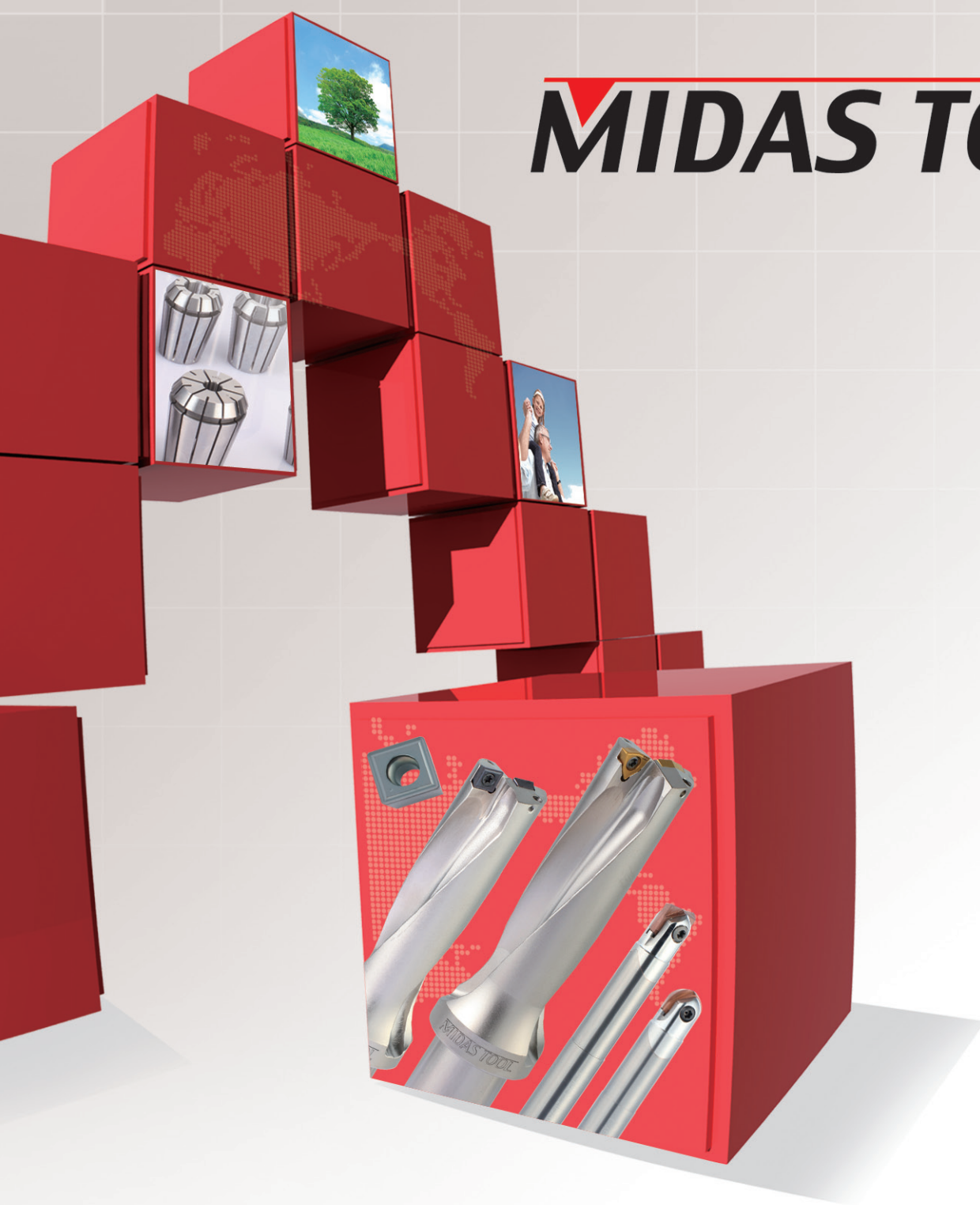




MIDAS TOOL



Global MIDAS TOOL

Global Challenger

Customer Satisfaction

Higher! Productivity

Faster! Cutting speed

Longer! Tool life



INSTRUCTION

MIDAS TOOL is one of the top leading machining center & CNC lathe tool manufacturers in Korea producing world-class level tools. MIDAS TOOL is committed to the goal to have the agent in 60 countries worldwide. MIDAS TOOL produces high quality tools with the most advanced facilities and technologies with precious know-how accumulated for a long time. MIDAS TOOL has continuously made technical innovations to meet changing customer needs.

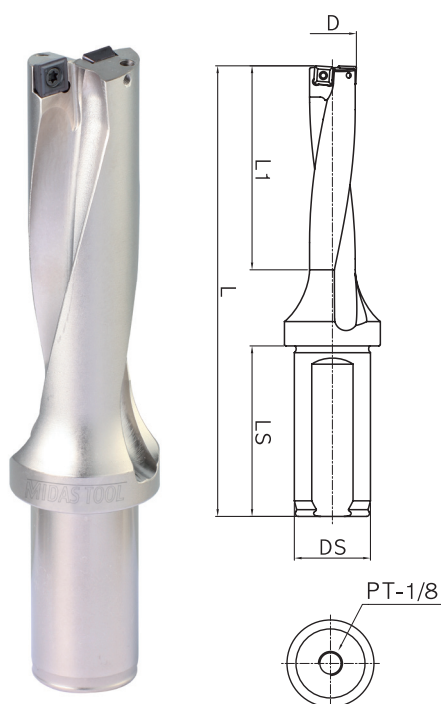
我们MIDASTOOL设立于1996年。主要生产加工中心工具、CNC床工具。以最先进设备及最高技术为基础，生产高精密度及高品质的工具。以在全球60个国家建立代理商为目标，公司的全体人员在不懈的努力。以长年积累的技术为基础，通过持续性的技术革新，我们会应对消费者多变性的要求。



CONTENTS

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KUD	10	MIDAS INSERT	17
VLD	12	OIL SKIMMER	18

Indexable Drill KTD



KTD DRILL FEATURES

- Drilling diameters are from 12.5mm to 50mm and a various of drilling depth is available(2D, 3D and 4D).
- Cost-effective by using 4-edge insert.
- A wide range of drilling such as double plates and inclined surface is possible.
- The especially treated surface of body makes wear resistance much better and tool life much longer.

