



产品综合样本

GENERAL CATALOGUE

• 整硬旋转刀具

Solid Carbide Tools

• 可转位刀具

Indexable Tools

• 智能刀具柜

Intelligent Tool Cabinet

金属切削刀具整体解决方案服务商

Metal Cutting Tools Overall Solution Provider



COMPANY INTRODUCTION

企业简介

阿诺成立于 2002 年 1 月，由德国工学博士柯亚仕创立，总部位于中新合作的苏州工业园区。阿诺作为金属切削刀具整体解决方案服务商，提供高品质精密金属切削刀具的设计研发、制造、修磨和技术支持等一条龙服务，具体产品有硬质合金钻头、可转位刀片、立铣刀、PCD 刀具、微小径刀具、医疗刀具、刀具涂层、刀具修磨、刀具管理、提供项目加工的整体解决方案。

公司通过了由德国 TUVSUD 认证的 ISO9001 质量认证体系和 ISO13485 质量认证体系，常设江苏省工程研究中心，“中国刀协副理事长单位”，国家级专精特新“小巨人”。

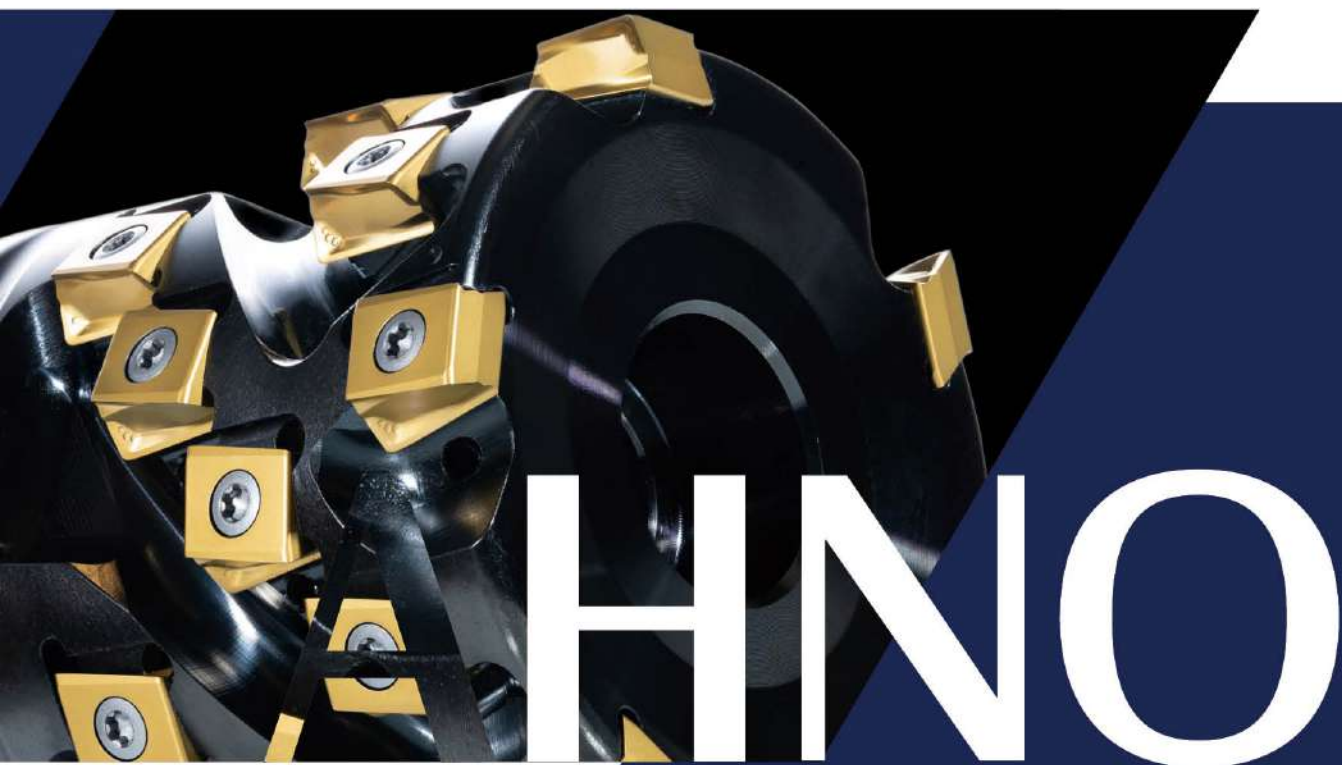
2024 年 7 月，阿诺正式加入山特维克集团。

Ahno was founded in January 2002 by Dr. Ke Yashi and is headquartered in Suzhou Industrial Park, a Sino-Singapore cooperation area. Ahno, as an overall solution service provider of metal cutting tools, provides one-stop service in the design, development, manufacturing, regrinding and technical support of high-quality precision metal cutting tools. The specific products are solid carbide drills, indexable tools, end mills, PCD tools, micro tools, medical tools, coating, regrinding, tool management, and overall solutions for projects.

The company has ISO9001 quality certification system and ISO13485 quality certification system certified by TUVSUD of Germany, and is an Engineering Research Center of Jiangsu Province, Vice director unit of CMCTEA, and National Specialty Super New Giant.

In July 2024, Ahno officially joined the Sandvik Group.





全国布局 National layout

6⁺
家

全国工厂

17⁺
家

全国修磨、涂层
服务中心

★ 总部

▲ 工厂 X 6

● 修磨中心 X 12

■ 涂层中心 X 5



CONTENTS

A

标准品钻头 SP Series Standard Drills

P11~P98

硬质合金麻花钻 Carbide Twist Drills	P13
深孔钻 Deep Hole Drills	P89
SP-X 标准品推荐切削条件 Recommended Cutting Parameters for SP-X Standard Products	P97

B

可换式钻头 Exchangeable Drills

P99~P121

穿山甲钻头 (EP197-P/M) Pangolin Drill	P102
穿山甲钻头 (EP065-P/M/K/N/S) Pangolin Drill	P105
穿山甲钻头 (EP100-P) Pangolin Drill	P108
穿山甲钻杆 (EP-G88103) Pangolin Drill Body	P110
穿山甲钻杆 (EP-G88105) Pangolin Drill Body	P111
穿山甲钻杆 (EP-G88107) Pangolin Drill Body	P112
穿山甲钻杆 (EP-G88108) Pangolin Drill Body	P113
穿山甲钻杆 (EP-G88110) Pangolin Drill Body	P114
穿山甲钻杆 (EP-G88112) Pangolin Drill Body	P115
钻头安装步骤 Mounting Instruction	P116
穿山甲钻杆 (备件 / 附件) Pangolin Drill Body(Spare Parts/ Accessories)	P117
技术信息 Technical Information	P118



飓风系列铣刀 (AHS 系列) Hurricane Series End Mills (AHS Series)

P122~P167

AHSEF 4 刃平头铣刀 AHSEF 4-flute End Mills	P126
AHSE 4 刃平头铣刀 AHSE 4-flute End Mills	P128
AHSE 6 刃平头铣刀 AHSE 6-flute End Mills	P130
AHSRF 4 刃圆鼻铣刀 AHSRF 4-flute End Mills with Corner Radius	P131
AHSR 4 刃圆鼻铣刀 AHSR 4-flute End Mills with Corner Radius	P134
AHSRP 4 刃短刃圆鼻铣刀 AHSRP 4-flute Short-flute End Mills with Corner Radius	P136
AHSR 6 刃圆鼻铣刀 AHSR 6-flute End Mills with Corner Radius	P138
AHSB 2 刃球头铣刀 AHSB 2-flute Ballnose End Mills	P139
AHSRK 4 刃强力型圆鼻铣刀 AHSRK 4-flute High-feed End Mills with Corner Radius	P141
AHSEL 4 刃长颈平头铣刀 AHSEL 4-flute End Mills with Neck Increased	P142
AHSRL 4 刃长颈圆鼻铣刀 AHSRL 4-flute End Mills with Neck Increased & Corner Radius	P143
AHSEL 2 刃长颈平头铣刀 AHSEL 2-flute End Mills with Neck Increased	P146
AHSRL 2 刃长颈圆鼻铣刀 AHSRL 2-flute End Mills with Neck Increased & Corner Radius	P148
AHSBL 2 刃长颈球头铣刀 AHSBL 2-flute Ballnose End Mills with Neck Increased	P153
切削参数 Cutting Parameters	P157



飓风系列铣刀 (AHM 系列)
Hurricane Series End Mills (AHM Series)

P168~P213

AHMEF 4 刃平头铣刀 AHMEF 4-flute End Mills	P169
AHME 6 刃平头铣刀 AHME 6-flute End Mills	P171
AHMR 4 刃圆鼻铣刀 AHMR 4-flute End Mills with Corner Radius	P172
AHMRF 4 刃圆鼻铣刀 AHMRF 4-flute End Mills with Corner Radius	P174
AHMRP 4 刃短刃圆鼻铣刀 AHMRP 4-flute Short-flute End Mills with Corner Radius	P177
AHMR 6 刃圆鼻铣刀 AHMR 6-flute End Mills with Corner Radius	P179
AHMRK 4 刃强力型圆鼻铣刀 AHMRK 4-flute High-feed End Mills with Corner Radius	P180
AHMB 2 刃球头铣刀 AHMB 2-flute Ballnose End Mills	P181
AHME 2 刃平头铣刀 AHME 2-flute End Mills	P183
AHMR 2 刃圆鼻铣刀 AHMR 2-flute End Mills with Corner Radius	P185
AHMEL 4 刃长颈平头铣刀 AHMEL 4-flute End Mills with Neck Increased	P187
AHMRL 4 刃长颈圆鼻铣刀 AHMRL 4-flute End Mills with Neck Increased & Corner Radius	P188
AHMEL 2 刃长颈平头铣刀 AHMEL 2-flute End Mills with Neck Increased	P191
AHMRL 2 刃长颈圆鼻铣刀 AHMRL 2-flute End Mills with Neck Increased & Corner Radius	P193
AHMBL 2 刃长颈球头铣刀 AHMBL 2-flute Ballnose End Mills with Neck Increased	P198
切削参数 Cutting Parameters	P202

D

钛合金与不锈钢专用铣刀 End Mills for Titanium and Stainless Steel

P214~P226

ACSEC 4 刃平头铣刀 (含 C 角) ACSEC 4-Flute End Mill(with Chamfer)	P218
ACSEC 5 刃平头铣刀 (含 C 角) ACSEC 5-Flute End Mill(with Chamfer)	P219
ACSR 4 刃圆鼻铣刀 ACSR 4-Flute Corner Radius End Mill	P220
ACSR 5 刃圆鼻铣刀 ACSR 5-Flute Corner Radius End Mill	P222
推荐切削参数 Recommended Cutting Parameter	P224

E

钢件铸铁铣刀、铝用铣刀 End Mills for Steel, Cast Iron and Aluminum

P227~P237

通用 4 刃平头铣刀 Universal 4-flute End Mills	P228
通用 4 刃圆鼻铣刀 Universal 4-flute End Mills	P229
通用 2 刃球头铣刀 Universal 2-flute Ball-nose End Mills	P230
铝用 3 刃平头铣刀 Aluminum 3-flute End Mills	P231
铝用 3 刃圆鼻铣刀 Aluminum 3-flute with Corner Radius	P232
铝用 2 刃球头铣刀 Aluminum 2-flute Ball-nose End Mills	P233
推荐切削参数 Recommended cutting parameter	P234

线边刀具管理 Tool management	P240
工装量具管理 Tool management	P244
刀具室管理 Tool room management	P246
仓库管理 Warehouse management	P248
客户案例 Customer cases	P264



车削系列

符号说明 - ISO 车削刀片	P274
车削材质一览	P278
车削槽型一览	P281
ISO 车削刀片 - 负型	P284
ISO 车削刀片 - 正型	P299

小零件加工系列

小零件加工 - 刀片材质一览	P305
小零件加工 - 刀片槽型一览	P306
小零件加工 - 刀杆	P308
小零件加工 - 刀片	P328

铣削系列

符号说明 - 铣削刀片	P364
铣削刀体命名	P368
铣削材质一览	P370
铣刀目录	P374
面铣刀	P376
方肩铣刀	P384
快进给铣刀	P398
倒角铣刀	P402
切削参数 - 切深和进给	P406
切削参数 - 线速度	P414

技术信息

刀片失效形式与分析	P418
计算公式	P419
铣削应用信息	P423
铣刀附件	P426
粗糙度信息	P427
材料硬度信息	P428



车削系列

Turning Series

符号说明 - ISO 车削刀片 Name Code System-ISO Turning Insert	P432
阿诺 - Loong 龍系列 - 车削材质一览 AHNO Loong Series-Turning Materials Overview	P436
阿诺 - Loong 龍系列 - 车削槽型一览 AHNO Loong Series-Turning Chipbreaker Overview	P438
阿诺 - Loong 龍系列 - ISO 车削刀片 - 负型 AHNO Loong Series-ISO Indexable Inserts-Negative	P442
阿诺 - Loong 龍系列 - ISO 车削刀片 - 正型 AHNO Loong Series-ISO Indexable Inserts-Positive	P453

铣削系列

Milling Series

符号说明 - 铣削刀片 Name Code System-Milling Inserts	P464
铣削刀体命名 Milling Body Names	P468
阿诺 - Loong 龍系列 - 铣削材质一览 AHNO Loong Series-Milling Materials Overview	P470
阿诺 - Loong 龍系列 - 铣刀目录 AHNO Loong Series-Milling Catalog	P472
阿诺 - Loong 龍系列 - 面铣刀 AHNO Loong Series-Face Millings	P474
阿诺 - Loong 龍系列 - 方肩铣刀 AHNO Loong Series-Square Millings	P480
阿诺 - Loong 龍系列 - 仿形铣刀 AHNO Loong Series-Profiling Millings	P492
阿诺 - Loong 龍系列 - 切削参数 AHNO Loong Series-Cutting Parameter	P500

技术信息

Technical Information

刀片失效形式与分析 Insert Failure Forms and Analysis	P508
计算公式 Calculation Formula	P509
铣削应用信息 Milling Application Information	P513
阿诺 - Loong 龍系列 - 铣刀附件 AHNO Loong Series-Milling Attachment	P518
材料硬度信息 Material Hardness Information	P520

STANDARD DRILLS

标准品钻头 >>>



整体硬质合金钻头型号识别

Solid Carbide Drills Naming System

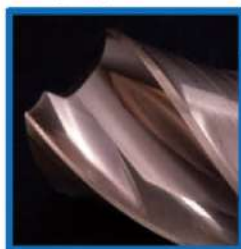
SP	—	X	8	0	1	03	0350
↓	↓	↓	↓	↓	↓	↓	↓
① 系列名称 Series name	② 被加工材料 Workpiece material	③ 钻头螺旋形式 Drill flute form	④ 钻头结构 Drill structure	⑤ 冷却方式 Coolant	⑥ 钻深比 Drill depth	⑦ 刃径 Diameter of cutting edge	
PF 高性能 High performance	P 钢件/铸铁 Steel/Cast iron	8 麻花钻 Carbide twist drill	0 普通 Normal drill	0 外冷 External coolant	03 3倍径 3 times	0350 3.5mm	
SP 钻神 Super drill	S 不锈钢 Stainless steel	7 直槽钻 Straight flute drill	1 同柄同径 dc=ds	1 内冷 Internal coolant	05 5倍径 5 times	1050 10.5mm	
	N 有色金属 Non-ferrous metals		2 三尖 Tritan-Drill		08 8倍径 8 times		
	X 通用(除有色金属) General (except for non-ferrous metals)		3 阶梯钻 Step drill		12 12倍径 12 times		

高效通用钻头 SP-X 系列

High-efficiency General-purpose Drill SP-X

① 超大排屑空间

Big chip evacuation space



② 双棱边设计

Design of double edge



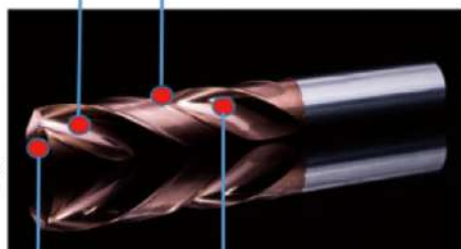
③ X 刃型设计

X-shape cutting edge



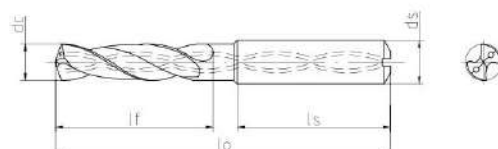
④ 排屑槽抛光

Polished chip evacuation flute



硬质合金麻花钻 (SP-X80103)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

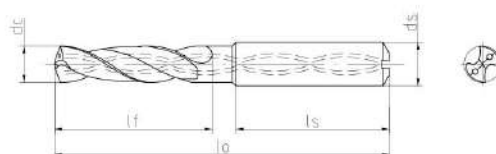
16.5105 订货编号 - Order code

Φ·d _c 公差 m7	槽长 l _f	柄径 d _s 公差 h6	柄长 l _s	总长 l _o	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	20	4	36	62	0300		
3.1	20	4	36	62	0310		
3.2	20	4	36	62	0320		
3.3	20	4	36	62	0330	M4x0.7	
3.4	20	4	36	62	0340	NO.8-32UNC	
3.5	20	4	36	62	0350	M4x0.5 NO.8-36UNF	
3.6	20	4	36	62	0360		
3.7	20	4	36	62	0370		M4x0.7
3.8	24	4	36	66	0380		M4x0.5
3.9	24	4	36	66	0390	NO.10-24UNC	
4.0	24	4	36	66	0400		
4.1	24	6	36	66	0410	NO.10-32UNF	
4.2	24	6	36	66	0420	M5x0.8	
4.3	24	6	36	66	0430		
4.4	24	6	36	66	0440		
4.5	24	6	36	66	0450	M5x0.5 NO.12-24UNC	
4.6	24	6	36	66	0460	NO.12-28UNF	M5x0.8
4.7	24	6	36	66	0470	NO.12-32UNEF	
4.8	28	6	36	66	0480		
4.9	28	6	36	66	0490		
5.0	28	6	36	66	0500	M6x1	
5.1	28	6	36	66	0510	1/4-20UNC	
5.2	28	6	36	66	0520		
5.3	28	6	36	66	0530	M6x0.75	
5.4	28	6	36	66	0540		
5.5	28	6	36	66	0550	1/4-28UNF	M6x1
5.6	28	6	36	66	0560	1/4-32UNEF	
5.7	28	6	36	66	0570		
5.8	28	6	36	66	0580		
5.9	28	6	36	66	0590		

A

硬质合金麻花钻 (SP-X80103)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

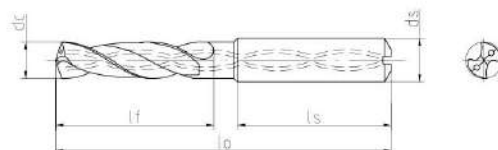
P M K S

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	28	6	36	66	0600		
6.1	34	8	36	79	0610		
6.2	34	8	36	79	0620		
6.3	34	8	36	79	0630		
6.4	34	8	36	79	0640		
6.5	34	8	36	79	0650		
6.6	34	8	36	79	0660	5/16-18UNC	
6.7	34	8	36	79	0670		
6.8	34	8	36	79	0680	M8x1.25	
6.9	34	8	36	79	0690	5/16-24UNF	
7.0	34	8	36	79	0700	M8x1	
7.1	41	8	36	79	0710	5/16-32UNEF	
7.2	41	8	36	79	0720		
7.3	41	8	36	79	0730	M8x0.75	
7.4	41	8	36	79	0740		M8x1.25
7.5	41	8	36	79	0750		
7.6	41	8	36	79	0760		
7.7	41	8	36	79	0770		
7.8	41	8	36	79	0780		
7.9	41	8	36	79	0790		
8.0	41	8	36	79	0800	3/8-16UNC	
8.1	47	10	40	89	0810		
8.2	47	10	40	89	0820		
8.3	47	10	40	89	0830		
8.4	47	10	40	89	0840		
8.5	47	10	40	89	0850	M10x1.5 3/8-24UNF	
8.6	47	10	40	89	0860		
8.7	47	10	40	89	0870	3/8-32UNEF	
8.8	47	10	40	89	0880	M10x1.25	
8.9	47	10	40	89	0890		

硬质合金麻花钻 (SP-X80103)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	47	10	40	89	0900	M10x1	
9.1	47	10	40	89	0910		
9.2	47	10	40	89	0920		
9.3	47	10	40	89	0930	M10x0.75	M10x1.5
9.4	47	10	40	89	0940	7/16-14UNC	
9.5	47	10	40	89	0950		
9.6	47	10	40	89	0960		
9.7	47	10	40	89	0970		
9.8	47	10	40	89	0980		
9.9	47	10	40	89	0990	7/16-20UNF	
10.0	47	10	40	89	1000		
10.1	55	12	45	102	1010		
10.2	55	12	45	102	1020	7/16-28UNEF	
10.3	55	12	45	102	1030	M12x1.75	
10.4	55	12	45	102	1040		
10.5	55	12	45	102	1050		
10.6	55	12	45	102	1060		
10.7	55	12	45	102	1070		
10.8	55	12	45	102	1080		
10.9	55	12	45	102	1090	1/2-13UNC	
11.0	55	12	45	102	1100	M12x1	
11.1	55	12	45	102	1110		
11.2	55	12	45	102	1120		M12x1.75
11.3	55	12	45	102	1130		
11.4	55	12	45	102	1140		
11.5	55	12	45	102	1150	1/2-20UNF	
11.6	55	12	45	102	1160		
11.7	55	12	45	102	1170		
11.8	55	12	45	102	1180	1/2-28UNEF	
11.9	55	12	45	102	1190		

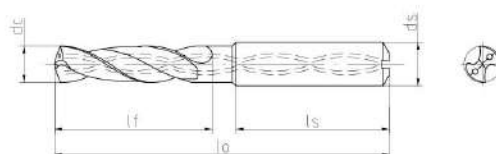
A

硬质合金麻花钻 (SP-X80103)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

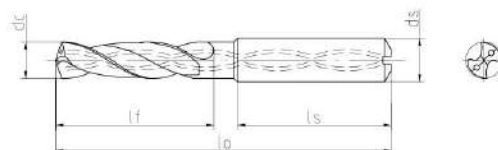
H

订货编号 Order code

Φ·dc 公差 m7	槽长 l _f	柄径 d _s 公差 h6	柄长 l _s	总长 l _o	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	55	12	45	102	1200	M14x2	
12.1	60	14	45	107	1210		
12.2	60	14	45	107	1220	9/16-12UNC	
12.3	60	14	45	107	1230		
12.4	60	14	45	107	1240		
12.5	60	14	45	107	1250	M14x1.5	
12.6	60	14	45	107	1260		
12.7	60	14	45	107	1270		
12.8	60	14	45	107	1280		
12.9	60	14	45	107	1290	9/16-18UNF	
13.0	60	14	45	107	1300	M14x1	M14x2
13.1	60	14	45	107	1310		
13.2	60	14	45	107	1320	9/16-24UNEF	
13.3	60	14	45	107	1330		
13.4	60	14	45	107	1340		
13.5	60	14	45	107	1350		
13.6	60	14	45	107	1360	5/8-11UNC	
13.7	60	14	45	107	1370		
13.8	60	14	45	107	1380		
13.9	60	14	45	107	1390		
14.0	60	14	45	107	1400	M16x2	
14.1	65	16	48	115	1410		
14.2	65	16	48	115	1420		
14.3	65	16	48	115	1430		
14.4	65	16	48	115	1440		
14.5	65	16	48	115	1450	M16x1.5 5/8-18UNF	
14.6	65	16	48	115	1460		
14.7	65	16	48	115	1470		
14.8	65	16	48	115	1480	5/8-24UNEF	
14.9	65	16	48	115	1490		

硬质合金麻花钻 (SP-X80103)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	65	16	48	115	1500	M16x1	M16x2
15.1	65	16	48	115	1510		
15.2	65	16	48	115	1520		
15.3	65	16	48	115	1530		
15.4	65	16	48	115	1540		
15.5	65	16	48	115	1550	M18x2.5	
15.6	65	16	48	115	1560		
15.7	65	16	48	115	1570		
15.8	65	16	48	115	1580		
15.9	65	16	48	115	1590		
16.0	65	16	48	115	1600	M18x2	
16.1	73	18	48	123	1610		
16.2	73	18	48	123	1620		
16.3	73	18	48	123	1630		
16.4	73	18	48	123	1640		
16.5	73	18	48	123	1650		
16.6	73	18	48	123	1660	3/4-10UNC	
16.7	73	18	48	123	1670		
16.8	73	18	48	123	1680		
16.9	73	18	48	123	1690		
17.0	73	18	48	123	1700	M18x1	
17.1	73	18	48	123	1710		
17.2	73	18	48	123	1720		
17.3	73	18	48	123	1730		
17.4	73	18	48	123	1740		
17.5	73	18	48	123	1750	M20x2.5 3/4-16UNF	
17.6	73	18	48	123	1760		
17.7	73	18	48	123	1770		
17.8	73	18	48	123	1780	3/4-20UNEF	
17.9	73	18	48	123	1790		

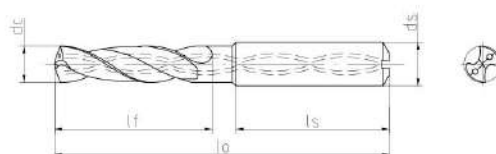
A

硬质合金麻花钻 (SP-X80103)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

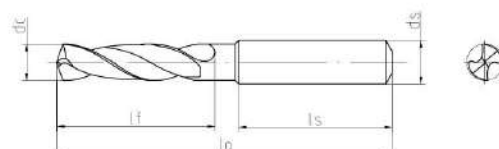
H

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	73	18	48	123	1800	M20x2	
18.1	79	20	50	131	1810		
18.2	79	20	50	131	1820		
18.3	79	20	50	131	1830		
18.4	79	20	50	131	1840		
18.5	79	20	50	131	1850	M20x1.5	
18.6	79	20	50	131	1860		
18.7	79	20	50	131	1870		
18.8	79	20	50	131	1880		
18.9	79	20	50	131	1890		
19.0	79	20	50	131	1900	M20x1	
19.1	79	20	50	131	1910		
19.2	79	20	50	131	1920		
19.3	79	20	50	131	1930		
19.4	79	20	50	131	1940		
19.5	79	20	50	131	1950		
19.6	79	20	50	131	1960	7/8-9UNC	
19.7	79	20	50	131	1970		
19.8	79	20	50	131	1980		
19.9	79	20	50	131	1990		
20.0	79	20	50	131	2000	M22x2	

硬质合金麻花钻 (SP-X80003)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	20	6	36	62	0300		
3.1	20	6	36	62	0310		
3.2	20	6	36	62	0320		
3.3	20	6	36	62	0330	M4x0.7	
3.4	20	6	36	62	0340	NO.8-32UNC	
3.5	20	6	36	62	0350	M4x0.5 NO.8-36UNF	
3.6	20	6	36	62	0360		
3.7	20	6	36	62	0370		M4x0.7
3.8	24	6	36	66	0380		M4x0.5
3.9	24	6	36	66	0390	NO.10-24UNC	
4.0	24	6	36	66	0400		
4.1	24	6	36	66	0410	NO.10-32UNC	
4.2	24	6	36	66	0420	M5x0.8	
4.3	24	6	36	66	0430		
4.4	24	6	36	66	0440		
4.5	24	6	36	66	0450	M5x0.5 NO.12-24UNC	
4.6	24	6	36	66	0460	NO.12-28UNF	M5x0.8
4.7	24	6	36	66	0470	NO.12-32UNEF	
4.8	28	6	36	66	0480		
4.9	28	6	36	66	0490		
5.0	28	6	36	66	0500	M6x1	
5.1	28	6	36	66	0510	1/4-20UNC	
5.2	28	6	36	66	0520		
5.3	28	6	36	66	0530	M6x0.75	
5.4	28	6	36	66	0540		
5.5	28	6	36	66	0550	1/4-28UNF	M6x1
5.6	28	6	36	66	0560	1/4-32UNEF	
5.7	28	6	36	66	0570		
5.8	28	6	36	66	0580		
5.9	28	6	36	66	0590		

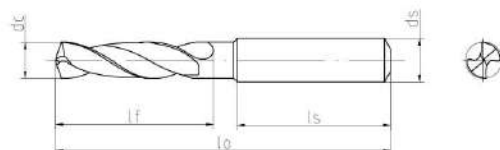
A

硬质合金麻花钻 (SP-X80003)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

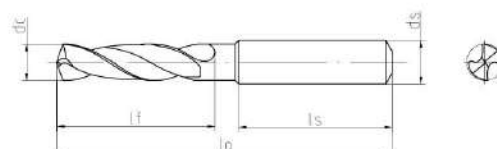
H

订货编号·Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	28	6	36	66	0600		
6.1	34	8	36	79	0610		
6.2	34	8	36	79	0620		
6.3	34	8	36	79	0630		
6.4	34	8	36	79	0640		
6.5	34	8	36	79	0650		
6.6	34	8	36	79	0660	5/16-18UNC	
6.7	34	8	36	79	0670		
6.8	34	8	36	79	0680	M8x1.25	
6.9	34	8	36	79	0690	5/16-24UNF	
7.0	34	8	36	79	0700	M8x1	
7.1	41	8	36	79	0710	5/16-32UNEF	
7.2	41	8	36	79	0720		
7.3	41	8	36	79	0730	M8x0.75	
7.4	41	8	36	79	0740		M8x1.25
7.5	41	8	36	79	0750		
7.6	41	8	36	79	0760		
7.7	41	8	36	79	0770		
7.8	41	8	36	79	0780		
7.9	41	8	36	79	0790		
8.0	41	8	36	79	0800	3/8-16UNC	
8.1	47	10	40	89	0810		
8.2	47	10	40	89	0820		
8.3	47	10	40	89	0830		
8.4	47	10	40	89	0840		
8.5	47	10	40	89	0850	M10x1.5 3/8-24UNF	
8.6	47	10	40	89	0860		
8.7	47	10	40	89	0870	3/8-32UNEF	
8.8	47	10	40	89	0880	M10x1.25	
8.9	47	10	40	89	0890		

硬质合金麻花钻 (SP-X80003)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	47	10	40	89	0900	M10x1	
9.1	47	10	40	89	0910		
9.2	47	10	40	89	0920		
9.3	47	10	40	89	0930	M10x0.75	M10x1.5
9.4	47	10	40	89	0940	7/16-14UNC	
9.5	47	10	40	89	0950		
9.6	47	10	40	89	0960		
9.7	47	10	40	89	0970		
9.8	47	10	40	89	0980		
9.9	47	10	40	89	0990	7/16-20UNF	
10.0	47	10	40	89	1000		
10.1	55	12	45	102	1010		
10.2	55	12	45	102	1020	7/16-28UNEF	
10.3	55	12	45	102	1030	M12x1.75	
10.4	55	12	45	102	1040		
10.5	55	12	45	102	1050		
10.6	55	12	45	02	1060		
10.7	55	12	45	02	1070		
10.8	55	12	45	102	1080		
10.9	55	12	45	102	1090	1/2-13UNC	
11.0	55	12	45	102	1100	M12x1	
11.1	55	12	45	102	1110		
11.2	55	12	45	102	1120		M12x1.75
11.3	55	12	45	102	1130		
11.4	55	12	45	102	1140		
11.5	55	12	45	102	1150	1/2-20UNF	
11.6	55	12	45	102	1160		
11.7	55	12	45	102	1170		
11.8	55	12	45	02	1180	1/2-28UNEF	
11.9	55	12	45	102	1190		

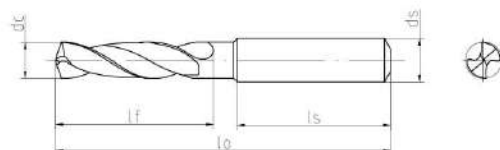
A

硬质合金麻花钻 (SP-X80003)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

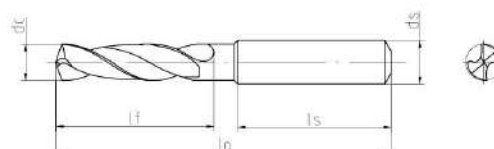
H

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	55	12	45	102	1200	M14x2	
12.1	60	14	45	107	1210		
12.2	60	14	45	107	1220	9/16-12UNC	
12.3	60	14	45	107	1230		
12.4	60	14	45	107	1240		
12.5	60	14	45	107	1250	M14x1.5	
12.6	60	14	45	107	1260		
12.7	60	14	45	107	1270		
12.8	60	14	45	107	1280		
12.9	60	14	45	107	1290	9/16-18UNF	
13.0	60	14	45	107	1300	M14x1	M14x2
13.1	60	14	45	107	1310		
13.2	60	14	45	107	1320	9/16-24UNEF	
13.3	60	14	45	107	1330		
13.4	60	14	45	107	1340		
13.5	60	14	45	107	1350		
13.6	60	14	45	107	1360	5/8-11UNC	
13.7	60	14	45	107	1370		
13.8	60	14	45	107	1380		
13.9	60	14	45	107	1390		
14.0	60	14	45	107	1400	M16x2	
14.1	65	16	48	115	1410		
14.2	65	16	48	115	1420		
14.3	65	16	48	115	1430		
14.4	65	16	48	115	1440		
14.5	65	16	48	115	1450	M16x1.5 5/8-18UNF	
14.6	65	16	48	115	1460		
14.7	65	16	48	115	1470		
14.8	65	16	48	115	1480	5/8-24UNEF	
14.9	65	16	48	115	1490		

硬质合金麻花钻 (SP-X80003)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号·Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	65	16	48	115	1500	M16x1	M16x2
15.1	65	16	48	115	1510		
15.2	65	16	48	115	1520		
15.3	65	16	48	115	1530		
15.4	65	16	48	115	1540		
15.5	65	16	48	115	1550	M18x2.5	
15.6	65	16	48	115	1560		
15.7	65	16	48	115	1570		
15.8	65	16	48	115	1580		
15.9	65	16	48	115	1590		
16.0	65	16	48	115	1600	M18x2	
16.1	73	18	48	123	1610		
16.2	73	18	48	123	1620		
16.3	73	18	48	123	1630		
16.4	73	18	48	123	1640		
16.5	73	18	48	123	1650		
16.6	73	18	48	123	1660	3/4-10UNC	
16.7	73	18	48	123	1670		
16.8	73	18	48	123	1680		
16.9	73	18	48	123	1690		
17.0	73	18	48	123	1700	M18x1	
17.1	73	18	48	123	1710		
17.2	73	18	48	123	1720		
17.3	73	18	48	123	1730		
17.4	73	18	48	123	1740		
17.5	73	18	48	123	1750	M20x2.5 3/4-16UNF	
17.6	73	18	48	123	1760		
17.7	73	18	48	123	1770		
17.8	73	18	48	123	1780	3/4-20UNEF	
17.9	73	18	48	123	1790		

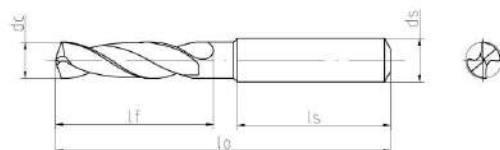
A

硬质合金麻花钻 (SP-X80003)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

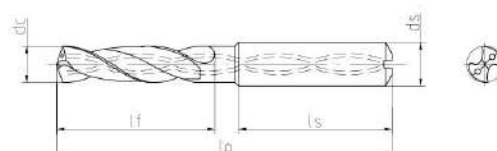
H

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	73	18	48	123	1800	M20x2	
18.1	79	20	50	131	1810		
18.2	79	20	50	131	1820		
18.3	79	20	50	131	1830		
18.4	79	20	50	131	1840		
18.5	79	20	50	131	1850	M20x1.5	
18.6	79	20	50	131	1860		
18.7	79	20	50	131	1870		
18.8	79	20	50	131	1880		
18.9	79	20	50	131	1890		
19.0	79	20	50	131	1900		
19.1	79	20	50	131	1910		
19.2	79	20	50	131	1920		
19.3	79	20	50	131	1930		
19.4	79	20	50	131	1940		
19.5	79	20	50	131	1950		
19.6	79	20	50	131	1960	7/8-9UNC	
19.7	79	20	50	131	1970		
19.8	79	20	50	131	1980		
19.9	79	20	50	131	1990		
20.0	79	20	50	131	2000	M22x2	

硬质合金麻花钻 (SP-N80103)

Carbide Twist Drills



- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	20	4	36	62	0300		
3.1	20	4	36	62	0310		
3.2	20	4	36	62	0320		
3.3	20	4	36	62	0330	M4x0.7	
3.4	20	4	36	62	0340	NO.8-32UNC	
3.5	20	4	36	62	0350	M4x0.5 NO.8-36UNF	
3.6	20	4	36	62	0360		
3.7	20	4	36	62	0370		M4x0.7
3.8	24	4	36	66	0380		M4x0.5
3.9	24	4	36	66	0390	NO.10-24UNC	
4.0	24	4	36	66	0400		
4.1	24	6	36	66	0410	NO.10-32UNF	
4.2	24	6	36	66	0420	M5x0.8	
4.3	24	6	36	66	0430		
4.4	24	6	36	66	0440		
4.5	24	6	36	66	0450	M4x0.5 NO.12-24UNC	
4.6	24	6	36	66	0460	NO.12-28UNF	M5x0.8
4.7	24	6	36	66	0470	NO.12-32UNEF	
4.8	28	6	36	66	0480		
4.9	28	6	36	66	0490		
5.0	28	6	36	66	0500	M6x1	
5.1	28	6	36	66	0510	1/4-20UNC	
5.2	28	6	36	66	0520		
5.3	28	6	36	66	0530	M6x0.75	
5.4	28	6	36	66	0540		
5.5	28	6	36	66	0550	1/4-28UNF	M6x1
5.6	28	6	36	66	0560	1/4-32UNEF	
5.7	28	6	36	66	0570		
5.8	28	6	36	66	0580		
5.9	28	6	36	66	0590		

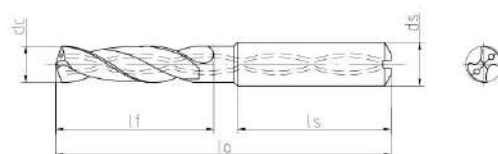
A

硬质合金麻花钻 (SP-N80103)

Carbide Twist Drills



B



C

- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

N

E

F

G

H

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	28	6	36	66	0600		
6.1	34	8	36	79	0610		
6.2	34	8	36	79	0620		
6.3	34	8	36	79	0630		
6.4	34	8	36	79	0640		
6.5	34	8	36	79	0650		
6.6	34	8	36	79	0660	5/16-18UNC	
6.7	34	8	36	79	0670		
6.8	34	8	36	79	0680	M8x1.25	
6.9	34	8	36	79	0690	5/16-24UNF	
7.0	34	8	36	79	0700	M8x1	
7.1	41	8	36	79	0710	5/16-32UNEF	
7.2	41	8	36	79	0720		
7.3	41	8	36	79	0730	M8x0.75	
7.4	41	8	36	79	0740		M8x1.25
7.5	41	8	36	79	0750		
7.6	41	8	36	79	0760		
7.7	41	8	36	79	0770		
7.8	41	8	36	79	0780		
7.9	41	8	36	79	0790		
8.0	41	8	36	79	0800	3/8-16UNC	
8.1	47	10	40	89	0810		
8.2	47	10	40	89	0820		
8.3	47	10	40	89	0830		
8.4	47	10	40	89	0840		
8.5	47	10	40	89	0850	M10x1.5 3/8-24UNF	
8.6	47	10	40	89	0860		
8.7	47	10	40	89	0870	3/8-32UNEF	
8.8	47	10	40	89	0880	M10x1.25	
8.9	47	10	40	89	0890		

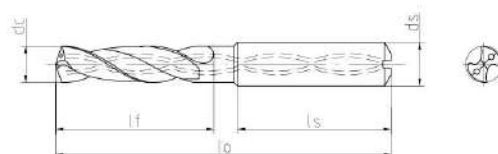
A

硬质合金麻花钻 (SP-N80103)

Carbide Twist Drills



B



C

- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

N

E

F

G

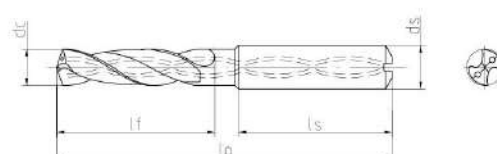
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	55	12	45	102	1200	M14x2	
12.1	60	14	45	107	1210		
12.2	60	14	45	107	1220	9/16-12UNC	
12.3	60	14	45	107	1230		
12.4	60	14	45	107	1240		
12.5	60	14	45	107	1250	M14x1.5	
12.6	60	14	45	107	1260		
12.7	60	14	45	107	1270		
12.8	60	14	45	107	1280		
12.9	60	14	45	107	1290	9/16-18UNF	
13.0	60	14	45	107	1300	M14x1	M14x2
13.1	60	14	45	107	1310		
13.2	60	14	45	107	1320	9/16-24UNEF	
13.3	60	14	45	107	1330		
13.4	60	14	45	107	1340		
13.5	60	14	45	107	1350		
13.6	60	14	45	107	1360	5/8-11UNC	
13.7	60	14	45	107	1370		
13.8	60	14	45	107	1380		
13.9	60	14	45	107	1390		
14.0	60	14	45	107	1400	M16x2	
14.1	65	16	48	115	1410		
14.2	65	16	48	115	1420		
14.3	65	16	48	115	1430		
14.4	65	16	48	115	1440		
14.5	65	16	48	115	1450	M16x1.5 5/8-18UNF	
14.6	65	16	48	115	1460		
14.7	65	16	48	115	1470		
14.8	65	16	48	115	1480	5/8-24UNEF	
14.9	65	16	48	115	1490		

硬质合金麻花钻 (SP-N80103)

Carbide Twist Drills



- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

N

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	65	16	48	115	1500	M16x1	M16x2
15.1	65	16	48	115	1510		
15.2	65	16	48	115	1520		
15.3	65	16	48	115	1530		
15.4	65	16	48	115	1540		
15.5	65	16	48	115	1550	M18x2.5	
15.6	65	16	48	115	1560		
15.7	65	16	48	115	1570		
15.8	65	16	48	115	1580		
15.9	65	16	48	115	1590		
16.0	65	16	48	115	1600	M18x2	
16.1	73	18	48	123	1610		
16.2	73	18	48	123	1620		
16.3	73	18	48	123	1630		
16.4	73	18	48	123	1640		
16.5	73	18	48	123	1650		
16.6	73	18	48	123	1660	3/4-10UNC	
16.7	73	18	48	123	1670		
16.8	73	18	48	123	1680		
16.9	73	18	48	123	1690		
17.0	73	18	48	123	1700	M18x1	
17.1	73	18	48	123	1710		
17.2	73	18	48	123	1720		
17.3	73	18	48	123	1730		
17.4	73	18	48	123	1740		
17.5	73	18	48	123	1750	M20x2.5 3/4-16UNF	
17.6	73	18	48	123	1760		
17.7	73	18	48	123	1770		
17.8	73	18	48	123	1780	3/4-20UNEF	
17.9	73	18	48	123	1790		

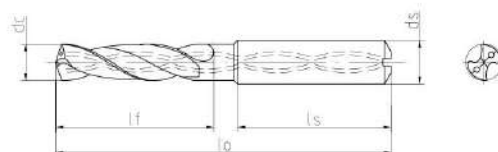
A

硬质合金麻花钻 (SP-N80103)

Carbide Twist Drills



B



C

- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

N

E

F

G

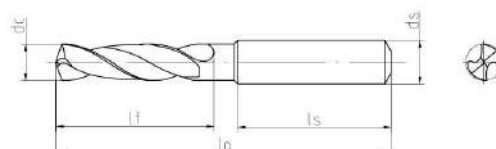
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	73	18	48	123	1800	M20x2	
18.1	79	20	50	131	1810		
18.2	79	20	50	131	1820		
18.3	79	20	50	131	1830		
18.4	79	20	50	131	1840		
18.5	79	20	50	131	1850	M20x1.5	
18.6	79	20	50	131	1860		
18.7	79	20	50	131	1870		
18.8	79	20	50	131	1880		
18.9	79	20	50	131	1890		
19.0	79	20	50	131	1900	M20x1	
19.1	79	20	50	131	1910		
19.2	79	20	50	131	1920		
19.3	79	20	50	131	1930		
19.4	79	20	50	131	1940		
19.5	79	20	50	131	1950		
19.6	79	20	50	131	1960	7/8-9UNC	
19.7	79	20	50	131	1970		
19.8	79	20	50	131	1980		
19.9	79	20	50	131	1990		
20.0	79	20	50	131	2000	M22x2	

硬质合金麻花钻 (SP-N80003)

Carbide Twist Drills



- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	20	6	36	62	0300		
3.1	20	6	36	62	0310		
3.2	20	6	36	62	0320		
3.3	20	6	36	62	0330	M4x0.7	
3.4	20	6	36	62	0340	NO.8-32UNC	
3.5	20	6	36	62	0350	M4x0.5 NO.8-36UNF	
3.6	20	6	36	62	0360		
3.7	20	6	36	62	0370		M4x0.7
3.8	24	6	36	66	0380		M4x0.5
3.9	24	6	36	66	0390	NO.10-24UNC	
4.0	24	6	36	66	0400		
4.1	24	6	36	66	0410	NO.10-32UNF	
4.2	24	6	36	66	0420	M5x0.8	
4.3	24	6	36	66	0430		
4.4	24	6	36	66	0440		
4.5	24	6	36	66	0450	M5x0.5 NO.12-24UNC	
4.6	24	6	36	66	0460	NO.12-28UNF	M5x0.8
4.7	24	6	36	66	0470	NO.12-32UNEF	
4.8	28	6	36	66	0480		
4.9	28	6	36	66	0490		
5.0	28	6	36	66	0500	M6x1	
5.1	28	6	36	66	0510	1/4-20UNC	
5.2	28	6	36	66	0520		
5.3	28	6	36	66	0530	M6x0.75	
5.4	28	6	36	66	0540		
5.5	28	6	36	66	0550	1/4-28UNF	M6x1
5.6	28	6	36	66	0560	1/4-32UNEF	
5.7	28	6	36	66	0570		
5.8	28	6	36	66	0580		
5.9	28	6	36	66	0590		

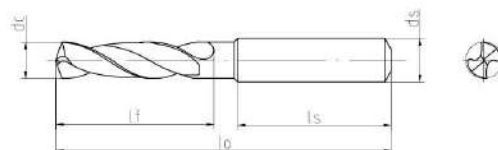
A

硬质合金麻花钻 (SP-N80003)

Carbide Twist Drills



B



C

- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

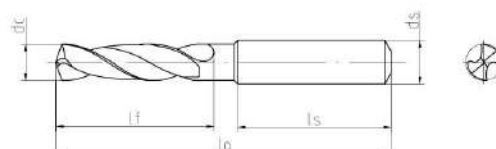
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	28	6	36	66	0600		
6.1	34	8	36	79	0610		
6.2	34	8	36	79	0620		
6.3	34	8	36	79	0630		
6.4	34	8	36	79	0640		
6.5	34	8	36	79	0650		
6.6	34	8	36	79	0660	5/16-18UNC	
6.7	34	8	36	79	0670		
6.8	34	8	36	79	0680	M8x1.25	
6.9	34	8	36	79	0690	5/16-24UNF	
7.0	34	8	36	79	0700	M8x1	
7.1	41	8	36	79	0710	5/16-32UNEF	
7.2	41	8	36	79	0720		
7.3	41	8	36	79	0730	M8x0.75	
7.4	41	8	36	79	0740		M8x1.25
7.5	41	8	36	79	0750		
7.6	41	8	36	79	0760		
7.7	41	8	36	79	0770		
7.8	41	8	36	79	0780		
7.9	41	8	36	79	0790		
8.0	41	8	36	79	0800	3/8-16UNC	
8.1	47	10	40	89	0810		
8.2	47	10	40	89	0820		
8.3	47	10	40	89	0830		
8.4	47	10	40	89	0840		
8.5	47	10	40	89	0850	M10x1.5 3/8-24UNF	
8.6	47	10	40	89	0860		
8.7	47	10	40	89	0870	3/8-32UNEF	
8.8	47	10	40	89	0880	M10x1.25	
8.9	47	10	40	89	0890		

硬质合金麻花钻 (SP-N80003)

Carbide Twist Drills



- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	47	10	40	89	0900	M10x1	
9.1	47	10	40	89	0910		
9.2	47	10	40	89	0920		
9.3	47	10	40	89	0930	M10x0.75	M10x1.5
9.4	47	10	40	89	0940	7/16-14UNC	
9.5	47	10	40	89	0950		
9.6	47	10	40	89	0960		
9.7	47	10	40	89	0970		
9.8	47	10	40	89	0980		
9.9	47	10	40	89	0990	7/16-20UNF	
10.0	47	10	40	89	1000		
10.1	55	12	45	102	1010		
10.2	55	12	45	102	1020	7/16-28UNEF	
10.3	55	12	45	102	1030	M12x1.75	
10.4	55	12	45	102	1040		
10.5	55	12	45	102	1050		
10.6	55	12	45	102	1060		
10.7	55	12	45	102	1070		
10.8	55	12	45	102	1080		
10.9	55	12	45	102	1090	1/2-13UNC	
11.0	55	12	45	102	1100	M12x1	
11.1	55	12	45	102	1110		
11.2	55	12	45	102	1120		M12x1.75
11.3	55	12	45	102	1130		
11.4	55	12	45	102	1140		
11.5	55	12	45	102	1150	1/2-20UNF	
11.6	55	12	45	102	1160		
11.7	55	12	45	102	1170		
11.8	55	12	45	102	1180	1/2-28UNEF	
11.9	55	12	45	102	1190		

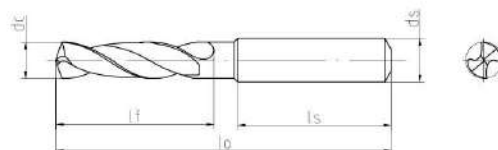
A

硬质合金麻花钻 (SP-N80003)

Carbide Twist Drills



B



C

- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

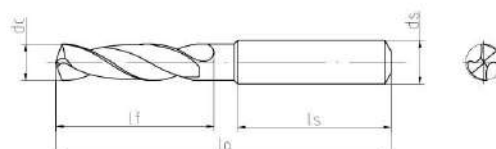
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	55	12	45	102	1200	M14x2	
12.1	60	14	45	107	1210		
12.2	60	14	45	107	1220	9/16-12UNC	
12.3	60	14	45	107	1230		
12.4	60	14	45	107	1240		
12.5	60	14	45	107	1250	M14x1.5	
12.6	60	14	45	107	1260		
12.7	60	14	45	107	1270		
12.8	60	14	45	107	1280		
12.9	60	14	45	107	1290	9/16-18UNF	
13.0	60	14	45	107	1300	M14x1	M14x2
13.1	60	14	45	107	1310		
13.2	60	14	45	107	1320	9/16-24UNEF	
13.3	60	14	45	107	1330		
13.4	60	14	45	107	1340		
13.5	60	14	45	107	1350		
13.6	60	14	45	107	1360	5/8-11UNC	
13.7	60	14	45	107	1370		
13.8	60	14	45	107	1380		
13.9	60	14	45	107	1390		
14.0	60	14	45	107	1400	M16x2	
14.1	65	16	48	115	1410		
14.2	65	16	48	115	1420		
14.3	65	16	48	115	1430		
14.4	65	16	48	115	1440		
14.5	65	16	48	115	1450	M16x1.5 5/8-18UNF	
14.6	65	16	48	115	1460		
14.7	65	16	48	115	1470		
14.8	65	16	48	115	1480	5/8-24UNEF	
14.9	65	16	48	115	1490		

硬质合金麻花钻 (SP-N80003)

Carbide Twist Drills



- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ · dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	65	16	48	115	1500	M16x1	M16x2
15.1	65	16	48	115	1510		
15.2	65	16	48	115	1520		
15.3	65	16	48	115	1530		
15.4	65	16	48	115	1540		
15.5	65	16	48	115	1550	M18x2.5	
15.6	65	16	48	115	1560		
15.7	65	16	48	115	1570		
15.8	65	16	48	115	1580		
15.9	65	16	48	115	1590		
16.0	65	16	48	115	1600	M18x2	
16.1	73	18	48	123	1610		
16.2	73	18	48	123	1620		
16.3	73	18	48	123	1630		
16.4	73	18	48	123	1640		
16.5	73	18	48	123	1650		
16.6	73	18	48	123	1660	3/4-10UNC	
16.7	73	18	48	123	1670		
16.8	73	18	48	123	1680		
16.9	73	18	48	123	1690		
17.0	73	18	48	123	1700	M18x1	
17.1	73	18	48	123	1710		
17.2	73	18	48	123	1720		
17.3	73	18	48	123	1730		
17.4	73	18	48	123	1740		
17.5	73	18	48	123	1750	M20x2.5 3/4-16UNF	
17.6	73	18	48	123	1760		
17.7	73	18	48	123	1770		
17.8	73	18	48	123	1780	3/4-20UNEF	
17.9	73	18	48	123	1790		

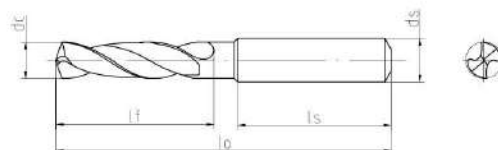
A

硬质合金麻花钻 (SP-N80003)

Carbide Twist Drills



B



C

- 尺寸形式参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

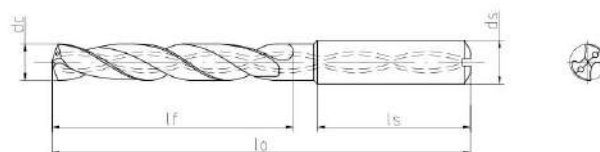
H

订货编号: Order code

Φ · dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	73	18	48	123	1800	M20x2	
18.1	79	20	50	131	1810		
18.2	79	20	50	131	1820		
18.3	79	20	50	131	1830		
18.4	79	20	50	131	1840		
18.5	79	20	50	131	1850	M20x1.5	
18.6	79	20	50	131	1860		
18.7	79	20	50	131	1870		
18.8	79	20	50	131	1880		
18.9	79	20	50	131	1890		
19.0	79	20	50	131	1900	M20x1	
19.1	79	20	50	131	1910		
19.2	79	20	50	131	1920		
19.3	79	20	50	131	1930		
19.4	79	20	50	131	1940		
19.5	79	20	50	131	1950		
19.6	79	20	50	131	1960	7/8-9UNC	
19.7	79	20	50	131	1970		
19.8	79	20	50	131	1980		
19.9	79	20	50	131	1990		
20.0	79	20	50	131	2000	M22x2	

硬质合金麻花钻 (SP-X80105)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

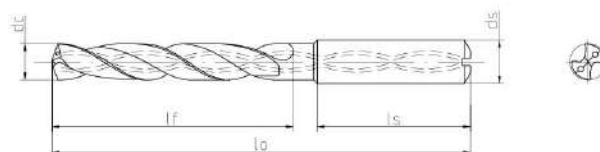
订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	28	4	36	66	0300		
3.1	28	4	36	66	0310		
3.2	28	4	36	66	0320		
3.3	28	4	36	66	0330	M4x0.7	
3.4	28	4	36	66	0340	NO.8-32UNC	
3.5	28	4	36	66	0350	M4x0.5 NO.8-36UNF	
3.6	28	4	36	66	0360		
3.7	28	4	36	66	0370		M4x0.7
3.8	36	4	36	74	0380		M4x0.5
3.9	36	4	36	74	0390	NO.10-24UNC	
4.0	36	4	36	74	0400		
4.1	36	6	36	74	0410	NO.10-32UNF	
4.2	36	6	36	74	0420	M5x0.8	
4.3	36	6	36	74	0430		
4.4	36	6	36	74	0440		
4.5	36	6	36	74	0450	M5x0.5 NO.12-24UNC	
4.6	36	6	36	74	0460	NO.12-28UNF	M5x0.8
4.7	36	6	36	74	0470	NO.12-32UNEF	
4.8	44	6	36	82	0480		
4.9	44	6	36	82	0490		
5.0	44	6	36	82	0500	M6x1	
5.1	44	6	36	82	0510	1/4-20UNC	
5.2	44	6	36	82	0520		
5.3	44	6	36	82	0530	M6x0.75	
5.4	44	6	36	82	0540		
5.5	44	6	36	82	0550	1/4-28UNF	M6x1
5.6	44	6	36	82	0560	1/4-32UNF	
5.7	44	6	36	82	0570		
5.8	44	6	36	82	0580		
5.9	44	6	36	82	0590		

A

硬质合金麻花钻 (SP-X80105)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

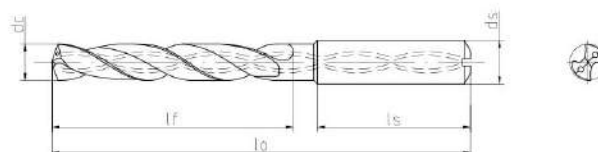
P M K S

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	44	6	36	82	0600		
6.1	53	8	36	91	0610		
6.2	53	8	36	91	0620		
6.3	53	8	36	91	0630		
6.4	53	8	36	91	0640		
6.5	53	8	36	91	0650		
6.6	53	8	36	91	0660	5/16-18UNC	
6.7	53	8	36	91	0670		
6.8	53	8	36	91	0680	M8X1.25	
6.9	53	8	36	91	0690	5/16-24UNF	
7.0	53	8	36	91	0700	M8X1	
7.1	53	8	36	91	0710	5/16-32UNEF	
7.2	53	8	36	91	0720		
7.3	53	8	36	91	0730	M8X0.75	
7.4	53	8	36	91	0740		M8X1.25
7.5	53	8	36	91	0750		
7.6	53	8	36	91	0760		
7.7	53	8	36	91	0770		
7.8	53	8	36	91	0780		
7.9	53	8	36	91	0790		
8.0	53	8	36	91	0800	3/8-16UNC	
8.1	61	10	40	103	0810		
8.2	61	10	40	103	0820		
8.3	61	10	40	103	0830		
8.4	61	10	40	103	0840		
8.5	66	10	40	103	0850	M10x1.5 3/8-24UNF	
8.6	61	10	40	103	0860		
8.7	61	10	40	103	0870	3/8-32UNEF	
8.8	61	10	40	103	0880	M10x1.25	
8.9	61	10	40	103	0890		

硬质合金麻花钻 (SP-X80105)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号·Order code

Φ·d _c 公差 m7	槽长 l _f	柄径 d _s 公差 h6	柄长 l _s	总长 l _o	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	61	10	40	103	0900	M10X1	
9.1	61	10	40	103	0910		
9.2	61	10	40	103	0920		
9.3	61	10	40	103	0930	M10X0.75	M10X1.5
9.4	61	10	40	103	0940	7/16-14UNC	
9.5	61	10	40	103	0950		
9.6	61	10	40	103	0960		
9.7	61	10	40	103	0970		
9.8	61	10	40	103	0980		
9.9	61	10	40	103	0990	7/16-20UNF	
10.0	61	10	40	103	1000		
10.1	71	12	45	118	1010		
10.2	71	12	45	118	1020	7/16-28UNEF	
10.3	71	12	45	118	1030	M12X1.75	
10.4	71	12	45	118	1040		
10.5	71	12	45	118	1050		
10.6	71	12	45	118	1060		
10.7	71	12	45	118	1070		
10.8	71	12	45	118	1080		
10.9	71	12	45	118	1090	1/2-13UNC	
11.0	71	12	45	118	1100	M12X1	
11.1	71	12	45	118	1110		
11.2	71	12	45	118	1120		M12X1.75
11.3	71	12	45	118	1130		
11.4	71	12	45	118	1140		
11.5	71	12	45	118	1150	1/2-20UNF	
11.6	71	12	45	118	1160		
11.7	71	12	45	118	1170		
11.8	71	12	45	118	1180	1/2-28UNEF	
11.9	71	12	45	118	1190		

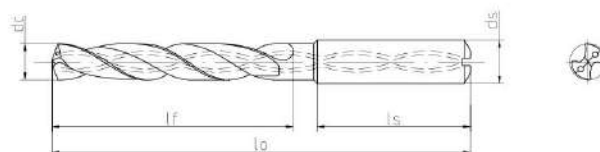
A

硬质合金麻花钻 (SP-X80105)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

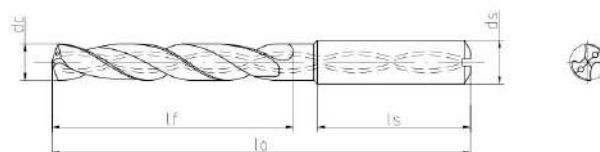
H

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	71	12	45	118	1200	M14x2	
12.1	77	14	45	124	1210		
12.2	77	14	45	124	1220	9/16-12UNC	
12.3	77	14	45	124	1230		
12.4	77	14	45	124	1240		
12.5	77	14	45	124	1250	M14x1.5	
12.6	77	14	45	124	1260		
12.7	77	14	45	124	1270		
12.8	77	14	45	124	1280		
12.9	77	14	45	124	1290	9/16-18UNF	
13.0	77	14	45	124	1300	M14x1	M14x2
13.1	77	14	45	124	1310		
13.2	77	14	45	124	1320	9/16-24UNEF	
13.3	77	14	45	124	1330		
13.4	77	14	45	124	1340		
13.5	77	14	45	124	1350		
13.6	77	14	45	124	1360	5/8-11UNC	
13.7	77	14	45	124	1370		
13.8	77	14	45	124	1380		
13.9	77	14	45	124	1390		
14.0	77	14	45	124	1400	M16x2	
14.1	83	16	48	133	1410		
14.2	83	16	48	133	1420		
14.3	83	16	48	133	1430		
14.4	83	16	48	133	1440		
14.5	83	16	48	133	1450	M16x1.5 5/8-18UNF	
14.6	83	16	48	133	1460		
14.7	83	16	48	133	1470		
14.8	83	16	48	133	1480	5/8-24UNEF	
14.9	83	16	48	133	1490		

硬质合金麻花钻 (SP-X80105)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号·Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	83	16	48	133	1500	M16x1	M16x2
15.1	83	16	48	133	1510		
15.2	83	16	48	133	1520		
15.3	83	16	48	133	1530		
15.4	83	16	48	133	1540		
15.5	83	16	48	133	1550	M18x2.5	
15.6	83	16	48	133	1560		
15.7	83	16	48	133	1570		
15.8	83	16	48	133	1580		
15.9	83	16	48	133	1590		
16.0	83	16	48	133	1600	M18x2	
16.1	93	18	48	143	1610		
16.2	93	18	48	143	1620		
16.3	93	18	48	143	1630		
16.4	93	18	48	143	1640		
16.5	93	18	48	143	1650		
16.6	93	18	48	143	1660	3/4-10UNC	
16.7	93	18	48	143	1670		
16.8	93	18	48	143	1680		
16.9	93	18	48	143	1690		
17.0	93	18	48	143	1700	M18x1	
17.1	93	18	48	143	1710		
17.2	93	18	48	143	1720		
17.3	93	18	48	143	1730		
17.4	93	18	48	143	1740		
17.5	93	18	48	143	1750	M20x2.5 3/4-16UNF	
17.6	93	18	48	143	1760		
17.7	93	18	48	143	1770		
17.8	93	18	48	143	1780	3/4-20UNEF	
17.9	93	18	48	143	1790		

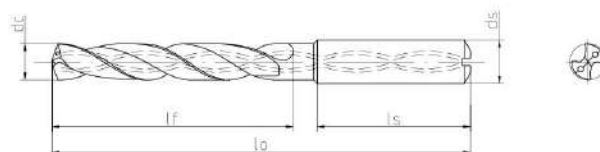
A

硬质合金麻花钻 (SP-X80105)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Fine polished flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

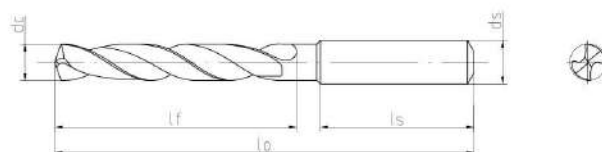
H

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	93	18	48	143	1800	M20X2	
18.1	101	20	50	153	1810		
18.2	101	20	50	153	1820		
18.3	101	20	50	153	1830		
18.4	101	20	50	153	1840		
18.5	101	20	50	153	1850	M20X1.5	
18.6	101	20	50	153	1860		
18.7	101	20	50	153	1870		
18.8	101	20	50	153	1880		
18.9	101	20	50	153	1890		
19.0	101	20	50	153	1900	M20X1	
19.1	101	20	50	153	1910		
19.2	101	20	50	153	1920		
19.3	101	20	50	153	1930		
19.4	101	20	50	153	1940		
19.5	101	20	50	153	1950		
19.6	101	20	50	153	1960	7/8-9UNC	
19.7	101	20	50	153	1970		
19.8	101	20	50	153	1980		
19.9	101	20	50	153	1990		
20.0	101	20	50	153	2000	M22X2	

硬质合金麻花钻 (SP-X80005)

Carbide Twist Drills



- 尺寸形式参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号·Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	28	6	36	66	0300		
3.1	28	6	36	66	0310		
3.2	28	6	36	66	0320		
3.3	28	6	36	66	0330	M4X0.7	
3.4	28	6	36	66	0340	NO.8-32UNC	
3.5	28	6	36	66	0350	M4x0.5 NO.8-36UNF	
3.6	28	6	36	66	0360		
3.7	28	6	36	66	0370		M4X0.7
3.8	36	6	36	74	0380		M4X0.5
3.9	36	6	36	74	0390	NO.10-24UNC	
4.0	36	6	36	74	0400		
4.1	36	6	36	74	0410	NO.10-32UNF	
4.2	36	6	36	74	0420	M5X0.8	
4.3	36	6	36	74	0430		
4.4	36	6	36	74	0440		
4.5	36	6	36	74	0450	M5x0.5 NO.12-24UNC	
4.6	36	6	36	74	0460	NO.12-28UNF	M5X0.8
4.7	36	6	36	74	0470	NO.12-32UNEF	
4.8	44	6	36	82	0480		
4.9	44	6	36	82	0490		
5.0	44	6	36	82	0500	M6X1	
5.1	44	6	36	82	0510	1/4-20UNC	
5.2	44	6	36	82	0520		
5.3	44	6	36	82	0530	M6X0.75	
5.4	44	6	36	82	0540		
5.5	44	6	36	82	0550	1/4-28UNF	M6X1
5.6	44	6	36	82	0560	1/4-32UNEF	
5.7	44	6	36	82	0570		
5.8	44	6	36	82	0580		
5.9	44	6	36	82	0590		

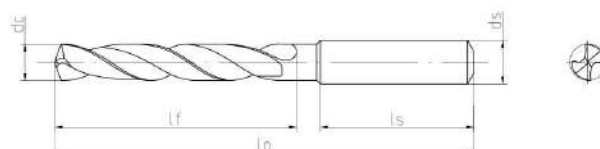
A

硬质合金麻花钻 (SP-X80005)

Carbide Twist Drills



B



C

- 尺寸形式参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

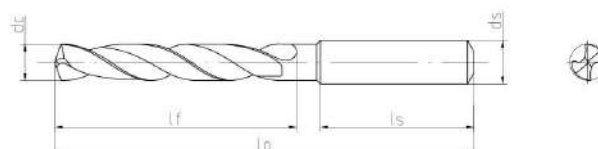
H

订货编号·Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	44	6	36	82	0600		
6.1	53	8	36	91	0610		
6.2	53	8	36	91	0620		
6.3	53	8	36	91	0630		
6.4	53	8	36	91	0640		
6.5	53	8	36	91	0650		
6.6	53	8	36	91	0660	5/16-18UNC	
6.7	53	8	36	91	0670		
6.8	53	8	36	91	0680	M8x1.25	
6.9	53	8	36	91	0690	5/16-24UNF	
7.0	53	8	36	91	0700	M8x1	
7.1	53	8	36	91	0710	5/16-32UNEF	
7.2	53	8	36	91	0720		
7.3	53	8	36	91	0730	M8x0.75	
7.4	53	8	36	91	0740		M8x1.25
7.5	53	8	36	91	0750		
7.6	53	8	36	91	0760		
7.7	53	8	36	91	0770		
7.8	53	8	36	91	0780		
7.9	53	8	36	91	0790		
8.0	53	8	36	91	0800	3/8-16UNC	
8.1	61	10	40	103	0810		
8.2	61	10	40	103	0820		
8.3	61	10	40	103	0830		
8.4	61	10	40	103	0840		
8.5	61	10	40	103	0850	M10x1.5 3/8-24UNF	
8.6	61	10	40	103	0860		
8.7	61	10	40	103	0870	3/8-32UNEF	
8.8	61	10	40	103	0880	M10x1.25	
8.9	61	10	40	103	0890		

硬质合金麻花钻 (SP-X80005)

Carbide Twist Drills



- 尺寸形式参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号·Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	61	10	40	103	0900	M10x1	
9.1	61	10	40	103	0910		
9.2	61	10	40	103	0920		
9.3	61	10	40	103	0930	M10x0.75	M10x1.5
9.4	61	10	40	103	0940	7/16-14UNC	
9.5	61	10	40	103	0950		
9.6	61	10	40	103	0960		
9.7	61	10	40	103	0970		
9.8	61	10	40	103	0980		
9.9	61	10	40	103	0990	7/16-20UNF	
10.0	61	10	40	103	1000		
10.1	71	12	45	118	1010		
10.2	71	12	45	118	1020	7/16-28UNEF	
10.3	71	12	45	118	1030	M12x1.75	
10.4	71	12	45	118	1040		
10.5	71	12	45	118	1050		
10.6	71	12	45	118	1060		
10.7	71	12	45	118	1070		
10.8	71	12	45	118	1080		
10.9	71	12	45	118	1090	1/2-13UNC	
11.0	71	12	45	118	1100	M12x1	
11.1	71	12	45	118	1110		
11.2	71	12	45	118	1120		M12x1.75
11.3	71	12	45	118	1130		
11.4	71	12	45	118	1140		
11.5	71	12	45	118	1150	1/2-20UNF	
11.6	71	12	45	118	1160		
11.7	71	12	45	118	1170		
11.8	71	12	45	118	1180	1/2-28UNEF	
11.9	71	12	45	118	1190		

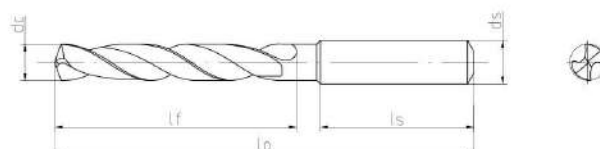
A

硬质合金麻花钻 (SP-X80005)

Carbide Twist Drills



B



C

- 尺寸形式参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

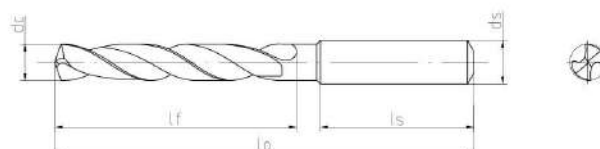
H

订货编号·Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	71	12	45	118	1200	M14x2	
12.1	77	14	45	124	1210		
12.2	77	14	45	124	1220	9/16-12UNC	
12.3	77	14	45	124	1230		
12.4	77	14	45	124	1240		
12.5	77	14	45	124	1250	M14x1.5	
12.6	77	14	45	124	1260		
12.7	77	14	45	124	1270		
12.8	77	14	45	124	1280		
12.9	77	14	45	124	1290	9/16-18UNF	
13.0	77	14	45	124	1300	M14x1	M14x2
13.1	77	14	45	124	1310		
13.2	77	14	45	124	1320	9/16-24UNEF	
13.3	77	14	45	124	1330		
13.4	77	14	45	124	1340		
13.5	77	14	45	124	1350		
13.6	77	14	45	124	1360	5/8-11UNC	
13.7	77	14	45	12	1370		
13.8	77	14	45	4124	1380		
13.9	77	14	45	124	1390		
14.0	77	14	45	124	1400	M16x2	
14.1	83	16	48	133	1410		
14.2	83	16	48	133	1420		
14.3	83	16	48	133	1430		
14.4	83	16	48	133	1440		
14.5	83	16	48	133	1450	M16x1.5 5/8-18UNF	
14.6	83	16	48	133	1460		
14.7	83	16	48	133	1470		
14.8	83	16	48	133	1480	5/8-24UNEF	
14.9	83	16	48	133	1490		

硬质合金麻花钻 (SP-X80005)

Carbide Twist Drills



- 尺寸形式参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号·Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	83	16	48	133	1500	M16x1	M16x2
15.1	83	16	48	133	1510		
15.2	83	16	48	133	1520		
15.3	83	16	48	133	1530		
15.4	83	16	48	133	1540		
15.5	83	16	48	133	1550	M18x2.5	
15.6	83	16	48	133	1560		
15.7	83	16	48	133	1570		
15.8	83	16	48	133	1580		
15.9	83	16	48	133	1590		
16.0	83	16	48	133	1600	M18x2	
16.1	93	18	48	143	1610		
16.2	93	18	48	143	1620		
16.3	93	18	48	143	1630		
16.4	93	18	48	143	1640		
16.5	93	18	48	143	1650		
16.6	93	18	48	143	1660	3/4-10UNC	
16.7	93	18	48	143	1670		
16.8	93	18	48	143	1680		
16.9	93	18	48	143	1690		
17.0	93	18	48	143	1700	M18x1	
17.1	93	18	48	143	1710		
17.2	93	18	48	143	1720		
17.3	93	18	48	143	1730		
17.4	93	18	48	143	1740		
17.5	93	18	48	143	1750	M20x2.5 3/4-16UNF	
17.6	93	18	48	143	1760		
17.7	93	18	48	143	1770		
17.8	93	18	48	143	1780	3/4-20UNEF	
17.9	93	18	48	143	1790		

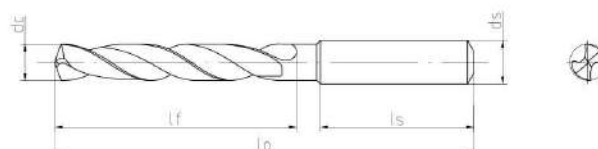
A

硬质合金麻花钻 (SP-X80005)

Carbide Twist Drills



B



C

- 尺寸形式参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

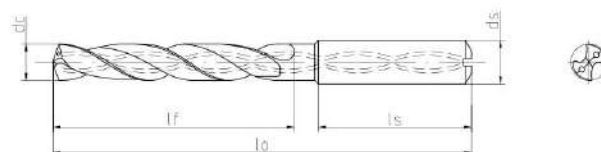
H

订货编号·Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	93	18	48	143	1800	M20x2	
18.1	101	20	50	153	1810		
18.2	101	20	50	153	1820		
18.3	101	20	50	153	1830		
18.4	101	20	50	153	1840		
18.5	101	20	50	153	1850	M20x1.5	
18.6	101	20	50	153	1860		
18.7	101	20	50	153	1870		
18.8	101	20	50	153	1880		
18.9	101	20	50	153	1890		
19.0	101	20	50	153	1900	M20x1	
19.1	101	20	50	153	1910		
19.2	101	20	50	153	1920		
19.3	101	20	50	153	1930		
19.4	101	20	50	153	1940		
19.5	101	20	50	153	1950		
19.6	101	20	50	153	1960	7/8-9UNC	
19.7	101	20	50	153	1970		
19.8	101	20	50	153	1980		
19.9	101	20	50	153	1990		
20.0	101	20	50	153	2000	M22x2	

硬质合金麻花钻 (SP-N80105)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ · d _c 公差 m7	槽长 l _f	柄径 d _s 公差 h6	柄长 l _s	总长 l _o	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	28	4	36	66	0300		
3.1	28	4	36	66	0310		
3.2	28	4	36	66	0320		
3.3	28	4	36	66	0330	M4x0.7	
3.4	28	4	36	66	0340	NO.8-32UNC	
3.5	28	4	36	66	0350	M4x0.5 NO.8-36UNF	
3.6	28	4	36	66	0360		
3.7	28	4	36	66	0370		M4x0.7
3.8	36	4	36	74	0380		M4x0.5
3.9	36	4	36	74	0390	NO.10-24UNC	
4.0	36	4	36	74	0400		
4.1	36	6	36	74	0410	NO.10-32UNF	
4.2	36	6	36	74	0420	M5x0.8	
4.3	36	6	36	74	0430		
4.4	36	6	36	74	0440		
4.5	36	6	36	74	0450	M5x0.5 NO.12-24UNC	
4.6	36	6	36	74	0460	NO.12-28UNF	M5x0.8
4.7	36	6	36	74	0470	NO.12-32UNEF	
4.8	44	6	36	82	0480		
4.9	44	6	36	82	0490		
5.0	44	6	36	82	0500	M6x1	
5.1	44	6	36	82	0510	1/4-20UNC	
5.2	44	6	36	82	0520		
5.3	44	6	36	82	0530	M6x0.75	
5.4	44	6	36	82	0540		
5.5	44	6	36	82	0550	1/4-28UNF	M6x1
5.6	44	6	36	82	0560	1/4-32UNEF	
5.7	44	6	36	82	0570		
5.8	44	6	36	82	0580		
5.9	44	6	36	82	0590		

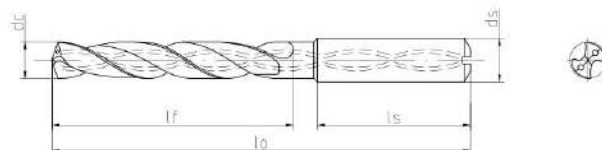
A

硬质合金麻花钻 (SP-N80105)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

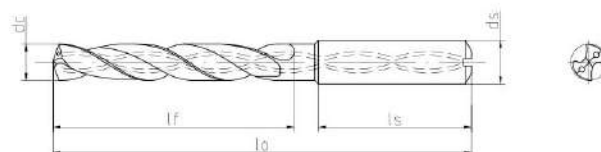
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	44	6	36	82	0600		
6.1	53	8	36	91	0610		
6.2	53	8	36	91	0620		
6.3	53	8	36	91	0630		
6.4	53	8	36	91	0640		
6.5	53	8	36	91	0650		
6.6	53	8	36	91	0660	5/16-18UNC	
6.7	53	8	36	91	0670		
6.8	53	8	36	91	0680	M8x1.25	
6.9	53	8	36	91	0690	5/16-24UNF	
7.0	53	8	36	91	0700	M8x1	
7.1	53	8	36	91	0710	5/16-32UNEF	
7.2	53	8	36	91	0720		
7.3	53	8	36	91	0730	M8x0.75	
7.4	53	8	36	91	0740		M8x1.25
7.5	53	8	36	91	0750		
7.6	53	8	36	91	0760		
7.7	53	8	36	91	0770		
7.8	53	8	36	91	0780		
7.9	53	8	36	91	0790		
8.0	53	8	36	91	0800	3/8-16UNC	
8.1	61	10	40	103	0810		
8.2	61	10	40	103	0820		
8.3	61	10	40	103	0830		
8.4	61	10	40	103	0840		
8.5	61	10	40	103	0850	M10x1.5 3/8-24UNF	
8.6	61	10	40	103	0860		
8.7	61	10	40	103	0870	3/8-32UNEF	
8.8	61	10	40	103	0880	M10x1.25	
8.9	61	10	40	103	0890		

硬质合金麻花钻 (SP-N80105)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ · dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	61	10	40	103	0900	M10x1	
9.1	61	10	40	103	0910		
9.2	61	10	40	103	0920		
9.3	61	10	40	103	0930	M10x0.75	M10x1.5
9.4	61	10	40	103	0940	7/16-14UNC	
9.5	61	10	40	103	0950		
9.6	61	10	40	103	0960		
9.7	61	10	40	103	0970		
9.8	61	10	40	103	0980		
9.9	61	10	40	103	0990	7/16-20UNF	
10.0	61	10	40	103	1000		
10.1	71	12	45	118	1010		
10.2	71	12	45	118	1020	7/16-28UNEF	
10.3	71	12	45	118	1030	M12x1.75	
10.4	71	12	45	118	1040		
10.5	71	12	45	118	1050		
10.6	71	12	45	118	1060		
10.7	71	12	45	118	1070		
10.8	71	12	45	118	1080		
10.9	71	12	45	118	1090	1/2-13UNC	
11.0	71	12	45	118	1100	M12x1	
11.1	71	12	45	118	1110		
11.2	71	12	45	118	1120		M12x1.75
11.3	71	12	45	118	1130		
11.4	71	12	45	118	1140		
11.5	71	12	45	118	1150	1/2-20UNF	
11.6	71	12	45	118	1160		
11.7	71	12	45	118	1170		
11.8	71	12	45	118	1180	1/2-28UNEF	
11.9	71	12	45	118	1190		

