

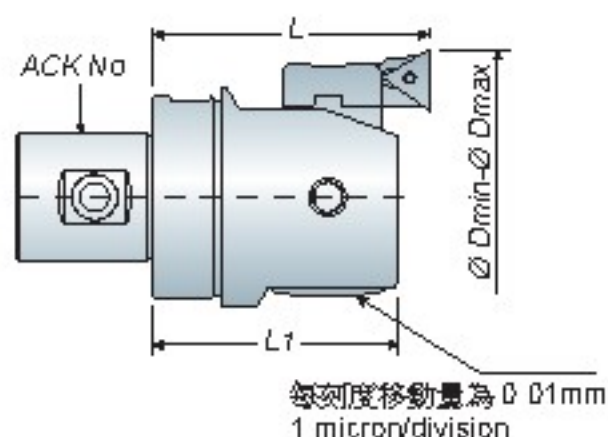
BT / NT
series

BCK

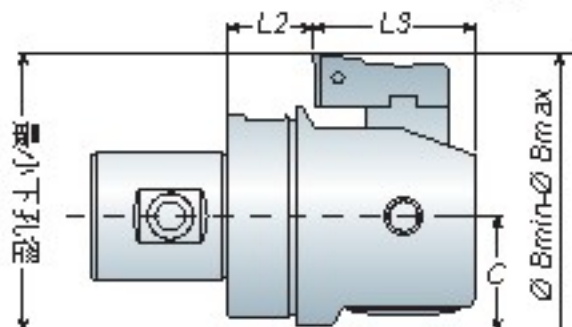
Micro Boring Head

微調精搪孔頭

正搪範圍示意圖 (Boring)



反搪範圍示意圖 (Back Boring)



最小下孔徑 = C + (反搪範圍 / 2)
Smallest Starting Hole Diameter = C + (Back Boring Diameter / 2)



Features

- Design of pre-balancing makes good cutting accuracy. Boring range is from 20mm ~ 203mm.
- The micro boring head is coolant type and both for boring and back boring.
- The insert holder is with three types for you to choice.
- Each micro boring head is included 1pc insert holder BCK H#-1, ex. H1-1, H2-1, H3-1.... Other sizes are optional accessories.
- Insert must be ordered separately.
- 預先動平衡設計，可以穩定加工精度。加工範圍 Ø20 ~ Ø203
- 標準搪頭皆有中心出水功能，搪頭可正、反搪，有三種刀座搪孔範圍可供選擇
- 每只精搪頭，皆包含 1 只標準刀片座 (BCK H#-1) 在內，例：H1-1, H2-1, H3-1...。其餘尺寸之刀片座需另購
- 刀片為另購品

Model No.	ACK No.	刀片座 Insert Holder	正搪範圍 Boring ØD			反搪範圍 Back Boring ØB				Weight (kg)	刀片 Insert
			Range	L	L1	Range	L2	L3	C		
BCK20	1	BCK H1-1	20~26			-				0.07	TP..0802
		BCK H1-2	25~31	32.5	29.5	30~31	10.5	19	10		
		BCK H1-3	30~36			30~36					
BCK25	2	BCK H2-1	25~33			-				0.12	TP..0802
		BCK H2-2	32~40	35.5	32.5	36~40	11.5	21	12.5		
		BCK H2-3	39~47			39~47					
BCK32	3	BCK H3-1	32~42			-				0.21	TP..0802
		BCK H3-2	41~51	40	35	46~51	10	25	16		
		BCK H3-3	50~60			50~60					
BCK41	4	BCK H4-1	41~54			-				0.40	TC..1102
		BCK H4-2	50~63	47	43	53~63	14	29	20		
		BCK H4-3	61~74			61~74					
BCK53	5	BCK H5-1	53~70			62~70				1.10	TC..1102
		BCK H5-2	65~82	57	53	65~82	19	34	25.5		
		BCK H5-3	78~95			78~95					
BCK68	6	BCK H6-1	68~100			80~100				1.74	TC..1102
		BCK H6-2	94~126	71	67.2	94~126	22	45.2	32.5		
		BCK H6-3	118~150			118~150					
BCK100	6	BCK H6-1	100~153			112~153				2.46	TC..1102
		BCK H6-2	126~179	71	67.2	126~179	22	45.2	45.5		
		BCK H6-3	150~203			150~203					

Unit: mm

Adjustable Balance Cutter

雙刃粗搪刀頭 Ø19 ~ Ø122mm

Model No.	Boring Range		D	D1	L	Tool Holder	Weight (kg)
	Min.	Max.					
ACK19-C	19	25	11	18	38	ACK1	0.10
ACK25-C	25	33	14	20	45	ACK2	0.20
ACK32-C	32	42	18	28	50	ACK3	0.30
ACK32-T	32	42	18	28	50	ACK3	0.30
ACK40-C	40	55	22	36	65	ACK4	0.50
ACK40-T	40	55	22	36	65	ACK4	0.50
ACK52-C	52	70	28	48	70	ACK5	0.90
ACK52-T	52	70	28	48	70	ACK5	0.90
ACK68-C	68	92	36	60	80	ACK6	1.80
ACK68-T	68	92	36	60	80	ACK6	1.80
ACK90-C	90	122	36	60	90	ACK6	2.60
ACK90-T	90	122	36	60	90	ACK6	2.60

