

Characteristic for each
SRB Tooling Model | SRB Tooling Model 数控深孔刮削滚光 镗头



Division 区分	ECOROLL TOOL					SIERRA TOOL	SANDVIK TOOL	Remarks 备注
	RDO	RIOA	RIOF	RIOK	SK/GZ			
Tooling Application 刀具适用范围	Skiving Burnishing 刮削滚光	C/Boring Burnishing 初加工刮削滚光	Skiving Burnishing 刮削滚光	Skiving Burnishing 刮削滚光	Skiving Burnishing 刮削滚光	C/Boring Skiving Burnishing 初加工刮削滚光	Skiving Burnishing 刮削滚光	
Stock removal 刀具调整范围	Max. ϕ 3mm F/P0.2: 0.6~2.0 F/P0.4: 1.2~2.4 F/P0.6: 1.6~3.0	Max. ϕ 16mm ~ ϕ 139: ~12mm ~ ϕ 360: ~16mm	Max. ϕ 3mm F/P0.2: 0.6~2.0 F/P0.4: 1.2~2.4 F/P0.6: 1.6~3.0	Max. ϕ 3mm F/P0.2: 0.6~2.0 F/P0.4: 1.2~2.4 F/P0.6: 1.6~3.0	Max. ϕ 3mm F/P0.2: 0.6~2.0 F/P0.4: 1.2~2.4 F/P0.6: 1.6~3.0	Max. ϕ 6mm	Max. ϕ 2.5mm	*Work thickness 工件厚度 ϕ 185 below(以下) Max. 5% ϕ 185 above(以上) Max. 10% *Straightness 加工进直度 : 1mm/m
Material Application 材料适用范围	Cold drawn tubes 冷拔管	Hot rolled tubes 热轧管	Cold drawn tubes 冷拔管	Cold drawn tubes 冷拔管	Cold drawn tubes 冷拔管	Cold drawn & Hot rolled tubes 冷拔管 热轧管	Cold drawn tubes 冷拔管	
Tool Head coupling 刀头连接方式	Floating 浮键	Fix 固定	Fix 固定	Floating 浮键	Floating 浮键	Fix 固定	Floating 浮键	
Pressure activation 油压力传送 方式	Retrac Cylinder 回装缸	Quick Coupler 快装接头	Quick Coupler 快装接头	Quick Coupler 快装接头	Quick Coupler 快装接头	Quick Coupler 快装接头	Quick Coupler 快装接头	
Tool activation Cycle 刀具加工作用 方式	Hydraulic 液压 40~60bar	Hydraulic 液压 80~100bar	Hydraulic 液压 80~100ba	Hydraulic 液压 80~100ba	Hydraulic 液压 80~100ba	Hydraulic (液压) A control that is linearly dependent (正压力比例控制装置) 30~100bar	Pneumatic 气压 4~7bar	
	During cutting operation 刮削滚光同时 进行	During cutting operation 刮削滚光同时 进行	During cutting operation 刮削滚光同时 进行	During cutting operation 刮削滚光同时 进行	During cutting operation 刮削滚光同时 进行	During cutting operation 刮削滚光同时 进行	During the return 进刮削退滚光	
Cutting Range 切削范围	ϕ 60~405mm x ~12m	ϕ 90~365mm x ~3.6m	ϕ 60~405mm x ~3.6m	ϕ 60~405mm x ~12m	ϕ 38~600mm x ~14m	ϕ 50~250mm x ~3m	ϕ 50~305mm x ~12m	Recommended amount for Tool Maker 推荐刀具品牌 (TACCHI 14m possible) (TACCHI 14m可能)
Adjusting Range 调节范围	-0.05/+0.3mm	-0.05/+0.3mm	-0.05/+0.3mm	-0.05/+0.3mm	-0.05/+0.3mm	-0.05/+0.3mm	-0.05/+0.3mm	
Tool Speed 刀具速度	~350m/min	180m/min	350m/min	350m/min	350m/min	350m/min	350m/min	80%Application Within 80%以内适用
Feed 进给	~ 2.5mm/rev	1.2~1.6mm/rev	~ 2.5mm/rev	~ 2.5mm/rev	~ 2.5mm/rev	~ 2.5mm/rev	~ 2.5mm/rev	80%Application Within 80%以内适用
Main spindle drive power(Kw) 主轴驱动功率	2Knife: 26~55 3Knife: 35~55 6Knife: 55~75	55~100	2Knife: 26~55 3Knife: 40~50 6Knife: 55~75	2Knife: 26~55 3Knife: 40~50 6Knife: 55~75	2Knife: 26~55 3Knife: 40~50 6Knife: 55~75	2Knife: 26~55 3Knife: 35~55 4Knife: 45~75	2Knife: 26~55 3Knife: 40~50	Fanuc, Mitsubishi, and Siemens can be used for. 适用于Fanuc, Mitsubishi, Siemens
Coolant 冷却液	Emulsion 水溶液 : 4 x nominal Diameter (l/min), Deep Boring Oil 切削油 : 2 x nominal Diameter (l/min)							

