

99146 龍捲風萬轉搪刀



尺寸範圍:
4.87mm ~ 50.12mm



0.01mm/div
可在刀具設定儀
預先調尺寸



調整範圍
+0.12 / -0.13mm.



動平衡
G6.3 10000 r.p.m



尺寸調整時
不用消除背隙

容易操作

- 尺寸調整容易，可在刀具設定儀預先調尺寸或在切削中心機上直接調整
- 尺寸調整時，不用消除背隙
- 更換頭部快速，尺寸變換容易

低成本的小孔徑精搪刀

- 比其他精搪刀更經濟

搪刀頭部從5mm到50mm可更換

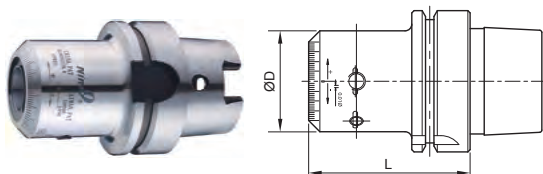
- 頭部尺寸齊全，更換快速，不影響動平衡

高轉速

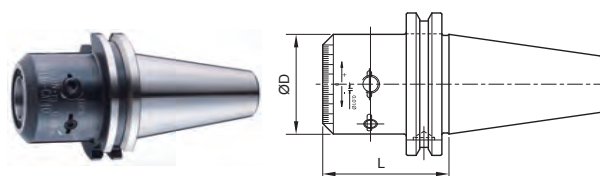
- 高轉速設計，動平衡G6.3 10,000rpm
- 階級孔，加倒角，加平面特殊搪刀頭部可訂製

▶ 微調搪刀柄

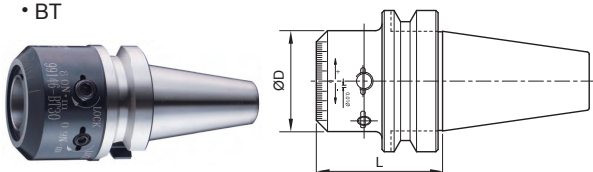
• HSK63



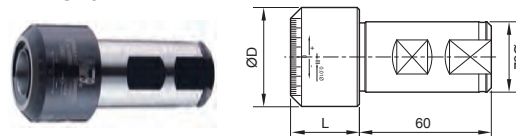
• CAT40



• BT



• SB32



訂購編號	Part No.	ØD	L
99146-HSK63AH	HSK63A-146-72	45	72
99146-CAT40H	CAT40-146-56	45	56.3
99146-BT30H	BT30-146-51	45	51.3
99146-BT40H	BT40-146-56	45	56.3
99146-BT50H	BT50-146-77	45	77.3
99146-SB32H	SB32-146-31	45	31.3