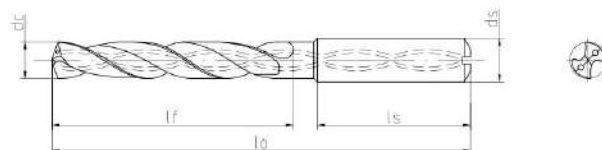
A

硬质合金麻花钻 (SP-N80105)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

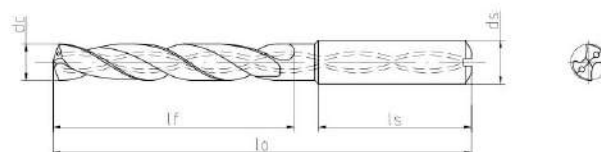
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	71	12	45	118	1200	M14x2	
12.1	77	14	45	124	1210		
12.2	77	14	45	124	1220	9/16-12UNC	
12.3	77	14	45	124	1230		
12.4	77	14	45	124	1240		
12.5	77	14	45	124	1250	M14x1.5	
12.6	77	14	45	124	1260		
12.7	77	14	45	124	1270		
12.8	77	14	45	124	1280		
12.9	77	14	45	124	1290	9/16-18UNF	
13.0	77	14	45	124	1300	M14x1	M14x2
13.1	77	14	45	124	1310		
13.2	77	14	45	124	1320	9/16-24UNEF	
13.3	77	14	45	124	1330		
13.4	77	14	45	124	1340		
13.5	77	14	45	124	1350		
13.6	77	14	45	124	1360	5/8-11UNC	
13.7	77	14	45	124	1370		
13.8	77	14	45	124	1380		
13.9	77	14	45	124	1390		
14.0	77	14	45	124	1400	M16x2	
14.1	83	16	48	133	1410		
14.2	83	16	48	133	1420		
14.3	83	16	48	133	1430		
14.4	83	16	48	133	1440		
14.5	83	16	48	133	1450	M16x1.5 5/8-18UNF	
14.6	83	16	48	133	1460		
14.7	83	16	48	133	1470		
14.8	83	16	48	133	1480	5/8-24UNEF	
14.9	83	16	48	133	1490		

硬质合金麻花钻 (SP-N80105)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	83	16	48	133	1500	M16x1	M16x2
15.1	83	16	48	133	1510		
15.2	83	16	48	133	1520		
15.3	83	16	48	133	1530		
15.4	83	16	48	133	1540		
15.5	83	16	48	133	1550	M18x2.5	
15.6	83	16	48	133	1560		
15.7	83	16	48	133	1570		
15.8	83	16	48	133	1580		
15.9	83	16	48	133	1590		
16.0	83	16	48	133	1600	M18x2	
16.1	93	18	48	143	1610		
16.2	93	18	48	143	1620		
16.3	93	18	48	143	1630		
16.4	93	18	48	143	1640		
16.5	93	18	48	143	1650		
16.6	93	18	48	143	1660	3/4-10UNC	
16.7	93	18	48	143	1670		
16.8	93	18	48	143	1680		
16.9	93	18	48	143	1690		
17.0	93	18	48	143	1700	M18x1	
17.1	93	18	48	143	1710		
17.2	93	18	48	143	1720		
17.3	93	18	48	143	1730		
17.4	93	18	48	143	1740		
17.5	93	18	48	143	1750	M20x2.5 3/4-16UNF	
17.6	93	18	48	143	1760		
17.7	93	18	48	143	1770		
17.8	93	18	48	143	1780	3/4-20UNEF	
17.9	93	18	48	143	1790		

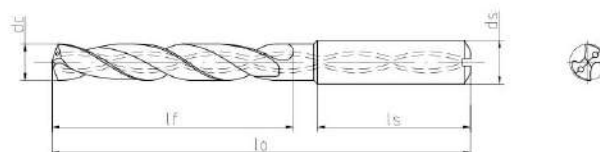
A

硬质合金麻花钻 (SP-N80105)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

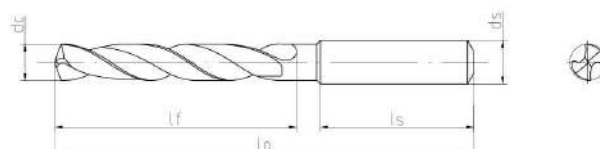
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	93	18	48	143	1800	M20x2	
18.1	101	20	50	153	1810		
18.2	101	20	50	153	1820		
18.3	101	20	50	153	1830		
18.4	101	20	50	153	1840		
18.5	101	20	50	153	1850	M20x1.5	
18.6	101	20	50	153	1860		
18.7	101	20	50	153	1870		
18.8	101	20	50	153	1880		
18.9	101	20	50	153	1890		
19.0	101	20	50	153	1900	M20x1	
19.1	101	20	50	153	1910		
19.2	101	20	50	153	1920		
19.3	101	20	50	153	1930		
19.4	101	20	50	153	1940		
19.5	101	20	50	153	1950		
19.6	101	20	50	153	1960	7/8-9UNC	
19.7	101	20	50	153	1970		
19.8	101	20	50	153	1980		
19.9	101	20	50	153	1990		
20.0	101	20	50	153	2000	M22x2	

硬质合金麻花钻 (SP-N80005)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	28	6	36	66	0300		
3.1	28	6	36	66	0310		
3.2	28	6	36	66	0320		
3.3	28	6	36	66	0330	M4x0.7	
3.4	28	6	36	66	0340	NO.8-32UNC	
3.5	28	6	36	66	0350	M4x0.5 NO.8-36UNF	
3.6	28	6	36	66	0360		
3.7	28	6	36	66	0370		M4x0.7
3.8	36	6	36	74	0380		M4x0.5
3.9	36	6	36	74	0390	NO.10-24UNC	
4.0	36	6	36	74	0400		
4.1	36	6	36	74	0410	NO.10-32UNF	
4.2	36	6	36	74	0420	M5x0.8	
4.3	36	6	36	74	0430		
4.4	36	6	36	74	0440		
4.5	36	6	36	74	0450	M5x0.5 NO.12-24UNC	
4.6	36	6	36	74	0460	NO.12-28UNF	M5x0.8
4.7	36	6	36	74	0470	NO.12-32UNEF	
4.8	44	6	36	82	0480		
4.9	44	6	36	82	0490		
5.0	44	6	36	82	0500	M6x1	
5.1	44	6	36	82	0510	1/4-20UNC	
5.2	44	6	36	82	0520		
5.3	44	6	36	82	0530	M6x0.75	
5.4	44	6	36	82	0540		
5.5	44	6	36	82	0550	1/4-28UNF	M6x1
5.6	44	6	36	82	0560	1/4-32UNEF	
5.7	44	6	36	82	0570		
5.8	44	6	36	82	0580		
5.9	44	6	36	82	0590		

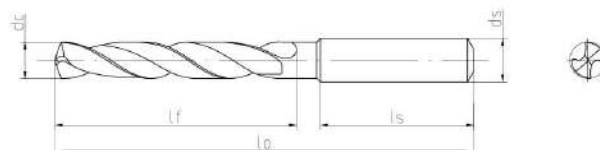
A

硬质合金麻花钻 (SP-N80005)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

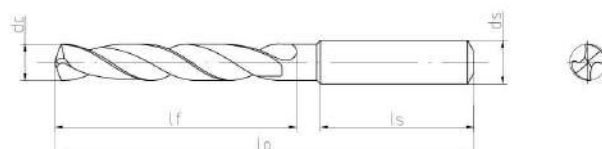
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	44	6	36	82	0600		
6.1	53	8	36	91	0610		
6.2	53	8	36	91	0620		
6.3	53	8	36	91	0630		
6.4	53	8	36	91	0640		
6.5	53	8	36	91	0650		
6.6	53	8	36	91	0660	5/16-18UNC	
6.7	53	8	36	91	0670		
6.8	53	8	36	91	0680	M8x1.25	
6.9	53	8	36	91	0690	5/16-24UNF	
7.0	53	8	36	91	0700	M8x1	
7.1	53	8	36	91	0710	5/16-32UNEF	
7.2	53	8	36	91	0720		
7.3	53	8	36	91	0730	M8x0.75	
7.4	53	8	36	91	0740		M8x1.25
7.5	53	8	36	91	0750		
7.6	53	8	36	91	0760		
7.7	53	8	36	91	0770		
7.8	53	8	36	91	0780		
7.9	53	8	36	91	0790		
8.0	53	8	36	91	0800	3/8-16UNC	
8.1	61	10	40	103	0810		
8.2	61	10	40	103	0820		
8.3	61	10	40	103	0830		
8.4	61	10	40	103	0840		
8.5	61	10	40	103	0850	M10x1.5 3/8-24UNF	
8.6	61	10	40	103	0860		
8.7	61	10	40	103	0870	3/8-32UNEF	
8.8	61	10	40	103	0880	M10x1.25	
8.9	61	10	40	103	0890		

硬质合金麻花钻 (SP-N80005)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	61	10	40	103	0900	M10x1	
9.1	61	10	40	103	0910		
9.2	61	10	40	103	0920		
9.3	61	10	40	103	0930	M10x0.75	M10x1.5
9.4	61	10	40	103	0940	7/16-14UNC	
9.5	61	10	40	103	0950		
9.6	61	10	40	103	0960		
9.7	61	10	40	103	0970		
9.8	61	10	40	103	0980		
9.9	61	10	40	103	0990	7/16-20UNF	
10.0	61	10	40	103	1000		
10.1	71	12	45	118	1010		
10.2	71	12	45	118	1020	7/16-28UNEF	
10.3	71	12	45	118	1030	M12x1.75	
10.4	71	12	45	118	1040		
10.5	71	12	45	118	1050		
10.6	71	12	45	118	1060		
10.7	71	12	45	118	1070		
10.8	71	12	45	118	1080		
10.9	71	12	45	118	1090	1/2-13UNC	
11.0	71	12	45	118	1100	M12x1	
11.1	71	12	45	118	1110		
11.2	71	12	45	118	1120		M12x1.75
11.3	71	12	45	118	1130		
11.4	71	12	45	118	1140		
11.5	71	12	45	118	1150	1/2-20UNF	
11.6	71	12	45	118	1160		
11.7	71	12	45	118	1170		
11.8	71	12	45	118	1180	1/2-28UNEF	
11.9	71	12	45	118	1190		

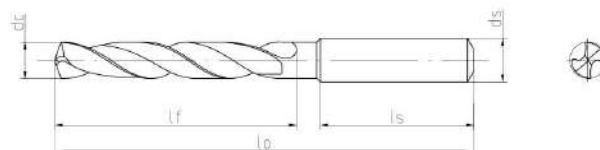
A

硬质合金麻花钻 (SP-N80005)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

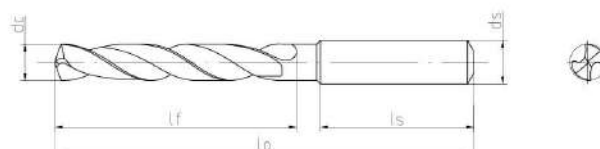
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	71	12	45	118	1200	M14x2	
12.1	77	14	45	124	1210		
12.2	77	14	45	124	1220	9/16-12UNC	
12.3	77	14	45	124	1230		
12.4	77	14	45	124	1240		
12.5	77	14	45	124	1250	M14x1.5	
12.6	77	14	45	124	1260		
12.7	77	14	45	124	1270		
12.8	77	14	45	124	1280		
12.9	77	14	45	124	1290	9/16-18UNF	
13.0	77	14	45	124	1300	M14x1	M14x2
13.1	77	14	45	124	1310		
13.2	77	14	45	124	1320	9/16-24UNEF	
13.3	77	14	45	124	1330		
13.4	77	14	45	124	1340		
13.5	77	14	45	124	1350		
13.6	77	14	45	124	1360	5/8-11UNC	
13.7	77	14	45	124	1370		
13.8	77	14	45	124	1380		
13.9	77	14	45	124	1390		
14.0	77	14	45	124	1400	M16x2	
14.1	83	16	48	133	1410		
14.2	83	16	48	133	1420		
14.3	83	16	48	133	1430		
14.4	83	16	48	133	1440		
14.5	83	16	48	133	1450	M16x1.5 5/8-18UNF	
14.6	83	16	48	133	1460		
14.7	83	16	48	133	1470		
14.8	83	16	48	133	1480	5/8-24UNEF	
14.9	83	16	48	133	1490		

硬质合金麻花钻 (SP-N80005)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	83	16	48	133	1500	M16x1	M16x2
15.1	83	16	48	133	1510		
15.2	83	16	48	133	1520		
15.3	83	16	48	133	1530		
15.4	83	16	48	133	1540		
15.5	83	16	48	133	1550	M18x2.5	
15.6	83	16	48	133	1560		
15.7	83	16	48	133	1570		
15.8	83	16	48	133	1580		
15.9	83	16	48	133	1590		
16.0	83	16	48	133	1600	M18x2	
16.1	93	18	48	143	1610		
16.2	93	18	48	143	1620		
16.3	93	18	48	143	1630		
16.4	93	18	48	143	1640		
16.5	93	18	48	143	1650		
16.6	93	18	48	143	1660	3/4-10UNC	
16.7	93	18	48	143	1670		
16.8	93	18	48	143	1680		
16.9	93	18	48	143	1690		
17.0	93	18	48	143	1700	M18x1	
17.1	93	18	48	143	1710		
17.2	93	18	48	143	1720		
17.3	93	18	48	143	1730		
17.4	93	18	48	143	1740		
17.5	93	18	48	143	1750	M20x2.5 3/4-16UNF	
17.6	93	18	48	143	1760		
17.7	93	18	48	143	1770		
17.8	93	18	48	143	1780	3/4-20UNEF	
17.9	93	18	48	143	1790		

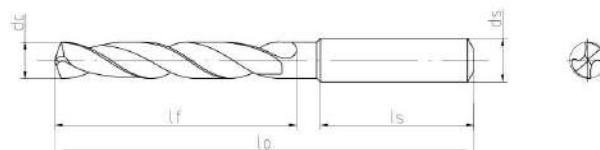
A

硬质合金麻花钻 (SP-N80005)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

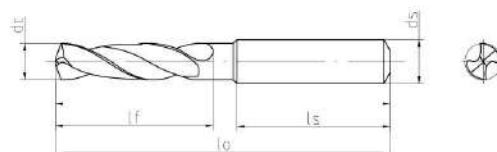
H

订货编号: Order code

Φ · dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	93	18	48	143	1800	M20x2	
18.1	101	20	50	153	1810		
18.2	101	20	50	153	1820		
18.3	101	20	50	153	1830		
18.4	101	20	50	153	1840		
18.5	101	20	50	153	1850	M20x1.5	
18.6	101	20	50	153	1860		
18.7	101	20	50	153	1870		
18.8	101	20	50	153	1880		
18.9	101	20	50	153	1890		
19.0	101	20	50	153	1900	M20x1	
19.1	101	20	50	153	1910		
19.2	101	20	50	153	1920		
19.3	101	20	50	153	1930		
19.4	101	20	50	153	1940		
19.5	101	20	50	153	1950		
19.6	101	20	50	153	1960	7/8-9UNC	
19.7	101	20	50	153	1970		
19.8	101	20	50	153	1980		
19.9	101	20	50	153	1990		
20.0	101	20	50	153	2000	M22x2	

硬质合金麻花钻 (SP-X80008)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

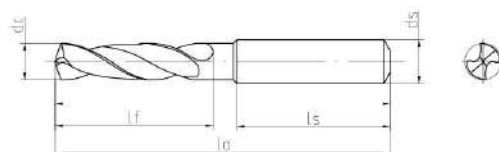
订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	35.5	4	36	75	0300		
3.1	35.5	4	36	75	0310		
3.2	35.5	4	36	75	0320		
3.3	35.5	4	36	75	0330	M4x0.7	
3.4	35.5	4	36	75	0340	NO.8-32UNC	
3.5	35.5	4	36	75	0350	M4x0.5 NO.8-36UNF	
3.6	35.5	4	36	75	0360		
3.7	35.5	4	36	75	0370		M4x0.7
3.8	42	4	36	83	0380		M4x0.5
3.9	42	4	36	83	0390	NO.10-24UNC	
4.0	42	4	36	83	0400		
4.1	50	6	36	90	0410	NO.10-32UNF	
4.2	50	6	36	90	0420	M5x0.8	
4.3	50	6	36	90	0430		
4.4	50	6	36	90	0440		
4.5	50	6	36	90	0450	M5x0.5 NO.12-24UNC	
4.6	50	6	36	90	0460	NO.12-28UNF	M5x0.8
4.7	50	6	36	90	0470	NO.12-32UNEF	
4.8	50	6	36	90	0480		
4.9	50	6	36	90	0490		
5.0	50	6	36	90	0500	M6x1	
5.1	57	6	36	97	0510	1/4-20UNC	
5.2	57	6	36	97	0520		
5.3	57	6	36	97	0530	M6x0.75	
5.4	57	6	36	97	0540		
5.5	57	6	36	97	0550	1/4-28UNF	M6x1
5.6	57	6	36	97	0560	1/4-32UNEF	
5.7	57	6	36	97	0570		
5.8	57	6	36	97	0580		
5.9	57	6	36	97	0590		

A

硬质合金麻花钻 (SP-X80008)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

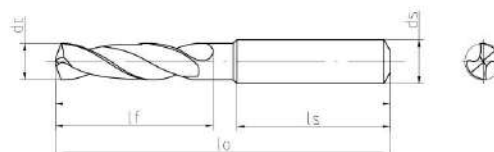
P M K S

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	57	6	36	97	0600		
6.1	66	8	36	106	0610		
6.2	66	8	36	106	0620		
6.3	66	8	36	106	0630		
6.4	66	8	36	106	0640		
6.5	66	8	36	106	0650		
6.6	66	8	36	106	0660	5/16-18UNC	
6.7	66	8	36	106	0670		
6.8	66	8	36	106	0680	M8x1.25	
6.9	76	8	36	116	0690	5/16-24UNF	
7.0	76	8	36	116	0700	M8x1	
7.1	76	8	36	116	0710	5/16-32UNEF	
7.2	76	8	36	116	0720		
7.3	76	8	36	116	0730	M8x0.75	
7.4	76	8	36	116	0740		M8x1.25
7.5	76	8	36	116	0750		
7.6	76	8	36	116	0760		
7.7	76	8	36	116	0770		
7.8	76	8	36	116	0780		
7.9	76	8	36	116	0790		
8.0	76	8	36	116	0800	3/8-16UNC	
8.1	87	10	40	131	0810		
8.2	87	10	40	131	0820		
8.3	87	10	40	131	0830		
8.4	87	10	40	131	0840		
8.5	87	10	40	131	0850	M10x1.5 3/8-24UNF	
8.6	87	10	40	131	0860		
8.7	87	10	40	131	0870	3/8-32UNEF	
8.8	87	10	40	131	0880	M10x1.25	
8.9	87	10	40	131	0890		

硬质合金麻花钻 (SP-X80008)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

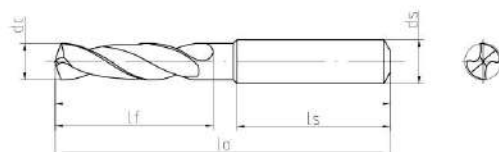
订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	87	10	40	131	0900	M10x1	
9.1	95	10	40	139	0910		
9.2	95	10	40	139	0920		
9.3	95	10	40	139	0930	M10x0.75	M10x1.5
9.4	95	10	40	139	0940	7/16-14UNC	
9.5	95	10	40	139	0950		
9.6	95	10	40	139	0960		
9.7	95	10	40	139	0970		
9.8	95	10	40	139	0980		
9.9	95	10	40	139	0990	7/16-20UNF	
10.0	95	10	40	139	1000		
10.1	106	12	45	155	1010		
10.2	106	12	45	155	1020	7/16-28UNEF	
10.3	106	12	45	155	1030	M12x1.75	
10.4	106	12	45	155	1040		
10.5	106	12	45	155	1050		
10.6	106	12	45	155	1060		
10.7	106	12	45	155	1070		
10.8	106	12	45	155	1080		
10.9	106	12	45	155	1090	1/2-13UNC	
11.0	106	12	45	155	1100	M12x1	
11.1	114	12	45	163	1110		
11.2	114	12	45	163	1120		M12x1.75
11.3	114	12	45	163	1130		
11.4	114	12	45	163	1140		
11.5	114	12	45	163	1150	1/2-20UNF	
11.6	114	12	45	163	1160		
11.7	114	12	45	163	1170		
11.8	114	12	45	163	1180	1/2-28UNEF	
11.9	114	12	45	163	1190		

A

硬质合金麻花钻 (SP-X80008)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

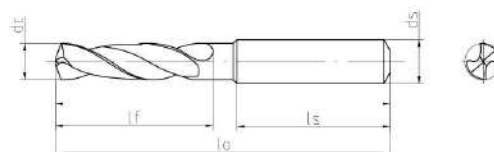
P M K S

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	114	12	45	163	1200	M14x2	
12.1	133	14	45	182	1210		
12.2	133	14	45	182	1220	9/16-12UNC	
12.3	133	14	45	182	1230		
12.4	133	14	45	182	1240		
12.5	133	14	45	182	1250	M14x1.5	
12.6	133	14	45	182	1260		
12.7	133	14	45	182	1270		
12.8	133	14	45	182	1280		
12.9	133	14	45	182	1290	9/16-18UNF	
13.0	133	14	45	182	1300	M14x1	M14x2
13.1	133	14	45	182	1310		
13.2	133	14	45	182	1320	9/16-24UNEF	
13.3	133	14	45	182	1330		
13.4	133	14	45	182	1340		
13.5	133	14	45	182	1350		
13.6	133	14	45	182	1360	5/8-11UNC	
13.7	133	14	45	182	1370		
13.8	133	14	45	182	1380		
13.9	133	14	45	182	1390		
14.0	133	14	45	182	1400	M16x2	
14.1	152	16	48	204	1410		
14.2	152	16	48	204	1420		
14.3	152	16	48	204	1430		
14.4	152	16	48	204	1440		
14.5	152	16	48	204	1450	M16x1.5 5/8-18UNF	
14.6	152	16	48	204	1460		
14.7	152	16	48	204	1470		
14.8	152	16	48	204	1480	5/8-24UNEF	
14.9	152	16	48	204	1490		

硬质合金麻花钻 (SP-X80008)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	152	16	48	204	1500	M16x1	M16x2
15.1	152	16	48	204	1510		
15.2	152	16	48	204	1520		
15.3	152	16	48	204	1530		
15.4	152	16	48	204	1540		
15.5	152	16	48	204	1550	M18x2.5	
15.6	152	16	48	204	1560		
15.7	152	16	48	204	1570		
15.8	152	16	48	204	1580		
15.9	152	16	48	204	1590		
16.0	152	16	48	204	1600	M18x2	
16.1	171	18	48	223	1610		
16.2	171	18	48	223	1620		
16.3	171	18	48	223	1630		
16.4	171	18	48	223	1640		
16.5	171	18	48	223	1650		
16.6	171	18	48	223	1660	3/4-10UNC	
16.7	171	18	48	223	1670		
16.8	171	18	48	223	1680		
16.9	171	18	48	223	1690		
17.0	171	18	48	223	1700	M18x1	
17.1	171	18	48	223	1710		
17.2	171	18	48	223	1720		
17.3	171	18	48	223	1730		
17.4	171	18	48	223	1740		
17.5	171	18	48	223	1750	M20x2.5 3/4-16UNF	
17.6	171	18	48	223	1760		
17.7	171	18	48	223	1770		
17.8	171	18	48	223	1780	3/4-20UNEF	
17.9	171	18	48	223	1790		

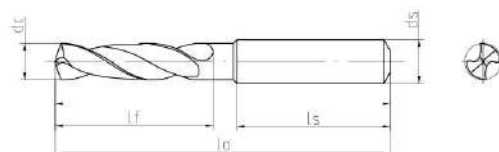
A

硬质合金麻花钻 (SP-X80008)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

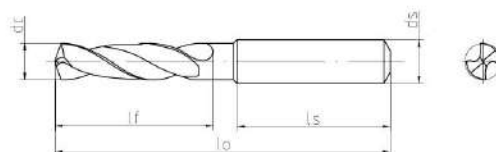
H

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	171	18	48	223	1800	M20x2	
18.1	190	20	50	244	1810		
18.2	190	20	50	244	1820		
18.3	190	20	50	244	1830		
18.4	190	20	50	244	1840		
18.5	190	20	50	244	1850	M20x1.5	
18.6	190	20	50	244	1860		
18.7	190	20	50	244	1870		
18.8	190	20	50	244	1880		
18.9	190	20	50	244	1890		
19.0	190	20	50	244	1900	M20x1	
19.1	190	20	50	244	1910		
19.2	190	20	50	244	1920		
19.3	190	20	50	244	1930		
19.4	190	20	50	244	1940		
19.5	190	20	50	244	1950		
19.6	190	20	50	244	1960	7/8-9UNC	
19.7	190	20	50	244	1970		
19.8	190	20	50	244	1980		
19.9	190	20	50	244	1990		
20.0	190	20	50	244	2000	M22x2	

硬质合金麻花钻 (SP-N80008)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	30	4	36	70	0300		
3.1	30	4	36	70	0310		
3.2	30	4	36	70	0320		
3.3	30	4	36	70	0330	M4x0.7	
3.4	35.5	4	36	75	0340	NO.8-32UNC	
3.5	35.5	4	36	75	0350	M4x0.5 NO.8-36UNF	
3.6	35.5	4	36	75	0360		
3.7	35.5	4	36	75	0370		M4x0.7
3.8	42	4	36	83	0380		M4x0.5
3.9	42	4	36	83	0390	NO.10-24UNC	
4.0	42	4	36	83	0400		
4.1	50	6	36	90	0410	NO.10-32UNF	
4.2	50	6	36	90	0420	M5x0.8	
4.3	50	6	36	90	0430		
4.4	50	6	36	90	0440		
4.5	50	6	36	90	0450	M5x0.5 NO.12-24UNC	
4.6	50	6	36	90	0460	NO.12-28UNF	M5x0.8
4.7	50	6	36	90	0470	NO.12-32UNEF	
4.8	50	6	36	90	0480		
4.9	50	6	36	90	0490		
5.0	50	6	36	90	0500	M6x1	
5.1	57	6	36	97	0510	1/4-20UNC	
5.2	57	6	36	97	0520		
5.3	57	6	36	97	0530	M6x0.75	
5.4	57	6	36	97	0540		
5.5	57	6	36	97	0550	1/4-28UNF	M6x1
5.6	57	6	36	97	0560	1/4-32UNEF	
5.7	57	6	36	97	0570		
5.8	57	6	36	97	0580		
5.9	57	6	36	97	0590		

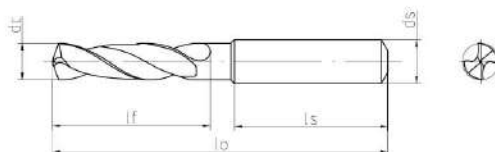
A

硬质合金麻花钻 (SP-N80008)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

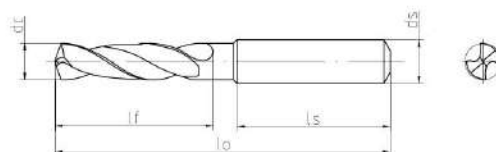
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	57	6	36	97	0600		
6.1	66	8	36	106	0610		
6.2	66	8	36	106	0620		
6.3	66	8	36	106	0630		
6.4	66	8	36	106	0640		
6.5	66	8	36	106	0650		
6.6	66	8	36	106	0660	5/16-18UNC	
6.7	66	8	36	106	0670		
6.8	66	8	36	106	0680	M8x1.25	
6.9	76	8	36	116	0690	5/16-24UNF	
7.0	76	8	36	116	0700	M8x1	
7.1	76	8	36	116	0710	5/16-32UNEF	
7.2	76	8	36	116	0720		
7.3	76	8	36	116	0730	M8x0.75	
7.4	76	8	36	116	0740		M8x1.25
7.5	76	8	36	116	0750		
7.6	76	8	36	116	0760		
7.7	76	8	36	116	0770		
7.8	76	8	36	116	0780		
7.9	76	8	36	116	0790		
8.0	76	8	36	116	0800	3/8-16UNC	
8.1	87	10	40	131	0810		
8.2	87	10	40	131	0820		
8.3	87	10	40	131	0830		
8.4	87	10	40	131	0840		
8.5	87	10	40	131	0850	M10x1.5 3/8-24UNF	
8.6	87	10	40	131	0860		
8.7	87	10	40	131	0870	3/8-32UNEF	
8.8	87	10	40	131	0880	M10x1.25	
8.9	87	10	40	131	0890		

硬质合金麻花钻 (SP-N80008)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	87	10	40	131	0900	M10x1	
9.1	95	10	40	139	0910		
9.2	95	10	40	139	0920		
9.3	95	10	40	139	0930	M10x0.75	M10x1.5
9.4	95	10	40	139	0940	7/16-14UNC	
9.5	95	10	40	139	0950		
9.6	95	10	40	139	0960		
9.7	95	10	40	139	0970		
9.8	95	10	40	139	0980		
9.9	95	10	40	139	0990	7/16-20UNF	
10.0	95	10	40	139	1000		
10.1	106	12	45	155	1010		
10.2	106	12	45	155	1020	7/16-28UNEF	
10.3	106	12	45	155	1030	M12x1.75	
10.4	106	12	45	155	1040		
10.5	106	12	45	155	1050		
10.6	106	12	45	155	1060		
10.7	106	12	45	155	1070		
10.8	106	12	45	155	1080		
10.9	106	12	45	155	1090	1/2-13UNC	
11.0	106	12	45	155	1100	M12x1	
11.1	114	12	45	163	1110		
11.2	114	12	45	163	1120		M12x1.75
11.3	114	12	45	163	1130		
11.4	114	12	45	163	1140		
11.5	114	12	45	163	1150	1/2-20UNF	
11.6	114	12	45	163	1160		
11.7	114	12	45	163	1170		
11.8	114	12	45	163	1180	1/2-28UNEF	
11.9	114	12	45	163	1190		

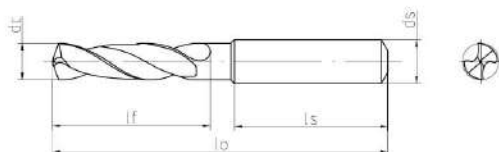
A

硬质合金麻花钻 (SP-N80008)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

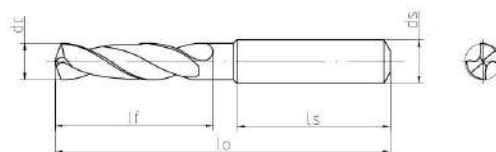
H

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	114	12	45	163	1200	M14x2	
12.1	133	14	45	182	1210		
12.2	133	14	45	182	1220	9/16-12UNC	
12.3	133	14	45	182	1230		
12.4	133	14	45	182	1240		
12.5	133	14	45	182	1250	M14x1.5	
12.6	133	14	45	182	1260		
12.7	133	14	45	182	1270		
12.8	133	14	45	182	1280		
12.9	133	14	45	182	1290	9/16-18UNF	
13.0	133	14	45	182	1300	M14x1	M14x2
13.1	133	14	45	182	1310		
13.2	133	14	45	182	1320	9/16-24UNEF	
13.3	133	14	45	182	1330		
13.4	133	14	45	182	1340		
13.5	133	14	45	182	1350		
13.6	133	14	45	182	1360	5/8-11UNC	
13.7	133	14	45	182	1370		
13.8	133	14	45	182	1380		
13.9	133	14	45	182	1390		
14.0	133	14	45	182	1400	M16x2	
14.1	152	16	48	204	1410		
14.2	152	16	48	204	1420		
14.3	152	16	48	204	1430		
14.4	152	16	48	204	1440		
14.5	152	16	48	204	1450	M16x1.5 5/8-18UNF	
14.6	152	16	48	204	1460		
14.7	152	16	48	204	1470		
14.8	152	16	48	204	1480	5/8-24UNEF	
14.9	152	16	48	204	1490		

硬质合金麻花钻 (SP-N80008)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	152	16	48	204	1500	M16x1	M16x2
15.1	152	16	48	204	1510		
15.2	152	16	48	204	1520		
15.3	152	16	48	204	1530		
15.4	152	16	48	204	1540		
15.5	152	16	48	204	1550	M18x2.5	
15.6	152	16	48	204	1560		
15.7	152	16	48	204	1570		
15.8	152	16	48	204	1580		
15.9	152	16	48	204	1590		
16.0	152	16	48	204	1600	M18x2	
16.1	171	18	48	223	1610		
16.2	171	18	48	223	1620		
16.3	171	18	48	223	1630		
16.4	171	18	48	223	1640		
16.5	171	18	48	223	1650		
16.6	171	18	48	223	1660	3/4-10UNC	
16.7	171	18	48	223	1670		
16.8	171	18	48	223	1680		
16.9	171	18	48	223	1690		
17.0	171	18	48	223	1700	M18x1	
17.1	171	18	48	223	1710		
17.2	171	18	48	223	1720		
17.3	171	18	48	223	1730		
17.4	171	18	48	223	1740		
17.5	171	18	48	223	1750	M20x2.5 3/4-16UNF	
17.6	171	18	48	223	1760		
17.7	171	18	48	223	1770		
17.8	171	18	48	223	1780	3/4-20UNEF	
17.9	171	18	48	223	1790		

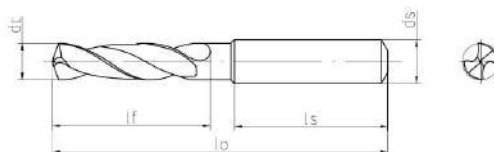
A

硬质合金麻花钻 (SP-N80008)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 精抛槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Fine polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

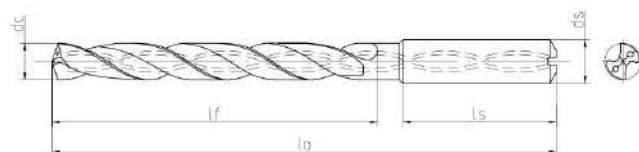
H

订货编号·Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	171	18	48	223	1800	M20x2	
18.1	190	20	50	244	1810		
18.2	190	20	50	244	1820		
18.3	190	20	50	244	1830		
18.4	190	20	50	244	1840		
18.5	190	20	50	244	1850	M20x1.5	
18.6	190	20	50	244	1860		
18.7	190	20	50	244	1870		
18.8	190	20	50	244	1880		
18.9	190	20	50	244	1890		
19.0	190	20	50	244	1900	M20x1	
19.1	190	20	50	244	1910		
19.2	190	20	50	244	1920		
19.3	190	20	50	244	1930		
19.4	190	20	50	244	1940		
19.5	190	20	50	244	1950		
19.6	190	20	50	244	1960	7/8-9UNC	
19.7	190	20	50	244	1970		
19.8	190	20	50	244	1980		
19.9	190	20	50	244	1990		
20.0	190	20	50	244	2000	M22x2	

硬质合金麻花钻 (SP-X80108)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	35.5	4	36	75	0300		
3.1	35.5	4	36	75	0310		
3.2	35.5	4	36	75	0320		
3.3	35.5	4	36	75	0330	M4x0.7	
3.4	35.5	4	36	75	0340	NO.8-32UNC	
3.5	35.5	4	36	75	0350	M4x0.5 NO.8-36UNF	
3.6	35.5	4	36	75	0360		
3.7	35.5	4	36	75	0370		M4x0.7
3.8	42	4	36	83	0380		M4x0.5
3.9	42	4	36	83	0390	NO.10-24UNC	
4.0	42	4	36	83	0400		
4.1	50	6	36	90	0410	NO.10-32UNF	
4.2	50	6	36	90	0420	M5x0.8	
4.3	50	6	36	90	0430		
4.4	50	6	36	90	0440		
4.5	50	6	36	90	0450	M5x0.5 NO.12-24UNC	
4.6	50	6	36	90	0460	NO.12-28UNF	M5x0.8
4.7	50	6	36	90	0470	NO.12-32UNEF	
4.8	50	6	36	90	0480		
4.9	50	6	36	90	0490		
5.0	50	6	36	90	0500	M6x1	
5.1	57	6	36	97	0510	1/4-20UNC	
5.2	57	6	36	97	0520		
5.3	57	6	36	97	0530	M6x0.75	
5.4	57	6	36	97	0540		
5.5	57	6	36	97	0550	1/4-28UNF	M6x1
5.6	57	6	36	97	0560	1/4-32UNEF	
5.7	57	6	36	97	0570		
5.8	57	6	36	97	0580		
5.9	57	6	36	97	0590		

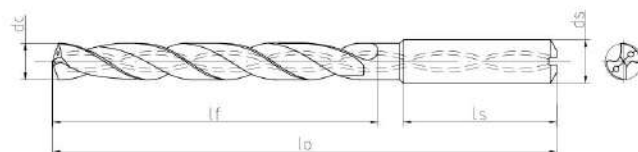
A

硬质合金麻花钻 (SP-X80108)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

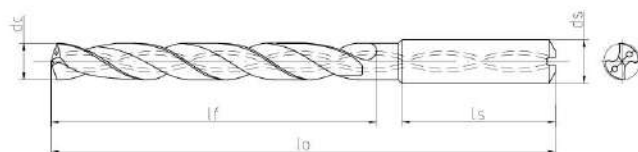
H

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	57	6	36	97	0600		
6.1	66	8	36	106	0610		
6.2	66	8	36	106	0620		
6.3	66	8	36	106	0630		
6.4	66	8	36	106	0640		
6.5	66	8	36	106	0650		
6.6	66	8	36	106	0660	5/16-18UNC	
6.7	66	8	36	106	0670		
6.8	66	8	36	106	0680	M8x1.25	
6.9	76	8	36	116	0690	5/16-24UNF	
7.0	76	8	36	116	0700	M8x1	
7.1	76	8	36	116	0710	5/16-32UNEF	
7.2	76	8	36	116	0720		
7.3	76	8	36	116	0730	M8x0.75	
7.4	76	8	36	116	0740		M8x1.25
7.5	76	8	36	116	0750		
7.6	76	8	36	116	0760		
7.7	76	8	36	116	0770		
7.8	76	8	36	116	0780		
7.9	76	8	36	116	0790		
8.0	76	8	36	116	0800	3/8-16UNC	
8.1	87	10	40	131	0810		
8.2	87	10	40	131	0820		
8.3	87	10	40	131	0830		
8.4	87	10	40	131	0840		
8.5	87	10	40	131	0850	M10x1.5 3/8-24UNF	
8.6	87	10	40	131	0860		
8.7	87	10	40	131	0870	3/8-32UNEF	
8.8	87	10	40	131	0880	M10x1.25	
8.9	87	10	40	131	0890		

硬质合金麻花钻 (SP-X80108)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号 Order code

Φ·d _c 公差 m7	槽长 l _f	柄径 d _s 公差 h6	柄长 l _s	总长 l _o	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	87	10	40	131	0900	M10x1	
9.1	95	10	40	139	0910		
9.2	95	10	40	139	0920		
9.3	95	10	40	139	0930	M10x0.75	M10x1.5
9.4	95	10	40	139	0940	7/16-14UNC	
9.5	95	10	40	139	0950		
9.6	95	10	40	139	0960		
9.7	95	10	40	139	0970		
9.8	95	10	40	139	0980		
9.9	95	10	40	139	0990	7/16-20UNF	
10.0	95	10	40	139	1000		
10.1	106	12	45	155	1010		
10.2	106	12	45	155	1020	7/16-28UNEF	
10.3	106	12	45	155	1030	M12x1.75	
10.4	106	12	45	155	1040		
10.5	106	12	45	155	1050		
10.6	106	12	45	155	1060		
10.7	106	12	45	155	1070		
10.8	106	12	45	155	1080		
10.9	106	12	45	155	1090	1/2-13UNC	
11.0	106	12	45	155	1100	M12x1	
11.1	114	12	45	163	1110		
11.2	114	12	45	163	1120		M12x1.75
11.3	114	12	45	163	1130		
11.4	114	12	45	163	1140		
11.5	114	12	45	163	1150	1/2-20UNF	
11.6	114	12	45	163	1160		
11.7	114	12	45	163	1170		
11.8	114	12	45	163	1180	1/2-28UNEF	
11.9	114	12	45	163	1190		

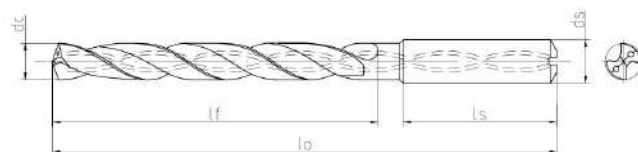
A

硬质合金麻花钻 (SP-X80108)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

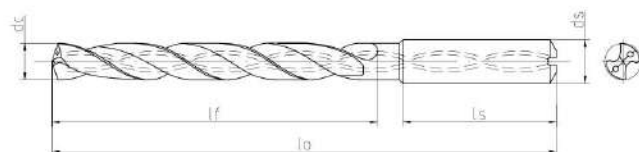
H

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	114	12	45	163	1200	M14x2	
12.1	133	14	45	182	1210		
12.2	133	14	45	182	1220	9/16-12UNC	
12.3	133	14	45	182	1230		
12.4	133	14	45	182	1240		
12.5	133	14	45	182	1250	M14x1.5	
12.6	133	14	45	182	1260		
12.7	133	14	45	182	1270		
12.8	133	14	45	182	1280		
12.9	133	14	45	182	1290	9/16-18UNF	
13.0	133	14	45	182	1300	M14x1	M14x2
13.1	133	14	45	182	1310		
13.2	133	14	45	182	1320	9/16-24UNEF	
13.3	133	14	45	182	1330		
13.4	133	14	45	182	1340		
13.5	133	14	45	182	1350		
13.6	133	14	45	182	1360	5/8-11UNC	
13.7	133	14	45	182	1370		
13.8	133	14	45	182	1380		
13.9	133	14	45	182	1390		
14.0	133	14	45	182	1400	M16x2	
14.1	152	16	48	204	1410		
14.2	152	16	48	204	1420		
14.3	152	16	48	204	1430		
14.4	152	16	48	204	1440		
14.5	152	16	48	204	1450	M16x1.5 5/8-18UNF	
14.6	152	16	48	204	1460		
14.7	152	16	48	204	1470		
14.8	152	16	48	204	1480	5/8-24UNEF	
14.9	152	16	48	204	1490		

硬质合金麻花钻 (SP-X80108)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号·Order code

Φ·d _c 公差 m7	槽长 l _f	柄径 d _s 公差 h6	柄长 l _s	总长 l _o	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	152	16	48	204	1500	M16x1	M16x2
15.1	152	16	48	204	1510		
15.2	152	16	48	204	1520		
15.3	152	16	48	204	1530		
15.4	152	16	48	204	1540		
15.5	152	16	48	204	1550	M18x2.5	
15.6	152	16	48	204	1560		
15.7	152	16	48	204	1570		
15.8	152	16	48	204	1580		
15.9	152	16	48	204	1590		
16.0	152	16	48	204	1600	M18x2	
16.1	171	18	48	223	1610		
16.2	171	18	48	223	1620		
16.3	171	18	48	223	1630		
16.4	171	18	48	223	1640		
16.5	171	18	48	223	1650		
16.6	171	18	48	223	1660	3/4-10UNC	
16.7	171	18	48	223	1670		
16.8	171	18	48	223	1680		
16.9	171	18	48	223	1690		
17.0	171	18	48	223	1700	M18x1	
17.1	171	18	48	223	1710		
17.2	171	18	48	223	1720		
17.3	171	18	48	223	1730		
17.4	171	18	48	223	1740		
17.5	171	18	48	223	1750	M20x2.5 3/4-16UNF	
17.6	171	18	48	223	1760		
17.7	171	18	48	223	1770		
17.8	171	18	48	223	1780	3/4-20UNEF	
17.9	171	18	48	223	1790		

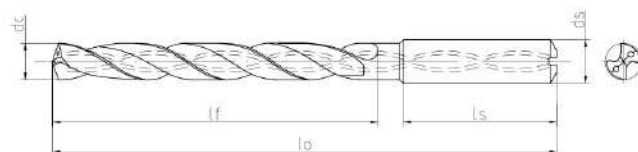
A

硬质合金麻花钻 (SP-X80108)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- AHNO 标准
- 定心力强
- 特殊槽型
- 超高性能刀具
- 通用性强
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Special Flute
- Super performance tools
- Universality on different materials

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

F

G

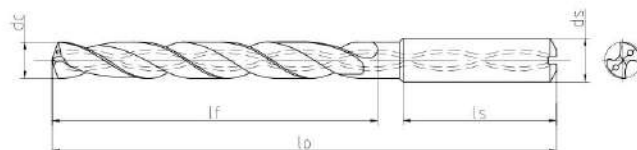
H

订货编号 Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	171	18	48	223	1800	M20x2	
18.1	190	20	50	244	1810		
18.2	190	20	50	244	1820		
18.3	190	20	50	244	1830		
18.4	190	20	50	244	1840		
18.5	190	20	50	244	1850	M20x1.5	
18.6	190	20	50	244	1860		
18.7	190	20	50	244	1870		
18.8	190	20	50	244	1880		
18.9	190	20	50	244	1890		
19.0	190	20	50	244	1900	M20x1	
19.1	190	20	50	244	1910		
19.2	190	20	50	244	1920		
19.3	190	20	50	244	1930		
19.4	190	20	50	244	1940		
19.5	190	20	50	244	1950		
19.6	190	20	50	244	1960	7/8-9UNC	
19.7	190	20	50	244	1970		
19.8	190	20	50	244	1980		
19.9	190	20	50	244	1990		
20.0	190	20	50	244	2000	M22x2	

硬质合金麻花钻 (SP-N80108)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

适合加工材料: N

Suitable for materials: N

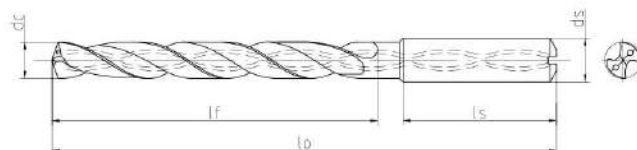
订货编号: Order code

Φ · dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	30	4	36	70	0300		
3.1	30	4	36	70	0310		
3.2	30	4	36	70	0320		
3.3	30	4	36	70	0330	M4x0.7	
3.4	35.5	4	36	75	0340	NO.8-32UNC	
3.5	35.5	4	36	75	0350	M4x0.5 NO.8-36UNF	
3.6	35.5	4	36	75	0360		
3.7	35.5	4	36	75	0370		M4x0.7
3.8	42	4	36	83	0380		M4x0.5
3.9	42	4	36	83	0390	NO.10-24UNC	
4.0	42	4	36	83	0400		
4.1	50	6	36	90	0410	NO.10-32UNF	
4.2	50	6	36	90	0420	M5x0.8	
4.3	50	6	36	90	0430		
4.4	50	6	36	90	0440		
4.5	50	6	36	90	0450	M5x0.5 NO.12-24UNC	
4.6	50	6	36	90	0460	NO.12-28UNF	M5x0.8
4.7	50	6	36	90	0470	NO.12-32UNEF	
4.8	50	6	36	90	0480		
4.9	50	6	36	90	0490		
5.0	50	6	36	90	0500	M6x1	
5.1	57	6	36	97	0510	1/4-20UNC	
5.2	57	6	36	97	0520		
5.3	57	6	36	97	0530	M6x0.75	
5.4	57	6	36	97	0540		
5.5	57	6	36	97	0550	1/4-28UNF	M6x1
5.6	57	6	36	97	0560	1/4-32UNEF	
5.7	57	6	36	97	0570		
5.8	57	6	36	97	0580		
5.9	57	6	36	97	0590		

A

硬质合金麻花钻 (SP-N80108)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

D

适合加工材料: N

Suitable for materials: N

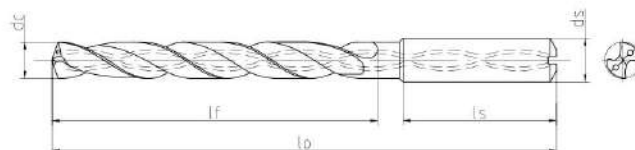
订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
6.0	57	6	36	97	0600		
6.1	66	8	36	106	0610		
6.2	66	8	36	106	0620		
6.3	66	8	36	106	0630		
6.4	66	8	36	106	0640		
6.5	66	8	36	106	0650		
6.6	66	8	36	106	0660	5/16-18UNC	
6.7	66	8	36	106	0670		
6.8	66	8	36	106	0680	M8x1.25	
6.9	76	8	36	116	0690	5/16-24UNF	
7.0	76	8	36	116	0700	M8x1	
7.1	76	8	36	116	0710	5/16-32UNEF	
7.2	76	8	36	116	0720		
7.3	76	8	36	116	0730	M8x0.75	
7.4	76	8	36	116	0740		M8x1.25
7.5	76	8	36	116	0750		
7.6	76	8	36	116	0760		
7.7	76	8	36	116	0770		
7.8	76	8	36	116	0780		
7.9	76	8	36	116	0790		
8.0	76	8	36	116	0800	3/8-16UNC	
8.1	87	10	40	131	0810		
8.2	87	10	40	131	0820		
8.3	87	10	40	131	0830		
8.4	87	10	40	131	0840		
8.5	87	10	40	131	0850	M10x1.5 3/8-24UNF	
8.6	87	10	40	131	0860		
8.7	87	10	40	131	0870	3/8-32UNEF	
8.8	87	10	40	131	0880	M10x1.25	
8.9	87	10	40	131	0890		

H

硬质合金麻花钻 (SP-N80108)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
9.0	87	10	40	131	0900	M10x1	
9.1	95	10	40	139	0910		
9.2	95	10	40	139	0920		
9.3	95	10	40	139	0930	M10x0.75	M10x1.5
9.4	95	10	40	139	0940	7/16-14UNC	
9.5	95	10	40	139	0950		
9.6	95	10	40	139	0960		
9.7	95	10	40	139	0970		
9.8	95	10	40	139	0980		
9.9	95	10	40	139	0990	7/16-20UNF	
10.0	95	10	40	139	1000		
10.1	106	12	45	155	1010		
10.2	106	12	45	155	1020	7/16-28UNEF	
10.3	106	12	45	155	1030	M12x1.75	
10.4	106	12	45	155	1040		
10.5	106	12	45	155	1050		
10.6	106	12	45	155	1060		
10.7	106	12	45	155	1070		
10.8	106	12	45	155	1080		
10.9	106	12	45	155	1090	1/2-13UNC	
11.0	106	12	45	155	1100	M12x1	
11.1	114	12	45	163	1110		
11.2	114	12	45	163	1120		M12x1.75
11.3	114	12	45	163	1130		
11.4	114	12	45	163	1140		
11.5	114	12	45	163	1150	1/2-20UNF	
11.6	114	12	45	163	1160		
11.7	114	12	45	163	1170		
11.8	114	12	45	163	1180	1/2-28UNEF	
11.9	114	12	45	163	1190		

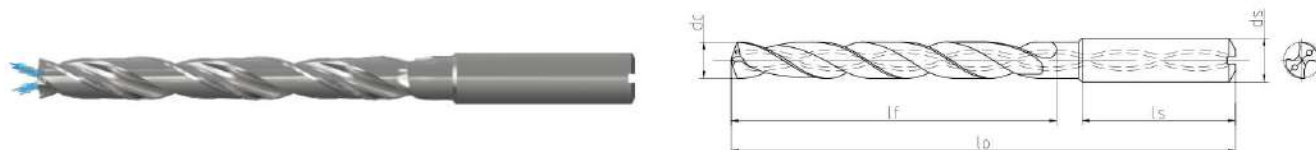
A

硬质合金麻花钻 (SP-N80108)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

D

适合加工材料: N

Suitable for materials: N

E

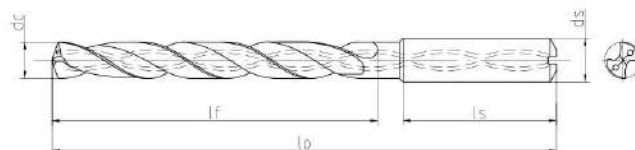
订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
12.0	114	12	45	163	1200	M14x2	
12.1	133	14	45	182	1210		
12.2	133	14	45	182	1220	9/16-12UNC	
12.3	133	14	45	182	1230		
12.4	133	14	45	182	1240		
12.5	133	14	45	182	1250	M14x1.5	
12.6	133	14	45	182	1260		
12.7	133	14	45	182	1270		
12.8	133	14	45	182	1280		
12.9	133	14	45	182	1290	9/16-18UNF	
13.0	133	14	45	182	1300	M14x1	M14x2
13.1	133	14	45	182	1310		
13.2	133	14	45	182	1320	9/16-24UNEF	
13.3	133	14	45	182	1330		
13.4	133	14	45	182	1340		
13.5	133	14	45	182	1350		
13.6	133	14	45	182	1360	5/8-11UNC	
13.7	133	14	45	182	1370		
13.8	133	14	45	182	1380		
13.9	133	14	45	182	1390		
14.0	133	14	45	182	1400	M16x2	
14.1	152	16	48	204	1410		
14.2	152	16	48	204	1420		
14.3	152	16	48	204	1430		
14.4	152	16	48	204	1440		
14.5	152	16	48	204	1450	M16x1.5 5/8-18UNF	
14.6	152	16	48	204	1460		
14.7	152	16	48	204	1470		
14.8	152	16	48	204	1480	5/8-24UNEF	
14.9	152	16	48	204	1490		

H

硬质合金麻花钻 (SP-N80108)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
15.0	152	16	48	204	1500	M16x1	M16x2
15.1	152	16	48	204	1510		
15.2	152	16	48	204	1520		
15.3	152	16	48	204	1530		
15.4	152	16	48	204	1540		
15.5	152	16	48	204	1550	M18x2.5	
15.6	152	16	48	204	1560		
15.7	152	16	48	204	1570		
15.8	152	16	48	204	1580		
15.9	152	16	48	204	1590		
16.0	152	16	48	204	1600	M18x2	
16.1	171	18	48	223	1610		
16.2	171	18	48	223	1620		
16.3	171	18	48	223	1630		
16.4	171	18	48	223	1640		
16.5	171	18	48	223	1650		
16.6	171	18	48	223	1660	3/4-10UNC	
16.7	171	18	48	223	1670		
16.8	171	18	48	223	1680		
16.9	171	18	48	223	1690		
17.0	171	18	48	223	1700	M18x1	
17.1	171	18	48	223	1710		
17.2	171	18	48	223	1720		
17.3	171	18	48	223	1730		
17.4	171	18	48	223	1740		
17.5	171	18	48	223	1750	M20x2.5 3/4-16UNF	
17.6	171	18	48	223	1760		
17.7	171	18	48	223	1770		
17.8	171	18	48	223	1780	3/4-20UNEF	
17.9	171	18	48	223	1790		

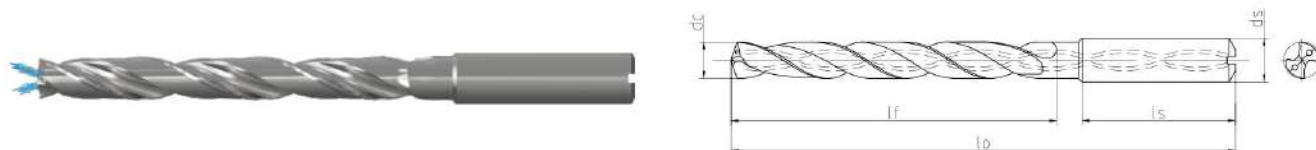
A

硬质合金麻花钻 (SP-N80108)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

D

适合加工材料: N

Suitable for materials: N

E

订货编号: Order code

Φ·dc 公差 m7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	171	18	48	223	1800	M20x2	
18.1	190	20	50	244	1810		
18.2	190	20	50	244	1820		
18.3	190	20	50	244	1830		
18.4	190	20	50	244	1840		
18.5	190	20	50	244	1850	M20x1.5	
18.6	190	20	50	244	1860		
18.7	190	20	50	244	1870		
18.8	190	20	50	244	1880		
18.9	190	20	50	244	1890		
19.0	190	20	50	244	1900	M20x1	
19.1	190	20	50	244	1910		
19.2	190	20	50	244	1920		
19.3	190	20	50	244	1930		
19.4	190	20	50	244	1940		
19.5	190	20	50	244	1950		
19.6	190	20	50	244	1960	7/8-9UNC	
19.7	190	20	50	244	1970		
19.8	190	20	50	244	1980		
19.9	190	20	50	244	1990		
20.0	190	20	50	244	2000	M22x2	

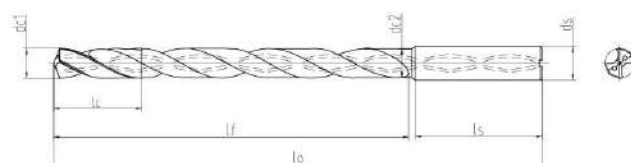
F

G

H

硬质合金麻花钻 (SP-P80112)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- 超高性能刀具
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute
- Super performance tools

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号·Order code

Φ·dc 公差 h7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	54	4	36	92	0300		
3.5	54	4	36	92	0350		
4.0	64	4	36	102	0400		
4.5	64	6	36	102	0450	M5x0.5 NO.12-24UNC	
5.0	80	6	36	118	0500	M6x1	
5.5	80	6	36	118	0550	1/4-28UNF	
6.0	80	6	36	118	0600		M6x1
6.5	108	7	36	146	0650		
7.0	108	8	36	146	0700	M8x1	
7.5	108	8	36	146	0750		
8.0	120	8	36	162	0800	3/8-16UNC	
8.5	120	10	40	162	0850	M10x1.5 3/8-24UNF	
9.0	120	10	40	162	0900	M10x1	
9.5	120	10	40	162	0950		
10.0	120	12	45	162	1000		
10.5	156	12	45	204	1050		
11.0	156	12	45	204	1100	M12x1	
11.5	156	12	45	204	1150	1/2-20UNF	
12.0	156	12	45	204	1200	M14x2	M14x2
12.5	182	14	45	230	1250	M14x1.5	
13.0	182	14	45	230	1300	M14x1	
13.5	182	14	45	230	1350		
14.0	182	14	45	230	1400	M16x2	
14.5	208	16	48	260	1450	M16x1.5 5/8-18UNF	
15.0	208	16	48	260	1500	M16x1	M16x2
15.5	208	16	48	260	1550	M18x2.5	
16.0	208	16	48	260	1600	M18x2	
16.5	234	18	48	285	1650		
17.0	234	18	48	285	1700	M18x1	
17.5	234	18	48	285	1750	M20x2.5 3/4-16UNF	

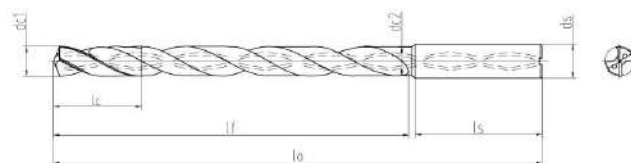
A

硬质合金麻花钻 (SP-P80112)

Carbide Twist Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- 超高性能刀具
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute
- Super performance tools

D

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

E

订货编号 · Order code

Φ · dc 公差 h7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	234	18	48	285	1800	M20x2	
18.5	258	20	50	310	1850	M20x1.5	
19.0	258	20	50	310	1900	M20x1	
19.5	258	20	50	310	1950		
20.0	258	20	50	310	2000	M22x2	

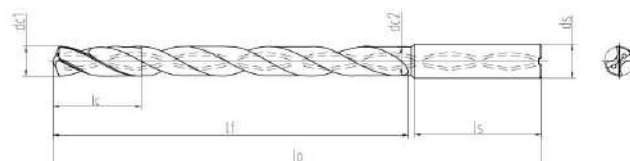
F

G

H

硬质合金麻花钻 (SP-N80112)

Carbide Twist Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

适合加工材料: N

Suitable for materials: N

订货编号: Order code

Φ · d _c 公差 h7	槽长 l _f	柄径 d _s 公差 h6	柄长 l _s	总长 l _o	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	54	4	36	92	0300		
3.5	54	4	36	92	0350		
4.0	64	4	36	102	0400		
4.5	64	6	36	102	0450	M5x0.5 NO.12-24UNC	
5.0	80	6	36	118	0500	M6x1	
5.5	80	6	36	118	0550	1/4-28UNF	
6.0	80	6	36	118	0600		M6x1
6.5	108	7	36	146	0650		
7.0	108	8	36	146	0700	M8x1	
7.5	108	8	36	146	0750		
8.0	120	8	36	162	0800	3/8-16UNC	
8.5	120	10	40	162	0850	M10x1.5 3/8-24UNF	
9.0	120	10	40	162	0900	M10x1	
9.5	120	10	40	162	0950		
10.0	120	10	45	162	1000		
10.5	156	12	45	204	1050		
11.0	156	12	45	204	1100	M12x1	
11.5	156	12	45	204	1150	1/2-20UNF	
12.0	156	12	45	204	1200	M14x2	M14x2
12.5	182	14	45	230	1250	M14x1.5	
13.0	182	14	45	230	1300	M14x1	
13.5	182	14	45	230	1350		
14.0	182	14	45	230	1400	M16x2	
14.5	208	16	48	260	1450	M16x1.5 5/8-18UNF	
15.0	208	16	48	260	1500	M16x1	M16x2
15.5	208	16	48	260	1550	M18x2.5	
16.0	208	16	48	260	1600	M18x2	
16.5	234	18	48	285	1650		
17.0	234	18	48	285	1700	M18x1	
17.5	234	18	48	285	1750	M20x2.5 3/4-16UNF	

A

硬质合金麻花钻 (SP-N80112)

Carbide Twist Drills

12xD

SP

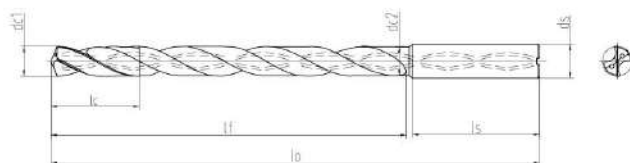
VHM

130°

30°

HA
DIN6535V_c/f
098

B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

D

适合加工材料 : N

Suitable for materials: N

E

订货编号 · Order code

Φ · d _c 公差 h7	槽长 l _f	柄径 d _s 公差 h6	柄长 l _s	总长 l _o	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
18.0	234	18	48	285	1800	M20x2	
18.5	258	20	50	310	1850	M20x1.5	
19.0	258	20	50	310	1900	M20x1	
19.5	258	20	50	310	1950		
20.0	258	20	50	310	2000	M22x2	

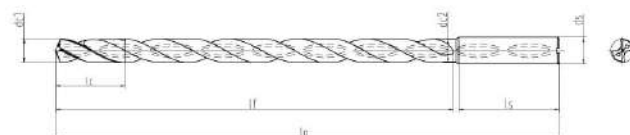
F

G

H

深孔钻 (SP-P80115)

Deep Hole Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 强化刃型
- 特殊槽型
- 超高性能刀具
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Enhanced edge
- Special flute
- Super performance tools

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P P M M K K S S

订货编号·Order code

Φ·dc 公差 h7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	55	4	36	95	0300		
3.5	55	4	36	95	0350		
4.0	71	4	36	109	0400		
4.5	93	6	36	133	0450	M5x0.5 NO.12-24UNC	
5.0	105	6	36	145	0500	M6x1	
5.5	105	6	36	145	0550	1/4-28UNF	
6.0	110	6	36	148	0600		M6x1
6.5	120	7	36	162	0650		
7.0	120	8	36	162	0700	M8x1	
7.5	137	8	36	180	0750		
8.0	137	8	36	180	0800		
8.5	160	10	40	204	0850	3/8-16UNC	
9.0	160	10	40	204	0900	M10x1.5 3/8-24UNF	
9.5	175	10	40	221	0950	M10x1	
10.0	175	10	40	221	1000		
10.5	198	12	45	247	1050		
11.0	198	12	45	247	1100	M12x1	
11.5	213	12	45	263	1150	1/2-20UNF	
12.0	213	12	45	263	1200	M14x2	M14x2
12.5	248	14	45	297	1250	M14x1.5	
13.0	248	14	45	297	1300	M14x1	
13.5	248	14	45	297	1350		
14.0	248	14	45	297	1400	M16x2	
14.5	258	16	48	313	1450	M16x1.5 5/8-18UNF	
15.0	258	16	48	313	1500	M16x1	M16x2

A

深孔钻 (SP-N80115)

Deep Hole Drills

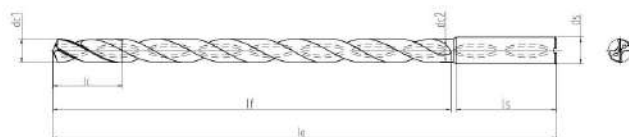
15×D

SP

VHM



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

D

适合加工材料: N

Suitable for materials: N

E

F

G

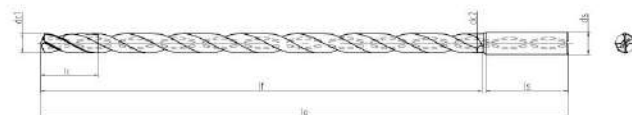
H

订货编号: Order code

Φ·dc 公差 h7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	55	4	36	95	0300		
3.5	55	4	36	95	0350		
4.0	71	4	36	109	0400		
4.5	93	6	36	133	0450	M5x0.5 NO.12-24UNC	
5.0	105	6	36	145	0500	M6x1	
5.5	105	6	36	145	0550	1/4-28UNF	
6.0	110	6	36	148	0600		M6x1
6.5	120	7	36	162	0650		
7.0	120	8	36	162	0700	M8x1	
7.5	137	8	36	180	0750		
8.0	137	8	36	180	0800	3/8-16UNC	
8.5	160	10	40	204	0850	M10x1.5 3/8-24UNF	
9.0	160	10	40	204	0900	M10x1	
9.5	175	10	40	221	0950		
10.0	175	10	40	221	1000		
10.5	198	12	45	247	1050		
11.0	198	12	45	247	1100	M12x1	
11.5	213	12	45	263	1150	1/2-20UNF	
12.0	213	12	45	263	1200	M14x2	M14x2
12.5	248	14	45	297	1250	M14x1.5	
13.0	248	14	45	297	1300	M14x1	
13.5	248	14	45	297	1350		
14.0	248	14	45	297	1400	M16x2	
14.5	258	16	48	313	1450	M16x1.5 5/8-18UNF	
15.0	258	16	48	313	1500	M16x1	M16x2

深孔钻 (SP-P80120)

Deep Hole Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 强化刃型
- 特殊槽型
- 超高性能刀具
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Enhanced edge
- Special flute
- Super performance tools

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P P M M K K S S

订货编号·Order code

Φ·dc 公差 h7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	70	4	36	110	0300	M4x0.5 NO.8-36UNF	
3.5	91	4	36	129	0350		
4.0	91	4	36	129	0400	M5x0.5 NO.12-24UNC	
4.5	118	6	36	158	0450		
5.0	118	6	36	158	0500		
5.5	134	6	36	172	0550	M6x1	M6x1
6.0	134	6	36	172	0600	1/4-28UNF	
6.5	162	7	36	200	0650		
7.0	162	8	36	200	0700	M8x1	
7.5	184	8	36	222	0750		
8.0	184	8	36	222	0800	3/8-16UNC	
8.5	205	10	40	249	0850		
9.0	205	10	40	249	0900	M10x1	
9.5	227	10	40	271	0950		
10.0	227	10	40	271	1000		

A

深孔钻 (SP-N80120)

Deep Hole Drills

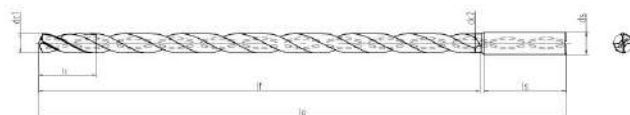
20×D

SP

VHM



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

D

适合加工材料 : N

Suitable for materials: N

E

订货编号·Order code

Φ·dc 公差 h7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	70	4	36	110	0300		
3.5	91	4	36	129	0350	M4x0.5 NO.8-36UNF	
4.0	91	4	36	129	0400		
4.5	118	6	36	158	0450	M5x0.5 NO.12-24UNC	
5.0	118	6	36	158	0500	M6x1	
5.5	134	6	36	172	0550	1/4-28UNF	M6x1
6.0	134	6	36	172	0600		
6.5	162	7	36	200	0650		
7.0	162	8	36	200	0700	M8x1	
7.5	184	8	36	222	0750		
8.0	184	8	36	222	0800	3/8-16UNC	
8.5	205	10	40	249	0850		
9.0	205	10	40	249	0900	M10x1	
9.5	227	10	40	271	0950		
10.0	227	10	40	271	1000		

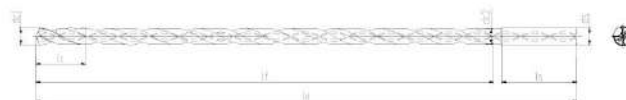
F

G

H

深孔钻 (SP-P80125)

Deep Hole Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 强化刃型
- 特殊槽型
- 超高性能刀具
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Enhanced edge
- Special flute
- Super performance tools

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号·Order code

Φ·dc 公差 h7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	85	4	36	125	0300		
3.5	116	4	36	156	0350	M4x0.5 NO.8-36UNF	
4.0	116	4	36	156	0400		
4.5	145	6	36	183	0450	M5x0.5 NO.12-24UNC	
5.0	145	6	36	183	0500	M6x1	
5.5	170	6	36	210	0550	1/4-28UNF	M6x1
6.0	170	6	36	210	0600		
6.5	197	7	36	237	0650		
7.0	197	8	36	237	0700	M8x1	
7.5	220	8	36	260	0750		
8.0	220	8	36	260	0800	3/8-16UNC	
8.5	250	10	40	294	0850	M10x15 3/8-24UNF	
9.0	250	10	40	294	0900	M10x1	
9.5	277	10	40	321	0950		
10.0	277	10	40	321	1000		

A

深孔钻 (SP-N80125)

Deep Hole Drills

25×D

SP

VHM



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

D

适合加工材料 : N

Suitable for materials: N

E

订货编号·Order code

Φ·dc 公差 h7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	85	4	36	125	0300		
3.5	116	4	36	156	0350	M4x0.5 NO.8-36UNF	
4.0	116	4	36	156	0400		
4.5	145	6	36	183	0450	M5x0.5 NO.12-24UNC	
5.0	145	6	36	183	0500	M6x1	
5.5	170	6	36	210	0550	1/4-28UNF	M6x1
6.0	170	6	36	210	0600		
6.5	197	7	36	237	0650		
7.0	197	8	36	237	0700	M8x1	
7.5	220	8	36	260	0750		
8.0	220	8	36	260	0800	3/8-16UNC	
8.5	250	10	40	294	0850	M10x15 3/8-24UNF	
9.0	250	10	40	294	0900	M10x1	
9.5	277	10	40	321	0950		
10.0	277	10	40	321	1000		

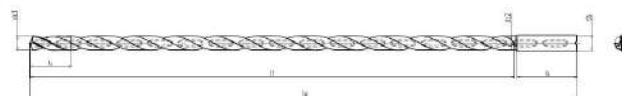
F

G

H

深孔钻 (SP-P80130)

Deep Hole Drills



- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 强化刃型
- 特殊槽型
- 超高性能刀具
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Enhanced edge
- Special flute
- Super performance tools

适合加工材料: P、M、K、S Suitable for materials: P、M、K、S

P M K S

订货编号·Order code

Φ·dc 公差 h7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	100	4	36	140	0300	M4x0.5 NO.8-36UNF	
3.5	136	4	36	176	0350		
4.0	136	4	36	176	0400	M5x0.5 NO.12-24UNC	
4.5	168	6	36	208	0450	M6x1	
5.0	168	6	36	208	0500	1/4-28UNF	M6x1
5.5	180	6	36	232	0550		
6.0	180	6	36	232	0600		
6.5	232	7	36	272	0650	M8x1	
7.0	232	8	36	272	0700		
7.5	263	8	36	303	0750	3/8-16UNC	
8.0	263	8	36	303	0800		

A

深孔钻 (SP-N80130)

Deep Hole Drills



B



C

- 尺寸形式 参考 DIN6537 标准制造
- 横刃修正 AHNO 标准
- 定心力强
- 抛光槽型
- Manufacturing standard: DIN 6537
- Chisel edge regrinding: AHNO standard
- Good centering performance
- Polished flute

D

适合加工材料: N

Suitable for materials: N

E

订货编号: Order code

Φ · dc 公差 h7	槽长 lf	柄径 ds 公差 h6	柄长 ls	总长 lo	尺寸编号 Dimension Code	丝锥推荐 Recommended Tap	
						切削丝锥 Cutting Tap	挤压丝锥 Forming Tap
3.0	100	4	36	140	0300	M4x0.5 NO.8-36UNF	
3.5	136	4	36	176	0350		
4.0	136	4	36	176	0400	M5x0.5 NO.12-24UNC	
4.5	168	6	36	208	0450	M6x1	
5.0	168	6	36	208	0500	1/4-28UNF	M6x1
5.5	180	6	36	232	0550		
6.0	180	6	36	232	0600		
6.5	232	7	36	272	0650	M8x1	
7.0	232	8	36	272	0700		
7.5	263	8	36	303	0750	3/8-16UNC	
8.0	263	8	36	303	0800		

F

G

H

SP-X 标准品推荐切削条件

Recommended Cutting Parameters for SP-X Standard Products

应用范围	P (钢件材料)				M (不锈钢材料)	
材料分类	冷轧钢、低碳钢、易切钢等	结构钢、渗碳钢、表面硬化钢、铸钢等	渗碳钢、表面硬化钢、调质钢、中 / 高碳素钢等	特殊热处理钢、冷作工具钢、渗氮钢等	铁素体结构、马氏体结构	奥氏体结构
强度极限	$\leq 600\text{N/mm}^2$	$\leq 800\text{N/mm}^2$	$\leq 1000\text{N/mm}^2$	$\leq 1200\text{N/mm}^2$	$\leq 950\text{N/mm}^2$	$\leq 950\text{N/mm}^2$
材料举例	DC01、ST15/S234JR 20#、1008/10Sb20、Y15Pb、SUN23、SPCE	E360 (St70-2)、Y15Pb、SUN23、16MnCr5、GS-25CrMo4、ZG1Cr13	20MoCr3、SCM415、SAE5120H、42CrMo4、4135、102Cr6、CK45	50CrMo4、35CrMoV、X45NiCrMo4、31CrMo12 38CrMoAL	X2CrTi12、SS430 SS445、9Cr18	X6CrNiMoTi17-12-12 0Cr18Ni9、SS316
加工条件	切削速度 Vc 每钻进给 f (m/min) (mm/r)	切削速度 Vc 每钻进给 f (m/min) (mm/r)	切削速度 Vc 每钻进给 f (m/min) (mm/r)	切削速度 Vc 每钻进给 f (m/min) (mm/r)	切削速度 Vc 每钻进给 f (m/min) (mm/r)	切削速度 Vc 每钻进给 f (m/min) (mm/r)

刃径 $\phi D_c(\text{mm})$	外冷式 推荐切削条件 External Coolant											
3.0	50-70	0.08-0.12	50-60	0.06-0.10	40-60	0.06-0.10	30-50	0.05-0.1	20-30	0.05-0.10	15-25	0.05-0.10
~4.0	50-70	0.10-0.15	50-60	0.06-0.10	40-60	0.06-0.10	30-50	0.05-0.1	20-30	0.05-0.10	15-25	0.05-0.10
~5.0	50-70	0.10-0.15	50-60	0.10-0.15	40-60	0.10-0.15	30-50	0.05-0.1	20-30	0.05-0.10	20-30	0.05-0.10
~6.0	50-70	0.15-0.20	50-60	0.10-0.15	40-60	0.10-0.15	30-50	0.10-0.15	20-30	0.05-0.10	25-35	0.05-0.10
~8.0	60-80	0.20-0.30	50-70	0.15-0.25	50-70	0.15-0.25	40-60	0.10-0.15	20-40	0.08-0.15	25-40	0.08-0.15
~10.0	60-80	0.20-0.30	50-70	0.15-0.25	50-70	0.15-0.25	40-60	0.15-0.20	20-40	0.08-0.15	30-40	0.08-0.15
~12.0	60-80	0.20-0.30	50-70	0.20-0.30	50-70	0.20-0.30	40-60	0.15-0.20	20-40	0.08-0.15	30-50	0.08-0.15
~16.0	70-90	0.25-0.30	60-80	0.20-0.30	50-70	0.20-0.30	40-60	0.20-0.25	30-50	0.10-0.20	30-50	0.10-0.20
~20.0	70-90	0.25-0.35	60-80	0.20-0.30	50-70	0.20-0.30	40-60	0.20-0.25	30-50	0.10-0.20	30-50	0.10-0.20

刃径 $\phi D_c(\text{mm})$	内冷式 推荐切削条件 Internal Coolant											
3.0	60-80	0.08-0.12	50-70	0.06-0.10	50-70	0.06-0.10	40-60	0.05-0.1	30-40	0.05-0.10	20-30	0.05-0.10
~4.0	60-80	0.10-0.15	50-70	0.06-0.10	50-70	0.06-0.10	40-60	0.05-0.1	30-40	0.05-0.10	20-30	0.05-0.10
~5.0	60-80	0.10-0.15	50-70	0.10-0.15	50-70	0.10-0.15	40-60	0.05-0.1	30-40	0.05-0.10	25-35	0.05-0.10
~6.0	60-80	0.15-0.20	50-70	0.10-0.15	50-70	0.10-0.15	40-60	0.10-0.15	30-40	0.05-0.10	30-40	0.05-0.10
~8.0	70-90	0.20-0.30	60-80	0.15-0.25	60-80	0.15-0.25	50-70	0.10-0.15	40-50	0.08-0.15	30-45	0.08-0.15
~10.0	70-90	0.20-0.30	60-80	0.15-0.25	60-80	0.15-0.25	50-70	0.15-0.20	40-50	0.08-0.15	30-45	0.08-0.15
~12.0	70-90	0.20-0.30	60-80	0.20-0.30	60-80	0.20-0.30	50-70	0.15-0.20	40-50	0.08-0.15	30-50	0.08-0.15
~16.0	80-100	0.25-0.30	70-90	0.20-0.30	60-80	0.20-0.30	50-70	0.20-0.25	50-60	0.10-0.20	30-50	0.10-0.20
~20.0	80-100	0.25-0.35	70-90	0.20-0.30	60-80	0.20-0.30	50-70	0.20-0.25	50-60	0.10-0.20	30-50	0.10-0.20

SP-X 标准品推荐切削条件

Recommended Cutting Parameters for SP-X Standard Products

应用范围	K (铸铁材料)				N (有色金属材料)			
材料分类	片状石墨铸铁 (GJL)		球墨铸铁 (GJS)		锻铝、铜		铸铝、铜	
强度极限	100-450N/mm ²		350-900N/mm ²					
材料举例	EN-GJL-200(GG20)、HT250 EN-GJL-200(GG20)、HT250		EN-GJS-400-15(GGG40)、QT400 EN-GJS-700-2(GGG70)、QT700					
加工条件	切削速度 Vc (m/min)	每钻进给 f (mm/r)	切削速度 Vc (m/min)	每钻进给 f (mm/r)	切削速度 Vc (m/min)	每钻进给 f (mm/r)	切削速度 Vc (m/min)	每钻进给 f (mm/r)

SP-N 标准品推荐切削条件

Recommended Cutting Parameters for SP-N Standard Products

刃径 ΦDc(mm)	外冷式 推荐切削条件 External Coolant							
3.0	60-90	0.10-0.15	40-70	0.08-0.12	80-100	0.08-0.1	100-120	0.08-0.1
~4.0	60-90	0.10-0.15	40-70	0.10-0.15	80-100	0.1-0.15	100-120	0.1-0.15
~5.0	60-90	0.15-0.20	40-70	0.10-0.15	80-100	0.1-0.15	100-120	0.1-0.15
~6.0	60-90	0.15-0.20	40-70	0.15-0.20	80-100	0.1-0.15	100-120	0.1-0.15
~8.0	70-100	0.20-0.30	50-80	0.20-0.30	100-120	0.15-0.2	110-130	0.15-0.2
~10.0	70-100	0.20-0.30	50-80	0.20-0.30	100-120	0.15-0.2	110-130	0.15-0.2
~12.0	70-100	0.20-0.30	50-80	0.20-0.30	100-120	0.2-0.3	110-130	0.2-0.3
~16.0	80-110	0.25-0.35	60-90	0.25-0.30	100-120	0.25-0.3	120-150	0.25-0.3
~20.0	80-110	0.30-0.35	60-90	0.25-0.35	100-120	0.25-0.35	120-150	0.25-0.35

刃径 ΦDc(mm)	内冷式 推荐切削条件 Internal Coolant							
3.0	70-100	0.10-0.15	50-80	0.08-0.12	100-120	0.08-0.1	150-180	0.08-0.1
~4.0	70-100	0.10-0.15	50-80	0.10-0.15	100-120	0.1-0.15	150-180	0.1-0.15
~5.0	70-100	0.15-0.20	50-80	0.10-0.15	100-120	0.1-0.15	150-180	0.1-0.15
~6.0	70-100	0.15-0.20	50-80	0.15-0.20	100-120	0.1-0.15	150-180	0.1-0.15
~8.0	80-110	0.20-0.30	60-90	0.20-0.30	120-140	0.15-0.2	180-220	0.15-0.2
~10.0	80-110	0.20-0.30	60-90	0.20-0.30	120-140	0.15-0.2	180-220	0.15-0.2
~12.0	80-110	0.20-0.30	60-90	0.20-0.30	120-140	0.2-0.3	180-220	0.2-0.3
~16.0	90-120	0.25-0.35	70-100	0.25-0.30	140-160	0.25-0.3	220-250	0.25-0.3
~20.0	90-120	0.30-0.35	70-100	0.25-0.35	140-160	0.25-0.35	220-250	0.25-0.35



*EXCHANGEABLE
DRILLS*

可换式钻头 >>>

风电行业

Wind Power Industry



工程机械行业

Construction Machinery Industry



热交换器行业

Heat Exchanger Industry



案例 Case	EP197-P
工件材料 Workpiece Material	Q345
零件 Parts	热交换管板 Heat Exchange Tube Plate

	AHNO	竞争对手
钻尖 Diameter	EP197-P-1950	D19.5 钻尖
直径 Diameter	19.50mm	19.50mm
材质 Material Grade	P20	
Vc (线速度 m/min)	85.7	85.7
S (转速 r/min)	1400	1400
F (进给 mm/min)	316	316
f (每齿进给 mm/r)	0.22	0.22
孔深 Drilling Depth	45	45
寿命 Tool Life	1100 孔	750 孔

EP - G 88 1 03 - 14 - B 20

1 2 3 4 5 6 7 8

1
系列名称 Series Name
EP经济型 Economy

2
G通用系列 General Series

3
钻头结构 Drill Structure
88 后拉式 Back pull

4
冷却形式 Cooling form
1 内冷 Internal cooling

5
长径比 L/D
03 三倍径 3xD
05 五倍径 5xD
07 七倍径 7xD
08 八倍径 8xD
10 十倍径 10xD
12 十二倍径 12xD

6
钻杆刃径 Drill Body·DC
14 14.00mm
15 15.00mm
16 16.00mm
181 18.01mm
.....

