

BSP 沉頭鑽系列

BSP series Countersunk Drill



加工螺絲沉頭孔專用成形刀具

Special forming tool for processing screw countersunk holes

節省刀具成本及加工時間

Saving tool cost and processing time.

刀片特色 Insert Feature



超細TiAlN基納米塗層，添加耐磨和耐高溫的稀有元素，綜合性能顯著提升。
TiAlN coating with high temperature resistant elements.

特殊的塗層處理技術，塗層和基體結合更牢固。
Treatment technology of special coating, the coating is more firmly bonded to the substrate

薄的PVD塗層，刃口鋒利。
Thin PVD coating make cutting edge sharp.

細晶體的碳化鎢基硬質合金，具有高的硬度和較強的韌性。
High hardness and high toughness.

塗層後特殊的表面處理技術，去除有害應力的同時提高了表面光潔度。
High surface finishing.

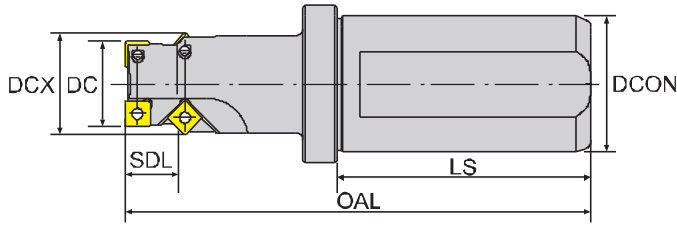
適用材質

合金鋼
Alloy Steel

不鏽鋼
Stainless Steel

鑄鐵
Cast Iron

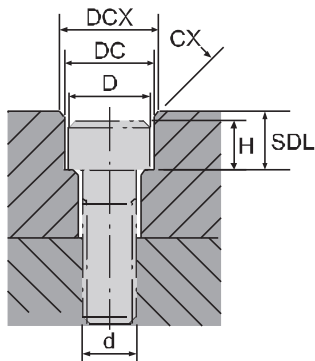
BSP



寸法 Dimension(mm)

產品型號 Model No	在庫 Stock	切削直徑		柄部直徑 DCON	階梯直徑長度 SDL	標準全長 OAL	刀柄長度 LS	刀片 Insert	螺絲 Screw	旗型板手 Wrench	價格 Price
		DC	DCX								
BSP06-C32-M6	●	11	13	32	7.5	110	60	SP□□ 0602	CS22	T-7	
BSP06-C32-M8	●	14	16	32	8.6	110	60				
BSP06-C32-M10	●	17.5	19.5	32	10.8	110	60				
BSP06-C32-M12	●	20	22	32	13	110	60				
BSP11-C32-M14	●	23	27	32	15.2	110	60	SP□□ 1104	CS40	T-15	
BSP11-C32-M16	●	26	30	32	17.5	110	60				
BSP11-C32-M18	●	29	33	32	19.5	110	60				
BSP11-C32-M20	●	32	36	32	21.5	110	60				
BSP11-C32-M22	●	35	39	32	23.5	110	60				
BSP11-C32-M24	●	39	43	32	25.5	110	60				

標準沉頭孔規格 Standard Counterbore



螺紋規格	切削直徑	最大切削直徑	螺絲頭直徑	階梯直徑長度	螺絲頭高度	倒角
d	DC	DCX	D	SDL	H	CX
M6	11	13	10	7.5	6	1
M8	14	16	13	8.6	8	1
M10	17.5	19.5	16	10.8	10	1
M12	20	22	18	13	12	1
M14	23	27	21	15.2	14	2
M16	26	30	24	17.5	16	2
M18	29	33	27	19.5	18	2
M20	32	36	30	21.5	20	2
M22	35	39	33	23.5	22	2
M24	39	43	36	25.5	24	2

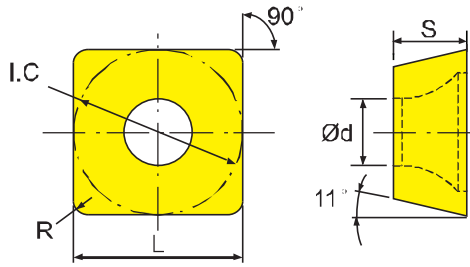
SPMT

- 標準庫存 * 僅限中國地區銷售
- Standard Stocks * Sell in China only
- ◎僅限台灣地區銷售
- ◎Sell in Taiwan only