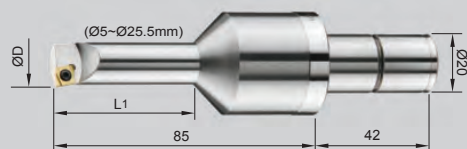
高速搪刀

10

99146 龍捲風萬轉搪刀

▶ 搪刀頭部 Ø5~Ø25

- 高合金鋼頭部
- 搪孔深度：L1, 2 ~ 3xD



- * 可依加工需求訂購中心出水型頭部。
- * 可訂製特殊規格。

ISO application



訂購編號	Part No.	ØD	L1	刀片/螺絲/扳手	訂購編號	Part No.	ØD	L1	刀片/螺絲/扳手
99146-0500S	C20-0500-10L	4.87~5.12	10.00	CC...030102 NS-16030 0.4Nm / NK-T6	99146-1725S	C20-1725-42L	17.12~17.37	42.50	
99146-0600S	C20-0600-12L	5.87~6.12	12.00		99146-1750S	C20-1750-43L	17.37~17.62	43.75	
99146-0700S	C20-0700-14L	6.87~7.12	14.00	CC...040102 NS-20036 0.6Nm / NK-T6	99146-1775S	C20-1775-43L	17.62~17.87	43.75	
99146-0800S	C20-0800-16L	7.87~8.12	16.00		99146-1800S	C20-1800-45L	17.87~18.12	45.00	
99146-0900S	C20-0900-18L	8.87~9.12	18.00		99146-1825S	C20-1825-45L	18.12~18.37	45.00	
99146-1000S	C20-1000-25L	9.87~10.12	25.00		99146-1850S	C20-1850-46L	18.37~18.62	46.25	
99146-1025S	C20-1025-25L	10.12~10.37	25.00		99146-1875S	C20-1875-46L	18.62~18.87	46.25	
99146-1050S	C20-1050-26L	10.37~10.62	26.25		99146-1900S	C20-1900-47L	18.87~19.12	47.50	
99146-1075S	C20-1075-26L	10.62~10.87	26.25		99146-1925S	C20-1925-47L	19.12~19.37	47.50	
99146-1100S	C20-1100-27L	10.87~11.12	27.50		99146-1950S	C20-1950-48L	19.37~19.62	48.75	
99146-1125S	C20-1125-27L	11.12~11.37	27.50		99146-1975S	C20-1975-48L	19.62~19.87	48.75	
99146-1150S	C20-1150-28L	11.37~11.62	28.75		99146-2000S	C20-2000-50L	19.87~20.12	50.00	
99146-1175S	C20-1175-28L	11.62~11.87	28.75		99146-2025S	C20-2025-50L	20.12~20.37	50.00	
99146-1200S	C20-1200-30L	11.87~12.12	30.00		99146-2050S	C20-2050-50L	20.37~20.62	50.00	
99146-1225S	C20-1225-30L	12.12~12.37	30.00	CC...060204 螺絲: NS-25045 0.9Nm 扳手: NK-T7	99146-2075S	C20-2075-50L	20.62~20.87	50.00	CC...060204 螺絲: NS-25060 0.9Nm 扳手: NK-T7
99146-1250S	C20-1250-31L	12.37~12.62	31.25		99146-2100S	C20-2100-50L	20.87~21.12	50.00	
99146-1275S	C20-1275-31L	12.62~12.87	31.25		99146-2125S	C20-2125-50L	21.12~21.37	50.00	
99146-1300S	C20-1300-32L	12.87~13.12	32.50		99146-2150S	C20-2150-50L	21.37~21.62	50.00	
99146-1325S	C20-1325-32L	13.12~13.37	32.50		99146-2175S	C20-2175-50L	21.62~21.87	50.00	
99146-1350S	C20-1350-33L	13.37~13.62	33.75		99146-2200S	C20-2200-50L	21.87~22.12	50.00	
99146-1375S	C20-1375-33L	13.62~13.87	33.75		99146-2225S	C20-2225-50L	22.12~22.37	50.00	
99146-1400S	C20-1400-35L	13.87~14.12	35.00		99146-2250S	C20-2250-50L	22.37~22.62	50.00	
99146-1425S	C20-1425-35L	14.12~14.37	35.00		99146-2275S	C20-2275-50L	22.62~22.87	50.00	
99146-1450S	C20-1450-36L	14.37~14.62	36.25		99146-2300S	C20-2300-50L	22.87~23.12	50.00	
99146-1475S	C20-1475-36L	14.62~14.87	36.25		99146-2325S	C20-2325-50L	23.12~23.37	50.00	
99146-1500S	C20-1500-37L	14.87~15.12	37.50		99146-2350S	C20-2350-50L	23.37~23.62	50.00	
99146-1525S	C20-1525-37L	15.12~15.37	37.50		99146-2375S	C20-2375-50L	23.62~23.87	50.00	
99146-1550S	C20-1550-38L	15.37~15.62	38.75		99146-2400S	C20-2400-50L	23.87~24.12	50.00	
99146-1575S	C20-1575-38L	15.62~15.87	38.75		99146-2425S	C20-2425-50L	24.12~24.37	50.00	
99146-1600S	C20-1600-40L	15.87~16.12	40.00		99146-2450S	C20-2450-50L	24.37~24.62	50.00	
99146-1625S	C20-1625-40L	16.12~16.37	40.00	CC...060204 螺絲: NS-25060 0.9Nm 扳手: NK-T7	99146-2475S	C20-2475-50L	24.62~24.87	50.00	
99146-1650S	C20-1650-41L	16.37~16.62	41.25		99146-2500S	C20-2500-50L	24.87~25.12	50.00	
99146-1675S	C20-1675-41L	16.62~16.87	41.25		99146-2525S	C20-2525-50L	25.12~25.37	50.00	
99146-1700S	C20-1700-42L	16.87~17.12	42.50		99146-2550S	C20-2550-50L	25.37~25.62	50.00	

