



寶濟工業股份有限公司
BAOJE Industrial Co., Ltd.

[小型CNC車床加工刀具] [Small CNC lathe boring tool]

■ 更換重複性高 ■ 具防呆功能 ■ 具高剛性抗震效果



寶濟工業股份有限公司
BAOJE Industrial Co., Ltd.

刀具部專線 Tool department extension /
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寶濟內孔刀-cnc車床之友社
BAOJE bore tool - CNC lathe association

■ Replacing high repeatability
■ Has foolproof
■ Best shock effect with high rigidity

| 客戶滿意化 | 理念國際化 | 品質標準化 | 技術卓越化 |

| Customer satisfaction | Concept internationalization | Quality standardization | Technological excellence

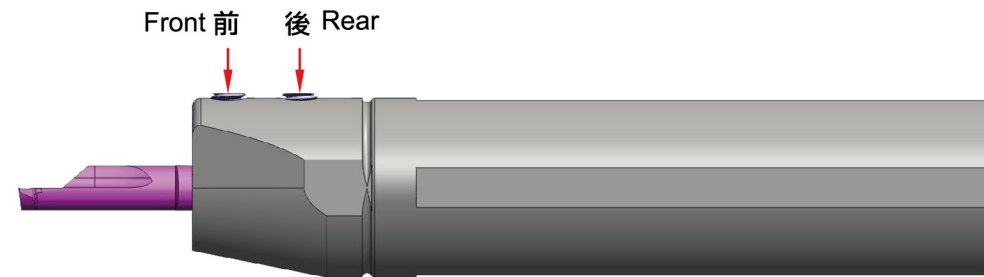
<http://www.baoje.com.tw>

刀柄鎖定容易 換刀不必拆刀柄

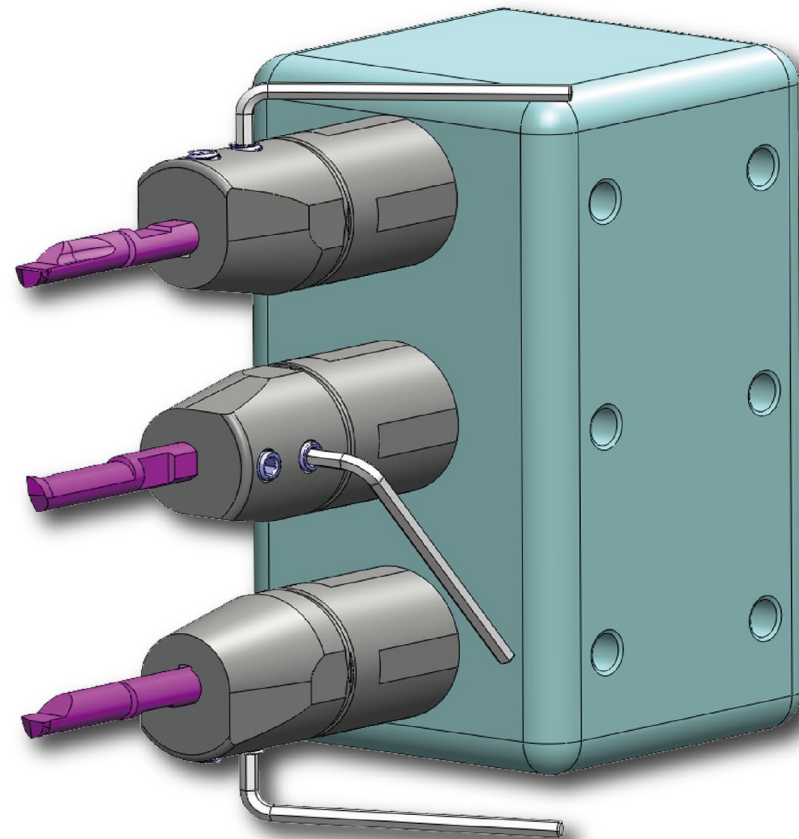
Tool lock easily and Changing tool don't move out the holder

鎖刀步驟 Lock tool process:

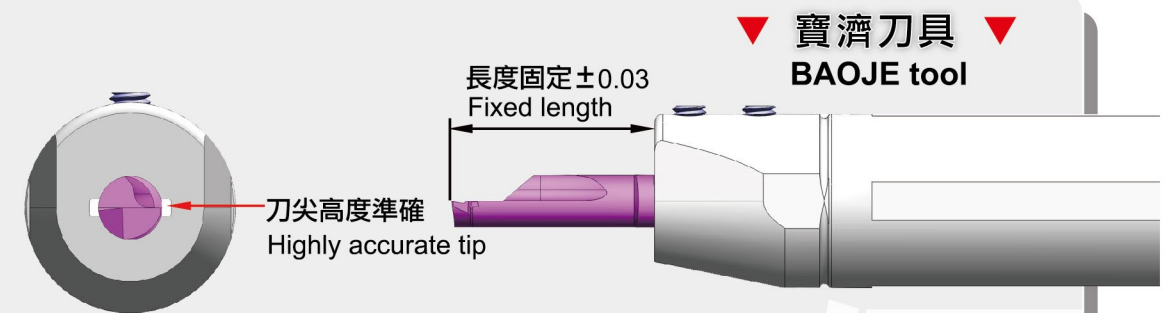
1. 選對刀具基準角度放到底 Alignment tool basic surface and put to the holder.
2. 後螺絲先鎖固定基準面角度 The rear screw lock slightly to the basic surface.
3. 前螺絲鎖緊 Locking tight the front screw.
4. 後螺絲再鎖緊 Re-locking tight the rear screw.



▼ 刀具基準面角度應用 Tool Basic Surface application ▼

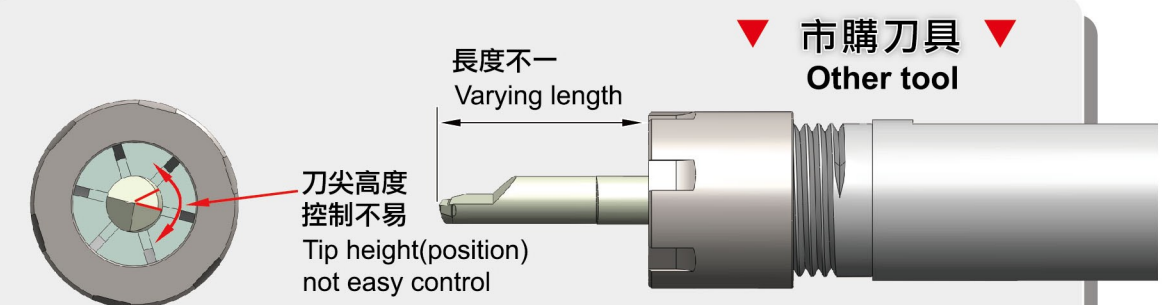


寶濟刀具 vs 市購刀具 BAOJE tool vs. Other tool



1. 換刀準確快速，顧車師傅輕鬆
Accurate and rapid tool change. Easy set up tool for technician
2. 刀尖高度準確，刀具壽命優
Highly accurate tip and excellent tool life.
3. 交貨速度、品質、效率提升，成本降低
Quickly of delivery, best quality, increase efficiency, reduce costs.
4. 依客戶圖面或樣品，客製化刀具，節省開發時間
According to customer drawing or sample. Customization tool to saving develop times.