7
钻杆柄部标准 Drill Body Shank Type
A DIN1835A
B DIN1835B
E DIN1835HE

8
钻杆柄径 Drill Body·SD
16 16.00mm
20 20.00mm
25 25.00mm
32 32.00mm
40 40.00mm

钻头命名规则 Drill Name Code

EP197 - P - 1600

1 2 3

1
钻头形式 Drill type
EP197 DW型 DW
EP065 四平面A型 Quadriplanar A
EP060 双弧面A型 Double Cabochon A
EP100 三尖E型 Tricuspid E
.....

2
被加工材料 Processed material
P 钢件材料 Steel materials
M 不锈钢材料 Stainless steel materials
K 铸铁材料 Cast materials
N 有色金属 Non-ferrous metal
S 钛合金、镍基合金、钴基合金、铁基合金 Titanium alloy nickel-based alloy cobalt-based alloy iron-based alloy
H 高硬材料 High hard materials

3
钻头直径 Drill diameter
1600 16.00mm
1630 16.30mm
.....

穿山甲钻头 (EP197-P/M)

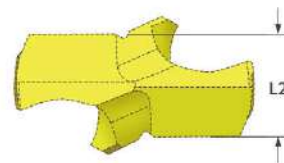
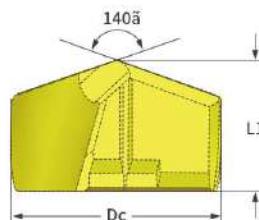
Pangolin Drill



EP197-P



EP197-M



订货号 Order Code	切削刃数量 Cutting Edges No.	Dc	L2	L1	刀座尺寸 Seat Size	对应穿山甲钻杆 Matching Drill Body
EP197-P-1250	2	12.50	5.4	10.6	C	EP-G8810.-125-B16
EP197-P-1270	2	12.70	5.4	10.6	C	
EP197-P-1280	2	12.80	5.4	10.6	C	
EP197-P-1300	2	13.00	5.4	10.6	C	EP-G8810.-13-B16
EP197-P-1310	2	13.10	5.4	10.6	C	
EP197-P-1320	2	13.20	5.4	10.6	C	
EP197-P-1350	2	13.50	5.4	10.6	C	EP-G8810.-135-B16
EP197-P-1351	2	13.51	5.8	11.1	B	EP-G8810.-136-B16
EP197-P-1370	2	13.70	5.8	11.1	B	
EP197-P-1380	2	13.80	5.8	11.1	B	
EP197-P-1389	2	13.89	5.8	11.1	B	
EP197-P-1400	2	14.00	5.8	11.1	B	EP-G8810.-14-B16
EP197-P-1410	2	14.10	5.8	11.1	B	
EP197-P-1420	2	14.20	5.8	11.1	B	
EP197-P-1429	2	14.29	5.8	11.1	B	
EP197-P-1440	2	14.40	5.8	11.1	B	EP-G8810.-145-B16
EP197-P-1450	2	14.50	5.8	11.1	B	
EP197-P-1451	2	14.51	6.2	11.6	A	EP-G8810.-146-B20
EP197-P-1468	2	14.68	6.2	11.6	A	
EP197-P-1480	2	14.80	6.2	11.6	A	
EP197-P-1500	2	15.00	6.2	11.6	A	EP-G8810.-15-B20
EP197-P-1508	2	15.08	6.2	11.6	A	
EP197-P-1530	2	15.30	6.2	11.6	A	
EP197-P-1550	2	15.50	6.2	11.6	A	EP-G8810.-155-B20
EP197-P-1560	2	15.60	6.2	11.6	A	
EP197-P-1570	2	15.70	6.2	11.6	A	
EP197-P-1580	2	15.80	6.2	11.6	A	
EP197-P-1588	2	15.88	7.0	12.6	1	EP-G8810.-16-B20
EP197-P-1600	2	16.00	7.0	12.6	1	
EP197-P-1610	2	16.10	7.0	12.6	1	
EP197-P-1620	2	16.20	7.0	12.6	1	
EP197-P-1625	2	16.25	7.0	12.6	1	
EP197-P-1633	2	16.33	7.0	12.6	1	
EP197-P-1640	2	16.40	7.0	12.6	1	
EP197-P-1650	2	16.50	7.0	12.6	1	
EP197-P-1690	2	16.90	7.0	12.6	1	

订购示例: EP197 - P - 1900 如选择 EP197 - P - 1900 (加工 P 类材料); EP197 - M - 1900 (加工 M 类材料)

Example Ordering: EP197-P-1900 such as EP197-P-1900(workpiece material type P); EP197-M-1900(workpiece material type M)

穿山甲钻头 (EP197-P/M)

Pangolin Drill

订货号 Order Code	切削刃数量 Cutting Edges No.	Dc	L2	L1	刀座尺寸 Seat Size	对应穿山甲钻杆 Matching Drill Body
EP197-P-1700	2	17.00	7.0	12.6	1	EP-G8810.-17-B20
EP197-P-1724	2	17.24	7.0	12.6	1	
EP197-P-1740	2	17.40	7.0	12.6	1	
EP197-P-1750	2	17.50	7.0	12.6	1	
EP197-P-1760	2	17.60	7.0	12.6	1	
EP197-P-1786	2	17.86	7.0	12.6	1	EP-G8810.-18-B20
EP197-P-1800	2	18.00	7.0	12.6	1	
EP197-P-1801	2	18.01	7.5	13.6	2	EP-G8810.-181-B25
EP197-P-1826	2	18.26	7.5	13.6	2	
EP197-P-1850	2	18.50	7.5	13.6	2	
EP197-P-1875	2	18.75	7.5	13.6	2	
EP197-P-1890	2	18.90	7.5	13.6	2	
EP197-P-1900	2	19.00	7.5	13.6	2	EP-G8810.-19-B25
EP197-P-1927	2	19.27	7.5	13.6	2	
EP197-P-1930	2	19.30	7.5	13.6	2	
EP197-P-1933	2	19.33	7.5	13.6	2	
EP197-P-1950	2	19.50	7.5	13.6	2	
EP197-P-1990	2	19.90	7.5	13.6	2	EP-G8810.-20-B25
EP197-P-2000	2	20.00	8.5	14.6	3	
EP197-P-2010	2	20.10	8.5	14.6	3	
EP197-P-2060	2	20.60	8.5	14.6	3	
EP197-P-2080	2	20.80	8.5	14.6	3	
EP197-P-2100	2	21.00	8.5	14.6	3	EP-G8810.-21-B25
EP197-P-2143	2	21.43	8.5	14.6	3	
EP197-P-2150	2	21.50	8.5	14.6	3	
EP197-P-2190	2	21.90	8.5	14.6	3	
EP197-P-2200	2	22.00	8.5	14.6	3	EP-G8810.-22-B25
EP197-P-2201	2	22.01	9.5	15.6	4	EP-G8810.-221-B25
EP197-P-2290	2	22.90	9.5	15.6	4	
EP197-P-2300	2	23.00	9.5	15.6	4	EP-G8810.-23-B25
EP197-P-2342	2	23.42	9.5	15.6	4	
EP197-P-2350	2	23.50	9.5	15.6	4	
EP197-P-2390	2	23.90	9.5	15.6	4	
EP197-P-2400	2	24.00	9.5	15.6	4	EP-G8810.-24-B25
EP197-P-2401	2	24.01	10.0	16.6	5	EP-G8810.-241-B32
EP197-P-2450	2	24.50	10.0	16.6	5	
EP197-P-2461	2	24.61	10.0	16.6	5	
EP197-P-2490	2	24.90	10.0	16.6	5	
EP197-P-2500	2	25.00	10.0	16.6	5	EP-G8810.-25-B32
EP197-P-2527	2	25.27	10.0	16.6	5	
EP197-P-2533	2	25.33	10.0	16.6	5	
EP197-P-2540	2	25.40	10.0	16.6	5	
EP197-P-2567	2	25.67	10.0	16.6	5	
EP197-P-2600	2	26.00	10.0	16.6	5	EP-G8810.-26-B32
EP197-P-2601	2	26.01	11.0	17.6	6	EP-G8810.-261-B32
EP197-P-2619	2	26.19	11.0	17.6	6	
EP197-P-2650	2	26.50	11.0	17.6	6	
EP197-P-2690	2	26.90	11.0	17.6	6	

订购示例: EP197-P-1900 如选择 EP197-P-1900 (加工 P 类材料); EP197-M-1900 (加工 M 类材料)

Example Ordering: EP197-P-1900 such as EP197-P-1900(workpiece material type P); EP197-M-1900(workpiece material type M)

穿山甲钻头 (EP197-P/M)

Pangolin Drill

订货号 Order Code	切削刃数量 Cutting Edges No.	Dc	L2	L1	刀座尺寸 Seat Size	对应穿山甲钻杆 Matching Drill Body
EP197-P-2700	2	27.00	11.0	17.6	6	EP-G8810.-27-B32
EP197-P-2750	2	27.50	11.0	17.6	6	
EP197-P-2790	2	27.90	11.0	17.6	6	
EP197-P-2800	2	28.00	11.0	17.6	6	EP-G8810.-28-B32
EP197-P-2801	2	28.01	12.0	18.6	7	
EP197-P-2818	2	28.18	12.0	18.6	7	
EP197-P-2850	2	28.50	12.0	18.6	7	EP-G8810.-281-B32
EP197-P-2890	2	28.90	12.0	18.6	7	
EP197-P-2900	2	29.00	12.0	18.6	7	
EP197-P-2937	2	29.37	12.0	18.6	7	EP-G8810.-29-B32
EP197-P-2950	2	29.50	12.0	18.6	7	
EP197-P-2990	2	29.90	12.0	18.6	7	
EP197-P-3000	2	30.00	12.0	18.6	7	EP-G8810.-30-B32
EP197-P-3001	2	30.01	12.5	19.6	8	
EP197-P-3016	2	30.16	12.5	19.6	8	
EP197-P-3050	2	30.50	12.5	19.6	8	EP-G8810.-301-B32
EP197-P-3090	2	30.90	12.5	19.6	8	
EP197-P-3100	2	31.00	12.5	19.6	8	
EP197-P-3150	2	31.50	12.5	19.6	8	EP-G8810.-31-B32
EP197-P-3175	2	31.75	12.5	19.6	8	
EP197-P-3200	2	32.00	12.5	19.6	8	
EP197-P-3201	2	32.01	14.0	20.6	9	EP-G8810.-321-B40
EP197-P-3250	2	32.50	14.0	20.6	9	
EP197-P-3300	2	33.00	14.0	20.6	9	
EP197-P-3334	2	33.34	14.0	20.6	9	EP-G8810.-33-B40
EP197-P-3400	2	34.00	14.0	20.6	9	
EP197-P-3413	2	34.13	14.0	20.6	9	
EP197-P-3493	2	34.93	14.0	20.6	9	EP-G8810.-34-B40
EP197-P-3500	2	35.00	14.0	20.6	9	
EP197-P-3550	2	35.55	14.0	20.6	9	
EP197-P-3600	2	36.00	14.0	20.6	9	EP-G8810.-36-B40
EP197-P-3601	2	36.01	15.0	22.6	10	
EP197-P-3700	2	37.00	15.0	22.6	10	
EP197-P-3750	2	37.50	15.0	22.6	10	EP-G8810.-37-B40
EP197-P-3800	2	38.00	15.0	22.6	10	
EP197-P-3810	2	38.10	15.0	22.6	10	
EP197-P-3850	2	38.50	15.0	22.6	10	EP-G8810.-38-B40
EP197-P-3900	2	39.00	15.0	22.6	10	
EP197-P-3950	2	39.50	15.0	22.6	10	
EP197-P-4000	2	40.00	15.0	22.6	10	EP-G8810.-39-B40
EP197-P-4100	2	41.00	15.0	22.6	10	
EP197-P-4200	2	42.00	15.0	22.6	10	

订购示例: EP197 - P - 1900 如选择 EP197 - P - 1900 (加工 P 类材料); EP197 - M - 1900 (加工 M 类材料)

Example Ordering: EP197-P-1900 such as EP197-P-1900(workpiece material type P); EP197-M-1900(workpiece material type M)

穿山甲钻头 (EP065-P/M/K/N/S)

Pangolin Drill



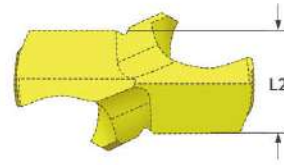
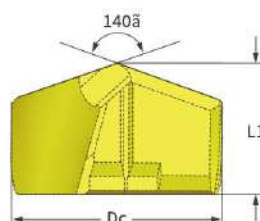
EP065-P



EP065-M



EP065-S



订货号 Order Code	切削刃数量 Cutting Edges No.	Dc	L2	L1	刀座尺寸 Seat Size	对应穿山甲钻杆 Matching Drill Body
EP065-P-1250	2	12.50	5.4	10.6	C	EP-G8810.-125-B16
EP065-P-1270	2	12.70	5.4	10.6	C	
EP065-P-1280	2	12.80	5.4	10.6	C	
EP065-P-1300	2	13.00	5.4	10.6	C	EP-G8810.-13-B16
EP065-P-1310	2	13.10	5.4	10.6	C	
EP065-P-1320	2	13.20	5.4	10.6	C	
EP065-P-1350	2	13.50	5.4	10.6	C	EP-G8810.-135-B16
EP065-P-1351	2	13.51	5.8	11.1	B	EP-G8810.-136-B16
EP065-P-1370	2	13.70	5.8	11.1	B	
EP065-P-1380	2	13.80	5.8	11.1	B	
EP065-P-1389	2	13.89	5.8	11.1	B	EP-G8810.-14-B16
EP065-P-1400	2	14.00	5.8	11.1	B	
EP065-P-1410	2	14.10	5.8	11.1	B	
EP065-P-1420	2	14.20	5.8	11.1	B	EP-G8810.-145-B16
EP065-P-1429	2	14.29	5.8	11.1	B	
EP065-P-1440	2	14.40	5.8	11.1	B	
EP065-P-1450	2	14.50	5.8	11.1	B	EP-G8810.-145-B16
EP065-P-1451	2	14.51	6.2	11.6	A	EP-G8810.-146-B20
EP065-P-1468	2	14.68	6.2	11.6	A	
EP065-P-1480	2	14.80	6.2	11.6	A	
EP065-P-1500	2	15.00	6.2	11.6	A	EP-G8810.-15-B20
EP065-P-1508	2	15.08	6.2	11.6	A	
EP065-P-1530	2	15.30	6.2	11.6	A	
EP065-P-1550	2	15.50	6.2	11.6	A	EP-G8810.-155-B20
EP065-P-1560	2	15.60	6.2	11.6	A	
EP065-P-1570	2	15.70	6.2	11.6	A	
EP065-P-1580	2	15.80	6.2	11.6	A	EP-G8810.-16-B20
EP065-P-1588	2	15.88	7.0	12.6	1	
EP065-P-1600	2	16.00	7.0	12.6	1	
EP065-P-1610	2	16.10	7.0	12.6	1	EP-G8810.-16-B20
EP065-P-1620	2	16.20	7.0	12.6	1	
EP065-P-1625	2	16.25	7.0	12.6	1	
EP065-P-1633	2	16.33	7.0	12.6	1	EP-G8810.-16-B20
EP065-P-1640	2	16.40	7.0	12.6	1	
EP065-P-1650	2	16.50	7.0	12.6	1	
EP065-P-1690	2	16.90	7.0	12.6	1	

订购示例: EP065-P-1900 如选择 EP065-P-1900 (加工 P 类材料); EP065-M-1900 (加工 M 类材料) EP065-S-1900 (加工 S 类材料)

Example Ordering: EP065-P-1900 such as EP065-P-1900(workpiece material type P); EP065-M-1900(workpiece material type M); EP065-S-1900(workpiece material type S)

穿山甲钻头 (EP065-P/M/K/N/S)

Pangolin Drill

订货号 Order Code	切削刃数量 Cutting Edges No.	Dc	L2	L1	刀座尺寸 Seat Size	对应穿山甲钻杆 Matching Drill Body
EP065-P-1700	2	17.00	7.0	12.6	1	EP-G8810.-17-B20
EP065-P-1724	2	17.24	7.0	12.6	1	
EP065-P-1740	2	17.40	7.0	12.6	1	
EP065-P-1750	2	17.50	7.0	12.6	1	
EP065-P-1760	2	17.60	7.0	12.6	1	
EP065-P-1786	2	17.86	7.0	12.6	1	EP-G8810.-18-B20
EP065-P-1800	2	18.00	7.0	12.6	1	
EP065-P-1801	2	18.01	7.5	13.6	2	EP-G8810.-181-B25
EP065-P-1826	2	18.26	7.5	13.6	2	
EP065-P-1850	2	18.50	7.5	13.6	2	
EP065-P-1875	2	18.75	7.5	13.6	2	
EP065-P-1890	2	18.90	7.5	13.6	2	
EP065-P-1900	2	19.00	7.5	13.6	2	EP-G8810.-19-B25
EP065-P-1927	2	19.27	7.5	13.6	2	
EP065-P-1930	2	19.30	7.5	13.6	2	
EP065-P-1933	2	19.33	7.5	13.6	2	
EP065-P-1950	2	19.50	7.5	13.6	2	
EP065-P-1990	2	19.90	7.5	13.6	2	EP-G8810.-20-B25
EP065-P-2000	2	20.00	8.5	14.6	3	
EP065-P-2010	2	20.10	8.5	14.6	3	
EP065-P-2060	2	20.60	8.5	14.6	3	
EP065-P-2080	2	20.80	8.5	14.6	3	
EP065-P-2100	2	21.00	8.5	14.6	3	EP-G8810.-21-B25
EP065-P-2143	2	21.43	8.5	14.6	3	
EP065-P-2150	2	21.50	8.5	14.6	3	
EP065-P-2190	2	21.90	8.5	14.6	3	
EP065-P-2200	2	22.00	8.5	14.6	3	EP-G8810.-22-B25
EP065-P-2201	2	22.01	9.5	15.6	4	EP-G8810.-221-B25
EP065-P-2290	2	22.90	9.5	15.6	4	
EP065-P-2300	2	23.00	9.5	15.6	4	EP-G8810.-23-B25
EP065-P-2342	2	23.42	9.5	15.6	4	
EP065-P-2350	2	23.50	9.5	15.6	4	
EP065-P-2390	2	23.90	9.5	15.6	4	
EP065-P-2400	2	24.00	9.5	15.6	4	EP-G8810.-24-B25
EP065-P-2401	2	24.01	10.0	16.6	5	EP-G8810.-241-B32
EP065-P-2450	2	24.50	10.0	16.6	5	
EP065-P-2461	2	24.61	10.0	16.6	5	
EP065-P-2490	2	24.90	10.0	16.6	5	
EP065-P-2500	2	25.00	10.0	16.6	5	EP-G8810.-25-B32
EP065-P-2527	2	25.27	10.0	16.6	5	
EP065-P-2533	2	25.33	10.0	16.6	5	
EP065-P-2540	2	25.40	10.0	16.6	5	
EP065-P-2567	2	25.67	10.0	16.6	5	
EP065-P-2600	2	26.00	10.0	16.6	5	EP-G8810.-26-B32
EP065-P-2601	2	26.01	11.0	17.6	6	EP-G8810.-261-B32
EP065-P-2619	2	26.19	11.0	17.6	6	
EP065-P-2650	2	26.50	11.0	17.6	6	
EP065-P-2690	2	26.90	11.0	17.6	6	

订购示例: EP065 - P - 1900 如选择 EP065 - P - 1900 (加工 P 类材料); EP065 - M - 1900 (加工 M 类材料) EP065 - S - 1900 (加工 S 类材料)

Example Ordering: EP065-P-1900 such as EP065-P-1900(workpiece material type P); EP065-M-1900(workpiece material type M); EP065-S-1900(workpiece material type S)

穿山甲钻头 (EP065-P/M/K/N/S)

Pangolin Drill

订货号 Order Code	切削刃数量 Cutting Edges No.	Dc	L2	L1	刀座尺寸 Seat Size	对应穿山甲钻杆 Matching Drill Body
EP065-P-2700	2	27.00	11.0	17.6	6	EP-G8810.-27-B32
EP065-P-2750	2	27.50	11.0	17.6	6	
EP065-P-2790	2	27.90	11.0	17.6	6	
EP065-P-2800	2	28.00	11.0	17.6	6	EP-G8810.-28-B32
EP065-P-2801	2	28.01	12.0	18.6	7	
EP065-P-2818	2	28.18	12.0	18.6	7	
EP065-P-2850	2	28.50	12.0	18.6	7	EP-G8810.-281-B32
EP065-P-2890	2	28.90	12.0	18.6	7	
EP065-P-2900	2	29.00	12.0	18.6	7	
EP065-P-2937	2	29.37	12.0	18.6	7	EP-G8810.-29-B32
EP065-P-2950	2	29.50	12.0	18.6	7	
EP065-P-2990	2	29.90	12.0	18.6	7	
EP065-P-3000	2	30.00	12.0	18.6	7	EP-G8810.-30-B32
EP065-P-3001	2	30.01	12.5	19.6	8	
EP065-P-3016	2	30.16	12.5	19.6	8	
EP065-P-3050	2	30.50	12.5	19.6	8	EP-G8810.-301-B32
EP065-P-3090	2	30.90	12.5	19.6	8	
EP065-P-3100	2	31.00	12.5	19.6	8	
EP065-P-3150	2	31.50	12.5	19.6	8	EP-G8810.-31-B32
EP065-P-3175	2	31.75	12.5	19.6	8	
EP065-P-3200	2	32.00	12.5	19.6	8	
EP065-P-3201	2	32.01	14.0	20.6	9	EP-G8810.-321-B40
EP065-P-3250	2	32.50	14.0	20.6	9	
EP065-P-3300	2	33.00	14.0	20.6	9	
EP065-P-3334	2	33.34	14.0	20.6	9	EP-G8810.-33-B40
EP065-P-3400	2	34.00	14.0	20.6	9	
EP065-P-3413	2	34.13	14.0	20.6	9	
EP065-P-3493	2	34.93	14.0	20.6	9	EP-G8810.-34-B40
EP065-P-3500	2	35.00	14.0	20.6	9	
EP065-P-3550	2	35.55	14.0	20.6	9	
EP065-P-3600	2	36.00	14.0	20.6	9	EP-G8810.-36-B40
EP065-P-3601	2	36.01	15.0	22.6	10	
EP065-P-3700	2	37.00	15.0	22.6	10	
EP065-P-3750	2	37.50	15.0	22.6	10	EP-G8810.-37-B40
EP065-P-3800	2	38.00	15.0	22.6	10	
EP065-P-3810	2	38.10	15.0	22.6	10	
EP065-P-3850	2	38.50	15.0	22.6	10	P-G8810.-38-B40
EP065-P-3900	2	39.00	15.0	22.6	10	
EP065-P-3950	2	39.50	15.0	22.6	10	
EP065-P-4000	2	40.00	15.0	22.6	10	EP-G8810.-39-B40
EP065-P-4100	2	41.00	15.0	22.6	10	
EP065-P-4200	2	42.00	15.0	22.6	10	

订购示例: EP065 - P - 1900 如选择 EP065 - P - 1900 (加工 P 类材料); EP065 - M - 1900 (加工 M 类材料) EP065-S-1900(加工 S 类材料)

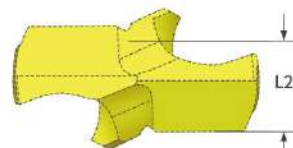
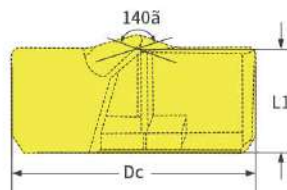
Example Ordering: EP065-P-1900 such as EP065-P-1900(workpiece material type P); EP065-M-1900(workpiece material type M);EP065-S-1900(workpiece material type S)

穿山甲钻头 (EP100-P)

Pangolin Drill



EP100-P



订货号 Order Code	切削刃数量 Cutting Edges No.	Dc	L2	L1	刀座尺寸 Seat Size	对应穿山甲钻杆 Matching Drill Body
EP100-P-1588	2	15.88	7.0	11.6	1	EP-G8810.-16-B20
EP100-P-1600	2	16.00	7.0	11.6	1	
EP100-P-1650	2	16.50	7.0	11.6	1	
EP100-P-1700	2	17.00	7.0	11.6	1	EP-G8810.-17-B20
EP100-P-1750	2	17.50	7.0	11.6	1	
EP100-P-1800	2	18.00	7.0	11.6	1	EP-G8810.-18-B20
EP100-P-1801	2	18.01	7.5	12.6	2	
EP100-P-1850	2	18.50	7.5	12.6	2	EP-G8810.-181-B25
EP100-P-1900	2	19.00	7.5	12.6	2	
EP100-P-1950	2	19.50	7.5	12.6	2	EP-G8810.-19-B25
EP100-P-2000	2	20.00	8.5	13.6	3	
EP100-P-2050	2	20.50	8.5	13.6	3	EP-G8810.-20-B25
EP100-P-2100	2	21.00	8.5	13.6	3	
EP100-P-2150	2	21.50	8.5	13.6	3	EP-G8810.-21-B25
EP100-P-2200	2	22.00	8.5	13.6	3	
EP100-P-2201	2	22.01	9.5	14.6	4	EP-G8810.-22-B25
EP100-P-2250	2	22.50	9.5	14.6	4	
EP100-P-2300	2	23.00	9.5	14.6	4	EP-G8810.-23-B25
EP100-P-2350	2	23.50	9.5	14.6	4	
EP100-P-2400	2	24.00	9.5	14.6	4	EP-G8810.-24-B25
EP100-P-2401	2	24.01	10.0	15.6	5	
EP100-P-2450	2	24.50	10.0	15.6	5	EP-G8810.-241-B32
EP100-P-2500	2	25.00	10.0	15.6	5	
EP100-P-2550	2	25.50	10.0	15.6	5	EP-G8810.-25-B32
EP100-P-2600	2	26.00	10.0	15.6	5	
EP100-P-2601	2	26.01	11.0	16.6	6	EP-G8810.-26-B32
EP100-P-2650	2	26.50	11.0	16.6	6	
EP100-P-2700	2	27.00	11.0	16.6	6	EP-G8810.-261-B32
EP100-P-2750	2	27.50	11.0	16.6	6	
EP100-P-2800	2	28.00	11.0	16.6	6	EP-G8810.-27-B32
						EP-G8810.-28-B32

订购示例: EP100 - P - 1900(加工 P 类材料)

注: EP100 平底钻尖; 具有需要锪平的普通钢材材质的盲孔加工, 不推荐用于难加工材料直接钻孔。

Example Ordering: EP100-P-1900(workpiece material type P)

Note: EP100 is tricuspid drill type; Blind hole machining with ordinary steel material that needs to be countersunk, direct drilling of difficult-to-machine materials is not recommended

穿山甲钻头 (EP100-P)

Pangolin Drill

订货号 Order Code	切削刃数量 Cutting Edges No.	Dc	L2	L1	刀座尺寸 Seat Size	对应穿山甲钻杆 Matching Drill Body
EP100-P-2801	2	28.01	12.0	17.6	7	EP-G8810.-281-B32
EP100-P-2850	2	28.50	12.0	17.6	7	
EP100-P-2900	2	29.00	12.0	17.6	7	EP-G8810.-29-B32
EP100-P-2950	2	29.50	12.0	17.6	7	
EP100-P-3000	2	30.00	12.0	17.6	7	EP-G8810.-30-B32
EP100-P-3001	2	30.01	12.5	18.6	8	EP-G8810.-301-B32
EP100-P-3050	2	30.50	12.5	18.6	8	
EP100-P-3100	2	31.00	12.5	18.6	8	EP-G8810.-31-B32
EP100-P-3150	2	31.50	12.5	18.6	8	
EP100-P-3200	2	32.00	12.5	18.6	8	EP-G8810.-32-B32
EP100-P-3201	2	32.01	14.0	20.6	9	EP-G8810.-321-B40
EP100-P-3250	2	32.50	14.0	20.6	9	
EP100-P-3300	2	33.00	14.0	20.6	9	EP-G8810.-33-B40
EP100-P-3350	2	33.50	14.0	20.6	9	
EP100-P-3400	2	34.00	14.0	20.6	9	EP-G8810.-34-B40
EP100-P-3450	2	34.50	14.0	20.6	9	
EP100-P-3500	2	35.00	14.0	20.6	9	EP-G8810.-35-B40
EP100-P-3550	2	35.55	14.0	20.6	9	
EP100-P-3600	2	36.00	14.0	20.6	9	EP-G8810.-36-B40
EP100-P-3650	2	36.01	15.0	22.6	10	EP-G8810.-361-B40
EP100-P-3700	2	37.00	15.0	22.6	10	
EP100-P-3750	2	37.50	15.0	22.6	10	EP-G8810.-37-B40
EP100-P-3800	2	38.00	15.0	22.6	10	
EP100-P-3810	2	38.10	15.0	22.6	10	EP-G8810.-38-B40
EP100-P-3850	2	38.50	15.0	22.6	10	
EP100-P-3900	2	39.00	15.0	22.6	10	EP-G8810.-39-B40
EP100-P-3950	2	39.50	15.0	22.6	10	
EP100-P-4000	2	40.00	15.0	22.6	10	EP-G8810.-40-B40

订购示例: EP100-P-1900(加工P类材料)

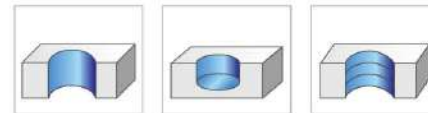
注: EP100 平底钻尖; 具有需要铰平的普通钢材材质的盲孔加工, 不推荐用于难加工材料直接钻孔

Example Ordering: EP100-P-1900(workpiece material type P)

Note: EP100 is tricuspoid drill type; Blind hole machining with ordinary steel material that needs to be countersunk, direct drilling of difficult-to-machine materials is not recommended

穿山甲钻杆 (EP-G88103)

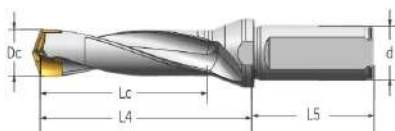
Pangolin Drill Body



适合加工材料: P、M、K、N、S Suitable for materials: P、M、K、N、S

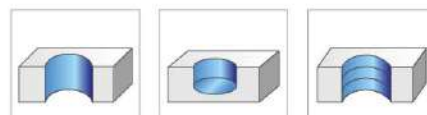


	订货号 Order Code	Lc mm	L4 mm	L5 mm	d mm	刀片尺寸 Seat size	Dc	Dc max
	EP-G88103-125-B16	54	64	48	16	C	12.50	13.00
	EP-G88103-13-B16	54	64	48	16	C	13.00	13.50
	EP-G88103-135-B16	54	64	48	16	C	13.50	13.50
	EP-G88103-136-B16	58	67	48	16	B	13.51	14.00
	EP-G88103-14-B16	58	67	48	16	B	14.00	14.50
	EP-G88103-145-B20	58	67	48	20	B	14.50	14.50
	EP-G88103-146-B20	64	75	50	20	A	14.51	15.00
	EP-G88103-15-B20	64	75	50	20	A	15.00	15.50
	EP-G88103-155-B20	64	75	50	20	A	15.50	15.87
	EP-G88103-16-B20	71	83	50	20	1	15.88	17.00
	EP-G88103-17-B20	71	83	50	20	1	17.00	18.00
	EP-G88103-18-B20	71	83	50	20	1	18.00	18.00
	EP-G88103-181-B25	81	96	56	25	2	18.01	19.00
	EP-G88103-19-B25	81	96	56	25	2	19.00	19.99
	EP-G88103-20-B25	88	102	56	25	3	20.00	21.00
	EP-G88103-21-B25	88	102	56	25	3	21.00	22.00
	EP-G88103-22-B25	88	102	56	25	3	22.00	22.00
	EP-G88103-221-B25	96	109	56	25	4	22.01	23.00
	EP-G88103-23-B25	96	109	56	25	4	23.00	24.00
	EP-G88103-24-B25	96	109	56	25	4	24.00	24.00
	EP-G88103-241-B32	107	125	60	32	5	24.01	25.00
	EP-G88103-25-B32	107	125	60	32	5	25.00	26.00
	EP-G88103-26-B32	107	125	60	32	5	26.00	26.00
	EP-G88103-261-B32	113	130	60	32	6	26.01	27.00
	EP-G88103-27-B32	113	130	60	32	6	27.00	28.00
	EP-G88103-28-B32	113	130	60	32	6	28.00	28.00
	EP-G88103-281-B32	120	136	60	32	7	28.01	29.00
	EP-G88103-29-B32	120	136	60	32	7	29.00	30.00
	EP-G88103-30-B32	120	136	60	32	7	30.00	30.00
	EP-G88103-301-B32	131	148	60	32	8	30.01	31.00
	EP-G88103-31-B32	131	148	60	32	8	31.00	32.00
	EP-G88103-32-B32	131	148	60	32	8	32.00	32.00
	EP-G88103-321-B40	136	159	70	40	9	32.01	33.00
	EP-G88103-33-B40	136	159	70	40	9	33.00	34.00
	EP-G88103-34-B40	136	159	70	40	9	34.00	35.00
	EP-G88103-35-B40	144	166	70	40	9	35.00	36.00
	EP-G88103-36-B40	144	166	70	40	9	36.00	36.00
	EP-G88103-361-B40	153	174	70	40	10	36.01	37.00
	EP-G88103-37-B40	153	174	70	40	10	37.00	38.00
	EP-G88103-38-B40	153	174	70	40	10	38.00	39.00
	EP-G88103-39-B40	162	182	70	40	10	39.00	40.00
	EP-G88103-40-B40	162	182	70	40	10	40.00	41.00
	EP-G88103-41-B40	162	182	70	40	10	41.00	42.00
	EP-G88103-42-B40	162	182	70	40	10	42.00	42.00



穿山甲钻杆 (EP-G88105)

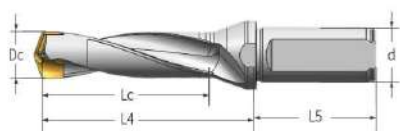
Pangolin Drill Body



适合加工材料: P、M、K、N、S Suitable for materials: P、M、K、N、S

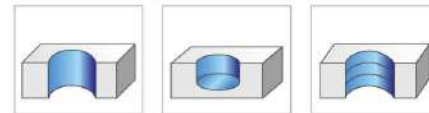
P M K N S

	订货号 Order Code	Lc mm	L4 mm	L5 mm	d mm	刀片尺寸 Seat size	Dc	Dc max
	EP-G88105-125-B16	80	90	48	16	C	12.50	13.00
	EP-G88105-13-B16	80	90	48	16	C	13.00	13.50
	EP-G88105-135-B16	80	90	48	16	C	13.50	13.50
	EP-G88105-136-B16	86	95	48	16	B	13.51	14.00
	EP-G88105-14-B16	86	95	48	16	B	14.00	14.50
	EP-G88105-145-B20	86	95	48	20	B	14.50	14.50
	EP-G88105-146-B20	94	105	50	20	A	14.51	15.00
	EP-G88105-15-B20	94	105	50	20	A	15.00	15.50
	EP-G88105-155-B20	94	105	50	20	A	15.50	15.87
	EP-G88105-16-B20	105	117	50	20	1	15.88	17.00
	EP-G88105-17-B20	105	117	50	20	1	17.00	18.00
	EP-G88105-18-B20	105	117	50	20	1	18.00	18.00
	EP-G88105-181-B25	119	134	56	25	2	18.01	19.00
	EP-G88105-19-B25	119	134	56	25	2	19.00	19.99
	EP-G88105-20-B25	130	144	56	25	3	20.00	21.00
	EP-G88105-21-B25	130	144	56	25	3	21.00	22.00
	EP-G88105-22-B25	130	144	56	25	3	22.00	22.00
	EP-G88105-221-B25	142	155	56	25	4	22.01	23.00
	EP-G88105-23-B25	142	155	56	25	4	23.00	24.00
	EP-G88105-24-B25	142	155	56	25	4	24.00	24.00
	EP-G88105-241-B32	157	175	60	32	5	24.01	25.00
	EP-G88105-25-B32	157	175	60	32	5	25.00	26.00
	EP-G88105-26-B32	157	175	60	32	5	26.00	26.00
	EP-G88105-261-B32	167	184	60	32	6	26.01	27.00
	EP-G88105-27-B32	167	184	60	32	6	27.00	28.00
	EP-G88105-28-B32	167	184	60	32	6	28.00	28.00
	EP-G88105-281-B32	178	194	60	32	7	28.01	29.00
	EP-G88105-29-B32	178	194	60	32	7	29.00	30.00
	EP-G88105-30-B32	178	194	60	32	7	30.00	30.00
	EP-G88105-301-B32	193	210	60	32	8	30.01	31.00
	EP-G88105-31-B32	193	210	60	32	8	31.00	32.00
	EP-G88105-32-B32	193	210	60	32	8	32.00	32.00
	EP-G88105-321-B40	202	225	70	40	9	32.01	33.00
	EP-G88105-33-B40	202	225	70	40	9	33.00	34.00
	EP-G88105-34-B40	202	225	70	40	9	34.00	35.00
	EP-G88105-35-B40	214	236	70	40	9	35.00	36.00
	EP-G88105-36-B40	214	236	70	40	9	36.00	36.00
	EP-G88105-361-B40	227	248	70	40	10	36.01	37.00
	EP-G88105-37-B40	227	248	70	40	10	37.00	38.00
	EP-G88105-38-B40	227	248	70	40	10	38.00	39.00
	EP-G88105-39-B40	240	260	70	40	10	39.00	40.00
	EP-G88105-40-B40	240	260	70	40	10	40.00	41.00
	EP-G88105-41-B40	248	268	70	40	10	41.00	42.00
	EP-G88105-42-B40	248	268	70	40	10	42.00	42.00



穿山甲钻杆 (EP-G88107)

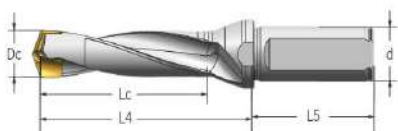
Pangolin Drill Body



适合加工材料: P、M、K、N、S Suitable for materials: P、M、K、N、S



	订货号 Order Code	Lc mm	L4 mm	L5 mm	d mm	刀片尺寸 Seat size	Dc	Dc max
	EP-G88107-125-B16	106	116	48	16	C	12.50	13.00
	EP-G88107-13-B16	106	116	48	16	C	13.00	13.50
	EP-G88107-135-B16	106	116	48	16	C	13.50	13.50
	EP-G88107-136-B16	114	123	48	16	B	13.51	14.00
	EP-G88107-14-B16	114	123	48	16	B	14.00	14.50
	EP-G88107-145-B20	114	123	48	20	B	14.50	14.50
	EP-G88107-146-B20	124	135	50	20	A	14.51	15.00
	EP-G88107-15-B20	124	135	50	20	A	15.00	15.50
	EP-G88107-155-B20	124	135	50	20	A	15.50	15.87
	EP-G88107-16-B20	139	151	50	20	1	15.88	17.00
	EP-G88107-17-B20	139	151	50	20	1	17.00	18.00
	EP-G88107-18-B20	139	151	50	20	1	18.00	18.00
	EP-G88107-181-B25	157	172	56	25	2	18.01	19.00
	EP-G88107-19-B25	157	172	56	25	2	19.00	19.99
	EP-G88107-20-B25	172	186	56	25	3	20.00	21.00
	EP-G88107-21-B25	172	186	56	25	3	21.00	22.00
	EP-G88107-22-B25	172	186	56	25	3	22.00	22.00
	EP-G88107-221-B25	188	201	56	25	4	22.01	23.00
	EP-G88107-23-B25	188	201	56	25	4	23.00	24.00
	EP-G88107-24-B25	188	201	56	25	4	24.00	24.00
	EP-G88107-241-B32	207	225	60	32	5	24.01	25.00
	EP-G88107-25-B32	207	225	60	32	5	25.00	26.00
	EP-G88107-26-B32	207	225	60	32	5	26.00	26.00
	EP-G88107-261-B32	221	238	60	32	6	26.01	27.00
	EP-G88107-27-B32	221	238	60	32	6	27.00	28.00
	EP-G88107-28-B32	221	238	60	32	6	28.00	28.00
	EP-G88107-281-B32	236	252	60	32	7	28.01	29.00
	EP-G88107-29-B32	236	252	60	32	7	29.00	30.00
	EP-G88107-30-B32	236	252	60	32	7	30.00	30.00
	EP-G88107-301-B32	255	272	60	32	8	30.01	31.00
	EP-G88107-31-B32	255	272	60	32	8	31.00	32.00
	EP-G88107-32-B32	255	272	60	32	8	32.00	32.00
	EP-G88107-321-B40	268	291	70	40	9	32.01	33.00
	EP-G88107-33-B40	268	291	70	40	9	33.00	34.00
	EP-G88107-34-B40	268	291	70	40	9	34.00	35.00
	EP-G88107-35-B40	284	306	70	40	9	35.00	36.00
	EP-G88107-36-B40	284	306	70	40	9	36.00	36.00
	EP-G88107-361-B40	301	322	70	40	10	36.01	37.00
	EP-G88107-37-B40	301	322	70	40	10	37.00	38.00
	EP-G88107-38-B40	301	322	70	40	10	38.00	39.00
	EP-G88107-39-B40	318	338	70	40	10	39.00	40.00
	EP-G88107-40-B40	318	338	70	40	10	40.00	41.00
	EP-G88107-41-B40	334	354	70	40	10	41.00	42.00
	EP-G88107-42-B40	334	354	70	40	10	42.00	42.00



穿山甲钻杆 (EP-G88108)

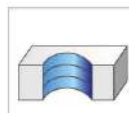
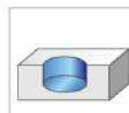
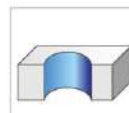
Pangolin Drill Body

Dc
12.5-42

8XDc

140°

Z=2

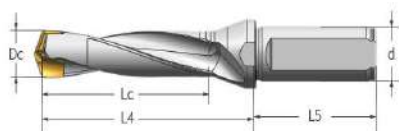


适合加工材料: P、M、K、N、S

Suitable for materials: P、M、K、N、S

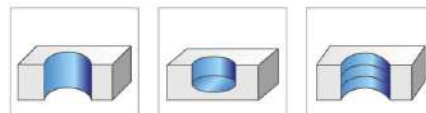
P M K N S

	订货号 Order Code	Lc mm	L4 mm	L5 mm	d mm	刀片尺寸 Seat size	Dc	Dc max
	EP-G88108-125-B16	119	129	48	16	C	12.50	13.00
	EP-G88108-13-B16	119	129	48	16	C	13.00	13.50
	EP-G88108-135-B16	119	129	48	16	C	13.50	13.50
	EP-G88108-136-B16	128	137	48	16	B	13.51	14.00
	EP-G88108-14-B16	128	137	48	16	B	14.00	14.50
	EP-G88108-145-B20	128	137	48	20	B	14.50	14.50
	EP-G88108-146-B20	139	150	50	20	A	14.51	15.00
	EP-G88108-15-B20	139	150	50	20	A	15.00	15.50
	EP-G88108-155-B20	139	150	50	20	A	15.50	15.87
	EP-G88108-16-B20	156	169	50	20	1	15.88	17.00
	EP-G88108-17-B20	156	169	50	20	1	17.00	18.00
	EP-G88108-18-B20	156	169	50	20	1	18.00	18.00
	EP-G88108-181-B25	176	191	56	25	2	18.01	19.00
	EP-G88108-19-B25	176	191	56	25	2	19.00	19.99
	EP-G88108-20-B25	193	207	56	25	3	20.00	21.00
	EP-G88108-21-B25	193	207	56	25	3	21.00	22.00
	EP-G88108-22-B25	193	208	56	25	3	22.00	22.00
	EP-G88108-221-B25	211	224	56	25	4	22.01	23.00
	EP-G88108-23-B25	211	224	56	25	4	23.00	24.00
	EP-G88108-24-B25	211	224	56	25	4	24.00	24.00
	EP-G88108-241-B32	232	250	60	32	5	24.01	25.00
	EP-G88108-25-B32	232	250	60	32	5	25.00	26.00
	EP-G88108-26-B32	232	250	60	32	5	26.00	26.00
	EP-G88108-261-B32	248	265	60	32	6	26.01	27.00
	EP-G88108-27-B32	248	265	60	32	6	27.00	28.00
	EP-G88108-28-B32	248	265	60	32	6	28.00	28.00
	EP-G88108-281-B32	265	281	60	32	7	28.01	29.00
	EP-G88108-29-B32	265	281	60	32	7	29.00	30.00
	EP-G88108-30-B32	265	281	60	32	7	30.00	30.00
	EP-G88108-301-B32	286	303	60	32	8	30.01	31.00
	EP-G88108-31-B32	286	303	60	32	8	31.00	32.00
	EP-G88108-32-B32	286	303	60	32	8	32.00	32.00
	EP-G88108-321-B40	301	324	70	40	9	32.01	33.00
	EP-G88108-33-B40	301	324	70	40	9	33.00	34.00
	EP-G88108-34-B40	301	324	70	40	9	34.00	35.00
	EP-G88108-35-B40	319	341	70	40	9	35.00	36.00
	EP-G88108-36-B40	319	341	70	40	9	36.00	36.00
	EP-G88108-361-B40	338	359	70	40	10	36.01	37.00
	EP-G88108-37-B40	338	359	70	40	10	37.00	38.00
	EP-G88108-38-B40	338	359	70	40	10	38.00	39.00
	EP-G88108-39-B40	357	377	70	40	10	39.00	40.00
	EP-G88108-40-B40	357	377	70	40	10	40.00	41.00
	EP-G88108-41-B40	377	397	70	40	10	41.00	42.00
	EP-G88108-42-B40	377	397	70	40	10	42.00	42.00



穿山甲钻杆 (EP-G88110)

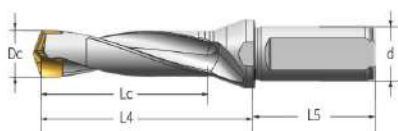
Pangolin Drill Body



适合加工材料: P、M、K、N、S Suitable for materials: P、M、K、N、S



	订货号 Order Code	Lc mm	L4 mm	L5 mm	d mm	刀片尺寸 Seat size	Dc	Dc max
	EP-G88110-125-B16	145	155	48	16	C	12.50	13.00
	EP-G88110-13-B16	145	155	48	16	C	13.00	13.50
	EP-G88110-135-B16	145	155	48	16	C	13.50	13.50
	EP-G88110-136-B16	156	165	48	16	B	13.51	14.00
	EP-G88110-14-B16	156	165	48	16	B	14.00	14.50
	EP-G88110-145-B20	156	165	48	20	B	14.50	14.50
	EP-G88110-146-B20	169	180	50	20	A	14.51	15.00
	EP-G88110-15-B20	169	180	50	20	A	15.00	15.50
	EP-G88110-155-B20	169	180	50	20	A	15.50	15.87
	EP-G88110-16-B20	190	202	50	20	1	15.88	17.00
	EP-G88110-17-B20	190	202	50	20	1	17.00	18.00
	EP-G88110-18-B20	190	202	50	20	1	18.00	18.00
	EP-G88110-181-B25	214	229	56	25	2	18.01	19.00
	EP-G88110-19-B25	214	229	56	25	2	19.00	19.99
	EP-G88110-20-B25	235	249	56	25	3	20.00	21.00
	EP-G88110-21-B25	235	249	56	25	3	21.00	22.00
	EP-G88110-22-B25	235	249	56	25	3	22.00	22.00
	EP-G88110-221-B25	257	270	56	25	4	22.01	23.00
	EP-G88110-23-B25	257	270	56	25	4	23.00	24.00
	EP-G88110-24-B25	257	270	56	25	4	24.00	24.00
	EP-G88110-241-B32	282	300	60	32	5	24.01	25.00
	EP-G88110-25-B32	282	300	60	32	5	25.00	26.00
	EP-G88110-26-B32	282	300	60	32	5	26.00	26.00
	EP-G88110-261-B32	302	319	60	32	6	26.01	27.00
	EP-G88110-27-B32	302	319	60	32	6	27.00	28.00
	EP-G88110-28-B32	302	319	60	32	6	28.00	28.00
	EP-G88110-281-B32	323	339	60	32	7	28.01	29.00
	EP-G88110-29-B32	323	339	60	32	7	29.00	30.00
	EP-G88110-30-B32	323	339	60	32	7	30.00	30.00
	EP-G88110-301-B32	348	365	60	32	8	30.01	31.00
	EP-G88110-31-B32	348	365	60	32	8	31.00	32.00
	EP-G88110-32-B32	348	365	60	32	8	32.00	32.00
	EP-G88110-321-B40	367	390	70	40	9	32.01	33.00
	EP-G88110-33-B40	367	390	70	40	9	33.00	34.00
	EP-G88110-34-B40	367	390	70	40	9	34.00	35.00
	EP-G88110-35-B40	389	411	70	40	9	35.00	36.00
	EP-G88110-36-B40	389	411	70	40	9	36.00	36.00
	EP-G88110-361-B40	412	433	70	40	10	36.01	37.00
	EP-G88110-37-B40	412	433	70	40	10	37.00	38.00
	EP-G88110-38-B40	412	433	70	40	10	38.00	39.00
	EP-G88110-39-B40	435	455	70	40	10	39.00	40.00
	EP-G88110-40-B40	435	455	70	40	10	40.00	41.00
	EP-G88110-41-B40	463	483	70	40	10	41.00	42.00
	EP-G88110-42-B40	463	483	70	40	10	42.00	42.00



A

B

C

D

E

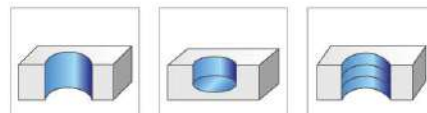
F

G

H

穿山甲钻杆 (EP-G88112)

Pangolin Drill Body



适合加工材料: P、M、K、N、S Suitable for materials: P、M、K、N、S

P M K N S

	订货号 Order Code	Lc mm	L4 mm	L5 mm	d mm	刀片尺寸 Seat size	Dc	Dc max
	EP-G88112-125-B16	171	181	48	16	C	12.50	13.00
	EP-G88112-13-B16	171	181	48	16	C	13.00	13.50
	EP-G88112-135-B16	171	181	48	16	C	13.50	13.50
	EP-G88112-136-B16	184	193	48	16	B	13.51	14.00
	EP-G88112-14-B16	184	193	48	16	B	14.00	14.50
	EP-G88112-145-B20	184	193	48	20	B	14.50	14.50
	EP-G88112-146-B20	199	210	50	20	A	14.51	15.00
	EP-G88112-15-B20	199	210	50	20	A	15.00	15.50
	EP-G88112-155-B20	199	210	50	20	A	15.50	15.87
	EP-G88112-16-B20	224	236	50	20	1	15.88	17.00
	EP-G88112-17-B20	224	236	50	20	1	17.00	18.00
	EP-G88112-18-B20	224	236	50	20	1	18.00	18.00
	EP-G88112-181-B25	252	267	56	25	2	18.01	19.00
	EP-G88112-19-B25	252	267	56	25	2	19.00	19.99
	EP-G88112-20-B25	277	291	56	25	3	20.00	21.00
	EP-G88112-21-B25	277	291	56	25	3	21.00	22.00
	EP-G88112-22-B25	277	291	56	25	3	22.00	22.00
	EP-G88112-221-B25	303	316	56	25	4	22.01	23.00
	EP-G88112-23-B25	303	316	56	25	4	23.00	24.00
	EP-G88112-24-B25	303	316	56	25	4	24.00	24.00
	EP-G88112-241-B32	332	350	60	32	5	24.01	25.00
	EP-G88112-25-B32	332	350	60	32	5	25.00	26.00
	EP-G88112-26-B32	332	350	60	32	5	26.00	26.00
	EP-G88112-261-B32	356	373	60	32	6	26.01	27.00
	EP-G88112-27-B32	356	373	60	32	6	27.00	28.00
	EP-G88112-28-B32	356	373	60	32	6	28.00	28.00
	EP-G88112-281-B32	381	397	60	32	7	28.01	29.00
	EP-G88112-29-B32	381	397	60	32	7	29.00	30.00
	EP-G88112-30-B32	381	397	60	32	7	30.00	30.00
	EP-G88112-301-B32	410	427	60	32	8	30.01	31.00
	EP-G88112-31-B32	410	427	60	32	8	31.00	32.00
	EP-G88112-32-B32	410	427	60	32	8	32.00	32.00
	EP-G88112-321-B40	433	456	70	40	9	32.01	33.00
	EP-G88112-33-B40	433	456	70	40	9	33.00	34.00
	EP-G88112-34-B40	433	456	70	40	9	34.00	35.00
	EP-G88112-35-B40	459	481	70	40	9	35.00	36.00
	EP-G88112-36-B40	459	481	70	40	9	36.00	36.00
	EP-G88112-361-B40	486	507	70	40	10	36.01	37.00
	EP-G88112-37-B40	486	507	70	40	10	37.00	38.00
	EP-G88112-38-B40	486	507	70	40	10	38.00	39.00



钻头安装步骤

Mounting Instruction



1

用鼓风装置对着钻杆头部灰尘吹3-5秒，清理灰尘。

To use the blast device to blow on the head of the tool holder for 3-5 seconds to clean up the dust.

把锁紧螺钉从头部装入，直至螺钉头部低于钻杆顶端。

To use the blast device to blow on the head of the tool holder for 3-5 seconds to clean up the dust.

2



3

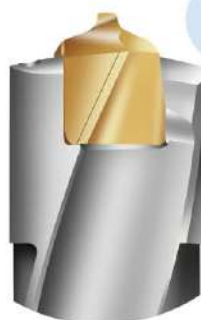
将穿山甲钻尖沿着定位导向面，放置在钻杆的槽部位置，将避空部分压入钻杆，并用手轻轻扶着。

To place the tip drill in the groove of the tool holder along the positioning guide surface, and press the air avoidance part into the tool holder, and gently hold it with your hand.

将扳手从钻杆尾端逆时针旋转直至锁紧螺钉向上顶动穿山甲钻尖。

To reverse the wrench from the end of the tool holder and rotate until the locking screw moves tip drill upward.

4



5

将扳手顺时针旋转，直至把穿山甲钻尖向下与钻杆完全贴合，操作时请注意使用手套，避免因为锋利的钻尖与钻杆造成受伤情况。

To turn the wrench clockwise until the head is completely attached to the tool holder. Please use gloves when operating to avoid injury due to the sharpness of the tools.

穿山甲钻杆（备件 / 附件）

Pangolin Drill Body(Spare Parts/ Accessories)

备件 Central lock screw	Dc/mm	12.5-13.5	13.51-15.87	15.88-19	20-24	24.01-28	28.01-32	32.01-42
	穿山甲螺钉 螺纹尺寸 Pangolin Screw Thread Size	AF312 M2.5L-m2.0	AF313 M3.0L-m2.5	AF315 M3.5L-m2.5	AF316 M4L-m3.0	AF317 M5L-m4	AF318 M6L-m5	AF319 M6L-m6

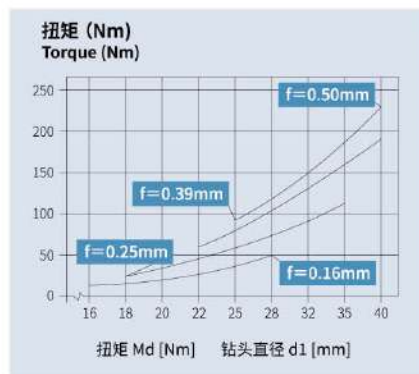
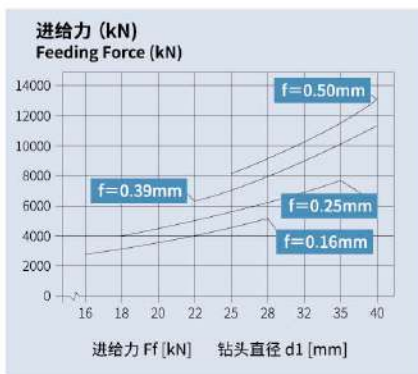
附件 Accessories	Dc/mm	12.5-13.5	13.51-15.87	15.88-19	20-24	24.01-28	28.01-32	32.01-42
	锁紧扳手型号 尺寸 Lock Wrench Size	AF521 T5*155mm	AF531 T6*156mm	AF551 1.5*185mm	AF561 2.0*210mm	AF571 2.5*240mm	AF581 3.0*265mm	
		AF522 T5*187mm	AF532 T6*188mm	AF552 1.5*225mm	AF562 2.0*260mm	AF572 2.5*295mm	AF582 3.0*330mm	AF582 3.0*330mm
		AF523 T5*189mm	AF533 T6*190mm	AF553 1.5*297mm	AF563 2.0*343mm	AF573 2.5*393mm	AF583 3.0*439mm	AF583 3.0*439mm

附件 Accessories	订货号 Order Code	Dc/mm	P	M	K	N	S
	EP197-P	12.50-42.00	● ●		●	●	
	EP197-M	12.50-42.00		● ●		●	
	EP065-S	12.50-42.00	● ●		●	●	● ●

● ● 首选 ● 备选
● ● First Choice ● Alternative

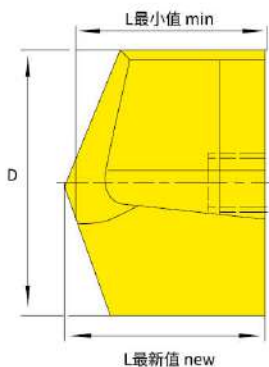
参数参考

Parameter Reference



● 注: 以上图表作为确定驱动功率、进给力、以及扭矩参数使用。 抗拉强度: $R_m=600\text{N/mm}^2$, 采用的基础切削速度为 $v_c=80\text{m/min}$ 。
Note: The above chart is used to determine the driving power, feeding force, and torque parameters. Tensile Strength: $R_m=600\text{N/mm}^2$. Base cutting speed $v_c=80\text{m/min}$.

	刀片安装座尺寸 Cartridge Size	直径范围 D (mm)	L最小值 min (mm)	L最新值 new (mm)
	C	12.50-13.50	8.5	9.6
	B	13.51-14.50	8.9	10.1
	A	14.51-15.88	9.4	10.6
	1	15.88-18.00	10.3	11.6
	2	18.01-19.99	11.2	12.6
	3	20.00-22.00	12.1	13.6
	4	22.01-24.00	13.0	14.6
	5	24.01-26.00	13.9	15.6
	6	26.01-28.00	14.8	16.6
	7	28.01-30.00	15.7	17.6
	8	30.01-32.00	16.6	18.6
	9	32.01-36.00	18.4	20.6
	10	36.01-40.00	20.2	22.6



建议采用以下冷却压力参数

Cooling Pressure Recommendations

相对钻孔深度 Relative Drilling Depth	冷却剂压力 Relative Drilling Depth
1-3XD	8bars
5XD	12bars
7XD	20bars
10XD	30bars

切削参数对照表

Cutting Parameters Recommendation

	应用范围-材料 Range of application-material	抗拉强度 Tensile strength	材料举例 Material examples	钻深 (Drilling depth) 3×D															
				EP-P															
				切削速度 Vc[m/min]			进给量f[mm/rev]												
				钻头直径 (Drill diameter) dc															
14-33mm			14-15.99mm			16-20.99mm			21-25.99mm			26-33mm							
				最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max	
P	钢件材料 Steel																		
	1.1	冷轧钢 Cold Rolled Steel	≤600N/mm²	DC01, SPCE, ST15	80	100	120	0.16	0.2	0.24	0.18	0.24	0.3	0.18	0.24	0.3	0.18	0.24	0.3
		低碳钢 Low Carbon Steel		S235JR(S137-2), 20#, 1008															
		易切钢, 等等 Free Cutting Steel, etc.		10SPb20, Y15Pb, SUN23															
	2.1	结构钢 Structural Steel	≤800N/mm²	E360(S170-2), 20CrMnTi	70	90	110	0.16	0.2	0.24	0.18	0.24	0.3	0.18	0.24	0.3	0.18	0.24	0.3
		渗碳钢, 表面硬化钢 Cemented Steel Surface Hardened Steel		16MnCr5															
		铸钢, 等等 Cast Steel, etc.		GS-25CrMo4, ZG1Cr13, C47H															
	3.1	渗碳钢, 表面硬化钢 Cemented Steel Surface Hardened Steel	≤1000N/mm²	20MoCr3, SCM415, SAE5120H	70	80	110	0.16	0.2	0.24	0.18	0.24	0.3	0.18	0.24	0.3	0.18	0.24	0.3
		调质钢 Modulating Steel		42CrMo4, 4135															
		中、高碳钢, 等等 Medium/High Carbon Steel, etc.		102Cr6, CK45, 70#															
	4.1	特殊热处理钢 Special Heat Treatment Steel	≤1200N/mm²	50CrMo4, 35CrMoV	60	70	90	0.14	0.18	0.22	0.16	0.22	0.28	0.16	0.22	0.28	0.16	0.22	0.28
		冷作工具钢 Cold Working Tool Steel		X45NiCrMo4															
		渗氮钢, 等等 Cemented Steel, etc.		31CrMo12, 38CrMoAl															
	5.1	高合金钢 High Alloy Steel	≤1400N/mm²	X38CrMoV5-3, 60Si2MnA, 50CrVA	50	60	90	0.14	0.18	0.22	0.16	0.22	0.28	0.16	0.22	0.28	0.16	0.22	0.28
		热作工具钢 Hot Working Tool Steel		X100CrMoV8-1-1, 5CrNiTi4															
模具钢, 等等 Mold Steel, etc.		Cr5WMoVS1, 20Cr2Mo2WVNCo																	
	不锈钢材料 Stainless Steel Materials																		
M	1.1	铁素体结构, 马氏体结构 Ferrite Structure Martensite Structure	≤950N/mm²	X2CrTi12, SS430, SS445, 9Cr18	60	70	90	0.14	0.18	0.22	0.16	0.22	0.28	0.16	0.22	0.28	0.16	0.22	0.28
	2.1	奥氏体结构 Stainless Steel Materials	≤950N/mm²	X6CrNiMoTi17-12-2, 0Cr18Ni9, SS316	50	60	70	0.12	0.16	0.2	0.14	0.18	0.22	0.14	0.18	0.22	0.14	0.18	0.22
	3.1	奥氏体-铁素体结构 (双相) Austenitic-Ferrite (Diphase)	≤1100N/mm²	X2CrNiMoN22-5-3, 00Cr23Ni4N, SAF2507	40	50	60	0.1	0.14	0.18	0.12	0.16	0.2	0.12	0.16	0.2	0.12	0.16	0.2
	4.1	奥氏体-马氏体耐热钢 (超双相) Austenitic-Martensite Heat-resistance steel (Super diphase)	≤1250N/mm²	UNS S32550, S32750, 00Cr25Ni7Mo4N	30	40	50	0.1	0.14	0.18	0.12	0.16	0.2	0.12	0.16	0.2	0.12	0.16	0.2
	铸铁材料 Cast Iron Material																		
K	1.1	片状石墨铸铁 (GJL) Flake Graphite Cast Iron	100-250N/mm²	EN-GJL-200(GG20), HT250	120	140	160	0.2	0.24	0.3	0.22	0.26	0.32	0.22	0.26	0.32	0.22	0.26	0.32
	250-450N/mm²		EN-GJL-300(GG30), HT350																
	2.1	球墨铸铁 (GJS) Nodular Cast Iron	350-500N/mm²	EN-GJS-400-15(GG40), QT400	100	120	140	0.2	0.24	0.3	0.22	0.26	0.32	0.22	0.26	0.32	0.22	0.26	0.32
	500-900N/mm²		EN-GJS-700-2(GGG70), QT700																
	3.1	蠕墨铸铁 (GJV) Vermicular Graphite Cast Iron	300-400N/mm²	GJV300, RuT380	100	120	140	0.2	0.24	0.3	0.22	0.26	0.32	0.22	0.26	0.32	0.22	0.26	0.32
	400-500N/mm²		GJV450, RuT420																
	4.1	可锻铸铁 (GTMW, GTMB) Malleable Cast Iron	250-500N/mm²	EN-GJMW-350-4(GTW-35), KTH330	80	100	120	0.18	0.22	0.26	0.2	0.24	0.3	0.2	0.24	0.3	0.2	0.24	0.3
	500-800N/mm²		EN-GJMB-450-6(GTS-45), KTZ700																

切削参数对照表

Cutting Parameters Recommendation

	应用范围-材料 Range of application-material	抗拉强度 Tensile strength	材料举例 Material examples	钻头深 (Drilling depth) 5×D														
				EP-P														
				切削速度 Vc[m/min]			进给量f[mm/rev]											
				钻头直径 (Drill diameter) dc														
14-33mm			14-15.99mm			16-20.99mm			21-25.99mm			26-33mm						
				最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max
P	钢件材料 Steel																	
	1.1	冷轧钢 Cold Rolled Steel	DC01, SPCE, ST15															
		低碳钢 Low Carbon Steel	S235JR(S137-2), 20#, 1008	80	100	120	0.16	0.2	0.24	0.18	0.24	0.3	0.18	0.24	0.3	0.18	0.24	0.3
		易切削, 等等 Free Cutting Steel, etc.	10SPb20, Y15Pb, SUN23															
	2.1	结构钢 Structural Steel	E360(S170-2), 20CrMnTi															
		渗碳钢, 表面硬化钢 Cemented Steel Surface Hardened Steel	16MnCr5	70	90	110	0.16	0.2	0.24	0.18	0.24	0.3	0.18	0.24	0.3	0.18	0.24	0.3
		铸钢, 等等 Cast Steel, etc.	GS-25CrMo4, ZG1Cr13, C47H															
	3.1	渗碳钢, 表面硬化钢 Cemented Steel Surface Hardened Steel	20MoCr3, SCM415, SAE5120H															
		调质钢 Modulating Steel	42CrMo4, 4135	70	80	110	0.16	0.2	0.24	0.18	0.24	0.3	0.18	0.24	0.3	0.18	0.24	0.3
		中、高碳素钢, 等等	102Cr6, CK45, 70#															
	4.1	特殊热处理钢 Special Heat Treatment Steel	50CrMo4, 35CrMoV															
		冷作工具钢 Cold Working Tool Steel	X45NiCrMo4	60	70	90	0.14	0.18	0.22	0.16	0.22	0.28	0.16	0.22	0.28	0.16	0.22	0.28
		渗碳钢, 等等 Cemented Steel, etc.	31CrMo12, 38CrMoAl															
	5.1	高合金钢 High Alloy Steel	X38CrMoV5-3, 60Si2MnA, 50CrVA															
		热作工具钢 Hot Working Tool Steel	X100CrMoV8-1-1, 5CrNiTi4	50	60	90	0.14	0.18	0.22	0.16	0.22	0.28	0.16	0.22	0.28	0.16	0.22	0.28
		模具钢, 等等 Mold Steel, etc.	Cr5WMoVS1, 20Cr2Mo2WVNCo															
不锈钢材料 Stainless Steel Materials																		
M	1.1	铁素体结构, 马氏体结构 Ferrite Structure Martensite Structure	X2CrTi12, SS430, SS445, 9Cr18	60	70	90	0.14	0.18	0.22	0.16	0.22	0.28	0.16	0.22	0.28	0.16	0.22	0.28
	2.1	奥氏体结构 Stainless Steel Materials	X6CrNiMoTi17-12-2, 0Cr18Ni9, SS316	50	60	70	0.12	0.16	0.2	0.14	0.18	0.22	0.14	0.18	0.22	0.14	0.18	0.22
	3.1	奥氏体-铁素体结构 (双相) Austenitic-Ferrite (Diphas)	X2CrNiMoN22-5-3, 00Cr23Ni4N, SAF2507	40	50	60	0.1	0.14	0.18	0.12	0.16	0.2	0.12	0.16	0.2	0.12	0.16	0.2
	4.1		UNS S32550, S32750, 00Cr25Ni7Mo4N	30	40	50	0.1	0.14	0.18	0.12	0.16	0.2	0.12	0.16	0.2	0.12	0.16	0.2
铸铁材料 Cast Iron Material																		
K	1.1	片状石墨铸铁 (GJL) Flake Graphite Cast Iron	100-250N/mm² EN-GJL-200(GG20), HT250	120	140	160	0.2	0.24	0.3	0.22	0.26	0.32	0.22	0.26	0.32	0.22	0.26	0.32
	1.2		250-450N/mm² EN-GJL-300(GG30), HT350															
	2.1	球墨铸铁 (GJS) Nodular Cast Iron	350-500N/mm² EN-GJS-400-15(GGG40), QT400	100	120	140	0.2	0.24	0.3	0.22	0.26	0.32	0.22	0.26	0.32	0.22	0.26	0.32
	2.2		500-900N/mm² EN-GJS-700-2(GGG70), QT700															
	3.1	蠕墨铸铁 (GJV) Vermicular Graphite Cast Iron	300-400N/mm² GJV300, RuT380	100	120	140	0.2	0.24	0.3	0.22	0.26	0.32	0.22	0.26	0.32	0.22	0.26	0.32
	3.2		400-500N/mm² GJV450, RuT420															
	4.1	可锻铸铁 (GTMW, GTMB) Malleable Cast Iron	250-500N/mm² EN-GJMW-350-4(GTW-35), KTH330	80	100	120	0.18	0.22	0.26	0.2	0.24	0.3	0.2	0.24	0.3	0.2	0.24	0.3
	4.2		500-800N/mm² EN-GJMB-450-6(GTS-45), KTT700															

切削参数对照表

Cutting Parameters Recommendation

	应用范围-材料 Range of application-material	抗拉强度 Tensile strength	材料举例 Material examples	钻深 (Drilling depth) 8×D																	
				EP-P																	
				切削速度 Vc[m/min]			进给量f[mm/rev]														
				钻头直径 (Drill diameter) dc																	
14-33mm			14-15.99mm			16-20.99mm			21-25.99mm			26-33mm									
				最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max	最小 Min	推荐 Best	最大 Max			
P	钢件材料 Steel																				
	1.1	冷轧钢 Cold Rolled Steel	≤600N/mm²	DC01, SPCE, ST15	80	100	120	0.14	0.18	0.22	0.16	0.22	0.28	0.16	0.22	0.28	0.16	0.22	0.28		
		低碳钢 Low Carbon Steel		S235JR(S137-2), 20#, 1008																	
		易切钢, 等等 Free Cutting Steel, etc.		10SPb20, Y15Pb, SUN23																	
	2.1	结构钢 Structural Steel	≤800N/mm²	E360(St70-2), 20CrMnTi	70	90	110	0.14	0.18	0.22	0.16	0.22	0.28	0.16	0.22	0.28	0.16	0.22	0.28		
		渗碳钢, 表面硬化钢 Cemented Steel Surface Hardened Steel		16MnCr5																	
		铸钢, 等等 Cast Steel, etc.		GS-25CrMo4, ZG1Cr13, C47H																	
	3.1	渗碳钢, 表面硬化钢 Cemented Steel Surface Hardened Steel	≤1000N/mm²	20MoCr3, SCM415, SAE5120H	70	80	110	0.14	0.18	0.22	0.16	0.22	0.28	0.16	0.22	0.28	0.16	0.22	0.28		
		调质钢 Modulating Steel		42CrMo4, 4135																	
		中、高强度钢, 等等		102Cr6, CK45, 70#																	
	4.1	特殊热处理钢 Special Heat Treatment Steel	≤1200N/mm²	50CrMo4, 35CrMoV	60	70	90	0.12	0.16	0.2	0.14	0.2	0.26	0.14	0.2	0.26	0.14	0.2	0.26		
		冷作工具钢 Cold Working Tool Steel		X45NiCrMo4																	
		渗氮钢, 等等 Cemented Steel, etc.		31CrMo12, 38CrMoAl																	
	5.1	高合金钢 High Alloy Steel	≤1400N/mm²	X38CrMoV5-3, 60Si2MnA, 50CrVA	50	60	90	0.12	0.16	0.2	0.14	0.2	0.26	0.14	0.2	0.26	0.14	0.2	0.26		
		热作工具钢 Hot Working Tool Steel		X100CrMoV8-1-1, 5CrNiTi4																	
模具钢, 等等 Mold Steel, etc.		Cr5WMoVSi, 20Cr2Mo2WVNiCo																			
	不锈钢材料 Stainless Steel Materials																				
M	1.1	铁素体结构, 马氏体结构 Ferrite Structure Martensite Structure	≤950N/mm²	X2CrTi12, SS430, SS445, 9Cr18	60	70	90	0.12	0.16	0.2	0.14	0.2	0.26	0.14	0.2	0.26	0.14	0.2	0.26		
		2.1	奥氏体结构 Stainless Steel Materials	≤950N/mm²	X6CrNiMoTi17-12-2, 0Cr18Ni9, SS316	50	60	70	0.1	0.14	0.18	0.12	0.16	0.2	0.12	0.16	0.2	0.12	0.16	0.2	
			3.1	奥氏体-铁素体结构 (双相) Austenitic Ferrite (Diphase)	≤1100N/mm²	X2CrNiMoN22-5-3, 00Cr23Ni4N, SAF2507	40	50	60	0.08	0.12	0.16	0.1	0.14	0.18	0.1	0.14	0.18	0.1	0.14	0.18
				4.1		≤1250N/mm²	UNS S32550, S32750, 00Cr25Ni7Mo4N	30	40	50	0.08	0.12	0.16	0.1	0.14	0.18	0.1	0.14	0.18	0.1	0.14
K	铸铁材料 Cast Iron Material																				
	1.1	片状石墨铸铁 (GJL) Flake Graphite Cast Iron	100-250N/mm²	EN-GJL-200(GG20), HT250	120	140	160	0.18	0.22	0.28	0.2	0.24	0.3	0.2	0.24	0.3	0.2	0.24	0.3		
		1.2	250-450N/mm²	EN-GJL-300(GG30), HT350																	
	2.1	球墨铸铁 (GJS) Nodular Cast Iron	350-500N/mm²	EN-GJS-400-15(GG40), QT400	100	120	140	0.18	0.22	0.28	0.2	0.24	0.3	0.2	0.24	0.3	0.2	0.24	0.3		
		2.2	500-900N/mm²	EN-GJS-700-2(GGG70), QT700																	
	3.1	蠕墨铸铁 (GJV) Vermicular Graphite Cast Iron	300-400N/mm²	GJV300, RuT380	100	120	140	0.18	0.22	0.28	0.2	0.24	0.3	0.2	0.24	0.3	0.2	0.24	0.3		
		3.2	400-500N/mm²	GJV450, RuT420																	
	4.1	可锻铸铁 (GTMW, GTMB) Malleable Cast Iron	250-500N/mm²	EN-GJMW-350-4(GTW-35), KTH330	80	100	120	0.16	0.2	0.24	0.18	0.22	0.28	0.18	0.22	0.28	0.18	0.22	0.28		
	4.2		500-800N/mm²	EN-GJMB-450-6(GTS-45), KTT700																	

**HURRICANE SERIES
END MILLS**

飓风系列铣刀



飓风系列铣刀

Hurricane Series End Mills

AHS 系列 AHS Series

高硬高效加工，适合加工淬火钢 HRC50-65，高合金材料

High-hardness and high-efficiency machining. Suitable for machining hardened steel HRC 50-65 and high-alloy materials.

AHM 系列 AHM Series

高速高耐磨加工，适合预制钢 $HRC \leq 52$ 、不锈钢和大型模具的长时间切削

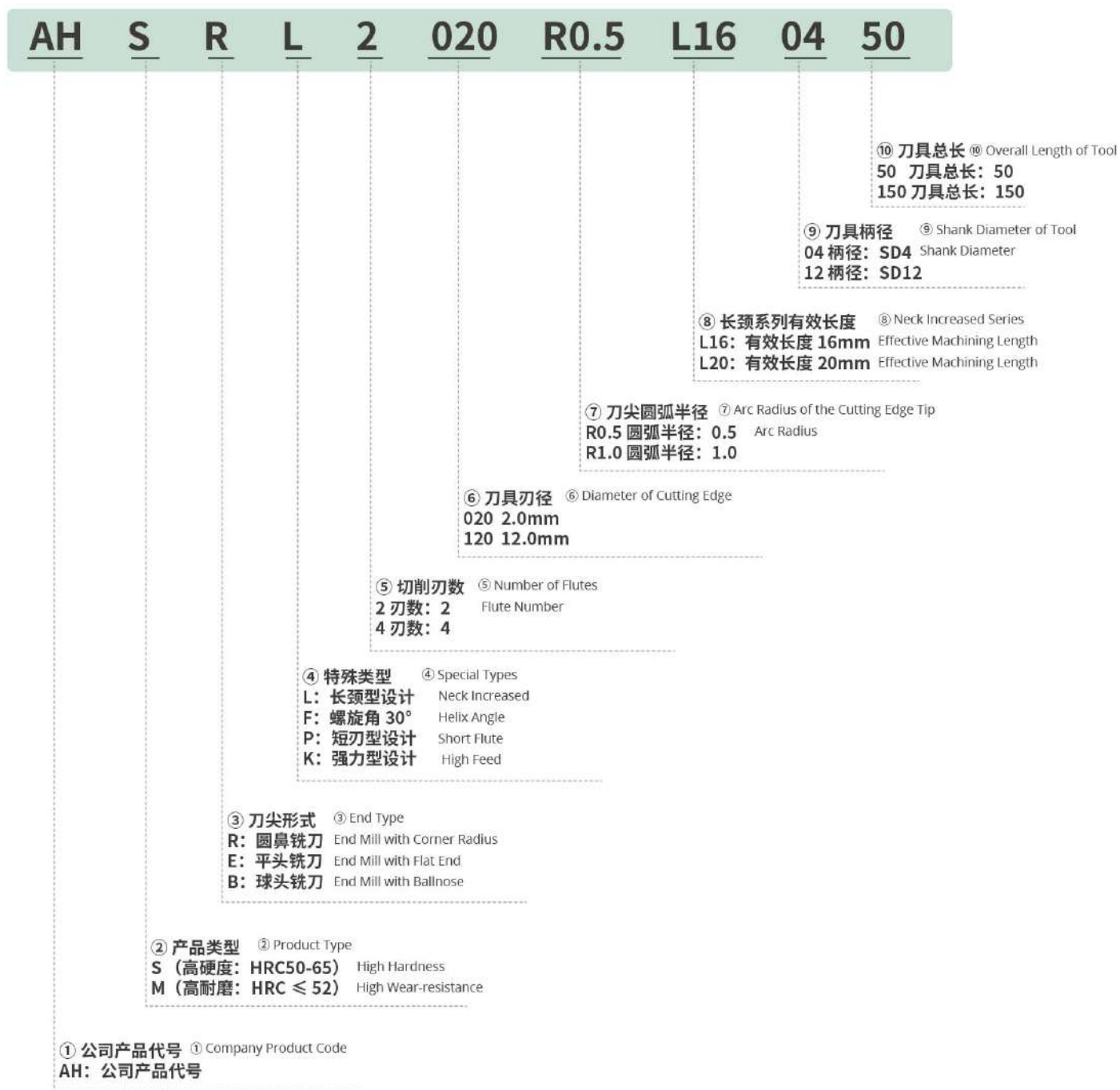
High-speed and high-wear-resisting machining. Suitable for long-time cutting of prefabricated steel $HRC \leq 52$, stainless steel and large molds.