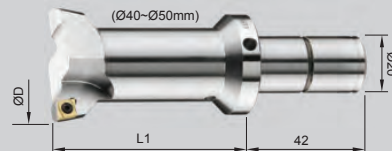
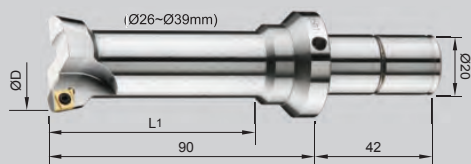
高速搪刀

10

99146 龍捲風萬轉搪刀

▶ 搪刀頭部 Ø26~Ø50

- 高合金鋼頭部
- 搪孔深度：L1, 2 ~ 3xD



▶ Ø26~Ø39mm

* 可依加工需求訂購中心出水型頭部。

訂購編號	Part No.	ØD	L1	刀片/螺絲/ 扳手
99146-26A	C20-2600-50L	25.87~26.12	50.00	CC..060204 螺絲: NS-25060 扳手: NK-T7
99146-27A	C20-2700-50L	26.87~27.12	50.00	
99146-28A	C20-2800-50L	27.87~28.12	50.00	
99146-29A	C20-2900-50L	28.87~29.12	50.00	
99146-30A	C20-3000-50L	29.87~30.12	50.00	
99146-31A	C20-3100-70L	30.87~31.12	70.00	
99146-32A	C20-3200-70L	31.87~32.12	70.00	
99146-33A	C20-3300-70L	32.87~33.12	70.00	
99146-34A	C20-3400-70L	33.87~34.12	70.00	
99146-35A	C20-3500-70L	34.87~35.12	70.00	
99146-36A	C20-3600-70L	35.87~36.12	70.00	
99146-37A	C20-3700-70L	36.87~37.12	70.00	
99146-38A	C20-3800-70L	37.87~38.12	70.00	
99146-39A	C20-3900-70L	38.87~39.12	70.00	

▶ Ø40~Ø50mm

* 可依加工需求訂購中心出水型頭部。

訂購編號	Part No.	ØD	L1	刀片/螺絲/ 扳手
99146-40A	C20-4000-70L	39.87~40.12	70.00	CC..060204 螺絲: NS-25060 扳手: NK-T7
99146-41A	C20-4100-70L	40.87~41.12	70.00	
99146-42A	C20-4200-70L	41.87~42.12	70.00	
99146-43A	C20-4300-70L	42.87~43.12	70.00	
99146-44A	C20-4400-70L	43.87~44.12	70.00	
99146-45A	C20-4500-70L	44.87~45.12	70.00	
99146-46A	C20-4600-70L	45.87~46.12	70.00	
99146-47A	C20-4700-70L	46.87~47.12	70.00	
99146-48A	C20-4800-70L	47.87~48.12	70.00	
99146-49A	C20-4900-70L	48.87~49.12	70.00	
99146-50A	C20-5000-70L	49.87~50.12	70.00	