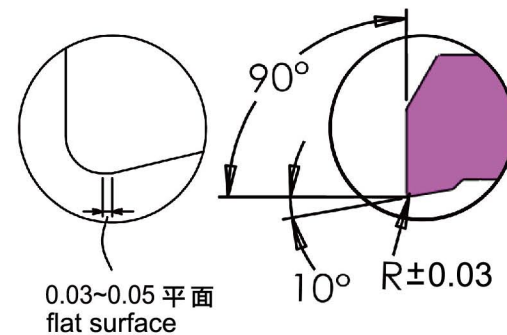
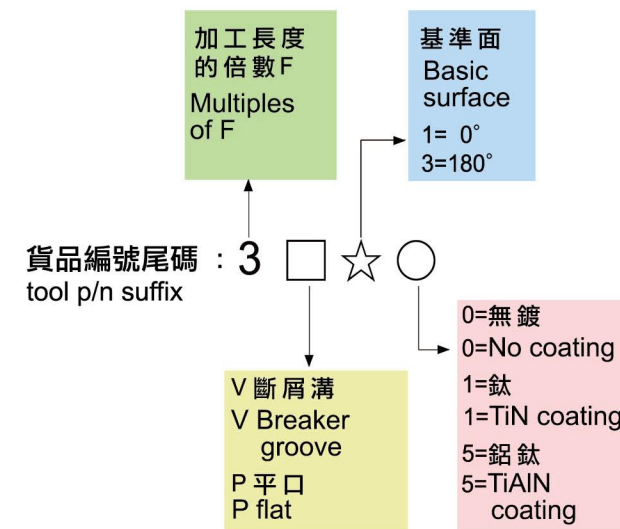
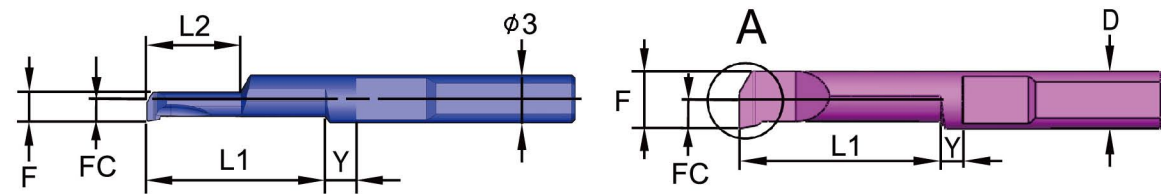
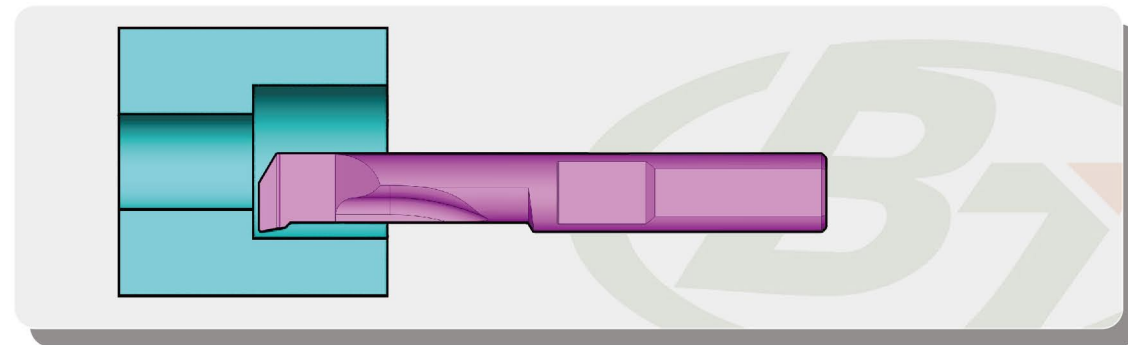
★ 最大特色：新手易上手換刀，解決技術執行難處 ★
The most prominent feature :
Easy tool change for novice. Solve technical implementation difficulties.



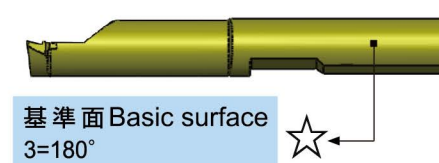
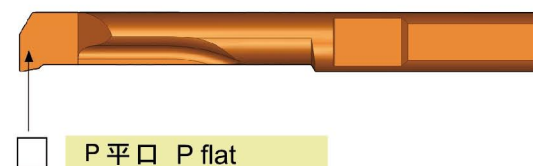
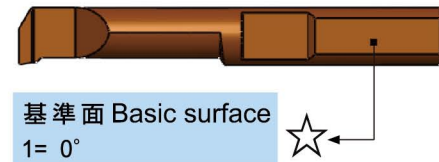
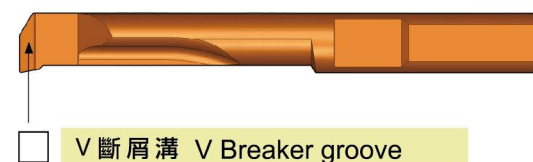
1. 重複鎖定，機械停機時間很長
Need repeat locked the tool, so machine downtime is very long.
2. 重複修改程式，顧車師傅很忙，車床還是停機
Repeat modification NC code. Reduce machine efficiency.
3. 刀尖高度難調以致跳刀、尺寸不穩、刀具壽命差
Tip height is difficult to adjust the size of instability and poor life of tools
4. 不良率高、機械稼動率低、品質難控制，成本高
Quality difficult to control and high poor rate and high cost.

最大盲點：更換刀需有技術能力且執行不易
Biggest blind spot:
Need to have the technical ability to replace the tool and difficult to implement.

0 度前掃刀 0 degree turning tool



▲ A 詳圖
A (see drawing)



▼ 0 度前掃刀規格表 Specifications for 0 degree turning tool ▼

貨品編號 tool p/n	D	最小加工徑 Minimum diameter	F	FC	R	倍數 Multiples	L1	L2	Y	庫存 Stock
TA306-4□☆○	3	0.7	0.6	1.4	0.03	4	4	2.7	3	
TA310-4□☆○	3	1.2	1.0	1.4	0.03	4	6	4.5	3	
TA318-3□☆○						3	8	6		
TA318-4□☆○						4	10.4	8		
TA318-5□☆○	3	2.0	1.8	1.4	0.05	5	13	10	3	
TA318-6□☆○						6	13	12		★
TA318-7□☆○						7	17	14		★
TA329-3□☆○						3	8			
TA329-4□☆○						4	10.4			
TA329-5□☆○	3	3.2	2.9	1.4	0.1	5	13		3	
TA329-6□☆○						6	17			★
TA329-7□☆○						7	20			★
TA439-3□☆○						3	10			
TA439-4□☆○						4	13.5			
TA439-5□☆○	4	4.2	3.9	1.9	0.1	5	17	-	3	
TA439-6□☆○						6	22			★
TA439-7□☆○						7	26			★
TA549-3□☆○						3	14			
TA549-4□☆○						4	18			
TA549-5□☆○	5	5.2	4.9	2.4	0.1	5	22	-	3	
TA549-6□☆○						6	29			★
TA549-7□☆○						7	34			★
TA659-3□☆○						3	16			
TA659-4□☆○						4	22			
TA659-5□☆○	6	6.2	5.9	2.9	0.1	5	27	-	3	
TA659-6□☆○						6	33			★
TA659-7□☆○						7	41			★

品號-品名對應 Product number - corresponding product name

TA549-5V15:549前掃刀5倍0度鋁鈦(有斷屑溝)