刀具型号标示指南

Cutting Tool Naming Guidelines

飓风 - 中 / 高硬铣刀命名规则



AHS SERIES

AHS 系列

AHS 系列特点

AHS SERIES FEATURES

材料特点：

- 采用极细超微粒基体
- 兼具良好的韧性和硬度

Material Features:

- Adopt extremely fine ultramicro matrix.
- Great toughness and hardness.

超 Y 涂层特点：

- 高红硬性，提高切削速度
- 稳定性高，涂层表面附着力强
- 涂层硬度高，提高刀具使用寿命
- 超耐高温，高速加工适合干切削或微润滑切削

Super-Y Coating Features:

- High red hardness. Increase cutting speed.
- High stability. Strong adhesion on the coating surface.
- High coating hardness. Improve tool life.
- High temperature resistance. High-speed machining. Suitable for dry cutting or micro-lubrication cutting.

应用领域：

- 适合加工淬硬钢（HRC 50-65）例：SKD61、S136H、SKD11 等
- 适合加工高合金材料

Application:

- Suitable for machining hardened steel (HRC50-65).
- SKD61, S136H, SKD11, etc.
- Suitable for machining high-alloy materials.

淬硬钢的终结者

Perfect Choice for Chilled Steel

50≤HRC≤65（高硬度）

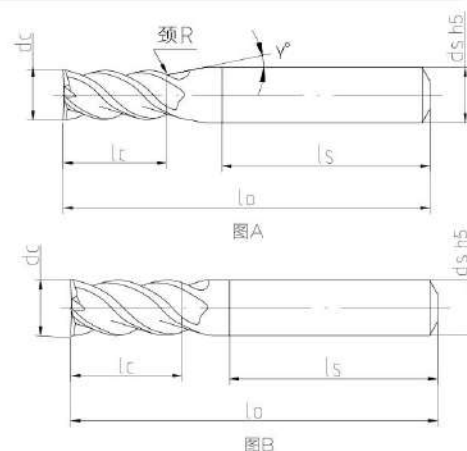


AHSEF 4 刃平头铣刀

AHSEF 4-flute End Mills



- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工作表面粗糙度;
- 为高精度铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- Designed for high precision milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 3$	0 ~ -0.010
$3 < \phi \leq 6$	0 ~ -0.012
$6 < \phi \leq 10$	0 ~ -0.015
$10 < \phi \leq 20$	0 ~ -0.018

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
☐	☐	☐	☒	☐	☐	☐

订货编号 · Order code									
代码 Code	规格型号 Designation	刃径 · d_s	刃长 · l_c	颈 R · R	柄锥角度 · $\gamma / ^\circ$	全长 · l_o	柄径 · d_s	图示 Graph	库存 Inventory
AHSEF 4010 0450	D1x3xL50xSD4	1	3	4	12	50	4	A	●
AHSEF 4010 0650	D1x3xL50xSD6				12	50	6	A	●
AHSEF 4015 0450	D1.5x4xL50xSD4	1.5	4	-	11	50	4	A	●
AHSEF 4015 0650	D1.5x4xL50xSD6				11	50	6	A	●
AHSEF 4020 0450	D2x5xL50xSD4	2	5	-	11	50	4	A	●
AHSEF 4020 0650	D2x5xL50xSD6				11	50	6	A	●
AHSEF 4025 0450	D2.5x6.5xL50xSD4	2.5	6.5	-	11	50	4	A	●
AHSEF 4025 0650	D2.5x6.5xL50xSD6				11	50	6	A	●
AHSEF 4030 0450	D3x7.5xL50xSD4	3	7.5	-	11	50	4	A	●
AHSEF 4030 0650	D3x7.5xL50xSD6				11	50	6	A	●
AHSEF 4030 0660	D3x7.5xL60xSD6				11	60	6	A	●
AHSEF 4030 0675	D3x7.5xL75xSD6				11	75	6	A	●
AHSEF 4040 0450	D4x10xL50xSD4	4	10	-	-	50	4	B	●
AHSEF 4040 0460	D4x10xL60xSD4				-	60	4	B	●
AHSEF 4040 0475	D4x10xL75xSD4				-	75	4	B	●
AHSEF 4040 0650	D4x10xL50xSD6				11	50	6	A	●
AHSEF 4040 0660	D4x10xL60xSD6				11	60	6	A	●
AHSEF 4040 0675	D4x10xL75xSD6				11	75	6	A	●
AHSEF 4050 0650	D5x12.5xL50xSD6	5	12.5	-	11	50	6	A	●
AHSEF 4050 0675	D5x12.5xL75xSD6				11	75	6	A	●
AHSEF 4060 0650	D6x15xL50xSD6	6	15	-	-	50	6	B	●
AHSEF 4060 0660	D6x15xL60xSD6				-	60	6	B	●
AHSEF 4060 0675	D6x15xL75xSD6				-	75	6	B	●
AHSEF 4060 06100	D6x15xL100xSD6				-	100	6	B	●

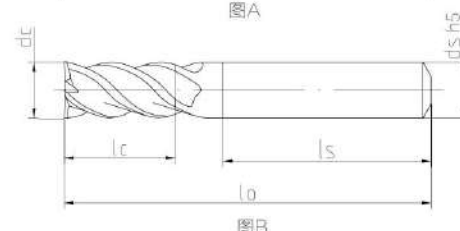
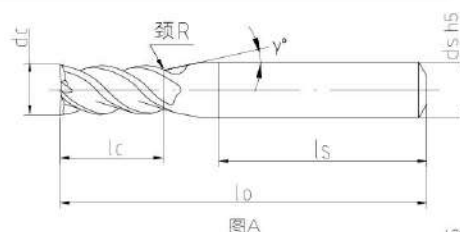
订货编号·Order code									
代码 Code	规格型号 Designation	刃径·ds	刃长·lc	颈 R·R	柄锥角度·γ/°	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHSEF 4080 0860	D8x20xL60xSD8	8	20	-	-	60	8	B	●
AHSEF 4080 0875	D8x20xL75xSD8				-	75	8	B	●
AHSEF 4080 08100	D8x20xL100xSD8				-	100	8	B	●
AHSEF 4100 1075	D10x25xL75xSD10	10	25	-	-	75	10	B	●
AHSEF 4100 10100	D10x25xL100xSD10				-	100	10	B	●
AHSEF 4120 1275	D12x30xL75xSD12	12	30	-	-	75	12	B	●
AHSEF 4120 12100	D12x30xL100xSD12				-	100	12	B	●
AHSEF 4140 1475	D14x35xL75xSD14	14	35	-	-	75	14	B	●
AHSEF 4140 14100	D14x35xL100xSD14				-	100	14	B	●
AHSEF 4160 16100	D16x40xL100xSD16	16	40	-	-	100	16	B	●
AHSEF 4160 16150	D16x40xL150xSD16				-	150	16	B	●
AHSEF 4200 20100	D20x50xL100xSD20	20	50	-	-	100	20	B	●
AHSEF 4200 20150	D20x50xL150xSD20				-	150	20	B	●

AHSE 4 刃平头铣刀

AHSE 4-flute End Mills



- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工件表面粗糙度;
- 为高精度铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- Designed for high precision milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 3$	0 ~ -0.010
$3 < \phi \leq 6$	0 ~ -0.012
$6 < \phi \leq 10$	0 ~ -0.015
$10 < \phi \leq 20$	0 ~ -0.018

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
☐	☐	☐	☒	☐	☐	☐

订货编号 · Order code									
代码 Code	规格型号 Designation	刃径 · d_s	刃长 · l_c	颈 R · R	柄锥角度 · $\gamma / ^\circ$	全长 · l_o	柄径 · d_s	图示 Graph	库存 Inventory
AHSE 4010 0450	D1x3xL50xSD4	1	3	4	12	50	4	A	●
AHSE 4010 0650	D1x3xL50xSD6				12	50	6	A	●
AHSE 4015 0450	D1.5x4xL50xSD4	1.5	4	-	11	50	4	A	●
AHSE 4015 0650	D1.5x4xL50xSD6				11	50	6	A	●
AHSE 4020 0450	D2x5xL50xSD4	2	5	-	11	50	4	A	●
AHSE 4020 0650	D2x5xL50xSD6				11	50	6	A	●
AHSE 4025 0450	D2.5x6.5xL50xSD4	2.5	6.5	-	11	50	4	A	●
AHSE 4025 0650	D2.5x6.5xL50xSD6				11	50	6	A	●
AHSE 4030 0450	D3x7.5xL50xSD4	3	7.5	-	11	50	4	A	●
AHSE 4030 0650	D3x7.5xL50xSD6				11	50	6	A	●
AHSE 4030 0660	D3x7.5xL60xSD6				11	60	6	A	●
AHSE 4030 0675	D3x7.5xL75xSD6				11	75	6	A	●
AHSE 4040 0450	D4x10xL50xSD4	4	10	-	-	50	4	B	●
AHSE 4040 0460	D4x10xL60xSD4				-	60	4	B	●
AHSE 4040 0475	D4x10xL75xSD4				-	75	4	B	●
AHSE 4040 0650	D4x10xL50xSD6				11	50	6	A	●
AHSE 4040 0660	D4x10xL60xSD6				11	60	6	A	●
AHSE 4040 0675	D4x10xL75xSD6				11	75	6	A	●
AHSE 4050 0650	D5x12.5xL50xSD6	5	12.5	-	11	50	6	A	●
AHSE 4050 0675	D5x12.5xL75xSD6				11	75	6	A	●
AHSE 4060 0650	D6x15xL50xSD6	6	15	-	-	50	6	B	●
AHSE 4060 0660	D6x15xL60xSD6				-	60	6	B	●
AHSE 4060 0675	D6x15xL75xSD6				-	75	6	B	●
AHSE 4060 06100	D6x15xL100xSD6				-	100	6	B	●

A

B

C

D

E

F

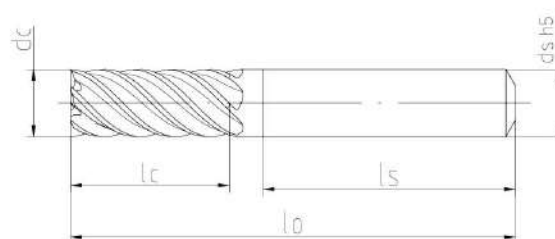
G

H

订货编号·Order code									
代码 Code	规格型号 Designation	刃径·ds	刃长·lc	颈 R·R	柄锥角度· $\gamma/^\circ$	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHSE 4080 0860	D8x20xL60xSD8	8	20	-	-	60	8	B	●
AHSE 4080 0875	D8x20xL75xSD8				-	75	8	B	●
AHSE 4080 08100	D8x20xL100xSD8				-	100	8	B	●
AHSE 4080 08125	D8x20xL125xSD8				-	125	8	B	●
AHSE 4080 08150	D8x20xL150xSD8				-	150	8	B	●
AHSE 4100 1075	D10x25xL75xSD10	10	25	-	-	75	10	B	●
AHSE 4100 10100	D10x25xL100xSD10				-	100	10	B	●
AHSE 4100 10125	D10x25xL125xSD10				-	125	10	B	●
AHSE 4100 10150	D10x25xL150xSD10				-	150	10	B	●
AHSE 4120 1275	D12x30xL75xSD12	12	30	-	-	75	12	B	●
AHSE 4120 12100	D12x30xL100xSD12				-	100	12	B	●
AHSE 4120 12125	D12x30xL125xSD12				-	125	12	B	●
AHSE 4120 12150	D12x30xL150xSD12				-	150	12	B	●
AHSE 4140 1475	D14x35xL75xSD14	14	35	-	-	75	14	B	●
AHSE 4140 14100	D14x35xL100xSD14				-	100	14	B	●
AHSE 4160 16100	D16x40xL100xSD16	16	40	-	-	100	16	B	●
AHSE 4160 16150	D16x40xL150xSD16				-	150	16	B	●
AHSE 4200 20100	D20x50xL100xSD20	20	50	-	-	100	20	B	●
AHSE 4200 20150	D20x50xL150xSD20				-	150	20	B	●

AHSE 6 刃平头铣刀

AHSE 6-flute End Mills



图B

- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工件表面粗糙度;
- 为高精度铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- Designed for high precision milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$3 < \phi \leq 6$	0 ~ -0.012
$6 < \phi \leq 10$	0 ~ -0.015
$10 < \phi \leq 20$	0 ~ -0.018

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
	○	○	⊗	○	○	

订货编号 · Order code

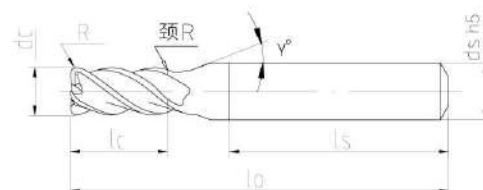
代码 Code	规格型号 Designation	刃径 · d_s	刃长 · l_c	全长 · l_o	柄径 · d_s	图示 Graph	库存 Inventory
AHSE 6060 0650	D6x15xL50xSD6	6	15	50	6	B	●
AHSE 6060 0660	D6x15xL60xSD6			60	6	B	●
AHSE 6080 0860	D8x20xL60xSD8	8	20	60	8	B	●
AHSE 6080 0875	D8x20xL75xSD8			75	8	B	●
AHSE 6100 1075	D10x25xL75xSD10	10	25	75	10	B	●
AHSE 6100 10100	D10x25xL100xSD10			100	10	B	●
AHSE 6120 1275	D12x30xL75xSD12	12	30	75	12	B	●
AHSE 6120 12100	D12x30xL100xSD12			100	12	B	●
AHSE 6120 12150	D12x30xL150xSD12			150	12	B	●
AHSE 6140 1475	D14x35xL75xSD14	14	35	75	14	B	●
AHSE 6140 14100	D14x35xL100xSD14			100	14	B	●
AHSE 6160 16100	D16x40xL100xSD16	16	40	100	16	B	●
AHSE 6160 16150	D16x40xL150xSD16			150	16	B	●
AHSE 6200 20100	D20x50xL100xSD20	20	50	100	20	B	●
AHSE 6200 20150	D20x50xL150xSD20			150	20	B	●

AHSRF 4 刃圆鼻铣刀

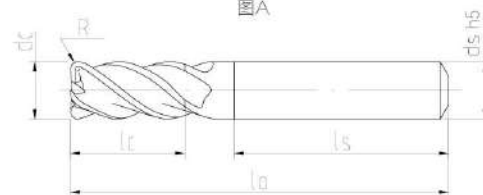
AHSRF 4-flute End Mills with Corner Radius



- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工作表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



图A



图B

刃径 ϕ_{dc}	ϕ_{dc} Tolerance	刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 12$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
	○	○	⊗	○	○	○

订货编号 · Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	颈 R·R	柄锥角度·γ/°	全长·lo	柄径·ds	图示 Graph	库存 Inventory		
AHSRF 4010R0.2 0450	D1R0.2x2xL50xSD4	1	0.2	2	4	12	50	4	A	●		
AHSRF 4015R0.2 0450	D1.5R0.2x3xL50xSD4	1.5	0.2	3	-	11	50	4	A	●		
AHSRF 4020R0.2 0450	D2R0.2x4xL50xSD4	2	0.2	4	-	11	50	4	A	●		
AHSRF 4020R0.5 0450	D2R0.5x4xL50xSD4		0.5			11	50	4	A	●		
AHSRF 4030R0.2 0450	D3R0.2x6xL50xSD4	3	0.2	6	-	11	50	4	A	●		
AHSRF 4030R0.2 0650	D3R0.2x6xL50xSD6					11	50	6	A	●		
AHSRF 4030R0.2 0660	D3R0.2x6xL60xSD6					11	60	6	A	●		
AHSRF 4030R0.2 0675	D3R0.2x6xL75xSD6					11	75	6	A	●		
AHSRF 4030R0.5 0450	D3R0.5x6xL50xSD4		0.5			11	50	4	A	●		
AHSRF 4030R0.5 0650	D3R0.5x6xL50xSD6					11	50	6	A	●		
AHSRF 4030R0.5 0660	D3R0.5x6xL60xSD6					11	60	6	A	●		
AHSRF 4030R0.5 0675	D3R0.5x6xL75xSD6					11	75	6	A	●		
AHSRF 4040R0.2 0450	D4R0.2x8xL50xSD4	4	0.2	8	-	-	50	4	B	●		
AHSRF 4040R0.2 0460	D4R0.2x8xL60xSD4					-	60	4	B	●		
AHSRF 4040R0.2 0475	D4R0.2x8xL75xSD4					-	75	4	B	●		
AHSRF 4040R0.2 0650	D4R0.2x8xL50xSD6					11	50	6	A	●		
AHSRF 4040R0.2 0660	D4R0.2x8xL60xSD6					11	60	6	A	●		
AHSRF 4040R0.2 0675	D4R0.2x8xL75xSD6					11	75	6	A	●		
AHSRF 4040R0.3 0450	D4R0.3x8xL50xSD4		0.3			-	50	4	B	●		
AHSRF 4040R0.3 0475	D4R0.3x8xL75xSD4					-	75	4	B	●		
AHSRF 4040R0.3 0650	D4R0.3x8xL50xSD6					11	50	6	A	●		
AHSRF 4040R0.3 0660	D4R0.3x8xL60xSD6					11	60	6	A	●		
AHSRF 4040R0.3 0675	D4R0.3x8xL75xSD6					11	75	6	A	●		

A

B

C

D

E

F

G

H

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	颈 R·R	柄锥角度·γ/°	全长·lo	柄径·ds	图示 Graph	库存 Inventory	
AHSRF 4040R0.5 0450	D4R0.5x8xL50xSD4	4	0.5	8	-	-	50	4	B	●	
AHSRF 4040R0.5 0460	D4R0.5x8xL60xSD4					-	60	4	B	●	
AHSRF 4040R0.5 0475	D4R0.5x8xL75xSD4					-	75	4	B	●	
AHSRF 4040R0.5 0650	D4R0.5x8xL50xSD6					11	50	6	A	●	
AHSRF 4040R0.5 0660	D4R0.5x8xL60xSD6					11	60	6	A	●	
AHSRF 4040R0.5 0675	D4R0.5x8xL75xSD6					11	75	6	A	●	
AHSRF 4040R1.0 0450	D4R1x8xL50xSD4		1.0			-	50	4	B	●	
AHSRF 4040R1.0 0460	D4R1x8xL60xSD4					-	60	4	B	●	
AHSRF 4040R1.0 0475	D4R1x8xL75xSD4					-	75	4	B	●	
AHSRF 4040R1.0 0650	D4R1x8xL50xSD6					11	50	6	A	●	
AHSRF 4040R1.0 0660	D4R1x8xL60xSD6					11	60	6	A	●	
AHSRF 4040R1.0 0675	D4R1x8xL75xSD6					11	75	6	A	●	
AHSRF 4060R0.2 0650	D6R0.2x12xL50xSD6	6	0.2	12	-	-	50	6	B	●	
AHSRF 4060R0.2 0660	D6R0.2x12xL60xSD6					-	60	6	B	●	
AHSRF 4060R0.2 0675	D6R0.2x12xL75xSD6					-	75	6	B	●	
AHSRF 4060R0.2 06100	D6R0.2x12xL100xSD6					-	100	6	B	●	
AHSRF 4060R0.5 0650	D6R0.5x12xL50xSD6		0.5			-	50	6	B	●	
AHSRF 4060R0.5 0660	D6R0.5x12xL60xSD6					-	60	6	B	●	
AHSRF 4060R0.5 0675	D6R0.5x12xL75xSD6					-	75	6	B	●	
AHSRF 4060R0.5 06100	D6R0.5x12xL100xSD6					-	100	6	B	●	
AHSRF 4060R1.0 0650	D6R1x12xL50xSD6		1.0			-	50	6	B	●	
AHSRF 4060R1.0 0660	D6R1x12xL60xSD6					-	60	6	B	●	
AHSRF 4060R1.0 0675	D6R1x12xL75xSD6					-	75	6	B	●	
AHSRF 4060R1.0 06100	D6R1x12xL100xSD6					-	100	6	B	●	
AHSRF 4080R0.2 0860A	D8R0.2x20xL60xSD8	8	0.2	20	-	-	60	8	B	●	
AHSRF 4080R0.2 0875A	D8R0.2x20xL75xSD8					-	75	8	B	●	
AHSRF 4080R0.2 08100A	D8R0.2x20xL100xSD8					-	100	8	B	●	
AHSRF 4080R0.5 0860	D8R0.5x16xL60xSD8		0.5	16		-	60	8	B	●	
AHSRF 4080R0.5 0875	D8R0.5x16xL75xSD8					-	75	8	B	●	
AHSRF 4080R0.5 08100	D8R0.5x16xL100xSD8					-	100	8	B	●	
AHSRF 4080R0.5 08125	D8R0.5x16xL125xSD8					-	125	8	B	●	
AHSRF 4080R0.5 08150	D8R0.5x16xL150xSD8					-	150	8	B	●	
AHSRF 4080R0.5 0860A	D8R0.5x20xL60xSD8			20		-	60	8	B	●	
AHSRF 4080R0.5 0875A	D8R0.5x20xL75xSD8					-	75	8	B	●	
AHSRF 4080R0.5 08100A	D8R0.5x20xL100xSD8					-	100	8	B	●	
AHSRF 4080R0.5 08125A	D8R0.5x20xL125xSD8					-	125	8	B	●	
AHSRF 4080R0.5 08150A	D8R0.5x20xL150xSD8					-	150	8	B	●	
AHSRF 4080R1.0 0860	D8R1x16xL60xSD8		1.0	16		-	60	8	B	●	
AHSRF 4080R1.0 0875	D8R1x16xL75xSD8					-	75	8	B	●	
AHSRF 4080R1.0 08100	D8R1x16xL100xSD8					-	100	8	B	●	
AHSRF 4080R1.0 0860A	D8R1x20xL60xSD8			20		-	60	8	B	●	
AHSRF 4080R1.0 0875A	D8R1x20xL75xSD8					-	75	8	B	●	
AHSRF 4080R1.0 08100A	D8R1x20xL100xSD8	-				100	8	B	●		
AHSRF 4100R0.2 1075A	D10R0.2x25xL75xSD10	10	0.2	25	-	-	75	10	B	●	
AHSRF 4100R0.2 10100A	D10R0.2x25xL100xSD10					-	100	10	B	●	
AHSRF 4100R0.5 1075	D10R0.5x20xL75xSD10		0.5	20		-	75	10	B	●	
AHSRF 4100R0.5 10100	D10R0.5x20xL100xSD10					-	100	10	B	●	
AHSRF 4100R0.5 10125	D10R0.5x20xL125xSD10					-	125	10	B	●	
AHSRF 4100R0.5 10150	D10R0.5x20xL150xSD10					-	150	10	B	●	
AHSRF 4100R0.5 1075A	D10R0.5x25xL75xSD10			25		-	75	10	B	●	
AHSRF 4100R0.5 10100A	D10R0.5x25xL100xSD10					-	100	10	B	●	
AHSRF 4100R0.5 10125A	D10R0.5x25xL125xSD10					-	125	10	B	●	
AHSRF 4100R0.5 10150A	D10R0.5x25xL150xSD10					-	150	10	B	●	
AHSRF 4100R1.0 1075	D10R1x20xL75xSD10		1.0	20		-	75	10	B	●	
AHSRF 4100R1.0 10100	D10R1x20xL100xSD10					-	100	10	B	●	
AHSRF 4100R1.0 1075A	D10R1x25xL75xSD10			25		-	75	10	B	●	
AHSRF 4100R1.0 10100A	D10R1x25xL100xSD10					-	100	10	B	●	
AHSRF 4100R1.0 10150A	D10R1x25xL150xSD10					-	150	10	B	●	
AHSRF 4100R2.0 1075	D10R2x20xL75xSD10		2.0	20		-	75	10	B	●	
AHSRF 4100R2.0 10100	D10R2x20xL100xSD10					-	100	10	B	●	

A

B

C

D

E

F

G

H

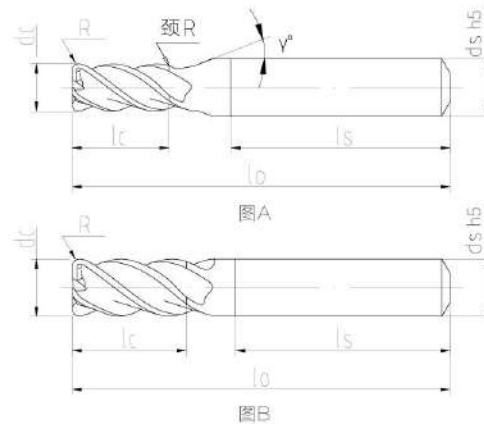
订货编号·Order code											
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	颈 R·R	柄锥角度· γ /°	全长·lo	柄径·ds	图示 Graph	库存 Inventory	
AHSRF 4120R0.5 1275	D12R0.5x24xL75xSD12	12	0.5	24	-	-	75	12	B	●	
AHSRF 4120R0.5 12100	D12R0.5x24xL100xSD12					-	100	12	B	●	
AHSRF 4120R0.5 12125	D12R0.5x24xL125xSD12					-	125	12	B	●	
AHSRF 4120R0.5 12150	D12R0.5x24xL150xSD12					-	150	12	B	●	
AHSRF 4120R0.5 1275A	D12R0.5x30xL75xSD12			30		-	75	12	B	●	
AHSRF 4120R0.5 12100A	D12R0.5x30xL100xSD12					-	100	12	B	●	
AHSRF 4120R0.5 12125A	D12R0.5x30xL125xSD12					-	125	12	B	●	
AHSRF 4120R0.5 12150A	D12R0.5x30xL150xSD12					-	150	12	B	●	
AHSRF 4120R1.0 1275	D12R1x24xL75xSD12		1.0	24	-	-	75	12	B	●	
AHSRF 4120R1.0 12100	D12R1x24xL100xSD12					-	100	12	B	●	
AHSRF 4120R1.0 1275A	D12R1x30xL75xSD12			30		-	75	12	B	●	
AHSRF 4120R1.0 12100A	D12R1x30xL100xSD12					-	100	12	B	●	
AHSRF 4120R1.0 12150A	D12R1x30xL150xSD12			24		-	150	12	B	●	
AHSRF 4120R2.0 1275	D12R2x24xL75xSD12		2.0	24		-	75	12	B	●	
AHSRF 4120R2.0 12100	D12R2x24xL100xSD12					-	100	12	B	●	
AHSRF 4120R2.0 1275A	D12R2x30xL75xSD12			30		-	75	12	B	●	
AHSRF 4120R2.0 12100A	D12R2x30xL100xSD12					-	100	12	B	●	

AHSR 4 刃圆鼻铣刀

AHSR 4-flute End Mills with Corner Radius



- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工作表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



刃径 ϕ .dc	ϕ .dc Tolerance	刃径 ϕ .dc	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 12$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
	○	○	⊗	○	○	

订货编号·Order code										
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	颈 R·R	柄锥角度· γ°	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHSR 4010R0.2 0450	D1R0.2x2xL50xSD4	1	0.2	2	4	12	50	4	A	●
AHSR 4015R0.2 0450	D1.5R0.2x3xL50xSD4	1.5	0.2	3	-	11	50	4	A	●
AHSR 4020R0.2 0450	D2R0.2x5xL50xSD4	2	0.2	5	-	11	50	4	A	●
AHSR 4020R0.5 0450	D2R0.5x5xL50xSD4		0.5			11	50	4	A	●
AHSR 4030R0.2 0450	D3R0.2x7.5xL50xSD4	3	0.2	7.5	-	11	50	4	A	●
AHSR 4030R0.2 0650	D3R0.2x7.5xL50xSD6					11	50	6	A	●
AHSR 4030R0.2 0660	D3R0.2x7.5xL60xSD6					11	60	6	A	●
AHSR 4030R0.2 0675	D3R0.2x7.5xL75xSD6					11	75	6	A	●
AHSR 4030R0.5 0450	D3R0.5x7.5xL50xSD4		0.5			11	50	4	A	●
AHSR 4030R0.5 0650	D3R0.5x7.5xL50xSD6					11	50	6	A	●
AHSR 4030R0.5 0660	D3R0.5x7.5xL60xSD6					11	60	6	A	●
AHSR 4030R0.5 0675	D3R0.5x7.5xL75xSD6					11	75	6	A	●
AHSR 4040R0.2 0450	D4R0.2x10xL50xSD4	4	0.2	10	-	-	50	4	B	●
AHSR 4040R0.2 0460	D4R0.2x10xL60xSD4					-	60	4	B	●
AHSR 4040R0.2 0475	D4R0.2x10xL75xSD4					-	75	4	B	●
AHSR 4040R0.2 0650	D4R0.2x10xL50xSD6					11	50	6	A	●
AHSR 4040R0.2 0660	D4R0.2x10xL60xSD6					11	60	6	A	●
AHSR 4040R0.2 0675	D4R0.2x10xL75xSD6					11	75	6	A	●
AHSR 4040R0.3 0450	D4R0.3x10xL50xSD4		0.3			-	50	4	B	●
AHSR 4040R0.3 0475	D4R0.3x10xL75xSD4					-	75	4	B	●
AHSR 4040R0.3 0650	D4R0.3x10xL50xSD6					11	50	6	A	●
AHSR 4040R0.3 0660	D4R0.3x10xL60xSD6					11	60	6	A	●
AHSR 4040R0.3 0675	D4R0.3x10xL75xSD6					11	75	6	A	●
AHSR 4040R0.5 0450	D4R0.5x10xL50xSD4					0.5	-	50	4	B

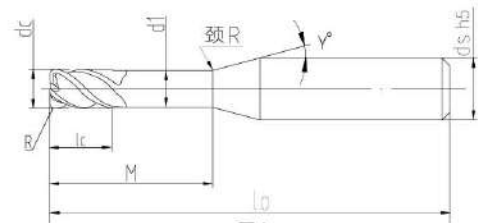
订货编号·Order code										
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	颈 R·R	柄锥角度·γ/°	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHSR 4040R0.5 0460	D4R0.5x10xL60xSD4	4	0.5	10	-	-	60	4	B	●
AHSR 4040R0.5 0475	D4R0.5x10xL75xSD4					-	75	4	B	●
AHSR 4040R0.5 0650	D4R0.5x10xL50xSD6					11	50	6	A	●
AHSR 4040R0.5 0660	D4R0.5x10xL60xSD6					11	60	6	A	●
AHSR 4040R0.5 0675	D4R0.5x10xL75xSD6					11	75	6	A	●
AHSR 4040R1.0 0450	D4R1x10xL50xSD4		1.0			-	50	4	B	●
AHSR 4040R1.0 0460	D4R1x10xL60xSD4					-	60	4	B	●
AHSR 4040R1.0 0475	D4R1x10xL75xSD4					-	75	4	B	●
AHSR 4040R1.0 0650	D4R1x10xL50xSD6					11	50	6	A	●
AHSR 4040R1.0 0660	D4R1x10xL60xSD6					11	60	6	A	●
AHSR 4040R1.0 0675	D4R1x10xL75xSD6					11	75	6	A	●
AHSR 4060R0.2 0650	D6R0.2x15xL50xSD6	6	0.2	15	-	-	50	6	B	●
AHSR 4060R0.2 0660	D6R0.2x15xL60xSD6					-	60	6	B	●
AHSR 4060R0.2 0675	D6R0.2x15xL75xSD6					-	75	6	B	●
AHSR 4060R0.2 06100	D6R0.2x15xL100xSD6					-	100	6	B	●
AHSR 4060R0.5 0650	D6R0.5x15xL50xSD6		0.5			-	50	6	B	●
AHSR 4060R0.5 0660	D6R0.5x15xL60xSD6					-	60	6	B	●
AHSR 4060R0.5 0675	D6R0.5x15xL75xSD6					-	75	6	B	●
AHSR 4060R0.5 06100	D6R0.5x15xL100xSD6					-	100	6	B	●
AHSR 4060R1.0 0650	D6R1x15xL50xSD6		1.0			-	50	6	B	●
AHSR 4060R1.0 0660	D6R1x15xL60xSD6					-	60	6	B	●
AHSR 4060R1.0 0675	D6R1x15xL75xSD6					-	75	6	B	●
AHSR 4060R1.0 06100	D6R1x15xL100xSD6					-	100	6	B	●
AHSR 4080R0.5 0860	D8R0.5x20xL60xSD8	8	0.5	20	-	-	60	8	B	●
AHSR 4080R0.5 0875	D8R0.5x20xL75xSD8					-	75	8	B	●
AHSR 4080R0.5 08100	D8R0.5x20xL100xSD8					-	100	8	B	●
AHSR 4080R0.5 08125	D8R0.5x20xL125xSD8					-	125	8	B	●
AHSR 4080R0.5 08150	D8R0.5x20xL150xSD8		1.0			-	150	8	B	●
AHSR 4080R1.0 0860	D8R1x20xL60xSD8					-	60	8	B	●
AHSR 4080R1.0 0875	D8R1x20xL75xSD8					-	75	8	B	●
AHSR 4080R1.0 08100	D8R1x20xL100xSD8					-	100	8	B	●
AHSR 4100R0.5 1075	D10R0.5x25xL75xSD10	10	0.5	25	-	-	75	10	B	●
AHSR 4100R0.5 10100	D10R0.5x25xL100xSD10					-	100	10	B	●
AHSR 4100R0.5 10125	D10R0.5x25xL125xSD10					-	125	10	B	●
AHSR 4100R0.5 10150	D10R0.5x25xL150xSD10					-	150	10	B	●
AHSR 4100R1.0 1075	D10R1x25xL75xSD10		1.0			-	75	10	B	●
AHSR 4100R1.0 10100	D10R1x25xL100xSD10					-	100	10	B	●
AHSR 4100R1.0 10150	D10R1x25xL150xSD10		2.0			-	150	10	B	●
AHSR 4100R2.0 1075	D10R2x25xL75xSD10					-	75	10	B	●
AHSR 4100R2.0 10100	D10R2x25xL100xSD10					-	100	10	B	●
AHSR 4120R0.5 1275	D12R0.5x30xL75xSD12	12	0.5	30	-	-	75	12	B	●
AHSR 4120R0.5 12100	D12R0.5x30xL100xSD12					-	100	12	B	●
AHSR 4120R0.5 12125	D12R0.5x30xL125xSD12					-	125	12	B	●
AHSR 4120R0.5 12150	D12R0.5x30xL150xSD12					-	150	12	B	●
AHSR 4120R1.0 1275	D12R1x30xL75xSD12		1.0			-	75	12	B	●
AHSR 4120R1.0 12100	D12R1x30xL100xSD12					-	100	12	B	●
AHSR 4120R1.0 12150	D12R1x30xL150xSD12					-	150	12	B	●
AHSR 4120R2.0 1275	D12R2x30xL75xSD12		2.0			-	75	12	B	●
AHSR 4120R2.0 12100	D12R2x30xL100xSD12					-	100	12	B	●

AHSRP 4 刃短刃圆鼻铣刀

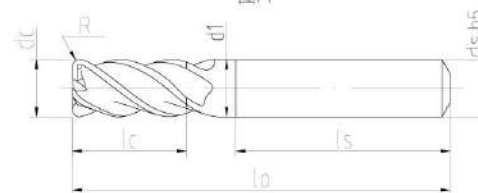
AHSR 4-flute End Mills with Corner Radius



- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工作表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



图A



图B

刃径 ϕ_{dc}	ϕ_{dc} Tolerance	刃径 ϕ_{dc}	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 12$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

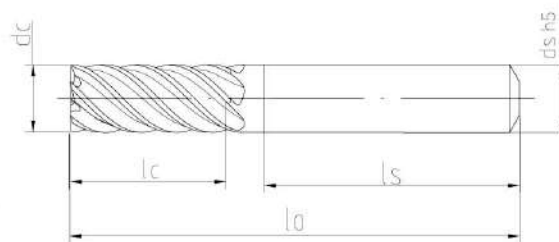
碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
	○	○	⊗	○	○	

订货编号 - Order code													
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径 · ϕ_{d1}	颈 R·R	柄锥角度 γ°	全长·lo	柄径·ds	图示 Graph	库存 Inventory	
AHSRP 4010R0.2 0450	D1R0.2x1x3xL50xSD4	1	0.2	1	3	0.94	4	12	50	4	A	●	
AHSRP 4015R0.2 0450	D1.5R0.2x1.5x4.5xL50xSD4	1.5	0.2	1.5	4.5	1.42	-	11	50	4	A	●	
AHSRP 4020R0.2 0450	D2R0.2x2x6xL50xSD4	2	0.2	2	6	1.9	-	11	50	4	A	●	
AHSRP 4020R0.5 0450	D2R0.5x2x6xL50xSD4		0.5					11	50	4	A	●	
AHSRP 4030R0.2 0450	D3R0.2x3x9xL50xSD4	3	0.2	3	9	2.9	-	11	50	4	A	●	
AHSRP 4030R0.2 0650	D3R0.2x3x9xL50xSD6							11	50	6	A	●	
AHSRP 4030R0.2 0660	D3R0.2x3x9xL60xSD6							11	60	6	A	●	
AHSRP 4030R0.2 0675	D3R0.2x3x9xL75xSD6							11	75	6	A	●	
AHSRP 4030R0.5 0450	D3R0.5x3x9xL50xSD4		0.5	3	9	2.9	-	11	50	4	A	●	
AHSRP 4030R0.5 0650	D3R0.5x3x9xL50xSD6							11	50	6	A	●	
AHSRP 4030R0.5 0660	D3R0.5x3x9xL60xSD6							11	60	6	A	●	
AHSRP 4030R0.5 0675	D3R0.5x3x9xL75xSD6							11	75	6	A	●	
AHSRP 4040R0.2 0450	D4R0.2x4x12xL50xSD4	4	0.2	4	12	3.9	-	-	50	4	B	●	
AHSRP 4040R0.2 0650	D4R0.2x4x12xL50xSD6							11	50	6	A	●	
AHSRP 4040R0.2 0660	D4R0.2x4x12xL60xSD6							11	60	6	A	●	
AHSRP 4040R0.2 0675	D4R0.2x4x12xL75xSD6							11	75	6	A	●	
AHSRP 4040R0.3 0450	D4R0.3x4x12xL50xSD4		0.3	4	12	3.9	-	-	50	4	B	●	
AHSRP 4040R0.3 0650	D4R0.3x4x12xL50xSD6							11	50	6	A	●	
AHSRP 4040R0.3 0660	D4R0.3x4x12xL60xSD6							11	60	6	A	●	
AHSRP 4040R0.3 0675	D4R0.3x4x12xL75xSD6							11	75	6	A	●	
AHSRP 4040R0.5 0450	D4R0.5x4x12xL50xSD4		0.5	4	12	3.9	-	-	50	4	B	●	
AHSRP 4040R0.5 0650	D4R0.5x4x12xL50xSD6							11	50	6	A	●	
AHSRP 4040R0.5 0660	D4R0.5x4x12xL60xSD6							11	60	6	A	●	
AHSRP 4040R0.5 0675	D4R0.5x4x12xL75xSD6							11	75	6	A	●	

订货编号·Order code												
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·Lc	有效长·M	颈径 · ϕ d1	颈 R·R	柄锥角度 γ °	全长·Lo	柄径·ds	图示 Graph	库存 Inventory
AHSRP 4040R1.0 0450	D4R1x4x12xL50xSD4	4	1.0	4	12	3.9	-	-	50	4	B	●
AHSRP 4040R1.0 0650	D4R1x4x12xL50xSD6							11	50	6	A	●
AHSRP 4040R1.0 0660	D4R1x4x12xL60xSD6							11	60	6	A	●
AHSRP 4040R1.0 0675	D4R1x4x12xL75xSD6							11	75	6	A	●
AHSRP 4060R0.2 0650	D6R0.2x6x18xL50xSD6	6	0.2	6	18	5.85	-	-	50	6	B	●
AHSRP 4060R0.2 0660	D6R0.2x6x18xL60xSD6							-	60	6	B	●
AHSRP 4060R0.2 0675	D6R0.2x6x18xL75xSD6							-	75	6	B	●
AHSRP 4060R0.2 06100	D6R0.2x6x18xL100xSD6							-	100	6	B	●
AHSRP 4060R0.5 0650	D6R0.5x6x18xL50xSD6		0.5					-	50	6	B	●
AHSRP 4060R0.5 0660	D6R0.5x6x18xL60xSD6							-	60	6	B	●
AHSRP 4060R0.5 0675	D6R0.5x6x18xL75xSD6							-	75	6	B	●
AHSRP 4060R0.5 06100	D6R0.5x6x18xL100xSD6							-	100	6	B	●
AHSRP 4060R1.0 0650	D6R1x6x18xL50xSD6		1.0					-	50	6	B	●
AHSRP 4060R1.0 0660	D6R1x6x18xL60xSD6							-	60	6	B	●
AHSRP 4060R1.0 0675	D6R1x6x18xL75xSD6							-	75	6	B	●
AHSRP 4060R1.0 06100	D6R1x6x18xL100xSD6							-	100	6	B	●
AHSRP 4080R0.5 0860	D8R0.5x8x24xL60xSD8	8	0.5	8	24	7.8	-	-	60	8	B	●
AHSRP 4080R0.5 0875	D8R0.5x8x24xL75xSD8							-	75	8	B	●
AHSRP 4080R0.5 08100	D8R0.5x8x24xL100xSD8							-	100	8	B	●
AHSRP 4080R0.5 08125	D8R0.5x8x24xL125xSD8							-	125	8	A	●
AHSRP 4080R0.5 08150	D8R0.5x8x24xL150xSD8		1.0					-	150	8	B	●
AHSRP 4080R1.0 0860	D8R1x8x24xL60xSD8							-	60	8	B	●
AHSRP 4080R1.0 0875	D8R1x8x24xL75xSD8							-	75	8	B	●
AHSRP 4080R1.0 08100	D8R1x8x24xL100xSD8							-	100	8	B	●
AHSRP 4100R0.5 1075	D10R0.5x10x30xL75xSD10	10	0.5	10	30	9.8	-	-	75	10	B	●
AHSRP 4100R0.5 10100	D10R0.5x10x30xL100xSD10							-	100	10	B	●
AHSRP 4100R0.5 10125	D10R0.5x10x30xL125xSD10							-	125	10	B	●
AHSRP 4100R0.5 10150	D10R0.5x10x30xL150xSD10							-	150	10	B	●
AHSRP 4100R1.0 1075	D10R1x10x30xL75xSD10		1.0					-	75	10	B	●
AHSRP 4100R1.0 10100	D10R1x10x30xL100xSD10							-	100	10	B	●
AHSRP 4100R1.0 10150	D10R1x10x30xL150xSD10							-	150	10	B	●
AHSRP 4100R2.0 1075	D10R2x10x30xL75xSD10							-	75	10	B	●
AHSRP 4100R2.0 10100	D10R2x10x30xL100xSD10	2.0	-	100	10	B	●					
AHSRP 4120R0.5 1275	D12R0.5x12x36xL75xSD12	12	0.5	12	36	11.7	-	-	75	12	B	●
AHSRP 4120R0.5 12100	D12R0.5x12x36xL100xSD12							-	100	12	B	●
AHSRP 4120R0.5 12125	D12R0.5x12x36xL125xSD12							-	125	12	B	●
AHSRP 4120R0.5 12150	D12R0.5x12x36xL150xSD12							-	150	12	B	●
AHSRP 4120R1.0 1275	D12R1x12x36xL75xSD12		1.0					-	75	12	B	●
AHSRP 4120R1.0 12100	D12R1x12x36xL100xSD12							-	100	12	B	●
AHSRP 4120R1.0 12150	D12R1x12x36xL150xSD12							-	150	12	B	●
AHSRP 4120R2.0 1275	D12R2x12x36xL75xSD12							-	75	12	B	●
AHSRP 4120R2.0 12100	D12R2x12x36xL100xSD12		2.0					-	100	12	B	●

AHSR 6 刃圆鼻铣刀

AHSR 6-flute End Mills with Corner Radius



图B

- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工件表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance	刃径 ϕ_{dc}	R Tolerance
$3 < \phi \leq 6$	0 ~ -0.012	$\phi \leq 12$	± 0.005
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
	○	○	⊗	○	○	

订货编号 · Order code

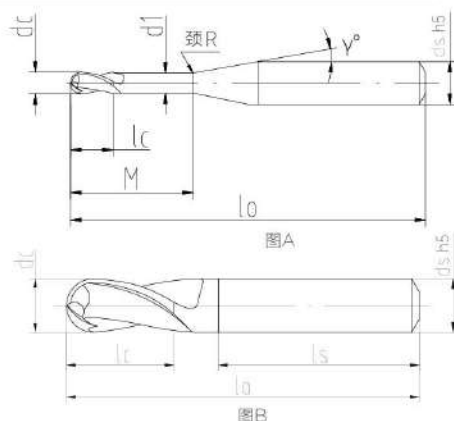
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	全长·lo	柄径·ds	图示 Graph	库存 Inventory	
AHSR 6060R0.5 0650	D6R0.5x15xL50xSD6	6	0.5	15	50	6	B	●	
AHSR 6060R0.5 0660	D6R0.5x15xL60xSD6				60	6	B	●	
AHSR 6060R1.0 0650	D6R1x15xL50xSD6		1.0		50	6	B	●	
AHSR 6060R1.0 0660	D6R1x15xL60xSD6				60	6	B	●	
AHSR 6080R0.5 0860	D8R0.5x20xL60xSD8	8	0.5	20	60	8	B	●	
AHSR 6080R0.5 0875	D8R0.5x20xL75xSD8				75	8	B	●	
AHSR 6080R1.0 0860	D8R1x20xL60xSD8		1.0		60	8	B	●	
AHSR 6080R1.0 0875	D8R1x20xL75xSD8				75	8	B	●	
AHSR 6100R0.5 1075	D10R0.5x25xL75xSD10	10	0.5	25	75	10	B	●	
AHSR 6100R0.5 10100	D10R0.5x25xL100xSD10				100	10	B	●	
AHSR 6100R1.0 1075	D10R1x25xL75xSD10		1.0		75	10	B	●	
AHSR 6100R1.0 10100	D10R1x25xL100xSD10				100	10	B	●	
AHSR 6100R2.0 1075	D10R2x25xL75xSD10		2.0		75	10	B	●	
AHSR 6100R2.0 10100	D10R2x25xL100xSD10				100	10	B	●	
AHSR 6120R0.5 1275	D12R0.5x30xL75xSD12	12	0.5	30	75	12	B	●	
AHSR 6120R0.5 12100	D12R0.5x30xL100xSD12				100	12	B	●	
AHSR 6120R1.0 1275	D12R1x30xL75xSD12		1.0		75	12	B	●	
AHSR 6120R1.0 12100	D12R1x30xL100xSD12				100	12	B	●	
AHSR 6120R2.0 1275	D12R2x30xL75xSD12		2.0		75	12	B	●	
AHSR 6120R2.0 12100	D12R2x30xL100xSD12				100	12	B	●	

AHSB 2 刃球头铣刀

AHSB 2-flute Ballnose End Mills



- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工作表面粗糙度;
- 高精度球头为精加工铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision ball-end is designed for finishing milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



刃径 ϕd_1	ϕd_1 Tolerance	刃径 ϕd_1	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 8$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012	$\phi > 8$	± 0.008
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
	○	○	⊗	○	○	○

订货编号 · Order code												
代码 Code	规格型号 Designation	刃径 · d_1	圆角半径 · R	刃长 · l_c	有效长 · M	颈径 · ϕd_1	颈 R · R	柄锥角度 γ°	全长 · l_o	柄径 · d_s	图示 Graph	库存 Inventory
AHSB 2004 0450	D0.4R0.2x0.6xL50xSD4	0.4	0.2	0.6	-	-	2	12	50	4	A	●
AHSB 2005 0450	D0.5R0.25x0.8xL50xSD4	0.5	0.25	0.8	-	-	2	12	50	4	A	●
AHSB 2006 0450	D0.6R0.3x0.9xL50xSD4	0.6	0.3	0.9	-	-	4	12	50	4	A	●
AHSB 2008 0450	D0.8R0.4x1.2xL50xSD4	0.8	0.4	1.2	-	-	4	12	50	4	A	●
AHSB 2010 0450	D1R0.5x0.8x2xL50xSD4	1	0.5	0.8	2.0	0.94	4	12	50	4	A	●
AHSB 2010 0650	D1R0.5x0.8x2.5xL50xSD6				2.5			12	50	6	A	●
AHSB 2010 0660	D1R0.5x0.8x2.5xL60xSD6				2.5			12	60	6	A	●
AHSB 2010 0675	D1R0.5x0.8x2.5xL75xSD6				2.5			12	75	6	A	●
AHSB 2010 06100	D1R0.5x0.8x2.5xL100xSD6				2.5			12	100	6	A	●
AHSB 2015 0450A	D1.5R0.75x1.2x3xL50xSD4	1.5	0.75	1.2	3	1.42	-	11	50	4	A	●
AHSB 2015 0450	D1.5R0.75x1.2x4xL50xSD4				4			11	50	4	A	●
AHSB 2015 0650	D1.5R0.75x1.2x4xL50xSD6				4			11	50	6	A	●
AHSB 2015 0660	D1.5R0.75x1.2x4xL60xSD6				4			11	60	6	A	●
AHSB 2015 0675	D1.5R0.75x1.2x4xL75xSD6				4			11	75	6	A	●
AHSB 2015 06100	D1.5R0.75x1.2x4xL100xSD6				4			11	100	6	A	●
AHSB 2020 0450	D2R1x1.6x6xL50xSD4	2	1	1.6	4	1.9	-	11	50	4	A	●
AHSB 2020 0650	D2R1x1.6x6xL50xSD6				6			11	50	6	A	●
AHSB 2020 0660	D2R1x1.6x6xL60xSD6				6			11	60	6	A	●
AHSB 2020 0675	D2R1x1.6x6xL75xSD6				6			11	75	6	A	●
AHSB 2020 06100	D2R1x1.6x6xL100xSD6				6			11	100	6	A	●
AHSB 2025 0450	D2.5R1.25x2x5xL50xSD4	2.5	1.25	2	5	2.4	-	11	50	4	A	●
AHSB 2025 0650	D2.5R1.25x2x7xL50xSD6				7			11	50	6	A	●
AHSB 2025 0660	D2.5R1.25x2x7xL60xSD6				7			11	60	6	A	●
AHSB 2025 0675	D2.5R1.25x2x7xL75xSD6				7			11	75	6	A	●
AHSB 2025 06100	D2.5R1.25x2x7xL100xSD6				7			11	100	6	A	●

A

B

C

D

E

F

G

H

订货编号 · Order code

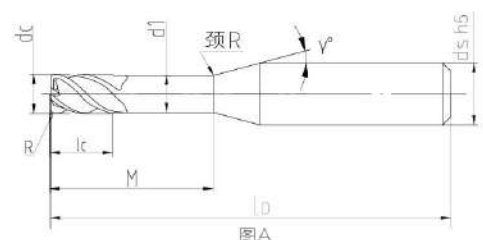
代码 Code	规格型号 Designation	刃径 · ds	圆角半径 · R	刃长 · lc	有效长 · M	颈径 · Ø d1	颈 R · R	柄锥角度 · γ / °	全长 · lo	柄径 · ds	图示 Graph	库存 Inventory
AHSB 2030 0450	D3R1.5x2.4x6xL50xSD4	3	1.5	2.4	6	2.9	-	11	50	4	A	●
AHSB 2030 0650	D3R1.5x2.4x8xL50xSD6				8			11	50	6	A	●
AHSB 2030 0660	D3R1.5x2.4x8xL60xSD6				8			11	60	6	A	●
AHSB 2030 0675	D3R1.5x2.4x8xL75xSD6				8			11	75	6	A	●
AHSB 2030 06100	D3R1.5x2.4x8xL100xSD6				8			11	100	6	A	●
AHSB 2040 0450	D4R2x6xL50xSD4	4	2	6	-	3.9	-	-	50	4	B	●
AHSB 2040 0475	D4R2x6xL75xSD4			3.2	-			-	75	4	B	●
AHSB 2040 0650	D4R2x3.2x10xL50xSD6				10			11	50	6	A	●
AHSB 2040 0660	D4R2x3.2x10xL60xSD6				10			11	60	6	A	●
AHSB 2040 0675	D4R2x3.2x10xL75xSD6				10			11	75	6	A	●
AHSB 2040 06100	D4R2x3.2x10xL100xSD6				10			11	100	6	A	●
AHSB 2050 0650	D5R2.5x4x12xL50xSD6	5	2.5	4	12	4.85	-	11	50	6	A	●
AHSB 2050 0660	D5R2.5x4x12xL60xSD6				12			11	60	6	A	●
AHSB 2050 0675	D5R2.5x4x12xL75xSD6				12			11	75	6	A	●
AHSB 2050 06100	D5R2.5x4x12xL100xSD6				12			11	100	6	A	●
AHSB 2060 0650	D6R3x9xL50xSD6	6	3	9	-	-	-	-	50	6	B	●
AHSB 2060 0660	D6R3x9xL60xSD6				-			-	60	6	B	●
AHSB 2060 0675	D6R3x9xL75xSD6				-			-	75	6	B	●
AHSB 2060 06100	D6R3x9xL100xSD6				-			-	100	6	B	●
AHSB 2080 0860	D8R4x12xL60xSD8	8	4	12	-	-	-	-	60	8	B	●
AHSB 2080 0875	D8R4x12xL75xSD8				-			-	75	8	B	●
AHSB 2080 08100	D8R4x12xL100xSD8				-			-	100	8	B	●
AHSB 2080 08125	D8R4x12xL125xSD8				-			-	125	8	B	●
AHSB 2080 08150	D8R4x12xL150xSD8				-			-	150	8	B	●
AHSB 2100 1075	D10R5x15xL75xSD10	10	5	15	-	-	-	-	75	10	B	●
AHSB 2100 10100	D10R5x15xL100xSD10				-			-	100	10	B	●
AHSB 2100 10125	D10R5x15xL125xSD10				-			-	125	10	B	●
AHSB 2100 10150	D10R5x15xL150xSD10				-			-	150	10	B	●
AHSB 2120 1275	D12R6x18xL75xSD12	12	6	18	-	-	-	-	75	12	B	●
AHSB 2120 12100	D12R6x18xL100xSD12				-			-	100	12	B	●
AHSB 2120 12125	D12R6x18xL125xSD12				-			-	125	12	B	●
AHSB 2120 12150	D12R6x18xL150xSD12				-			-	150	12	B	●
AHSB 2160 16100	D16R8x24xL100xSD16	16	8	24	-	-	-	-	100	16	B	●
AHSB 2160 16150	D16R8x24xL150xSD16				-			-	150	16	B	●

AHSRK 4 刃强力型圆鼻铣刀

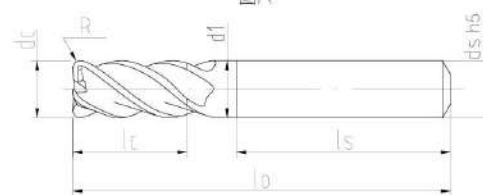
AHSRK 4-flute High-feed End Mills with Corner Radius



- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工作表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



图A



图B

刃径 ϕ dc	ϕ dc Tolerance	刃径 ϕ dc	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 12$	± 0.010
$3 < \phi \leq 6$	0 ~ -0.012		
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

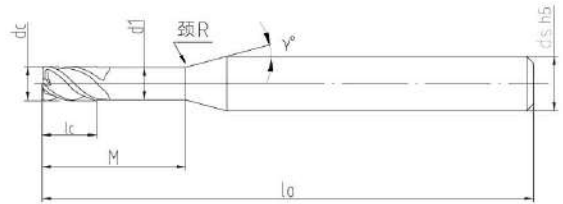
碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
		○	◎	○		

订货编号 · Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径 · $\varnothing$ d1	柄锥角度· $\gamma / ^\circ$	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHSRK 4030R0.5 0650	D3R0.5x1.2x10xL50xSD6	3	0.5	1.2	10	2.9	11	50	6	A	●
AHSRK 4030R0.5 0675	D3R0.5x1.2x10xL75xSD6						11	75	6	A	●
AHSRK 4030R1.0 0650	D3R1x1.2x10xL50xSD6		1				11	50	6	A	●
AHSRK 4030R1.0 0675	D3R1x1.2x10xL75xSD6						11	75	6	A	●
AHSRK 4040R0.5 0650	D4R0.5x1.6x12xL50xSD6	4	0.5	1.6	12	3.9	11	50	6	A	●
AHSRK 4040R0.5 0675	D4R0.5x1.6x12xL75xSD6						11	75	6	A	●
AHSRK 4040R1.0 0650	D4R1x1.6x12xL50xSD6		1				11	50	6	A	●
AHSRK 4040R1.0 0675	D4R1x1.6x12xL75xSD6						11	75	6	A	●
AHSRK 4050R1.0 0650	D5R1x2x15xL50xSD6	5	1	2	15	4.85	11	50	6	A	●
AHSRK 4050R1.0 0675	D5R1x2x15xL75xSD6						11	75	6	A	●
AHSRK 4060R1.0 0650	D6R1x2.5x18xL50xSD6	6	1	2.5	18	5.85	-	50	6	B	●
AHSRK 4060R1.0 0675	D6R1x2.5x18xL75xSD6						-	75	6	B	●
AHSRK 4060R1.5 0650	D6R1.5x2.5x18xL50xSD6		1.5				-	50	6	B	●
AHSRK 4060R1.5 0675	D6R1.5x2.5x18xL75xSD6						-	75	6	B	●
AHSRK 4080R1.0 0875	D8R1x3.5x24xL75xSD8	8	1	3.5	24	7.8	-	75	8	B	●
AHSRK 4080R1.0 0810	D8R1x3.5x24xL100xSD8						-	100	8	B	●
AHSRK 4100R1.0 1075	D10R1x4x30xL75xSD10	10	1	4	30	9.8	-	75	10	B	●
AHSRK 4100R1.0 10100	D10R1x4x30xL100xSD10						-	100	10	B	●
AHSRK 4100R2.0 1075	D10R2x4x30xL75xSD10		2				-	75	10	B	●
AHSRK 4100R2.0 10100	D10R2x4x30xL100xSD10						-	100	10	B	●
AHSRK 4120R2.0 1275	D12R2x5x36xL75xSD12	12	2	5	36	11.7	-	75	12	B	●
AHSRK 4120R2.0 12100	D12R2x5x36xL100xSD12						-	100	12	B	●
AHSRK 4120R3.0 1275	D12R3x5x36xL75xSD12		3				-	75	12	B	●
AHSRK 4120R3.0 12100	D12R3x5x36xL100xSD12						-	100	12	B	●

AHSEL 4 刃长颈平头铣刀

AHSEL 4-flute End Mills with Neck Increased



图A

- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工作表面粗糙度;
- 为高精度铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- Designed for high precision milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 3$	0 ~ -0.010
$3 < \phi \leq 6$	0 ~ -0.012

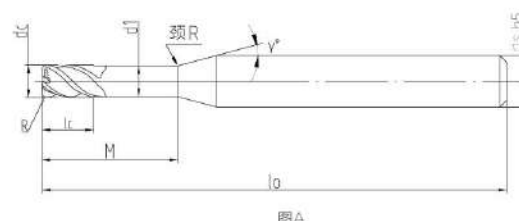
碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
		○	◎	○	○	○

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	刃长·lc	有效长 ·M	颈径 · ϕ_{d1}	颈 R·R	柄锥角度· $\gamma/^\circ$	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHSEL 4008L2 0450	D0.8x2xL50xSD4	0.8	0.6	2	0.76	4	12	50	4	A	●
AHSEL 4008L4 0450	D0.8x4xL50xSD4			4			12	50	4	A	●
AHSEL 4008L6 0450	D0.8x6xL50xSD4			6			12	50	4	A	●
AHSEL 4008L8 0450	D0.8x8xL50xSD4			8			12	50	4	A	●
AHSEL 4010L4 0450	D1x4xL50xSD4	1	0.8	4	0.94	4	12	50	4	A	●
AHSEL 4010L6 0450	D1x6xL50xSD4			6			12	50	4	A	●
AHSEL 4010L8 0450	D1x8xL50xSD4			8			12	50	4	A	●
AHSEL 4010L10 0450	D1x10xL50xSD4			10			12	50	4	A	●
AHSEL 4015L6 0450	D1.5x6xL50xSD4	1.5	1.2	6	1.42	-	11	50	4	A	●
AHSEL 4015L8 0450	D1.5x8xL50xSD4			8			11	50	4	A	●
AHSEL 4015L10 0450	D1.5x10xL50xSD4			10			11	50	4	A	●
AHSEL 4015L12 0450	D1.5x12xL50xSD4			12			11	50	4	A	●
AHSEL 4020L8 0450	D2x8xL50xSD4	2	1.6	8	1.9	-	11	50	4	A	●
AHSEL 4020L10 0450	D2x10xL50xSD4			10			11	50	4	A	●
AHSEL 4020L12 0450	D2x12xL50xSD4			12			11	50	4	A	●
AHSEL 4020L16 0450	D2x16xL50xSD4			16			11	50	4	A	●
AHSEL 4025L10 0450	D2.5x10xL50xSD4	2.5	2	10	2.4	-	11	50	4	A	●
AHSEL 4025L12 0450	D2.5x12xL50xSD4			12			11	50	4	A	●
AHSEL 4025L16 0450	D2.5x16xL50xSD4			16			11	50	4	A	●
AHSEL 4025L20 0450	D2.5x20xL50xSD4			20			11	50	4	A	●
AHSEL 4030L10 0450	D3x10xL50xSD4	3	2.4	10	2.9	-	11	50	4	A	●
AHSEL 4030L10 0660	D3x10xL60xSD6			10			11	60	6	A	●
AHSEL 4030L12 0450	D3x12xL50xSD4			12			11	50	4	A	●
AHSEL 4030L12 0660	D3x12xL60xSD6			12			11	60	6	A	●
AHSEL 4030L16 0450	D3x16xL50xSD4			16			11	50	4	A	●
AHSEL 4030L16 0660	D3x16xL60xSD6			16			11	60	6	A	●
AHSEL 4030L20 0660	D3x20xL60xSD6			20			11	60	6	A	●
AHSEL 4030L25 0675	D3x25xL75xSD6			25			11	75	6	A	●
AHSEL 4040L12 0660	D4x12xL60xSD6	4	3.2	12	3.9	-	11	60	6	A	●
AHSEL 4040L16 0660	D4x16xL60xSD6			16			11	60	6	A	●
AHSEL 4040L20 0660	D4x20xL60xSD6			20			11	60	6	A	●
AHSEL 4040L25 0675	D4x25xL75xSD6			25			11	75	6	A	●
AHSEL 4040L30 0675	D4x30xL75xSD6			30			11	75	6	A	●

AHSRL 4 刃长颈圆鼻铣刀

AHSRL 4-flute End Mills with Neck Increased & Corner Radius



图A

- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工件表面粗糙度;
- 为高精度铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- Designed for high precision milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance	刃径 ϕ_{dc}	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 4$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
		○	◎	○	○	○

订货编号 · Order code																		
代码 Code	规格型号 Designation	刃径 · ds	圆角半径 · R	刃长 · lc	有效长 · M	颈径 · Ø d1	颈 R · R	柄锥角度 · γ°	全长 · lo	柄径 · ds	图示 Graph	库存 Inventory						
AHSRL 4008R0.02L2 0450	D0.8R0.02x2xL50xSD4	0.8	0.02	0.6	2	0.76	4	12	50	4	A	●						
AHSRL 4008R0.02L3 0450	D0.8R0.02x3xL50xSD4				3			12	50	4	A	●						
AHSRL 4008R0.02L4 0450	D0.8R0.02x4xL50xSD4				4			12	50	4	A	●						
AHSRL 4008R0.02L6 0450	D0.8R0.02x6xL50xSD4				6			12	50	4	A	●						
AHSRL 4008R0.02L8 0450	D0.8R0.02x8xL50xSD4				8			12	50	4	A	●						
AHSRL 4008R0.02L10 0450	D0.8R0.02x10xL50xSD4				10			12	50	4	A	●						
AHSRL 4008R0.02L12 0450	D0.8R0.02x12xL50xSD4				12			12	50	4	A	●						
AHSRL 4008R0.05L2 0450	D0.8R0.05x2xL50xSD4		2		12			50	4	A	●							
AHSRL 4008R0.05L3 0450	D0.8R0.05x3xL50xSD4		3		12			50	4	A	●							
AHSRL 4008R0.05L4 0450	D0.8R0.05x4xL50xSD4		4		12			50	4	A	●							
AHSRL 4008R0.05L6 0450	D0.8R0.05x6xL50xSD4		6		12			50	4	A	●							
AHSRL 4008R0.05L8 0450	D0.8R0.05x8xL50xSD4		8		12			50	4	A	●							
AHSRL 4008R0.05L10 0450	D0.8R0.05x10xL50xSD4		10		12			50	4	A	●							
AHSRL 4008R0.05L12 0450	D0.8R0.05x12xL50xSD4		12		12			50	4	A	●							
AHSRL 4008R0.1L2 0450	D0.8R0.1x2xL50xSD4		2		0.1			0.6	0.76	4	12	50	4	A	●			
AHSRL 4008R0.1L3 0450	D0.8R0.1x3xL50xSD4		3								12	50	4	A	●			
AHSRL 4008R0.1L4 0450	D0.8R0.1x4xL50xSD4		4								12	50	4	A	●			
AHSRL 4008R0.1L6 0450	D0.8R0.1x6xL50xSD4		6								12	50	4	A	●			
AHSRL 4008R0.1L8 0450	D0.8R0.1x8xL50xSD4		8								12	50	4	A	●			
AHSRL 4008R0.1L10 0450	D0.8R0.1x10xL50xSD4		10								12	50	4	A	●			
AHSRL 4008R0.1L12 0450	D0.8R0.1x12xL50xSD4		12								12	50	4	A	●			
AHSRL 4008R0.2L2 0450	D0.8R0.2x2xL50xSD4		2		0.2						0.6	0.76	4	12	50	4	A	●
AHSRL 4008R0.2L3 0450	D0.8R0.2x3xL50xSD4		3											12	50	4	A	●
AHSRL 4008R0.2L4 0450	D0.8R0.2x4xL50xSD4		4											12	50	4	A	●
AHSRL 4008R0.2L6 0450	D0.8R0.2x6xL50xSD4		6											12	50	4	A	●
AHSRL 4008R0.2L8 0450	D0.8R0.2x8xL50xSD4		8											12	50	4	A	●
AHSRL 4008R0.2L10 0450	D0.8R0.2x10xL50xSD4		10											12	50	4	A	●
AHSRL 4008R0.2L12 0450	D0.8R0.2x12xL50xSD4		12											12	50	4	A	●
AHSRL 4009R0.1L4 0450	D0.9R0.1x4xL50xSD4	0.9	0.1	0.65	4	0.86	4							12	50	4	A	●
AHSRL 4009R0.1L8 0450	D0.9R0.1x8xL50xSD4				8									12	50	4	A	●

A

B

C

D

E

F

G

H

订货编号·Order code													
代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长 ·M	颈径 · ϕ d1	颈 R·R	柄锥角度· γ /°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory	
AHSRL 4010R0.05L3 0450	D1R0.05x3xL50xSD4	1	0.05	0.75	3	0.95	4	12	50	4	A	●	
AHSRL 4010R0.05L4 0450	D1R0.05x4xL50xSD4				4			12	50	4	A	●	
AHSRL 4010R0.05L5 0450	D1R0.05x5xL50xSD4				5			12	60	4	A	●	
AHSRL 4010R0.05L6 0450	D1R0.05x6xL50xSD4				6			12	50	4	A	●	
AHSRL 4010R0.05L8 0450	D1R0.05x8xL50xSD4				8			12	50	4	A	●	
AHSRL 4010R0.05L10 0450	D1R0.05x10xL50xSD4				10			12	50	4	A	●	
AHSRL 4010R0.05L12 0450	D1R0.05x12xL50xSD4				12			12	50	4	A	●	
AHSRL 4010R0.05L16 0450	D1R0.05x16xL50xSD4				16			12	50	4	A	●	
AHSRL 4010R0.05L20 0460	D1R0.05x20xL60xSD4				20			12	60	4	A	●	
AHSRL 4010R0.1L3 0450	D1R0.1x3xL50xSD4		0.1	0.75	3			12	50	4	A	●	
AHSRL 4010R0.1L4 0450	D1R0.1x4xL50xSD4				4			12	50	4	A	●	
AHSRL 4010R0.1L5 0450	D1R0.1x5xL50xSD4				5			12	50	4	A	●	
AHSRL 4010R0.1L6 0450	D1R0.1x6xL50xSD4				6			12	50	4	A	●	
AHSRL 4010R0.1L8 0450	D1R0.1x8xL50xSD4				8			12	50	4	A	●	
AHSRL 4010R0.1L10 0450	D1R0.1x10xL50xSD4				10			12	50	4	A	●	
AHSRL 4010R0.1L12 0450	D1R0.1x12xL50xSD4				12			12	50	4	A	●	
AHSRL 4010R0.1L16 0450	D1R0.1x16xL50xSD4				16			12	50	4	A	●	
AHSRL 4010R0.1L20 0460	D1R0.1x20xL60xSD4				20			12	60	4	A	●	
AHSRL 4010R0.2L3 0450	D1R0.2x3xL50xSD4		0.2	0.75	3			12	50	4	A	●	
AHSRL 4010R0.2L4 0450	D1R0.2x4xL50xSD4				4			12	50	4	A	●	
AHSRL 4010R0.2L5 0450	D1R0.2x5xL50xSD4				5			12	50	4	A	●	
AHSRL 4010R0.2L6 0450	D1R0.2x6xL50xSD4				6			12	50	4	A	●	
AHSRL 4010R0.2L8 0450	D1R0.2x8xL50xSD4				8			12	50	4	A	●	
AHSRL 4010R0.2L10 0450	D1R0.2x10xL50xSD4				10			12	50	4	A	●	
AHSRL 4010R0.2L12 0450	D1R0.2x12xL50xSD4				12			12	50	4	A	●	
AHSRL 4010R0.2L16 0450	D1R0.2x16xL50xSD4				16			12	50	4	A	●	
AHSRL 4010R0.2L20 0460	D1R0.2x20xL60xSD4				20			12	60	4	A	●	
AHSRL 4010R0.3L3 0450	D1R0.3x3xL50xSD4		0.3	0.75	3			12	50	4	A	●	
AHSRL 4010R0.3L4 0450	D1R0.3x4xL50xSD4				4			12	50	4	A	●	
AHSRL 4010R0.3L5 0450	D1R0.3x5xL50xSD4				5			12	50	4	A	●	
AHSRL 4010R0.3L6 0450	D1R0.3x6xL50xSD4				6			12	50	4	A	●	
AHSRL 4010R0.3L8 0450	D1R0.3x8xL50xSD4				8			12	50	4	A	●	
AHSRL 4010R0.3L10 0450	D1R0.3x10xL50xSD4				10			12	50	4	A	●	
AHSRL 4010R0.3L12 0450	D1R0.3x12xL50xSD4				12			12	50	4	A	●	
AHSRL 4010R0.3L16 0450	D1R0.3x16xL50xSD4				16			12	50	4	A	●	
AHSRL 4010R0.3L20 0460	D1R0.3x20xL60xSD4				20			12	60	4	A	●	
AHSRL 4015R0.1L6 0450	D1.5R0.1x6xL50xSD4	1.5	0.1	1.2	6	1.42	-	11	50	4	A	●	
AHSRL 4015R0.1L8 0450	D1.5R0.1x8xL50xSD4				8			11	50	4	A	●	
AHSRL 4015R0.1L10 0450	D1.5R0.1x10xL50xSD4				10			11	50	4	A	●	
AHSRL 4015R0.1L12 0450	D1.5R0.1x12xL50xSD4				12			11	50	4	A	●	
AHSRL 4015R0.2L6 0450	D1.5R0.2x6xL50xSD4		0.2		6			11	50	4	A	●	
AHSRL 4015R0.2L8 0450	D1.5R0.2x8xL50xSD4				8			11	50	4	A	●	
AHSRL 4015R0.2L10 0450	D1.5R0.2x10xL50xSD4				10			11	50	4	A	●	
AHSRL 4015R0.2L12 0450	D1.5R0.2x12xL50xSD4				12			11	50	4	A	●	
AHSRL 4020R0.1L8 0450	D2R0.1x8xL50xSD4	2	0.1	1.6	8	1.9	-	11	50	4	A	●	
AHSRL 4020R0.1L10 0450	D2R0.1x10xL50xSD4				10			11	50	4	A	●	
AHSRL 4020R0.1L12 0450	D2R0.1x12xL50xSD4				12			11	50	4	A	●	
AHSRL 4020R0.1L16 0450	D2R0.1x16xL50xSD4				16			11	50	4	A	●	
AHSRL 4020R0.2L8 0450	D2R0.2x8xL50xSD4		0.2		8			11	50	4	A	●	
AHSRL 4020R0.2L10 0450	D2R0.2x10xL50xSD4				10			11	50	4	A	●	
AHSRL 4020R0.2L12 0450	D2R0.2x12xL50xSD4				12			11	50	4	A	●	
AHSRL 4020R0.2L16 0450	D2R0.2x16xL50xSD4				16			11	50	4	A	●	
AHSRL 4020R0.5L8 0450	D2R0.5x8xL50xSD4		0.5		8			11	50	4	A	●	
AHSRL 4020R0.5L10 0450	D2R0.5x10xL50xSD4				10			11	50	4	A	●	
AHSRL 4020R0.5L12 0450	D2R0.5x12xL50xSD4				12			11	50	4	A	●	
AHSRL 4020R0.5L16 0450	D2R0.5x16xL50xSD4				16			11	50	4	A	●	
AHSRL 4030R0.1L10 0450	D3R0.1x10xL50xSD4	3	0.1	2.4	10	2.9	-	11	50	4	A	●	
AHSRL 4030R0.1L10 0660	D3R0.1x10xL60xSD6				10			11	60	6	A	●	
AHSRL 4030R0.1L12 0450	D3R0.1x12xL50xSD4				12			11	50	4	A	●	
AHSRL 4030R0.1L12 0660	D3R0.1x12xL60xSD6				12			11	60	6	A	●	
AHSRL 4030R0.1L16 0450	D3R0.1x16xL50xSD4				16			11	50	4	A	●	
AHSRL 4030R0.1L16 0660	D3R0.1x16xL60xSD6				16			11	60	6	A	●	

A

B

C

D

E

F

G

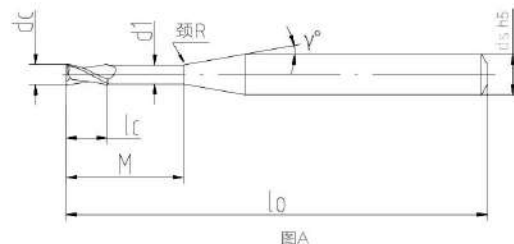
H

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长 ·M	颈径 · $\varnothing$ d1	颈 R·R	柄锥角度· γ /°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory	
AHSRL 4030R0.1L20 0660	D3R0.1x20xL60xSD6	3	0.1	2.4	20	2.9	-	11	60	6	A	●	
AHSRL 4030R0.1L25 0675	D3R0.1x25xL75xSD6				25			11	75	6	A	●	
AHSRL 4030R0.2L10 0450	D3R0.2x10xL50xSD4		10		11			50	4	A	●		
AHSRL 4030R0.2L10 0660	D3R0.2x10xL60xSD6		10		11			60	6	A	●		
AHSRL 4030R0.2L12 0450	D3R0.2x12xL50xSD4		12		11			50	4	A	●		
AHSRL 4030R0.2L12 0660	D3R0.2x12xL60xSD6		12		11			60	6	A	●		
AHSRL 4030R0.2L16 0450	D3R0.2x16xL50xSD4		16		11			50	4	A	●		
AHSRL 4030R0.2L16 0660	D3R0.2x16xL60xSD6		16		11			60	6	A	●		
AHSRL 4030R0.2L20 0660	D3R0.2x20xL60xSD6		20		11			60	6	A	●		
AHSRL 4030R0.2L25 0675	D3R0.2x25xL75xSD6		25		11			75	6	A	●		
AHSRL 4030R0.5L10 0450	D3R0.5x10xL50xSD4		10		11			50	4	A	●		
AHSRL 4030R0.5L10 0660	D3R0.5x10xL60xSD6		10		11			60	6	A	●		
AHSRL 4030R0.5L12 0450	D3R0.5x12xL50xSD4		12		11			50	4	A	●		
AHSRL 4030R0.5L12 0660	D3R0.5x12xL60xSD6		12		11			60	6	A	●		
AHSRL 4030R0.5L16 0450	D3R0.5x16xL50xSD4		16		11			50	4	A	●		
AHSRL 4030R0.5L16 0660	D3R0.5x16xL60xSD6		16		11			60	6	A	●		
AHSRL 4030R0.5L20 0660	D3R0.5x20xL60xSD6		20		11			60	6	A	●		
AHSRL 4030R0.5L25 0675	D3R0.5x25xL75xSD6		25		11			75	6	A	●		
AHSRL 4040R0.1L12 0660	D4R0.1x12xL60xSD6	4	0.1	3.2	12	3.9	-	11	60	6	A	●	
AHSRL 4040R0.1L16 0660	D4R0.1x16xL60xSD6				16			11	60	6	A	●	
AHSRL 4040R0.1L20 0660	D4R0.1x20xL60xSD6				20			11	60	6	A	●	
AHSRL 4040R0.1L25 0675	D4R0.1x25xL75xSD6				25			11	75	6	A	●	
AHSRL 4040R0.1L30 0675	D4R0.1x30xL75xSD6				30			11	75	6	A	●	
AHSRL 4040R0.2L12 0660	D4R0.2x12xL60xSD6		0.2		12			11	60	6	A	●	
AHSRL 4040R0.2L16 0660	D4R0.2x16xL60xSD6				16			11	60	6	A	●	
AHSRL 4040R0.2L20 0660	D4R0.2x20xL60xSD6				20			11	60	6	A	●	
AHSRL 4040R0.2L25 0675	D4R0.2x25xL75xSD6				25			11	75	6	A	●	
AHSRL 4040R0.2L30 0675	D4R0.2x30xL75xSD6				30			11	75	6	A	●	
AHSRL 4040R0.5L12 0660	D4R0.5x12xL60xSD6		0.5		12			11	60	6	A	●	
AHSRL 4040R0.5L16 0660	D4R0.5x16xL60xSD6				16			11	60	6	A	●	
AHSRL 4040R0.5L20 0660	D4R0.5x20xL60xSD6				20			11	60	6	A	●	
AHSRL 4040R0.5L25 0675	D4R0.5x25xL75xSD6				25			11	75	6	A	●	
AHSRL 4040R0.5L30 0675	D4R0.5x30xL75xSD6				30			11	75	6	A	●	
AHSRL 4040R1.0L12 0660	D4R1x12xL60xSD6		1.0		12			11	60	6	A	●	
AHSRL 4040R1.0L16 0660	D4R1x16xL60xSD6				16			11	60	6	A	●	
AHSRL 4040R1.0L20 0660	D4R1x20xL60xSD6				20			11	60	6	A	●	
AHSRL 4040R1.0L25 0675	D4R1x25xL75xSD6				25			11	75	6	A	●	
AHSRL 4040R1.0L30 0675	D4R1x30xL75xSD6				30			11	75	6	A	●	