▶ 套組

訂購編號	內容
99146-BT30-05SET	BT30H 微調搪刀柄
99146-BT40-05SET	BT40H 微調搪刀柄
99146-BT50-05SET	BT50H 微調搪刀柄
99146-CAT40-05SET	CAT40H 微調搪刀柄
99146-HSK63A-05SET	HSK63A 微調搪刀柄

微調搪刀柄: 1支
搪刀頭部: Ø5~Ø50 任何 5 支
配件: 3~5 支

• 注意: 套組不包含刀片, 請分開訂購。

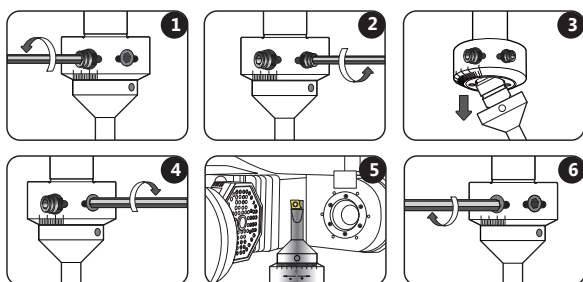
高速搪刀

10

99146 龍捲風萬轉搪刀 - 組裝流程



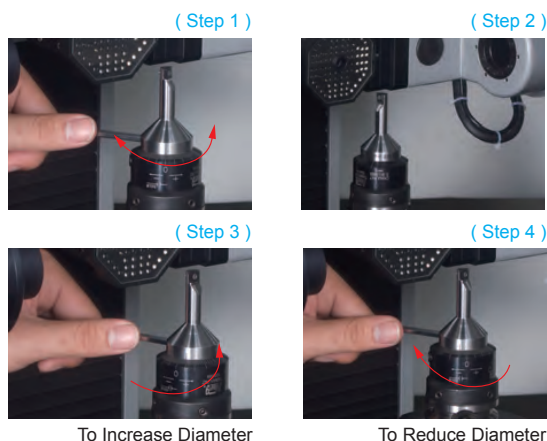
1. 用4mm扳手鬆開M8螺絲，不用取出螺絲
2. 用3mm扳手鬆開M6螺絲，不用取出螺絲
3. 取下舊頭部，更換新尺寸的頭部
4. 鎖緊M6預壓螺絲，扭力設定0.9 – 1.0Nm
5. 刀具設定儀預先調尺寸
6. 鎖緊M8鎖固螺絲，扭力設定8-9 Nm



- 尺寸調整步驟

在刀具設定儀

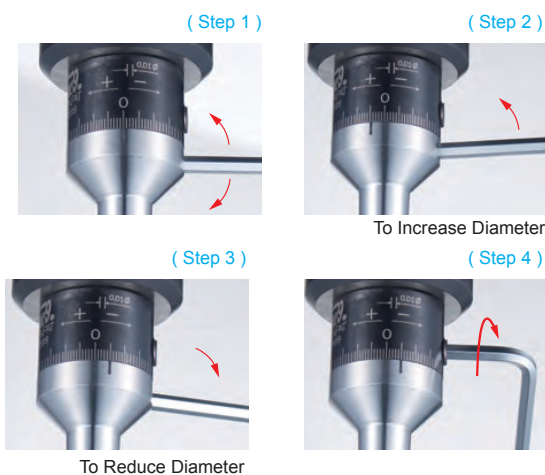
1. 鬆開M8螺絲
2. 設定頭部在中間位置 (Step 1)
3. 量測尺寸值，並設定需要的尺寸 (Step 2)
4. 試加工後，依據所需的尺寸作調整 (Step 3, 4)
5. 鎖固M8螺絲



在切削中心機或銑床上

的調整方式

1. 設定在所需尺寸位置 (Step 1)
2. 鎖固M8螺絲
3. 先試搪一個孔，3 ~ 5mm深
4. 量測加工尺寸
5. 根據加工尺寸大小，作尺寸調整 (Step 2, 3)
6. 鎖緊M8鎖固螺絲 (Step 4)



高速搪刀

10