Unit: mm

- When ordering, please specify the cutter with AA or AB type.
For example: ACK68 (AA-C)
- 請於訂購時，確認刃高為 AA 或 AB 型
例：ACK68 (AA-C)

Features

- AA type (FIG. 1) - 兩刃同高：用於盲孔
AA type (FIG. 1) - Standard type = Use the blind hole
- AB type (FIG. 2) - 兩刃不同高：用於通孔
AB type (FIG. 2) - Stepped type = Use the through hole

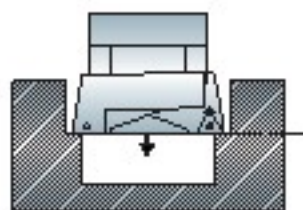


FIG 1

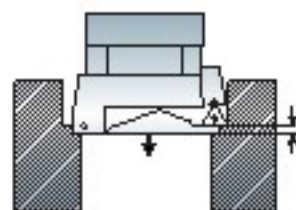
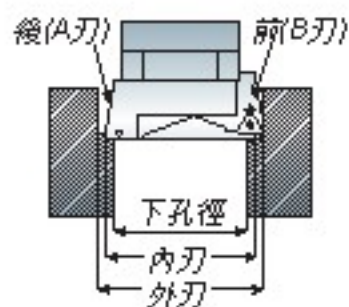


FIG 2



2 段平衡式切削：
將刀片座分為一前(B刃)一後(A刃)，使
AB Type 將比 AA Type 增加 2 倍的切削力
Stepped cutting:
AB Type will be approx double removal
than AA Type.

Extension Adapter

雙刃刀頭延長桿

Model No.	D	L	ACK / BCK Cutter No.	Weight (kg)
ACK1-30	11	30	ACK19	0.10
ACK2-30	14	30	ACK25	0.10
ACK3-35	18	35	ACK32 / BCK32	0.20
ACK4-40	22	40	ACK40 / BCK41	0.40
ACK5-45	28	45	ACK52 / BCK53	0.80
ACK6-52	36	52	ACK68 / ACK90 / BCK68 / BCK100	1.20

Unit: mm

ACK

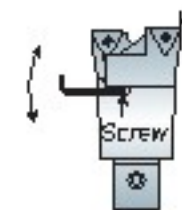
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ACK19 - ACK90: 為出水型搪頭
ACK19 - ACK90: Coolant type boring head.

- 旋轉兩顆螺絲，即可調整搪孔尺寸
Adjust screws that can set the boring range.

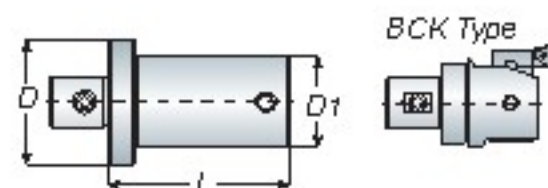


BT / NT
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HBOR ACK/BCK

Adapter

縮徑接桿



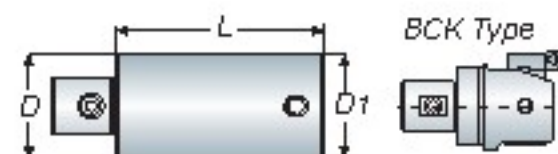
Model No.	D	D1	L	Weight (kg)
ACK3-ACK2-025	32	25	32	0.20
ACK4-ACK2-030	40	25	40	0.30
-ACK3-030	40	32	40	0.40
ACK5-ACK2-035	50	25	50	0.50
-060	50	25	75	0.60
-ACK3-035	50	32	50	0.60
-067	50	32	82	0.80
-ACK4-035	50	40	50	0.70
-075	50	40	90	1.10
ACK6-ACK2-040	63	25	63	0.80
-090	63	25	113	1.10
-ACK3-040	63	32	63	0.90
-100	63	32	127	1.30
-ACK4-040	63	40	63	1.10
-120	63	40	143	1.80
-ACK5-040	63	50	63	1.20
-140	63	50	163	2.80

Unit: mm



Extension Adapter

延長接桿



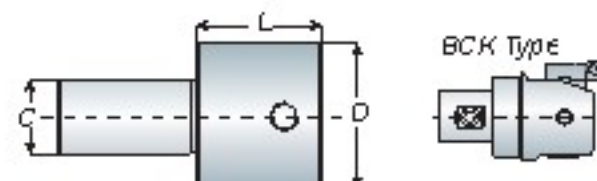
Model No.	D	D1	L	Weight (kg)
ACK2-ACK2-025	25	25	25	0.10
-050	25	25	50	0.30
ACK3-ACK3-032	32	32	32	0.20
-064	32	32	64	0.60
ACK4-ACK4-040	40	40	40	0.40
-080	40	40	80	0.80
ACK5-ACK5-050	50	50	50	0.80
-100	50	50	100	1.50
ACK6-ACK6-063	63	63	63	1.50
-126	63	63	126	2.80

Unit: mm



Adapter - Straight Shank

直柄接桿



Model No.	C	D	L	Weight (kg)
C32 ACK2-035	32	25	53	0.30
ACK3-040	32	32	40	0.50
ACK4-040	32	40	40	0.80
ACK5-040	32	50	40	0.90
ACK6-055	32	63	55	1.30

Unit: mm

- Suitable for HBOR micro boring head and ACK/BCK boring cutter.
- 適用於 HBOR 極細微調精磨孔頭和 ACK/BCK 刀頭