KTD 钻头的特点

- 加工直径为 $\Phi 12.5 \sim \Phi 50$ 、加工深度为D(加工直径) $\times 2D$ 、 $3D$ 、 $4D$ ，有多种加工选择。
- 采用了4角刀片，提高了其经济性。
- 可加工合板或倾斜面，扩大了加工范围。
- 特殊处理钻头，提高了其耐磨性及使用寿命。

Construction System of Indexable Drill's Code No.

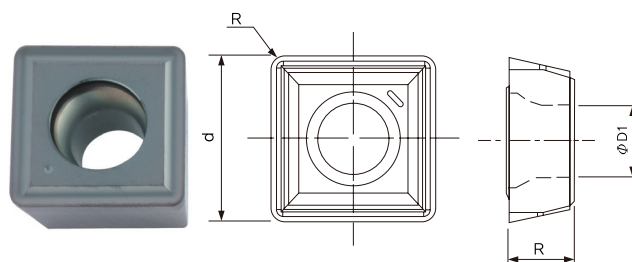
钻头规格结构

KTD - 200 20D

Drill group
钻头种类

Drilling diameter: 20 Φ
加工直径 : 20 Φ

Drilling depth: Dia X 2
加工深度 : Dia X 2

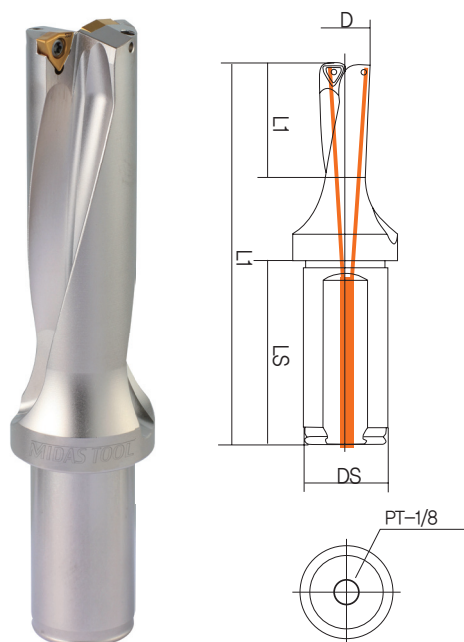


MIDAS KTD INSERT

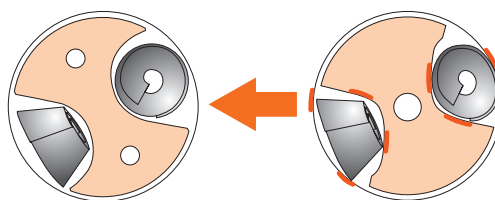
CODE NO. 型号	Dimension(mm) 尺寸			
	d	t	R	$\Phi D1$
SPMT050204DT KT9300	5.00	2.38	0.4	2.25
SPMT060204DT KT9300	6.00	2.38	0.4	2.61
SPMT07T308DT KT9300	7.94	3.97	0.8	2.85
SPMT090408DT KT9300	9.80	4.30	0.8	4.05
SPMT110408DT KT9300	11.50	4.80	0.8	4.45
SPMT140512DT KT9300	14.30	5.20	1.2	5.75