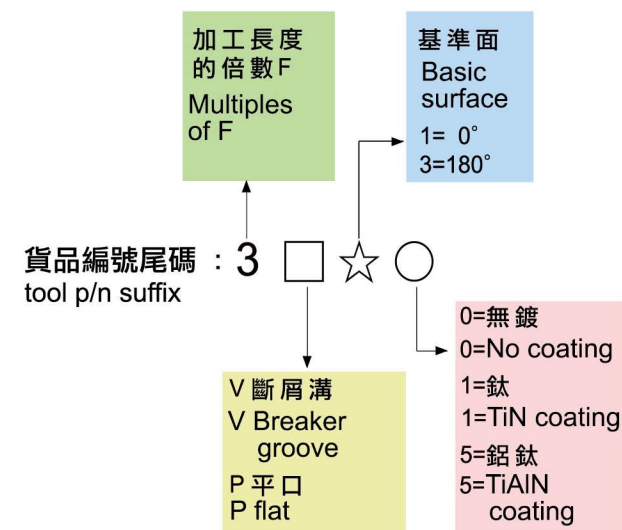
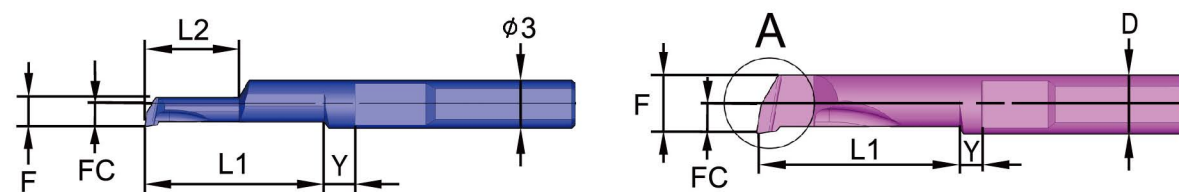
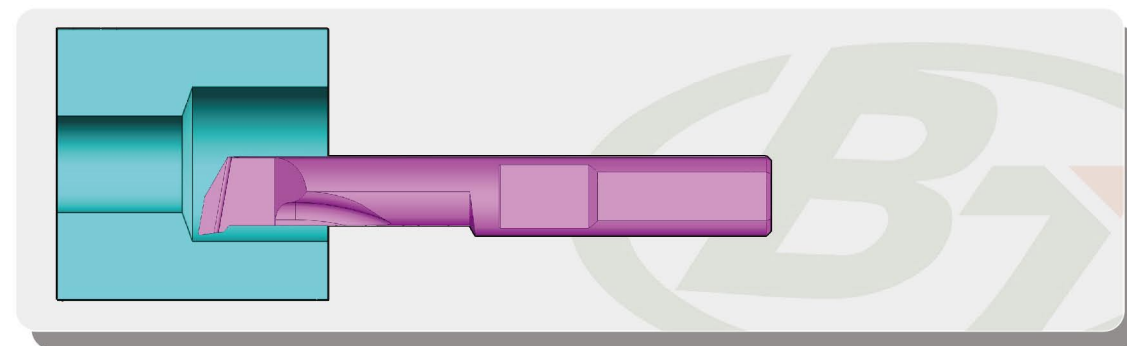
TA549-5V15: 549 turning tool 5 times, 0 degree TiAlN coating (with breaker groove)

TA310-3P30:310平口前掃刀3倍180度無鍍

TA310-3P30: 310 flat turning tool 3 times, 180 degrees, no coating

★ 訂製品 Custom product

10度前掃刀 10 degree turning tool



□ V 斷屑溝 V Breaker groove

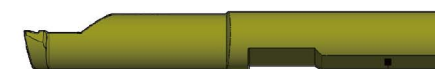


基準面 Basic surface
1= 0° ☆

V Breaker groove



□ P 平口 P flat



基準面 Basic surface
3=180° ☆

10度前掃刀規格表 Specifications for 10 degree turning tool

貨品編號 tool p/n	D	最小加工徑 Minimum diameter	F	FC	R	倍數 Multiples	L1	L2	Y	庫存 Stock
T306-4□☆○	3	0.7	0.6	1.4	0.03	4	4	2.7	3	
T310-4□☆○	3	1.2	1.0	1.4	0.03	4	6	4.5	3	
T318-3□☆○	3	2.0	1.8	1.4	0.05	3	8	6	3	
T318-4□☆○						4	10.4	8		
T318-5□☆○						5	13	10		
T318-6□☆○						6	13	12		★
T318-7□☆○						7	17	14		★
T329-3□☆○	3	3.2	2.9	1.4	0.1	3	8		3	
T329-4□☆○						4	10.4			
T329-5□☆○						5	13			
T329-6□☆○						6	17			★
T329-7□☆○						7	20			★
T439-3□☆○	4	4.2	3.9	1.9	0.1	3	10		3	
T439-4□☆○						4	13.5			
T439-5□☆○						5	17	-		
T439-6□☆○						6	22			★
T439-7□☆○						7	26			★
T549-3□☆○	5	5.2	4.9	2.4	0.1	3	14		3	
T549-4□☆○						4	18			
T549-5□☆○						5	22	-		
T549-6□☆○						6	29			★
T549-7□☆○						7	34			★
T659-3□☆○	6	6.2	5.9	2.9	0.1	3	16		3	
T659-4□☆○						4	22			
T659-5□☆○						5	27	-		
T659-6□☆○						6	33			★
T659-7□☆○						7	41			★

品號-品名對應 Product number - corresponding product name

T549-5V15:549前掃刀5倍0度鋁鈦 (有斷屑溝)

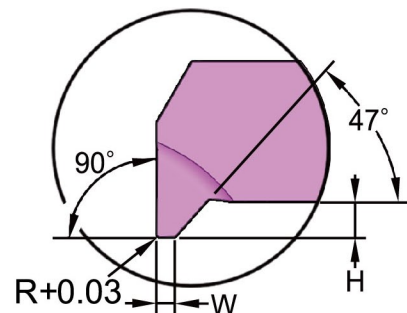
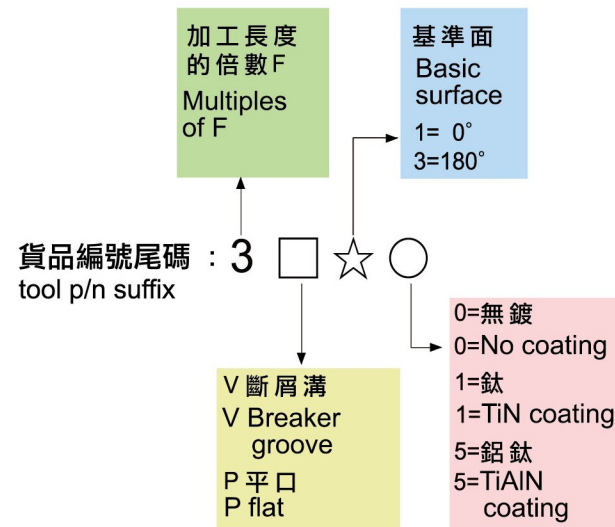
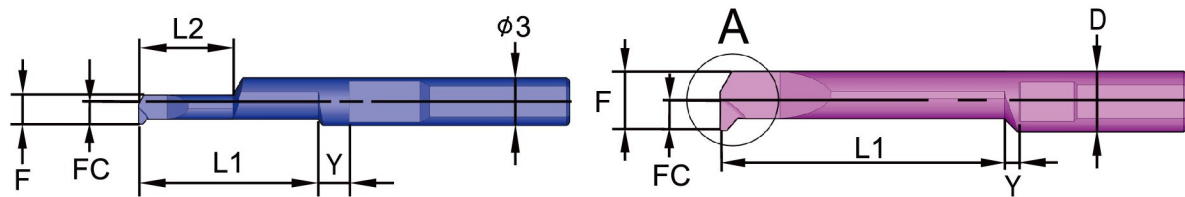
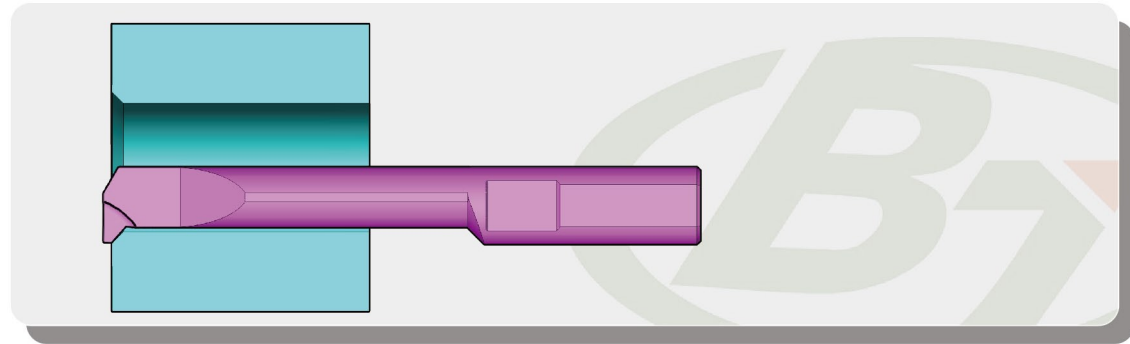
T549-5V15: 549 turning tool 5 times, 0 degree TiAlN coating (with breaker groove)