◆材質介紹→參考A04頁
Grade Ref. Page-A04

◆斷削槽選擇→參考A06-A08頁
Chipbreaker Ref. Page-A06-A08

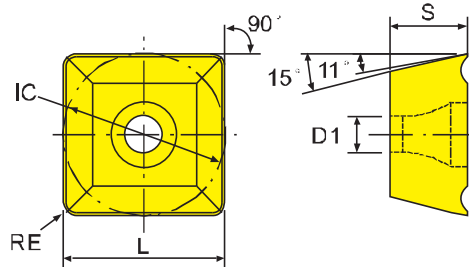
◆切削條件→參考A09頁
Cutting condition Ref. Page-A09




塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	RE	L	IC	S	D1	塗層硬質合金 Carbide Coated								
							P	M	K	N					
							DF133	DF233	DF333	ECM200	BEJ750	BEP706	ECK200	BEG607	BEJ757
GO中切削 Medium 	SPMT050204-GO	0.4	5	5	2.38	2.2					●				
	SPMT060204-GO	0.4	6	6	2.38	2.6					●				
	SPMT07T308-GO	0.8	7.94	7.94	3.97	2.8					●				
	SPMT090408-GO	0.8	9.8	9.8	4.3	4.2					●				
	SPMT110408-GO	0.8	11.5	11.5	4.76	4.4					●				
	SPMT140512-GO	1.2	14.3	14.3	5.2	5.75					●				

SPGT



塗層硬質合金 Carbide Coated

形狀 Shape	型號 Model No	RE	L	IC	S	D1	塗層硬質合金 Carbide Coated											
							P	M	K									
							ECM100	ECM200	BE4875	BEP706	BEJ750	BEJ757	BEJ758	ECK100	ECK200	ECK300	BEG607	
RO中切削 Medium 	SPGT050204+RO	0.4	5	5	2.38	2.2					●	●						
	SPGT060204+RO	0.4	6	6	2.38	2.6					●	●						
	SPGT07T308+RO	0.8	7.94	7.94	3.97	2.8					●	●						
	SPGT090408+RO	0.8	9.8	9.8	4.3	4.2					●	●						
	SPGT110408+RO	0.8	11.5	11.5	4.76	4.4					●	●						
	SPGT140512+RO	1.2	14.3	14.3	5.2	5.75					●	●						

材質推薦切屑表

Recommended Cutting Condition

被削材 Workpiece		VC切削速度 VC Cuting Speed (m/min)	加工直徑及進給量 Feed(aspect ratio=3D)(m/rev) Depending On Drill Dia.				
			12-16mm	17-23mm	24-29mm	30-42mm	43-60mm
P 鋼 Steel	合金鋼 碳素鋼 Alloy Steel vs Carbon Steel	50-100-150	0.04~0.08	0.04~0.08	0.04~0.08	0.04~0.08	0.04~0.08
				0.04~0.12	0.05~0.16	0.08~0.18	0.10~0.22
		50-100-160	0.01~0.10	0.04~0.10	0.04~0.12	0.04~0.14	0.04~0.14
			0.06~0.12	0.06~0.14	0.06~0.14	0.06~0.16	0.06~0.16
			0.04~0.10	0.06~0.12	0.08~0.16	0.08~0.18	0.08~0.22
		30-70-120	0.04~0.18	0.06~0.12	0.08~0.18	0.08~0.18	0.08~0.22
			0.04~0.12	0.06~0.14	0.08~0.17	0.08~0.17	0.08~0.20
		M 不鏽鋼 Stainless Steel	40-90-150	0.04~0.10	0.04~0.12	0.04~0.12	0.04~0.12
				0.06~0.14	0.06~0.16	0.06~0.20	
60-100-160	0.04~0.10		0.04~0.12	0.04~0.12	0.04~0.12	0.04~0.12	
				0.06~0.14	0.06~0.14	0.06~0.14	
K 鑄鐵 Cast	80-100-150	0.04~0.10	0.05~0.14	0.06~0.18	0.10~0.22	0.10~0.26	
			0.04~0.12	0.04~0.14	0.05~0.16	0.05~0.18	