2D CODE NO.	Dimension (mm)			3D CODE NO.	Dimension (mm)			4D CODE NO.	Dimension (mm)					INSERT	Component	
	D	L1	L		D	L1	L		D	L1	L	DS	LS		Screw	Wrench
KTD-13020D	13	29	99	KTD-13030D	13	42	112	KTD-13040D	13	55	125			SPMT050204DT KT9300	TSB-20045	TXL-6
KTD-13520D	13.5	30	100	KTD-13530D	13.5	44	114	KTD-13540D	13.5	57	127					
KTD-14020D	14	31	101	KTD-14030D	14	45	115	KTD-14040D	14	59	129	20	50			
KTD-14520D	14.5	32	102	KTD-14530D	14.5	47	117	KTD-14540D	14.5	61	131					
KTD-15020D	15	33	103	KTD-15030D	15	48	118	KTD-15040D	15	63	133			SPMT060204DT KT9300	TSB-22052	TXL-6
KTD-15520D	15.5	34	115	KTD-15530D	15.5	50	131	KTD-15540D	15.5	65	146					
KTD-16020D	16	35	116	KTD-16030D	16	51	132	KTD-16040D	16	67	148					
KTD-16520D	16.5	36	117	KTD-16530D	16.5	53	134	KTD-16540D	16.5	69	150					
KTD-17020D	17	37	118	KTD-17030D	17	54	135	KTD-17040D	17	71	152					
KTD-17520D	17.5	38	119	KTD-17530D	17.5	56	137	KTD-17540D	17.5	73	154					
KTD-18020D	18	39	120	KTD-18030D	18	57	138	KTD-18040D	18	75	156					
KTD-18520D	18.5	40	121	KTD-18530D	18.5	59	140	KTD-18540D	18.5	77	158	25	56			
KTD-19020D	19	41	122	KTD-19030D	19	60	141	KTD-19040D	19	79	160					
KTD-19520D	19.5	42	123	KTD-19530D	19.5	62	143	KTD-19540D	19.5	81	162					
KTD-20020D	20	43	124	KTD-20030D	20	63	144	KTD-20040D	20	83	164					
KTD-20520D	20.5	44	125	KTD-20530D	20.5	65	146	KTD-20540D	20.5	85	166					
KTD-21020D	21	45	126	KTD-21030D	21	66	147	KTD-21040D	21	87	168			SPMT07T308DT KT9300	TSB-25065	TXL-8
KTD-21520D	21.5	46	127	KTD-21530D	21.5	68	149	KTD-21540D	21.5	89	170					
KTD-22020D	22	47	137	KTD-22030D	22	69	159	KTD-22040D	22	91	181					
KTD-22520D	22.5	48	138	KTD-22530D	22.5	71	161	KTD-22540D	22.5	93	183					
KTD-23020D	23	49	139	KTD-23030D	23	72	162	KTD-23040D	23	95	185					
KTD-23520D	23.5	50	140	KTD-23530D	23.5	74	164	KTD-23540D	23.5	97	187					
KTD-24020D	24	51	141	KTD-24030D	24	75	165	KTD-24040D	24	99	189					
KTD-24520D	24.5	52	142	KTD-24530D	24.5	77	167	KTD-24540D	24.5	101	191	32	60			
KTD-25020D	25	53	143	KTD-25030D	25	78	168	KTD-25040D	25	103	193					
KTD-25520D	25.5	54	144	KTD-25530D	25.5	80	170	KTD-25540D	25.5	105	195					
KTD-26020D	26	55	145	KTD-26030D	26	81	171	KTD-26040D	26	107	197					
KTD-26520D	26.5	56	146	KTD-26530D	26.5	83	173	KTD-26540D	26.5	109	199					
KTD-27020D	27	57	147	KTD-27030D	27	84	174	KTD-27040D	27	111	201			SPMT090408DT KT9300	TSB-35090	TXL-15
KTD-27520D	27.5	58	148	KTD-27530D	27.5	86	176	KTD-27540D	27.5	113	203					
KTD-28020D	28	59	149	KTD-28030D	28	87	177	KTD-28040D	28	115	205					
KTD-28520D	28.5	60	150	KTD-28530D	28.5	89	179	KTD-28540D	28.5	117	207					
KTD-29020D	29	61	151	KTD-29030D	29	90	180	KTD-29040D	29	120	210					
KTD-29520D	29.5	63	153	KTD-29530D	29.5	93	183	KTD-29540D	29.5	123	213	32	60			
KTD-30020D	30	65	155	KTD-30030D	30	95	185	KTD-30040D	30	125	215					
KTD-31020D	31	67	157	KTD-31030D	31	98	188	KTD-31040D	31	129	219					
KTD-32020D	32	69	159	KTD-32030D	32	101	191	KTD-32040D	32	133	223			SPMT110408DT KT9300	TSB-40100	TXL-15
KTD-33020D	33	71	161	KTD-33030D	33	104	194	KTD-33040D	33	137	227					
KTD-34020D	34	73	178	KTD-34030D	34	107	212	KTD-34040D	34	141	246					
KTD-35020D	35	75	180	KTD-35030D	35	110	215	KTD-35040D	35	145	250					
KTD-36020D	36	77	182	KTD-36030D	36	113	218	KTD-36040D	36	149	254					
KTD-37020D	37	79	184	KTD-37030D	37	116	221	KTD-37040D	37	153	258	40	70			
KTD-38020D	38	81	186	KTD-38030D	38	119	224	KTD-38040D	38	157	262					
KTD-39020D	39	83	188	KTD-39030D	39	122	227	KTD-39040D	39	161	266					
KTD-40020D	40	85	190	KTD-40030D	40	125	230	KTD-40040D	40	165	270			SPMT140512DT KT9300	TSB-50125	TXL-20
KTD-41020D	41	87	192	KTD-41030D	41	128	233	KTD-41040D	41	169	274					
KTD-42020D	42	89	194	KTD-42030D	42	131	236	KTD-42040D	42	173	278					
KTD-43020D	43	91	196	KTD-43030D	43	134	239	KTD-43040D	43	177	282					
KTD-44020D	44	93	198	KTD-44030D	44	137	242	KTD-44040D	44	181	286					
KTD-45020D	45	95	200	KTD-45030D	45	140	245	KTD-45040D	45	185	290					
KTD-46020D	46	97	202	KTD-46030D	46	143	248	KTD-46040D	46	189	294	40	70			
KTD-47020D	47	99	204	KTD-47030D	47	146	251	KTD-47040D	47	193	298					
KTD-48020D	48	101	206	KTD-48030D	48	149	254	KTD-48040D	48	197	302			SPMT140512DT KT9300	TSB-50125	TXL-20
KTD-49020D	49	103	208	KTD-49030D	49	152	257	KTD-49040D	49	201	306					
KTD-50020D	50	105	210	KTD-50030D	50	155	260	KTD-50040D	50	205	310					

Indexable Drill KUD



the wide chip discharging space
扩大了排出碎片空间。



The features of KUD small drills

- Small Dia drills are designed oil holes to 11 types so the hardness of the drill body is improved and the space of chip break is greatly extended.
- The drilling performance and the drilled surface are excellent by the best design.