** To keep the hydraulic pressure of SIERRA Tool extensible, static pressure control is necessary.



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RESEARCH & DEVELOPMENT



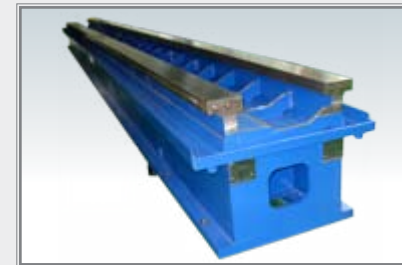
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PRODUCTS | You dream it, We make it!

Bed



2 types can be manufactured upon ordering; One is of high-strength and low-vibration structure by meehanite casting (FC30). The other one is of steel structure.

床身使用高刚性、低振动结构的米汉纳铸铁(FC30)制造, 根据结构和刚性进行定做。

Coolant Head



A system structure that has anti-shock, anti-friction, and anti-abrasion for Tool Bar's rotational and translational motion.

A structure that is optimized for a good fluid flow and chip emission

系统结构是耐磨损型、通过刀杆的旋转运动和直线运动, 确保耐冲击性、耐摩擦性。

通过切削液流动, 实现最佳的排屑效果。

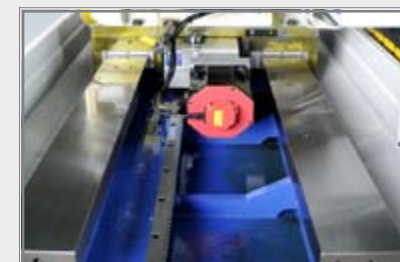
Spindle Head



High-rigidity, high-torque structure which is 130mm,150mm in diameter with Front Bearing

在前轴承上装有 φ130, φ150的强力高刚性扭矩构造

Spindle Feeding



The minimization of likely bucking load in contrast with the structure of Ball Screw

滚珠丝杠结构对比发生弯曲下重最小化

Tool Bar Rest & Spindle



- Tool Bar Rest
Minimization of buckling load of tool
刀具偏差最小化

- Spindle
The structure of spindle supporting tool bar safely
充分考虑支撑刀杆的主轴结构

Tool Bar



High rigidity and high straightness with HRC of 52 or more.

HRC52以上的高硬度和高直线性

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Work Head-clamp



The subsidiary clamp for workpiece of 4m or more in length

4m以上工件的补助抓紧

Coolant System



1Step - Dirty Tank & Chip Conveyor
2Step- Magnetic Separator
3Step- Filtering & Clean Tank

切屑液输送装置及排屑器
磁性分离器
自动过滤器及切屑液箱

Work Rest



While workpieces loaded, a work-piece supporter easily mounted on the center of a machine

装载工件时期到支撑作用的装置、装卸非常方便。

SRB Tool (SANDVIK)



Skiving forward and roller burnishing backward

前部进行刮削工序、后部进行滚光工序。

Controller



Fanuc, Mitsubishi, and Siemens can be used for.