AHSEL 2 刃长颈平头铣刀

AHSEL 2-flute End Mills with Neck Increased



图A

- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工作表面粗糙度;
- 为高精度铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- Designed for high precision milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 3$	0 ~ -0.010
$3 < \phi \leq 6$	0 ~ -0.012

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
		○	◎	○	○	○

订货编号 · Order code

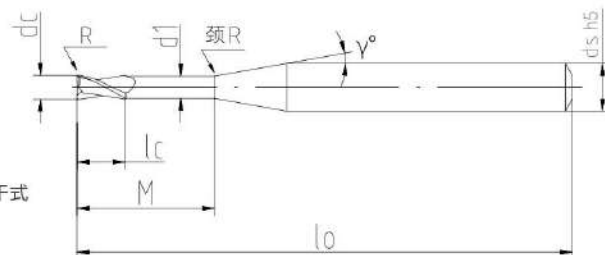
代码 Code	规格型号 Designation	刃径 · d_s	刃长 · l_c	有效长 · M	颈径 · ϕ_{d1}	颈 R · R	柄锥角度 · γ°	全长 · l_o	柄径 · d_s	图示 Graph	库存 Inventory
AHSEL 2001L0.3 0450	D0.1x0.3xL50xSD4	0.1	0.07	0.3	0.085	2	12	50	4	A	●
AHSEL 2001L0.5 0450	D0.1x0.5xL50xSD4			0.5			12	50	4	A	●
AHSEL 2001L1 0450	D0.1x1xL50xSD4			1			12	50	4	A	●
AHSEL 2002L0.5 0450	D0.2x0.5xL50xSD4	0.2	0.15	0.5	0.18	2	12	50	4	A	●
AHSEL 2002L1 0450	D0.2x1xL50xSD4			1			12	50	4	A	●
AHSEL 2002L2 0450	D0.2x2xL50xSD4			2			12	50	4	A	●
AHSEL 2003L1 0450	D0.3x1xL50xSD4	0.3	0.2	1	0.28	2	12	50	4	A	●
AHSEL 2003L2 0450	D0.3x2xL50xSD4			2			12	50	4	A	●
AHSEL 2003L3 0450	D0.3x3xL50xSD4			3			12	50	4	A	●
AHSEL 2004L2 0450	D0.4x2xL50xSD4	0.4	0.3	2	0.36	2	12	50	4	A	●
AHSEL 2004L3 0450	D0.4x3xL50xSD4			3			12	50	4	A	●
AHSEL 2005L2 0450	D0.5x2xL50xSD4			2			12	50	4	A	●
AHSEL 2005L3 0450	D0.53xL50xSD4	0.5	0.4	3	0.46	2	12	50	4	A	●
AHSEL 2005L4 0450	D0.5x4xL50xSD4			4			12	50	4	A	●
AHSEL 2006L2 0450	D0.6x2xL50xSD4			2			12	50	4	A	●
AHSEL 2006L3 0450	D0.6x3xL50xSD4	0.6	0.5	3	0.56	4	12	50	4	A	●
AHSEL 2006L4 0450	D0.6x4xL50xSD4			4			12	50	4	A	●
AHSEL 2008L4 0450	D0.8x4xL50xSD4			4			12	50	4	A	●
AHSEL 2008L6 0450	D0.8x6xL50xSD4	0.8	0.7	6	0.76	4	12	50	4	A	●
AHSEL 2010L4 0450	D1x4xL50xSD4			4			12	50	4	A	●
AHSEL 2010L6 0450	D1x6xL50xSD4			6			12	50	4	A	●
AHSEL 2010L8 0450	D1x8xL50xSD4	1	0.8	8	0.94	4	12	50	4	A	●
AHSEL 2010L10 0450	D1x10xL50xSD4			10			12	50	4	A	●

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	刃长·lc	有效长·M	颈径 · $\varnothing d1$	颈 R·R	柄锥角度· γ/P	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory
AHSEL 2015L6 0450	D1.5x6xL50xSD4	1.5	1.2	6	1.42	-	11	50	4	A	●
AHSEL 2015L8 0450	D1.5x8xL50xSD4			8			11	50	4	A	●
AHSEL 2015L10 0450	D1.5x10xL50xSD4			10			11	50	4	A	●
AHSEL 2015L12 0450	D1.5x12xL50xSD4			12			11	50	4	A	●
AHSEL 2020L8 0450	D2x8xL50xSD4	2	1.6	8	1.9	-	11	50	4	A	●
AHSEL 2020L10 0450	D2x10xL50xSD4			10			11	50	4	A	●
AHSEL 2020L12 0450	D2x12xL50xSD4			12			11	50	4	A	●
AHSEL 2020L16 0450	D2x16xL50xSD4			16			11	50	4	A	●
AHSEL 2025L10 0450	D2.5x10xL50xSD4	2.5	2	10	2.4	-	11	50	4	A	●
AHSEL 2025L12 0450	D2.5x12xL50xSD4			12			11	50	4	A	●
AHSEL 2025L16 0450	D2.5x16xL50xSD4			16			11	50	4	A	●
AHSEL 2025L20 0450	D2.5x20xL50xSD4			20			11	50	4	A	●
AHSEL 2030L10 0450	D3x10xL50xSD4	3	2.4	10	2.9	-	11	50	4	A	●
AHSEL 2030L10 0660	D3x10xL60xSD6			10			11	60	6	A	●
AHSEL 2030L12 0450	D3x12xL50xSD4			12			11	50	4	A	●
AHSEL 2030L12 0660	D3x12xL60xSD6			12			11	60	6	A	●
AHSEL 2030L16 0450	D3x16xL50xSD4			16			11	50	4	A	●
AHSEL 2030L16 0660	D3x16xL60xSD6			16			11	60	6	A	●
AHSEL 2030L20 0660	D3x20xL60xSD6			20			11	60	6	A	●
AHSEL 2030L25 0675	D3x25xL75xSD6			25			11	75	6	A	●
AHSEL 2040L12 0660	D4x12xL60xSD6	4	3.2	12	3.9	-	11	60	6	A	●
AHSEL 2040L16 0660	D4x16xL60xSD6			16			11	60	6	A	●
AHSEL 2040L20 0660	D4x20xL60xSD6			20			11	60	6	A	●
AHSEL 2040L25 0675	D4x25xL75xSD6			25			11	75	6	A	●
AHSEL 2040L30 0675	D4x30xL75xSD6			30			11	75	6	A	●

AHSRL 2 刃长颈圆鼻铣刀

AHSRL 2-flute End Mills with Neck Increased & Corner Radius



图A

- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工作表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刀;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 3$	0 ~ -0.010
$3 < \phi \leq 6$	0 ~ -0.012

刃径 ϕ_{dc}	R Tolerance
$\phi \leq 4$	± 0.005

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长 ·M	颈径 · ϕ_{d1}	颈 R ·R	柄锥角度· γ°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory
AHSRL 2002R0.02L0.5 0450	D0.2R0.02x0.5xL50xSD4	0.2	0.02	0.15	0.5	0.18	2	12	50	4	A	●
AHSRL 2002R0.02L1 0450	D0.2R0.02x1xL50xSD4				1			12	50	4	A	●
AHSRL 2002R0.02L1.5 0450	D0.2R0.02x1.5xL50xSD4				1.5			12	50	4	A	●
AHSRL 2002R0.02L2 0450	D0.2R0.02x2xL50xSD4		2		12			50	4	A	●	
AHSRL 2002R0.05L0.5 0450	D0.2R0.05x0.5xL50xSD4		0.5		12			50	4	A	●	
AHSRL 2002R0.05L1 0450	D0.2R0.05x1xL50xSD4		1		12			50	4	A	●	
AHSRL 2002R0.05L1.5 0450	D0.2R0.05x1.5xL50xSD4		1.5		12			50	4	A	●	
AHSRL 2002R0.05L2 0450	D0.2R0.05x2xL50xSD4		2		12			50	4	A	●	
AHSRL 2003R0.02L1 0450	D0.3R0.02x1xL50xSD4	0.3	0.02	0.2	1	0.28	2	12	50	4	A	●
AHSRL 2003R0.02L1.5 0450	D0.3R0.02x1.5xL50xSD4				1.5			12	50	4	A	●
AHSRL 2003R0.02L2 0450	D0.3R0.02x2xL50xSD4				2			12	50	4	A	●
AHSRL 2003R0.02L2.5 0450	D0.3R0.02x2.5xL50xSD4		2.5		12			50	4	A	●	
AHSRL 2003R0.02L3 0450	D0.3R0.02x3xL50xSD4		3		12			50	4	A	●	
AHSRL 2003R0.05L1 0450	D0.3R0.05x1xL50xSD4		1		12			50	4	A	●	
AHSRL 2003R0.05L1.5 0450	D0.3R0.05x1.5xL50xSD4		1.5		12			50	4	A	●	
AHSRL 2003R0.05L2 0450	D0.3R0.05x2xL50xSD4		2		12			50	4	A	●	
AHSRL 2003R0.05L2.5 0450	D0.3R0.05x2.5xL50xSD4	2.5	12	50	4	A	●					
AHSRL 2003R0.05L3 0450	D0.3R0.05x3xL50xSD4	3	12	50	4	A	●					
AHSRL 2004R0.02L1 0450	D0.4R0.02x1xL50xSD4	0.4	0.02	0.3	1	0.37	2	12	50	4	A	●
AHSRL 2004R0.02L1.5 0450	D0.4R0.02x1.5xL50xSD4				1.5			12	50	4	A	●
AHSRL 2004R0.02L2 0450	D0.4R0.02x2xL50xSD4				2			12	50	4	A	●
AHSRL 2004R0.02L2.5 0450	D0.4R0.02x2.5xL50xSD4				2.5			12	50	4	A	●
AHSRL 2004R0.02L3 0450	D0.4R0.02x3xL50xSD4				3			12	50	4	A	●
AHSRL 2004R0.02L4 0450	D0.4R0.02x4xL50xSD4		4		12			50	4	A	●	
AHSRL 2004R0.05L1 0450	D0.4R0.05x1xL50xSD4		1		12			50	4	A	●	
AHSRL 2004R0.05L1.5 0450	D0.4R0.05x1.5xL50xSD4		1.5		12			50	4	A	●	
AHSRL 2004R0.05L2 0450	D0.4R0.05x2xL50xSD4		2		12			50	4	A	●	
AHSRL 2004R0.05L2.5 0450	D0.4R0.05x2.5xL50xSD4		2.5		12			50	4	A	●	
AHSRL 2004R0.05L3 0450	D0.4R0.05x3xL50xSD4		3		12			50	4	A	●	
AHSRL 2004R0.05L4 0450	D0.4R0.05x4xL50xSD4		4		12			50	4	A	●	
AHSRL 2004R0.1L1 0450	D0.4R0.1x1xL50xSD4		1		12			50	4	A	●	
AHSRL 2004R0.1L1.5 0450	D0.4R0.1x1.5xL50xSD4		1.5		12			50	4	A	●	

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长 ·M	颈径 · ϕ d1	颈 R ·R	柄锥角度· γ /°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory	
AHSRL 2004R0.1L2 0450	D0.4R0.1x2xL50xSD4	0.4	0.1	0.3	2	0.37	2	12	50	4	A	●	
AHSRL 2004R0.1L2.5 0450	D0.4R0.1x2.5xL50xSD4				2.5			12	50	4	A	●	
AHSRL 2004R0.1L3 0450	D0.4R0.1x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2004R0.1L4 0450	D0.4R0.1x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2005R0.02L1 0450	D0.5R0.02x1xL50xSD4	0.5	0.02	0.35	1	0.46	2	12	50	4	A	●	
AHSRL 2005R0.02L1.5 0450	D0.5R0.02x1.5xL50xSD4				1.5			12	50	4	A	●	
AHSRL 2005R0.02L2 0450	D0.5R0.02x2xL50xSD4				2			12	50	4	A	●	
AHSRL 2005R0.02L2.5 0450	D0.5R0.02x2.5xL50xSD4				2.5			12	50	4	A	●	
AHSRL 2005R0.02L3 0450	D0.5R0.02x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2005R0.02L4 0450	D0.5R0.02x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2005R0.02L5 0450	D0.5R0.02x5xL50xSD4				5			12	50	4	A	●	
AHSRL 2005R0.02L6 0450	D0.5R0.02x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2005R0.05L1 0450	D0.5R0.05x1xL50xSD4		0.05		1			12	50	4	A	●	
AHSRL 2005R0.05L1.5 0450	D0.5R0.05x1.5xL50xSD4				1.5			12	50	4	A	●	
AHSRL 2005R0.05L2 0450	D0.5R0.05x2xL50xSD4				2			12	50	4	A	●	
AHSRL 2005R0.05L2.5 0450	D0.5R0.05x2.5xL50xSD4				2.5			12	50	4	A	●	
AHSRL 2005R0.05L3 0450	D0.5R0.05x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2005R0.05L4 0450	D0.5R0.05x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2005R0.05L5 0450	D0.5R0.05x5xL50xSD4				5			12	50	4	A	●	
AHSRL 2005R0.05L6 0450	D0.5R0.05x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2005R0.1L1 0450	D0.5R0.1x1xL50xSD4		0.1		1			12	50	4	A	●	
AHSRL 2005R0.1L1.5 0450	D0.5R0.1x1.5xL50xSD4				1.5			12	50	4	A	●	
AHSRL 2005R0.1L2 0450	D0.5R0.1x2xL50xSD4				2			12	50	4	A	●	
AHSRL 2005R0.1L2.5 0450	D0.5R0.1x2.5xL50xSD4				2.5			12	50	4	A	●	
AHSRL 2005R0.1L3 0450	D0.5R0.1x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2005R0.1L4 0450	D0.5R0.1x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2005R0.1L5 0450	D0.5R0.1x5xL50xSD4				5			12	50	4	A	●	
AHSRL 2005R0.1L6 0450	D0.5R0.1x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2006R0.02L2 0450	D0.6R0.02x2xL50xSD4	0.6	0.02	0.45	2	0.56	4	12	50	4	A	●	
AHSRL 2006R0.02L3 0450	D0.6R0.02x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2006R0.02L4 0450	D0.6R0.02x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2006R0.02L6 0450	D0.6R0.02x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2006R0.02L8 0450	D0.6R0.02x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2006R0.02L10 0450	D0.6R0.02x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2006R0.05L2 0450	D0.6R0.05x2xL50xSD4		0.05		2			12	50	4	A	●	
AHSRL 2006R0.05L3 0450	D0.6R0.05x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2006R0.05L4 0450	D0.6R0.05x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2006R0.05L6 0450	D0.6R0.05x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2006R0.05L8 0450	D0.6R0.05x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2006R0.05L10 0450	D0.6R0.05x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2006R0.1L2 0450	D0.6R0.1x2xL50xSD4		0.1		2			12	50	4	A	●	
AHSRL 2006R0.1L3 0450	D0.6R0.1x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2006R0.1L4 0450	D0.6R0.1x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2006R0.1L6 0450	D0.6R0.1x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2006R0.1L8 0450	D0.6R0.1x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2006R0.1L10 0450	D0.6R0.1x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2007R0.02L2 0450	D0.7R0.02x2xL50xSD4	0.7	0.02	0.5	2	0.66	4	12	50	4	A	●	
AHSRL 2007R0.02L3 0450	D0.7R0.02x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2007R0.02L4 0450	D0.7R0.02x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2007R0.02L6 0450	D0.7R0.02x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2007R0.02L8 0450	D0.7R0.02x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2007R0.02L10 0450	D0.7R0.02x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2007R0.05L2 0450	D0.7R0.05x2xL50xSD4		0.05		2			12	50	4	A	●	
AHSRL 2007R0.05L3 0450	D0.7R0.05x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2007R0.05L4 0450	D0.7R0.05x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2007R0.05L6 0450	D0.7R0.05x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2007R0.05L8 0450	D0.7R0.05x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2007R0.05L10 0450	D0.7R0.05x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2007R0.1L2 0450	D0.7R0.1x2xL50xSD4		0.1		2			12	50	4	A	●	
AHSRL 2007R0.1L3 0450	D0.7R0.1x3xL50xSD4				3			12	50	4	A	●	

A

B

C

D

E

F

G

H

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刀长·lc	有效长 ·M	颈径 · $\varnothing$ d1	颈 R ·R	柄锥角度· γ /°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory	
AHSRL 2007R0.1L4 0450	D0.7R0.1x4xL50xSD4	0.7	0.1	0.5	4	0.66	4	12	50	4	A	●	
AHSRL 2007R0.1L6 0450	D0.7R0.1x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2007R0.1L8 0450	D0.7R0.1x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2007R0.1L10 0450	D0.7R0.1x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2008R0.02L2 0450	D0.8R0.02x2xL50xSD4	0.8	0.02	0.6	2	0.76	4	12	50	4	A	●	
AHSRL 2008R0.02L3 0450	D0.8R0.02x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2008R0.02L4 0450	D0.8R0.02x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2008R0.02L6 0450	D0.8R0.02x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2008R0.02L8 0450	D0.8R0.02x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2008R0.02L10 0450	D0.8R0.02x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2008R0.02L12 0450	D0.8R0.02x12xL50xSD4				12			12	50	4	A	●	
AHSRL 2008R0.05L2 0450	D0.8R0.05x2xL50xSD4		0.05		2			12	50	4	A	●	
AHSRL 2008R0.05L3 0450	D0.8R0.05x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2008R0.05L4 0450	D0.8R0.05x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2008R0.05L6 0450	D0.8R0.05x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2008R0.05L8 0450	D0.8R0.05x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2008R0.05L10 0450	D0.8R0.05x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2008R0.05L12 0450	D0.8R0.05x12xL50xSD4				12			12	50	4	A	●	
AHSRL 2008R0.1L2 0450	D0.8R0.1x2xL50xSD4		0.1		2			12	50	4	A	●	
AHSRL 2008R0.1L3 0450	D0.8R0.1x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2008R0.1L4 0450	D0.8R0.1x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2008R0.1L6 0450	D0.8R0.1x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2008R0.1L8 0450	D0.8R0.1x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2008R0.1L10 0450	D0.8R0.1x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2008R0.1L12 0450	D0.8R0.1x12xL50xSD4				12			12	50	4	A	●	
AHSRL 2008R0.2L2 0450	D0.8R0.2x2xL50xSD4		0.2		2			12	50	4	A	●	
AHSRL 2008R0.2L3 0450	D0.8R0.2x3xL50xSD4				3			12	50	4	A	●	
AHSRL 2008R0.2L4 0450	D0.8R0.2x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2008R0.2L6 0450	D0.8R0.2x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2008R0.2L8 0450	D0.8R0.2x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2008R0.2L10 0450	D0.8R0.2x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2008R0.2L12 0450	D0.8R0.2x12xL50xSD4				12			12	50	4	A	●	
AHSRL 2009R0.1L4 0450	D0.9R0.1x4xL50xSD4	0.9	0.1	0.65	4	0.86	4	12	50	4	A	●	
AHSRL 2009R0.1L8 0450	D0.9R0.1x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2010R0.05L3 0450	D1R0.05x3xL50xSD4	1	0.05	0.75	3	0.95	4	12	50	4	A	●	
AHSRL 2010R0.05L4 0450	D1R0.05x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2010R0.05L5 0450	D1R0.05x5xL50xSD4				5			12	60	4	A	●	
AHSRL 2010R0.05L6 0450	D1R0.05x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2010R0.05L8 0450	D1R0.05x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2010R0.05L10 0450	D1R0.05x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2010R0.05L12 0450	D1R0.05x12xL50xSD4				12			12	50	4	A	●	
AHSRL 2010R0.05L16 0450	D1R0.05x16xL50xSD4				16			12	50	4	A	●	
AHSRL 2010R0.05L20 0460	D1R0.05x20xL60xSD4				20			12	50	4	A	●	
AHSRL 2010R0.1L3 0450	D1R0.1x3xL50xSD4		0.1		3			12	50	4	A	●	
AHSRL 2010R0.1L4 0450	D1R0.1x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2010R0.1L5 0450	D1R0.1x5xL50xSD4				5			12	50	4	A	●	
AHSRL 2010R0.1L6 0450	D1R0.1x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2010R0.1L8 0450	D1R0.1x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2010R0.1L10 0450	D1R0.1x10xL50xSD4				10			12	60	4	A	●	
AHSRL 2010R0.1L12 0450	D1R0.1x12xL50xSD4				12			12	50	4	A	●	
AHSRL 2010R0.1L16 0450	D1R0.1x16xL50xSD4				16			12	50	4	A	●	
AHSRL 2010R0.1L20 0460	D1R0.1x20xL60xSD4				20			12	60	4	A	●	
AHSRL 2010R0.2L3 0450	D1R0.2x3xL50xSD4		0.2		3			12	50	4	A	●	
AHSRL 2010R0.2L4 0450	D1R0.2x4xL50xSD4				4			12	50	4	A	●	
AHSRL 2010R0.2L5 0450	D1R0.2x5xL50xSD4				5			12	50	4	A	●	
AHSRL 2010R0.2L6 0450	D1R0.2x6xL50xSD4				6			12	50	4	A	●	
AHSRL 2010R0.2L8 0450	D1R0.2x8xL50xSD4				8			12	50	4	A	●	
AHSRL 2010R0.2L10 0450	D1R0.2x10xL50xSD4				10			12	50	4	A	●	
AHSRL 2010R0.2L12 0450	D1R0.2x12xL50xSD4				12			12	50	4	A	●	
AHSRL 2010R0.2L16 0450	D1R0.2x16xL50xSD4				16			12	50	4	A	●	

订货编号·Order code													
代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刀长·lc	有效长·M	颈径 · ϕ d1	颈 R ·R	柄锥角度· γ /°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory	
AHSRL 2010R0.2L20 0460	D1R0.2x20xL60xSD4	1	0.2	0.75	20	0.95	4	12	60	4	A	●	
AHSRL 2010R0.3L3 0450	D1R0.3x3xL50xSD4		3		12			50	4	A	●		
AHSRL 2010R0.3L4 0450	D1R0.3x4xL50xSD4		4		12			50	4	A	●		
AHSRL 2010R0.3L5 0450	D1R0.3x5xL50xSD4		5		12			50	4	A	●		
AHSRL 2010R0.3L6 0450	D1R0.3x6xL50xSD4		6		12			50	4	A	●		
AHSRL 2010R0.3L8 0450	D1R0.3x8xL50xSD4		8		12			50	4	A	●		
AHSRL 2010R0.3L10 0450	D1R0.3x10xL50xSD4		10		12			50	4	A	●		
AHSRL 2010R0.3L12 0450	D1R0.3x12xL50xSD4		12		12			50	4	A	●		
AHSRL 2010R0.3L16 0450	D1R0.3x16xL50xSD4		16		12			50	4	A	●		
AHSRL 2010R0.3L20 0460	D1R0.3x20xL60xSD4		20		12			60	4	A	●		
AHSRL 2015R0.1L6 0450	D1.5R0.1x6xL50xSD4	1.5	0.1	1.2	6	1.42	-	11	50	4	A	●	
AHSRL 2015R0.1L8 0450	D1.5R0.1x8xL50xSD4				8			11	50	4	A	●	
AHSRL 2015R0.1L10 0450	D1.5R0.1x10xL50xSD4				10			11	50	4	A	●	
AHSRL 2015R0.1L12 0450	D1.5R0.1x12xL50xSD4				12			11	50	4	A	●	
AHSRL 2015R0.2L6 0450	D1.5R0.2x6xL50xSD4		0.2		6			11	50	4	A	●	
AHSRL 2015R0.2L8 0450	D1.5R0.2x8xL50xSD4				8			11	50	4	A	●	
AHSRL 2015R0.2L10 0450	D1.5R0.2x10xL50xSD4				10			11	50	4	A	●	
AHSRL 2015R0.2L12 0450	D1.5R0.2x12xL50xSD4				12			11	50	4	A	●	
AHSRL 2020R0.1L8 0450	D2R0.1x8xL50xSD4	2	0.1	1.6	8	1.9	-	11	50	4	A	●	
AHSRL 2020R0.1L10 0450	D2R0.1x10xL50xSD4				10			11	50	4	A	●	
AHSRL 2020R0.1L12 0450	D2R0.1x12xL50xSD4				12			11	50	4	A	●	
AHSRL 2020R0.1L16 0450	D2R0.1x16xL50xSD4				16			11	50	4	A	●	
AHSRL 2020R0.2L8 0450	D2R0.2x8xL50xSD4		0.2		8			11	50	4	A	●	
AHSRL 2020R0.2L10 0450	D2R0.2x10xL50xSD4				10			11	50	4	A	●	
AHSRL 2020R0.2L12 0450	D2R0.2x12xL50xSD4				12			11	50	4	A	●	
AHSRL 2020R0.2L16 0450	D2R0.2x16xL50xSD4				16			11	50	4	A	●	
AHSRL 2020R0.5L8 0450	D2R0.5x8xL50xSD4		0.5		8			11	50	4	A	●	
AHSRL 2020R0.5L10 0450	D2R0.5x10xL50xSD4				10			11	50	4	A	●	
AHSRL 2020R0.5L12 0450	D2R0.5x12xL50xSD4				12			11	50	4	A	●	
AHSRL 2020R0.5L16 0450	D2R0.5x16xL50xSD4				16			11	50	4	A	●	
AHSRL 2030R0.1L10 0450	D3R0.1x10xL50xSD4	3	0.1	2.4	10	2.9	-	11	50	4	A	●	
AHSRL 2030R0.1L10 0660	D3R0.1x10xL60xSD6				10			11	60	6	A	●	
AHSRL 2030R0.1L12 0450	D3R0.1x12xL50xSD4				12			11	50	4	A	●	
AHSRL 2030R0.1L12 0660	D3R0.1x12xL60xSD6				12			11	60	6	A	●	
AHSRL 2030R0.1L16 0450	D3R0.1x16xL50xSD4				16			11	50	4	A	●	
AHSRL 2030R0.1L16 0660	D3R0.1x16xL60xSD6				16			11	60	6	A	●	
AHSRL 2030R0.1L20 0660	D3R0.1x20xL60xSD6				20			11	60	6	A	●	
AHSRL 2030R0.1L25 0675	D3R0.1x25xL75xSD6				25			11	75	6	A	●	
AHSRL 2030R0.2L10 0450	D3R0.2x10xL50xSD4		0.2		10			11	50	4	A	●	
AHSRL 2030R0.2L10 0660	D3R0.2x10xL60xSD6				10			11	60	6	A	●	
AHSRL 2030R0.2L12 0450	D3R0.2x12xL50xSD4				12			11	50	4	A	●	
AHSRL 2030R0.2L12 0660	D3R0.2x12xL60xSD6				12			11	60	6	A	●	
AHSRL 2030R0.2L16 0450	D3R0.2x16xL50xSD4				16			11	50	4	A	●	
AHSRL 2030R0.2L16 0660	D3R0.2x16xL60xSD6				16			11	60	6	A	●	
AHSRL 2030R0.2L20 0660	D3R0.2x20xL60xSD6				20			11	60	6	A	●	
AHSRL 2030R0.2L25 0675	D3R0.2x25xL75xSD6				25			11	75	6	A	●	
AHSRL 2030R0.5L10 0450	D3R0.5x10xL50xSD4		0.5		10			11	50	4	A	●	
AHSRL 2030R0.5L10 0660	D3R0.5x10xL60xSD6				10			11	60	6	A	●	
AHSRL 2030R0.5L12 0450	D3R0.5x12xL50xSD4				12			11	50	4	A	●	
AHSRL 2030R0.5L12 0660	D3R0.5x12xL60xSD6				12			11	60	6	A	●	
AHSRL 2030R0.5L16 0450	D3R0.5x16xL50xSD4				16			11	50	4	A	●	
AHSRL 2030R0.5L16 0660	D3R0.5x16xL60xSD6				16			11	60	6	A	●	
AHSRL 2030R0.5L20 0660	D3R0.5x20xL60xSD6				20			11	60	6	A	●	
AHSRL 2030R0.5L25 0675	D3R0.5x25xL75xSD6				25			11	75	6	A	●	
AHSRL 2040R0.1L12 0660	D4R0.1x12xL60xSD6	4	0.1	3.2	12	3.9	-	11	60	6	A	●	
AHSRL 2040R0.1L16 0660	D4R0.1x16xL60xSD6				16			11	60	6	A	●	
AHSRL 2040R0.1L20 0660	D4R0.1x20xL60xSD6				20			11	60	6	A	●	
AHSRL 2040R0.1L25 0675	D4R0.1x25xL75xSD6				25			11	75	6	A	●	
AHSRL 2040R0.1L30 0675	D4R0.1x30xL75xSD6				30			11	75	6	A	●	
AHSRL 2040R0.2L12 0660	D4R0.2x12xL60xSD6		0.2		12			11	60	6	A	●	

A

B

C

D

E

F

G

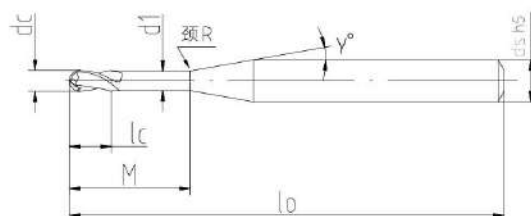
H

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长·M	颈径 · $\varnothing$ d1	颈 R ·R	柄锥角度· $\gamma/^\circ$	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory
AHSRL 2040R0.2L16 0660	D4R0.2x16xL60xSD6	4	0.2	3.2	16	3.9	-	11	60	6	A	●
AHSRL 2040R0.2L20 0660	D4R0.2x20xL60xSD6				20			11	60	6	A	●
AHSRL 2040R0.2L25 0675	D4R0.2x25xL75xSD6				25			11	75	6	A	●
AHSRL 2040R0.2L30 0675	D4R0.2x30xL75xSD6				30			11	75	6	A	●
AHSRL 2040R0.5L12 0660	D4R0.5x12xL60xSD6		0.5		12			11	60	6	A	●
AHSRL 2040R0.5L16 0660	D4R0.5x16xL60xSD6				16			11	60	6	A	●
AHSRL 2040R0.5L20 0660	D4R0.5x20xL60xSD6				20			11	60	6	A	●
AHSRL 2040R0.5L25 0675	D4R0.5x25xL75xSD6				25			11	75	6	A	●
AHSRL 2040R0.5L30 0675	D4R0.5x30xL75xSD6				30			11	75	6	A	●
AHSRL 2040R1.0L12 0660	D4R1x12xL60xSD6		1.0		12			11	60	6	A	●
AHSRL 2040R1.0L16 0660	D4R1x16xL60xSD6				16			11	60	6	A	●
AHSRL 2040R1.0L20 0660	D4R1x20xL60xSD6				20			11	60	6	A	●
AHSRL 2040R1.0L25 0675	D4R1x25xL75xSD6				25			11	75	6	A	●
AHSRL 2040R1.0L30 0675	D4R1x30xL75xSD6				30			11	75	6	A	●

AHSBL 2 刃长颈球头铣刀

AHSB 2-flute Ballnose End Mills



图A

- 专为加工高硬度材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 适用于干式切削或微润滑高速切削;
- 卓越的工作表面粗糙度;
- 高精度球头为精加工铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining high hardness materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision ball-end is designed for finishing milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ ·dc	ϕ ·dc Tolerance	刃径 ϕ ·dc	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 5$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
	○	○	⊗	○	○	○

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长 ·M	颈径 · ϕ d1	颈 R ·R	柄锥角度· γ °	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory
AHSBL 2001L0.2 0450	D0.1R0.05x0.2xL50xSD4	0.1	0.05	0.07	0.2	0.085	-	12	50	4	A	●
AHSBL 2001L0.3 0450	D0.1R0.05x0.3xL50xSD4				0.3			12	50	4	A	●
AHSBL 2001L0.5 0450	D0.1R0.05x0.5xL50xSD4				0.5			12	50	4	A	●
AHSBL 2001L0.75 0450	D0.1R0.05x0.75xL50xSD4				0.75			12	50	4	A	●
AHSBL 2001L1 0450	D0.1R0.05x1xL50xSD4				1			12	50	4	A	●
AHSBL 20015L0.3 0450	D0.15R0.075x0.3xL50xSD4	0.15	0.075	0.1	0.3	0.13	-	12	50	4	A	●
AHSBL 20015L0.5 0450	D0.15R0.075x0.5xL50xSD4				0.5			12	50	4	A	●
AHSBL 20015L0.75 0450	D0.15R0.075x0.75xL50xSD4				0.75			12	50	4	A	●
AHSBL 20015L1 0450	D0.15R0.075x1xL50xSD4				1			12	50	4	A	●
AHSBL 20015L1.5 0450	D0.15R0.075x1.5xL50xSD4				1.5			12	50	4	A	●
AHSBL 2002L0.3 0450	D0.2R0.1x0.3xL50xSD4	0.2	0.1	0.15	0.3	0.18	-	12	50	4	A	●
AHSBL 2002L0.5 0450	D0.2R0.1x0.5xL50xSD4				0.5			12	50	4	A	●
AHSBL 2002L0.75 0450	D0.2R0.1x0.75xL50xSD4				0.75			12	50	4	A	●
AHSBL 2002L1 0450	D0.2R0.1x1xL50xSD4				1			12	50	4	A	●
AHSBL 2002L1.25 0450	D0.2R0.1x1.25xL50xSD4				1.25			12	50	4	A	●
AHSBL 2002L1.5 0450	D0.2R0.1x1.5xL50xSD4				1.5			12	50	4	A	●
AHSBL 2002L1.75 0450	D0.2R0.1x1.75xL50xSD4				1.75			12	50	4	A	●
AHSBL 2002L2 0450	D0.2R0.1x2xL50xSD4				2			12	50	4	A	●
AHSBL 2002L2.5 0450	D0.2R0.1x2.5xL50xSD4				2.5			12	50	4	A	●
AHSBL 2002L3 0450	D0.2R0.1x3xL50xSD4				3			12	50	4	A	●
AHSBL 2003L0.5 0450	D0.3R0.15x0.5xL50xSD4	0.3	0.15	0.2	0.5	0.28	-	12	50	4	A	●
AHSBL 2003L0.6 0450	D0.3R0.15x0.6xL50xSD4				0.6			12	50	4	A	●
AHSBL 2003L0.75 0450	D0.3R0.15x0.75xL50xSD4				0.75			12	50	4	A	●
AHSBL 2003L1 0450	D0.3R0.15x1xL50xSD4				1			12	50	4	A	●

A

B

C

D

E

F

G

H

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长 ·M	颈径 · ϕ d1	颈 R ·R	柄锥角度· γ /°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory
AHSBL 2003L1.25 0450	D0.3R0.15x1.25xL50xSD4	0.3	0.15	0.2	1.25	0.28	-	12	50	4	A	●
AHSBL 2003L1.5 0450	D0.3R0.15x1.5xL50xSD4				1.5			12	50	4	A	●
AHSBL 2003L1.75 0450	D0.3R0.15x1.75xL50xSD4				1.75			12	50	4	A	●
AHSBL 2003L2 0450	D0.3R0.15x2xL50xSD4				2			12	50	4	A	●
AHSBL 2003L2.25 0450	D0.3R0.15x2.25xL50xSD4				2.25			12	50	4	A	●
AHSBL 2003L2.5 0450	D0.3R0.15x2.5xL50xSD4				2.5			12	50	4	A	●
AHSBL 2003L3 0450	D0.3R0.15x3xL50xSD4				3			12	50	4	A	●
AHSBL 2003L3.5 0450	D0.3R0.15x3.5xL50xSD4				3.5			12	50	4	A	●
AHSBL 2003L4 0450	D0.3R0.15x4xL50xSD4				4			12	50	4	A	●
AHSBL 2004L0.5 0450	D0.4R0.2x0.5xL50xSD4	0.4	0.2	0.3	0.5	0.37	-	12	50	4	A	●
AHSBL 2004L0.8 0450	D0.4R0.2x0.8xL50xSD4				0.8			12	50	4	A	●
AHSBL 2004L1 0450	D0.4R0.2x1xL50xSD4				1			12	50	4	A	●
AHSBL 2004L1.5 0450	D0.4R0.2x1.5xL50xSD4				1.5			12	50	4	A	●
AHSBL 2004L2 0450	D0.4R0.2x2xL50xSD4				2			12	50	4	A	●
AHSBL 2004L2.5 0450	D0.4R0.2x2.5xL50xSD4				2.5			12	50	4	A	●
AHSBL 2004L3 0450	D0.4R0.2x3xL50xSD4				3			12	50	4	A	●
AHSBL 2004L3.5 0450	D0.4R0.2x3.5xL50xSD4				3.5			12	50	4	A	●
AHSBL 2004L4 0450	D0.4R0.2x4xL50xSD4				4			12	50	4	A	●
AHSBL 2004L4.5 0450	D0.4R0.2x4.5xL50xSD4				4.5			12	50	4	A	●
AHSBL 2004L5 0450	D0.4R0.2x5xL50xSD4				5			12	50	4	A	●
AHSBL 2004L6 0450	D0.4R0.2x6xL50xSD4				6			12	50	4	A	●
AHSBL 2004L8 0450	D0.4R0.2x8xL50xSD4				8			12	50	4	A	●
AHSBL 2005L1 0450	D0.5R0.25x1xL50xSD4	0.5	0.25	0.35	1	0.46	-	12	50	4	A	●
AHSBL 2005L1.5 0450	D0.5R0.25x1.5xL50xSD4				1.5			12	50	4	A	●
AHSBL 2005L2 0450	D0.5R0.25x2xL50xSD4				2			12	50	4	A	●
AHSBL 2005L2.5 0450	D0.5R0.25x2.5xL50xSD4				2.5			12	50	4	A	●
AHSBL 2005L3 0450	D0.5R0.25x3xL50xSD4				3			12	50	4	A	●
AHSBL 2005L3.5 0450	D0.5R0.25x3.5xL50xSD4				3.5			12	50	4	A	●
AHSBL 2005L4 0450	D0.5R0.25x4xL50xSD4				4			12	50	4	A	●
AHSBL 2005L4.5 0450	D0.5R0.25x4.5xL50xSD4				4.5			12	50	4	A	●
AHSBL 2005L5 0450	D0.5R0.25x5xL50xSD4				5			12	50	4	A	●
AHSBL 2005L5.5 0450	D0.5R0.25x5.5xL50xSD4				5.5			12	50	4	A	●
AHSBL 2005L6 0450	D0.5R0.25x6xL50xSD4				6			12	50	4	A	●
AHSBL 2005L8 0450	D0.5R0.25x8xL50xSD4				8			12	50	4	A	●
AHSBL 2005L10 0450	D0.5R0.25x10xL50xSD4				10			12	50	4	A	●
AHSBL 2006L1 0450	D0.6R0.3x1xL50xSD4	0.6	0.3	0.45	1	0.56	-	12	50	4	A	●
AHSBL 2006L1.5 0450	D0.6R0.3x1.5xL50xSD4				1.5			12	50	4	A	●
AHSBL 2006L2 0450	D0.6R0.3x2xL50xSD4				2			12	50	4	A	●
AHSBL 2006L2.5 0450	D0.6R0.3x2.5xL50xSD4				2.5			12	50	4	A	●
AHSBL 2006L3 0450	D0.6R0.3x3xL50xSD4				3			12	50	4	A	●
AHSBL 2006L3.5 0450	D0.6R0.3x3.5xL50xSD4				3.5			12	50	4	A	●
AHSBL 2006L4 0450	D0.6R0.3x4xL50xSD4				4			12	50	4	A	●
AHSBL 2006L4.5 0450	D0.6R0.3x4.5xL50xSD4				4.5			12	50	4	A	●
AHSBL 2006L5 0450	D0.6R0.3x5xL50xSD4				5			12	50	4	A	●
AHSBL 2006L5.5 0450	D0.6R0.3x5.5xL50xSD4				5.5			12	50	4	A	●
AHSBL 2006L6 0450	D0.6R0.3x6xL50xSD4				6			12	50	4	A	●
AHSBL 2006L7 0450	D0.6R0.3x7xL50xSD4				7			12	50	4	A	●
AHSBL 2006L8 0450	D0.6R0.3x8xL50xSD4				8			12	50	4	A	●
AHSBL 2006L9 0450	D0.6R0.3x9xL50xSD4				9			12	50	4	A	●
AHSBL 2006L10 0450	D0.6R0.3x10xL50xSD4				10			12	50	4	A	●
AHSBL 2006L12 0450	D0.6R0.3x12xL50xSD4				12			12	50	4	A	●
AHSBL 2007L2 0450	D0.7R0.35x2xL50xSD4	0.7	0.35	0.5	2	0.66	-	12	50	4	A	●
AHSBL 2007L3 0450	D0.7R0.35x3xL50xSD4				3			12	50	4	A	●
AHSBL 2007L4 0450	D0.7R0.35x4xL50xSD4				4			12	50	4	A	●
AHSBL 2007L6 0450	D0.7R0.35x6xL50xSD4				6			12	50	4	A	●
AHSBL 2007L8 0450	D0.7R0.35x8xL50xSD4				8			12	50	4	A	●
AHSBL 2008L2 0450	D0.8R0.4x2xL50xSD4	0.8	0.4	0.6	2	0.76	-	12	50	4	A	●
AHSBL 2008L2.5 0450	D0.8R0.4x2.5xL50xSD4				2.5			12	50	4	A	●
AHSBL 2008L3 0450	D0.8R0.4x3xL50xSD4				3			12	50	4	A	●
AHSBL 2008L4 0450	D0.8R0.4x4xL50xSD4				4			12	50	4	A	●

订货编号·Order code												
代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长 ·M	颈径 · $\varnothing d1$	颈R·R	柄锥角度· $\gamma/^\circ$	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory
AHSBL 2008L5 0450	D0.8R0.4x5xL50xSD4	0.8	0.4	0.6	5	0.76	-	12	50	4	A	●
AHSBL 2008L6 0450	D0.8R0.4x6xL50xSD4				6			12	50	4	A	●
AHSBL 2008L7 0450	D0.8R0.4x7xL50xSD4				7			12	50	4	A	●
AHSBL 2008L8 0450	D0.8R0.4x8xL50xSD4				8			12	50	4	A	●
AHSBL 2008L10 0450	D0.8R0.4x10xL50xSD4				10			12	50	4	A	●
AHSBL 2008L12 0450	D0.8R0.4x12xL50xSD4				12			12	50	4	A	●
AHSBL 2008L16 0450	D0.8R0.4x16xL50xSD4				16			12	50	4	A	●
AHSBL 2009L2 0450	D0.9R0.45x2xL50xSD4	0.9	0.45	0.65	2	0.86	-	12	50	4	A	●
AHSBL 2009L4 0450	D0.9R0.45x4xL50xSD4				4			12	50	4	A	●
AHSBL 2009L6 0450	D0.9R0.45x6xL50xSD4				6			12	50	4	A	●
AHSBL 2009L8 0450	D0.9R0.45x8xL50xSD4				8			12	50	4	A	●
AHSBL 2010L2.5 0450	D1R0.5x2.5xL50xSD4	1	0.5	0.75	2.5	0.95	-	12	50	4	A	●
AHSBL 2010L3 0450	D1R0.5x3xL50xSD4				3			12	50	4	A	●
AHSBL 2010L4 0450	D1R0.5x4xL50xSD4				4			12	50	4	A	●
AHSBL 2010L4 0660	D1R0.5x4xL60xSD6				4			12	60	6	A	●
AHSBL 2010L5 0450	D1R0.5x5xL50xSD4				5			12	50	4	A	●
AHSBL 2010L6 0450	D1R0.5x6xL50xSD4				6			12	50	4	A	●
AHSBL 2010L6 0660	D1R0.5x6xL60xSD6				6			12	60	6	A	●
AHSBL 2010L7 0450	D1R0.5x7xL50xSD4				7			12	50	4	A	●
AHSBL 2010L8 0450	D1R0.5x8xL50xSD4				8			12	50	4	A	●
AHSBL 2010L8 0660	D1R0.5x8xL60xSD6				8			12	60	6	A	●
AHSBL 2010L9 0450	D1R0.5x9xL50xSD4				9			12	50	4	A	●
AHSBL 2010L10 0450	D1R0.5x10xL50xSD4				10			12	50	4	A	●
AHSBL 2010L10 0660	D1R0.5x10xL60xSD6				10			12	60	6	A	●
AHSBL 2010L12 0450	D1R0.5x12xL50xSD4				12			12	50	4	A	●
AHSBL 2010L14 0450	D1R0.5x14xL50xSD4				14			12	50	4	A	●
AHSBL 2010L16 0450	D1R0.5x16xL50xSD4				16			12	50	4	A	●
AHSBL 2010L18 0460	D1R0.5x18xL60xSD4				18			12	60	4	A	●
AHSBL 2010L20 0460	D1R0.5x20xL60xSD4				20			12	60	4	A	●
AHSBL 2010L22 0460	D1R0.5x22xL60xSD4				22			12	60	4	A	●
AHSBL 2015L6 0450	D1.5R0.75x6xL50xSD4	1.5	0.75	1.2	6	1.42	-	11	50	4	A	●
AHSBL 2015L6 0660	D1.5R0.75x6xL60xSD6				6			11	60	6	A	●
AHSBL 2015L8 0450	D1.5R0.75x8xL50xSD4				8			11	50	4	A	●
AHSBL 2015L8 0660	D1.5R0.75x8xL60xSD6				8			11	60	6	A	●
AHSBL 2015L10 0450	D1.5R0.75x10xL50xSD4				10			11	50	4	A	●
AHSBL 2015L10 0660	D1.5R0.75x10xL60xSD6				10			11	60	6	A	●
AHSBL 2015L12 0450	D1.5R0.75x12xL50xSD4	2	1	1.6	12	1.9	-	11	50	4	A	●
AHSBL 2015L12 0660	D1.5R0.75x12xL60xSD6				12			11	60	6	A	●
AHSBL 2020L6 0450	D2R1x6xL50xSD4				6			11	50	4	A	●
AHSBL 2020L8 0450	D2R1x8xL50xSD4				8			11	50	4	A	●
AHSBL 2020L8 0660	D2R1x8xL60xSD6				8			11	60	6	A	●
AHSBL 2020L10 0450	D2R1x10xL50xSD4				10			11	50	4	A	●
AHSBL 2020L10 0660	D2R1x10xL60xSD6	3	1.5	2.4	10	2.9	-	11	60	6	A	●
AHSBL 2020L12 0450	D2R1x12xL50xSD4				12			11	50	4	A	●
AHSBL 2020L12 0660	D2R1x12xL60xSD6				12			11	60	6	A	●
AHSBL 2020L16 0450	D2R1x16xL50xSD4				16			11	50	4	A	●
AHSBL 2020L16 0660	D2R1x16xL60xSD6				16			11	60	6	A	●
AHSBL 2025L8 0450	D2.5R1.25x8xL50xSD4	2.5	1.25	2	8			11	50	4	A	●
AHSBL 2025L10 0450	D2.5R1.25x10xL50xSD4				10			11	50	4	A	●
AHSBL 2025L12 0450	D2.5R1.25x12xL50xSD4				12			11	50	4	A	●
AHSBL 2025L16 0450	D2.5R1.25x16xL50xSD4				16			11	50	4	A	●
AHSBL 2030L10 0450	D3R1.5x10xL50xSD4	4	2	3.2	10	3.9	-	11	50	4	A	●
AHSBL 2030L10 0660	D3R1.5x10xL60xSD6				10			11	60	6	A	●
AHSBL 2030L12 0450	D3R1.5x12xL50xSD4				12			11	50	4	A	●
AHSBL 2030L12 0660	D3R1.5x12xL60xSD6				12			11	60	6	A	●
AHSBL 2030L16 0450	D3R1.5x16xL50xSD4				16			11	50	4	A	●
AHSBL 2030L16 0660	D3R1.5x16xL60xSD6				16			11	60	6	A	●
AHSBL 2030L20 0660	D3R1.5x20xL60xSD6				20			11	60	6	A	●
AHSBL 2030L25 0675	D3R1.5x25xL75xSD6				25			11	75	6	A	●
AHSBL 2040L12 0660	D4R2x12xL60xSD6	4	2	3.2	12	3.9	-	11	60	6	A	●

A

B

C

D

E

F

G

H

订货编号·Order code												
代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长 ·M	颈径 · $\varnothing$ d1	颈 R ·R	柄锥角度· γ /°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory
AHSBL 2040L16 0660	D4R2x16xL60xSD6	4	2	3.2	16	3.9	-	11	60	6	A	●
AHSBL 2040L20 0660	D4R2x20xL60xSD6				20			11	60	6	A	●
AHSBL 2040L25 0675	D4R2x25xL75xSD6				25			11	75	6	A	●
AHSBL 2040L30 0675	D4R2x30xL75xSD6				30			11	75	6	A	●
AHSBL 2050L16 0660	D5R2.5x16xL60xSD6	5	2.5	4	16	4.85	-	11	60	6	A	●
AHSBL 2050L20 0660	D5R2.5x20xL60xSD6				20			11	60	6	A	●
AHSBL 2050L25 0675	D5R2.5x25xL75xSD6				25			11	75	6	A	●
AHSBL 2050L30 0675	D5R2.5x30xL75xSD6				30			11	75	6	A	●

切削参数 -AHS 系列

Cutting Parameters-AHS series

AHSEF 4 刃平头铣刀 AHSEF 4-edge flat end milling cutter

被削材 Material	淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSEF 4010	15000	250	2	0.05	12000	200	2	0.03
AHSEF 4015	12000	300	3	0.05	10000	250	3	0.03
AHSEF 4020	10000	350	4	0.05	8500	300	4	0.04
AHSEF 4025	8500	400	5	0.05	7000	350	5	0.04
AHSEF 4030	7500	450	6	0.05	5000	400	6	0.04
AHSEF 4040	5800	550	8	0.05	4000	440	8	0.04
AHSEF 4050	5000	580	10	0.1	3800	480	10	0.04
AHSEF 4060	4500	600	12	0.1	3400	500	12	0.05
AHSEF 4080	3800	600	16	0.1	2800	530	16	0.05
AHSEF 4100	3500	550	20	0.1	2500	500	20	0.05
AHSEF 4120	2800	500	24	0.1	2200	450	24	0.05
AHSEF 4140	2500	500	28	0.1	2000	400	28	0.05
AHSEF 4160	2200	450	32	0.1	1800	400	32	0.05
AHSEF 4200	2000	400	40	0.1	1500	350	40	0.05

AHSE 4 刃平头铣刀 AHSE 4-edge flat end milling cutter

被削材 Material	淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSE 4010	15000	250	2	0.05	12000	200	2	0.03
AHSE 4015	12000	300	3	0.05	10000	250	3	0.03
AHSE 4020	10000	350	4	0.05	8500	300	4	0.04
AHSE 4025	8500	400	5	0.05	7000	350	5	0.04
AHSE 4030	7500	450	6	0.05	5000	400	6	0.04
AHSE 4040	5800	550	8	0.05	4000	440	8	0.04
AHSE 4050	5000	580	10	0.1	3800	480	10	0.04
AHSE 4060	4500	600	12	0.1	3400	500	12	0.05
AHSE 4080	3800	600	16	0.1	2800	530	16	0.05
AHSE 4100	3500	550	20	0.1	2500	500	20	0.05
AHSE 4120	2800	500	24	0.1	2200	450	24	0.05
AHSE 4140	2500	500	28	0.1	2000	400	28	0.05
AHSE 4160	2200	450	32	0.1	1800	400	32	0.05
AHSE 4200	2000	400	40	0.1	1500	350	40	0.05

AHSE 6 刃平头铣刀 AHSE 6-edge flat end milling cutter

被削材 Material	淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSE 6060	4000	870	15	0.1	3200	600	15	0.05
AHSE 6080	3500	900	18	0.1	2800	600	18	0.05
AHSE 6100	2800	850	25	0.1	2240	600	25	0.05
AHSE 6120	2500	800	30	0.1	2000	500	30	0.05
AHSE 6140	2200	750	30	0.1	2000	500	30	0.05
AHSE 6160	2200	750	35	0.1	1760	500	35	0.05
AHSE 6200	2000	700	40	0.1	1600	400	40	0.05

切削参数 -AHS 系列

Cutting Parameters-AHS series

AHSRF 4 刃圆鼻铣刀 - 侧铣 AHSRF 4-edge round nose milling cutter-Side milling

被削材 Material	淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSRF 4010R_	10000	600	0.05	0.03	9000	500	0.03	0.03
AHSRF 4015R_	9500	800	0.05	0.03	8800	600	0.03	0.03
AHSRF 4020R_	9000	1500	0.1	0.05	8500	1000	0.03	0.03
AHSRF 4030R_	8500	2000	0.1	0.05	8000	1200	0.04	0.04
AHSRF 4040R_	8000	2000	0.2	0.05	7200	1500	0.05	0.04
AHSRF 4060R_	6000	2500	0.2	0.08	4500	2000	0.1	0.05
AHSRF 4080R_	5000	3000	0.2	0.1	3600	2500	0.1	0.05
AHSRF 4100R_	4500	3000	0.2	0.1	2800	2500	0.2	0.05
AHSRF 4120R_	4000	3000	0.2	0.1	2400	2000	0.2	0.05

AHSRF 4 刃圆鼻铣刀 - 侧铣 AHSRF 4-edge round nose milling cutter-Side milling

被削材 Material	淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSR 4010R_	10000	600	0.05	0.03	9000	500	0.03	0.03
AHSR 4015R_	9500	800	0.05	0.03	8800	600	0.03	0.03
AHSR 4020R_	9000	1500	0.1	0.05	8500	1000	0.03	0.03
AHSR 4030R_	8500	2000	0.1	0.05	8000	1200	0.04	0.04
AHSR 4040R_	8000	2000	0.2	0.05	7200	1500	0.05	0.04
AHSR 4060R_	6000	2500	0.2	0.08	4500	2000	0.1	0.05
AHSR 4080R_	5000	3000	0.2	0.1	3600	2500	0.1	0.05
AHSR 4100R_	4500	3000	0.2	0.1	2800	2500	0.2	0.05
AHSR 4120R_	4000	3000	0.2	0.1	2400	2000	0.2	0.05

AHSRP 4 刃短刃圆鼻铣刀 - 侧铣 AHSRP 4-edge short edge round nose milling cutter-Side milling

被削材 Material	淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSRP 4010R_	10000	600	0.05	0.03	9000	500	0.03	0.03
AHSRP 4015R_	9500	800	0.05	0.03	8800	600	0.03	0.03
AHSRP 4020R_	9000	1500	0.1	0.05	8500	1000	0.03	0.03
AHSRP 4030R_	8500	2000	0.1	0.05	8000	1200	0.04	0.04
AHSRP 4040R_	8000	2000	0.2	0.05	7200	1500	0.05	0.04
AHSRP 4060R_	6000	2500	0.2	0.08	4500	2000	0.1	0.05
AHSRP 4080R_	5000	3000	0.2	0.1	3600	2500	0.1	0.05
AHSRP 4100R_	4500	3000	0.2	0.1	2800	2500	0.2	0.05
AHSRP 4120R_	4000	3000	0.2	0.1	2400	2000	0.2	0.05

切削参数-AHS 系列

Cutting Parameters-AHS series

AHSR 4 刃圆鼻铣刀 - 平面精铣 AHSR 4-flute End Mills with Corner Radius-Surface finishing milling

被削材 Material	淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSR 4060R_	6000	600	0.05	3.5	4500	500	0.04	3.5
AHSR 4080R_	5000	800	0.05	4.5	4200	600	0.04	4.5
AHSR 4100R_	4500	1000	0.06	6	2800	700	0.05	6
AHSR 4120R_	4000	1200	0.06	8	2400	800	0.05	8

AHSR 6 刃圆鼻铣刀 - 侧铣 AHSR 6-flute End Mills with Corner Radius -Side milling

被削材 Material	淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSR 6060R_	4000	870	15	0.1	3200	600	15	0.05
AHSR 6080R_	3500	900	18	0.1	2800	600	18	0.05
AHSR 6100R_	2800	850	25	0.1	2240	600	25	0.05
AHSR 6120R_	2500	800	30	0.1	2000	500	30	0.05

AHSR 6 刃圆鼻铣刀 - 平面精铣 AHSR 6-flute End Mills with Corner Radius -Surface finishing milling

被削材 Material	淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSR 6060R_	6000	600	0.05	3.5	4500	500	0.04	3.5
AHSR 6080R_	5000	800	0.05	4.5	4200	600	0.04	4.5
AHSR 6100R_	4500	1000	0.06	6	2800	700	0.05	6
AHSR 6120R_	4000	1200	0.06	8	2400	800	0.05	8

AHSRK 4 刃强力型圆鼻铣刀 AHSRK 4-flute High-feed End Mills with Corner Radius

被削材 Material	淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSRK 4030R_	10400	1600	0.1	1.8
AHSRK 4040R_	9600	2160	0.1	2.4
AHSRK 4050R_	8000	2200	0.1	3
AHSRK 4060R_	7000	2400	0.15	3.6
AHSRK 4080R_	6300	2400	0.15	4.8
AHSRK 40100R_	5000	2400	0.2	6
AHSRK 40120R_	4500	2000	0.2	8

切削参数 -AHS 系列

Cutting Parameters-AHS series

AHSB 2 刃球头铣刀 AHSB 2-flute Ballnose End Mills

被削材 Material		淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSB 2004		26500	540	0.03	0.03	24000	500	0.02	0.03
AHSB 2005		24000	650	0.03	0.03	21000	600	0.02	0.03
AHSB 2006		21000	720	0.03	0.03	19000	650	0.03	0.03
AHSB 2008		19000	900	0.04	0.04	17000	800	0.03	0.04
AHSB 2010		17000	1100	0.04	0.04	15000	980	0.03	0.04
AHSB 2015		15000	1350	0.05	0.05	13500	1200	0.04	0.05
AHSB 2020		14060	1404	0.04	0.06	12654	1263.6	0.04	0.06
AHSB 2025		13680	1512	0.04	0.08	12312	1360.8	0.04	0.08
AHSB 2030		12350	1800	0.04	0.08	11115	1620	0.04	0.08
AHSB 2040		11400	2160	0.05	0.1	10260	1944	0.05	0.1
AHSB 2050		9500	2250	0.05	0.1	8550	2025	0.05	0.1
AHSB 2060		8550	2520	0.05	0.12	7695	2268	0.05	0.12
AHSB 2080		7600	2700	0.05	0.15	6840	2430	0.05	0.15
AHSB 2100		6840	2700	0.08	0.2	6156	2430	0.08	0.2
AHSB 2120		6080	2700	0.08	0.25	5472	2430	0.08	0.2
AHSB 2160		5700	3240	0.1	0.25	5130	2916	0.1	0.2

AHSEL 4 刃长颈平头铣刀 AHSEL 4-flute End Mills with Neck Increased

被削材 Material		淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSEL 4008L	2	23000	1600	0.012	0.16	22000	1400	0.011	0.12
	4	23000	1280	0.01	0.16	22000	1120	0.009	0.12
	6	18000	960	0.01	0.15	17000	840	0.01	0.1
	8	14000	800	0.008	0.15	13000	700	0.007	0.1
AHSEL 4010L	4	22000	1100	0.05	0.6	19000	800	0.03	0.6
	6	18000	750	0.04	0.6	15000	600	0.02	0.6
	8	15000	600	0.03	0.6	13000	500	0.02	0.6
	10	14000	520	0.02	0.6	12000	400	0.01	0.6
AHSEL 4015L	6	16000	1100	0.07	0.9	13500	800	0.05	0.9
	8	14000	900	0.06	0.9	12000	700	0.04	0.9
	10	13000	780	0.05	0.9	11000	600	0.03	0.9
	12	12000	670	0.04	0.9	10000	500	0.03	0.9
AHSEL 4020L	8	13000	1200	0.09	1.2	11100	900	0.063	1.2
	10	13000	1100	0.08	1.2	11100	800	0.056	1.2
	12	12000	1000	0.07	1.2	10200	800	0.049	1.2
	16	10000	750	0.05	1.2	8500	600	0.035	1.2
AHSEL 4030L	10	9000	1350	0.14	1.8	7700	1000	0.098	1.8
	12	9000	1200	0.12	1.8	7700	900	0.084	1.8
	16	8000	900	0.09	1.8	6800	700	0.063	1.8
	20	7000	680	0.07	1.8	6000	500	0.049	1.8
	25	6000	570	0.06	1.8	5100	400	0.042	1.8
AHSEL 4040L	12	6000	1300	0.25	2.4	5100	1000	0.175	2.4
	16	6000	1200	0.2	2.4	5100	900	0.14	2.4
	20	6000	1100	0.15	2.4	5100	800	0.105	2.4
	25	5000	900	0.1	2.4	4300	700	0.07	2.4
	30	5000	800	0.080	2.4	4300	600	0.056	2.4

切削参数 -AHS 系列

Cutting Parameters-AHS series

AHSRL 4 刃长颈圆鼻铣刀 AHSRL 4-flute End Mills with Neck Increased & Corner Radius

被削材 Material		淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSRL 4008R_L	2	23000	1600	0.012	0.16	22000	1400	0.011	0.12
	4	23000	1280	0.01	0.16	22000	1120	0.009	0.12
	6	18000	960	0.01	0.15	17000	840	0.01	0.1
	8	14000	800	0.008	0.15	13000	700	0.007	0.1
	10	13500	640	0.006	0.12	12750	560	0.005	0.08
	12	12000	480	0.006	0.12	11500	420	0.005	0.10
HSRL 4009R_L	4	20000	1400	0.02	0.2	17500	1250	0.015	0.15
	8	14000	700	0.008	0.2	13000	650	0.007	0.15
AHSRL 4010R_L	4	21000	1920	0.04	0.25	19000	1680	0.035	0.23
	5	20000	1600	0.04	0.25	18500	1400	0.035	0.23
	6	18000	1440	0.03	0.25	16500	1260	0.025	0.23
	8	16000	1280	0.02	0.25	14500	1120	0.015	0.23
	10	14000	1120	0.01	0.25	13000	980	0.006	0.23
	12	13000	960	0.008	0.25	12000	840	0.006	0.23
	16	13000	640	0.008	0.25	12000	560	0.006	0.23
	20	11000	560	0.008	0.25	10000	490	0.006	0.23
AHSRL 4015R_L	6	18000	960	0.02	0.04	14000	840	0.02	0.04
	8	18000	800	0.02	0.04	14000	700	0.02	0.04
	10	18000	800	0.01	0.03	14000	700	0.01	0.03
	12	18000	640	0.01	0.03	14000	560	0.01	0.03
AHSRL 2020R_L	8	16000	1280	0.033	0.04	12000	1120	0.03	0.04
	10	16000	1120	0.033	0.04	12000	980	0.03	0.04
	12	16000	960	0.022	0.03	12000	840	0.02	0.03
	16	16000	800	0.017	0.03	12000	700	0.015	0.03
AHSRL 2030R_L	10	10000	1600	0.033	0.05	8500	1400	0.03	0.05
	12	9600	1280	0.033	0.05	8000	1120	0.03	0.05
	16	8000	960	0.022	0.04	7000	840	0.02	0.04
	20	8000	640	0.022	0.03	7000	560	0.02	0.03
	25	7200	480	0.017	0.025	6500	420	0.015	0.025
AHSRL 2040R_L	12	7000	1280	0.044	0.05	5000	1120	0.04	0.05
	16	6400	960	0.033	0.05	4400	840	0.03	0.05
	20	6000	640	0.022	0.04	4000	560	0.02	0.04
	25	5600	480	0.022	0.04	3600	420	0.02	0.04
	30	3800	320	0.022	0.03	2800	280	0.02	0.03

切削参数 -AHS 系列

Cutting Parameters-AHS series

AHSEL 2 刃长颈平头铣刀 AHSEL 2-flute End Mills with Neck Increased

被削材 Material		淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSEL 2001L	0.3	32000	120	0.003	0.05	28000	105	0.002	0.045
	0.5	32000	80	0.003	0.05	28000	70	0.002	0.045
	1	32000	50	0.001	0.05	28000	45	0.001	0.045
AHSEL 2002L	0.5	24000	200	0.003	0.1	21000	180	0.002	0.09
	1	24000	150	0.003	0.1	21000	135	0.002	0.09
	2	24000	50	0.002	0.1	21000	35	0.002	0.09
AHSEL 2003L	1	24000	300	0.003	0.15	21000	275	0.002	0.14
	2	24000	150	0.003	0.15	21000	135	0.002	0.14
		24000	50	0.002	0.15	21000	40	0.001	0.14
AHSEL 2004L	2	24000	330	0.02	0.15	20000	270	0.02	0.13
	3	21500	300	0.01	0.15	20000	240	0.01	0.13
AHSEL 2005L	2	24000	330	0.03	0.2	22500	270	0.03	0.16
	3	21500	300	0.02	0.2	20000	240	0.02	0.16
	4	21500	300	0.02	0.2	20000	240	0.02	0.16
AHSEL 2006L	2	24000	480	0.03	0.22	22500	380	0.03	0.2
	3	21500	430	0.03	0.22	20000	350	0.03	0.2
	4	21500	430	0.02	0.22	20000	350	0.02	0.2
AHSEL 2008L	4	24000	700	0.05	0.3	22500	420	0.04	0.26
	6	24000	660	0.03	0.3	20000	380	0.02	0.26
AHSEL 2010L	4	20000	900	0.05	0.6	15000	700	0.06	0.45
	6	18000	860	0.03	0.6	14000	600	0.06	0.45
	8	16000	600	0.02	0.5	12000	500	0.05	0.4
	10	14000	500	0.01	0.5	10000	400	0.05	0.4
AHSEL 2015L	6	20000	800	0.04	0.75	18000	700	0.08	0.6
	8	18000	600	0.03	0.75	14000	600	0.08	0.6
	10	16000	500	0.03	0.75	14000	500	0.08	0.6
	12	14000	500	0.02	0.75	12000	430	0.06	0.6
AHSEL 2020L	8	16000	800	0.05	1	12000	600	0.04	0.8
	10	14000	700	0.05	1	12000	500	0.04	0.8
	12	12000	600	0.04	1	10000	500	0.03	0.8
	16	10000	500	0.03	0.8	9200	400	0.03	0.8
AHSEL 2025L	10	13000	850	0.065	1.25	9800	650	0.045	1
	12	12000	700	0.06	1.25	9600	600	0.04	1
	16	10000	600	0.05	1	8500	500	0.04	1
	20	8200	500	0.05	1	7500	500	0.04	0.8
AHSEL 2030L	10	13000	850	0.065	1.25	9800	700	0.05	1
	12	12000	750	0.06	1.25	9600	650	0.04	1
	16	10000	650	0.05	1.25	8500	600	0.04	1
	20	8200	580	0.05	1.25	7500	550	0.04	1
	25	7500	530	0.04	1.25	7200	500	0.03	0.8
AHSEL 2040L	12	13000	850	0.065	1.5	9800	700	0.05	1.5
	16	12000	750	0.06	1.5	9600	650	0.04	1
	20	10000	650	0.05	1.5	8500	600	0.04	1
	25	8200	580	0.05	1.25	7500	550	0.04	1
	30	7500	530	0.04	1	7200	500	0.03	0.8

切削参数 -AHS 系列

Cutting Parameters-AHS series

AHSRL 2 刃长颈圆鼻铣刀 AHSRL 2-flute End Mills with Neck Increased & Corner Radius

被削材 Material		淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSRL 2002R_L	0.5	24000	300	0.003	0.1	21000	250	0.002	0.09
	1	24000	200	0.003	0.1	21000	150	0.002	0.09
	1.5	24000	150	0.002	0.1	21000	125	0.002	0.09
	2	24000	100	0.002	0.1	21000	75	0.002	0.09
AHSRL 2003R_L	1	24000	350	0.003	0.15	21000	325	0.001	0.14
	1.5	24000	250	0.003	0.15	21000	225	0.001	0.14
	2	24000	200	0.003	0.15	21000	175	0.002	0.14
	2.5	24000	150	0.002	0.15	21000	125	0.001	0.14
	3	24000	80	0.002	0.15	21000	70	0.001	0.14
AHSRL 2004R_L	1	24000	400	0.005	0.2	21000	350	0.003	0.18
	1.5	24000	360	0.005	0.2	21000	315	0.003	0.18
	2	24000	328	0.005	0.2	21000	287	0.003	0.18
	2.5	24000	304	0.005	0.2	21000	266	0.003	0.18
	3	24000	288	0.004	0.2	21000	252	0.002	0.18
AHSRL 2005R_L	4	24000	240	0.003	0.2	21000	210	0.002	0.18
	1	23000	480	0.007	0.1	22000	420	0.006	0.08
	1.5	23000	440	0.007	0.1	22000	385	0.006	0.08
	2	23000	384	0.007	0.1	22000	336	0.006	0.08
	2.5	23000	360	0.007	0.1	22000	315	0.006	0.08
	3	23000	320	0.005	0.1	22000	280	0.006	0.08
	4	23000	280	0.003	0.1	22000	245	0.002	0.08
AHSRL 2006R_L	5	18000	200	0.003	0.1	17000	175	0.003	0.08
	6	18000	160	0.002	0.1	17000	140	0.002	0.08
	2	23000	480	0.01	0.15	22000	420	0.005	0.13
	3	21000	400	0.008	0.15	19500	350	0.002	0.13
	4	20000	320	0.007	0.15	18500	280	0.003	0.13
	6	18000	180	0.005	0.15	17000	160	0.003	0.13
	8	14000	140	0.002	0.15	13000	120	0.001	0.13
AHSRL 2007R_L	10	12000	100	0.001	0.15	11000	90	0.001	0.13
	2	23000	560	0.02	0.15	22000	490	0.02	0.1
	3	23000	520	0.015	0.15	22000	455	0.015	0.1
	4	23000	480	0.01	0.15	22000	420	0.01	0.1
	6	18000	320	0.01	0.15	17000	280	0.01	0.1
	8	14000	240	0.008	0.15	13000	210	0.008	0.1
AHSRL 2008R_L	10	12000	160	0.006	0.15	11000	140	0.006	0.1
	2	23000	800	0.012	0.16	22000	700	0.011	0.12
	3	23000	720	0.012	0.16	22000	630	0.011	0.12
	4	23000	640	0.01	0.16	22000	560	0.009	0.12
	6	18000	480	0.01	0.15	17000	420	0.01	0.1
	8	14000	400	0.008	0.15	13000	350	0.007	0.1
	10	13500	320	0.006	0.12	12750	280	0.005	0.08
	12	12000	240	0.006	0.12	11500	210	0.005	0.10

切削参数 -AHS 系列

Cutting Parameters-AHS series

AHSRL 2 刃长颈圆鼻铣刀 AHSRL 2-flute End Mills with Neck Increased & Corner Radius

被削材 Material		淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSRL 2009R_L	4	20000	800	0.02	0.2	17500	750	0.015	0.15
	8	14000	400	0.008	0.2	13000	350	0.007	0.15
AHSRL 2010R_L	3	22000	1080	0.025	0.3	20500	945	0.022	0.3
	4	21000	960	0.04	0.25	19000	840	0.035	0.22
	5	20000	800	0.04	0.25	18500	700	0.035	0.22
	6	18000	720	0.03	0.25	16500	630	0.025	0.22
	8	16000	640	0.02	0.25	14500	560	0.015	0.22
	10	14000	560	0.01	0.25	13000	490	0.005	0.22
	12	13000	480	0.008	0.25	12000	420	0.005	0.22
	16	13000	320	0.008	0.25	12000	280	0.005	0.22
	20	11000	280	0.008	0.25	10000	245	0.007	0.22
	6	18000	480	0.02	0.04	14000	420	0.02	0.04
AHSRL 2015R_L	8	18000	400	0.02	0.04	14000	350	0.02	0.04
	10	18000	400	0.02	0.03	14000	350	0.02	0.03
	12	18000	320	0.02	0.03	14000	280	0.02	0.03
AHSRL 2020R_L	8	16000	640	0.033	0.04	12000	560	0.03	0.04
	10	16000	560	0.033	0.04	12000	490	0.03	0.04
	12	16000	480	0.022	0.03	12000	420	0.02	0.03
	16	16000	400	0.017	0.03	12000	350	0.015	0.03
AHSRL 2030R_L	10	9600	800	0.033	0.05	8000	700	0.03	0.05
	12	8000	640	0.033	0.05	7000	560	0.03	0.05
	16	8000	480	0.022	0.04	7000	420	0.02	0.04
	20	8000	320	0.022	0.03	7000	280	0.02	0.03
	25	7200	240	0.017	0.025	6500	210	0.015	0.025
AHSRL 2040R_L	12	7000	640	0.044	0.05	5000	560	0.04	0.05
	16	6400	480	0.033	0.05	4400	420	0.03	0.05
	20	6000	320	0.022	0.04	4000	280	0.02	0.04
	25	5600	240	0.022	0.04	3600	210	0.02	0.04
	30	3800	160	0.022	0.03	2800	140	0.02	0.03

切削参数 -AHS 系列

Cutting Parameters-AHS series

AHSBL 2 刃长颈球头铣刀 AHSBL 2-flute Ballnose End Mills with Neck Increased

被削材 Material		淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSBL 2001L	0.2	40000	70	0.002	0.003	40000	55	0.002	0.003
	0.3	40000	50	0.002	0.003	40000	40	0.002	0.003
	0.5	40000	30	0.001	0.002	40000	20	0.001	0.002
	0.75	40000	30	0.001	0.002	40000	20	0.001	0.002
	1	40000	30	0.001	0.002	40000	30	0.001	0.002
AHSBL 20015L	0.3	40000	100	0.002	0.003	40000	75	0.002	0.003
	0.5	40000	70	0.002	0.003	40000	45	0.002	0.003
	0.75	40000	30	0.001	0.002	40000	20	0.001	0.002
	1	40000	30	0.001	0.002	40000	20	0.001	0.002
	1.5	40000	30	0.001	0.002	40000	30	0.001	0.002
AHSBL 2002L	0.3	36000	200	0.003	0.003	34000	150	0.002	0.003
	0.5	36000	180	0.003	0.003	34200	130	0.002	0.003
	0.75	36000	150	0.002	0.003	34200	125	0.002	0.003
	1	36000	120	0.001	0.002	34200	100	0.001	0.002
	1.25	36000	100	0.001	0.002	34200	80	0.001	0.002
	1.5	36000	80	0.001	0.002	34200	60	0.001	0.002
	1.75	36000	60	0.001	0.002	34200	40	0.001	0.002
	2	36000	50	0.001	0.001	34200	35	0.001	0.001
	2.5	36000	40	0.001	0.001	34200	30	0.001	0.001
AHSBL 2003L	3	36000	30	0.001	0.001	34200	25	0.001	0.001
	0.5	30000	280	0.003	0.005	28500	270	0.001	0.005
	0.6	30000	250	0.003	0.005	28500	225	0.002	0.005
	0.75	30000	230	0.003	0.005	28500	205	0.002	0.005
	1	30000	200	0.003	0.005	28500	175	0.002	0.005
	1.25	30000	160	0.002	0.003	28500	140	0.002	0.003
	1.5	30000	120	0.002	0.003	28500	90	0.002	0.003
	1.75	30000	100	0.002	0.002	28500	75	0.002	0.002
	2	30000	90	0.002	0.002	28500	75	0.002	0.002
	2.25	30000	80	0.001	0.001	28500	70	0.001	0.001
	2.5	30000	70	0.001	0.001	28500	65	0.001	0.001
AHSBL 2004L	3	30000	60	0.001	0.001	28500	55	0.001	0.001
	3.5	30000	50	0.001	0.001	28500	45	0.001	0.001
	4	30000	40	0.001	0.001	28500	35	0.001	0.001
	0.5	30000	580	0.009	0.02	28500	510	0.005	0.02
	0.8	30000	580	0.008	0.02	28500	510	0.005	0.02
	1	30000	580	0.008	0.02	28500	510	0.005	0.02
	1.5	30000	400	0.005	0.01	28500	350	0.003	0.01
	2	30000	300	0.005	0.007	28500	260	0.003	0.007
	2.5	30000	260	0.003	0.005	28500	240	0.002	0.005
	3	30000	200	0.003	0.005	28500	180	0.002	0.005
	3.5	30000	120	0.002	0.003	28500	100	0.002	0.003
	4	30000	90	0.002	0.003	30000	75	0.002	0.003
	4.5	30000	60	0.001	0.002	30000	50	0.001	0.002
	5	30000	40	0.001	0.002	30000	35	0.001	0.002
	6	30000	30	0.001	0.001	30000	25	0.001	0.001
	8	30000	30	0.001	0.001	30000	25	0.001	0.001

切削参数 -AHS 系列

Cutting Parameters-AHS series

AHSBL 2 刃长颈球头铣刀 AHSBL 2-flute Ballnose End Mills with Neck Increased

被削材 Material		淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSBL 2005L	1	30000	500	0.01	0.025	27600	455	0.01	0.025
	1.5	30000	500	0.009	0.02	27600	455	0.009	0.02
	2	30000	400	0.008	0.02	27600	365	0.008	0.02
	2.5	28000	400	0.007	0.015	25760	365	0.007	0.015
	3	28000	360	0.007	0.01	25760	330	0.007	0.01
	3.5	25000	360	0.006	0.01	23000	330	0.006	0.01
	4	25000	300	0.005	0.008	23000	275	0.005	0.008
	4.5	25000	260	0.004	0.008	23000	240	0.004	0.008
	5	25000	260	0.004	0.008	23000	240	0.004	0.008
	5.5	25000	240	0.004	0.006	23000	220	0.004	0.006
AHSBL 2006L	6	22000	120	0.003	0.005	20240	110	0.003	0.005
	8	20000	80	0.003	0.003	18400	75	0.003	0.003
	10	20000	50	0.003	0.003	18400	45	0.003	0.003
	1	28800	600	0.02	0.03	27540	550	0.02	0.03
	1.5	28800	600	0.02	0.03	27540	550	0.02	0.03
	2	28800	480	0.02	0.03	27540	440	0.02	0.03
	2.5	26880	480	0.015	0.02	25704	440	0.015	0.02
	3	26880	432	0.015	0.02	25704	398	0.015	0.02
	3.5	24000	432	0.01	0.02	22950	398	0.01	0.02
	4	24000	360	0.01	0.02	22950	330	0.01	0.02
	4.5	24000	312	0.01	0.02	22950	288	0.01	0.02
	5	24000	312	0.01	0.02	22950	288	0.01	0.02
AHSBL 2007L	5.5	24000	288	0.008	0.01	22950	264	0.008	0.01
	6	21120	144	0.008	0.01	20196	132	0.008	0.01
	7	19200	96	0.006	0.008	18360	90	0.006	0.008
	8	19200	60	0.005	0.008	18360	55	0.005	0.008
	9	18048	50	0.005	0.008	17978	42.5	0.005	0.008
AHSBL 2008L	10	18000	40	0.003	0.005	17906	30	0.003	0.005
	12	18000	30	0.003	0.005	17906	20	0.003	0.005
	2	36000	1000	0.02	0.035	33400	850	0.02	0.035
	3	30000	800	0.02	0.03	25000	720	0.02	0.03
	4	30000	600	0.015	0.02	25000	490	0.015	0.02
AHSBL 2009L	6	25000	420	0.006	0.01	22500	380	0.006	0.01
	8	20000	250	0.004	0.006	20000	185	0.004	0.006
	2	20000	1200	0.03	0.05	19000	1000	0.03	0.05
	2.5	20000	1200	0.03	0.05	19000	1000	0.03	0.05
	3	20000	1200	0.03	0.05	19000	1000	0.03	0.05
	4	20000	860	0.03	0.05	19000	690	0.03	0.05
	5	20000	620	0.02	0.03	19000	430	0.02	0.03
	6	18000	560	0.02	0.03	17100	460	0.02	0.03
	7	18000	520	0.02	0.03	17100	440	0.02	0.03
	8	18000	480	0.01	0.02	17100	420	0.01	0.02
AHSBL 2009L	10	16000	320	0.008	0.015	15200	290	0.008	0.015
	12	15000	200	0.006	0.012	14250	170	0.006	0.012
	16	15000	200	0.005	0.01	14250	170	0.005	0.01
	2	20000	1200	0.03	0.05	19000	1000	0.03	0.05
AHSBL 2009L	4	20000	860	0.03	0.05	19000	690	0.03	0.05
	6	18000	560	0.02	0.03	17100	460	0.02	0.03
	8	18000	480	0.01	0.02	17100	420	0.01	0.02