KUD 小口径钻头特点

- KUD 小口径 ($13\Phi \sim \Phi 20$) 钻头通过改善设计 (切削油孔改为“11”字形), 来提高钻头机体的强度及扩大了碎片的排出空间。
- 以采用最佳设计, 来提高切削效果及实现了良好的表面光照度。

The features of KUD middle and big diameter drills

- The chip discharging space for KUD middle dia and big dia drill ($\Phi 20.5 \sim \Phi 58$) was greatly extended. These drills are stable and drilling surface are excellent in the deep hole drilling also.
- Please make sure the proper oil pressure and the cutting data (p10) for the best performance. (The proper pressure for KUD2XD, 3XD is over $3\text{kg}/\text{cm}^2$, the proper pressure for 4XD is over $4\text{kg}/\text{cm}^2$)

KUD 中·大口径钻头的特点

- KUD 中·大口径 ($20.5\Phi \sim \Phi 58$) 钻头采用了最佳设计方案, 大大扩大了排出碎片的空间。加工深孔时, 能够保持稳定的钻孔能力及实现了良好的表面光照度。
- 为获得最佳加工效果, 请检查切削条件表 (p10) 及切削油的适合压力。
(适合压力为, 加工KUD 2XD、3XD时, 保持 $3\text{kg}/\text{cm}^2$ 以上的压力, 加工4XD时, 保持 $4\text{kg}/\text{cm}^2$ 以上的压力)

2D Code No.	Dimension (mm)			3D Code No.	Dimension (mm)			4D Code No.	Dimension (mm)					INSERT	Component	
	D	L1	L		D	L1	L		D	L1	L	Ds	Ls		Screw	Wrench
KUD-13020D	13.0	29	99	KUD-13030D	13.0	42	112	KUD-13040D	13.0	55	125	20	50	WC..03T104	TSB-18045	TXL-6
KUD-13520D	13.5	30	100	KUD-13530D	13.5	44	114	KUD-13540D	13.5	57	127					
KUD-14020D	14.0	31	101	KUD-14030D	14.0	45	115	KUD-14040D	14.0	59	129					
KUD-14520D	14.5	32	102	KUD-14530D	14.5	47	117	KUD-14540D	14.5	61	131					
KUD-15020D	15.0	33	103	KUD-15030D	15.0	48	118	KUD-15040D	15.0	63	133					
KUD-15520D	15.5	34	104	KUD-15530D	15.5	50	120	KUD-15540D	15.5	65	135					
KUD-16020D	16.0	35	116	KUD-16030D	16.0	51	132	KUD-16040D	16.0	67	148	25	56	WC..030204	TSB-22045	TXL-6
KUD-16520D	16.5	36	117	KUD-16530D	16.5	53	134	KUD-16540D	16.5	69	150					
KUD-17020D	17.0	37	118	KUD-17030D	17.0	54	135	KUD-17040D	17.0	71	152					
KUD-17520D	17.5	38	119	KUD-17530D	17.5	56	137	KUD-17540D	17.5	73	154					
KUD-18020D	18.0	39	120	KUD-18030D	18.0	57	138	KUD-18040D	18.0	75	156					
KUD-18520D	18.5	40	121	KUD-18530D	18.5	59	140	KUD-18540D	18.5	77	158					
KUD-19020D	19.0	41	122	KUD-19030D	19.0	60	141	KUD-19040D	19.0	79	160					
KUD-19520D	19.5	42	123	KUD-19530D	19.5	62	143	KUD-19540D	19.5	81	162					
KUD-20020D	20.0	43	124	KUD-20030D	20.0	63	144	KUD-20040D	20.0	83	164					
KUD-20520D	20.5	44	125	KUD-20530D	20.5	65	146	KUD-20540D	20.5	85	166	25	56	WC..040204	TSB-25055	TXL-8
KUD-21020D	21.0	45	126	KUD-21030D	21.0	66	147	KUD-21040D	21.0	87	168					
KUD-21520D	21.5	46	127	KUD-21530D	21.5	68	149	KUD-21540D	21.5	89	170					
KUD-22020D	22.0	47	128	KUD-22030D	22.0	69	150	KUD-22040D	22.0	91	172					
KUD-22520D	22.5	48	129	KUD-22530D	22.5	71	152	KUD-22540D	22.5	93	174					
KUD-23020D	23.0	49	130	KUD-23030D	23.0	72	153	KUD-23040D	23.0	95	176					
KUD-23520D	23.5	50	131	KUD-23530D	23.5	74	155	KUD-23540D	23.5	97	178					
KUD-24020D	24.0	51	132	KUD-24030D	24.0	75	156	KUD-24040D	24.0	99	180					
KUD-24520D	24.5	52	133	KUD-24530D	24.5	77	158	KUD-24540D	24.5	101	182					
KUD-25020D	25.0	53	134	KUD-25030D	25.0	78	159	KUD-25040D	25.0	103	184					
KUD-25520D	25.5	54	144	KUD-25530D	25.5	80	170	KUD-25540D	25.5	105	195	32	60	WC..050308	TSB-30070	TXL-8
KUD-26020D	26.0	55	145	KUD-26030D	26.0	81	171	KUD-26040D	26.0	107	197					
KUD-26520D	26.5	56	146	KUD-26530D	26.5	83	173	KUD-26540D	26.5	109	199					
KUD-27020D	27.0	57	147	KUD-27030D	27.0	84	174	KUD-27040D	27.0	111	201					
KUD-27520D	27.5	58	148	KUD-27530D	27.5	86	176	KUD-27540D	27.5	113	203					
KUD-28020D	28.0	59	149	KUD-28030D	28.0	87	177	KUD-28040D	28.0	115	205					
KUD-28520D	28.5	60	150	KUD-28530D	28.5	89	179	KUD-28540D	28.5	117	207					
KUD-29020D	29.0	61	151	KUD-29030D	29.0	90	180	KUD-29040D	29.0	119	209					
KUD-29520D	29.5	62	152	KUD-29530D	29.5	92	182	KUD-29540D	29.5	121	211					
KUD-30020D	30.0	63	153	KUD-30030D	30.0	93	183	KUD-30040D	30.0	123	213					
KUD-31020D	31.0	65	155	KUD-31030D	31.0	96	186	KUD-31040D	31.0	127	217	32	60	WC..06T308	TSB-35090	TXL-15
KUD-32020D	32.0	67	157	KUD-32030D	32.0	99	189	KUD-32040D	32.0	131	221					
KUD-33020D	33.0	69	159	KUD-33030D	33.0	102	192	KUD-33040D	33.0	135	225					
KUD-34020D	34.0	71	161	KUD-34030D	34.0	105	195	KUD-34040D	34.0	139	229					
KUD-35020D	35.0	73	163	KUD-35030D	35.0	108	198	KUD-35040D	35.0	143	233					
KUD-36020D	36.0	75	165	KUD-36030D	36.0	111	201	KUD-36040D	36.0	147	237					
KUD-37020D	37.0	77	167	KUD-37030D	37.0	114	204	KUD-37040D	37.0	151	241					
KUD-38020D	38.0	79	169	KUD-38030D	38.0	117	207	KUD-38040D	38.0	155	245					
KUD-39020D	39.0	81	171	KUD-39030D	39.0	120	210	KUD-39040D	39.0	159	249					
KUD-40020D	40.0	83	173	KUD-40030D	40.0	123	213	KUD-40040D	40.0	163	253					
KUD-41020D	41.0	85	175	KUD-41030D	41.0	126	216	KUD-41040D	41.0	167	257					
KUD-42020D	42.0	87	192	KUD-42030D	42.0	129	234	KUD-42040D	42.0	171	276	40	70	WC..080408	TSB-40110	TXL-15
KUD-43020D	43.0	89	194	KUD-43030D	43.0	132	237	KUD-43040D	43.0	175	280					
KUD-44020D	44.0	91	196	KUD-44030D	44.0	135	240	KUD-44040D	44.0	179	284					
KUD-45020D	45.0	93	198	KUD-45030D	45.0	138	243	KUD-45040D	45.0	183	288					
KUD-46020D	46.0	95	200	KUD-46030D	46.0	141	246	KUD-46040D	46.0	187	292					
KUD-47020D	47.0	97	202	KUD-47030D	47.0	144	249	KUD-47040D	47.0	191	296					
KUD-48020D	48.0	99	204	KUD-48030D	48.0	147	252	KUD-48040D	48.0	195	300					
KUD-49020D	49.0	101	206	KUD-49030D	49.0	150	255	KUD-49040D	49.0	199	304					
KUD-50020D	50.0	103	208	KUD-50030D	50.0	153	258	KUD-50040D	50.0	203	308					
KUD-51020D	51.0	105	210	KUD-51030D	51.0	156	261	KUD-51040D	51.0	207	312					
KUD-52020D	52.0	107	212	KUD-52030D	52.0	159	264	KUD-52040D	52.0	211	316					
KUD-53020D	53.0	109	214	KUD-53030D	53.0	162	267	KUD-53040D	53.0	215	320					
KUD-54020D	54.0	111	216	KUD-54030D	54.0	165	270	KUD-54040D	54.0	219	324					
KUD-55020D	55.0	113	218	KUD-55030D	55.0	168	273	KUD-55040D	55.0	223	328					
KUD-56020D	56.0	115	220	KUD-56030D	56.0	171	276	KUD-56040D	56.0	227	332					
KUD-57020D	57.0	117	222	KUD-57030D	57.0	174	279	KUD-57040D	57.0	231	336					
KUD-58020D	58.0	119	224	KUD-58030D	58.0	177	282	KUD-58040D	58.0	235	340					

