

S-SMS

千鳥刃側刃付メタルソー

Metal Slitting Saw with Side Cutting Edge, Staggered Tooth



SKH51

外径許容差 $+1.0$
 $+0.4$

刃幅許容差 ± 0.03

| 外径 | 刃幅 | 穴径 | 刃数 | サイド刃の長さ | ボス径 |
|-----|-----|------|----|---------|-----|
| 75 | 1.5 | 25.4 | 38 | 10 | 40 |
| 75 | 1.6 | 25.4 | 38 | 10 | 40 |
| 75 | 1.7 | 25.4 | 38 | 10 | 40 |
| 75 | 1.8 | 25.4 | 38 | 10 | 40 |
| 75 | 1.9 | 25.4 | 38 | 10 | 40 |
| 75 | 2 | 25.4 | 38 | 10 | 40 |
| 75 | 2.1 | 25.4 | 38 | 10 | 40 |
| 75 | 2.2 | 25.4 | 38 | 10 | 40 |
| 75 | 2.3 | 25.4 | 38 | 10 | 40 |
| 75 | 2.4 | 25.4 | 38 | 10 | 40 |
| 75 | 2.5 | 25.4 | 38 | 10 | 40 |
| 75 | 2.6 | 25.4 | 38 | 10 | 40 |
| 75 | 2.7 | 25.4 | 38 | 10 | 40 |
| 75 | 2.8 | 25.4 | 38 | 10 | 40 |
| 75 | 2.9 | 25.4 | 38 | 10 | 40 |
| 75 | 3 | 25.4 | 38 | 10 | 40 |
| 75 | 3.5 | 25.4 | 38 | 10 | 40 |
| 75 | 3.8 | 25.4 | 38 | 10 | 40 |
| 75 | 4 | 25.4 | 38 | 10 | 40 |
| 75 | 4.5 | 25.4 | 38 | 10 | 40 |
| 75 | 5 | 25.4 | 38 | 10 | 40 |
| | | | | | |
| 100 | 1.5 | 25.4 | 50 | 14 | 50 |
| 100 | 1.6 | 25.4 | 50 | 14 | 50 |
| 100 | 1.7 | 25.4 | 50 | 14 | 50 |
| 100 | 1.8 | 25.4 | 50 | 14 | 50 |
| 100 | 1.9 | 25.4 | 50 | 14 | 50 |
| 100 | 2 | 25.4 | 50 | 14 | 50 |
| 100 | 2.1 | 25.4 | 50 | 14 | 50 |
| 100 | 2.2 | 25.4 | 50 | 14 | 50 |
| 100 | 2.3 | 25.4 | 50 | 14 | 50 |
| 100 | 2.4 | 25.4 | 50 | 14 | 50 |
| 100 | 2.5 | 25.4 | 50 | 14 | 50 |
| 100 | 2.6 | 25.4 | 50 | 14 | 50 |
| 100 | 2.7 | 25.4 | 50 | 14 | 50 |
| 100 | 2.8 | 25.4 | 50 | 14 | 50 |
| 100 | 2.9 | 25.4 | 50 | 14 | 50 |

| 被削材種 型番 | 硬度 | 鋳物 | 炭素鋼 | 合金鋼 | 工具鋼 | 調質鋼 | ステンレス鋼 | アルミ合金 | 銅合金 | チタン合金 | 耐熱合金 |
|------------|--------|--------|------|-----|-----|---------|--------|-------|-----|---------|-------|
| | | FC、FCD | S45C | SCM | SKD | NAK、HPM | SUS | Al | Cu | Ti6Al4V | インコネル |
| S-SMS | ~200HB | ○ | ○ | ○ | | | △ | | | | |