T310-3P30:310平口前掃刀3倍180度無鍍

T310-3P30: 310 angle turning tool 3 times, 180 degrees, no coating

★ 訂製品 Custom product

47度前掃倒勾刀 47 degree turning of undercut tool



▲ A 詳圖

A (see drawing)

請注意：V型刀具W有斜度
Please note: "W" has taper of V type



V斷屑溝 V breaker groove



P平口 P flat



基準面 Basic surface
1= 0°



基準面 Basic surface
3=180°

47度前掃倒勾刀規格表 Specifications for 47 degree turning of undercut tool

貨品編號 tool p/n	D	最小加工徑 Minimum diameter	F	FC	R	W	H	倍數 Multiples	L1	L2	Y	庫存 stock
U318-3□☆○	3	2.0	1.8	1.4	0.05	0.3	0.5	3	8	6	3	
U318-4□☆○								4	10.4	8		
U318-5□☆○								5	13	10		★
U318-6□☆○								6	13	12		★
U318-7□☆○								7	17	14		
U329-3□☆○	3	3.2	2.9	1.4	0.05	0.4	0.7	3	8		3	
U329-4□☆○								4	10.4			
U329-5□☆○								5	13	-		★
U329-6□☆○								6	17			★
U329-7□☆○								7	20			
U439-3□☆○	4	4.2	3.9	1.9	0.1	0.5	0.8	3	10		3	
U439-4□☆○								4	13.5			
U439-5□☆○								5	17	-		★
U439-6□☆○								6	22			★
U439-7□☆○								7	26			
U549-3□☆○	5	5.2	4.9	2.4	0.1	0.5	1.1	3	14		3	
U549-4□☆○								4	18			
U549-5□☆○								5	22	-		★
U549-6□☆○								6	29			★
U549-7□☆○								7	34			
U659-3□☆○	6	6.2	5.9	2.9	0.1	0.5	1.2	3	16		3	
U659-4□☆○								4	22			
U659-5□☆○								5	27	-		★
U659-6□☆○								6	33			★
U659-7□☆○								7	41			

品號-品名對應 Product number - corresponding product name

U329-5V15:329前掃倒勾刀5倍0度鋁鈦 (有斷屑溝)

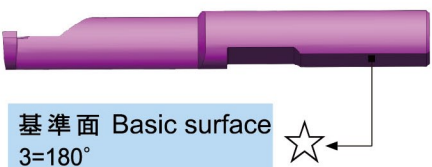
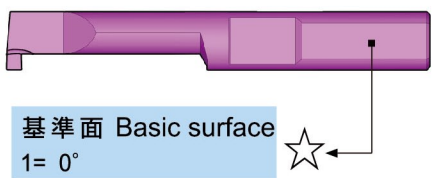
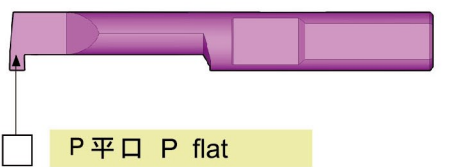
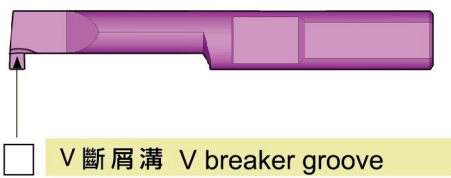
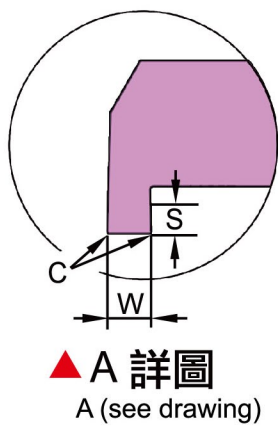
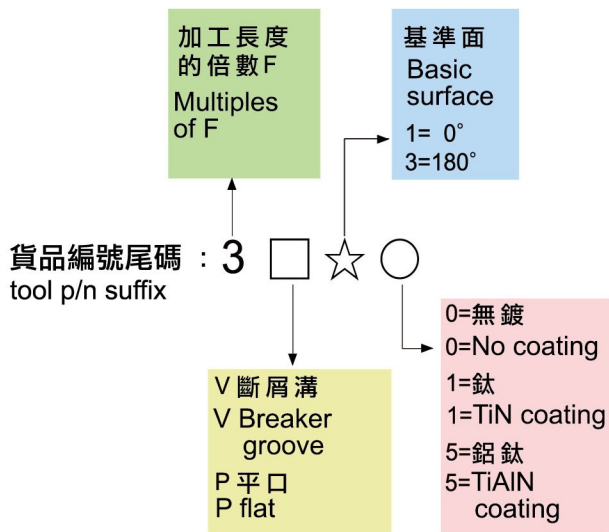
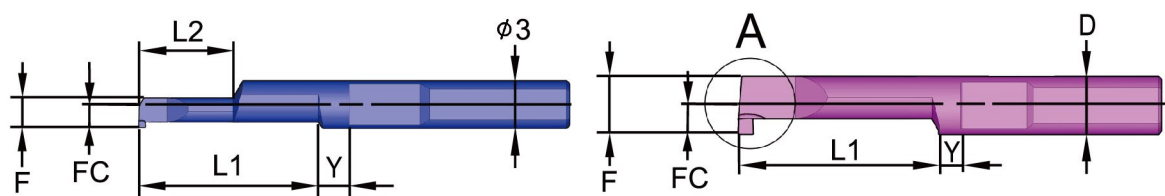
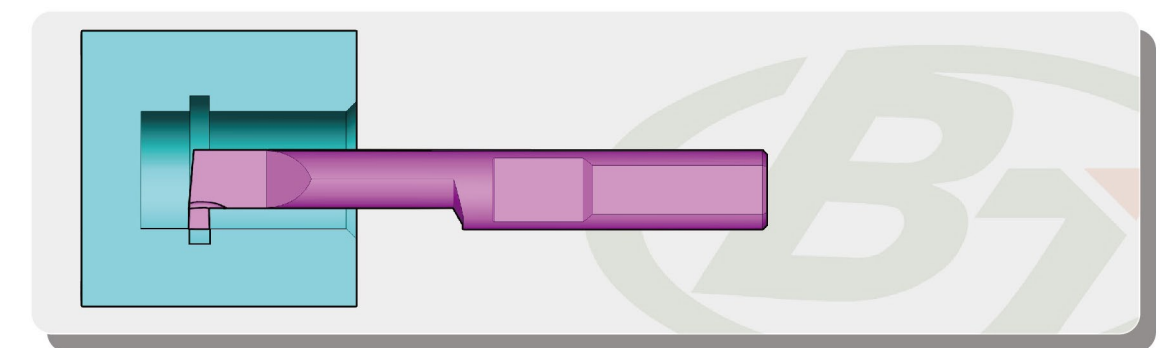
U329-5V15: 329 turning tool with undercut 5 times, 0 degree TiAlN coating (with breaker groove)