Technical Information (KTD & KUD) 技术资料

Formula for Cutting operation 切削加工公式

RPM[min-1] 主轴转速

$$n = \frac{V_c \times 1,000}{D \times \pi}$$

Cutting Speed[m/min] 切削速度

$$V_c = \frac{\pi \times D \times n}{1,000}$$

Feed Rate [mm/rev] 每转进给量

$$f = f_z \times Z$$

Feed Speed[mm/min] 进给速度

$$V_f = f \times n$$

D : Drill Diameter 钻头直径

n : RPM 转速

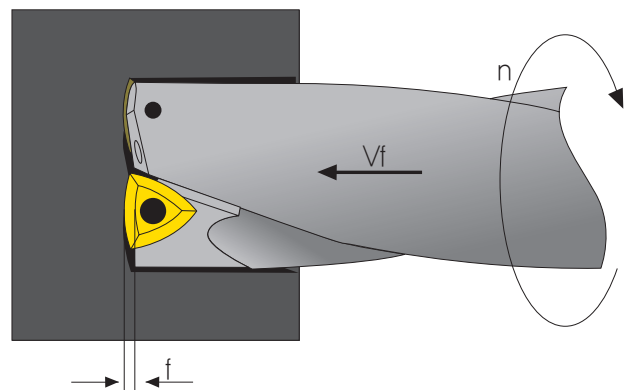
Z : NO. of tooth 刃数

f : Feed rate(mm/rev) 每转进给量

V_c : Cutting Speed(m/min) 切削速度

V_f : Feed Speed(mm/min) 进给速度

f_z : Feed rate(mm/tooth) 每刃进给量





Technical Information [KTD]

