50	100	0.8	8	4	●		
6.8	H7	50	100	0.8	8	4	●		
6.9	H7	50	100	0.8	8	4	●		
7	H7	50	100	0.8	8	4	●		
7.1	H7	50	100	0.8	8	4	●		
7.2	H7	50	100	0.8	8	4	●		
7.3	H7	50	100	0.8	8	4	●		
7.4	H7	50	100	0.8	8	4	●		
7.5	H7	50	100	0.8	8	4	●		
7.6	H7	50	100	0.8	8	4	●		
7.7	H7	50	100	0.8	8	4	●		
7.8	H7	50	100	0.8	8	4	●		
7.9	H7	50	100	0.8	8	4	●		
7.97	0/+0.004	50	100	0.8	8	4	●		
7.98	0/+0.004	50	100	0.8	8	4	●		
7.99	0/+0.004	50	100	0.8	8	4	●		
8	H7	50	100	0.8	8	4	●		
8.01	0/+0.004	50	100	0.8	8	4	●		
8.02	0/+0.004	50	100	0.8	8	4	●		
8.03	0/+0.004	50	100	0.8	8	4	●		
8.1	H7	60	120	1	10	4	●		
8.2	H7	60	120	1	10	4	●		
8.3	H7	60	120	1	10	4	●		
8.4	H7	60	120	1	10	4	●		
8.5	H7	60	120	1	10	4	●		
8.6	H7	60	120	1	10	4	●		
8.7	H7	60	120	1	10	4	●		
8.8	H7	60	120	1	10	4	●		
8.9	H7	60	120	1	10	4	●		
9	H7	60	120	1	10	4	●		
9.1	H7	60	120	1	10	4	●		
9.2	H7	60	120	1	10	4	●		
9.3	H7	60	120	1	10	4	●		
9.4	H7	60	120	1	10	4	●		
9.5	H7	60	120	1	10	4	●		
9.6	H7	60	120	1	10	4	●		
9.7	H7	60	120	1	10	4	●		

## NC Machine Reamers (High Hardness)

Dc mm	Tolerance mm	Lc mm	L mm	a mm	d h5	Z teeth	R208TX AlTiSiN		
9.8	H7	60	120	1	10	4	●		
9.9	H7	60	120	1	10	4	●		
9.97	0/+0.004	60	120	1	10	4	●		
9.98	0/+0.004	60	120	1	10	4	●		
9.99	0/+0.004	60	120	1	10	4	●		
10	H7	60	120	1	10	4	●		
10.01	0/+0.004	60	120	1	10	4	●		
10.02	0/+0.004	60	120	1	10	4	●		
10.03	0/+0.004	60	120	1	10	4	●		
10.1	H7	70	140	1.2	12	4	●		
10.2	H7	70	140	1.2	12	4	●		
10.3	H7	70	140	1.2	12	4	●		
10.4	H7	70	140	1.2	12	4	●		
10.5	H7	70	140	1.2	12	4	●		
10.6	H7	70	140	1.2	12	4	●		
10.7	H7	70	140	1.2	12	4	●		
10.8	H7	70	140	1.2	12	4	●		
10.9	H7	70	140	1.2	12	4	●		
11	H7	70	140	1.2	12	4	●		
11.1	H7	70	140	1.2	12	4	●		
11.2	H7	70	140	1.2	12	4	●		
11.3	H7	70	140	1.2	12	4	●		
11.4	H7	70	140	1.2	12	4	●		
11.5	H7	70	140	1.2	12	4	●		
11.6	H7	70	140	1.2	12	4	●		
11.7	H7	70	140	1.2	12	4	●		
11.8	H7	70	140	1.2	12	4	●		
11.9	H7	70	140	1.2	12	4	●		
11.97	0/+0.004	70	140	1.2	12	4	●		
11.98	0/+0.004	70	140	1.2	12	4	●		
11.99	0/+0.004	70	140	1.2	12	4	●		
12	H7	70	140	1.2	12	4	●		
12.01	0/+0.004	70	140	1.2	12	4	●		
12.02	0/+0.004	70	140	1.2	12	4	●		
12.03	0/+0.004	70	140	1.2	12	4	●		

切削條件參考表請參照P31頁

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