切削参数 -AHS 系列

Cutting Parameters-AHS series

AHSBL 2 刃长颈球头铣刀 AHSBL 2-flute Ballnose End Mills with Neck Increased

被削材 Material		淬火钢 (HRC46 ~ 55) Hardened Steel				淬火钢 (HRC56 ~ 65) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHSBL 2010L	2.5	20000	1200	0.03	0.05	19000	1000	0.03	0.05
	3	20000	1200	0.03	0.05	19000	1000	0.03	0.05
	4	20000	1200	0.03	0.05	19000	1000	0.03	0.05
	5	20000	920	0.03	0.05	19000	580	0.03	0.05
	6	18000	740	0.02	0.05	17100	510	0.015	0.05
	7	18000	680	0.02	0.03	17100	545	0.015	0.03
	8	18000	560	0.02	0.03	17100	410	0.015	0.03
	9	16000	500	0.01	0.02	15200	375	0.005	0.02
	10	15000	450	0.01	0.02	14250	365	0.005	0.02
	12	15000	400	0.005	0.01	14250	340	0.004	0.01
	14	14000	320	0.002	0.006	13300	300	0.002	0.006
	16	14000	200	0.002	0.003	13300	175	0.002	0.003
	18	14000	85	0.002	0.002	13300	67.5	0.002	0.002
	20	12000	60	0.002	0.002	11400	52.5	0.002	0.002
	22	10000	35	0.001	0.002	9500	32.5	0.001	0.002
AHSBL 2015L	6	20000	1900	0.08	0.04	14000	1700	0.05	0.03
	8	20000	1900	0.08	0.04	14000	1700	0.05	0.03
	10	18000	1500	0.06	0.04	12000	1250	0.04	0.03
	12	18000	960	0.05	0.03	12000	840	0.04	0.03
AHSBL 2020L	6	14000	3000	0.04	0.064	10000	2400	0.03	0.048
	8	11200	2500	0.04	0.064	8000	2000	0.03	0.048
	10	11200	2500	0.04	0.064	8000	2000	0.03	0.048
	12	8400	1800	0.032	0.064	6000	1440	0.024	0.048
	16	7000	1600	0.032	0.064	5000	1280	0.024	0.048
AHSBL 2025L	8	11500	3000	0.05	0.07	8500	2500	0.05	0.05
	10	11200	3000	0.048	0.064	8000	2400	0.042	0.056
	12	11200	2500	0.048	0.064	8000	2000	0.042	0.056
	16	11200	1800	0.048	0.064	8000	1440	0.042	0.056
AHSBL 2030L	10	11200	4000	0.056	0.075	8000	3200	0.042	0.06
	12	11200	3000	0.056	0.075	8000	2400	0.042	0.06
	16	11200	1800	0.056	0.075	8000	1440	0.042	0.06
	20	8400	1200	0.048	0.075	6000	960	0.036	0.06
	25	5600	800	0.05	0.075	4000	640	0.03	0.06
AHSBL 2040L	12	11200	4000	0.06	0.09	8000	3200	0.05	0.07
	16	11200	3500	0.06	0.09	8000	2800	0.05	0.07
	20	9800	3300	0.06	0.09	7000	2640	0.05	0.07
	25	8400	2600	0.05	0.09	6000	2080	0.04	0.07
	30	8400	2600	0.05	0.09	6000	2080	0.04	0.07
AHSBL 2050L	16	11200	4000	0.08	0.11	8000	3200	0.06	0.08
	20	11200	4000	0.08	0.11	8000	3200	0.06	0.08
	25	8400	3000	0.06	0.11	6000	2400	0.05	0.08
	30	7000	2400	0.06	0.11	5000	1920	0.05	0.08

AHM SERIES

AHM 系列

AHM 系列特点

AHM SERIES FEATURES

材料特点:

- 采用极细超微粒基体
- 兼具良好的韧性和硬度
- 实现高速高耐磨性加工

Material Features:

- Made of Ultra-fine grain carbide grade
- Toughness and hardness in balance
- Achieve high-speed and wear resistance machining

材料特点:

- 具有优异的抗氧化性及红硬性
- 润滑性强, 降低摩擦系数及切削阻力
- 高耐磨性, 减少粘屑, 延长刀具寿命
- 高耐热性, 高速加工下减少刃口破损

AX Coating Features:

- Excellent oxidation resistance and hardness
- Good surface, reduce friction and cutting force
- High wear resistance, reduce built-up and increase tool life
- Good heat resistance, reduce cutting edge wear under high speed machining

应用领域: :

- 适合 $HRC \leq 52$ 以下的通用切削
- 大型模具的长时间切削
- 广泛适用于加工预制钢 ($HRC \leq 52$) 例: P20、1.2738、S136、NAK80、不锈钢等

Application:

- Suitable for general cutting with $HRC \leq 52$
- Long time cutting of large mould
- Widely used in machining precast steel ($HRC \leq 52$) cases :P20, 1.2738, S136, NAK80, stainless steel, etc

模具加工利器

Great Tools for Mould Machining

HRC $\leq$ 52 (高耐磨)

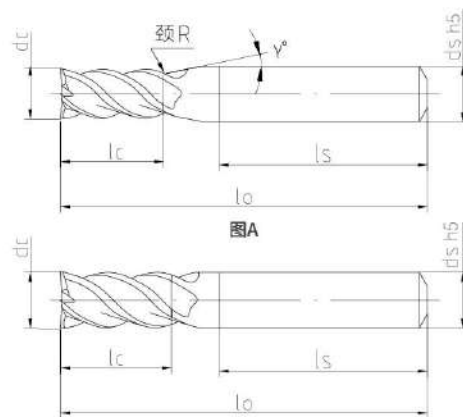


AHMEF 4 刃平头铣刀

AHMEF 4-flute End Mills



- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 为高精度铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- Designed for high precision milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



图B

刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 3$	0 ~ -0.010
$3 < \phi \leq 6$	0 ~ -0.012
$6 < \phi \leq 10$	0 ~ -0.015
$10 < \phi \leq 20$	0 ~ -0.018

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	钛合金
◎	○	◎	○		○	○

订货编号 · Order code

代码 Code	规格型号 Designation	刃径·ds	刃长·lc	颈 R·R	柄锥角度· γ°	全长·lo	柄径·ds	图示·Graph	库存 Inventory
AHMEF 4010 0450	D1x3xL50xSD4	1	3	4	12	50	4	A	●
AHMEF 4010 0650	D1x3xL50xSD6				12	50	6	A	●
AHMEF 4015 0450	D1.5x4xL50xSD4	1.5	4	-	11	50	4	A	●
AHMEF 4015 0650	D1.5x4xL50xSD6				11	50	6	A	●
AHMEF 4020 0450	D2x5xL50xSD4	2	5	-	11	50	4	A	●
AHMEF 4020 0650	D2x5xL50xSD6				11	50	6	A	●
AHMEF 4025 0450	D2.5x6.5xL50xSD4	2.5	6.5	-	11	50	4	A	●
AHMEF 4025 0650	D2.5x6.5xL50xSD6				11	50	6	A	●
AHMEF 4030 0450	D3x7.5xL50xSD4	3	7.5	-	11	50	4	A	●
AHMEF 4030 0650	D3x7.5xL50xSD6				11	50	6	A	●
AHMEF 4030 0660	D3x7.5xL60xSD6				11	60	6	A	●
AHMEF 4030 0675	D3x7.5xL75xSD6				11	75	6	A	●
AHMEF 4040 0450	D4x10xL50xSD4	4	10	-	-	50	4	B	●
AHMEF 4040 0460	D4x10xL60xSD4				-	60	4	B	●
AHMEF 4040 0475	D4x10xL75xSD4				11	75	4	A	●
AHMEF 4040 0650	D4x10xL50xSD6				11	50	6	A	●
AHMEF 4040 0660	D4x10xL60xSD6				11	60	6	A	●
AHMEF 4040 0675	D4x10xL75xSD6				11	75	6	A	●
AHMEF 4050 0650	D5x12.5xL50xSD6	5	12.5	-	11	50	6	A	●
AHMEF 4050 0675	D5x12.5xL75xSD6				11	75	6	A	●
AHMEF 4060 0650	D6x15xL50xSD6	6	15	-	-	50	6	B	●
AHMEF 4060 0660	D6x15xL60xSD6				-	60	6	B	●
AHMEF 4060 0675	D6x15xL75xSD6				-	75	6	B	●
AHMEF 4060 06100	D6x15xL100xSD6				-	100	6	B	●

A

B

C

D

E

F

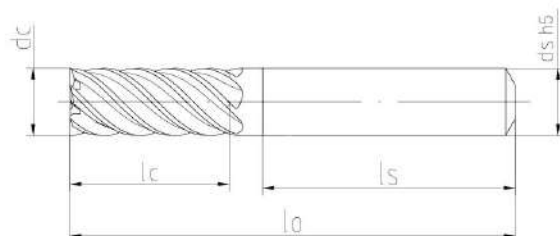
G

H

订货编号·Order code									
代码 Code	规格型号 Designation	刃径·ds	刃长·lc	颈 R·R	柄锥角度· $\gamma/^\circ$	全长·lo	柄径·ds	图示·Graph	库存 Inventory
AHMEF 4080 0860	D8x20xL60xSD8	8	20	-	-	60	8	B	●
AHMEF 4080 0875	D8x20xL75xSD8				-	75	8	B	●
AHMEF 4080 08100	D8x20xL100xSD8				-	100	8	B	●
AHMEF 4100 1075	D10x25xL75xSD10	10	25	-	-	75	10	B	●
AHMEF 4100 10100	D10x25xL100xSD10				-	100	10	B	●
AHMEF 4120 1275	D12x30xL75xSD12	12	30	-	-	75	12	B	●
AHMEF 4120 12100	D12x30xL100xSD12				-	100	12	B	●
AHMEF 4140 1475	D14x35xL75xSD14	14	35	-	-	75	14	B	●
AHMEF 4140 14100	D14x35xL100xSD14				-	100	14	B	●
AHMEF 4160 16100	D16x40xL100xSD16	16	40	-	-	100	16	B	●
AHMEF 4160 16150	D16x40xL150xSD16				-	150	16	B	●
AHMEF 4200 20100	D20x50xL100xSD20	20	50	-	-	100	20	B	●
AHMEF 4200 20150	D20x50xL150xSD20				-	150	20	B	●

AHME 6 刃平头铣刀

AHME 6-flute End Mills



图B

- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 为高精度铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- Designed for high precision milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$3 < \phi \leq 6$	0 ~ -0.012
$6 < \phi \leq 10$	0 ~ -0.015
$10 < \phi \leq 20$	0 ~ -0.018

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

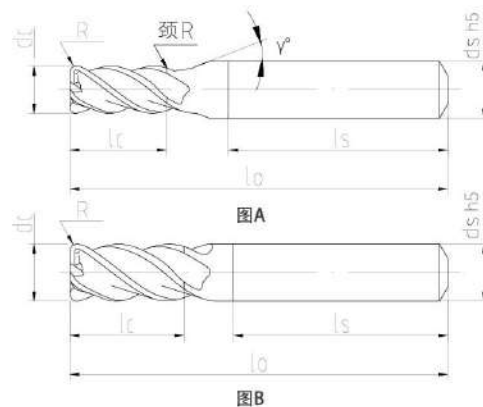
订货编号·Order code							
代码 Code	规格型号 Designation	刃径·ds	刃长·lc	全长·lo	柄径·ds	图示·Graph	库存 Inventory
AHME 6060 0650	D6x15xL50xSD6	6	15	50	6	B	●
AHME 6060 0660	D6x15xL60xSD6			60	6	B	●
AHME 6080 0860	D8x20xL60xSD8	8	20	60	8	B	●
AHME 6080 0875	D8x20xL75xSD8			75	8	B	●
AHME 6100 1075	D10x25xL75xSD10	10	25	75	10	B	●
AHME 6100 10100	D10x25xL100xSD10			100	10	B	●
AHME 6120 1275	D12x30xL75xSD12	12	30	75	12	B	●
AHME 6120 12100	D12x30xL100xSD12			100	12	B	●
AHME 6120 12150	D12x30xL150xSD12			150	12	B	●
AHME 6140 1475	D14x35xL75xSD14	14	35	75	14	B	●
AHME 6140 14100	D14x35xL100xSD14			100	14	B	●
AHME 6160 16100	D16x40xL100xSD16	16	40	100	16	B	●
AHME 6160 16150	D16x40xL150xSD16			150	16	B	●
AHME 6200 20100	D20x50xL100xSD20	20	50	100	20	B	●
AHME 6200 20150	D20x50xL150xSD20			150	20	B	●

AHMR 4 刃圆鼻铣刀

AHMR 4-flute End Mills with Corner Radius



- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 适用于粗精一体加工;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用超细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- It is suitable for coarse and fine integrated machining ;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



刃径 ϕ_{dc}	ϕ_{dc} Tolerance	刃径 ϕ_{dc}	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 12$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号·Order code													
代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长 ·M	颈径 · ϕ d1	颈 R·R	柄锥角度· γ °	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory	
AHMR 4010R0.2 0450	D1R0.2x2xL50xSD4	1	0.2	2	-	-	4	12	50	4	A	●	
AHMR 4015R0.2 0450	D1.5R0.2x3xL50xSD4	1.5	0.2	3	-	-	-	11	50	4	A	●	
AHMR 4020R0.2 0450	D2R0.2x5xL50xSD4	2	0.2	5	-	-	-	11	50	4	A	●	
AHMR 4020R0.5 0450	D2R0.5x5xL50xSD4		0.5					11	50	4	A	●	
AHMR 4030R0.2 0450	D3R0.2x7.5xL50xSD4	3	0.2	7.5	-	-	-	11	50	4	A	●	
AHMR 4030R0.2 0650	D3R0.2x7.5xL50xSD6							11	50	6	A	●	
AHMR 4030R0.2 0660	D3R0.2x7.5xL60xSD6							11	60	6	A	●	
AHMR 4030R0.2 0675	D3R0.2x7.5xL75xSD6							11	75	6	A	●	
AHMR 4030R0.5 0450	D3R0.5x7.5xL50xSD4		0.5					11	50	4	A	●	
AHMR 4030R0.5 0650	D3R0.5x7.5xL50xSD6							11	50	6	A	●	
AHMR 4030R0.5 0660	D3R0.5x7.5xL60xSD6							11	60	6	A	●	
AHMR 4030R0.5 0675	D3R0.5x7.5xL75xSD6							11	75	6	A	●	
AHMR 4040R0.2 0450	D4R0.2x10xL50xSD4	4	0.2	10	-	-	-	-	50	4	B	●	
AHMR 4040R0.2 0460	D4R0.2x10xL60xSD4							-	60	4	B	●	
AHMR 4040R0.2 0475	D4R0.2x10xL75xSD4							-	75	4	B	●	
AHMR 4040R0.2 0650	D4R0.2x10xL50xSD6							11	50	6	A	●	
AHMR 4040R0.2 0660	D4R0.2x10xL60xSD6							11	60	6	A	●	
AHMR 4040R0.2 0675	D4R0.2x10xL75xSD6							11	75	6	A	●	
AHMR 4040R0.3 0450	D4R0.3x10xL50xSD4		0.3					-	50	4	B	●	
AHMR 4040R0.3 0475	D4R0.3x10xL75xSD4							-	75	4	B	●	
AHMR 4040R0.3 0650	D4R0.3x10xL50xSD6							11	50	6	A	●	
AHMR 4040R0.3 0660	D4R0.3x10xL60xSD6							11	60	6	A	●	
AHMR 4040R0.3 0675	D4R0.3x10xL75xSD6							11	75	6	A	●	
AHMR 4040R0.5 0450	D4R0.5x10xL50xSD4							0.5	-	50	4	B	●
AHMR 4040R0.5 0460	D4R0.5x10xL60xSD4								-	60	4	B	●
AHMR 4040R0.5 0475	D4R0.5x10xL75xSD4								-	75	4	B	●

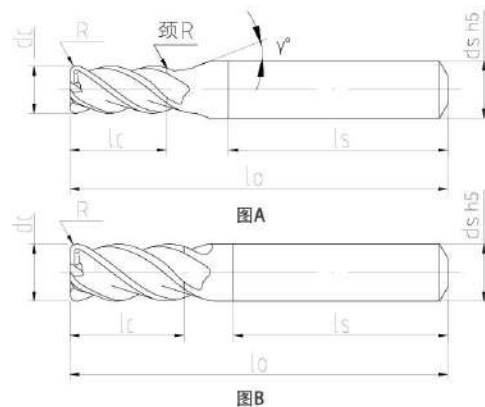
订货编号·Order code													
代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效长 ·M	颈径 · $\varnothing$ d1	颈 R·R	柄锥角度· γ °	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory	
AHMR 4040R0.5 0650	D4R0.5x10xL50xSD6	4	0.5	10	-	-	-	11	50	6	A	●	
AHMR 4040R0.5 0660	D4R0.5x10xL60xSD6							11	60	6	A	●	
AHMR 4040R0.5 0675	D4R0.5x10xL75xSD6							11	75	6	A	●	
AHMR 4040R1.0 0450	D4R1x10xL50xSD4		1					-	50	4	B	●	
AHMR 4040R1.0 0460	D4R1x10xL60xSD4							-	60	4	B	●	
AHMR 4040R1.0 0475	D4R1x10xL75xSD4							-	75	4	B	●	
AHMR 4040R1.0 0650	D4R1x10xL50xSD6							11	50	6	A	●	
AHMR 4040R1.0 0660	D4R1x10xL60xSD6							11	60	6	A	●	
AHMR 4040R1.0 0675	D4R1x10xL75xSD6							11	75	6	A	●	
AHMR 4060R0.2 0650	D6R0.2x15xL50xSD6	6	0.2	15	-	-	-	-	50	6	B	●	
AHMR 4060R0.2 0660	D6R0.2x15xL60xSD6							-	60	6	B	●	
AHMR 4060R0.2 0675	D6R0.2x15xL75xSD6							-	75	6	B	●	
AHMR 4060R0.2 06100	D6R0.2x15xL100xSD6							-	100	6	B	●	
AHMR 4060R0.5 0650	D6R0.5x15xL50xSD6		0.5					-	50	6	B	●	
AHMR 4060R0.5 0660	D6R0.5x15xL60xSD6							-	60	6	B	●	
AHMR 4060R0.5 0675	D6R0.5x15xL75xSD6							-	75	6	B	●	
AHMR 4060R0.5 06100	D6R0.5x15xL100xSD6							-	100	6	B	●	
AHMR 4060R1.0 0650	D6R1x15xL50xSD6							1	-	50	6	B	●
AHMR 4060R1.0 0660	D6R1x15xL60xSD6								-	60	6	B	●
AHMR 4060R1.0 0675	D6R1x15xL75xSD6		-						75	6	B	●	
AHMR 4060R1.0 06100	D6R1x15xL100xSD6		-						100	6	B	●	
AHMR 4080R0.2 0860	D8R0.2x20xL60xSD8	8	0.2	20	-	-	-	-	60	8	B	●	
AHMR 4080R0.2 0875	D8R0.2x20xL75xSD8							-	75	8	B	●	
AHMR 4080R0.2 08100	D8R0.2x20xL100xSD8							-	100	8	B	●	
AHMR 4080R0.5 0860	D8R0.5x20xL60xSD8		0.5					-	60	8	B	●	
AHMR 4080R0.5 0875	D8R0.5x20xL75xSD8							-	75	8	B	●	
AHMR 4080R0.5 08100	D8R0.5x20xL100xSD8							-	100	8	B	●	
AHMR 4080R0.5 08125	D8R0.5x20xL125xSD8							-	125	8	B	●	
AHMR 4080R0.5 08150	D8R0.5x20xL150xSD8							-	150	8	B	●	
AHMR 4080R1.0 0860	D8R1x20xL60xSD8		1					-	60	8	B	●	
AHMR 4080R1.0 0875	D8R1x20xL75xSD8							-	75	8	B	●	
AHMR 4080R1.0 08100	D8R1x20xL100xSD8							-	100	8	B	●	
AHMR 4100R0.2 1075	D10R0.2x25xL75xSD10	10	0.2	25	-	-	-	-	75	10	B	●	
AHMR 4100R0.2 10100	D10R0.2x25xL100xSD10							-	100	10	B	●	
AHMR 4100R0.5 1075	D10R0.5x25xL75xSD10		0.5					-	75	10	B	●	
AHMR 4100R0.5 10100	D10R0.5x25xL100xSD10							-	100	10	B	●	
AHMR 4100R0.5 10125	D10R0.5x25xL125xSD10							-	125	10	B	●	
AHMR 4100R0.5 10150	D10R0.5x25xL150xSD10							-	150	10	B	●	
AHMR 4100R1.0 1075	D10R1x25xL75xSD10		1					-	75	10	B	●	
AHMR 4100R1.0 10100	D10R1x25xL100xSD10							-	100	10	B	●	
AHMR 4100R1.0 10150	D10R1x25xL150xSD10							-	150	10	B	●	
AHMR 4120R0.5 1275	D12R0.5x30xL75xSD12	12	0.5	30	-	-	-	-	75	12	B	●	
AHMR 4120R0.5 12100	D12R0.5x30xL100xSD12							-	100	12	B	●	
AHMR 4120R0.5 12125	D12R0.5x30xL125xSD12							-	125	12	B	●	
AHMR 4120R0.5 12150	D12R0.5x30xL150xSD12							-	150	12	B	●	
AHMR 4120R1.0 1275	D12R1x30xL75xSD12		1					-	75	12	B	●	
AHMR 4120R1.0 12100	D12R1x30xL100xSD12							-	100	12	B	●	
AHMR 4120R1.0 12150	D12R1x30xL150xSD12							-	150	12	B	●	
AHMR 4120R2.0 1275	D12R2x30xL75xSD12		2					-	75	12	B	●	
AHMR 4120R2.0 12100	D12R2x30xL100xSD12							-	100	12	B	●	

AHMRF 4 刃圆鼻铣刀

AHMRF 4-flute End Mills with Corner Radius



- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 适用于半精 / 精加工;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- It is suitable for semi-finishing and finishing;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



刃径 ϕ_{dc}	ϕ_{dc} Tolerance	刃径 ϕ_{dc}	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 12$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号 · Order code												
代码 Code	规格型号 Designation	刃径 · ds	圆角半径 · R	刃长 · lc	颈 R · R	柄锥角度 γ°	全长 · lo	柄径 · ds	图示 Graph	库存 Inventory		
AHMRF 4010R0.2 0450	D1R0.2x2xL50xSD4	1	0.2	2	4	12	50	4	A	●		
AHMRF 4015R0.2 0450	D1.5R0.2x3xL50xSD4	1.5	0.2	3	-	11	50	4	A	●		
AHMRF 4020R0.2 0450	D2R0.2x4xL50xSD4	2	0.2	4	-	11	50	4	A	●		
AHMRF 4020R0.5 0450	D2R0.5x4xL50xSD4		0.5			11	50	4	A	●		
AHMRF 4030R0.2 0450	D3R0.2x6xL50xSD4	3	0.2	6	-	11	50	4	A	●		
AHMRF 4030R0.2 0650	D3R0.2x6xL50xSD6					11	50	6	A	●		
AHMRF 4030R0.2 0660	D3R0.2x6xL60xSD6					11	60	6	A	●		
AHMRF 4030R0.2 0675	D3R0.2x6xL75xSD6					11	75	6	A	●		
AHMRF 4030R0.5 0450	D3R0.5x6xL50xSD4		0.5			11	50	4	A	●		
AHMRF 4030R0.5 0650	D3R0.5x6xL50xSD6					11	50	6	A	●		
AHMRF 4030R0.5 0660	D3R0.5x6xL60xSD6					11	60	6	A	●		
AHMRF 4030R0.5 0675	D3R0.5x6xL75xSD6					11	75	6	A	●		
AHMRF 4040R0.2 0450	D4R0.2x8xL50xSD4	4	0.2	8	-	-	50	4	B	●		
AHMRF 4040R0.2 0460	D4R0.2x8xL60xSD4					-	60	4	B	●		
AHMRF 4040R0.2 0475	D4R0.2x8xL75xSD4					-	75	4	B	●		
AHMRF 4040R0.2 0650	D4R0.2x8xL50xSD6					11	50	6	A	●		
AHMRF 4040R0.2 0660	D4R0.2x8xL60xSD6					11	60	6	A	●		
AHMRF 4040R0.2 0675	D4R0.2x8xL75xSD6					11	75	6	A	●		
AHMRF 4040R0.3 0450	D4R0.3x8xL50xSD4		0.3			-	50	4	B	●		
AHMRF 4040R0.3 0475	D4R0.3x8xL75xSD4					-	75	4	B	●		
AHMRF 4040R0.3 0650	D4R0.3x8xL50xSD6					11	50	6	A	●		
AHMRF 4040R0.3 0660	D4R0.3x8xL60xSD6					11	60	6	A	●		
AHMRF 4040R0.3 0675	D4R0.3x8xL75xSD6					11	75	6	A	●		
AHMRF 4040R0.5 0450	D4R0.5x8xL50xSD4					-	50	4	B	●		

订货编号·Order code												
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	颈 R·R	柄锥角度· $\gamma/^\circ$	全长·lo	柄径·ds	图示 Graph	库存 Inventory		
AHMRF 4040R0.5 0460	D4R0.5x8xL50xSD4	4	0.5	8	-	-	60	4	B	●		
AHMRF 4040R0.5 0475	D4R0.5x8xL75xSD4					-	75	4	B	●		
AHMRF 4040R0.5 0650	D4R0.5x8xL50xSD6					11	50	4	A	●		
AHMRF 4040R0.5 0660	D4R0.5x8xL60xSD6					11	60	4	A	●		
AHMRF 4040R0.5 0675	D4R0.5x8xL75xSD6					11	75	4	A	●		
AHMRF 4040R1.0 0450	D4R1x8xL50xSD4		1.0			-	50	4	B	●		
AHMRF 4040R1.0 0460	D4R1x8xL60xSD4					-	60	4	B	●		
AHMRF 4040R1.0 0475	D4R1x8xL75xSD4					-	75	4	B	●		
AHMRF 4040R1.0 0650	D4R1x8xL50xSD6					11	50	6	A	●		
AHMRF 4040R1.0 0660	D4R1x8xL60xSD6					11	60	6	A	●		
AHMRF 4040R1.0 0675	D4R1x8xL75xSD6					11	75	6	A	●		
AHMRF 4060R0.2 0650	D6R0.2x12xL50xSD6	6	0.2	12	-	-	50	6	B	●		
AHMRF 4060R0.2 0660	D6R0.2x12xL60xSD6					-	60	6	B	●		
AHMRF 4060R0.2 0675	D6R0.2x12xL75xSD6					-	75	6	B	●		
AHMRF 4060R0.2 06100	D6R0.2x12xL100xSD6					-	100	6	B	●		
AHMRF 4060R0.5 0650	D6R0.5x12xL50xSD6		0.5			-	50	6	B	●		
AHMRF 4060R0.5 0660	D6R0.5x12xL60xSD6					-	60	6	B	●		
AHMRF 4060R0.5 0675	D6R0.5x12xL60xSD6					-	75	6	B	●		
AHMRF 4060R0.5 06100	D6R0.5x12xL100xSD6					-	100	6	B	●		
AHMRF 4060R1.0 0650	D6R1x12xL50xSD6		1.0			-	50	6	B	●		
AHMRF 4060R1.0 0660	D6R1x12xL50xSD6					-	60	6	B	●		
AHMRF 4060R1.0 0675	D6R1x12xL75xSD6					-	75	6	B	●		
AHMRF 4060R1.0 06100	D6R1x12xL100xSD6					-	100	6	B	●		
AHMRF 4080R0.2 0860A	D8R0.2x20xL60xSD8	8	0.2	20	-	-	60	8	B	●		
AHMRF 4080R0.2 0875A	D8R0.2x20xL75xSD8					-	75	8	B	●		
AHMRF 4080R0.2 08100A	D8R0.2x20xL100xSD8					-	100	8	B	●		
AHMRF 4080R0.5 0860	D8R0.5x16xL60xSD8		0.5	16		-	60	8	B	●		
AHMRF 4080R0.5 0875	D8R0.5x16xL75xSD8					-	75	8	B	●		
AHMRF 4080R0.5 08100	D8R0.5x16xL100xSD8					-	100	8	B	●		
AHMRF 4080R0.5 08125	D8R0.5x16xL125xSD8					-	125	8	B	●		
AHMRF 4080R0.5 08150	D8R0.5x16xL150xSD8					-	150	8	B	●		
AHMRF 4080R0.5 0860A	D8R0.5x20xL60xSD8			20		-	60	8	B	●		
AHMRF 4080R0.5 0875A	D8R0.5x20xL75xSD8					-	75	8	B	●		
AHMRF 4080R0.5 08100A	D8R0.5x20xL100xSD8					-	100	8	B	●		
AHMRF 4080R0.5 08125A	D8R0.5x20xL125xSD8					-	125	8	B	●		
AHMRF 4080R0.5 08150A	D8R0.5x20xL150xSD8					-	150	8	B	●		
AHMRF 4080R1.0 0860	D8R1x16xL60xSD8		1.0	16		-	60	8	B	●		
AHMRF 4080R1.0 0875	D8R1x16xL75xSD8					-	75	8	B	●		
AHMRF 4080R1.0 08100	D8R1x16xL100xSD8					-	100	8	B	●		
AHMRF 4080R1.0 0860A	D8R1x20xL60xSD8			20		-	60	8	B	●		
AHMRF 4080R1.0 0875A	D8R1x20xL75xSD8					-	75	8	B	●		
AHMRF 4080R1.0 08100A	D8R1x20xL100xSD8					-	100	8	B	●		
AHMRF 4100R0.2 1075A	D10R0.2x25xL75xSD10	10	0.2	25	-	-	75	10	B	●		
AHMRF 4100R0.2 10100A	D10R0.2x25xL100xSD10					-	100	10	B	●		
AHMRF 4100R0.5 1075	D10R0.5x20xL75xSD10		0.5	20		-	75	10	B	●		
AHMRF 4100R0.5 10100	D10R0.5x20xL100xSD10					-	100	10	B	●		
AHMRF 4100R0.5 10125	D10R0.5x20xL125xSD10					-	125	10	B	●		
AHMRF 4100R0.5 10150	D10R0.5x20xL150xSD10					-	150	10	B	●		
AHMRF 4100R0.5 1075A	D10R0.5x25xL75xSD10			25		-	75	10	B	●		
AHMRF 4100R0.5 10100A	D10R0.5x25xL100xSD10					-	100	10	B	●		
AHMRF 4100R0.5 10125A	D10R0.5x25xL125xSD10					-	125	10	B	●		
AHMRF 4100R0.5 10150A	D10R0.5x25xL150xSD10					-	150	10	B	●		
AHMRF 4100R1.0 1075	D10R1x20xL75xSD10		1.0	20		-	75	10	B	●		
AHMRF 4100R1.0 10100	D10R1x20xL100xSD10					-	100	10	B	●		
AHMRF 4100R1.0 1075A	D10R1x25xL75xSD10			25		-	75	10	B	●		
AHMRF 4100R1.0 10100A	D10R1x25xL75xSD10					-	100	10	B	●		
AHMRF 4100R1.0 10150A	D10R1x25xL150xSD10					-	150	10	B	●		
AHMRF 4100R2.0 1075	D10R2x20xL75xSD10		2.0	20		-	75	10	B	●		
AHMRF 4100R2.0 10100	D10R2x20xL100xSD10					-	100	10	B	●		
AHMRF 4120R0.5 1275	D12R0.5x24xL75xSD12	12	0.5	24	-	-	75	12	B	●		

A

B

C

D

E

F

G

H

订货编号·Order code

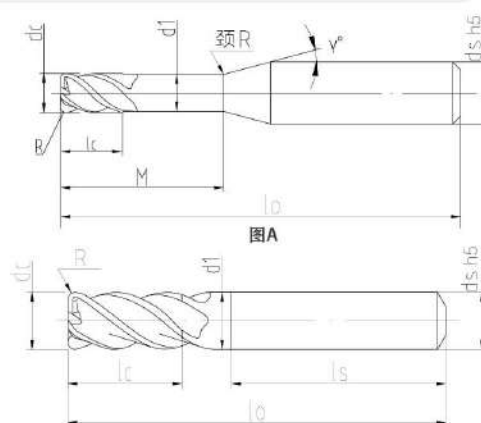
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	颈 R·R	柄锥角度·γ/°	全长·lo	柄径·ds	图示 Graph	库存 Inventory	
AHMRF 4120R0.5 12100	D12R0.5x24xL100xSD12	12	0.5	24	-	-	100	12	B	●	
AHMRF 4120R0.5 12125	D12R0.5x24xL125xSD12					-	125	12	B	●	
AHMRF 4120R0.5 12150	D12R0.5x24xL150xSD12					-	150	12	B	●	
AHMRF 4120R0.5 1275A	D12R0.5x30xL75xSD12			-		75	12	B	●		
AHMRF 4120R0.5 12100A	D12R0.5x30xL100xSD12			-		100	12	B	●		
AHMRF 4120R0.5 12125A	D12R0.5x30xL125xSD12			-		125	12	B	●		
AHMRF 4120R0.5 12150A	D12R0.5x30xL150xSD12			-		150	12	B	●		
AHMRF 4120R1.0 1275	D12R1x24xL75xSD12		1.0	24		-	75	12	B	●	
AHMRF 4120R1.0 12100	D12R1x24xL100xSD12					-	100	12	B	●	
AHMRF 4120R1.0 1275A	D12R1x30xL75xSD12					-	75	12	B	●	
AHMRF 4120R1.0 12100A	D12R1x30xL100xSD12			-		100	12	B	●		
AHMRF 4120R1.0 12150A	D12R1x30xL150xSD12			-		150	12	B	●		
AHMRF 4120R2.0 1275	D12R2x24xL75xSD12			2.0		24	-	75	12	B	●
AHMRF 4120R2.0 12100	D12R2x24xL100xSD12						-	100	12	B	●
AHMRF 4120R2.0 1275A	D12R2x30xL75xSD12		-			75	12	B	●		
AHMRF 4120R2.0 12100A	D12R2x30xL100xSD12		-			100	12	B	●		

AHMRP 4 刃短刃圆鼻铣刀

AHMRP 4-flute Short-flute End Mills with Corner Radius



- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



图B

刃径 ϕ .dc	ϕ .dc Tolerance	刃径 ϕ .dc	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 12$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号·Order code												
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径· Ø d1	颈 R·R	柄锥角度 γ /°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory
AHMRP 4010R0.2 0450	D1R0.2x1x3xL50xSD4	1	0.2	1	3	0.94	4	12	50	4	A	●
AHMRP 4015R0.2 0450	D1.5R0.2x1.5x4.5xL50xSD4	1.5	0.2	1.5	4.5	1.42	-	11	50	4	A	●
AHMRP 4020R0.2 0450	D2R0.2x2x6xL50xSD4	2	0.2	2	6	1.9	-	11	50	4	A	●
AHMRP 4020R0.5 0450	D2R0.5x2x6xL50xSD4		0.5					11	50	4	A	●
AHMRP 4030R0.2 0450	D3R0.2x3x9xL50xSD4	3	0.2	3	9	2.9	-	11	50	4	A	●
AHMRP 4030R0.2 0650	D3R0.2x3x9xL50xSD6							11	50	6	A	●
AHMRP 4030R0.2 0660	D3R0.2x3x9xL60xSD6							11	60	6	A	●
AHMRP 4030R0.2 0675	D3R0.2x3x9xL75xSD6							11	75	6	A	●
AHMRP 4030R0.5 0450	D3R0.2x3x9xL75xSD6		0.5					11	50	4	A	●
AHMRP 4030R0.5 0650	D3R0.5x3x9xL50xSD6							11	50	6	A	●
AHMRP 4030R0.5 0660	D3R0.5x3x9xL60xSD6							11	60	6	A	●
AHMRP 4030R0.5 0675	D3R0.5x3x9xL75xSD6							11	75	6	A	●
AHMRP 4040R0.2 0450	D4R0.2x4x12xL50xSD4	4	0.2	4	12	3.9	-	-	50	4	B	●
AHMRP 4040R0.2 0650	D4R0.2x4x12xL50xSD6							11	50	6	A	●
AHMRP 4040R0.2 0660	D4R0.2x4x12xL60xSD6							11	60	6	A	●
AHMRP 4040R0.2 0675	D4R0.2x4x12xL75xSD6							11	75	6	A	●
AHMRP 4040R0.3 0450	D4R0.3x4x12xL50xSD4		0.3					-	50	4	B	●
AHMRP 4040R0.3 0650	D4R0.3x4x12xL50xSD6							11	50	6	A	●
AHMRP 4040R0.3 0660	D4R0.3x4x12xL60xSD6							11	60	6	A	●
AHMRP 4040R0.3 0675	D4R0.3x4x12xL75xSD6							11	75	6	A	●
AHMRP 4040R0.5 0450	D4R0.5x4x12xL50xSD4		0.5					-	50	4	B	●
AHMRP 4040R0.5 0650	D4R0.5x4x12xL50xSD6							11	50	6	A	●
AHMRP 4040R0.5 0660	D4R0.5x4x12xL60xSD6							11	60	6	A	●
AHMRP 4040R0.5 0675	D4R0.5x4x12xL75xSD6							11	75	6	A	●

A

B

C

D

E

F

G

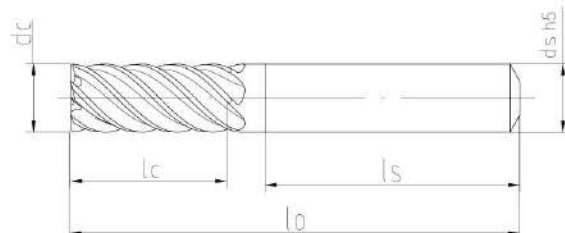
H

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径· Ø d1	颈 R·R	柄锥角度·γ/°	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHMRP 4040R1.0 0450	D4R1x4x12xL50xSD6	4	1.0	4	12	3.9	-	-	50	4	B	●
AHMRP 4040R1.0 0650	D4R1x4x12xL50xSD6							11	50	6	A	●
AHMRP 4040R1.0 0660	D4R1x4x12xL60xSD6							11	60	6	A	●
AHMRP 4040R1.0 0675	D4R1x4x12xL75xSD6							11	75	6	A	●
AHMRP 4060R0.2 0650	D6R0.2x6x18xL50xSD6	6	0.2	6	18	5.85	-	-	50	6	B	●
AHMRP 4060R0.2 0660	D6R0.2x6x18xL60xSD6							-	60	6	B	●
AHMRP 4060R0.2 0675	D6R0.2x6x18xL75xSD6							-	75	6	B	●
AHMRP 4060R0.2 06100	D6R0.2x6x18xL100xSD6							-	100	6	B	●
AHMRP 4060R0.5 0650	D6R0.5x6x18xL50xSD6		0.5					-	50	6	B	●
AHMRP 4060R0.5 0660	D6R0.5x6x18xL60xSD6							-	60	6	B	●
AHMRP 4060R0.5 0675	D6R0.5x6x18xL75xSD6							-	75	6	B	●
AHMRP 4060R0.5 06100	D6R0.5x6x18xL100xSD6							-	100	6	B	●
AHMRP 4060R1.0 0650	D6R1x6x18xL50xSD6		1.0					-	50	6	B	●
AHMRP 4060R1.0 0660	D6R1x6x18xL60xSD6							-	60	6	B	●
AHMRP 4060R1.0 0675	D6R1x6x18xL75xSD6							-	75	6	B	●
AHMRP 4060R1.0 06100	D6R1x6x18xL100xSD6							-	100	6	B	●
AHMRP 4080R0.5 0860	D8R0.5x8x24xL60xSD8	8	0.5	8	24	7.8	-	-	60	8	B	●
AHMRP 4080R0.5 0875	D8R0.5x8x24xL75xSD8							-	75	8	B	●
AHMRP 4080R0.5 08100	D8R0.5x8x24xL100xSD8							-	100	8	B	●
AHMRP 4080R0.5 08125	D8R0.5x8x24xL125xSD8							-	125	8	B	●
AHMRP 4080R0.5 08150	D8R0.5x8x24xL150xSD8		1.0					-	150	8	B	●
AHMRP 4080R1.0 0860	D8R1x8x24xL60xSD8							-	60	8	B	●
AHMRP 4080R1.0 0875	D8R1x8x24xL75xSD8							-	75	8	B	●
AHMRP 4080R1.0 08100	D8R1x8x24xL100xSD8							-	100	8	B	●
AHMRP 4100R0.5 1075	D10R0.5x10x30xL75xSD10	10	0.5	10	30	9.8	-	-	75	10	B	●
AHMRP 4100R0.5 10100	D10R0.5x10x30xL100xSD10							-	100	10	B	●
AHMRP 4100R0.5 10125	D10R0.5x10x30xL125xSD10							-	125	10	B	●
AHMRP 4100R0.5 10150	D10R0.5x10x30xL150xSD10							-	150	10	B	●
AHMRP 4100R1.0 1075	D10R1x10x30xL75xSD10		1.0					-	75	10	B	●
AHMRP 4100R1.0 10100	D10R1x10x30xL100xSD10							-	100	10	B	●
AHMRP 4100R1.0 10150	D10R1x10x30xL150xSD10							-	150	10	B	●
AHMRP 4100R2.0 1075	D10R2x10x30xL75xSD10							-	75	10	B	●
AHMRP 4100R2.0 10100	D10R2x10x30xL100xSD10	2.0	-	100	10	B	●					
AHMRP 4120R0.5 1275	D12R0.5x12x36xL75xSD12	12	0.5	12	36	11.7	-	-	75	12	B	●
AHMRP 4120R0.5 12100	D12R0.5x12x36xL100xSD12							-	100	12	B	●
AHMRP 4120R0.5 12125	D12R0.5x12x36xL125xSD12							-	125	12	B	●
AHMRP 4120R0.5 12150	D12R0.5x12x36xL150xSD12							-	150	12	B	●
AHMRP 4120R1.0 1275	D12R1x12x36xL75xSD12		1.0					-	75	12	B	●
AHMRP 4120R1.0 12100	D12R1x12x36xL100xSD12							-	100	12	B	●
AHMRP 4120R1.0 12150	D12R1x12x36xL150xSD12							-	150	12	B	●
AHMRP 4120R2.0 1275	D12R2x12x36xL75xSD12							-	75	12	B	●
AHMRP 4120R2.0 12100	D12R2x12x36xL100xSD12		2.0					-	100	12	B	●

AHMR 6 刃圆鼻铣刀

AHMR 6-flute End Mills with Corner Radius



图B

- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance	刃径 ϕ_{dc}	R Tolerance
$3 < \phi \leq 6$	0 ~ -0.012	$\phi \leq 12$	± 0.005
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号 · Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	全长·lo	柄径·ds	图示 Graph	库存 Inventory	
AHMR 6060R0.5 0650	D6R0.5x15xL50xSD6	6	0.5	15	50	6	B	●	
AHMR 6060R0.5 0660	D6R0.5x15xL60xSD6				60	6	B	●	
AHMR 6060R1.0 0650	D6R1x15xL50xSD6		1.0		50	6	B	●	
AHMR 6060R1.0 0660	D6R1x15xL60xSD6				60	6	B	●	
AHMR 6080R0.5 0860	D8R0.5x20xL60xSD8	8	0.5	20	60	8	B	●	
AHMR 6080R0.5 0875	D8R0.5x20xL75xSD8				75	8	B	●	
AHMR 6080R1.0 0860	D8R1x20xL60xSD8		1.0		60	8	B	●	
AHMR 6080R1.0 0875	D8R1x20xL75xSD8				75	8	B	●	
AHMR 6100R0.5 1075	D10R0.5x25xL75xSD10	10	0.5	25	75	10	B	●	
AHMR 6100R0.5 10100	D10R0.5x25xL100xSD10				100	10	B	●	
AHMR 6100R1.0 1075	D10R1x25xL75xSD10		1.0		75	10	B	●	
AHMR 6100R1.0 10100	D10R1x25xL100xSD10				100	10	B	●	
AHMR 6100R2.0 1075	D10R2x25xL75xSD10		2.0		75	10	B	●	
AHMR 6100R2.0 10100	D10R2x25xL100xSD10				100	10	B	●	
AHMR 6120R0.5 1275	D12R0.5x30xL75xSD12	12	0.5	30	75	12	B	●	
AHMR 6120R0.5 12100	D12R0.5x30xL100xSD12				100	12	B	●	
AHMR 6120R1.0 1275	D12R1x30xL75xSD12		1.0		75	12	B	●	
AHMR 6120R1.0 12100	D12R1x30xL100xSD12				100	12	B	●	
AHMR 6120R2.0 1275	D12R2x30xL75xSD12		2.0		75	12	B	●	
AHMR 6120R2.0 12100	D12R2x30xL100xSD12				100	12	B	●	

AHMRK 4 刃强力型圆鼻铣刀

AHMRK 4-flute High-feed End Mills with Corner Radius

UMG
硬质合金
Carbide

0°

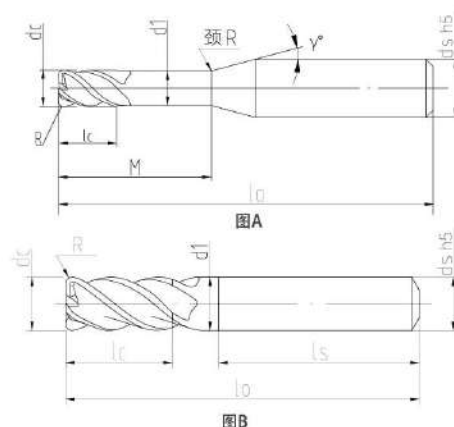
圆弧后角
Arc Relief angle

≤ 52
HRC

AX
涂层
Coating



- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



刃径 ϕ dc	ϕ dc Tolerance	刃径 ϕ dc	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 12$	± 0.010
$3 < \phi \leq 6$	0 ~ -0.012		
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

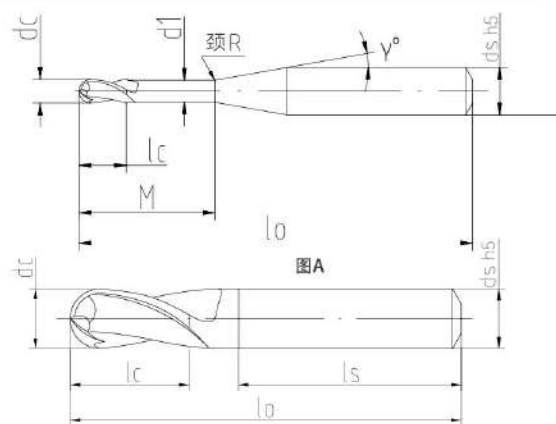
8 订货编号 · Order code											
代码 Code	规格型号 Designation	刃径 · ds	圆角半径 · R	刃长 · lc	有效长 · M	颈径 · Ø d1	柄锥角度 · γ °	全长 · lo	柄径 · ds	图示 Graph	库存 Inventory
AHMRK 4030R0.5 0650	D3R0.5x1.2x10xL50xSD6	3	0.5	1.2	10	2.9	11	50	6	A	●
AHMRK 4030R0.5 0675	D3R0.5x1.2x10xL75xSD6						11	75	6	A	●
AHMRK 4030R1.0 0650	D3R1x1.2x10xL50xSD6		1				11	50	6	A	●
AHMRK 4030R1.0 0675	D3R1x1.2x10xL75xSD6						11	75	6	A	●
AHMRK 4040R0.5 0650	D4R0.5x1.6x12xL50xSD6	4	0.5	1.6	12	3.9	11	50	6	A	●
AHMRK 4040R0.5 0675	D4R0.5x1.6x12xL75xSD6						11	75	6	A	●
AHMRK 4040R1.0 0650	D4R1x1.6x12xL50xSD6		1				11	50	6	A	●
AHMRK 4040R1.0 0675	D4R1x1.6x12xL75xSD6						11	75	6	A	●
AHMRK 4050R1.0 0650	D5R1x2x15xL50xSD6	5	1	2	15	4.85	11	50	6	A	●
AHMRK 4050R1.0 0675	D5R1x2x15xL75xSD6						11	75	6	A	●
AHMRK 4060R1.0 0650	D6R1x2.5x18xL50xSD6	6	1	2.5	18	5.85	-	50	6	B	●
AHMRK 4060R1.0 0675	D6R1x2.5x18xL75xSD6						-	75	6	B	●
AHMRK 4060R1.5 0650	D6R1.5x2.5x18xL50xSD6		1.5				-	50	6	B	●
AHMRK 4060R1.5 0675	D6R1.5x2.5x18xL75xSD6						-	75	6	B	●
AHMRK 4080R1.0 0875	D8R1x3.5x24xL75xSD8	8	1	3.5	24	7.8	-	75	8	B	●
AHMRK 4080R1.0 0810	D8R1x3.5x24xL100xSD8						-	100	8	B	●
AHMRK 4100R1.0 1075	D10R1x4x30xL75xSD10	10	1	4	30	9.8	-	75	10	B	●
AHMRK 4100R1.0 10100	D10R1x4x30xL100xSD10						-	100	10	B	●
AHMRK 4100R2.0 1075	D10R2x4x30xL75xSD10		2				-	75	10	B	●
AHMRK 4100R2.0 10100	D10R2x4x30xL100xSD10						-	100	10	B	●
AHMRK 4120R2.0 1275	D12R2x5x36xL75xSD12	12	2	5	36	11.7	-	75	12	B	●
AHMRK 4120R2.0 12100	D12R2x5x36xL100xSD12						-	100	12	B	●
AHMRK 4120R3.0 1275	D12R3x5x36xL75xSD12		3				-	75	12	B	●
AHMRK 4120R3.0 12100	D12R3x5x36xL100xSD12						-	100	12	B	●

AHMB 2 刃球头铣刀

AHMB 2-flute Ballnose End Mills



- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 高精度球头为精加工铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision ball-end is designed for finishing milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



图B

刃径 ϕ dc	ϕ dc Tolerance	刃径 ϕ dc	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 8$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012	$\phi > 8$	± 0.008
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号 · Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效 长·M	颈径· ϕ d1	颈 R·R	柄锥角度· γ°	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHMB 2004 0450	D0.4R0.2x0.6xL50xSD4	0.4	0.2	0.6	-	-	2	12	50	4	A	●
AHMB 2005 0450	D0.5R0.25x0.8xL50xSD4	0.5	0.25	0.8	-	-	2	12	50	4	A	●
AHMB 2006 0450	D0.6R0.3x0.9xL50xSD4	0.6	0.3	0.9	-	-	4	12	50	4	A	●
AHMB 2008 0450	D0.8R0.4x1.2xL50xSD4	0.8	0.4	1.2	-	-	4	12	50	4	A	●
AHMB 2010 0450	D1R0.5x0.8x2.5xL50xSD4	1	0.5	0.8	2	0.94	4	12	50	4	A	●
AHMB 2010 0650	D1R0.5x0.8x2.5xL50xSD6				2.5			12	50	6	A	●
AHMB 2010 0660	D1R0.5x0.8x2.5xL60xSD6				2.5			12	60	6	A	●
AHMB 2010 0675	D1R0.5x0.8x2.5xL75xSD6				2.5			12	75	6	A	●
AHMB 2010 06100	D1R0.5x0.8x2.5xL100xSD6	1.5	0.75	1.2	2.5	1.42	-	12	100	6	A	●
AHMB 2015 0450	D1.5R0.75x1.2x3xL50xSD4				3			11	50	4	A	●
AHMB 2015 0650	D1.5R0.75x1.2x4xL50xSD6				4			11	50	6	A	●
AHMB 2015 0660	D1.5R0.75x1.2x4xL60xSD6				4			11	60	6	A	●
AHMB 2015 0675	D1.5R0.75x1.2x4xL75xSD6	2	1	1.6	4	1.9	-	11	75	6	A	●
AHMB 2015 06100	D1.5R0.75x1.2x4xL100xSD6				4			11	100	6	A	●
AHMB 2020 0450	D2R1x1.6x4xL50xSD4				4			11	50	4	A	●
AHMB 2020 0650	D2R1x1.6x6xL50xSD6				6			11	50	6	A	●
AHMB 2020 0660	D2R1x1.6x6xL60xSD6	2.5	1.25	2	6	2.4	-	11	60	6	A	●
AHMB 2020 0675	D2R1x1.6x6xL75xSD6				6			11	75	6	A	●
AHMB 2020 06100	D2R1x1.6x6xL100xSD6				6			11	100	6	A	●
AHMB 2025 0450	D2.5R1.25x2x5xL50xSD4				5			11	50	4	A	●
AHMB 2025 0650	D2.5R1.25x2x7xL50xSD6	2.5	1.25	2	7	2.4	-	11	50	6	A	●
AHMB 2025 0660	D2.5R1.25x2x7xL60xSD6				7			11	60	6	A	●
AHMB 2025 0675	D2.5R1.25x2x7xL75xSD6				7			11	75	6	A	●
AHMB 2025 06100	D2.5R1.25x2x7xL100xSD6				7			11	100	6	A	●

A

B

C

D

E

F

G

H

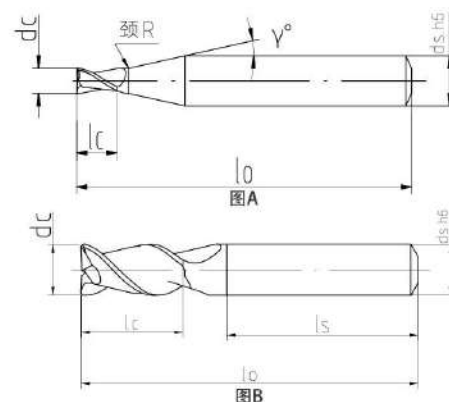
订货编号·Order code												
代码 Code	规格型号 Designation	刃径·ds	圆角半径 ·R	刃长·lc	有效 长·M	颈径· ϕ d1	颈 R·R	柄锥角度 γ /°	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHMB 2030 0450	D3R1.5x2.4x6xL50xSD4	3	1.5	2.4	6	2.9	-	11	50	4	A	●
AHMB 2030 0650	D3R1.5x2.4x8xL50xSD6				8			11	50	6	A	●
AHMB 2030 0660	D3R1.5x2.4x8xL60xSD6				8			11	60	4	A	●
AHMB 2030 0675	D3R1.5x2.4x8xL75xSD6				8			11	75	4	A	●
AHMB 2030 06100	D3R1.5x2.4x8xL100xSD6				8			11	100	4	A	●
AHMB 2040 0450	D4R2x6xL50xSD4	4	2	6	-	-	-	50	4	B	●	
AHMB 2040 0475	D4R2x6xL75xSD4			3.2	10		3.9	-	75	4	B	●
AHMB 2040 0650	D4R2x3.2x10xL50xSD6						11	50	6	A	●	
AHMB 2040 0660	D4R2x3.2x10xL60xSD6						11	60	6	A	●	
AHMB 2040 0675	D4R2x3.2x10xL75xSD6						11	75	6	A	●	
AHMB 2040 06100	D4R2x3.2x10xL100xSD6						11	100	6	A	●	
AHMB 2050 0650	D5R2.5x4x12xL50xSD6	5	2.5	4	12	4.85	-	11	50	6	A	●
AHMB 2050 0660	D5R2.5x4x12xL60xSD6							11	60	6	A	●
AHMB 2050 0675	D5R2.5x4x12xL75xSD6							11	75	6	A	●
AHMB 2050 06100	D5R2.5x4x12xL100xSD6							11	100	6	A	●
AHMB 2060 0650	D6R3x9xL50xSD6	6	3	9	-	-	-	-	50	6	B	●
AHMB 2060 0660	D6R3x9xL60xSD6							-	60	6	B	●
AHMB 2060 0675	D6R3x9xL75xSD6							-	75	6	B	●
AHMB 2060 06100	D6R3x9xL100xSD6							-	100	6	B	●
AHMB 2080 0860	D8R4x12xL60xSD8	8	4	12	-	-	-	-	60	8	B	●
AHMB 2080 0875	D8R4x12xL75xSD8							-	75	8	B	●
AHMB 2080 08100	D8R4x12xL100xSD8							-	100	8	B	●
AHMB 2080 08125	D8R4x12xL125xSD8							-	125	8	B	●
AHMB 2080 08150	D8R4x12xL150xSD8							-	150	8	B	●
AHMB 2100 1075	D10R5x15xL75xSD10	10	5	15	-	-	-	-	75	10	B	●
AHMB 2100 10100	D10R5x15xL100xSD10							-	100	10	B	●
AHMB 2100 10125	D10R5x15xL125xSD10							-	125	10	B	●
AHMB 2100 10150	D10R5x15xL150xSD10							-	150	10	B	●
AHMB 2120 1275	D12R6x18xL75xSD12	12	6	18	-	-	-	-	75	12	B	●
AHMB 2120 12100	D12R6x18xL100xSD12							-	100	12	B	●
AHMB 2120 12125	D12R6x18xL125xSD12							-	125	12	B	●
AHMB 2120 12150	D12R6x18xL150xSD12							-	150	12	B	●
AHMB 2160 16100	D16R8x24xL100xSD16	16	8	24	-	-	-	-	100	16	B	●
AHMB 2160 16150	D16R8x24xL150xSD16							-	150	16	B	●

AHME 2 刃平头铣刀

AHME 2-flute End Mills



- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 3$	0 ~ -0.010
$3 < \phi \leq 6$	0 ~ -0.012
$6 < \phi \leq 10$	0 ~ -0.015
$10 < \phi \leq 20$	0 ~ -0.018

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号 · Order code									
代码 Code	规格型号 Designation	刃径 · d_s	刃长 · l_c	颈 R · R	柄锥角度 · $\gamma / ^\circ$	全长 · l_o	柄径 · d_s	图示 Graph	库存 Inventory
AHME 2004 0450	D0.4x1.2xL50xSD4	0.4	1.2	2	12	50	4	A	●
AHME 2005 0450	D0.5x1.5xL50xSD4	0.5	1.5	2	12	50	4	A	●
AHME 2006 0450	D0.6x1.8xL50xSD4	0.6	1.8	4	12	50	4	A	●
AHME 2008 0450	D0.8x2.4xL50xSD4	0.8	2.4	4	12	50	4	A	●
AHME 2010 0450	D1x3xL50xSD4	1	3	4	12	50	4	A	●
AHME 2010 0650	D1x3xL50xSD6				12	50	6	A	●
AHME 2015 0450	D1.5x4xL50xSD4	1.5	4	-	11	50	4	A	●
AHME 2015 0650	D1.5x4xL50xSD6				11	50	6	A	●
AHME 2020 0450	D2x5xL50xSD4	2	5	-	11	50	4	A	●
AHME 2020 0650	D2x5xL50xSD6				11	50	6	A	●
AHME 2025 0450	D2.5x6.5xL50xSD4	2.5	6.5	-	11	50	4	A	●
AHME 2025 0650	D2.5x6.5xL50xSD6				11	50	6	A	●
AHME 2030 0450	D3x7.5xL50xSD4	3	7.5	-	11	50	4	A	●
AHME 2030 0650	D3x7.5xL50xSD6				11	50	6	A	●
AHME 2030 0660	D3x7.5xL60xSD6				11	60	6	A	●
AHME 2030 0675	D3x7.5xL75xSD6				11	75	6	A	●
AHME 2040 0450	D4x10xL50xSD4	4	10	-	-	50	4	B	●
AHME 2040 0475	D4x10xL75xSD4				-	75	4	B	●
AHME 2040 0650	D4x10xL50xSD6				11	50	6	A	●
AHME 2040 0660	D4x10xL60xSD6				11	60	6	A	●
AHME 2040 0675	D4x10xL75xSD6				11	75	6	A	●
AHME 2050 0650	D5x12.5xL50xSD6	5	12.5	-	11	50	6	A	●
AHME 2050 0675	D5x12.5xL75xSD6				11	75	6	A	●

A

B

C

D

E

F

G

H

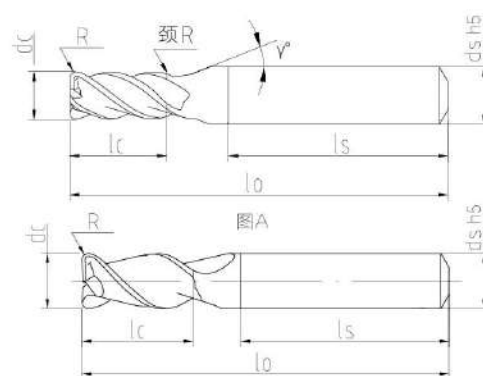
订货编号·Order code									
代码 Code	规格型号 Designation	刃径·ds	刃长·lc	颈 R·R	柄锥角度· $\gamma/^\circ$	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHME 2060 0650	D6x15xL50xSD6	6	15	-	-	50	6	B	●
AHME 2060 0660	D6x15xL60xSD6				-	60	6	B	●
AHME 2060 0675	D6x15xL75xSD6				-	75	6	B	●
AHME 2060 06100	D6x15xL100xSD6				-	100	6	B	●
AHME 2080 0860	D8x20xL60xSD8	8	20	-	-	60	8	B	●
AHME 2080 0875	D8x20xL75xSD8				-	75	8	B	●
AHME 2080 08100	D8x20xL100xSD8				-	100	8	B	●
AHME 2100 1075	D10x25xL75xSD10				-	75	10	B	●
AHME 2100 10100	D10x25xL100xSD10	10	25	-	-	100	10	B	●
AHME 2120 1275	D12x30xL75xSD12	12	30	-	-	75	12	B	●
AHME 2120 12100	D12x30xL100xSD12				-	100	12	B	●
AHME 2140 1475	D14x35xL75xSD14	14	35	-	-	75	14	B	●
AHME 2140 14100	D14x35xL100xSD14				-	100	14	B	●
AHME 2160 16100	D16x40xL100xSD16	16	40	-	-	100	16	B	●
AHME 2160 16150	D16x40xL150xSD16				-	150	16	B	●
AHME 2200 20100	D20x50xL100xSD20	20	50	-	-	100	20	B	●
AHME 2200 20150	D20x50xL150xSD20				-	150	20	B	●

AHMR 2 刃圆鼻铣刀

AHMR 2-flute End Mills with Corner Radius



- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工作表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;



图B

刃径 ϕ ·dc	ϕ ·dc Tolerance	刃径 ϕ ·dc	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 12$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		
$6 < \phi \leq 10$	0 ~ -0.015		
$10 < \phi \leq 20$	0 ~ -0.018		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号 · Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	颈 R·R	柄锥角度· $\gamma / ^\circ$	全长·lo	柄径·ds	图示 Graph	库存 Inventory		
AHMR 2010R0.2 0450	D1R0.2x2xL50xSD4	1	0.2	2	4	12	50	4	A	●		
AHMR 2015R0.2 0450	D1.5R0.2x3xL50xSD4	1.5	0.2	3	-	11	50	4	A	●		
AHMR 2020R0.2 0450	D2R0.2x4xL50xSD4	2	0.2	4	-	11	50	4	A	●		
AHMR 2020R0.5 0450	D2R0.5x4xL50xSD4		0.5			11	50	4	A	●		
AHMR 2025R0.2 0450	D2.5R0.2x5xL50xSD4	2.5	0.2	5	-	11	50	4	A	●		
AHMR 2025R0.5 0450	D2.5R0.5x5xL50xSD4		0.5			11	50	4	A	●		
AHMR 2030R0.2 0450	D3R0.2x6xL50xSD4	3	0.2	6	-	11	50	4	A	●		
AHMR 2030R0.2 0650	D3R0.2x6xL50xSD6					11	50	6	A	●		
AHMR 2030R0.2 0660	D3R0.2x6xL60xSD6					11	60	6	A	●		
AHMR 2030R0.2 0675	D3R0.2x6xL75xSD6					11	75	6	A	●		
AHMR 2030R0.5 0450	D3R0.5x6xL50xSD4		0.5			11	50	4	A	●		
AHMR 2030R0.5 0450	D3R0.5x6xL50xSD6					11	50	6	A	●		
AHMR 2030R0.5 0660	D3R0.5x6xL60xSD6					11	60	6	A	●		
AHMR 2030R0.5 0675	D3R0.5x6xL75xSD6					11	75	6	A	●		
AHMR 2040R0.2 0450	D4R0.2x8xL50xSD4	4	0.2	8	-	-	50	4	B	●		
AHMR 4040R0.5 0460	D4R0.2x8xL60xSD4					-	60	4	B	●		
AHMR 2040R0.2 0475	D4R0.2x8xL75xSD4					-	75	4	B	●		
AHMR 2040R0.2 0650	D4R0.2x8xL50xSD6					11	50	6	A	●		
AHMR 2040R0.2 0660	D4R0.2x8xL60xSD6					11	60	6	A	●		
AHMR 2040R0.2 0675	D4R0.2x8xL75xSD6					11	75	6	A	●		
AHMR 2040R0.5 0450	D4R0.5x8xL50xSD4		0.5			-	50	4	B	●		
AHMR 4040R0.5 0460	D4R0.5x8xL60xSD4					-	60	4	B	●		
AHMR 2040R0.5 0475	D4R0.5x8xL75xSD4					-	75	4	B	●		
AHMR 2040R0.5 0650	D4R0.5x8xL50xSD6					11	50	6	A	●		
AHMR 2040R0.5 0660	D4R0.5x8xL60xSD6					11	60	6	A	●		
AHMR 2040R0.5 0675	D4R0.5x8xL75xSD6					11	75	6	A	●		

A

B

C

D

E

F

G

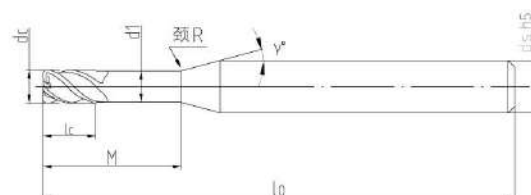
H

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	颈 R·R	柄锥角度 γ°	全长·lo	柄径·ds	图示 Graph	库存 Inventory		
AHMR 2040R1.0 0450	D4R1x8xL50xSD4	4	1.0	8	-	-	50	4	B	●		
AHMR 4040R1.0 0460	D4R1x8xL60xSD4					-	75	4	B	●		
AHMR 2040R1.0 0475	D4R1x8xL75xSD4					-	75	4	B	●		
AHMR 2040R1.0 0650	D4R1x8xL50xSD6					11	50	6	A	●		
AHMR 2040R1.0 0660	D4R1x8xL60xSD6					11	60	6	A	●		
AHMR 2040R1.0 0675	D4R1x8xL75xSD6					11	75	6	A	●		
AHMR 2060R0.5 0650	D6R0.5x12xL50xSD6	6	0.5	12	-	-	50	6	B	●		
AHMR 2060R0.5 0660	D6R0.5x12xL60xSD6					-	60	6	B	●		
AHMR 2060R0.5 0675	D6R0.5x12xL75xSD6					-	75	6	B	●		
AHMR 2060R0.5 06100	D6R0.5x12xL100xSD6					-	100	6	B	●		
AHMR 2060R1.0 0650	D6R1x12xL50xSD6		1.0			-	50	6	B	●		
AHMR 2060R1.0 0660	D6R1x12xL60xSD6					-	60	6	B	●		
AHMR 2060R1.0 0675	D6R1x12xL75xSD6					-	75	6	B	●		
AHMR 2060R1.0 06100	D6R1x12xL100xSD6					-	100	6	B	●		
AHMR 2080R0.5 0860	D8R0.5x16xL60xSD8	8	0.5	16	-	-	60	-	B	●		
AHMR 2080R0.5 0875	D8R0.5x16xL75xSD8					-	75	8	B	●		
AHMR 2080R0.5 08100	D8R0.5x16xL100xSD8					-	100	8	B	●		
AHMR 2080R1.0 0860	D8R1x16xL60xSD8		1.0			-	60	8	B	●		
AHMR 2080R1.0 0875	D8R1x16xL75xSD8					-	75	8	B	●		
AHMR 2080R1.0 08100	D8R1x16xL100xSD8					-	100	8	B	●		
AHMR 2100R0.5 1075	D10R0.5x20xL75xSD10	10	0.5	20	-	-	75	10	B	●		
AHMR 2100R0.5 10100	D10R0.5x20xL100xSD10		1.0			-	100	10	B	●		
AHMR 2100R1.0 1075	D10R1x20xL75xSD10					-	75	10	B	●		
AHMR 2100R1.0 10100	D10R1x20xL100xSD10					-	100	10	B	●		
AHMR 2120R0.5 1275	D12R0.5x24xL75xSD12	12	0.5	24	-	-	75	12	B	●		
AHMR 2120R0.5 12100	D12R0.5x24xL100xSD12		1.0			-	100	12	B	●		
AHMR 2120R1.0 1275	D12R1x24xL75xSD12					-	75	12	B	●		
AHMR 2120R1.0 12100	D12R1x24xL100xSD12					-	100	12	B	●		
AHMR 2120R2.0 1275	D12R2x24xL75xSD12		2.0			-	75	12	B	●		
AHMR 2120R2.0 12100	D12R2x24xL100xSD12					-	100	12	B	●		

AHMEL 4 刃长颈平头铣刀

AHMEL 4-flute End Mills with Neck Increased



图A

- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工作表面粗糙度;
- 为高精度铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- Designed for high precision milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 3$	0 ~ -0.010
$3 < \phi \leq 6$	0 ~ -0.012

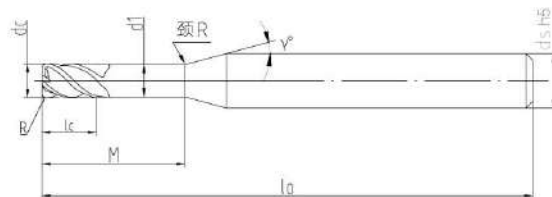
碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号·Order code

代码 Code	规格型号 Designation	刃径· d_s	刃长· l_c	有效长· M	颈径· ϕd_1	颈 R· R	柄锥角度· γ°	全长· l_o	柄径· d_s	图示 Graph	库存 Inventory
AHMEL 4008L2 0450	D0.8x2xL50xSD4	0.8	0.6	2	0.76	4	12	50	4	A	●
AHMEL 4008L4 0450	D0.8x4xL50xSD4			4			12	50	4	A	●
AHMEL 4008L6 0450	D0.8x6xL50xSD4			6			12	50	4	A	●
AHMEL 4008L8 0450	D0.8x8xL50xSD4			8			12	50	4	A	●
AHMEL 4010L4 0450	D1x4xL50xSD4	1	0.8	4	0.94	4	12	50	4	A	●
AHMEL 4010L6 0450	D1x6xL50xSD4			6			12	50	4	A	●
AHMEL 4010L8 0450	D1x8xL50xSD4			8			12	50	4	A	●
AHMEL 4010L10 0450	D1x10xL50xSD4			10			12	50	4	A	●
AHMEL 4015L6 0450	D1.5x6xL50xSD4	1.5	1.2	6	1.42	-	11	50	4	A	●
AHMEL 4015L8 0450	D1.5x8xL50xSD4			8			11	50	4	A	●
AHMEL 4015L10 0450	D1.5x10xL50xSD4			10			11	50	4	A	●
AHMEL 4015L12 0450	D1.5x12xL50xSD4			12			11	50	4	A	●
AHMEL 4020L8 0450	D2x8xL50xSD4	2	1.6	8	1.9	-	11	50	4	A	●
AHMEL 4020L10 0450	D2x10xL50xSD4			10			11	50	4	A	●
AHMEL 4020L12 0450	D2x12xL50xSD4			12			11	50	4	A	●
AHMEL 4020L16 0450	D2x16xL50xSD4			16			11	50	4	A	●
AHMEL 4025L10 0450	D2.5x10xL50xSD4	2.5	2	10	2.4	-	11	50	4	A	●
AHMEL 4025L12 0450	D2.5x12xL50xSD4			12			11	50	4	A	●
AHMEL 4025L16 0450	D2.5x16xL50xSD4			16			11	50	4	A	●
AHMEL 4025L20 0450	D2.5x20xL50xSD4			20			11	50	4	A	●
AHMEL 4030L10 0450	D3x10xL50xSD4	3	2.4	10	2.9	-	11	50	4	A	●
AHMEL 4030L10 0660	D3x10xL60xSD6			10			11	60	6	A	●
AHMEL 4030L12 0450	D3x12xL50xSD4			12			11	50	4	A	●
AHMEL 4030L12 0660	D3x12xL60xSD6			12			11	60	6	A	●
AHMEL 4030L16 0450	D3x16xL50xSD4			16			11	50	4	A	●
AHMEL 4030L16 0660	D3x16xL60xSD6			16			11	60	6	A	●
AHMEL 4030L20 0660	D3x20xL60xSD6			20			11	60	6	A	●
AHMEL 4030L25 0675	D3x25xL75xSD6			25			11	75	6	A	●
AHMEL 4040L12 0660	D4x12xL60xSD6	4	3.2	12	3.9	-	11	60	6	A	●
AHMEL 4040L16 0660	D4x16xL60xSD6			16			11	60	6	A	●
AHMEL 4040L20 0660	D4x20xL60xSD6			20			11	60	6	A	●
AHMEL 4040L25 0675	D4x25xL75xSD6			25			11	75	6	A	●
AHMEL 4040L30 0675	D4x30xL75xSD6			30			11	75	6	A	●

AHMRL 4 刃长颈圆鼻铣刀

AHMRL 4-flute End Mills with Neck Increased & Corner Radius



图A

- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	R Tolerance	刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 4$	± 0.005	$\phi \leq 3$	$0 \sim -0.010$
		$3 < \phi \leq 6$	$0 \sim -0.012$

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号 - Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径· ϕ_{d1}	颈 R·R	柄锥角度· γ°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory
AHMRL 4008R0.02L2 0450	D0.8R0.02x2xL50xSD4	0.8	0.02	0.6	2	0.76	4	12	50	4	A	●
AHMRL 4008R0.02L3 0450	D0.8R0.02x3xL50xSD4				3			12	50	4	A	●
AHMRL 4008R0.02L4 0450	D0.8R0.02x4xL50xSD4				4			12	50	4	A	●
AHMRL 4008R0.02L6 0450	D0.8R0.02x6xL50xSD4				6			12	50	4	A	●
AHMRL 4008R0.02L8 0450	D0.8R0.02x8xL50xSD4				8			12	50	4	A	●
AHMRL 4008R0.02L10 0450	D0.8R0.02x10xL50xSD4				10			12	50	4	A	●
AHMRL 4008R0.02L12 0450	D0.8R0.02x12xL50xSD4				12			12	50	4	A	●
AHMRL 4008R0.05L2 0450	D0.8R0.05x2xL50xSD4		2		0.05			12	50	4	A	●
AHMRL 4008R0.05L3 0450	D0.8R0.05x3xL50xSD4		3					12	50	4	A	●
AHMRL 4008R0.05L4 0450	D0.8R0.05x4xL50xSD4		4					12	50	4	A	●
AHMRL 4008R0.05L6 0450	D0.8R0.05x6xL50xSD4		6					12	50	4	A	●
AHMRL 4008R0.05L8 0450	D0.8R0.05x8xL50xSD4		8					12	50	4	A	●
AHMRL 4008R0.05L10 0450	D0.8R0.05x10xL50xSD4		10					12	50	4	A	●
AHMRL 4008R0.05L12 0450	D0.8R0.05x12xL50xSD4		12					12	50	4	A	●
AHMRL 4008R0.1L2 0450	D0.8R0.1x2xL50xSD4	2	0.1	12	50	4	A	●				
AHMRL 4008R0.1L3 0450	D0.8R0.1x3xL50xSD4	3		12	50	4	A	●				
AHMRL 4008R0.1L4 0450	D0.8R0.1x4xL50xSD4	4		12	50	4	A	●				
AHMRL 4008R0.1L6 0450	D0.8R0.1x6xL50xSD4	6		12	50	4	A	●				
AHMRL 4008R0.1L8 0450	D0.8R0.1x8xL50xSD4	8		12	50	4	A	●				
AHMRL 4008R0.1L10 0450	D0.8R0.1x10xL50xSD4	10		12	50	4	A	●				
AHMRL 4008R0.1L12 0450	D0.8R0.1x12xL50xSD4	12		12	50	4	A	●				
AHMRL 4008R0.2L2 0450	D0.8R0.2x2xL50xSD4	2	0.2	12	50	4	A	●				
AHMRL 4008R0.2L3 0450	D0.8R0.2x3xL50xSD4	3		12	50	4	A	●				
AHMRL 4008R0.2L4 0450	D0.8R0.2x4xL50xSD4	4		12	50	4	A	●				

订货编号·Order code													
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刀长·lc	有效长·M	颈径· ϕ d1	颈 R·R	柄锥角度· $\gamma/^\circ$	全长·lo	柄径·ds	图示 Graph	库存 Inventory	
AHMRL 4008R0.2L6 0450	D0.8R0.2x6xL50xSD4	0.8	0.2	0.6	6	0.76	4	12	50	4	A	●	
AHMRL 4008R0.2L8 0450	D0.8R0.2x8xL50xSD4				8			12	50	4	A	●	
AHMRL 4008R0.2L10 0450	D0.8R0.2x10xL50xSD4				10			12	50	4	A	●	
AHMRL 4008R0.2L12 0450	D0.8R0.2x12xL50xSD4				12			12	50	4	A	●	
AHMRL 4009R0.1L4 0450	D0.9R0.1x4xL50xSD4	0.9	0.1	0.65	4	0.86	4	12	50	4	A	●	
AHMRL 4009R0.1L8 0450	D0.9R0.1x8xL50xSD4				8			12	50	4	A	●	
AHMRL 4010R0.05L3 0450	D1R0.05x3xL50xSD4	1	0.05	0.75	3	0.95	4	12	50	4	A	●	
AHMRL 4010R0.05L4 0450	D1R0.05x4xL50xSD4				4			12	50	4	A	●	
AHMRL 4010R0.05L5 0450	D1R0.05x5xL50xSD4				5			12	60	4	A	●	
AHMRL 4010R0.05L6 0450	D1R0.05x6xL50xSD4				6			12	50	4	A	●	
AHMRL 4010R0.05L8 0450	D1R0.05x8xL50xSD4				8			12	50	4	A	●	
AHMRL 4010R0.05L10 0450	D1R0.05x10xL50xSD4				10			12	50	4	A	●	
AHMRL 4010R0.05L12 0450	D1R0.05x12xL50xSD4				12			12	50	4	A	●	
AHMRL 4010R0.05L16 0450	D1R0.05x16xL50xSD4				16			12	50	4	A	●	
AHMRL 4010R0.05L20 0460	D1R0.05x20xL60xSD4				20			12	60	4	A	●	
AHMRL 4010R0.1L3 0450	D1R0.1x3xL50xSD4		0.1		3			12	50	4	A	●	
AHMRL 4010R0.1L4 0450	D1R0.1x4xL50xSD4				4			12	50	4	A	●	
AHMRL 4010R0.1L5 0450	D1R0.1x5xL50xSD4				5			12	50	4	A	●	
AHMRL 4010R0.1L6 0450	D1R0.1x6xL50xSD4				6			12	50	4	A	●	
AHMRL 4010R0.1L8 0450	D1R0.1x8xL50xSD4				8			12	50	4	A	●	
AHMRL 4010R0.1L10 0450	D1R0.1x10xL50xSD4				10			12	50	4	A	●	
AHMRL 4010R0.1L12 0450	D1R0.1x12xL50xSD4				12			12	50	4	A	●	
AHMRL 4010R0.1L16 0450	D1R0.1x16xL50xSD4				16			12	50	4	A	●	
AHMRL 4010R0.1L20 0460	D1R0.1x20xL60xSD4				20			12	60	4	A	●	
AHMRL 4010R0.2L3 0450	D1R0.2x3xL50xSD4		0.2		3			12	50	4	A	●	
AHMRL 4010R0.2L4 0450	D1R0.2x4xL50xSD4				4			12	50	4	A	●	
AHMRL 4010R0.2L5 0450	D1R0.2x5xL50xSD4				5			12	50	4	A	●	
AHMRL 4010R0.2L6 0450	D1R0.2x6xL50xSD4				6			12	50	4	A	●	
AHMRL 4010R0.2L8 0450	D1R0.2x8xL50xSD4				8			12	50	4	A	●	
AHMRL 4010R0.2L10 0450	D1R0.2x10xL50xSD4				10			12	50	4	A	●	
AHMRL 4010R0.2L12 0450	D1R0.2x12xL50xSD4				12			12	50	4	A	●	
AHMRL 4010R0.2L16 0450	D1R0.2x16xL50xSD4				16			12	50	4	A	●	
AHMRL 4010R0.2L20 0460	D1R0.2x20xL60xSD4				20			12	60	4	A	●	
AHMRL 4010R0.3L3 0450	D1R0.3x3xL50xSD4		0.3		3			12	50	4	A	●	
AHMRL 4010R0.3L4 0450	D1R0.3x4xL50xSD4				4			12	50	4	A	●	
AHMRL 4010R0.3L5 0450	D1R0.3x5xL50xSD4				5			12	50	4	A	●	
AHMRL 4010R0.3L6 0450	D1R0.3x6xL50xSD4				6			12	50	4	A	●	
AHMRL 4010R0.3L8 0450	D1R0.3x8xL50xSD4				8			12	50	4	A	●	
AHMRL 4010R0.3L10 0450	D1R0.3x10xL50xSD4				10			12	50	4	A	●	
AHMRL 4010R0.3L12 0450	D1R0.3x12xL50xSD4				12			12	50	4	A	●	
AHMRL 4010R0.3L16 0450	D1R0.3x16xL50xSD4				16			12	50	4	A	●	
AHMRL 4010R0.3L20 0460	D1R0.3x20xL60xSD4				20			12	60	4	A	●	
AHMRL 4015R0.1L6 0450	D1.5R0.1x6xL50xSD4	1.5	0.1	1.2	6	1.42	-	11	50	4	A	●	
AHMRL 4015R0.1L8 0450	D1.5R0.1x8xL50xSD4				8			11	50	4	A	●	
AHMRL 4015R0.1L10 0450	D1.5R0.1x10xL50xSD4				10			11	50	4	A	●	
AHMRL 4015R0.1L12 0450	D1.5R0.1x12xL50xSD4				12			11	50	4	A	●	
AHMRL 4015R0.2L6 0450	D1.5R0.2x6xL50xSD4		0.2		6			11	50	4	A	●	
AHMRL 4015R0.2L8 0450	D1.5R0.2x8xL50xSD4				8			11	50	4	A	●	
AHMRL 4015R0.2L10 0450	D1.5R0.2x10xL50xSD4				10			11	50	4	A	●	
AHMRL 4015R0.2L12 0450	D1.5R0.2x12xL50xSD4				12			11	50	4	A	●	
AHMRL 4020R0.1L8 0450	D2R0.1x8xL50xSD4	2	0.1	1.6	8	1.9	-	11	50	4	A	●	
AHMRL 4020R0.1L10 0450	D2R0.1x10xL50xSD4				10			11	50	4	A	●	
AHMRL 4020R0.1L12 0450	D2R0.1x12xL50xSD4				12			11	50	4	A	●	
AHMRL 4020R0.1L16 0450	D2R0.1x16xL50xSD4				16			11	50	4	A	●	
AHMRL 4020R0.2L8 0450	D2R0.2x8xL50xSD4		0.2		8			11	50	4	A	●	
AHMRL 4020R0.2L10 0450	D2R0.2x10xL50xSD4				10			11	50	4	A	●	
AHMRL 4020R0.2L12 0450	D2R0.2x12xL50xSD4				12			11	50	4	A	●	
AHMRL 4020R0.2L16 0450	D2R0.2x16xL50xSD4				16			11	50	4	A	●	
AHMRL 4020R0.5L8 0450	D2R0.5x8xL50xSD4		0.5		8			11	50	4	A	●	
AHMRL 4020R0.5L10 0450	D2R0.5x10xL50xSD4				10			11	50	4	A	●	
AHMRL 4020R0.5L12 0450	D2R0.5x12xL50xSD4				12			11	50	4	A	●	
AHMRL 4020R0.5L16 0450	D2R0.5x16xL50xSD4				16			11	50	4	A	●	