技术资料

	Material 材质	Vc	Feed Rate 进给 (mm/rev)								
		(m/min)	Φ 12.5~ Φ 15	Φ 15.5~ Φ 21.5	Φ 22~ Φ 27.5	Φ 28~ Φ 33	Φ 34~ Φ 41	Φ 42~ Φ 50	Φ 50~ Φ 60	Φ 60~ Φ 75	Φ 75~ Φ 80
Steel 刚	低碳钢 (0.25%) (Unalloyed steel)	180-250	0.05-0.08	0.06-0.10	0.06-0.12	0.07-0.13	0.08-0.15	0.08-0.16	0.06-0.12	0.08-0.12	0.08-0.12
	高碳钢 (0.25%~) (Low-alloy steel)	160-220	0.05-0.08	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25	0.10-0.14	0.12-0.18	0.11-0.18
	低合金钢 (-HB300) (Low-alloy steel)	150-220	0.06-0.12	0.08-0.14	0.10-0.18	0.12-0.22	0.12-0.23	0.13-0.24	0.08-0.15	0.10-0.18	0.10-0.18
	高合金钢 (HB300~) (High-alloy steel)	130-180	0.06-0.10	0.08-0.15	0.10-0.20	0.12-0.23	0.12-0.24	0.13-0.25	0.08-0.14	0.09-0.15	0.09-0.14
Stainless steel 不锈钢	不锈钢 Stainless steel	170-240	0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.19	0.06-0.13	0.08-0.15	0.08-0.14
Cast iron 铸铁	灰铸铁 Grey cast iron	180-250	0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30	0.12-0.20	0.15-0.20	0.15-0.20
	球黑铸铁 Cast iron with nodular cast iron	130-200	0.06-0.10	0.08-0.15	0.10-0.18	0.12-0.20	0.15-0.23	0.16-0.25	0.10-0.15	0.09-0.18	0.10-0.18
Nonferrous metals 非铁金属	铝合金 Aluminum	330-380	0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26	0.14-0.20	0.14-0.23	0.15-0.23
Super-alloys and titanium 钛合金	钛合金 Super-alloys and titanium	30-60	0.05-0.10	0.06-0.14	0.08-0.18	0.10-0.22	0.12-0.22	0.14-0.24	0.10-0.15	0.1-0.15	0.1-0.15



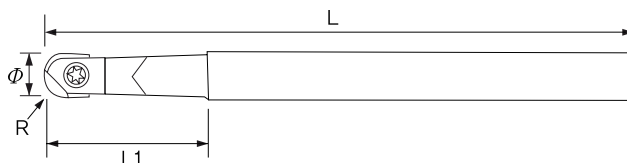
Technical Information [KUD]

技术资料

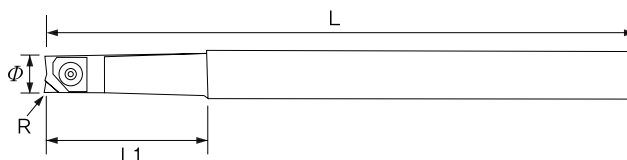
	Material 材质	Vc	Feed Rate 进给 (mm/rev)						
		(m/min)	Φ 13~ Φ 15.5	Φ 16~ Φ 20	Φ 20.5~ Φ 25	Φ 25.5~ Φ 30	Φ 31~ Φ 41	Φ 42~ Φ 58	Φ 59~ Φ 80
Steel 刚	低碳钢 (-0.25%) (Unalloyed steel)	180-260	0.05-0.08	0.06-0.10	0.07-0.12	0.09-0.15	0.11-0.18	0.15-0.28	0.11-0.18
	高碳钢 (0.25%~) (Low-alloy steel)	150-240	0.05-0.08	0.06-0.10	0.07-0.12	0.09-0.15	0.11-0.18	0.15-0.28	0.11-0.18
	低合金钢 (-HB300) (Low-alloy steel)	120-240	0.05-0.08	0.06-0.10	0.07-0.12	0.09-0.15	0.11-0.18	0.15-0.28	0.11-0.18
	高合金钢 (HB300~) (High-alloy steel)	130-220	0.05-0.08	0.06-0.10	0.07-0.12	0.09-0.15	0.11-0.18	0.15-0.28	0.11-0.18
Stainless steel 不锈钢	不锈钢 Stainless steel	150-220	0.04-0.08	0.05-0.09	0.06-0.12	0.07-0.13	0.08-0.16	0.10-0.20	0.08-0.16
Cast iron 铸铁	灰铸铁 Grey cast iron	150-250	0.05-0.11	0.07-0.13	0.08-0.12	0.10-0.18	0.14-0.26	0.18-0.35	0.14-0.26
	球墨铸铁 Cast iron with nodular cast iron	120-200	0.05-0.11	0.06-0.13	0.07-0.12	0.08-0.18	0.14-0.26	0.18-0.35	0.14-0.26
Nonferrous metals 非铁金属	铝锻造合金 Aluminium forging alloys	300-380	0.04-0.06	0.05-0.07	0.16-0.08	0.07-0.09	0.10-0.14	0.12-0.17	0.10-0.14
	铝铸造合金 Aluminium cast alloys	260-330	0.04-0.06	0.05-0.07	0.06-0.08	0.07-0.09	0.10-0.14	0.12-0.17	0.10-0.14
Super-alloys and titanium 钛合金	钛合金 Super-alloys and titanium	40-80	0.03-0.05	0.04-0.06	0.04-0.07	0.05-0.08	0.06-0.10	0.07-0.13	0.06-0.10