千鳥刃側刃付メタルソーは刃型形状から下記の様なお使用方法には向いておりません。

- ① 鉄以外の非鉄金属（アルミ、銅等）の加工。（加工したワークの溝が曲がる可能性があります。）
- ② 組合せ使用（刃先に対してボス高です。）

また、刃型形状から熱処理による歪みや曲がり非常にやすく、切削する際切り粉の掃けに影響が出ますので深く切り込む場合は回転数、送りに注意して加工してください。

切削条件 P.305 キー溝形状 P.319

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| 外径 | 刃幅 | 穴径 | 刃数 | サイド刃の長さ | ボス径 |
|-----|-----|-------|----|---------|-----|
| 100 | 3 | 25.4 | 50 | 14 | 50 |
| 100 | 3.5 | 25.4 | 50 | 14 | 50 |
| 100 | 4 | 25.4 | 50 | 14 | 50 |
| 100 | 4.5 | 25.4 | 50 | 14 | 50 |
| 100 | 4.8 | 25.4 | 50 | 14 | 50 |
| 100 | 5 | 25.4 | 50 | 14 | 50 |
| | | | | | |
| 125 | 1.5 | 25.4 | 60 | 16 | 60 |
| 125 | 1.6 | 25.4 | 60 | 16 | 60 |
| 125 | 1.7 | 25.4 | 60 | 16 | 60 |
| 125 | 1.8 | 25.4 | 60 | 16 | 60 |
| 125 | 1.9 | 25.4 | 60 | 16 | 60 |
| 125 | 2 | 25.4 | 60 | 16 | 60 |
| 125 | 2.5 | 25.4 | 60 | 16 | 60 |
| 125 | 3 | 25.4 | 60 | 16 | 60 |
| 125 | 3.5 | 25.4 | 60 | 16 | 60 |
| 125 | 4 | 25.4 | 60 | 16 | 60 |
| 125 | 4.5 | 25.4 | 60 | 16 | 60 |
| 125 | 5 | 25.4 | 60 | 16 | 60 |
| 125 | 6 | 25.4 | 60 | 16 | 60 |
| | | | | | |
| 150 | 1.5 | 25.4 | 70 | 18 | 60 |
| 150 | 2 | 25.4 | 70 | 18 | 60 |
| 150 | 2.5 | 25.4 | 70 | 18 | 60 |
| 150 | 3 | 25.4 | 70 | 18 | 60 |
| 150 | 3.5 | 25.4 | 70 | 18 | 60 |
| 150 | 4 | 25.4 | 70 | 18 | 60 |
| 150 | 4.5 | 25.4 | 70 | 18 | 60 |
| 150 | 5 | 25.4 | 70 | 18 | 60 |
| 150 | 6 | 25.4 | 70 | 18 | 60 |
| | | | | | |
| 175 | 2 | 25.4 | 80 | 20 | 70 |
| 175 | 2.5 | 25.4 | 80 | 20 | 70 |
| 175 | 3 | 25.4 | 80 | 20 | 70 |
| 175 | 3.5 | 25.4 | 80 | 20 | 70 |
| 175 | 4 | 25.4 | 80 | 20 | 70 |
| 175 | 5 | 25.4 | 80 | 20 | 70 |
| | | | | | |
| 200 | 2 | 25.4 | 94 | 23 | 80 |
| 200 | 2.5 | 25.4 | 94 | 23 | 80 |
| 200 | 2.7 | 25.4 | 94 | 23 | 80 |
| 200 | 2.8 | 25.4 | 94 | 23 | 80 |
| 200 | 3 | 25.4 | 94 | 23 | 80 |
| 200 | 3.5 | 25.4 | 94 | 23 | 80 |
| 200 | 4 | 25.4 | 94 | 23 | 80 |
| 200 | 4.5 | 25.4 | 94 | 23 | 80 |
| 200 | 5 | 25.4 | 94 | 23 | 80 |
| | | | | | |
| 100 | 1.5 | 31.75 | 50 | 14 | 50 |
| 100 | 2 | 31.75 | 50 | 14 | 50 |
| 100 | 2.5 | 31.75 | 50 | 14 | 50 |
| 100 | 3 | 31.75 | 50 | 14 | 50 |
| | | | | | |
| 125 | 1.5 | 31.75 | 60 | 16 | 60 |
| 125 | 2 | 31.75 | 60 | 16 | 60 |
| 125 | 2.5 | 31.75 | 60 | 16 | 60 |
| 125 | 3 | 31.75 | 60 | 16 | 60 |
| | | | | | |
| 150 | 1.5 | 31.75 | 70 | 18 | 60 |
| 150 | 2 | 31.75 | 70 | 18 | 60 |

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| 外 径 | 刃 幅 | 穴 径 | 刃 数 | サイド刃の長さ | ボス径 |
|-----|-----|-------|-----|---------|-----|
| 150 | 2.5 | 31.75 | 70 | 18 | 60 |
| 150 | 3 | 31.75 | 70 | 18 | 60 |
| 175 | 3 | 31.75 | 80 | 20 | 70 |
| 200 | 3 | 31.75 | 94 | 23 | 80 |
| 200 | 4 | 31.75 | 94 | 23 | 80 |