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TAIWAN ASAHI DIAMOND

可調式電著鑽石搪磨棒

Electroplated Adjustable Diamond Reamers



台灣鑽石工業股份有限公司
Taiwan Asahi Diamond Industrial Co., Ltd.

Technical specification

工具徑(Diameter)	8mm 以上為佳 (Min. 5mm) Regular OD size is over 8mm (Min. 5mm)
可調直徑範圍 (Expansion range)	D+0 ~ +0.1mm*1
工件材質 (Workpiece material)	FC、FCD、FCV、Aluminum
加工方式 (Process)	通孔加工(Through bore)、盲孔加工(Blind bore)
切削油 (Coolant)	水溶性或油性(Coolant : Water base or Oil)
推送速度 (Feed rate)	1.2~1.5m/min
線速度 (Line speed)	10~20 m/min
孔徑移除量 (Removal amount)	<0.05mm *2 (Regular : <0.03mm)
面粗度 (Roughness)	依材質, 工具粒度及加工條件而異 (Based on different workpiece materials, grit size and operating conditions)
真圓度 (Roundness)	



1. 依工具外徑而異

(Actual expansion range is depending on tool diameter.)

2. 依材質, 工具粒度及加工條件而異

(Based on different workpiece materials, grit size and operating conditions)

盲孔加工 - 柱塞鋼體內孔加工

BLIND BORE - Plunger pump -



材質 (material)	FC, FCD
面粗度 (Roughness)	Ra 0.7um
真圓度 (Circularity)	2.5um
圓筒度 (Cylindricity)	3.5um

通孔加工 - 活塞內孔加工

THROUGH BORE - Piston -



材質 (material)	鋁合金 Aluminum
面粗度 (Roughness)	Ra 0.5um
真圓度 (Circularity)	2um
圓筒度 (Cylindricity)	2um
壽命 (Life-time)	35000 pcs ↑



www.taiwandiamond.com

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