MIDAS ABPF HOLDER



CARBIDE HOLDER							
Dimension 尺寸							
CODE NO. 规格	Φ	R	L	L ₁	Insert 配合的刀片	Screw 螺丝	Wrench 扳手
C-ABPF 10×150	10	5	150	20	SP1W100/SP1Q100 SP1W110	581-142	104-T10
C-ABPF 12×150	12	6	150	30	SP1W120/SP1Q120 SP1W130/SP1Q130	581-143	105-T20
C-ABPF 16×200	16	8	200	70	SP1W160/SP1Q160 SP1W170/SP1Q170	581-144	105-T20
C-ABPF 20×220	20	10	220	80	SP1W200/SP1Q200 SP1W210/SP1Q210	581-145	101-T25S
C-ABPF 25×250	25	12.5	250	80	SP1W250/SP1Q250 SP1W260/SP1Q260	581-146	105-T30A
C-ABPF 30×300	30	15	300	100	SP1W300/SP1Q300 SP1W330	581-147	105-T30A



STEEL HOLDER							
Dimension 尺寸							
CODE NO. 规格	Φ	R	L	L ₁	Insert 配合的刀片	Screw 螺丝	Wrench 扳手
ABPF 16×220	16	8	220	70	SP1W160/SP1Q160 SP1W170/SP1Q170	581-144	105-T20
ABPF 20×220	20	10	220	80	SP1W200/SP1Q200 SP1W210/SP1Q210	581-145	101-T25S
ABPF 25×250	25	12.5	250	80	SP1W250/SP1Q250 SP1W260/SP1Q260	581-146	105-T30A
ABPF 30×250	30	15	250	100	SP1W300/SP1Q300 SP1W330	581-147	105-T30A

How to install insert

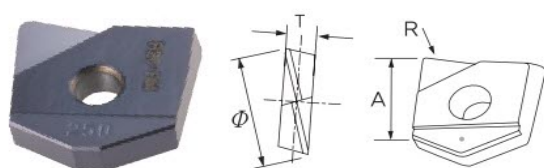
The marking part of insert is located on the top and installed in holder.

插入刀片的方法

刀片中的标志向上安装在刀杆上方部位。

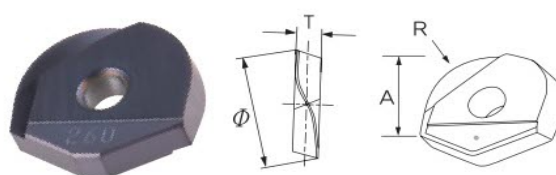
MIDAS INSERT

SP1Q



SP1Q				
CODE NO. 规格	R	A	Φ	T
SP1Q100×0.5R	0.5	11.6	10.0	2.7
SP1Q100×1.0R	1.5			
SP1Q100×2.0R	2.0			
SP1Q120×0.5R	0.5	14.3	12.0	3.2
SP1Q120×1.0R	1.0			
SP1Q120×2.0R	2.0			
SP1Q130×0.3R	0.3	12.7	13.0	3.2
SP1Q130×0.5R	0.5			
SP1Q130×1.0R	1.0			
SP1Q160×0.5R	0.5	16.6	16.0	4.2
SP1Q160×1.0R	1.0			
SP1Q160×2.0R	2.0			
SP1Q170×0.5R	0.5	15.9	17.0	4.2
SP1Q170×1.0R	1.0			
SP1Q170×2.0R	2.0			
SP1Q200×0.5R	0.5	19.9	20.0	5.2
SP1Q200×1.0R	1.0			
SP1Q200×2.0R	2.0			
SP1Q210×0.5R	0.5	20.3	21.0	5.2
SP1Q210×1.0R	1.0			
SP1Q210×2.0R	2.0			
SP1Q250×0.5R	0.5	22.3	25.0	6.2
SP1Q250×1.0R	1.0			
SP1Q250×2.0R	2.0			
SP1Q260×0.5R	0.5	22.9	26.0	6.2
SP1Q260×1.0R	1.0			
SP1Q260×2.0R	2.0			
SP1Q300×0.5R	0.5	27.2	30.0	7.2
SP1Q300×1.0R	1.0			
SP1Q300×2.0R	2.0			

SP1W



SP1W				
CODE NO. 规格	R	A	Φ	T
SP1W100×5.0R	5.0	12.0	10.0	2.7
SP1W110×5.5R	5.5	12.0	11.0	
SP1W120×6.0R	6.0	14.6	12.0	3.2
SP1W130×6.5R	6.5	14.6	13.0	
SP1W160×8R	8.0	16.6	16.0	4.2
SP1W170×8.5R	8.5	17.0	17.0	
SP1W200×10R	10.0	20.3	20.0	5.2
SP1W210×10.5R	10.5	21.0	21.0	
SP1W250×12.5R	12.5	24.1	25.0	6.2
SP1W260×13R	13.0	24.5	26.0	
SP1W300×15R	15.0	29.2	30.0	7.2

Features

1. High precision (± 0.01 below)
2. Use one holder
3. Compatible with other products
4. 30% cost reduction compared with Japanese same type inserts
 - Utility Model No. 0355943

刀片特征

1. 高精度 (± 0.01 以下)
2. 使用1个刀杆
3. 跟别的公司的产品交换使用可能
4. 比日本产品的价格30%降低成本
 - 实用新案 No.0355943

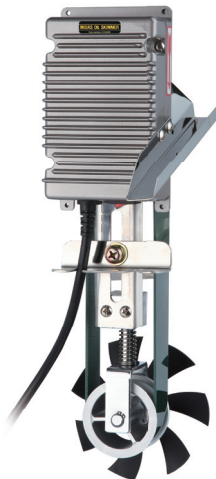


MIDAS OIL SKIMMER

MIDAS 油水分离器

Improve your working environment and Reduce machine maintenance costs

改善工作环境，减少维持费用



Primary Features

- Removal and separation of water-soluble cutting oil and hydraulic fluid.
- Circulation of cutting oil by FAN leads to removal of oil and other floating materials.
- Oil Skimmer is installed easily on MACHINING CENTER, CNC LATHE and OTHER MACHINES.