U659-3P30:659平口前掃倒勾刀3倍180度無鍍

U659-3P30: 659 angle turning tool with undercut 3 times, 180 degree, no coating

★訂製品 Custom product

插溝刀 Internal Grooving tool



插溝刀規格表 Internal Grooving tool Specifications

貨品編號 tool p/n	D	最小加工徑 Minimum diameter	F	FC	W	S	H	倍數 Multiples	L1	L2	C±0.01	庫存 Stock
G318-0505-3□☆○	3	2.0	1.8	1.4	0.5	0.3	0.5	3	8	3	0	
G30505-3□☆○	3	3.2	2.9	1.4	0.5	0.5	0.7	3	8	3	0.04	
G307508-3□☆○	3	3.2	2.9	1.4	0.75	0.8	1.0	3	8	3	0.04	
G40505-3□☆○	4	4.2	3.9	1.9	0.5	0.5	0.7	3	10	3	0.04	
G407508-3□☆○	4	4.2	3.9	1.9	0.75	0.8	1.0	3	10	3	0.04	
G50506-3□☆○	5	5.2	4.9	2.4	0.5	0.6	0.8	3	14	3	0.04	
G51010-3□☆○	5	5.2	4.9	2.4	1.0	1.0	1.2	3	14	3	0.04	
G512515-3□☆○	5	5.2	4.9	2.4	1.25	1.5	1.7	3	14	3	0.04	
G60506-3□☆○	6	6.2	5.9	2.9	0.5	0.6	0.8	3	16	3	0.04	
G61015-3□☆○	6	6.2	5.9	2.9	1.0	1.5	1.7	3	16	3	0.04	
G61518-3□☆○	6	6.2	5.9	2.9	1.5	1.8	2.0	3	16	3	0.04	

備註 Note:

1.品號-品名對應 Product number - corresponding product name

G40505-3V15:40505插溝刀3倍0度鋁鈦

G40505-3V15: 40505 grooving tool 3 times, 0 degree TiAlN coating

G61518-4P30:61518平口插溝刀4倍180度無鍍

G61518-4P30: 61518 flat grooving tool 4 times, 180 degrees, no coating

2.以上僅列出 加工倍數3倍，高倍數請來電諮詢

The above only lists the 3 times processing multiples. For higher multiples, please contact us.

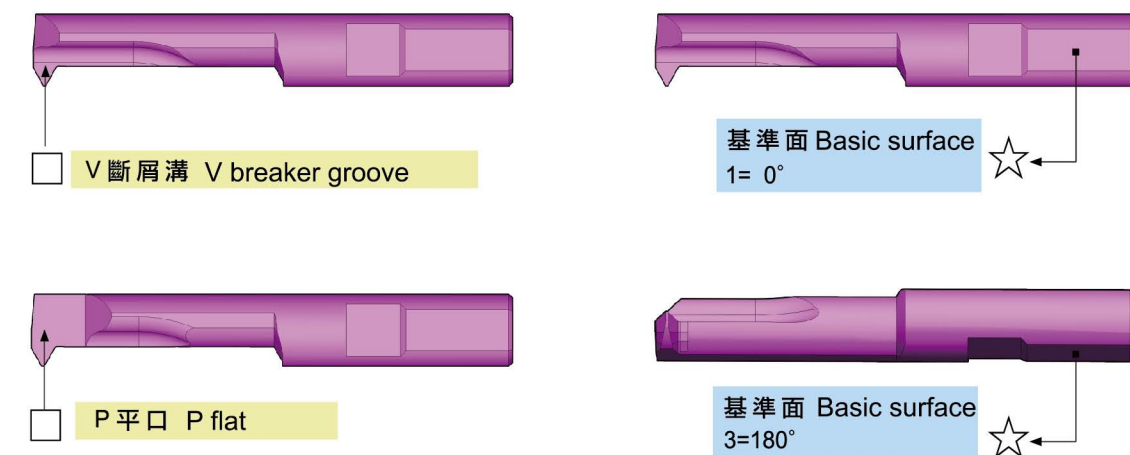
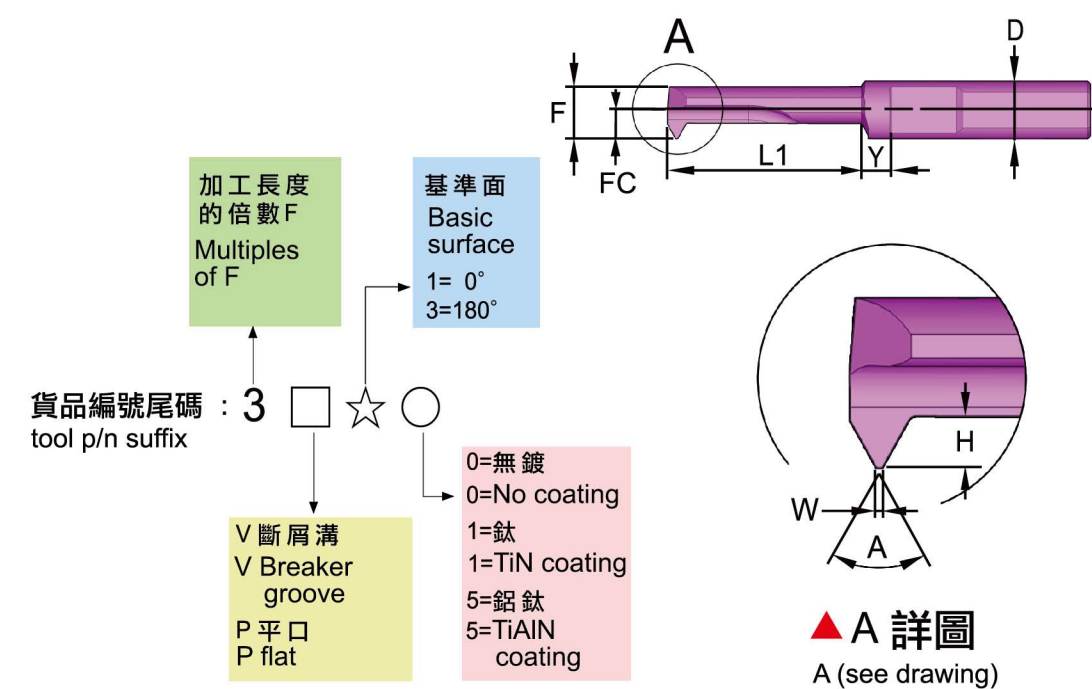
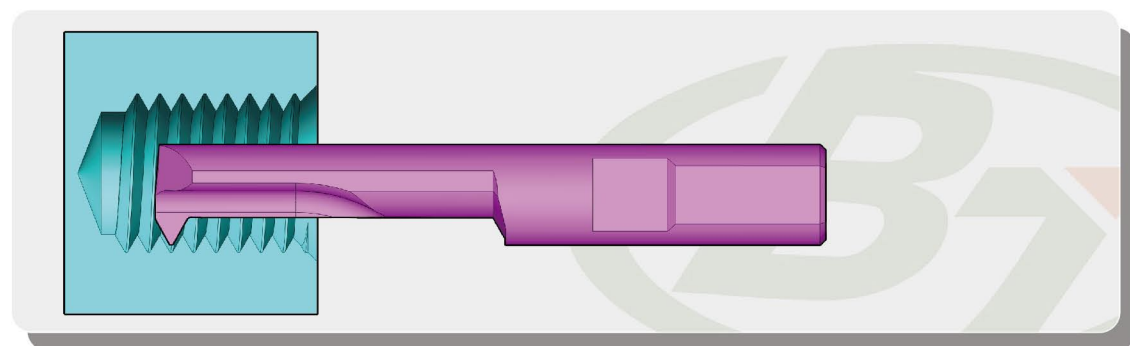
3.插溝刀尺寸眾多，請來電諮詢

Internal grooving tool have numerous sizes, please call for inquiries.

最小孔徑，加工深度，需求插溝寬度W，需求插溝深度S

Minimum bore diameter, processing length, required groove width W, and required groove depth S.