A

B

C

D

E

F

G

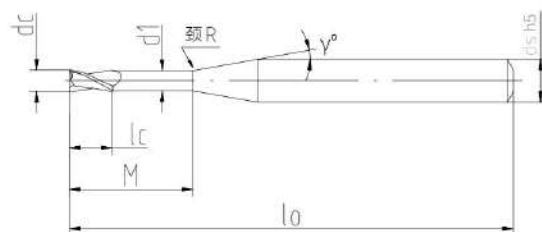
H

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径φ d1	颈 R·R	柄锥角度 γ/°	全长·lo	柄径 ·ds	图示 Graph	库存 Inventory	
AHMRL 4030R0.1L10 0450	D3R0.1x10xL50xSD4	3	0.1	2.4	10	2.9	-	11	50	4	A	●	
AHMRL 4030R0.1L10 0660	D3R0.1x10xL60xSD6				10			11	60	6	A	●	
AHMRL 4030R0.1L12 0450	D3R0.1x12xL50xSD4				12			11	50	4	A	●	
AHMRL 4030R0.1L12 0660	D3R0.1x12xL60xSD6				12			11	60	6	A	●	
AHMRL 4030R0.1L16 0450	D3R0.1x16xL50xSD4				16			11	50	4	A	●	
AHMRL 4030R0.1L16 0660	D3R0.1x16xL60xSD6				16			11	60	6	A	●	
AHMRL 4030R0.1L20 0660	D3R0.1x20xL60xSD6				20			11	60	6	A	●	
AHMRL 4030R0.1L25 0675	D3R0.1x25xL75xSD6				25			11	75	6	A	●	
AHMRL 4030R0.2L10 0450	D3R0.2x10xL50xSD4		10		0.2			10	11	50	4	A	●
AHMRL 4030R0.2L10 0660	D3R0.2x10xL60xSD6		10					11	60	6	A	●	
AHMRL 4030R0.2L12 0450	D3R0.2x12xL50xSD4		12					11	50	4	A	●	
AHMRL 4030R0.2L12 0660	D3R0.2x12xL60xSD6		12					11	60	6	A	●	
AHMRL 4030R0.2L16 0450	D3R0.2x16xL50xSD4		16					11	50	4	A	●	
AHMRL 4030R0.2L16 0660	D3R0.2x16xL60xSD6		16					11	60	6	A	●	
AHMRL 4030R0.2L20 0660	D3R0.2x20xL60xSD6		20					11	60	6	A	●	
AHMRL 4030R0.2L25 0675	D3R0.2x25xL75xSD6		25					11	75	6	A	●	
AHMRL 4030R0.5L10 0450	D3R0.5x10xL50xSD4		10		0.5			10	11	50	4	A	●
AHMRL 4030R0.5L10 0660	D3R0.5x10xL60xSD6		10					11	60	6	A	●	
AHMRL 4030R0.5L12 0450	D3R0.5x12xL50xSD4		12					11	50	4	A	●	
AHMRL 4030R0.5L12 0660	D3R0.5x12xL60xSD6		12					11	60	6	A	●	
AHMRL 4030R0.5L16 0450	D3R0.5x16xL50xSD4		16					11	50	4	A	●	
AHMRL 4030R0.5L16 0660	D3R0.5x16xL60xSD6		16					11	60	6	A	●	
AHMRL 4030R0.5L20 0660	D3R0.5x20xL60xSD6		20					11	60	6	A	●	
AHMRL 4030R0.5L25 0675	D3R0.5x25xL75xSD6		25					11	75	6	A	●	
AHMRL 4040R0.1L12 0660	D4R0.1x12xL60xSD6	4	0.1	3.2	12	3.9	-	11	60	6	A	●	
AHMRL 4040R0.1L16 0660	D4R0.1x16xL60xSD6				16			11	60	6	A	●	
AHMRL 4040R0.1L20 0660	D4R0.1x20xL60xSD6				20			11	60	6	A	●	
AHMRL 4040R0.1L25 0675	D4R0.1x25xL75xSD6				25			11	75	6	A	●	
AHMRL 4040R0.1L30 0675	D4R0.1x30xL75xSD6				30			11	75	6	A	●	
AHMRL 4040R0.2L12 0660	D4R0.2x12xL60xSD6		0.2		12			11	60	6	A	●	
AHMRL 4040R0.2L16 0660	D4R0.2x16xL60xSD6				16			11	60	6	A	●	
AHMRL 4040R0.2L20 0660	D4R0.2x20xL60xSD6				20			11	60	6	A	●	
AHMRL 4040R0.2L25 0675	D4R0.2x25xL75xSD6				25			11	75	6	A	●	
AHMRL 4040R0.2L30 0675	D4R0.2x30xL75xSD6				30			11	75	6	A	●	
AHMRL 4040R0.5L12 0660	D4R0.5x12xL60xSD6		0.5		12			11	60	6	A	●	
AHMRL 4040R0.5L16 0660	D4R0.5x16xL60xSD6				16			11	60	6	A	●	
AHMRL 4040R0.5L20 0660	D4R0.5x20xL60xSD6				20			11	60	6	A	●	
AHMRL 4040R0.5L25 0675	D4R0.5x25xL75xSD6				25			11	75	6	A	●	
AHMRL 4040R0.5L30 0675	D4R0.5x30xL75xSD6				30			11	75	6	A	●	
AHMRL 4040R1.0L12 0660	D4R1x12xL60xSD6		1.0		12			11	60	6	A	●	
AHMRL 4040R1.0L16 0660	D4R1x16xL60xSD6				16			11	60	6	A	●	
AHMRL 4040R1.0L20 0660	D4R1x20xL60xSD6				20			11	60	6	A	●	
AHMRL 4040R1.0L25 0675	D4R1x25xL75xSD6				25			11	75	6	A	●	
AHMRL 4040R1.0L30 0675	D4R1x30xL75xSD6				30			11	75	6	A	●	

AHMEI 2 刃长颈平头铣刀

AHMEI 2-flute End Mills with Neck Increased



图A

- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 为高精度铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- Designed for high precision milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance
$\phi \leq 3$	0 ~ -0.010
$3 < \phi \leq 6$	0 ~ -0.012

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
●	○	●	○		○	○

订货编号 · Order code

代码 Code	规格型号 Designation	刃径 · d_s	刃长 · l_c	有效长 · M	颈径 · ϕ_{d1}	颈 R · R	柄锥角度 · $\gamma / ^\circ$	全长 · l_o	柄径 · d_s	图示 Graph	库存 Inventory
AHMEI 2001L0.3 0450	D0.1x0.3xL50xSD4	0.1	0.07	0.3	0.085	2	12	50	4	A	●
AHMEI 2001L0.5 0450	D0.1x0.5xL50xSD4			0.5			12	50	4	A	●
AHMEI 2001L1 0450	D0.1x1xL50xSD4			1			12	50	4	A	●
AHMEI 2002L0.5 0450	D0.2x0.5xL50xSD4	0.2	0.15	0.5	0.18	2	12	50	4	A	●
AHMEI 2002L1 0450	D0.2x1xL50xSD4			1			12	50	4	A	●
AHMEI 2002L2 0450	D0.2x2xL50xSD4			2			12	50	4	A	●
AHMEI 2003L1 0450	D0.3x1xL50xSD4	0.3	0.2	1	0.28	2	12	50	4	A	●
AHMEI 2003L2 0450	D0.3x2xL50xSD4			2			12	50	4	A	●
AHMEI 2003L3 0450	D0.3x3xL50xSD4			3			12	50	4	A	●
AHMEI 2004L2 0450	D0.4x2xL50xSD4	0.4	0.3	2	0.36	2	12	50	4	A	●
AHMEI 2004L3 0450	D0.4x3xL50xSD4			3			12	50	4	A	●
AHMEI 2005L2 0450	D0.5x2xL50xSD4			2			12	50	4	A	●
AHMEI 2005L3 0450	D0.5x3xL50xSD4	0.5	0.4	3	0.46	2	12	50	4	A	●
AHMEI 2005L4 0450	D0.5x4xL50xSD4			4			12	50	4	A	●
AHMEI 2006L2 0450	D0.6x2xL50xSD4			2			12	50	4	A	●
AHMEI 2006L3 0450	D0.6x3xL50xSD4	0.6	0.5	3	0.56	4	12	50	4	A	●
AHMEI 2006L4 0450	D0.6x4xL50xSD4			4			12	50	4	A	●
AHMEI 2008L4 0450	D0.8x4xL50xSD4	0.8	0.7	4	0.76	4	12	50	4	A	●
AHMEI 2008L6 0450	D0.8x6xL50xSD4			6			12	50	4	A	●
AHMEI 2010L4 0450	D1x4xL50xSD4			4			12	50	4	A	●
AHMEI 2010L6 0450	D1x6xL50xSD4	1	0.8	6	0.94	4	12	50	4	A	●
AHMEI 2010L8 0450	D1x8xL50xSD4			8			12	50	4	A	●
AHMEI 2010L10 0450	D1x10xL50xSD4			10			12	50	4	A	●

A

B

C

D

E

F

G

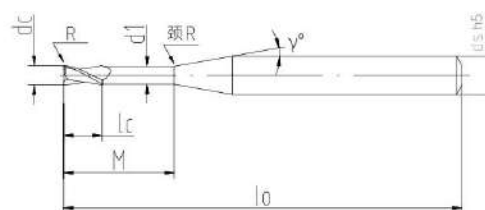
H

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	刃长·lc	有效长·M	颈径· $\varnothing$ d1	颈 R·R	柄锥角度· $\gamma/^\circ$	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHMEL 2015L6 0450	D1.5x6xL50xSD4	1.5	1.2	6	1.42	-	11	50	4	A	●
AHMEL 2015L8 0450	D1.5x8xL50xSD4			8			11	50	4	A	●
AHMEL 2015L10 0450	D1.5x10xL50xSD4			10			11	50	4	A	●
AHMEL 2015L12 0450	D1.5x12xL50xSD4			12			11	50	4	A	●
AHMEL 2020L8 0450	D2x8xL50xSD4	2	1.6	8	1.9	-	11	50	4	A	●
AHMEL 2020L10 0450	D2x10xL50xSD4			10			11	50	4	A	●
AHMEL 2020L12 0450	D2x12xL50xSD4			12			11	50	4	A	●
AHMEL 2020L16 0450	D2x16xL50xSD4			16			11	50	4	A	●
AHMEL 2025L10 0450	D2.5x10xL50xSD4	2.5	2	10	2.4	-	11	50	4	A	●
AHMEL 2025L12 0450	D2.5x12xL50xSD4			12			11	50	4	A	●
AHMEL 2025L16 0450	D2.5x16xL50xSD4			16			11	50	4	A	●
AHMEL 2025L20 0450	D2.5x20xL50xSD4			20			11	50	4	A	●
AHMEL 2030L10 0450	D3x10xL50xSD4	3	2.4	10	2.9	-	11	50	4	A	●
AHMEL 2030L10 0660	D3x10xL60xSD6			10			11	60	6	A	●
AHMEL 2030L12 0450	D3x12xL50xSD4			12			11	50	4	A	●
AHMEL 2030L12 0660	D3x12xL60xSD6			12			11	60	6	A	●
AHMEL 2030L16 0450	D3x16xL50xSD4			16			11	50	4	A	●
AHMEL 2030L16 0660	D3x16xL60xSD6			16			11	60	6	A	●
AHMEL 2030L20 0660	D3x20xL60xSD6			20			11	60	6	A	●
AHMEL 2030L25 0675	D3x25xL75xSD6			25			11	75	6	A	●
AHMEL 2040L12 0660	D4x12xL60xSD6	4	3.2	12	3.9	-	11	60	6	A	●
AHMEL 2040L16 0660	D4x16xL60xSD6			16			11	60	6	A	●
AHMEL 2040L20 0660	D4x20xL60xSD6			20			11	60	6	A	●
AHMEL 2040L25 0675	D4x25xL75xSD6			25			11	75	6	A	●
AHMEL 2040L30 0675	D4x30xL75xSD6			30			11	75	6	A	●

AHMRL 2 刃长颈圆鼻铣刀

AHMRL 2-flute End Mills with Neck Increased & Corner Radius



图A

- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 高精度圆弧角可防止高速切削时崩刃;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision arc angle can prevent chipping during high speed cutting.
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ dc	ϕ dc Tolerance	刃径 ϕ dc	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 4$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号 · Order code												
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径· Ø d1	颈 R·R	柄锥角度· γ°	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHMRL 2002R0.02L0.5 0450	D0.2R0.02x0.5xL50xSD4	0.2	0.02	0.15	0.5	0.18	2	12	50	4	A	●
AHMRL 2002R0.02L1 0450	D0.2R0.02x1xL50xSD4				1			12	50	4	A	●
AHMRL 2002R0.02L1.5 0450	D0.2R0.02x1.5xL50xSD4				1.5			12	50	4	A	●
AHMRL 2002R0.02L2 0450	D0.2R0.02x2xL50xSD4		2		12			50	4	A	●	
AHMRL 2002R0.05L0.5 0450	D0.2R0.05x0.5xL50xSD4		0.5		12			50	4	A	●	
AHMRL 2002R0.05L1 0450	D0.2R0.05x1xL50xSD4		1		12			50	4	A	●	
AHMRL 2002R0.05L1.5 0450	D0.2R0.05x1.5xL50xSD4	0.05		1.5		12	50	4	A	●		
AHMRL 2002R0.05L2 0450	D0.2R0.05x2xL50xSD4			2		12	50	4	A	●		
AHMRL 2003R0.02L1 0450	D0.3R0.02x1xL50xSD4			1		12	50	4	A	●		
AHMRL 2003R0.02L1.5 0450	D0.3R0.02x1.5xL50xSD4	0.3	0.02	0.2	1.5	0.28	2	12	50	4	A	●
AHMRL 2003R0.02L2 0450	D0.3R0.02x2xL50xSD4				2			12	50	4	A	●
AHMRL 2003R0.02L2.5 0450	D0.3R0.02x2.5xL50xSD4				2.5			12	50	4	A	●
AHMRL 2003R0.02L3 0450	D0.3R0.02x3xL50xSD4		3		12			50	4	A	●	
AHMRL 2003R0.05L1 0450	D0.3R0.05x1xL50xSD4		1		12			50	4	A	●	
AHMRL 2003R0.05L1.5 0450	D0.3R0.05x1.5xL50xSD4		1.5		12			50	4	A	●	
AHMRL 2003R0.05L2 0450	D0.3R0.05x2xL50xSD4	0.05		2		12	50	4	A	●		
AHMRL 2003R0.05L2.5 0450	D0.3R0.05x2.5xL50xSD4			2.5	12	50	4	A	●			
AHMRL 2003R0.05L3 0450	D0.3R0.05x3xL50xSD4			3	12	50	4	A	●			
AHMRL 2004R0.02L1 0450	D0.4R0.02x1xL50xSD4	0.4	0.02	0.3	1	0.37	2	12	50	4	A	●
AHMRL 2004R0.02L1.5 0450	D0.4R0.02x1.5xL50xSD4				1.5			12	50	4	A	●
AHMRL 2004R0.02L2 0450	D0.4R0.02x2xL50xSD4				2			12	50	4	A	●
AHMRL 2004R0.02L2.5 0450	D0.4R0.02x2.5xL50xSD4		2.5		12			50	4	A	●	
AHMRL 2004R0.02L3 0450	D0.4R0.02x3xL50xSD4		3		12			50	4	A	●	
AHMRL 2004R0.02L4 0450	D0.4R0.02x4xL50xSD4		4		12			50	4	A	●	
AHMRL 2004R0.05L1 0450	D0.4R0.05x1xL50xSD4	0.05		1		12	50	4	A	●		
AHMRL 2004R0.05L1.5 0450	D0.4R0.05x1.5xL50xSD4			1.5		12	50	4	A	●		

A

B

C

D

E

F

G

H

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刀长·lc	有效长·M	颈径· Ø d1	颈 R·R	柄锥角度·γ°	全长·lo	柄径· ds	图示 Graph	库存 Inventory					
AHMRL 2004R0.05L2 0450	D0.4R0.05x2xL50xSD4	0.4	0.05	0.3	2	0.37	2	12	50	4	A	●					
AHMRL 2004R0.05L2.5 0450	D0.4R0.05x2.5xL50xSD4				2.5			12	50	4	A	●					
AHMRL 2004R0.05L3 0450	D0.4R0.05x3xL50xSD4				3			12	50	4	A	●					
AHMRL 2004R0.05L4 0450	D0.4R0.05x4xL50xSD4		4		12			50	4	A	●						
AHMRL 2004R0.1L1 0450	D0.4R0.1x1xL50xSD4		0.1		1			12	50	4	A	●					
AHMRL 2004R0.1L1.5 0450	D0.4R0.1x1.5xL50xSD4				1.5			12	50	4	A	●					
AHMRL 2004R0.1L2 0450	D0.4R0.1x2xL50xSD4				2			12	50	4	A	●					
AHMRL 2004R0.1L2.5 0450	D0.4R0.1x2.5xL50xSD4				2.5			12	50	4	A	●					
AHMRL 2004R0.1L3 0450	D0.4R0.1x3xL50xSD4				3			12	50	4	A	●					
AHMRL 2004R0.1L4 0450	D0.4R0.1x4xL50xSD4	4		12	50	4	A	●									
AHMRL 2005R0.02L1 0450	D0.5R0.02x1xL50xSD4	0.5	0.02	0.35	1	0.46	2	12	50	4	A	●					
AHMRL 2005R0.02L1.5 0450	D0.5R0.02x1.5xL50xSD4				1.5			12	50	4	A	●					
AHMRL 2005R0.02L2 0450	D0.5R0.02x2xL50xSD4				2			12	50	4	A	●					
AHMRL 2005R0.02L2.5 0450	D0.5R0.02x2.5xL50xSD4				2.5			12	50	4	A	●					
AHMRL 2005R0.02L3 0450	D0.5R0.02x3xL50xSD4				3			12	50	4	A	●					
AHMRL 2005R0.02L4 0450	D0.5R0.02x4xL50xSD4				4			12	50	4	A	●					
AHMRL 2005R0.02L5 0450	D0.5R0.02x5xL50xSD4				5			12	50	4	A	●					
AHMRL 2005R0.02L6 0450	D0.5R0.02x6xL50xSD4				6			12	50	4	A	●					
AHMRL 2005R0.05L1 0450	D0.5R0.05x1xL50xSD4				0.05			1	12	50	4	A	●				
AHMRL 2005R0.05L1.5 0450	D0.5R0.05x1.5xL50xSD4							1.5	12	50	4	A	●				
AHMRL 2005R0.05L2 0450	D0.5R0.05x2xL50xSD4							2	12	50	4	A	●				
AHMRL 2005R0.05L2.5 0450	D0.5R0.05x2.5xL50xSD4							2.5	12	50	4	A	●				
AHMRL 2005R0.05L3 0450	D0.5R0.05x3xL50xSD4		3					12	50	4	A	●					
AHMRL 2005R0.05L4 0450	D0.5R0.05x4xL50xSD4		4					12	50	4	A	●					
AHMRL 2005R0.05L5 0450	D0.5R0.05x5xL50xSD4		5					12	50	4	A	●					
AHMRL 2005R0.05L6 0450	D0.5R0.05x6xL50xSD4		6					12	50	4	A	●					
AHMRL 2005R0.1L1 0450	D0.5R0.1x1xL50xSD4		0.1					1	12	50	4	A	●				
AHMRL 2005R0.1L1.5 0450	D0.5R0.1x1.5xL50xSD4							1.5	12	50	4	A	●				
AHMRL 2005R0.1L2 0450	D0.5R0.1x2xL50xSD4							2	12	50	4	A	●				
AHMRL 2005R0.1L2.5 0450	D0.5R0.1x2.5xL50xSD4							2.5	12	50	4	A	●				
AHMRL 2005R0.1L3 0450	D0.5R0.1x3xL50xSD4				3			12	50	4	A	●					
AHMRL 2005R0.1L4 0450	D0.5R0.1x4xL50xSD4				4			12	50	4	A	●					
AHMRL 2005R0.1L5 0450	D0.5R0.1x5xL50xSD4				5			12	50	4	A	●					
AHMRL 2005R0.1L6 0450	D0.5R0.1x6xL50xSD4				6			12	50	4	A	●					
AHMRL 2006R0.02L2 0450	D0.6R0.02x2xL50xSD4	0.6		0.02	0.45	2	0.56	4	12	50	4	A	●				
AHMRL 2006R0.02L3 0450	D0.6R0.02x3xL50xSD4					3			12	50	4	A	●				
AHMRL 2006R0.02L4 0450	D0.6R0.02x4xL50xSD4					4			12	50	4	A	●				
AHMRL 2006R0.02L6 0450	D0.6R0.02x6xL50xSD4					6			12	50	4	A	●				
AHMRL 2006R0.02L8 0450	D0.6R0.02x8xL50xSD4		8			12			50	4	A	●					
AHMRL 2006R0.02L10 0450	D0.6R0.02x10xL50xSD4		10			12			50	4	A	●					
AHMRL 2006R0.05L2 0450	D0.6R0.05x2xL50xSD4		0.05	2		12			50	4	A	●					
AHMRL 2006R0.05L3 0450	D0.6R0.05x3xL50xSD4			3		12			50	4	A	●					
AHMRL 2006R0.05L4 0450	D0.6R0.05x4xL50xSD4			4		12			50	4	A	●					
AHMRL 2006R0.05L6 0450	D0.6R0.05x6xL50xSD4			6		12			50	4	A	●					
AHMRL 2006R0.05L8 0450	D0.6R0.05x8xL50xSD4			8		12			50	4	A	●					
AHMRL 2006R0.05L10 0450	D0.6R0.05x10xL50xSD4			10		12			50	4	A	●					
AHMRL 2006R0.1L2 0450	D0.6R0.1x2xL50xSD4			0.1		2			12	50	4	A	●				
AHMRL 2006R0.1L3 0450	D0.6R0.1x3xL50xSD4					3			12	50	4	A	●				
AHMRL 2006R0.1L4 0450	D0.6R0.1x4xL50xSD4					4			12	50	4	A	●				
AHMRL 2006R0.1L6 0450	D0.6R0.1x6xL50xSD4					6			12	50	4	A	●				
AHMRL 2006R0.1L8 0450	D0.6R0.1x8xL50xSD4					8			12	50	4	A	●				
AHMRL 2006R0.1L10 0450	D0.6R0.1x10xL50xSD4					10			12	50	4	A	●				
AHMRL 2007R0.02L2 0450	D0.7R0.02x2xL50xSD4		0.7			0.02			0.5	2	0.66	4	12	50	4	A	●
AHMRL 2007R0.02L3 0450	D0.7R0.02x3xL50xSD4									3			12	50	4	A	●
AHMRL 2007R0.02L4 0450	D0.7R0.02x4xL50xSD4			4						12			50	4	A	●	
AHMRL 2007R0.02L6 0450	D0.7R0.02x6xL50xSD4			6						12			50	4	A	●	
AHMRL 2007R0.02L8 0450	D0.7R0.02x8xL50xSD4			8						12			50	4	A	●	
AHMRL 2007R0.02L10 0450	D0.7R0.02x10xL50xSD4			10						12			50	4	A	●	
AHMRL 2007R0.05L2 0450	D0.7R0.05x2xL50xSD4	0.05		2	12	50	4	A		●							
AHMRL 2007R0.05L3 0450	D0.7R0.05x3xL50xSD4			3	12	50	4	A		●							

订货编号·Order code													
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径· Ø d1	颈 R·R	柄锥角度·γ°	全长·lo	柄径·ds	图示 Graph	库存 Inventory	
AHMRL 2007R0.05L4 0450	D0.7R0.05x4xL50xSD4	0.7	0.05	0.5	4	0.66	4	12	50	4	A	●	
AHMRL 2007R0.05L6 0450	D0.7R0.05x6xL50xSD4				6			12	50	4	A	●	
AHMRL 2007R0.05L8 0450	D0.7R0.05x8xL50xSD4				8			12	50	4	A	●	
AHMRL 2007R0.05L10 0450	D0.7R0.05x10xL50xSD4		10		12			50	4	A	●		
AHMRL 2007R0.1L2 0450	D0.7R0.1x2xL50xSD4		2		12			50	4	A	●		
AHMRL 2007R0.1L3 0450	D0.7R0.1x3xL50xSD4		3		12			50	4	A	●		
AHMRL 2007R0.1L4 0450	D0.7R0.1x4xL50xSD4		4		12			50	4	A	●		
AHMRL 2007R0.1L6 0450	D0.7R0.1x6xL50xSD4		6		12			50	4	A	●		
AHMRL 2007R0.1L8 0450	D0.7R0.1x8xL50xSD4		8		12			50	4	A	●		
AHMRL 2007R0.1L10 0450	D0.7R0.1x10xL50xSD4		10		12			50	4	A	●		
AHMRL 2008R0.02L2 0450	D0.8R0.02x2xL50xSD4	0.8	0.02	0.6	2	0.76	4	12	50	4	A	●	
AHMRL 2008R0.02L3 0450	D0.8R0.02x3xL50xSD4				3			12	50	4	A	●	
AHMRL 2008R0.02L4 0450	D0.8R0.02x4xL50xSD4				4			12	50	4	A	●	
AHMRL 2008R0.02L6 0450	D0.8R0.02x6xL50xSD4				6			12	50	4	A	●	
AHMRL 2008R0.02L8 0450	D0.8R0.02x8xL50xSD4				8			12	50	4	A	●	
AHMRL 2008R0.02L10 0450	D0.8R0.02x10xL50xSD4				10			12	50	4	A	●	
AHMRL 2008R0.02L12 0450	D0.8R0.02x12xL50xSD4				12			12	50	4	A	●	
AHMRL 2008R0.05L2 0450	D0.8R0.05x2xL50xSD4		0.05		2			12	50	4	A	●	
AHMRL 2008R0.05L3 0450	D0.8R0.05x3xL50xSD4				3			12	50	4	A	●	
AHMRL 2008R0.05L4 0450	D0.8R0.05x4xL50xSD4				4			12	50	4	A	●	
AHMRL 2008R0.05L6 0450	D0.8R0.05x6xL50xSD4				6			12	50	4	A	●	
AHMRL 2008R0.05L8 0450	D0.8R0.05x8xL50xSD4				8			12	50	4	A	●	
AHMRL 2008R0.05L10 0450	D0.8R0.05x10xL50xSD4				10			12	50	4	A	●	
AHMRL 2008R0.05L12 0450	D0.8R0.05x12xL50xSD4				12			12	50	4	A	●	
AHMRL 2008R0.1L2 0450	D0.8R0.1x2xL50xSD4		0.1		2			12	50	4	A	●	
AHMRL 2008R0.1L3 0450	D0.8R0.1x3xL50xSD4				3			12	50	4	A	●	
AHMRL 2008R0.1L4 0450	D0.8R0.1x4xL50xSD4				4			12	50	4	A	●	
AHMRL 2008R0.1L6 0450	D0.8R0.1x6xL50xSD4				6			12	50	4	A	●	
AHMRL 2008R0.1L8 0450	D0.8R0.1x8xL50xSD4				8			12	50	4	A	●	
AHMRL 2008R0.1L10 0450	D0.8R0.1x10xL50xSD4				10			12	50	4	A	●	
AHMRL 2008R0.1L12 0450	D0.8R0.1x12xL50xSD4				12			12	50	4	A	●	
AHMRL 2008R0.2L2 0450	D0.8R0.2x2xL50xSD4		0.2		2			12	50	4	A	●	
AHMRL 2008R0.2L3 0450	D0.8R0.2x3xL50xSD4				3			12	50	4	A	●	
AHMRL 2008R0.2L4 0450	D0.8R0.2x4xL50xSD4				4			12	50	4	A	●	
AHMRL 2008R0.2L6 0450	D0.8R0.2x6xL50xSD4				6			12	50	4	A	●	
AHMRL 2008R0.2L8 0450	D0.8R0.2x8xL50xSD4				8			12	50	4	A	●	
AHMRL 2008R0.2L10 0450	D0.8R0.2x10xL50xSD4				10			12	50	4	A	●	
AHMRL 2008R0.2L12 0450	D0.8R0.2x12xL50xSD4				12			12	50	4	A	●	
AHMRL 2009R0.1L4 0450	D0.9R0.1x4xL50xSD4	0.9	0.1	0.65	4	0.86	4	12	50	4	A	●	
AHMRL 2009R0.1L8 0450	D0.9R0.1x8xL50xSD4				8			12	50	4	A	●	
AHMRL 2010R0.05L3 0450	D1R0.05x3xL50xSD4	1	0.05	0.75	3	0.95	4	12	50	4	A	●	
AHMRL 2010R0.05L4 0450	D1R0.05x4xL50xSD4				4			12	50	4	A	●	
AHMRL 2010R0.05L5 0450	D1R0.05x5xL50xSD4				5			12	60	4	A	●	
AHMRL 2010R0.05L6 0450	D1R0.05x6xL50xSD4				6			12	50	4	A	●	
AHMRL 2010R0.05L8 0450	D1R0.05x8xL50xSD4				8			12	50	4	A	●	
AHMRL 2010R0.05L10 0450	D1R0.05x10xL50xSD4				10			12	50	4	A	●	
AHMRL 2010R0.05L12 0450	D1R0.05x12xL50xSD4				12			12	50	4	A	●	
AHMRL 2010R0.05L16 0450	D1R0.05x16xL50xSD4				16			12	50	4	A	●	
AHMRL 2010R0.05L20 0460	D1R0.05x20xL60xSD4				20			12	60	4	A	●	
AHMRL 2010R0.1L3 0450	D1R0.1x3xL50xSD4		0.1		3			12	50	4	A	●	
AHMRL 2010R0.1L4 0450	D1R0.1x4xL50xSD4				4			12	50	4	A	●	
AHMRL 2010R0.1L5 0450	D1R0.1x5xL50xSD4				5			12	50	4	A	●	
AHMRL 2010R0.1L6 0450	D1R0.1x6xL50xSD4				6			12	50	4	A	●	
AHMRL 2010R0.1L8 0450	D1R0.1x8xL50xSD4				8			12	50	4	A	●	
AHMRL 2010R0.1L10 0450	D1R0.1x10xL50xSD4				10			12	50	4	A	●	
AHMRL 2010R0.1L12 0450	D1R0.1x12xL50xSD4				12			12	50	4	A	●	
AHMRL 2010R0.1L16 0450	D1R0.1x16xL50xSD4				16			12	50	4	A	●	
AHMRL 2010R0.1L20 0460	D1R0.1x20xL60xSD4				20			12	60	4	A	●	
AHMRL 2010R0.2L3 0450	D1R0.2x3xL50xSD4		0.2		3			12	50	4	A	●	
AHMRL 2010R0.2L4 0450	D1R0.2x4xL50xSD4				4			12	50	4	A	●	

A

B

C

D

E

F

G

H

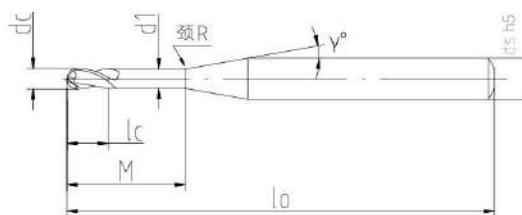
订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刀长·lc	有效长·M	颈径· Ø d1	颈 R·R	柄锥角度· γ /°	全长·lo	柄径· ds	图示 Graph	库存 Inventory	
AHMRL 2010R0.2L5 0450	D1R0.2x5xL50xSD4	1	0.2	0.75	5	0.95	4	12	50	4	A	●	
AHMRL 2010R0.2L6 0450	D1R0.2x6xL50xSD4				6			12	50	4	A	●	
AHMRL 2010R0.2L8 0450	D1R0.2x8xL50xSD4				8			12	50	4	A	●	
AHMRL 2010R0.2L10 0450	D1R0.2x10xL50xSD4				10			12	50	4	A	●	
AHMRL 2010R0.2L12 0450	D1R0.2x12xL50xSD4				12			12	50	4	A	●	
AHMRL 2010R0.2L16 0450	D1R0.2x16xL50xSD4				16			12	50	4	A	●	
AHMRL 2010R0.2L20 0460	D1R0.2x20xL60xSD4				20			12	60	4	A	●	
AHMRL 2010R0.3L3 0450	D1R0.3x3xL50xSD4		0.3		3			12	50	4	A	●	
AHMRL 2010R0.3L4 0450	D1R0.3x4xL50xSD4				4			12	50	4	A	●	
AHMRL 2010R0.3L5 0450	D1R0.3x5xL50xSD4				5			12	50	4	A	●	
AHMRL 2010R0.3L6 0450	D1R0.3x6xL50xSD4				6			12	50	4	A	●	
AHMRL 2010R0.3L8 0450	D1R0.3x8xL50xSD4				8			12	50	4	A	●	
AHMRL 2010R0.3L10 0450	D1R0.3x10xL50xSD4				10			12	50	4	A	●	
AHMRL 2010R0.3L12 0450	D1R0.3x12xL50xSD4				12			12	50	4	A	●	
AHMRL 2010R0.3L16 0450	D1R0.3x16xL50xSD4				16			12	50	4	A	●	
AHMRL 2010R0.3L20 0460	D1R0.3x20xL60xSD4				20			12	60	4	A	●	
AHMRL 2015R0.1L6 0450	D1.5R0.1x6xL50xSD4	1.5	0.1	1.2	6	1.42	-	11	50	4	A	●	
AHMRL 2015R0.1L8 0450	D1.5R0.1x8xL50xSD4				8			11	50	4	A	●	
AHMRL 2015R0.1L10 0450	D1.5R0.1x10xL50xSD4				10			11	50	4	A	●	
AHMRL 2015R0.1L12 0450	D1.5R0.1x12xL50xSD4				12			11	50	4	A	●	
AHMRL 2015R0.2L6 0450	D1.5R0.2x6xL50xSD4		0.2		6			11	50	4	A	●	
AHMRL 2015R0.2L8 0450	D1.5R0.2x8xL50xSD4				8			11	50	4	A	●	
AHMRL 2015R0.2L10 0450	D1.5R0.2x10xL50xSD4				10			11	50	4	A	●	
AHMRL 2015R0.2L12 0450	D1.5R0.2x12xL50xSD4				12			11	50	4	A	●	
AHMRL 2020R0.1L8 0450	D2R0.1x8xL50xSD4	2	0.1	1.6	8	1.9	-	11	50	4	A	●	
AHMRL 2020R0.1L10 0450	D2R0.1x10xL50xSD4				10			11	50	4	A	●	
AHMRL 2020R0.1L12 0450	D2R0.1x12xL50xSD4				12			11	50	4	A	●	
AHMRL 2020R0.1L16 0450	D2R0.1x16xL50xSD4				16			11	50	4	A	●	
AHMRL 2020R0.2L8 0450	D2R0.2x8xL50xSD4		0.2		8			11	50	4	A	●	
AHMRL 2020R0.2L10 0450	D2R0.2x10xL50xSD4				10			11	50	4	A	●	
AHMRL 2020R0.2L12 0450	D2R0.2x12xL50xSD4				12			11	50	4	A	●	
AHMRL 2020R0.2L16 0450	D2R0.2x16xL50xSD4				16			11	50	4	A	●	
AHMRL 2020R0.5L8 0450	D2R0.5x8xL50xSD4		0.5		8			11	50	4	A	●	
AHMRL 2020R0.5L10 0450	D2R0.5x10xL50xSD4				10			11	50	4	A	●	
AHMRL 2020R0.5L12 0450	D2R0.5x12xL50xSD4				12			11	50	4	A	●	
AHMRL 2020R0.5L16 0450	D2R0.5x16xL50xSD4				16			11	50	4	A	●	
AHMRL 2030R0.1L10 0450	D3R0.1x10xL50xSD4	3	0.1	2.4	10	2.9	-	11	50	4	A	●	
AHMRL 2030R0.1L10 0660	D3R0.1x10xL60xSD6				10			11	60	6	A	●	
AHMRL 2030R0.1L12 0450	D3R0.1x12xL50xSD4				12			11	50	4	A	●	
AHMRL 2030R0.1L12 0660	D3R0.1x12xL60xSD6				12			11	60	6	A	●	
AHMRL 2030R0.1L16 0450	D3R0.1x16xL50xSD4				16			11	50	4	A	●	
AHMRL 2030R0.1L16 0660	D3R0.1x16xL60xSD6				16			11	60	6	A	●	
AHMRL 2030R0.1L20 0660	D3R0.1x20xL60xSD6				20			11	60	6	A	●	
AHMRL 2030R0.1L25 0675	D3R0.1x25xL75xSD6				25			11	75	6	A	●	
AHMRL 2030R0.2L10 0450	D3R0.2x10xL50xSD4		0.2		10			11	50	4	A	●	
AHMRL 2030R0.2L10 0660	D3R0.2x10xL60xSD6				10			11	60	6	A	●	
AHMRL 2030R0.2L12 0450	D3R0.2x12xL50xSD4				12			11	50	4	A	●	
AHMRL 2030R0.2L12 0660	D3R0.2x12xL60xSD6				12			11	60	6	A	●	
AHMRL 2030R0.2L16 0450	D3R0.2x16xL50xSD4				16			11	50	4	A	●	
AHMRL 2030R0.2L16 0660	D3R0.2x16xL60xSD6				16			11	60	6	A	●	
AHMRL 2030R0.2L20 0660	D3R0.2x20xL60xSD6				20			11	60	6	A	●	
AHMRL 2030R0.2L25 0675	D3R0.2x25xL75xSD6				25			11	75	6	A	●	
AHMRL 2030R0.5L10 0450	D3R0.5x10xL50xSD4		0.5		10			11	50	4	A	●	
AHMRL 2030R0.5L10 0660	D3R0.5x10xL60xSD6				10			11	60	6	A	●	
AHMRL 2030R0.5L12 0450	D3R0.5x12xL50xSD4				12			11	50	4	A	●	
AHMRL 2030R0.5L12 0660	D3R0.5x12xL60xSD6				12			11	60	6	A	●	
AHMRL 2030R0.5L16 0660	D3R0.5x16xL60xSD6				16			11	60	6	A	●	
AHMRL 2030R0.5L16 0450	D3R0.5x16xL50xSD4				16			11	50	4	A	●	
AHMRL 2030R0.5L20 0660	D3R0.5x20xL60xSD6				20			11	60	6	A	●	
AHMRL 2030R0.5L25 0675	D3R0.5x25xL75xSD6				25			11	75	6	A	●	
AHMRL 2040R0.1L12 0660	D4R0.1x12xL60xSD6	4	0.1	3.9	12	3.9	-	11	60	6	A	●	
AHMRL 2040R0.1L16 0660	D4R0.1x16xL60xSD6				16			11	60	6	A	●	

订货编号·Order code													
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径· ∅ d1	颈 R·R	柄锥角度·γ/°	全长·lo	柄径·ds	图示 Graph	库存 Inventory	
AHMRL 2040R0.1L20 0660	D4R0.1x20xL60xSD6	4	0.1	3.2	20	3.9	-	11	60	6	A	●	
AHMRL 2040R0.1L25 0675	D4R0.1x25xL75xSD6				25			11	75	6	A	●	
AHMRL 2040R0.1L30 0675	D4R0.1x30xL75xSD6				30			11	75	6	A	●	
AHMRL 2040R0.2L12 0660	D4R0.2x12xL60xSD6		0.2		12			11	60	6	A	●	
AHMRL 2040R0.2L16 0660	D4R0.2x16xL60xSD6				16			11	60	6	A	●	
AHMRL 2040R0.2L20 0660	D4R0.2x20xL60xSD6				20			11	60	6	A	●	
AHMRL 2040R0.2L25 0675	D4R0.2x25xL75xSD6				25			11	75	6	A	●	
AHMRL 2040R0.2L30 0675	D4R0.2x30xL75xSD6				30			11	75	6	A	●	
AHMRL 2040R0.5L12 0660	D4R0.5x12xL60xSD6		0.5		12			11	60	6	A	●	
AHMRL 2040R0.5L16 0660	D4R0.5x16xL60xSD6				16			11	60	6	A	●	
AHMRL 2040R0.5L20 0660	D4R0.5x20xL60xSD6				20			11	60	6	A	●	
AHMRL 2040R0.5L25 0675	D4R0.5x25xL75xSD6				25			11	75	6	A	●	
AHMRL 2040R0.5L30 0675	D4R0.5x30xL75xSD6				30			11	75	6	A	●	
AHMRL 2040R1.0L12 0660	D4R1x12xL60xSD6		1.0		12			11	60	6	A	●	
AHMRL 2040R1.0L16 0660	D4R1x16xL60xSD6				16			11	60	6	A	●	
AHMRL 2040R1.0L20 0660	D4R1x20xL60xSD6				20			11	60	6	A	●	
AHMRL 2040R1.0L25 0675	D4R1x25xL75xSD6				25			11	75	6	A	●	
AHMRL 2040R1.0L30 0675	D4R1x30xL75xSD6				30			11	75	6	A	●	

AHMBL 2 刃长颈球头铣刀

AHMBL 2-flute Ballnose End Mills with Neck Increased



图A

- 专为加工 HRC ≤ 52 以下材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合, 干湿加工均能发挥卓越性能;
- 卓越的工件表面粗糙度;
- 高精度球头为精加工铣削设计;
- 采用极细晶粒度的刀具材料, 兼顾韧性与耐磨性;
- Designed for machining HRC≤52 materials;
- Newly-developed coating has excellent oxidation resistance, red hardness and outstanding wear resistance combined with toughness. It's suitable for dry cutting or micro-lubricated high speed cutting;
- Excellent surface roughness of the workpiece;
- High precision ball-end is designed for finishing milling;
- Adopting extremely small grain size for tool materials, taking into account both toughness and wear resistance;

刃径 ϕ_{dc}	ϕ_{dc} Tolerance	刃径 ϕ_{dc}	R Tolerance
$\phi \leq 3$	0 ~ -0.010	$\phi \leq 5$	± 0.005
$3 < \phi \leq 6$	0 ~ -0.012		

碳钢、合金钢 ($< \text{HRC}30$)	铸铁	工具钢, 预硬钢 ($\leq \text{HRC}45$)	高硬度钢 ($\leq \text{HRC}60$)	高硬度钢 ($> \text{HRC}60$)	马氏体不锈钢	铜合金
◎	○	◎	○		○	○

订货编号·Order code

代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径· ϕ_{d1}	颈 R·R	柄锥角度· γ°	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHMBL 2001L0.2 0450	D0.1R0.05x0.2xL50xSD4	0.1	0.05	0.07	0.2	0.085	2	12	50	4	A	●
AHMBL 2001L0.3 0450	D0.1R0.05x0.3xL50xSD4				0.3				50	4	A	●
AHMBL 2001L0.5 0450	D0.1R0.05x0.5xL50xSD4				0.5				50	4	A	●
AHMBL 2001L0.75 0450	D0.1R0.05x0.75xL50xSD4				0.75				50	4	A	●
AHMBL 2001L1 0450	D0.1R0.05x1xL50xSD4				1				50	4	A	●
AHMBL 20015L0.3 0450	D0.15R0.075x0.3xL50xSD4	0.15	0.075	0.1	0.3	0.13	2	12	50	4	A	●
AHMBL 20015L0.5 0450	D0.15R0.075x0.5xL50xSD4				0.5				50	4	A	●
AHMBL 20015L0.75 0450	D0.15R0.075x0.75xL50xSD4				0.75				50	4	A	●
AHMBL 20015L1 0450	D0.15R0.075x1xL50xSD4				1				50	4	A	●
AHMBL 20015L1.5 0450	D0.15R0.075x1.5xL50xSD4				1.5				50	4	A	●
AHMBL 2002L0.3 0450	D0.2R0.1x0.3xL50xSD4	0.2	0.1	0.15	0.3	0.18	2	12	50	4	A	●
AHMBL 2002L0.5 0450	D0.2R0.1x0.5xL50xSD4				0.5				50	4	A	●
AHMBL 2002L0.75 0450	D0.2R0.1x0.75xL50xSD4				0.75				50	4	A	●
AHMBL 2002L1 0450	D0.2R0.1x1xL50xSD4				1				50	4	A	●
AHMBL 2002L1.25 0450	D0.2R0.1x1.25xL50xSD4				1.25				50	4	A	●
AHMBL 2002L1.5 0450	D0.2R0.1x1.5xL50xSD4				1.5				50	4	A	●
AHMBL 2002L1.75 0450	D0.2R0.1x1.75xL50xSD4				1.75				50	4	A	●
AHMBL 2002L2 0450	D0.2R0.1x2xL50xSD4				2				50	4	A	●
AHMBL 2002L2.5 0450	D0.2R0.1x2.5xL50xSD4				2.5				50	4	A	●
AHMBL 2002L3 0450	D0.2R0.1x3xL50xSD4				3				50	4	A	●
AHMBL 2003L0.5 0450	D0.3R0.15x0.5xL50xSD4	0.3	0.15	0.2	0.5	0.28	2	12	50	4	A	●
AHMBL 2003L0.6 0450	D0.3R0.15x0.6xL50xSD4				0.6				50	4	A	●
AHMBL 2003L0.75 0450	D0.3R0.15x0.75xL50xSD4				0.75				50	4	A	●
AHMBL 2003L1 0450	D0.3R0.15x1xL50xSD4				1				50	4	A	●
AHMBL 2003L1.25 0450	D0.3R0.15x1.25xL50xSD4				1.25				50	4	A	●

订货编号·Order code												
代码 Code	规格型号 Designation	刀径·ds	圆角半径·R	刀长·lc	有效长·M	颈径· Ø d1	颈 R·R	柄锥角度·γ/°	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHMBL 2003L1.5 0450	D0.3R0.15x1.5xL50xSD4	0.3	0.15	0.2	1.5	0.28	2	12	50	4	A	●
AHMBL 2003L1.75 0450	D0.3R0.15x1.75xL50xSD4				1.75			12	50	4	A	●
AHMBL 2003L2 0450	D0.3R0.15x2xL50xSD4				2			12	50	4	A	●
AHMBL 2003L2.25 0450	D0.3R0.15x2.25xL50xSD4				2.25			12	50	4	A	●
AHMBL 2003L2.5 0450	D0.3R0.15x2.5xL50xSD4				2.5			12	50	4	A	●
AHMBL 2003L3 0450	D0.3R0.15x3xL50xSD4				3			12	50	4	A	●
AHMBL 2003L3.5 0450	D0.3R0.15x3.5xL50xSD4				3.5			12	50	4	A	●
AHMBL 2003L4 0450	D0.3R0.15x4xL50xSD4				4			12	50	4	A	●
AHMBL 2004L0.5 0450	D0.4R0.2x0.5xL50xSD4	0.4	0.2	0.3	0.5	0.37	2	12	50	4	A	●
AHMBL 2004L0.8 0450	D0.4R0.2x0.8xL50xSD4				0.8			12	50	4	A	●
AHMBL 2004L1 0450	D0.4R0.2x1xL50xSD4				1			12	50	4	A	●
AHMBL 2004L1.5 0450	D0.4R0.2x1.5xL50xSD4				1.5			12	50	4	A	●
AHMBL 2004L2 0450	D0.4R0.2x2xL50xSD4				2			12	50	4	A	●
AHMBL 2004L2.5 0450	D0.4R0.2x2.5xL50xSD4				2.5			12	50	4	A	●
AHMBL 2004L3 0450	D0.4R0.2x3xL50xSD4				3			12	50	4	A	●
AHMBL 2004L3.5 0450	D0.4R0.2x3.5xL50xSD4				3.5			12	50	4	A	●
AHMBL 2004L4 0450	D0.4R0.2x4xL50xSD4				4			12	50	4	A	●
AHMBL 2004L4.5 0450	D0.4R0.2x4.5xL50xSD4				4.5			12	50	4	A	●
AHMBL 2004L5 0450	D0.4R0.2x5xL50xSD4				5			12	50	4	A	●
AHMBL 2004L6 0450	D0.4R0.2x6xL50xSD4				6			12	50	4	A	●
AHMBL 2004L8 0450	D0.4R0.2x8xL50xSD4				8			12	50	4	A	●
AHMBL 2005L1 0450	D0.5R0.25x1xL50xSD4	0.5	0.25	0.35	1	0.46	4	12	50	4	A	●
AHMBL 2005L1.5 0450	D0.5R0.25x1.5xL50xSD4				1.5			12	50	4	A	●
AHMBL 2005L2 0450	D0.5R0.25x2xL50xSD4				2			12	50	4	A	●
AHMBL 2005L2.5 0450	D0.5R0.25x2.5xL50xSD4				2.5			12	50	4	A	●
AHMBL 2005L3 0450	D0.5R0.25x3xL50xSD4				3			12	50	4	A	●
AHMBL 2005L3.5 0450	D0.5R0.25x3.5xL50xSD4				3.5			12	50	4	A	●
AHMBL 2005L4 0450	D0.5R0.25x4xL50xSD4				4			12	50	4	A	●
AHMBL 2005L4.5 0450	D0.5R0.25x4.5xL50xSD4				4.5			12	50	4	A	●
AHMBL 2005L5 0450	D0.5R0.25x5xL50xSD4				5			12	50	4	A	●
AHMBL 2005L5.5 0450	D0.5R0.25x5.5xL50xSD4				5.5			12	50	4	A	●
AHMBL 2005L6 0450	D0.5R0.25x6xL50xSD4				6			12	50	4	A	●
AHMBL 2005L8 0450	D0.5R0.25x8xL50xSD4				8			12	50	4	A	●
AHMBL 2005L10 0450	D0.5R0.25x10xL50xSD4				10			12	50	4	A	●
AHMBL 2006L1 0450	D0.6R0.3x1xL50xSD4	0.6	0.3	0.45	1	0.56	4	12	50	4	A	●
AHMBL 2006L1.5 0450	D0.6R0.3x1.5xL50xSD4				1.5			12	50	4	A	●
AHMBL 2006L2 0450	D0.6R0.3x2xL50xSD4				2			12	50	4	A	●
AHMBL 2006L2.5 0450	D0.6R0.3x2.5xL50xSD4				2.5			12	50	4	A	●
AHMBL 2006L3 0450	D0.6R0.3x3xL50xSD4				3			12	50	4	A	●
AHMBL 2006L3.5 0450	D0.6R0.3x3.5xL50xSD4				3.5			12	50	4	A	●
AHMBL 2006L4 0450	D0.6R0.3x4xL50xSD4				4			12	50	4	A	●
AHMBL 2006L4.5 0450	D0.6R0.3x4.5xL50xSD4				4.5			12	50	4	A	●
AHMBL 2006L5 0450	D0.6R0.3x5xL50xSD4				5			12	50	4	A	●
AHMBL 2006L5.5 0450	D0.6R0.3x5.5xL50xSD4				5.5			12	50	4	A	●
AHMBL 2006L6 0450	D0.6R0.3x6xL50xSD4				6			12	50	4	A	●
AHMBL 2006L7 0450	D0.6R0.3x7xL50xSD4				7			12	50	4	A	●
AHMBL 2006L8 0450	D0.6R0.3x8xL50xSD4				8			12	50	4	A	●
AHMBL 2006L9 0450	D0.6R0.3x9xL50xSD4				9			12	50	4	A	●
AHMBL 2006L10 0450	D0.6R0.3x10xL50xSD4				10			12	50	4	A	●
AHMBL 2006L12 0450	D0.6R0.3x12xL50xSD4				12			12	50	4	A	●
AHMBL 2007L2 0450	D0.7R0.35x2xL50xSD4	0.7	0.35	0.5	2	0.66	4	12	50	4	A	●
AHMBL 2007L3 0450	D0.7R0.35x3xL50xSD4				3			12	50	4	A	●
AHMBL 2007L4 0450	D0.7R0.35x4xL50xSD4				4			12	50	4	A	●
AHMBL 2007L6 0450	D0.7R0.35x6xL50xSD4				6			12	50	4	A	●
AHMBL 2007L8 0450	D0.7R0.35x8xL50xSD4				8			12	50	4	A	●
AHMBL 2008L2 0450	D0.8R0.4x2xL50xSD4	0.8	0.4	0.6	2	0.76	4	12	50	4	A	●
AHMBL 2008L2.5 0450	D0.8R0.4x2.5xL50xSD4				2.5			12	50	4	A	●
AHMBL 2008L3 0450	D0.8R0.4x3xL50xSD4				3			12	50	4	A	●
AHMBL 2008L4 0450	D0.8R0.4x4xL50xSD4				4			12	50	4	A	●
AHMBL 2008L5 0450	D0.8R0.4x5xL50xSD4				5			12	50	4	A	●

A

B

C

D

E

F

G

H

订货编号·Order code

代码 Code	规格型号 Designation	刀径·ds	圆角半径·R	刃长·lc	有效长·M	颈径· $\varnothing$ d1	颈 R·R	柄锥角度· γ / °	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHMBL 2008L6 0450	D0.8R0.4x6xL50xSD4	0.8	0.4	0.6	6	0.76	4	12	50	4	A	●
AHMBL 2008L7 0450	D0.8R0.4x7xL50xSD4				7			12	50	4	A	●
AHMBL 2008L8 0450	D0.8R0.4x8xL50xSD4				8			12	50	4	A	●
AHMBL 2008L10 0450	D0.8R0.4x10xL50xSD4				10			12	50	4	A	●
AHMBL 2008L12 0450	D0.8R0.4x12xL50xSD4				12			12	50	4	A	●
AHMBL 2008L16 0450	D0.8R0.4x16xL50xSD4				16			12	50	4	A	●
AHMBL 2009L2 0450	D0.9R0.45x2xL50xSD4	0.9	0.45	0.65	2	0.86	4	12	50	4	A	●
AHMBL 2009L4 0450	D0.9R0.45x4xL50xSD4				4			12	50	4	A	●
AHMBL 2009L6 0450	D0.9R0.45x6xL50xSD4				6			12	50	4	A	●
AHMBL 2009L8 0450	D0.9R0.45x8xL50xSD4				8			12	50	4	A	●
AHMBL 2010L2.5 0450	D1R0.5x2.5xL50xSD4	1	0.5	0.75	2.5	0.95	4	12	50	4	A	●
AHMBL 2010L3 0450	D1R0.5x3xL50xSD4				3			12	50	4	A	●
AHMBL 2010L4 0450	D1R0.5x4xL50xSD4				4			12	50	4	A	●
AHMBL 2010L4 0660	D1R0.5x4xL60xSD6				4			12	60	6	A	●
AHMBL 2010L5 0450	D1R0.5x5xL50xSD4				5			12	50	4	A	●
AHMBL 2010L6 0450	D1R0.5x6xL50xSD4				6			12	50	4	A	●
AHMBL 2010L6 0660	D1R0.5x6xL60xSD6				6			12	60	6	A	●
AHMBL 2010L7 0450	D1R0.5x7xL50xSD4				7			12	50	4	A	●
AHMBL 2010L8 0450	D1R0.5x8xL50xSD4				8			12	50	4	A	●
AHMBL 2010L8 0660	D1R0.5x8xL60xSD6				8			12	60	6	A	●
AHMBL 2010L9 0450	D1R0.5x9xL50xSD4				9			12	50	4	A	●
AHMBL 2010L10 0450	D1R0.5x10xL50xSD4				10			12	50	4	A	●
AHMBL 2010L10 0660	D1R0.5x10xL60xSD6				10			12	60	6	A	●
AHMBL 2010L12 0450	D1R0.5x12xL50xSD4				12			12	50	4	A	●
AHMBL 2010L14 0450	D1R0.5x14xL50xSD4				14			12	50	4	A	●
AHMBL 2010L16 0450	D1R0.5x16xL50xSD4				16			12	50	4	A	●
AHMBL 2010L18 0460	D1R0.5x18xL60xSD4				18			12	60	4	A	●
AHMBL 2010L20 0460	D1R0.5x20xL60xSD4				20			12	60	4	A	●
AHMBL 2010L22 0460	D1R0.5x22xL60xSD4				22			12	60	4	A	●
AHMBL 2015L6 0450	D1.5R0.75x6xL50xSD4	1.5	0.75	1.2	6	1.42	-	11	50	4	A	●
AHMBL 2015L6 0660	D1.5R0.75x6xL60xSD6				6			11	60	6	A	●
AHMBL 2015L8 0450	D1.5R0.75x8xL50xSD4				8			11	50	4	A	●
AHMBL 2015L8 0660	D1.5R0.75x8xL60xSD6				8			11	60	6	A	●
AHMBL 2015L10 0450	D1.5R0.75x10xL50xSD4				10			11	50	4	A	●
AHMBL 2015L10 0660	D1.5R0.75x10xL60xSD6				10			11	60	6	A	●
AHMBL 2015L12 0450	D1.5R0.75x12xL50xSD4	2	1	1.6	12	1.9	-	11	50	4	A	●
AHMBL 2015L12 0660	D1.5R0.75x12xL60xSD6				12			11	60	6	A	●
AHMBL 2020L6 0450	D2R1x6xL50xSD4				6			11	50	4	A	●
AHMBL 2020L8 0450	D2R1x8xL50xSD4				8			11	50	4	A	●
AHMBL 2020L8 0660	D2R1x8xL60xSD6				8			11	60	6	A	●
AHMBL 2020L10 0450	D2R1x10xL50xSD4				10			11	50	4	A	●
AHMBL 2020L10 0660	D2R1x10xL60xSD6	2.5	1.25	2	10	2.4	-	11	60	6	A	●
AHMBL 2020L12 0450	D2R1x12xL50xSD4				12			11	50	4	A	●
AHMBL 2020L12 0660	D2R1x12xL60xSD6				12			11	60	6	A	●
AHMBL 2020L16 0450	D2R1x16xL50xSD4				16			11	50	4	A	●
AHMBL 2020L16 0660	D2R1x16xL60xSD6				16			11	60	6	A	●
AHMBL 2025L8 0450	D2.5R1.25x8xL50xSD4				8	2.9	-	11	50	4	A	●
AHMBL 2025L10 0450	D2.5R1.25x10xL50xSD4	3	1.5	2.4	10			11	60	6	A	●
AHMBL 2025L12 0450	D2.5R1.25x12xL50xSD4				12			11	50	4	A	●
AHMBL 2025L16 0450	D2.5R1.25x16xL50xSD4				16			11	50	4	A	●
AHMBL 2030L10 0450	D3R1.5x10xL50xSD4	4	2	3.2	10	3.9	-	11	50	4	A	●
AHMBL 2030L10 0660	D3R1.5x10xL60xSD6				10			11	60	6	A	●
AHMBL 2030L12 0450	D3R1.5x12xL50xSD4				12			11	50	4	A	●
AHMBL 2030L12 0660	D3R1.5x12xL60xSD6				12			11	60	6	A	●
AHMBL 2030L16 0450	D3R1.5x16xL50xSD4				16			11	50	4	A	●
AHMBL 2030L16 0660	D3R1.5x16xL60xSD6				16			11	60	6	A	●
AHMBL 2030L20 0660	D3R1.5x20xL60xSD6				20			11	60	6	A	●
AHMBL 2030L25 0675	D3R1.5x25xL75xSD6				25			11	75	6	A	●
AHMBL 2040L12 0660	D4R2x12xL60xSD6	4	2	3.2	12	-	-	11	60	6	A	●
AHMBL 2040L16 0660	D4R2x16xL60xSD6				16			11	60	6	A	●
AHMBL 2040L20 0660	D4R2x20xL60xSD6				20			11	60	6	A	●
AHMBL 2040L25 0675	D4R2x25xL75xSD6				25			11	75	6	A	●

订货编号·Order code												
代码 Code	规格型号 Designation	刃径·ds	圆角半径·R	刃长·lc	有效长·M	颈径· ∅ d1	颈 R·R	柄锥角度· $\gamma/^\circ$	全长·lo	柄径·ds	图示 Graph	库存 Inventory
AHMBL 2040L30 0675	D4R2x30xL75xSD6	4	2	3.2	30	3.9	-	11	75	6	A	●
AHMBL 2050L16 0660	D5R2.5x16xL60xSD6	5	2.5	4	16	4.85	-	11	60	6	A	●
AHMBL 2050L20 0660	D5R2.5x20xL60xSD6				20			11	60	6	A	●
AHMBL 2050L25 0675	D5R2.5x25xL75xSD6				25			11	75	6	A	●
AHMBL 2050L30 0675	D5R2.5x30xL75xSD6				30			11	75	6	A	●

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMEF 4 刃平头铣刀 AHMEF 4-flute End Mills

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMEF 4010	16000	320	2	0.05	15000	250	2	0.05
AHMEF 4015	12500	360	3	0.05	12000	300	3	0.05
AHMEF 4020	11000	400	4	0.1	10000	350	4	0.05
AHMEF 4025	9350	440	5	0.1	8500	400	5	0.05
AHMEF 4030	8250	480	6	0.1	7500	450	6	0.05
AHMEF 4040	6380	600	8	0.1	5800	550	8	0.05
AHMEF 4050	5500	700	10	0.1	5000	580	10	0.1
AHMEF 4060	4950	1000	12	0.1	4500	600	12	0.1
AHMEF 4080	4180	1500	16	0.2	3800	600	16	0.1
AHMEF 4100	3850	2000	20	0.2	3500	550	20	0.1
AHMEF 4120	3080	2500	24	0.2	2800	500	24	0.1
AHMEF 4140	2750	2000	28	0.2	2500	500	28	0.1
AHMEF 4160	2420	2000	32	0.2	2200	450	32	0.1
AHMEF 4200	2200	2000	40	0.2	2000	400	40	0.1

AHME 6 刃平头铣刀 AHME 6-flute End Mills

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHME 6060	4500	1936	15	0.2	4000	870	15	0.1
AHME 6080	4000	1920	18	0.2	3500	900	18	0.1
AHME 6100	3500	1840	25	0.2	2800	850	25	0.1
AHME 6120	3000	1600	30	0.2	2500	800	30	0.1
AHME 6140	2700	1600	30	0.2	2200	750	30	0.1
AHME 6160	2400	1600	35	0.2	2200	750	35	0.1
AHME 6200	2200	1440	40	0.2	2000	700	40	0.1

AHMRF 4 刃圆鼻铣刀 - 侧铣 AHMRF 4-flute End Mills with Corner Radius-Side milling

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMRF 4010R_	12000	670	0.05	0.03	9300	480	0.05	0.03
AHMRF 4015R_	10000	900	0.05	0.03	7600	640	0.05	0.03
AHMRF 4020R_	9400	1700	0.1	0.05	7200	1200	0.1	0.05
AHMRF 4030R_	8800	2250	0.1	0.05	6800	1600	0.1	0.05
AHMRF 4040R_	8300	2250	0.2	0.05	6400	1600	0.2	0.05
AHMRF 4060R_	6200	2500	0.2	0.08	4800	1800	0.2	0.08
AHMRF 4080R_	5200	3350	0.2	0.1	4000	2400	0.2	0.1
AHMRF 4100R_	4600	3350	0.2	0.1	3600	2400	0.2	0.1
AHMRF 4120R_	4100	3350	0.2	0.1	3200	2400	0.2	0.1

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMRP 4 刃短刃圆鼻铣刀 - 侧铣 AHMRP 4-flute Short-flute End Mills with Corner Radius-Side milling

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMRP 4010R_	12000	670	0.05	0.03	9300	480	0.05	0.03
AHMRP 4015R_	10000	900	0.05	0.03	7600	640	0.05	0.03
AHMRP 4020R_	9400	1700	0.1	0.05	7200	1200	0.1	0.05
AHMRP 4030R_	8800	2250	0.1	0.05	6800	1600	0.1	0.05
AHMRP 4040R_	8300	2250	0.2	0.05	6400	1600	0.2	0.05
AHMRP 4060R_	6200	2500	0.2	0.08	4800	1800	0.2	0.08
AHMRP 4080R_	5200	3350	0.2	0.1	4000	2400	0.2	0.1
AHMRP 4100R_	4600	3350	0.2	0.1	3600	2400	0.2	0.1
AHMRP 4120R_	4100	3350	0.2	0.1	3200	2400	0.2	0.1

AHMR 4 刃圆鼻铣刀 - 平面精铣 AHMR 4-flute End Mills with Corner Radius-Surface finishing milling

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMR 4060R_	5500	440	0.08	3.5	5000	400	0.05	3.5
AHMR 4080R_	4950	660	0.08	4.5	4500	600	0.05	4.5
AHMR 4100R_	4600	880	0.08	6	4200	800	0.06	6
AHMR 4120R_	3850	880	0.08	8	3500	800	0.06	8

AHMR 6 刃圆鼻铣刀 - 侧铣 AHMR 6-flute End Mills with Corner Radius-Side milling

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMR 6060R_	4500	1936	15	0.2	4000	870	15	0.1
AHMR 6080R_	4000	1920	18	0.2	3500	900	18	0.1
AHMR 6100R_	3500	1840	25	0.2	2800	850	25	0.1
AHMR 6120R_	3000	1600	30	0.2	2500	800	30	0.1

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMR 6 刃圆鼻铣刀 - 平面精铣 AHMR 6-flute End Mills with Corner Radius-Surface finishing milling

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMR 6060R_	6600	660	0.08	3.5	6000	600	0.05	3.5
AHMR 6080R_	5500	880	0.08	4.5	5000	800	0.05	4.5
AHMR 6100R_	4950	1100	0.08	6	4500	1000	0.06	6
AHMR 6120R_	4400	1320	0.08	8	4000	1200	0.06	8

AHMRK 4 刃强力型圆鼻铣刀 AHMRK 4-flute High-feed End Mills with Corner Radius

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMRK 4030R_	12480	3200	0.15	2.16	10400	1600	0.1	1.8
AHMRK 4040R_	11520	4320	0.15	2.88	9600	2160	0.1	2.4
AHMRK 4050R_	9600	4400	0.2	3.6	8000	2200	0.1	3
AHMRK 4060R_	8400	4800	0.2	4.32	7000	2400	0.15	3.6
AHMRK 4080R_	7560	4800	0.3	5.76	6300	2400	0.15	4.8
AHMRK 40100R_	6000	4800	0.3	7.2	5000	2400	0.2	6
AHMRK 40120R_	5400	5000	0.3	9.6	4500	2000	0.2	8

AHMB 2 刃球头铣刀 AHMB 2-flute Ballnose End Mills

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMB 2004	28000	600	0.03	0.03	25000	540	0.03	0.03
AHMB 2005	25000	720	0.03	0.03	22500	650	0.03	0.03
AHMB 2006	22000	800	0.03	0.03	19800	720	0.03	0.03
AHMB 2008	20000	1000	0.03	0.03	18000	900	0.03	0.03
AHMB 2010	18000	1200	0.03	0.05	16000	1100	0.03	0.05
AHMB 2015	16000	1500	0.03	0.05	14500	1350	0.03	0.05
AHMB 2020	14800	1560	0.04	0.06	13300	1400	0.04	0.06
AHMB 2025	14400	1680	0.04	0.06	13000	1500	0.04	0.06
AHMB 2030	13000	2000	0.05	0.08	11500	1800	0.05	0.08
AHMB 2040	12000	2400	0.05	0.1	10800	2100	0.05	0.1
AHMB 2050	10000	2500	0.08	0.1	9000	2250	0.05	0.1
AHMB 2060	9000	2800	0.08	0.15	8100	2500	0.05	0.15
AHMB 2080	8000	3000	0.08	0.2	7200	2700	0.05	0.2
AHMB 2100	7200	3000	0.08	0.25	6500	2700	0.08	0.25
AHMB 2120	6400	3200	0.1	0.25	5800	2900	0.1	0.25
AHMB 2160	6000	3600	0.1	0.3	5400	3200	0.1	0.3

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHME 2 刃平头铣刀 AHME 2-flute End Mills

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHME 2004	30000	275	0.03	0.28	28000	250	0.03	0.28
AHME 2005	27500	330	0.03	0.3	25000	300	0.03	0.3
AHME 2006	24000	380	0.04	0.42	22000	350	0.04	0.42
AHME 2008	22000	440	0.04	0.56	20000	400	0.04	0.56
AHME 2010	20000	550	0.05	0.7	18000	500	0.05	0.7
AHME 2015	16500	66	0.05	1.05	15000	600	0.05	1.05
AHME 2020	13800	800	0.1	1.5	12500	750	0.05	1.5
AHME 2025	11000	1100	0.1	1.75	10000	1000	0.05	1.75
AHME 2030	8800	1100	0.1	2.1	8000	1000	0.05	2.1
AHME 2040	7200	2200	0.1	2.8	6500	2000	0.05	2.8
AHME 2050	6600	1100	0.1	3.5	6000	1000	0.1	3.5
AHME 2060	5500	660	0.1	4.2	5000	600	0.1	4.2
AHME 2080	5000	660	0.2	5.6	4500	600	0.1	5.6
AHME 2100	4400	550	0.2	7	4000	500	0.1	7
AHME 2120	3800	550	0.2	8.4	3500	500	0.1	8.4
AHME 2140	3300	550	0.2	9.6	3000	500	0.1	9.6
AHME 2160	3000	550	0.2	11.2	2800	500	0.1	11.2
AHME 2200	2750	550	0.2	14	2500	500	0.1	14

AHMR 2 刃圆鼻铣刀 AHMR 2-flute End Mills with Corner Radius

被削材 Material	预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMR 2010R_	12800	330	0.05	0.03	11600	300	0.05	0.03
AHMR 2015R_	10500	440	0.05	0.03	9500	400	0.05	0.03
AHMR 2020R_	9900	825	0.1	0.05	9000	750	0.1	0.05
AHMR 2025R_	9600	950	0.1	0.05	8800	750	0.1	0.05
AHMR 2030R_	9300	1100	0.1	0.05	8500	1000	0.1	0.05
AHMR 2040R_	8800	1100	0.2	0.05	8000	1000	0.2	0.05
AHMR 2060R_	6600	1375	0.2	0.08	6000	1000	0.2	0.08
AHMR 2080R_	5500	1650	0.2	0.1	5000	1250	0.2	0.1
AHMR 2100R_	4950	1650	0.2	0.1	4500	1500	0.2	0.1
AHMR 2120R_	4400	1650	0.2	0.1	4000	1500	0.2	0.1

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMEL 4 刃长颈平头铣刀 AHMEL 4-flute End Mills with Neck Increased

被削材 Material		预硬钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMEL 4008L	2	25000	2000	0.014	0.25	23000	1600	0.012	0.16
	4	25000	1600	0.012	0.25	23000	1280	0.01	0.16
	6	20000	1200	0.01	0.25	18000	960	0.01	0.15
	8	16000	1000	0.01	0.25	14000	800	0.008	0.15
AHMEL 4010L	4	22000	1400	0.05	0.5	17600	1120	0.04	0.4
	6	18000	1000	0.04	0.5	14400	800	0.03	0.4
	8	15000	800	0.03	0.5	12000	640	0.02	0.4
	10	14000	700	0.02	0.5	11200	560	0.01	0.4
AHMEL 4015L	6	16000	1440	0.07	0.75	12800	1150	0.06	0.6
	8	14000	1160	0.06	0.75	11200	930	0.05	0.6
	10	13000	1040	0.05	0.75	10400	830	0.04	0.6
	12	12000	900	0.04	0.75	9600	720	0.03	0.6
AHMEL 4020L	8	13000	1600	0.09	1	10400	1280	0.07	0.8
	10	13000	1500	0.08	1	10400	1200	0.06	0.8
	12	12000	1300	0.07	1	9600	1040	0.06	0.8
	16	10000	1000	0.05	1	8000	800	0.04	0.8
AHMEL 4025L	10	11000	1600	0.11	1.25	8800	1280	0.09	1
	12	11000	750	0.1	1.25	8800	600	0.08	1
	16	9000	1100	0.07	1.25	7200	880	0.06	1
	20	7000	800	0.05	1.25	5600	640	0.04	1
AHMEL 4030	10	9000	1800	0.14	1.5	7200	1440	0.11	1.2
	12	9000	1600	0.12	1.5	7200	1280	0.1	1.2
	16	8000	1200	0.09	1.5	6400	960	0.07	1.2
	20	7000	900	0.07	1.5	5600	720	0.06	1.2
	25	6000	760	0.06	1.5	4800	600	0.05	1.2
AHMEL 4040L	12	6000	1700	0.25	2	4800	1350	0.2	1.6
	16	6000	1600	0.2	2	4800	1280	0.16	1.6
	20	6000	1460	0.15	2	4800	1150	0.12	1.6
	25	5000	1200	0.1	2	4000	960	0.08	1.6
	30	5000	1080	0.08	2	4000	960	0.06	1.6

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMRL 4 刃长颈圆鼻铣刀 AHMRL 4-flute End Mills with Neck Increased & Corner Radius

被削材 Material		预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMRL 4008R_L	2	25000	2000	0.014	0.25	23000	1600	0.012	0.16
	4	25000	1600	0.012	0.25	23000	1280	0.01	0.16
	6	20000	1200	0.01	0.25	18000	960	0.01	0.15
	8	16000	1000	0.01	0.25	14000	800	0.008	0.15
	10	15000	800	0.008	0.2	13500	640	0.006	0.12
	12	13000	600	0.008	0.15	12000	480	0.006	0.12
AHMRL 4009R_L	4	25000	1700	0.03	0.3	20000	1400	0.02	0.2
	8	16000	800	0.01	0.3	14000	700	0.008	0.2
AHMRL 4010R_L	4	25000	2400	0.05	0.3	21000	1920	0.04	0.25
	5	23000	2000	0.05	0.3	20000	1600	0.04	0.25
	6	21000	1800	0.04	0.3	18000	1440	0.03	0.25
	8	19000	1600	0.03	0.3	16000	1280	0.02	0.25
	10	16000	1400	0.02	0.3	14000	1120	0.01	0.25
	12	15000	1200	0.015	0.3	13000	960	0.008	0.25
	16	15000	800	0.015	0.3	13000	640	0.008	0.25
	20	13000	700	0.01	0.3	11000	560	0.008	0.25
AHMRL 4015R_L	6	20000	960	0.02	0.07	18000	840	0.02	0.03
	8	18000	800	0.02	0.06	16000	700	0.02	0.03
	10	16000	800	0.02	0.05	15000	700	0.02	0.02
	12	14000	640	0.02	0.04	13000	560	0.02	0.02
AHMRL 4020R_L	8	16000	1280	0.03	0.1	13000	1120	0.03	0.03
	10	16000	1120	0.03	0.09	13000	980	0.03	0.03
	12	14000	960	0.02	0.08	11000	840	0.02	0.02
	16	12000	800	0.02	0.06	10000	700	0.02	0.02
AHMRL 4030R_L	10	12000	1600	0.03	0.19	10000	1400	0.03	0.08
	12	11000	1280	0.03	0.14	9000	1120	0.03	0.06
	16	10000	960	0.02	0.11	8000	840	0.02	0.05
	20	9000	640	0.02	0.09	6400	560	0.02	0.04
	25	8000	480	0.02	0.07	5600	420	0.02	0.03
AHMRL 4040R_L	12	9000	1280	0.04	0.19	7000	1120	0.04	0.08
	16	8000	960	0.03	0.17	6400	840	0.03	0.08
	20	7500	640	0.02	0.14	6000	560	0.02	0.07
	25	7000	480	0.02	0.1	5600	420	0.02	0.06
	30	6000	320	0.02	0.07	4800	280	0.02	0.03

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMEL 2 刃长颈平头铣刀 AHMEL 2-flute End Mills with Neck Increased