主要特点

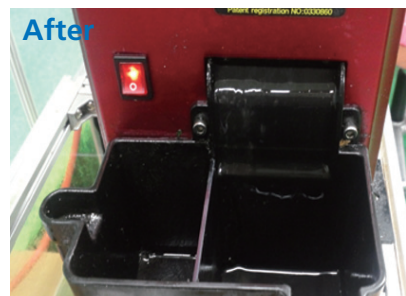
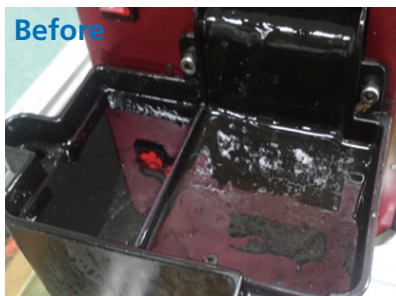
- 本产品是在水溶性切割油中分离及去除浮油的装置。
- 安装FAN，来引导切割油的循环作用，能够去除远距离的油分及其它浮游物质。
- 可简单安装在多工序自动数学控制机床及CNC机床等全部装备

Benefits

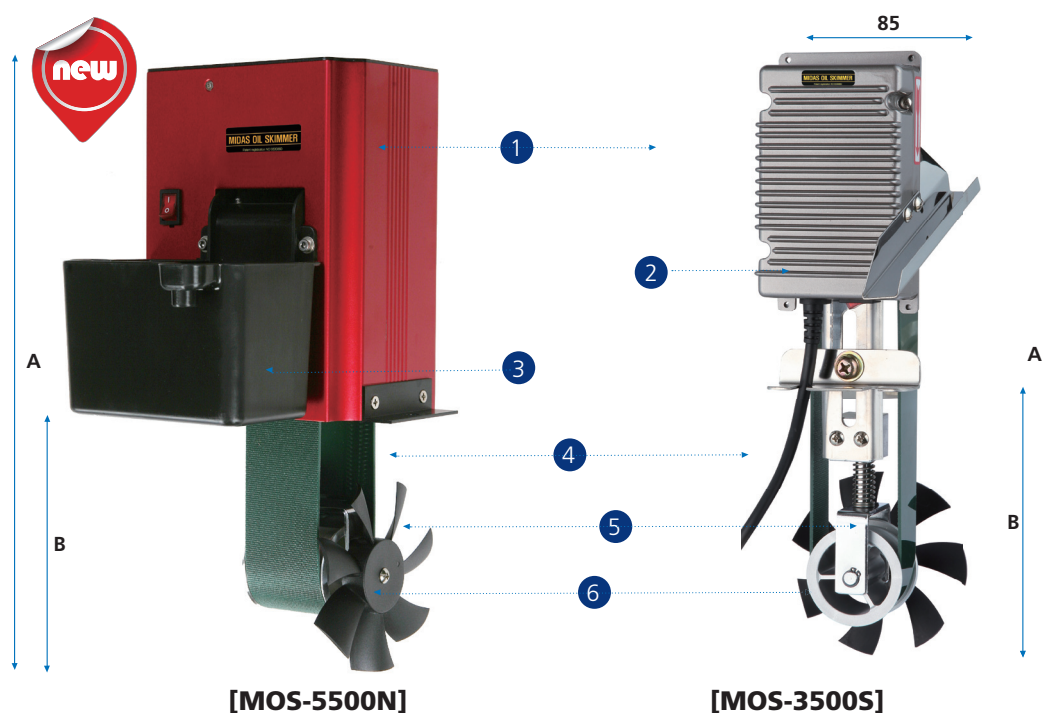
- Remove foul odors and prevent corruption of being produced by cutting oil and water.
- Improve efficiency and reduce disposal cost of waste oil.
- Extend machinery life and improve surface lubricity of work piece by removing waste chips.
- Reduce cost of changing hoses for cutting oil.
- Prevent oil sticking to the product and reduce, thereby reducing the post-processing cost.
- Prevent decoloration and discoloration of material especially when processing STAINLESS STEEL or ALUMINUM.
- All the parts are standardized with patented technology.

优点

- 以防止切割油独有的异味及腐蚀，来改善工作环境及提高工作效率。另外降低废油处理费用。
- 去除微细的碎片，延长工具的使用寿命及提高加工产品的表面光照度。
- 减少切割油排管的更换费用。
- 以预防产品表面上粘贴油分，来减少精加工费用。
- 尤其是加工SUS或铝制品加工时，有显著的防止材料的变色及脱色效果。
- 以100%韩国国内专利技术制造。实现全部部件的规格化。简单、方便维修。



Name & Fuction



- ① **MOTOR BOX** : Made of aluminum and prevent waste materials penetration
以特殊涂色处理，来预防切削油引起的腐蚀及提高了外壳的强度。
- ② **SCRAPPER** : Separated oil from water-soluble oil
油水分离
- ③ **BOX FOR SEPARATING WALTER AND OIL**
油水分离桶
- ④ **BELT** : Oil stick to belt
油水分离机专用皮带
- ⑤ **FAN** : Make cutting oil flow
循环切削油
- ⑥ **PULLEY** : Power of motor is conveyed to belt by PULLEY
采用了坚固的材质，采用弹簧的自动张力功能

MODEL	A	B	WIDTH OF BELT	CAPACITY
型号			皮带副	最大处理功能
MOS-3500S	370	150~200	34	400cc/10min
 MOS-5500N	350	150	54	1000cc/10min



ISO 9001:2008



ISO 14001:2004



The Excellent
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of Seoul

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