牙刀 Internal threading tool



▼ 牙刀規格表 Internal threading tool Specifications ▼

貨品編號 tool p/n	D	F	FC	A	H	W	最大牙距 Maximum pitch	倍數 Multiples	L1	Y	庫存 stock
i321-3□☆○	3	2.1	1.05	60	0.5	0.03	0.6	3	8	3	
i326-3□☆○	3	2.6	1.4	60	0.6	0.04	0.7	3	8	3	
i326-4□☆○								4	9.9	3.5	
i435-3□☆○								3	10	3	
i435-4□☆○	4	3.5	1.9	60	0.05	60	0.8	4	12.5	4	
i435-5□☆○								5	15	5	
i545-3□☆○								3	14	3	
i545-4□☆○	5	4.5	2.4	60	0.07	60	1.25	4	16	5	
i545-5□☆○								5	18	7	
i659-3□☆○								3	16	3	
i659-4□☆○	6	5.9	2.9	60	0.11	60	1.5	4	19	6	
i659-5□☆○								5	22	8	

備註 Note:

1. 品號-品名對應 Product number - corresponding product name

i435-3V15:435牙刀3倍0度鋁鈦

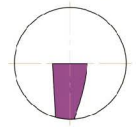
i435 - 3V15: 435 threading tool (3 times ,0 degree, TiAlN coating)

i659-4P30:659平口牙刀4倍180度無鍍

i659 - 4P30: 659 flat threading tool (4 times, 180 degrees, no coating)

端面刀 Face Grooving tool

正常型
Normal type

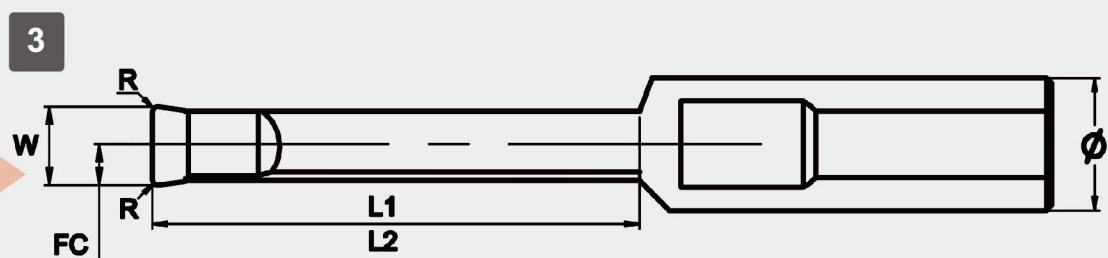
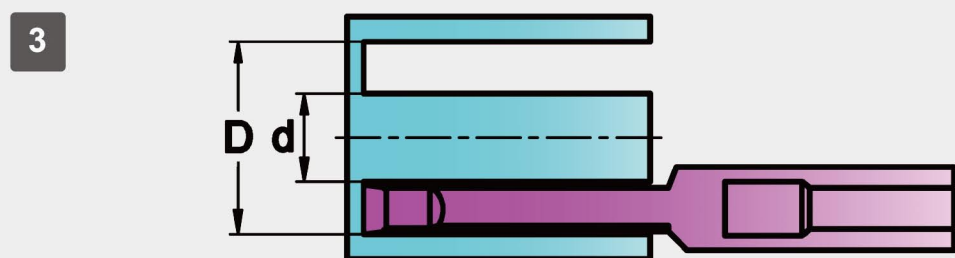
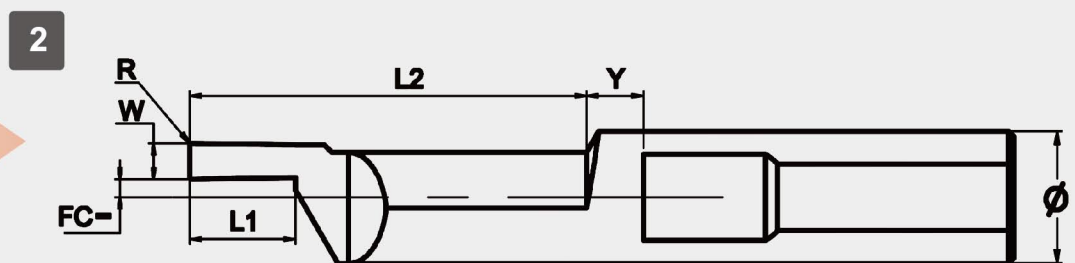
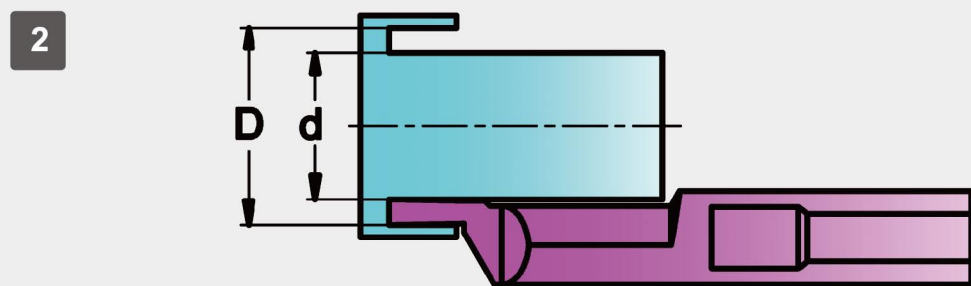
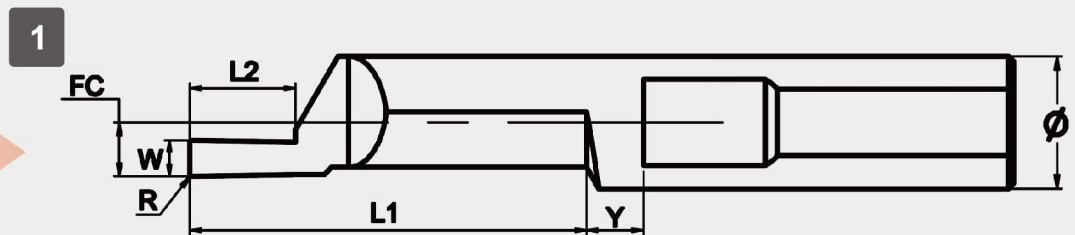
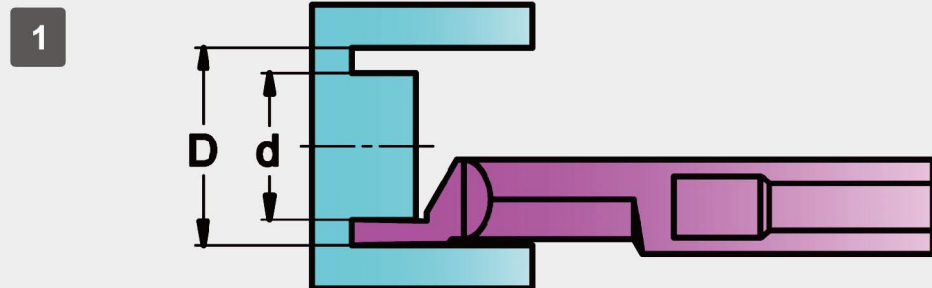
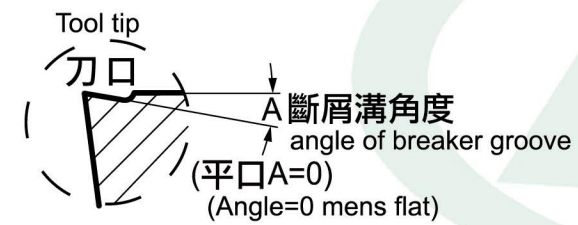


強力型
High Rigid type



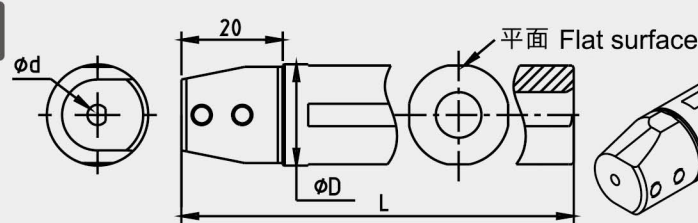
可針對工件尺寸作客製刀
配合寶濟專利設計刀柄讓
新手得心應手

For different size of workpiece can
customization tool, with BAOJE
patented design allows novice easy
to handle