可适用于Fanuc、Mitsubishi、Siemens

SRB Tool (ECOROLL)



Skiving & roller burnishing both forward

刮削工作部及滚光工作部都在前面。

Characteristic for each SRB Tooling Model | SRB Tooling Model 数控深孔刮削滚光 镗头

HTC SRB-Series | You dream it, We make it!

ECOROLL Skive-Burnishing Tools 依克诺刮削 - 滚光镗头

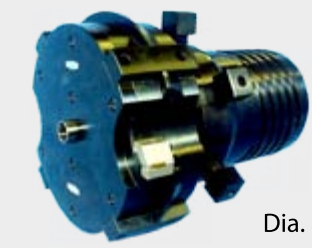
Combined 一体
Skiving + Roller Burnishing = RDO, RIOF, RIOK Type
Counterboring, Skiving + RB = RIOA Type



Separately 分开
Skiving Tools SK
Dia. < 38



Roller Burnishing Tools GZ



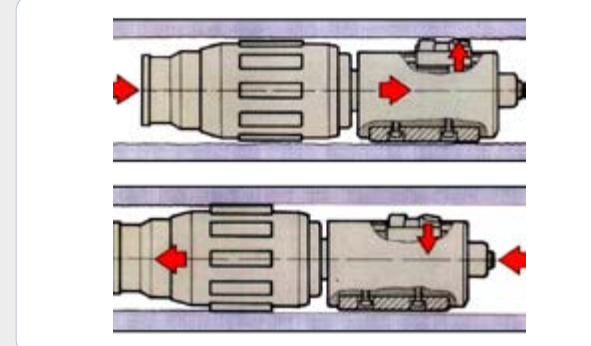
Dia. > 400

SANDVIK Skive-Burnishing Tools 山特维克刮削 - 滚光镗头



To extend Tool, Air is used. 压力控制刀片进出

Skiving on the forward stroke 刀具前进时进行刮削工序



Roller burnishing on the return stroke 刀具退出时进行滚光工序

SIERRA Skive-Burnishing Tools SIERRA刮削 - 滚光镗头



Keep Hydraulic pressure of Tool extensible.
- A control that is linearly dependent with static pressure is required. (Additional cost of USD8,500, compared to products from other companies)
可扩展液压工具
-需要正压力比例控制装置(价格比其它刀具高USD8,500)

Applied for material for cold drawing and hot rolling
适用于冷拔管和热轧管

Only applied for one with cutting amount less than φ6
最大刮削量 < φ6

Maximum processing Capa is φ250mm X 3m.
最大加工范围 φ250mm X 3m

Skiving Head is of Fixing Type.
刮削头是固定式

CNC Skiving & Roller Burnishing Machine

Machine Specification

Description		SRB 20 Series	SRB 30 Series	SRB 45 Series
Work Size	In diameter	mm	Ø 50~Ø200	Ø 50~Ø300
	Out diameter	mm	~Ø250	~Ø356
	Max. Length (8Type)	mm	1,500 / 2,000 / 3,000 / 4,000 / 6,000 / 9,000 / 10,000 / 12,000	~ Ø570
Capacity	Skiving & Roller Burnishing	mm	Ø 50~Ø200	Ø 50~Ø300
Travel	Z-axis stroke	mm	Work Max.Length +1,000	
	Rapid	mm/min	6,000 ~ 8,000	
Speed	Feeding	mm/min	0~3,000	
	Spindle speed	rpm	Low 50~450	
		rpm	High 200~1,370	
Motor	Tool rotating	Kw	22/26~37/45	45/55/75
	High pressure pump	l /min	500	720
	Low pressure pump	l /min	600	1,000
Coolant System	Tank capacity(Clean Tank)	l	4,000	5,000
	Tank capacity(Dirty Tank)	l	1,350	
	Filtering	µm	50 (Dual Mesh Filter)	
CNC System	Controller	Fanuc, Mitsubishi, Siemens		
	Main power source	AC220/380V/440±10% 3Φ50Hz(60Hz)		
Total Power	KVA	150	120/150	270

Tooling Selection Part

① Tool & wear parts
② Tool bar
③ Spindle adapter

④ Tool adapter
⑤ Tool rest spindle
⑥ Stuffing housing

⑦ Work con head