刀柄規格表 Tool holder Specifications

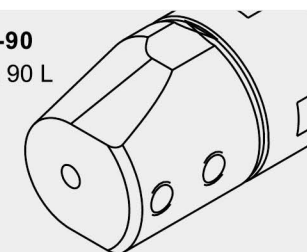
1



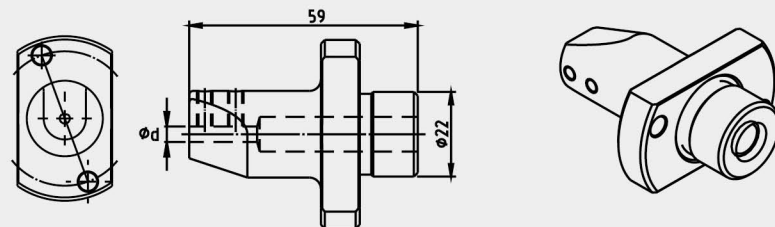
$\phi 16 \times 100L$ $\phi 22 \times 110L$
 $\phi 17 \times 100L$ $\phi 23 \times 110L$
 $\phi 19.05 \times 70L$ $\phi 25 \times 90L$
 $\phi 19.05 \times 95L$ $\phi 25 \times 150L$
 $\phi 20 \times 70L$ $\phi 25.4 \times 90L$
 $\phi 20 \times 100L$
 $\phi 20 \times 150L$

範例：柄徑 $\phi 25.4$ 圓棒徑 $\phi 5$ 刀柄長度 $90L \rightarrow BJA-254-05-90$
 Example: Holder diameter $\phi 25.4$, tool diameter $\phi 5$, holder length $90L \rightarrow BJA-254-05-90$

1 BJA-□□-0□-□□□
 刀柄外徑 圓棒外徑 刀柄長度
 holder diameter tool diameter tool holder length

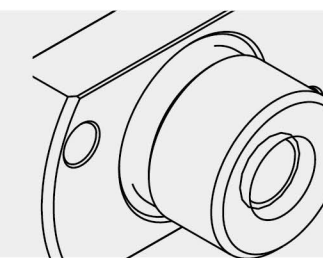


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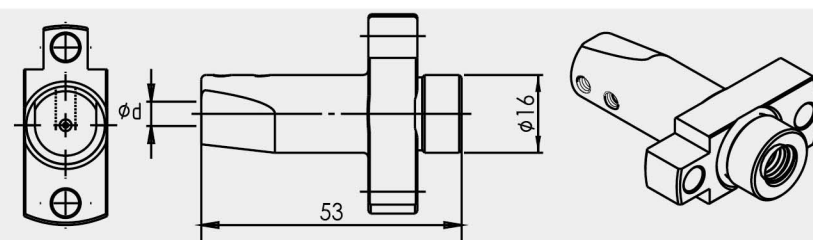


STAR用
 Used for CNC
 Lathe "STAR"
 $\phi 22 \times 59L$

2 BJM-22-0□-59
 圓棒外徑
 tool diameter

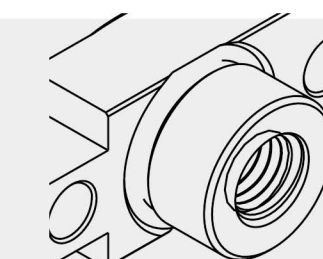


3

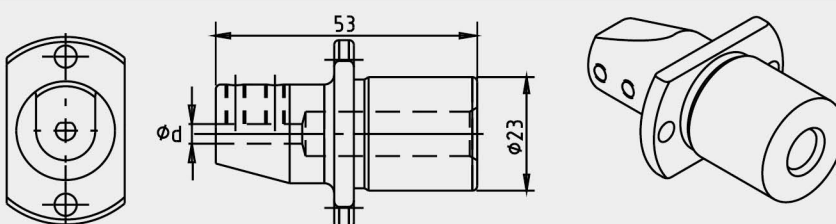


STAR 10J用
 Used for CNC Lathe
 "STAR SR-10J"
 $\phi 16 \times 53L$

3 BJJ-16-0□-53
 圓棒外徑
 tool diameter

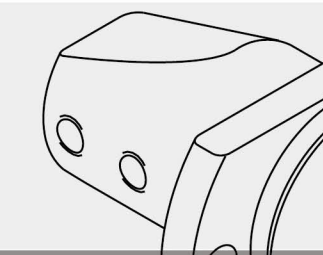


4

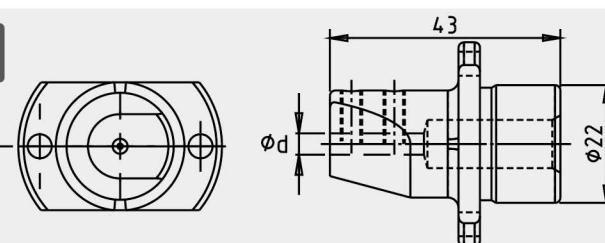


NOMURA用
 Used for CNC Lathe
 "Nomura"
 $\phi 23 \times 53L$

4 BJN-23-0□-53
 圓棒外徑
 tool diameter

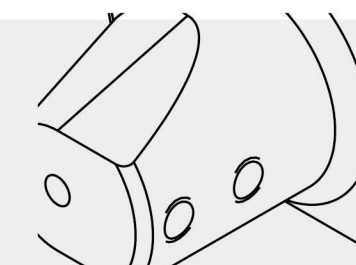


5

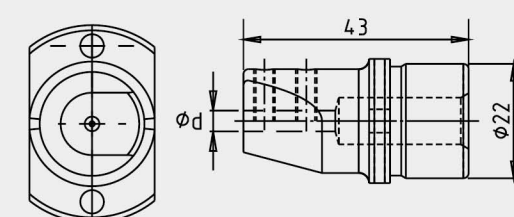


NOMURA用
 Used for CNC Lathe
 "Nomura"
 $\phi 22 \times 43L$
 ★鎖柄與鎖附孔成 0°
 Lock holder and lock
 attached hole forms 0°

5 BJN-E22-0□-43
 圓棒外徑
 tool diameter

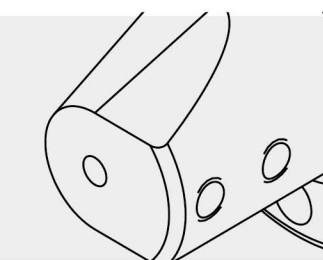


6

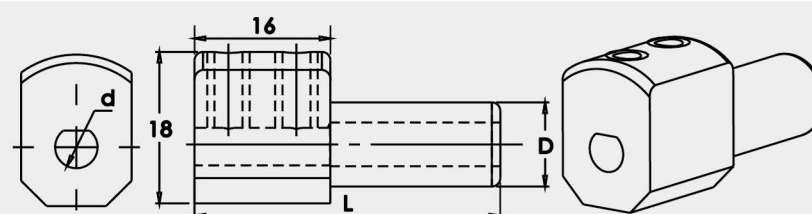


NOMURA用
 Used for CNC Lathe
 "Nomura"
 $\phi 22 \times 43L$
 ★鎖柄與鎖附孔成 90°
 Lock holder and lock
 attached hole forms 90°

6 BJN-N22-0□-43
 圓棒外徑
 tool diameter

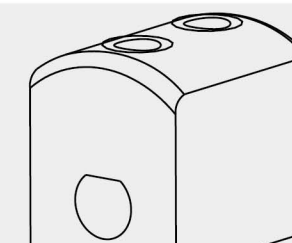


7



簡易型
 Simple type
 $\phi 10 \times 36L$
 $\phi 13 \times 36L$

7 BJAS -□□-0□-36
 刀柄外徑 圓棒外徑
 holder diameter tool diameter



- 1**

1 BJZ-10-03-4

▲ 10柄3mm 4倍
10 mm holder size , 3 mm tool diameter, 4 times
- 2**

2 BJZ-10-04-4

▲ 10柄4mm 4倍
10 mm holder size , 4 mm tool diameter, 4 times
- 3**

3 BJZ-12-03-4

▲ 12柄3mm 4倍
12 mm holder size , 3 mm tool diameter, 4 times
- 4**

4 BJZ-12-04-4

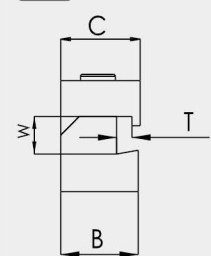
▲ 12柄4mm 4倍
12 pieces, 4 mm, 4 times
12 mm holder size , 4 mm tool diameter, 4 times
- 5**

5 BJZ-12-05-4

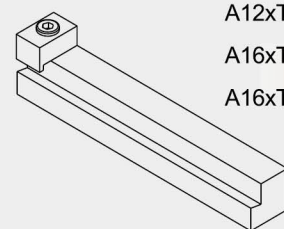
▲ 12柄5mm 4倍
12 pieces, 5 mm, 4 times
12 mm holder size , 5 mm tool diameter, 4 times

專利外徑刀柄 Patent tool holder (Used for outer diameter turning)

1



◀ 單頭 Single head



A08xT2.5xL80
A10xT2.5xL80
A12xT2.5xL80
A16xT2.5xL80
A16xT3xL80

範例：柄徑8柄 使用刀片T2.5XW6 刀柄長度80L→BJB-S08-25-80

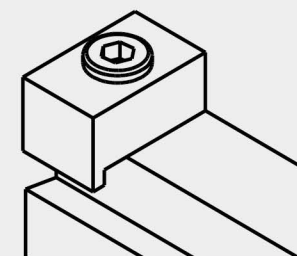
Example: Holder size 8 mm use blade T2.5 x W6 with holder length 80L → BJB-S08-25-80

1 BJB - S □ □ - □ □ - □ □

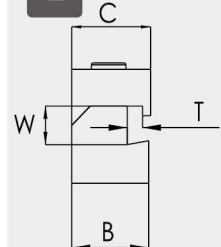
A刀柄
A tool
holder

T刀片厚度
T blade
thickness

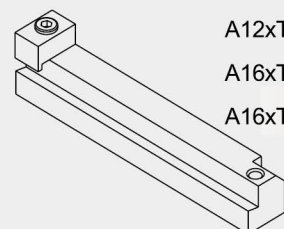
L刀柄長度
L holder
length



2



◀ 雙頭 Dual head



A10xT2.5xL80
A12xT2.5xL80
A12xT2.5xL100
A16xT2.5xL90
A16xT3xL85

範例：柄徑10柄 使用刀片T2.5XW6 刀柄長度80L→BJB-D10-25-80

Example: Holder size 10 mm use blade T2.5 x W6 with holder length 80L → BJB-D10-25-80

範例：柄徑12柄 使用刀片T2.5XW6 刀柄長度100L→BJB-D12-25-100

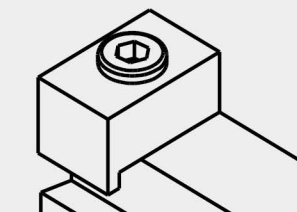
Example: Holder size 12 mm use blade T2.5 x W6 with holder length 100L → BJB-D12-25-100

2 BJB - D □ □ - □ □ - □ □

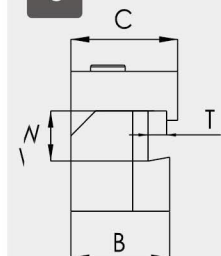
A刀柄
A tool
holder

T刀片厚度
T blade
thickness

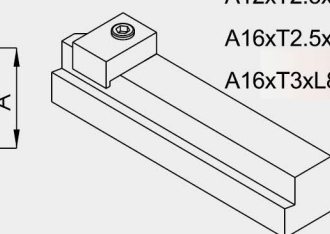
L刀柄長度
L holder
length



3



◀ 強力型 Powerful type



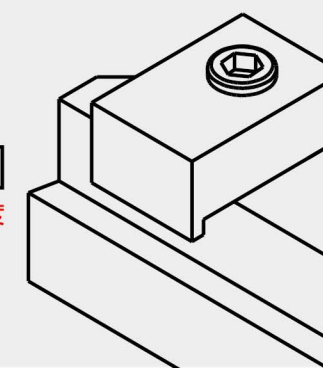
A10xT2.5xL80
A12xT2.5xL80
A12xT2.5xL100
A16xT2.5xL90
A16xT3xL85

3 BJB - P □ □ - □ □ - □ □

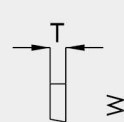
A刀柄
A tool
holder

T刀片厚度
T blade
thickness

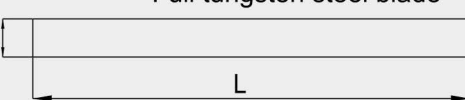
L刀柄長度
L holder
length



4



◀ 全鎢鋼刀片
Full tungsten steel blade



T2.5xW6xL70
T3xW8xL100

建議適用 車削材質	Recommendations apply Turning Material	材質 代碼
		K1
		K2
鋼材	Steel material	JP01
鋁合金	Aluminum alloy	JP02
鈦合金	Titanium alloy	JP03

範例：T2.5XW6XL70 用於車削鋁合金→BJC-250670-JP02

Example: T2.5 x W6 x L70 for turning aluminum alloy → BJC-250670-JP02

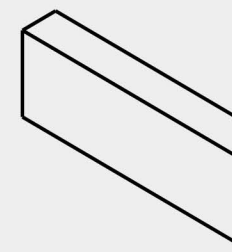
4 BJC - □ □ □ □ □ □ - □ □

T厚度
T thickness

W寬度
W width

L長度
L length

材質代碼
material code



成品(檢驗品)剖開機 Inspection product cutter

▼ 規格表 Specifications ▼

型號 Model	B350	B550
電源 Power	220V	220V
齒輪比 Gear ratio	10比/ratio	15比/ratio
可加工範圍 Machinable range	Ø4~Ø35/100L	Ø10~Ø50/100L
馬達 Motor	400W	400W
切削油桶 Cutting oil tank	18L	18L
鋸片規格 Saw specifications	Ø125X Ø25.4X1.2	Ø150X Ø25.4X2.0
重量 Weight	110Kg	110Kg
機器尺寸 Machine size	780(長length)X650(寬width)X650(高height)	

台灣、中國 已申請專利 成品(檢驗品)剖開機-省時省力

Patents have been applied in Taiwan and China
Inspection product cutter – saves time and effort



針對成品工件需量測內孔尺寸
Focused on measuring the bore size of the workpiece.

工件剖開工程簡易操作設備
Easy workpiece cutting equipment

產品特性
Product characteristics

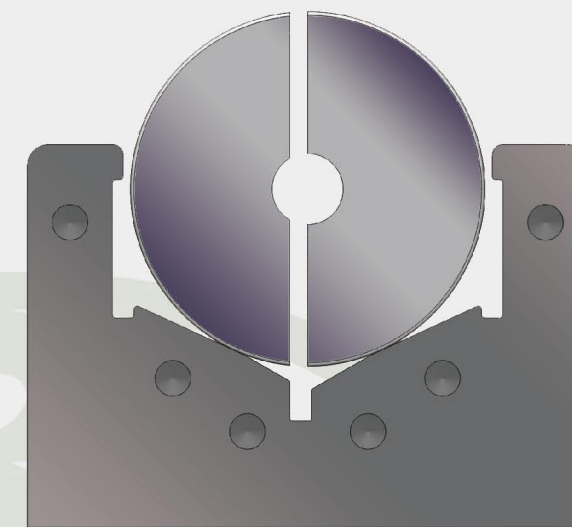
- ✓ 安全
Safety
- ✓ 易操作
Easy to operate
- ✓ 可作難切削材剖開
Can be used for cutting hard material
- ✓ 可自動對正中心
Set up center can automatically

一刀剖開 One cut sectioning

剖開範例 examples	工件尺寸 Work piece size	
外徑 Outer diameter	23	20
材質 Material	S45C SUS303	



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BAOJE has the right to change the design without further notice



▲ 專利設計：大小剖開件自動對中

Patent design: Workpiece of different sizes are automatically center