被削材 Material		预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMEL 2001L	0.3	40000	150	0.005	0.06	32000	120	0.003	0.05
	0.5	40000	100	0.005	0.06	32000	80	0.003	0.05
	1	40000	60	0.002	0.06	32000	50	0.001	0.05
AHMEL 2002L	0.5	30000	240	0.005	0.12	24000	200	0.003	0.1
	1	30000	180	0.005	0.12	24000	150	0.003	0.1
	2	30000	80	0.003	0.12	24000	50	0.002	0.1
AHMEL 2003L	1	30000	350	0.007	0.18	24000	300	0.003	0.15
	2	30000	180	0.005	0.18	24000	150	0.003	0.15
	3	30000	70	0.004	0.18	24000	50	0.002	0.15
AHMEL 2004L	2	22000	250	0.01	0.25	17600	200	0.008	0.2
	3	18000	150	0.005	0.25	14400	120	0.004	0.2
AHMEL 2005L	2	22000	300	0.01	0.25	17600	240	0.008	0.2
	3	18000	200	0.005	0.25	14400	160	0.004	0.2
	4	14000	150	0.002	0.25	11200	120	0.002	0.2
AHMEL 2006L	2	22000	230	0.01	0.25	17600	180	0.008	0.2
	3	18000	140	0.005	0.25	14400	110	0.004	0.2
	4	14000	90	0.002	0.25	11200	70	0.002	0.2
AHMEL 2008L	4	22000	400	0.03	0.4	17600	320	0.02	0.32
	6	18000	300	0.02	0.4	14400	240	0.02	0.32
AHMEL 2010L	4	22000	700	0.05	0.5	17600	560	0.04	0.4
	6	18000	500	0.04	0.5	14400	400	0.03	0.4
	8	15000	400	0.03	0.5	12000	320	0.02	0.4
	10	14000	350	0.02	0.5	11200	280	0.01	0.4
AHMEL 2015L	6	16000	720	0.07	0.75	12800	580	0.06	0.6
	8	14000	580	0.06	0.75	11200	460	0.05	0.6
	10	13000	520	0.05	0.75	10400	400	0.04	0.6
	12	12000	450	0.04	0.75	9600	360	0.03	0.6
AHMEL 2020L	8	13000	800	0.09	1	10400	640	0.07	0.8
	10	13000	750	0.08	1	10400	600	0.06	0.8
	12	12000	650	0.07	1	9600	520	0.06	0.8
	16	10000	500	0.05	1	8000	400	0.04	0.8
AHMEL 2025L	10	11000	800	0.1	1.25	8800	640	0.09	1
	12	11000	750	0.1	1.25	8800	600	0.08	1
	16	9000	550	0.07	1.25	7200	440	0.06	1
	20	7000	400	0.05	1.25	5600	320	0.04	1
AHMEL 2030L	10	9000	900	0.15	1.5	7200	720	0.11	1.2
	12	9000	800	0.12	1.5	7200	640	0.01	1.2
	16	8000	600	0.09	1.5	6400	480	0.07	1.2
	20	7000	450	0.07	1.5	5600	360	0.06	1.2
	25	6000	380	0.06	1.5	4800	300	0.05	1.2
AHMEL 2040	12	6000	850	0.25	2	4800	680	0.2	1.6
	16	6000	800	0.2	2	4800	640	0.16	1.6
	20	6000	730	0.15	2	4800	580	0.12	1.6
	25	5000	600	0.1	2	4000	480	0.08	1.6
	30	5000	540	0.08	2	4000	430	0.06	1.6

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMRL 2 刃长颈圆鼻铣刀 AHMRL 2-flute End Mills with Neck Increased & Corner Radius

被削材 Material		预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMRL 2002R_L	0.5	30000	400	0.005	0.12	24000	300	0.003	0.1
	1	30000	300	0.005	0.12	24000	200	0.003	0.1
	1.5	30000	200	0.005	0.12	24000	150	0.002	0.1
	2	30000	150	0.005	0.12	24000	100	0.002	0.1
AHMRL 2003R_L	1	30000	400	0.007	0.18	24000	350	0.003	0.15
	1.5	30000	300	0.007	0.18	24000	250	0.003	0.15
	2	30000	250	0.005	0.18	24000	200	0.003	0.15
	2.5	30000	200	0.004	0.18	24000	150	0.002	0.15
	3	30000	100	0.004	0.18	24000	80	0.002	0.15
AHMRL 2004R_L	1	30000	500	0.01	0.24	24000	400	0.005	0.2
	1.5	30000	450	0.01	0.24	24000	360	0.005	0.2
	2	30000	410	0.01	0.24	24000	328	0.005	0.2
	2.5	30000	380	0.008	0.24	24000	304	0.005	0.2
	3	30000	360	0.008	0.24	24000	288	0.004	0.2
	4	30000	300	0.006	0.24	24000	240	0.003	0.2
AHMRL 2005R_L	1	25000	600	0.01	0.15	23000	480	0.007	0.1
	1.5	25000	550	0.01	0.15	23000	440	0.007	0.1
	2	25000	480	0.01	0.15	23000	384	0.007	0.1
	2.5	25000	450	0.01	0.15	23000	360	0.007	0.1
	3	25000	400	0.008	0.15	23000	320	0.005	0.1
	4	25000	350	0.005	0.15	23000	280	0.003	0.1
	5	20000	250	0.004	0.15	18000	200	0.003	0.1
	6	20000	200	0.003	0.15	18000	160	0.002	0.1
AHMRL 2006R_L	2	25000	600	0.02	0.2	23000	480	0.01	0.15
	3	24000	500	0.02	0.2	21000	400	0.008	0.15
	4	23000	400	0.015	0.2	20000	320	0.007	0.15
	6	20000	220	0.008	0.2	18000	180	0.005	0.15
	8	16000	180	0.005	0.2	14000	140	0.002	0.15
	10	14000	120	0.002	0.2	12000	100	0.001	0.15
AHMRL 2007R_L	2	25000	700	0.03	0.25	23000	560	0.02	0.15
	3	25000	650	0.03	0.25	23000	520	0.015	0.15
	4	25000	600	0.02	0.25	23000	480	0.01	0.15
	6	20000	400	0.01	0.25	18000	320	0.01	0.15
	8	16000	300	0.01	0.25	14000	240	0.008	0.15
	10	14000	200	0.01	0.25	12000	160	0.006	0.15
AHMRL 2008R_L	2	25000	1000	0.014	0.25	23000	800	0.012	0.16
	3	25000	900	0.014	0.25	23000	720	0.012	0.16
	4	25000	800	0.012	0.25	23000	640	0.01	0.16
	6	20000	600	0.01	0.25	18000	480	0.01	0.15
	8	16000	500	0.01	0.25	14000	400	0.008	0.15
	10	15000	400	0.008	0.2	13500	320	0.006	0.12
	12	13000	300	0.008	0.15	12000	240	0.006	0.12
AHMRL 2009R_L	4	25000	900	0.03	0.3	20000	800	0.02	0.2
	8	16000	500	0.01	0.3	14000	400	0.008	0.2

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMRL 2 刃长颈圆鼻铣刀 AHMRL 2-flute End Mills with Neck Increased & Corner Radius

被削材 Material		预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMRL 2010R_L	3	25000	1350	0.03	0.3	22000	1080	0.025	0.3
	4	25000	1200	0.05	0.3	21000	960	0.04	0.25
	5	23000	1000	0.05	0.3	20000	800	0.04	0.25
	6	21000	900	0.04	0.3	18000	720	0.03	0.25
	8	19000	800	0.03	0.3	16000	640	0.02	0.25
	10	16000	700	0.02	0.3	14000	560	0.01	0.25
	12	15000	600	0.015	0.3	13000	480	0.008	0.25
	16	15000	400	0.015	0.3	13000	320	0.008	0.25
AHMRL 2015R_L	20	13000	350	0.01	0.3	11000	280	0.008	0.25
	6	20000	480	0.02	0.07	18000	420	0.02	0.03
	8	18000	400	0.02	0.06	16000	350	0.02	0.03
	10	16000	400	0.02	0.05	15000	350	0.02	0.03
AHMRL 2020R_L	12	14000	320	0.02	0.04	13000	280	0.02	0.02
	8	16000	640	0.03	0.1	13000	560	0.03	0.03
	10	16000	560	0.03	0.09	13000	490	0.03	0.03
	12	14000	480	0.02	0.08	11000	420	0.02	0.02
AHMRL 2030R_L	16	12000	400	0.02	0.06	10000	350	0.02	0.02
	10	12000	800	0.03	0.19	10000	700	0.03	0.08
	12	11000	640	0.03	0.14	9000	560	0.03	0.06
	16	10000	480	0.02	0.11	8000	420	0.02	0.05
	20	9000	320	0.02	0.09	6400	280	0.02	0.04
AHMRL 2040R_L	25	8000	240	0.02	0.07	5600	210	0.02	0.03
	12	9000	640	0.04	0.19	7000	560	0.04	0.08
	16	8000	480	0.03	0.17	6400	420	0.03	0.08
	20	7500	320	0.02	0.14	6000	280	0.02	0.07
	25	7000	240	0.02	0.1	5600	210	0.02	0.06
	30	6000	160	0.02	0.07	4800	140	0.02	0.03

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMBL 2 刃长颈球头铣刀 AHMBL 2-flute Ballnose End Mills with Neck Increased

被削材 Material		预硬钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMBL 2001L	0.2	40000	100	0.002	0.005	40000	70	0.002	0.003
	0.3	40000	70	0.002	0.005	40000	50	0.002	0.003
	0.5	40000	50	0.001	0.003	40000	30	0.001	0.002
	0.75	40000	50	0.001	0.003	40000	30	0.001	0.002
	1	40000	30	0.001	0.003	40000	30	0.001	0.002
AHMBL 20015L	0.3	40000	150	0.002	0.005	40000	100	0.002	0.003
	0.5	40000	120	0.002	0.005	40000	70	0.002	0.003
	0.75	40000	50	0.001	0.003	40000	30	0.001	0.002
	1	40000	50	0.001	0.003	40000	30	0.001	0.002
	1.5	40000	30	0.001	0.003	40000	30	0.001	0.002
AHMBL 2002L	0.3	40000	300	0.006	0.005	36000	200	0.003	0.003
	0.5	39600	280	0.005	0.005	36000	180	0.003	0.003
	0.75	39600	200	0.003	0.005	36000	150	0.002	0.003
	1	39600	160	0.002	0.003	36000	120	0.001	0.002
	1.25	39600	140	0.002	0.003	36000	100	0.001	0.002
	1.5	39600	120	0.002	0.003	36000	80	0.001	0.002
	1.75	39600	100	0.001	0.002	36000	60	0.001	0.002
	2	39600	80	0.001	0.002	36000	50	0.001	0.001
	2.5	39600	60	0.001	0.001	36000	40	0.001	0.001
AHMBL 2003L	3	39600	40	0.001	0.001	36000	30	0.001	0.001
	0.5	33000	300	0.007	0.01	30000	280	0.003	0.005
	0.6	33000	300	0.005	0.007	30000	250	0.003	0.005
	0.75	33000	280	0.005	0.007	30000	230	0.003	0.005
	1	33000	250	0.005	0.007	30000	200	0.003	0.005
	1.25	33000	200	0.003	0.005	30000	160	0.002	0.003
	1.5	33000	180	0.003	0.005	30000	120	0.002	0.003
	1.75	33000	150	0.002	0.003	30000	100	0.002	0.002
	2	33000	120	0.002	0.003	30000	90	0.002	0.002
	2.25	33000	100	0.001	0.002	30000	80	0.001	0.001
	2.5	33000	80	0.001	0.002	30000	70	0.001	0.001
	3	33000	70	0.001	0.002	30000	60	0.001	0.001
AHMBL 2004L	3.5	33000	60	0.001	0.001	30000	50	0.001	0.001
	4	33000	50	0.001	0.001	30000	40	0.001	0.001
	0.5	33000	720	0.03	0.03	30000	580	0.009	0.02
	0.8	33000	720	0.02	0.03	30000	580	0.008	0.02
	1	33000	720	0.02	0.03	30000	580	0.008	0.02
	1.5	33000	500	0.01	0.02	30000	400	0.005	0.01
	2	33000	380	0.01	0.01	30000	300	0.005	0.007
	2.5	33000	300	0.005	0.007	30000	260	0.003	0.005
	3	33000	240	0.005	0.007	30000	200	0.003	0.005
	3.5	33000	160	0.003	0.005	30000	120	0.002	0.003
	4	30000	120	0.003	0.003	30000	90	0.002	0.003
	4.5	30000	80	0.002	0.003	30000	60	0.001	0.002
	5	30000	50	0.001	0.002	30000	40	0.001	0.002
	6	30000	40	0.001	0.001	30000	30	0.001	0.001
	8	30000	40	0.001	0.001	30000	30	0.001	0.001

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMBL 2 刃长颈球头铣刀 AHMBL 2-flute Ballnose End Mills with Neck Increased

被削材 Material		预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMBL 2005L	1	34800	590	0.01	0.025	30000	500	0.01	0.025
	1.5	34800	590	0.009	0.02	30000	500	0.009	0.02
	2	34800	470	0.008	0.02	30000	400	0.008	0.02
	2.5	32480	470	0.007	0.015	28000	400	0.007	0.015
	3	32480	420	0.007	0.01	28000	360	0.007	0.01
	3.5	29000	420	0.006	0.01	25000	360	0.006	0.01
	4	29000	350	0.005	0.008	25000	300	0.005	0.008
	4.5	29000	300	0.004	0.008	25000	260	0.004	0.008
	5	29000	300	0.004	0.008	25000	260	0.004	0.008
	5.5	29000	280	0.004	0.006	25000	240	0.004	0.006
AHMBL 2006L	6	25520	140	0.003	0.005	22000	120	0.003	0.005
	8	23200	90	0.003	0.003	20000	80	0.003	0.003
	10	23200	60	0.003	0.003	20000	50	0.003	0.003
	1	31320	700	0.02	0.03	28800	600	0.02	0.03
	1.5	31320	700	0.02	0.03	28800	600	0.02	0.03
	2	31320	560	0.02	0.03	28800	480	0.02	0.03
	2.5	29232	560	0.015	0.02	26880	480	0.015	0.02
	3	29232	500	0.015	0.02	26880	432	0.015	0.02
	3.5	26100	500	0.01	0.02	24000	432	0.01	0.02
	4	26100	420	0.01	0.02	24000	360	0.01	0.02
	4.5	26100	360	0.01	0.02	24000	312	0.01	0.02
	5	26100	360	0.01	0.02	24000	312	0.01	0.02
AHMBL 2007L	5.5	26100	336	0.008	0.01	24000	288	0.008	0.01
	6	22968	168	0.008	0.01	21120	144	0.008	0.01
	7	20880	108	0.006	0.008	19200	96	0.006	0.008
	8	20880	70	0.005	0.008	19200	60	0.005	0.008
	9	18188	65	0.005	0.008	18048	50	0.005	0.008
	10	18188	60	0.003	0.005	18000	40	0.003	0.005
	12	18188	50	0.003	0.005	18000	30	0.003	0.005
	2	41200	1300	0.02	0.035	36000	1000	0.02	0.035
AHMBL 2008L	3	40000	960	0.02	0.03	30000	800	0.02	0.03
	4	40000	820	0.015	0.02	30000	600	0.015	0.02
	6	30000	500	0.006	0.01	25000	420	0.006	0.01
	8	20000	380	0.004	0.006	20000	250	0.004	0.006
AHMBL 2008L	2	22000	1600	0.03	0.05	20000	1200	0.03	0.05
	2.5	22000	1600	0.03	0.05	20000	1200	0.03	0.05
	3	22000	1600	0.03	0.05	20000	1200	0.03	0.05
	4	22000	1200	0.03	0.05	20000	860	0.03	0.05
	5	22000	1000	0.02	0.03	20000	620	0.02	0.03
	6	19800	760	0.02	0.03	18000	560	0.02	0.03
	7	19800	680	0.02	0.03	18000	520	0.02	0.03
	8	19800	600	0.01	0.02	18000	480	0.01	0.02
	10	17600	380	0.008	0.015	16000	320	0.008	0.015
	12	16500	260	0.006	0.012	15000	200	0.006	0.012
	16	16500	260	0.005	0.01	15000	200	0.005	0.01

切削参数 -AHM 系列

Cutting Parameters-AHM series

AHMBL 2 刃长颈球头铣刀 AHMBL 2-flute Ballnose End Mills with Neck Increased

被削材 Material		预制钢 (HRC35 ~ 45) Pre-hardened Steel				淬火钢 (HRC46 ~ 55) Hardened Steel			
型号 type		转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 S/min ⁻¹	进给速度 Vf/mm/min	切深 ap/mm	切宽 ae/mm
AHMBL 2009L	2	22000	1600	0.03	0.05	20000	1200	0.03	0.05
	4	22000	1200	0.03	0.05	20000	860	0.03	0.05
	6	19800	760	0.02	0.03	18000	560	0.02	0.03
	8	19800	600	0.01	0.02	18000	480	0.01	0.02
AHMBL 2010L	2.5	22000	1600	0.03	0.05	20000	1200	0.03	0.05
	3	22000	1600	0.03	0.05	20000	1200	0.03	0.05
	4	22000	1600	0.03	0.05	20000	1200	0.03	0.05
	5	22000	1600	0.03	0.05	20000	920	0.03	0.05
	6	19800	1200	0.03	0.05	18000	740	0.02	0.05
	7	19800	950	0.03	0.04	18000	680	0.02	0.03
	8	19800	860	0.03	0.04	18000	560	0.02	0.03
	9	17600	750	0.02	0.03	16000	500	0.01	0.02
	10	16500	620	0.02	0.03	15000	450	0.01	0.02
	12	16500	520	0.007	0.02	15000	400	0.005	0.01
	14	15400	360	0.003	0.007	14000	320	0.002	0.006
	16	15400	250	0.003	0.005	14000	200	0.002	0.003
	18	15400	120	0.002	0.005	14000	85	0.002	0.002
	20	13200	75	0.002	0.003	12000	60	0.002	0.002
	22	11000	40	0.002	0.002	10000	35	0.001	0.002
AHMBL 2015L	6	20000	1900	0.08	0.04	14000	1700	0.05	0.03
	8	20000	1900	0.08	0.04	14000	1700	0.05	0.03
	10	18000	1440	0.06	0.04	12000	1300	0.04	0.03
	12	18000	960	0.06	0.03	12000	840	0.04	0.02
AHMBL 2020L	6	20000	2450	0.08	0.06	14000	2100	0.06	0.04
	8	16000	2050	0.08	0.06	11200	1750	0.06	0.04
	10	16000	2050	0.06	0.05	11200	1750	0.05	0.04
	12	12000	1500	0.06	0.05	8400	1260	0.05	0.04
	16	10000	1300	0.06	0.04	7000	1120	0.04	0.03
AHMBL 2025L	10	14400	2400	0.08	0.05	12800	1800	0.07	0.04
	12	14400	2000	0.08	0.05	12800	1500	0.07	0.04
	16	14400	1450	0.06	0.05	12800	1080	0.06	0.04
	20	10800	880	0.04	0.04	9600	660	0.04	0.03
AHMBL 2030L	10	12800	3200	0.08	0.05	11200	2800	0.06	0.04
	12	12800	2400	0.08	0.05	11200	2100	0.06	0.04
	16	12800	1440	0.06	0.05	11200	1260	0.05	0.04
	20	9600	960	0.06	0.05	8400	840	0.05	0.04
	25	7200	800	0.01	0.04	6600	720	0.08	0.04
AHMBL 2040L	12	12800	3200	0.08	0.08	9600	2400	0.06	0.06
	16	12800	2800	0.08	0.06	9600	2100	0.06	0.05
	20	11200	2650	0.06	0.06	8400	2000	0.05	0.05
	25	9600	2100	0.06	0.05	7200	1560	0.05	0.04
	30	9600	2100	0.05	0.05	7200	1560	0.04	0.04
AHMBL 2050L	16	12800	3200	0.08	0.11	9600	2400	0.06	0.09
	20	12800	3200	0.08	0.11	9600	2400	0.06	0.09
	25	9600	2400	0.06	0.08	7200	1800	0.05	0.06
	30	8000	1920	0.06	0.08	6000	1440	0.05	0.06

***END MILLS FOR TITANIUM
AND STAINLESS STEEL***

钛合金与不锈钢专用铣刀 >>>



刀具型号标示指南

Cutting Tool Naming Guidelines

钛合金与不锈钢专用铣刀命名规则

AC S R C 4 030 C0.1 06 50

① 公司产品代号
AC: 公司产品代号

② 产品类型
S(钛合金与不锈钢专用)

③ 刀尖结构
R: 圆鼻铣刀
E: 平头铣刀

④ 特殊类型
C: 刀尖含 C 角

⑤ 切削刃数
4 刃数: 4
5 刃数: 5

⑥ 刀具刃径
030 3.0mm
120 12.0mm

⑦ 刀尖形式
C0.1 刀尖倒角: 0.1x45°
R1.0 圆弧半径: 1.0

⑧ 刀具柄径
06 柄径: SD6
12 柄径: SD12

⑨ 刀具总长
50 刀具总长: 50
100 刀具总长: 100

ACS 系列

钛合金与不锈钢专用铣刀

应用领域 Application fields

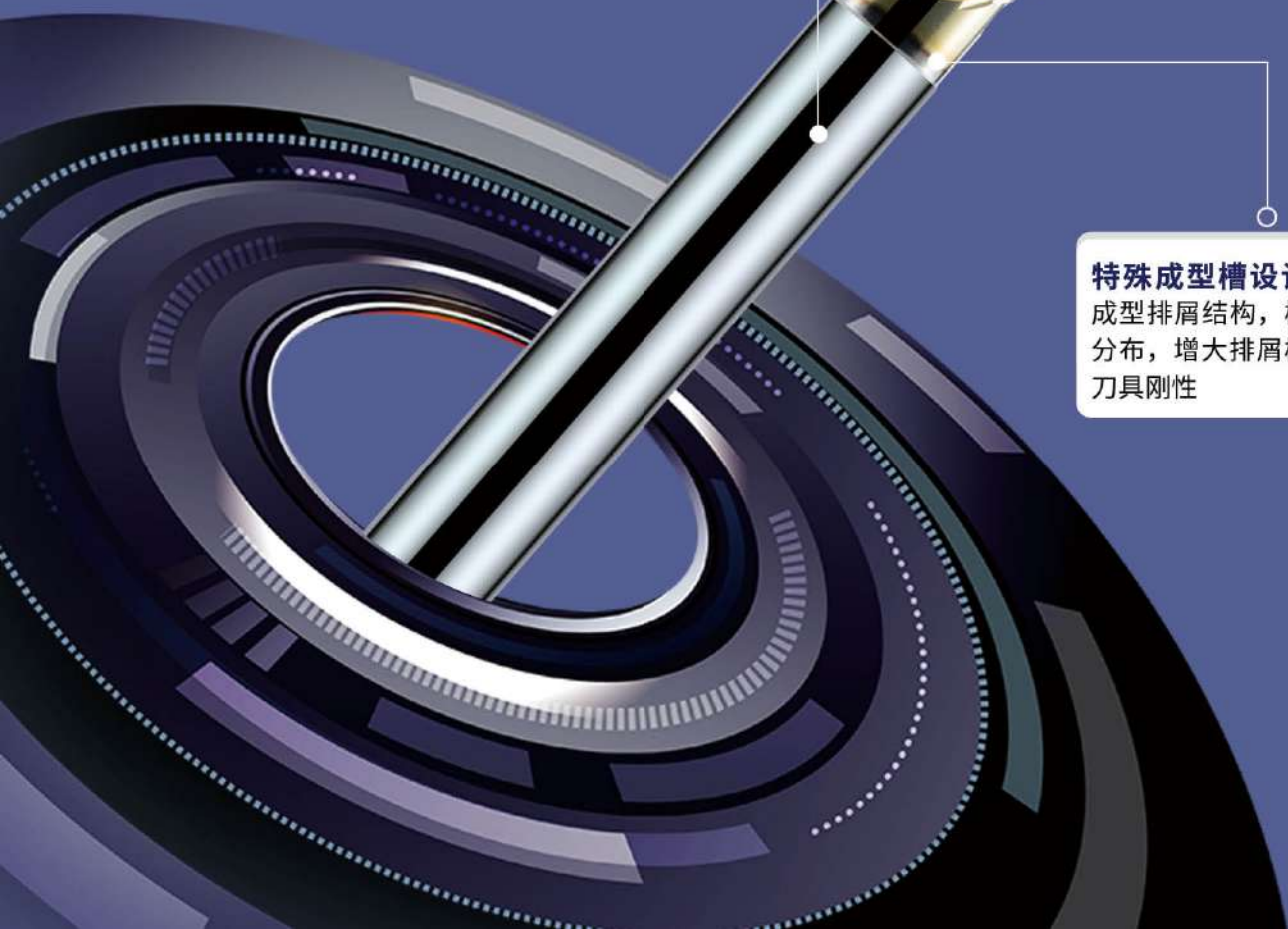
- 适合各类不锈钢、钛合金材质的高效加工 例：304、316L、17-4 等不锈钢；TA15、TC4、TC11 等钛合金
- 铣削方式适合铣槽、侧铣和摆线铣等高效加工

不等分度：采用刀口型线不等结构，改变切削固有频率，有效抑制颤振

不等螺旋：($\alpha_1 \neq \alpha_2$) 采用相邻螺旋型线不相等结构，单位时间内刃口不均匀地参与切削，提高抗振能力

刀尖设计：航空级刀尖设计 (包括圆鼻及 C 角)，可实现高速和重载切削

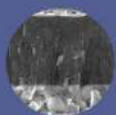
特殊成型槽设计：采用弧面成型排屑结构，槽底圆弧型面分布，增大排屑槽空间，重构刀具刚性



基材涂层 Substrate coating



- 采用超微细颗粒硬质合金
- 兼具良好的耐磨性和较高的抗弯强度



- 摩擦系数更低的涂层牌号，适合粘性材料的加工
- 稳定性高，涂层表面附着力强

应用案例 Application cases

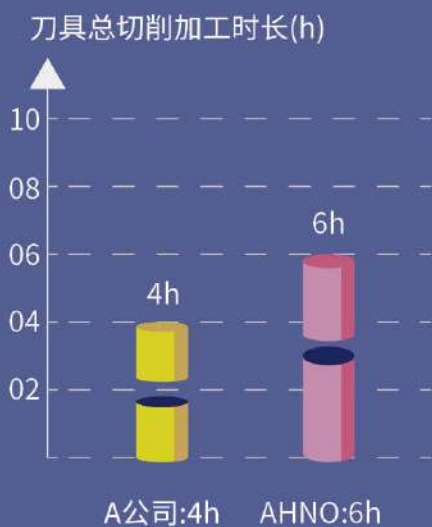
刀具规格: ACSEC 4100C0.15 1075

加工方式: 半精加工

加工材料: 钛合金 TC4

切削参数: $V_c=80\text{m/min}$ $f_z=0.08\text{mm/z}$
 $a_p=10\text{mm}$ $a_e=1.0\text{mm}$

加工机床: 立式五轴加工中心



ACSEC 4 刃平头铣刀 (含 C 角)

ACSEC 4-flute End Mills(with chamfer)



- 专为加工钛合金与不锈钢材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合;
- 采用特殊几何形状槽型设计, 提高排屑顺畅性, 快速散热。
- Designed for machining titanium alloy and stainless steel materials;
- The newly developed coating has excellent oxidation resistance, red hardness, and outstanding wear resistance combined with toughness;
- Special geometry for flute design, improving chip breaking smoothness and fast heat dissipation.

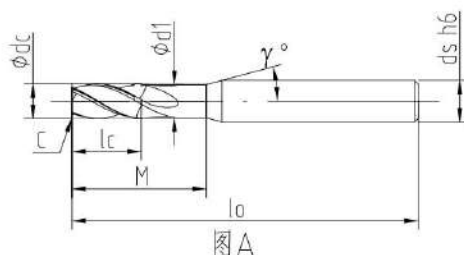


图 A

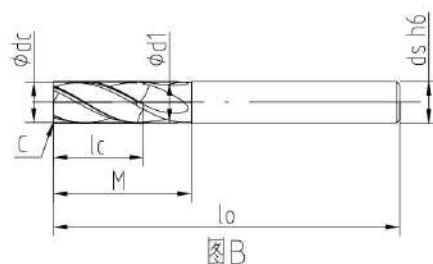


图 B

刃径 ϕdc	ϕdc Tolerance	刃径 ϕdc	C Tolerance
$\phi \leq 8$	0 ~ -0.020	$\phi \leq 6$	± 0.03
$8 < \phi \leq 12$	0 ~ -0.025	$\phi > 6$	± 0.05
$12 < \phi \leq 20$	0 ~ -0.030		

适合加工材料: M、S

Suitable for materials: M、S

M S

订货编号·Order code

代码·Code	规格型号·Designation	刃径·dc	刀尖倒角·C	刃长·lc	有效长·M	颈径·d1	柄锥角度· γ°	全长·lo	柄径·ds	图示·Diagram	库存 Stock
ACSEC 4030C0.1 0450	D3x8xL50xSD4	3	0.10	8	-	-	15	50	4	A	●
ACSEC 4030C0.1 0460	D3x8xL60xSD4	3	0.10	8	-	-	15	60	4	A	●
ACSEC 4040C0.1 0450	D4x10xL50xSD4	4	0.10	10	-	-	-	50	4	B	●
ACSEC 4040C0.1 0460	D4x10xL60xSD4	4	0.10	10	-	-	-	60	4	B	●
ACSEC 4040C0.1 0650	D4x10xL50xSD6	4	0.10	10	-	-	15	50	6	A	●
ACSEC 4040C0.1 0660	D4x10xL60xSD6	4	0.10	10	-	-	15	60	6	A	●
ACSEC 4050C0.1 0650	D5x13x18xL50xSD6	5	0.10	13	18	4.8	15	50	6	A	●
ACSEC 4050C0.1 0660	D5x13x18xL60xSD6	5	0.10	13	18	4.8	15	60	6	A	●
ACSEC 4060C0.1 0650	D6x13x20xL50xSD6	6	0.10	13	20	5.7	-	50	6	B	●
ACSEC 4060C0.1 0660	D6x13x20xL60xSD6	6	0.10	13	20	5.7	-	60	6	B	●
ACSEC 4060C0.1 0675	D6x13x20xL75xSD6	6	0.10	13	20	5.7	-	75	6	B	●
ACSEC 4080C0.15 0860	D8x19x25xL60xSD8	8	0.15	19	25	7.7	-	60	8	B	●
ACSEC 4080C0.15 0875	D8x19x25xL75xSD8	8	0.15	19	25	7.7	-	75	8	B	●
ACSEC 4080C0.15 08100	D8x19x25xL100xSD8	8	0.15	19	25	7.7	-	100	8	B	●
ACSEC 4100C0.15 1075	D10x22x30xL75xSD10	10	0.15	22	30	9.7	-	75	10	B	●
ACSEC 4100C0.15 10100	D10x22x30xL100xSD10	10	0.15	22	30	9.7	-	100	10	B	●
ACSEC 4120C0.15 1275	D12x26x36xL75xSD12	12	0.15	26	36	11.6	-	75	12	B	●
ACSEC 4120C0.15 12100	D12x26x36xL100xSD12	12	0.15	26	36	11.6	-	100	12	B	●
ACSEC 4160C0.2 16100	D16x32x42xL100xSD16	16	0.20	32	42	15.6	-	100	16	B	●
ACSEC 4160C0.2 16150	D16x32x42xL150xSD16	16	0.20	32	42	15.6	-	150	16	B	●
ACSEC 4200C0.2 20100	D20x40x52xL100xSD20	20	0.20	40	52	19.6	-	100	20	B	●
ACSEC 4200C0.2 20150	D20x40x52xL150xSD20	20	0.20	40	52	19.6	-	150	20	B	●

ACSEC 5 刃平头铣刀 (含 C 角)

ACSEC 5-flute End Mills(with Chamfer)



- 专为加工钛合金与不锈钢材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合;
- 采用特殊几何形状槽型设计, 提高排屑顺畅性, 快速散热。
- Designed for machining titanium alloy and stainless steel materials;
- The newly developed coating has excellent oxidation resistance, red hardness, and outstanding wear resistance combined with toughness;
- Special geometry for flute design, improving chip breaking smoothness and fast heat dissipation.

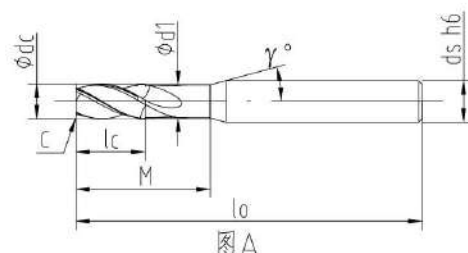
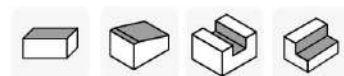


图 A

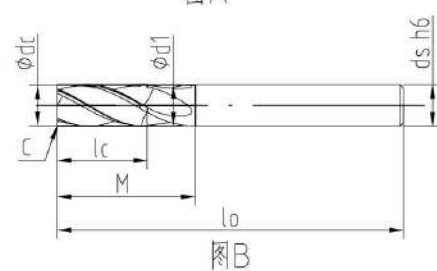


图 B

刃径 ϕdc	ϕdc Tolerance	刃径 ϕdc	R Tolerance
$\phi \leq 8$	0 ~ -0.020	$\phi \leq 6$	± 0.03
$8 < \phi \leq 12$	0 ~ -0.025	$\phi > 6$	± 0.05
$12 < \phi \leq 25$	0 ~ -0.030		

适合加工材料: M、S

Suitable for materials: M、S

M S

订货编号·Order code

代码·Code	规格型号·Designation	刃径 .dc	刀尖倒角 .C	刃长 .lc	有效长 .M	颈径 .d1	柄锥角度 . γ°	全长 .lo	柄径 .ds	图示·Diagram	库存
ACSEC 5060C0.1 0650	D6x13x20xL50xSD6	6	0.10	13	20	5.7	-	50	6	B	●
ACSEC 5060C0.1 0660	D6x13x20xL60xSD6	6	0.10	13	20	5.7	-	60	6	B	●
ACSEC 5060C0.1 0675	D6x13x20xL75xSD6	6	0.10	13	20	5.7	-	75	6	B	●
ACSEC 5080C0.15 0860	D8x19x25xL60xSD8	8	0.15	19	25	7.7	-	60	8	B	●
ACSEC 5080C0.15 0875	D8x19x25xL75xSD8	8	0.15	19	25	7.7	-	75	8	B	●
ACSEC 5080C0.15 08100	D8x19x25xL100xSD8	8	0.15	19	25	7.7	-	100	8	B	●
ACSEC 5100C0.15 1075	D10x22x30xL75xSD10	10	0.15	22	30	9.7	-	75	10	B	●
ACSEC 5100C0.15 10100	D10x22x30xL100xSD10	10	0.15	22	30	9.7	-	100	10	B	●
ACSEC 5120C0.15 1275	D12x26x36xL75xSD12	12	0.15	26	36	11.6	-	75	12	B	●
ACSEC 5120C0.15 12100	D12x26x36xL100xSD12	12	0.15	26	36	11.6	-	100	12	B	●
ACSEC 5160C0.2 16100	D16x32x42xL100xSD16	16	0.20	32	42	15.6	-	100	16	B	●
ACSEC 5160C0.2 16150	D16x32x42xL150xSD16	16	0.20	32	42	15.6	-	150	16	B	●
ACSEC 5200C0.2 20100	D20x40x52xL100xSD20	20	0.20	40	52	19.6	-	100	20	B	●
ACSEC 5200C0.2 20150	D20x40x52xL150xSD20	20	0.20	40	52	19.6	-	150	20	B	●
ACSEC 5250C0.25 25120	D25x50x62xL120xSD25	25	0.25	50	62	24.5	-	120	25	B	●

ACSR 4 刃圆鼻铣刀

ACSR 4-flute with Corner Radius



- 专为加工钛合金与不锈钢材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合;
- 采用特殊几何形状槽型设计, 提高排屑顺畅性, 快速散热。
- Designed for machining titanium alloy and stainless steel materials;
- The newly developed coating has excellent oxidation resistance, red hardness, and outstanding wear resistance combined with toughness;
- Special geometry for flute design, improving chip breaking smoothness and fast heat dissipation.

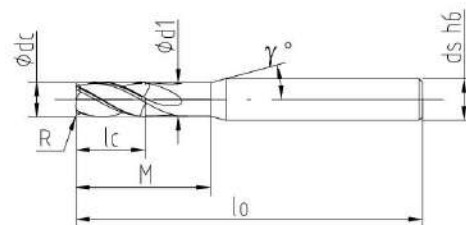


图 A

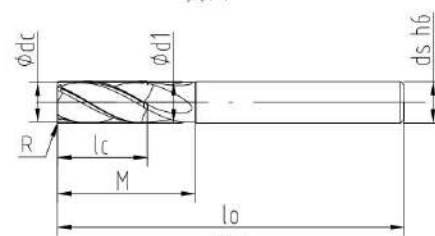


图 B

刃径 ϕdc	ϕdc Tolerance	刃径 ϕdc	R Tolerance
$\phi \leq 8$	0 ~ -0.020	$\phi \leq 6$	± 0.03
$8 < \phi \leq 12$	0 ~ -0.025	$\phi > 6$	± 0.05
$12 < \phi \leq 20$	0 ~ -0.030		

适合加工材料: M、S

Suitable for materials: M、S

M S

订货编号: Order code

代码: Code	规格型号: Designation	刃径: ϕdc	圆角半径: R	刃长: lc	有效长: M	颈径: $d1$	柄锥角度: γ°	全长: lo	柄径: ds	图示: Diagram	库存
ACSR 4030R0.2 0450	D3R0.2x8xL50xSD4	3	0.20	8	-	-	15	50	4	A	●
ACSR 4030R0.2 0460	D3R0.2x8xL60xSD4	3	0.20	8	-	-	15	60	4	A	●
ACSR 4040R0.2 0450	D4R0.2x10xL50xSD4	4	0.20	10	-	-	-	50	4	B	●
ACSR 4040R0.2 0460	D4R0.2x10xL60xSD4	4	0.20	10	-	-	-	60	4	B	●
ACSR 4040R0.2 0650	D4R0.2x10xL50xSD6	4	0.20	10	-	-	15	50	6	A	●
ACSR 4040R0.2 0660	D4R0.2x10xL60xSD6	4	0.20	10	-	-	15	60	6	A	●
ACSR 4050R0.2 0650	D5R0.2x13x18xL50xSD6	5	0.20	13	18	4.8	15	50	6	A	●
ACSR 4050R0.2 0660	D5R0.2x13x18xL60xSD6	5	0.20	13	18	4.8	15	60	6	A	●
ACSR 4060R0.2 0650	D6R0.2x13x20xL50xSD6	6	0.20	13	20	5.7	-	50	6	B	●
ACSR 4060R0.2 0660	D6R0.2x13x20xL60xSD6	6	0.20	13	20	5.7	-	60	6	B	●
ACSR 4060R0.2 0675	D6R0.2x13x20xL75xSD6	6	0.20	13	20	5.7	-	75	6	B	●
ACSR 4030R0.5 0450	D3R0.5x8xL50xSD4	3	0.50	8	-	-	15	50	4	A	●
ACSR 4030R0.5 0460	D3R0.5x8xL60xSD4	3	0.50	8	-	-	15	60	4	A	●
ACSR 4040R0.5 0450	D4R0.5x10xL50xSD4	4	0.50	10	-	-	-	50	4	B	●
ACSR 4040R0.5 0460	D4R0.5x10xL60xSD4	4	0.50	10	-	-	-	60	4	B	●
ACSR 4040R0.5 0650	D4R0.5x10xL50xSD6	4	0.50	10	-	-	15	50	6	A	●
ACSR 4040R0.5 0660	D4R0.5x10xL60xSD6	4	0.50	10	-	-	15	60	6	A	●
ACSR 4050R0.5 0650	D5R0.5x13x18xL50xSD6	5	0.50	13	18	4.8	15	50	6	A	●
ACSR 4050R0.5 0660	D5R0.5x13x18xL60xSD6	5	0.50	13	18	4.8	15	60	6	A	●
ACSR 4060R0.5 0650	D6R0.5x13x20xL50xSD6	6	0.50	13	20	5.7	-	50	6	B	●
ACSR 4060R0.5 0660	D6R0.5x13x20xL60xSD6	6	0.50	13	20	5.7	-	60	6	B	●
ACSR 4060R0.5 0675	D6R0.5x13x20xL75xSD6	6	0.50	13	20	5.7	-	75	6	B	●
ACSR 4080R0.5 0860	D8R0.5x19x25xL60xSD8	8	0.50	19	25	7.7	-	60	8	B	●
ACSR 4080R0.5 0875	D8R0.5x19x25xL75xSD8	8	0.50	19	25	7.7	-	75	8	B	●

ACSR 4 刃圆鼻铣刀

ACSR 4-flute with Corner Radius



- 专为加工钛合金与不锈钢材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合;
- 采用特殊几何形状槽型设计, 提高排屑顺畅性, 快速散热。
- Designed for machining titanium alloy and stainless steel materials;
- The newly developed coating has excellent oxidation resistance, red hardness, and outstanding wear resistance combined with toughness;
- Special geometry for flute design, improving chip breaking smoothness and fast heat dissipation.

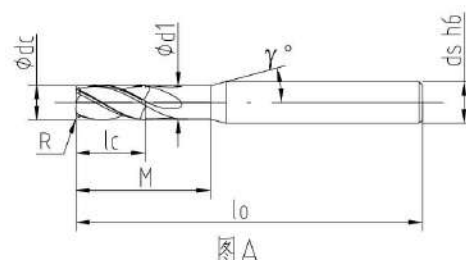


图 A

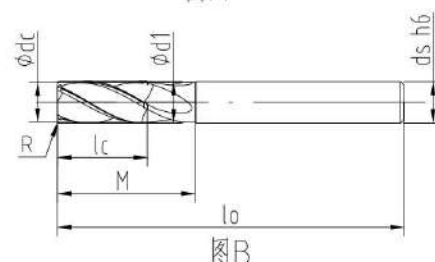


图 B

刃径 ϕ_{dc}	ϕ_{dc} Tolerance	刃径 ϕ_{dc}	R Tolerance
$\phi \leq 8$	0 ~ -0.020	$\phi \leq 6$	± 0.03
$8 < \phi \leq 12$	0 ~ -0.025	$\phi > 6$	± 0.05
$12 < \phi \leq 20$	0 ~ -0.030		

适合加工材料: M、S

Suitable for materials: M、S

M S

订货编号 · Order code

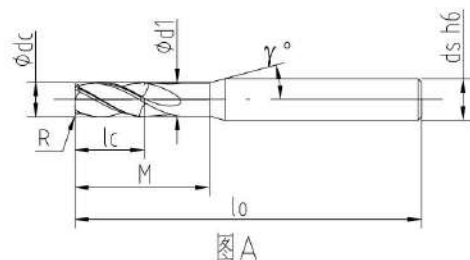
代码 · Code	规格型号 · Designation	刃径 · ϕ_{dc}	圆角半径 · R	刃长 · lc	有效长 · M	颈径 · $d1$	柄锥角度 · γ°	全长 · lo	柄径 · ds	图示 · Diagram	库存
ACSR 4080R0.5 08100	D8R0.5x19x25xL100xSD8	8	0.50	19	25	7.7	-	100	8	B	●
ACSR 4100R0.5 1075	D10R0.5x22x30xL75xSD10	10	0.50	22	30	9.7	-	75	10	B	●
ACSR 4100R0.5 10100	D10R0.5x22x30xL100xSD10	10	0.50	22	30	9.7	-	100	10	B	●
ACSR 4120R0.5 1275	D12R0.5x26x36xL75xSD12	12	0.50	26	36	11.6	-	75	12	B	●
ACSR 4120R0.5 12100	D12R0.5x26x36xL100xSD12	12	0.50	26	36	11.6	-	100	12	B	●
ACSR 4040R1.0 0450	D4R1.0x10xL50xSD4	4	1.00	10	-	-	-	50	4	B	●
ACSR 4040R1.0 0460	D4R1.0x10xL60xSD4	4	1.00	10	-	-	-	60	4	B	●
ACSR 4040R1.0 0650	D4R1x10xL50xSD6	4	1.00	10	-	-	15	50	6	A	●
ACSR 4040R1.0 0660	D4R1x10xL60xSD6	4	1.00	10	-	-	15	60	6	A	●
ACSR 4050R1.0 0650	D5R1x13x18xL50xSD6	5	1.00	13	18	4.8	15	50	6	A	●
ACSR 4050R1.0 0660	D5R1x13x18xL60xSD6	5	1.00	13	18	4.8	15	60	6	A	●
ACSR 4060R1.0 0650	D6R1x13x20xL50xSD6	6	1.00	13	20	5.7	-	50	6	B	●
ACSR 4060R1.0 0660	D6R1x13x20xL60xSD6	6	1.00	13	20	5.7	-	60	6	B	●
ACSR 4060R1.0 0675	D6R1x13x20xL75xSD6	6	1.00	13	20	5.7	-	75	6	B	●
ACSR 4080R1.0 0860	D8R1x19x25xL60xSD8	8	1.00	19	25	7.7	-	60	8	B	●
ACSR 4080R1.0 0875	D8R1x19x25xL75xSD8	8	1.00	19	25	7.7	-	75	8	B	●
ACSR 4080R1.0 08100	D8R1x19x25xL100xSD8	8	1.00	19	25	7.7	-	100	8	B	●
ACSR 4100R1.0 1075	D10R1x22x30xL75xSD10	10	1.00	22	30	9.7	-	75	10	B	●
ACSR 4100R1.0 10100	D10R1x22x30xL100xSD10	10	1.00	22	30	9.7	-	100	10	B	●
ACSR 4120R1.0 1275	D12R1x26x36xL75xSD12	12	1.00	26	36	11.6	-	75	12	B	●
ACSR 4120R1.0 12100	D12R1x26x36xL100xSD12	12	1.00	26	36	11.6	-	100	12	B	●
ACSR 4100R2.0 1075	D10R2x22x30xL75xSD10	10	2.00	22	30	9.7	-	75	10	B	●
ACSR 4100R2.0 10100	D10R2x22x30xL100xSD10	10	2.00	22	30	9.7	-	100	10	B	●
ACSR 4120R2.0 1275	D12R2x26x36xL75xSD12	12	2.00	26	36	11.6	-	75	12	B	●
ACSR 4120R2.0 12100	D12R2x26x36xL100xSD12	12	2.00	26	36	11.6	-	100	12	B	●

ACSR 5 刃圆鼻铣刀

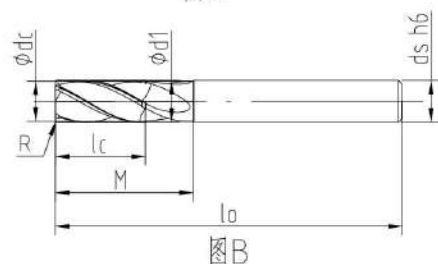
ACSR 5-flute with Corner Radius



- 专为加工钛合金与不锈钢材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合;
- 采用特殊几何形状槽型设计, 提高排屑顺畅性, 快速散热。
- Designed for machining titanium alloy and stainless steel materials;
- The newly developed coating has excellent oxidation resistance, red hardness, and outstanding wear resistance combined with toughness;
- Special geometry for flute design, improving chip breaking smoothness and fast heat dissipation.



图A



图B

刃径 ϕdc	ϕdc Tolerance	刃径 ϕdc	R Tolerance
$\phi \leq 8$	0 ~ -0.020	$\phi \leq 6$	± 0.03
$8 < \phi \leq 12$	0 ~ -0.025	$\phi > 6$	± 0.05
$12 < \phi \leq 25$	0 ~ -0.030		

适合加工材料: M、S

Suitable for materials: M、S

M S

订货编号 · Order code

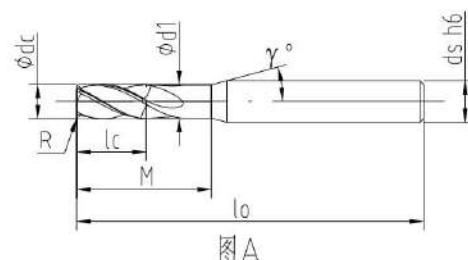
代码 · Code	规格型号 · Designation	刃径 · ϕc	圆角半径 · R	刃长 · lc	有效长 · M	柄径 · $d1$	柄锥角度 · γ°	全长 · lo	柄径 · ds	图示 · Diagram	库存
ACSR 5060R0.5 0650	D6R0.5x13x20xL50xSD6	6	0.50	13	20	5.7	-	50	6	B	●
ACSR 5060R0.5 0660	D6R0.5x13x20xL60xSD6	6	0.50	13	20	5.7	-	60	6	B	●
ACSR 5060R0.5 0675	D6R0.5x13x20xL75xSD6	6	0.50	13	20	5.7	-	75	6	B	●
ACSR 5080R0.5 0860	D8R0.5x19x25xL60xSD8	8	0.50	19	25	7.7	-	60	8	B	●
ACSR 5080R0.5 0875	D8R0.5x19x25xL75xSD8	8	0.50	19	25	7.7	-	75	8	B	●
ACSR 5080R0.5 08100	D8R0.5x19x25xL100xSD8	8	0.50	19	25	7.7	-	100	8	B	●
ACSR 5100R0.5 1075	D10R0.5x22x30xL75xSD10	10	0.50	22	30	9.7	-	75	10	B	●
ACSR 5100R0.5 10100	D10R0.5x22x30xL100xSD10	10	0.50	22	30	9.7	-	100	10	B	●
ACSR 5120R0.5 1275	D12R0.5x26x36xL75xSD12	12	0.50	26	36	11.6	-	75	12	B	●
ACSR 5120R0.5 12100	D12R0.5x26x36xL100xSD12	12	0.50	26	36	11.6	-	100	12	B	●
ACSR 5160R0.5 16100	D16R0.5x32x42xL100xSD16	16	0.50	32	42	15.6	-	100	16	B	●
ACSR 5160R0.5 16150	D16R0.5x32x42xL150xSD16	16	0.50	32	42	15.6	-	150	16	B	●
ACSR 5200R0.5 20100	D20R0.5x40x52xL100xSD20	20	0.50	40	52	19.6	-	100	20	B	●
ACSR 5200R0.5 20150	D20R0.5x40x52xL150xSD20	20	0.50	40	52	19.6	-	150	20	B	●
ACSR 5250R0.5 25120	D25R0.5x50x65xL120xSD25	25	0.50	50	65	24.5	-	120	25	B	●
ACSR 5060R1.0 0650	D6R1x13x20xL50xSD6	6	1.00	13	20	5.7	-	50	6	B	●
ACSR 5060R1.0 0660	D6R1x13x20xL60xSD6	6	1.00	13	20	5.7	-	60	6	B	●
ACSR 5060R1.0 0675	D6R1x13x20xL75xSD6	6	1.00	13	20	5.7	-	75	6	B	●
ACSR 5080R1.0 0860	D8R1x19x25xL60xSD8	8	1.00	19	25	7.7	-	60	8	B	●
ACSR 5080R1.0 0875	D8R1x19x25xL75xSD8	8	1.00	19	25	7.7	-	75	8	B	●
ACSR 5080R1.0 08100	D8R1x19x25xL100xSD8	8	1.00	19	25	7.7	-	100	8	B	●
ACSR 5100R1.0 1075	D10R1x22x30xL75xSD10	10	1.00	22	30	9.7	-	75	10	B	●
ACSR 5100R1.0 10100	D10R1x22x30xL100xSD10	10	1.00	22	30	9.7	-	100	10	B	●
ACSR 5120R1.0 1275	D12R1x26x36xL75xSD12	12	1.00	26	36	11.6	-	75	12	B	●

ACSR 5 刃圆鼻铣刀

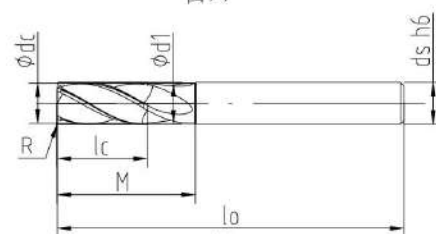
ACSR 5-flute with Corner Radius



- 专为加工钛合金与不锈钢材料设计;
- 新开发的涂层具有优异的抗氧化性能、红硬性以及突出的耐磨性能与韧性相结合;
- 采用特殊几何形状槽型设计, 提高排屑顺畅性, 快速散热。
- Designed for machining titanium alloy and stainless steel materials;
- The newly developed coating has excellent oxidation resistance, red hardness, and outstanding wear resistance combined with toughness;
- Special geometry for flute design, improving chip breaking smoothness and fast heat dissipation.



图A



图B

刃径 ϕ_{dc}	ϕ_{dc} Tolerance	刃径 ϕ_{dc}	R Tolerance
$\phi \leq 8$	0 ~ -0.020	$\phi \leq 6$	± 0.03
$8 < \phi \leq 12$	0 ~ -0.025	$\phi > 6$	± 0.05
$12 < \phi \leq 25$	0 ~ -0.030		

适合加工材料: M、S

Suitable for materials: M、S

M S

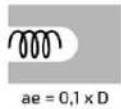
订货编号 · Order code

代码 · Code	规格型号 · Designation	刃径 · ϕ_{dc}	圆角半径 · R	刃长 · lc	有效长 · M	颈径 · $d1$	柄锥角度 · γ°	全长 · lo	柄径 · ds	图示 · Diagram	库存
ACSR 5120R1.0 12100	D12R1x26x36xL100xSD12	12	1.00	26	36	11.6	-	100	12	B	●
ACSR 5160R1.0 16100	D16R1x32x42xL100xSD16	16	1.00	32	42	15.6	-	100	16	B	●
ACSR 5160R1.0 16150	D16R1x32x42xL150xSD16	16	1.00	32	42	15.6	-	150	16	B	●
ACSR 5200R1.0 20100	D20R1x40x52xL100xSD20	20	1.00	40	52	19.6	-	100	20	B	●
ACSR 5200R1.0 20150	D20R1x40x52xL150xSD20	20	1.00	40	52	19.6	-	150	20	B	●
ACSR 5250R1.0 25120	D25R1x50x65xL120xSD25	25	1.00	50	65	24.5	-	120	25	B	●
ACSR 5100R2.0 1075	D10R2x22x30xL75xSD10	10	2.00	22	30	9.7	-	75	10	B	●
ACSR 5100R2.0 10100	D10R2x22x30xL100xSD10	10	2.00	22	30	9.7	-	100	10	B	●
ACSR 5120R2.0 1275	D12R2x26x36xL75xSD12	12	2.00	26	36	11.6	-	75	12	B	●
ACSR 5120R2.0 12100	D12R2x26x36xL100xSD12	12	2.00	26	36	11.6	-	100	12	B	●
ACSR 5160R2.0 16100	D16R2x32x42xL100xSD16	16	2.00	32	42	15.6	-	100	16	B	●
ACSR 5160R2.0 16150	D16R2x32x42xL150xSD16	16	2.00	32	42	15.6	-	150	16	B	●
ACSR 5200R2.0 20100	D20R2x40x52xL100xSD20	20	2.00	40	52	19.6	-	100	20	B	●
ACSR 5200R2.0 20150	D20R2x40x52xL150xSD20	20	2.00	40	52	19.6	-	150	20	B	●
ACSR 5250R2.0 25120	D25R2x50x65xL120xSD25	25	2.00	50	65	24.5	-	120	25	B	●
ACSR 5100R3.0 1075	D10R3x22x30xL75xSD10	10	3.00	22	30	9.7	-	75	10	B	●
ACSR 5100R3.0 10100	D10R3x22x30xL100xSD10	10	3.00	22	30	9.7	-	100	10	B	●
ACSR 5120R3.0 1275	D12R3x26x36xL75xSD12	12	3.00	26	36	11.6	-	75	12	B	●
ACSR 5120R3.0 12100	D12R3x26x36xL100xSD12	12	3.00	26	36	11.6	-	100	12	B	●
ACSR 5160R3.0 16100	D16R3x32x42xL100xSD16	16	3.00	32	42	15.6	-	100	16	B	●
ACSR 5160R3.0 16150	D16R3x32x42xL150xSD16	16	3.00	32	42	15.6	-	150	16	B	●
ACSR 5200R3.0 20100	D20R3x40x52xL100xSD20	20	3.00	40	52	19.6	-	100	20	B	●
ACSR 5200R3.0 20150	D20R3x40x52xL150xSD20	20	3.00	40	52	19.6	-	150	20	B	●
ACSR 5250R3.0 25120	D25R3x50x65xL120xSD25	25	3.00	50	65	24.5	-	120	25	B	●

切削参数

Cutting Parameters

ACSEC/ACSR-Z4

铣削方式 Milling Type	示意图 Diagram									
	铣削方式 Milling Type	槽铣 Slot Milling			侧铣 Side milling			摆线铣 Cycloidal milling		
被加工材料 Workpiece materials	线速度 Linear velocity	Vc=140m/min			Vc=130m/min			Vc=170m/min		
	直径 Diameter	fz	F	n	fz	F	n	fz	F	n
	mm	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹
铁素体不锈钢 Ferrite stainless steel	3	0.013	772	14854	0.013	717	13793	0.02	1443	18038
	4	0.02	891	11141	0.02	828	10345	0.06	3247	13528
	6	0.03	891	7427	0.03	828	6897	0.13	4690	9019
	8	0.04	891	5570	0.04	828	5173	0.16	4329	6764
	10	0.05	891	4456	0.05	828	4138	0.19	4113	5411
	12	0.06	891	3714	0.06	828	3448	0.22	3968	4509
	16	0.07	780	2785	0.07	724	2586	0.25	3382	3382
	20	0.08	713	2228	0.08	662	2069	0.3	3247	2706

被加工材料 Workpiece materials	线速度 Linear velocity	Vc=120m/min			Vc=110m/min			Vc=150m/min		
	直径 Diameter	fz	F	n	fz	F	n	fz	F	n
	mm	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹
奥氏体不锈钢 Austenitic steel	3	0.013	772	14854	0.013	717	13793	0.02	1443	18038
	4	0.02	891	11141	0.02	828	10345	0.06	3247	13528
	6	0.03	891	7427	0.03	828	6897	0.13	4690	9019
	8	0.04	891	5570	0.04	828	5173	0.16	4329	6764
	10	0.05	891	4456	0.05	828	4138	0.19	4113	5411
	12	0.06	891	3714	0.06	828	3448	0.22	3968	4509
	16	0.07	780	2785	0.07	724	2586	0.25	3382	3382
	20	0.08	713	2228	0.08	662	2069	0.3	3247	2706

被加工材料 Workpiece materials	线速度 Linear velocity	Vc=80m/min			Vc=80m/min			Vc=100m/min		
	直径 Diameter	fz	F	n	fz	F	n	fz	F	n
	mm	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹
钛合金 Titanium alloy	3	0.004	136	8488	0.011	373	8488	0.02	849	10610
	4	0.006	153	6366	0.015	382	6366	0.06	1910	7958
	6	0.009	153	4244	0.023	390	4244	0.13	2759	5305
	8	0.012	153	3183	0.03	382	3183	0.16	2546	3979
	10	0.015	153	2546	0.04	407	2546	0.19	2419	3183
	12	0.02	170	2122	0.05	424	2122	0.22	2334	2653
	16	0.03	191	1592	0.06	382	1592	0.25	1989	1989
	20	0.04	204	1273	0.075	382	1273	0.3	1910	1592

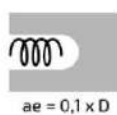
切削参数

Cutting Parameters

被加工材料 Workpiece materials	线速度 Linear velocity	Vc=195m/min			Vc=210m/min			Vc=220m/min		
	直径 Diameter	fz	F	n	fz	F	n	fz	F	n
	mm	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹
钢 < 800N/mm ² Steel < 1000N/mm ²	3	0.008	662	20690	0.008	713	22282	0.02	1867	23343
	4	0.012	745	15518	0.012	802	16711	0.06	4202	17507
	6	0.02	828	10345	0.02	891	11141	0.13	6069	11671
	8	0.03	931	7759	0.03	1003	8356	0.16	5602	8754
	10	0.04	993	6207	0.04	1070	6685	0.19	5322	7003
	12	0.05	1035	5173	0.05	1114	5570	0.22	5135	5836
	16	0.06	931	3879	0.06	1050	4178	0.25	4377	4377
	20	0.07	869	3104	0.07	936	3342	0.3	4202	3501

被加工材料 Workpiece materials	线速度 Linear velocity	Vc=140m/min			Vc=150m/min			Vc=180m/min		
	直径 Diameter	fz	F	n	fz	F	n	fz	F	n
	mm	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹
钢 < 1000N/mm ² Steel < 1000N/mm ²	3	0.008	475	14854	0.008	509	15915	0.02	1528	19099
	4	0.012	535	11141	0.012	573	11937	0.06	3438	14324
	6	0.02	594	7427	0.02	637	7958	0.13	4966	9549
	8	0.03	668	5570	0.03	716	5968	0.16	4584	7162
	10	0.04	713	4456	0.04	764	4775	0.19	4354	5730
	12	0.05	743	3714	0.05	796	3979	0.22	4202	4775
	16	0.06	668	2785	0.06	716	2984	0.25	3581	3581
	20	0.07	624	2228	0.07	668	2387	0.3	3438	2865

ACSEC/ACSR-Z5

铣削方式 Milling Type	示意图									
	铣削方式	槽铣			侧铣			摆线铣		
被加工材料 Workpiece materials	线速度 Linear velocity	Vc=130m/min			Vc=130m/min			Vc=170m/min		
	直径 Diameter	fz	F	n	fz	F	n	fz	F	n
	mm	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹
铁素体不锈钢 Ferrite stainless steel	6	0.015	517	6897	0.03	1035	6897	0.13	5862	9019
	8	0.025	647	5173	0.04	1035	5173	0.16	5411	6764
	10	0.035	724	4138	0.05	1035	4138	0.19	5141	5411
	12	0.045	776	3448	0.06	1035	3448	0.22	4960	4509
	16	0.055	711	2586	0.07	905	2586	0.25	4228	3382
	20	0.06	621	2069	0.08	828	2069	0.3	4058	2706

切削参数

Cutting Parameters

被加工材料 Workpiece materials	线速度 Linear velocity	Vc=110m/min			Vc=110m/min			Vc=150m/min		
	直径 Diameter	fz	F	n	fz	F	n	fz	F	n
	mm	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹
奥氏体不锈钢 Austenitic Steel	6	0.015	438	5836	0.03	875	5836	0.13	5173	7958
	8	0.025	547	4377	0.04	875	4377	0.16	4775	5968
	10	0.035	613	3501	0.05	875	3501	0.19	4536	4775
	12	0.045	657	2918	0.06	875	2918	0.22	4277	3979
	16	0.055	602	2188	0.07	766	2188	0.25	3730	2984
	20	0.06	525	1751	0.08	700	1751	0.3	3581	2387

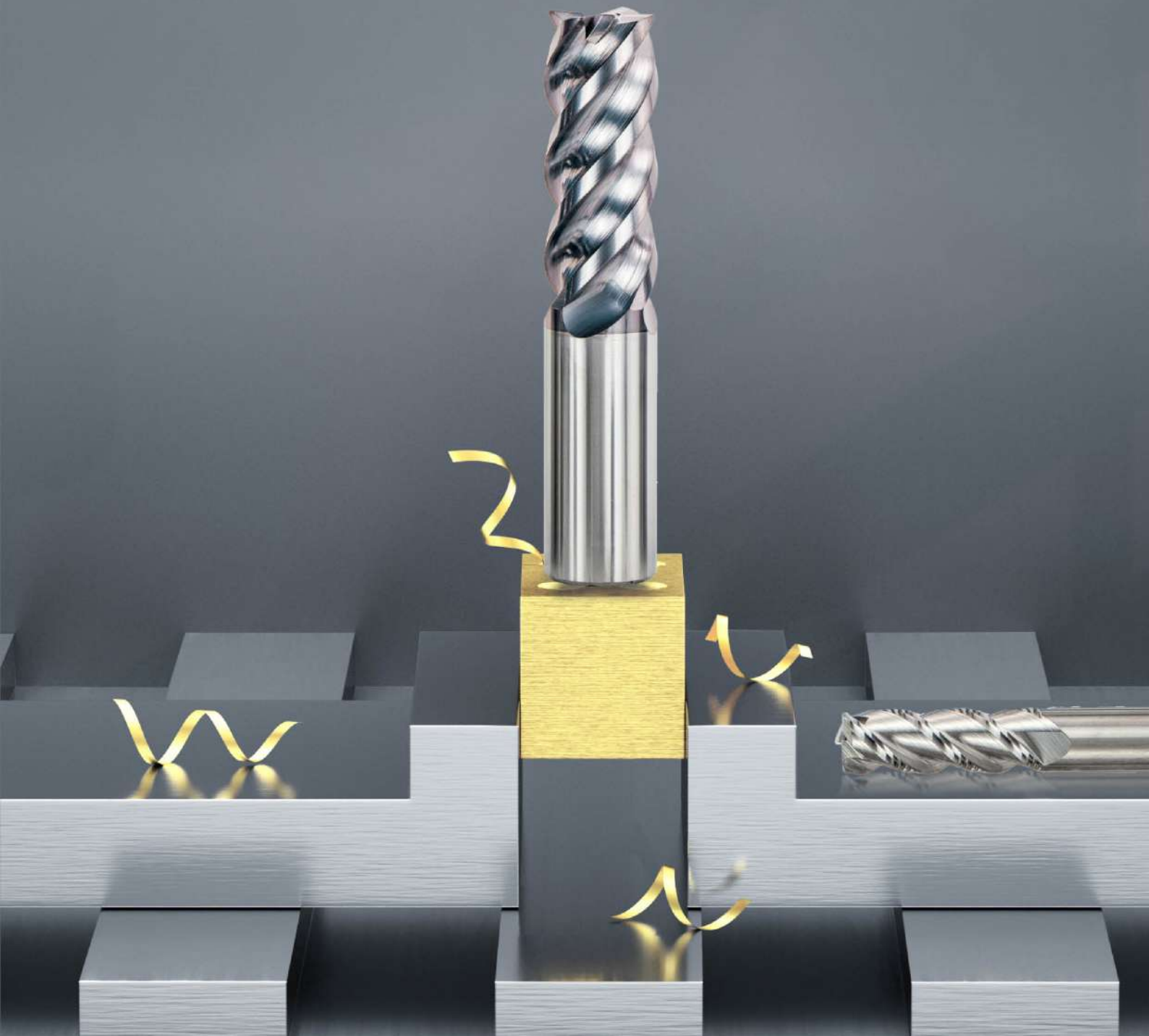
被加工材料 Workpiece materials	线速度 Linear velocity	Vc=80m/min			Vc=80m/min			Vc=80m/min		
	直径 Diameter	fz	F	n	fz	F	n	fz	F	n
	mm	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹
钛合金 Titanium Alloy	6	0.06	127	4244	0.023	477	4244	0.13	2759	4244
	8	0.08	127	3183	0.03	477	3183	0.16	2546	3183
	10	0.01	127	2546	0.04	509	2546	0.19	2419	2546
	12	0.012	127	2122	0.05	531	2122	0.22	2334	2122
	16	0.016	127	1592	0.06	477	1592	0.25	1989	1592
	20	0.024	153	1273	0.07	446	1273	0.3	1910	1273

被加工材料 Workpiece materials	线速度 Linear velocity	Vc=170m/min			Vc=195m/min			Vc=220m/min		
	直径 Diameter	fz	F	n	fz	F	n	fz	F	n
	mm	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹
钢 < 800N/mm ² Steel < 1000N/mm ²	6	0.02	902	9019	0.03	1552	10345	0.13	7586	11671
	8	0.03	1051	6764	0.04	1552	7759	0.16	7003	8754
	10	0.04	1082	5411	0.05	1552	6207	0.19	6653	7003
	12	0.045	1015	4509	0.06	1552	5173	0.22	6419	5836
	16	0.055	930	3382	0.068	1319	3879	0.25	5471	4377
	20	0.065	879	2706	0.075	1164	3104	0.3	5252	3501

被加工材料 Workpiece materials	线速度 Linear velocity	Vc=130m/min			Vc=150m/min			Vc=180m/min		
	直径 Diameter	fz	F	n	fz	F	n	fz	F	n
	mm	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹	mm/z	mm/min	min ⁻¹
钢 < 1000N/mm ²	6	0.02	690	6987	0.03	1194	7958	0.13	6207	9549
	8	0.03	776	5173	0.04	1194	5968	0.16	5730	7162
	10	0.04	828	4138	0.05	1194	4775	0.19	5443	5730
	12	0.045	776	3448	0.06	1194	3979	0.22	5252	4775
	16	0.055	711	2586	0.068	1015	2984	0.25	4476	3581
	20	0.065	621	2069	0.075	895	2387	0.3	4297	2865

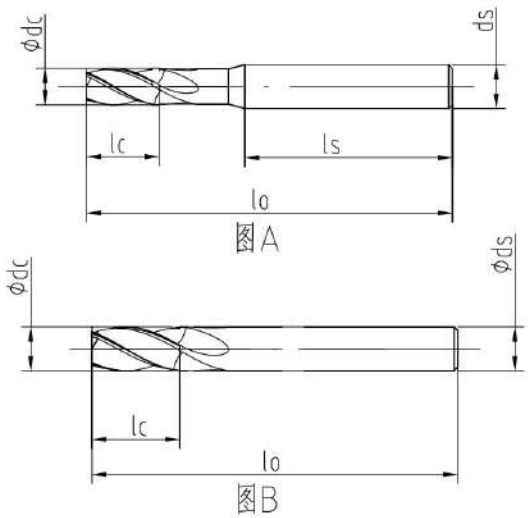
***END MILLS FOR STEEL
CAST IRON AND ALUMINUM***

钢件铸铁铣刀、铝用铣刀 >>>



通用 4 刃平头铣刀

Universal 4-flute End Mills



- 适用于普通钢件和铸铁，粗加工和精加工
- 采用高性能涂层，耐高温，耐磨损
- Suitable for ordinary steel and cast iron, roughing and finishing
- Use high performance coating, high temperature and wear resistance

适合加工材料：P、K

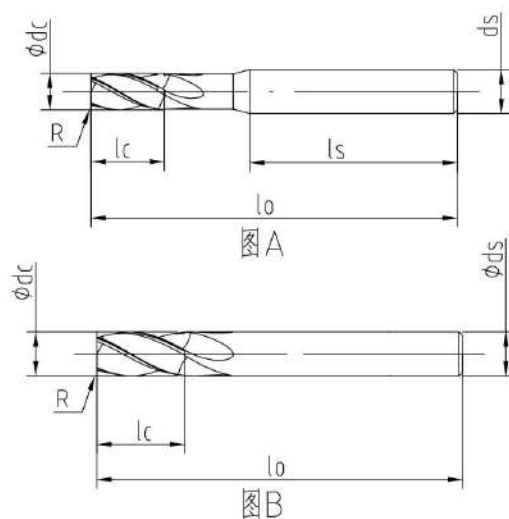
Suitable for materials: P、K

P K

规格型号 Designation	刃径 dc	刃长 lc	全长 lo	柄径 ds	图示·Diagram
D1.0x3x50xSD4	1	3	50	4	A
D1.5x4x50xSD4	1.5	4	50	4	A
D2.0x6x50xSD4	2	6	50	4	A
D2.5x6x50xSD4	2.5	6	50	4	A
D3.0x8x50xSD4	3	8	50	4	A
D4.0x10x50xSD4	4	10	50	4	B
D6.0x15x50xSD6	6	15	50	6	B
D8.0x20x60xSD8	8	20	60	8	B
D10.0x30x75xSD10	10	30	75	10	B
D12.0x30x75xSD12	12	30	75	12	B
D14.0x35x100xSD14	14	35	100	14	B
D16.0x45x100xSD16	16	45	100	16	B
D20.0x50x100xSD20	20	50	100	20	B

通用 4 刃圆鼻铣刀

Universal 4-flute with Corner Radius



- 适用于普通钢件和铸铁，粗加工和精加工
- 采用高性能涂层，耐高温，耐磨损
- Suitable for ordinary steel and cast iron, roughing and finishing
- Use high performance coating, high temperature and wear resistance

适合加工材料：P、K

Suitable for materials: P、K

P K

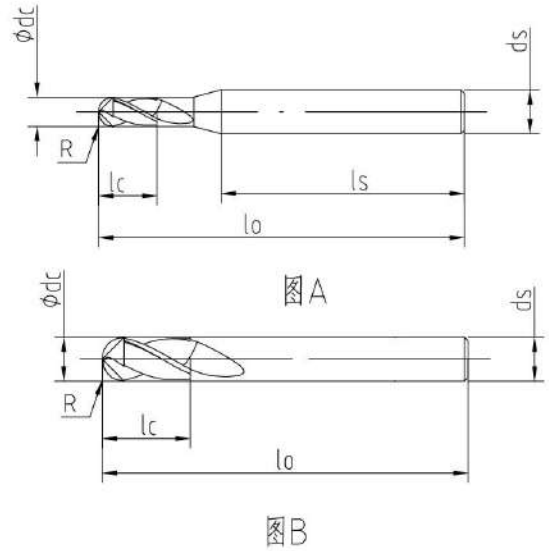
规格型号 Designation	刃径 d_c	圆角半径 r	刃长 l_c	全长 l_o	柄径 d_s	图示·Diagram
D1.0xR0.2x3x50xSD4	1	0.2	3	50	4	A
D1.5xR0.2x4x50xSD4	1.5	0.2	4	50	4	A
D2.0xR0.2x6x50xSD4	2	0.2	6	50	4	A
D3.0xR0.2x8x50xSD3	3	0.2	8	50	3	A
D4.0xR0.5x10x50xSD4	4	0.5	10	50	4	B
D6.0xR0.5x16x50xSD6	6	0.5	16	50	6	B
D8.0xR0.5x20x60xSD8	8	0.5	20	60	8	B
D10.0xR0.5x25x75xSD10	10	0.5	25	75	10	B
D12.0xR0.5x30x75xSD12	12	0.5	30	75	12	B

通用 2 刃球头铣刀

Universal 2-flute Ball-nose End Mills



- 适用于普通钢件和铸铁，粗加工和精加工
- 采用高性能涂层，耐高温，耐磨损
- Suitable for ordinary steel and cast iron, roughing and finishing
- Use high performance coating, high temperature and wear resistance



适合加工材料：P、K Suitable for materials: P、K

P K

规格型号 Designation	刃径 d_c	圆角半径 r	刃长 l_c	全长 l_o	柄径 d_s	图示·Diagram
R0.5x2x50xSD4	1	0.5	2	50	4	A
R0.75x3x50xSD4	1.5	0.75	3	50	4	A
R1x4x50xSD4	2	1	4	50	4	A
R1.25x5x50xSD4	2.5	1.25	5	50	4	A
R1.5x6x50xSD4	3	1.5	6	50	4	A
R2x8x50xSD4	4	2	8	50	4	B
R3x12x50xSD6	6	3	12	50	6	B
R4x16x60xSD8	8	4	16	60	8	B
R5x20x75xSD10	10	5	20	75	10	B
R6x24x75xSD12	12	6	24	75	12	B
R8x32x100xSD16	16	8	32	100	16	B
R10x40x100xSD20	20	10	40	100	20	B

铝用 3 刃平头铣刀

Aluminum 3-flute End Mills

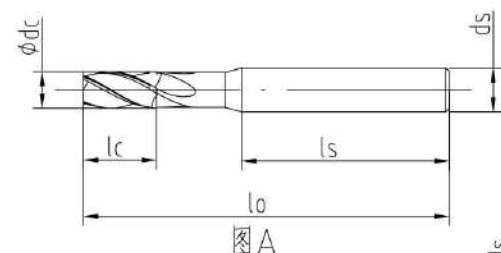


图 A

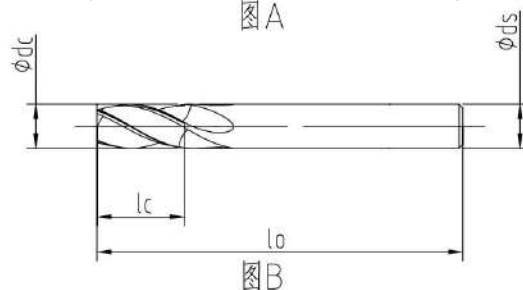


图 B

- 高效能铝用铣刀，高金属去除率及高要求的外观效果
- 特殊刃型设计，有效防止震动和解决刃口粘屑问题
- High performance end mills for aluminum with high metal removal rate and high appearance requirements
- Special edge design, effectively prevent vibration and solve the problem of sticky chips on the cutting edge

适合加工材料：N

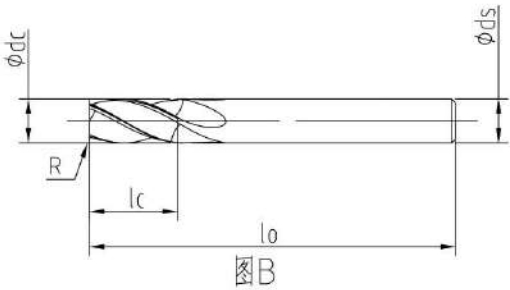
Suitable for materials: N

N

规格型号 Designation	刃径 dc	刃长 lc	全长 lo	柄径 ds	图示·Diagram
D1.0x3x50xSD4	1	3	50	4	A
D1.5x4x50xSD4	1.5	4	50	4	A
D2.0x6x50xSD4	2	6	50	4	A
D3.0x8x50xSD4	3	8	50	4	A
D4.0x12x50xSD4	4	12	50	4	B
D6.0x18x50xSD6	6	18	50	6	B
D8.0x20x60xSD8	8	20	60	8	B
D10.0x30x75xSD10	10	30	75	10	B
D12.0x30x75xSD12	12	30	75	12	B

铝用 3 刃圆鼻铣刀

Aluminum 3-flute with Corner Radius



- 高效能铝用铣刀，高金属去除率及高要求的外观效果
- 特殊刃型设计，有效防止震动和解决刃口粘屑问题
- High performance end mills for aluminum with high metal removal rate and high appearance requirements
- Special edge design, effectively prevent vibration and solve the problem of sticky chips on the cutting edge

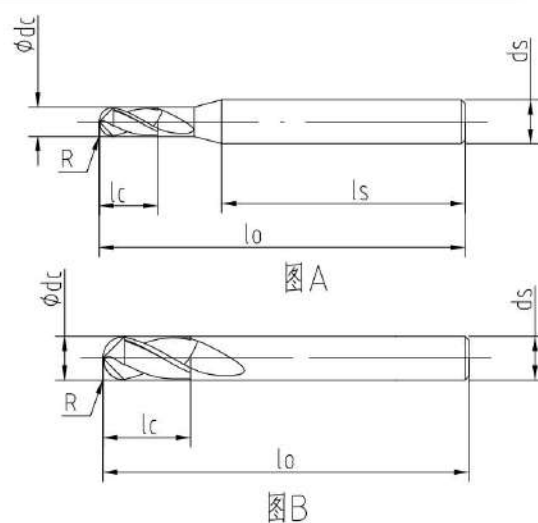
适合加工材料 : N Suitable for materials: N

N

规格型号 Designation	刃径 dc	圆角半径 r	刃长 lc	全长 lo	柄径 ds	图示·Diagram
D4.0xR0.5x10x50xSD4	4	0.5	10	50	4	B
D6.0xR0.5x16x50xSD6	6	0.5	16	50	6	B
D8.0xR0.5x20x60xSD8	8	0.5	20	60	8	B
D10.0xR0.5x25x75xSD10	10	0.5	25	75	10	B
D12.0xR0.5x30x75xSD12	12	0.5	30	75	12	B

铝用 2 刃球头铣刀

Aluminum 2-flute Ball-nose End Mills



- 高效能铝用铣刀，高金属去除率及高要求的外观效果
- 特殊刃型设计，有效防止震动和解决刃口粘屑问题
- High performance end mills for aluminum with high metal removal rate and high appearance requirements
- Special edge design, effectively prevent vibration and solve the problem of sticky chips on the cutting edge

适合加工材料：N

Suitable for materials: N

N

规格型号 Designation	刃径 dc	圆角半径 r	刃长 lc	全长 lo	柄径 ds	图示·Diagram
R0.5x2x50xSD4	1	0.5	2	50	4	A
R1x4x50xSD4	2	1	4	50	4	A
R1.5x6x50xSD4	3	1.5	6	50	4	A
R2x8x50xSD4	4	2	8	50	4	B
R3x12x50xSD6	6	3	12	50	6	B
R4x16x60xSD8	8	4	16	60	8	B
R5x20x75xSD10	10	5	20	75	10	B
R6x24x75xSD12	12	6	24	75	12	B

切削参数

Cutting Parameters

通用系列·平头铣刀 槽铣 Universal Series·End Mills Slot Milling

加工材料 Workpiece material	铸铁、碳素钢 Cast iron, carbon steel S50C、HT250、Q235(-HRC22)				合金钢、工具钢 Alloyed steel, tool steel P20、H13、D2(HRC25-35)				铜 Copper C11000、B152			
型号 Designation	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm
D1	9000-10000	600-800	0.03-0.05	1	8000-9000	500-800	0.03-0.05	1	10000-12000	800-1000	0.05-0.08	1
D1.5	9000-10000	600-800	0.03-0.05	1.5	8000-9000	500-800	0.03-0.05	1.5	10000-12000	800-1000	0.05-0.08	1.5
D2	8700-9200	800-1200	0.05-0.08	2	7500-8000	700-1000	0.05-0.08	2	9000-10000	1000-1400	0.08-0.1	2
D2.5	8700-9200	800-1200	0.05-0.08	2.5	7500-8000	700-1000	0.05-0.08	2.5	9000-10000	1000-1400	0.08-0.1	2.5
D3	7500-8000	1000-1400	0.08-0.1	3	7000-7500	800-1200	0.08-0.1	3	8500-9000	1400-1600	0.1-0.12	3
D4	5700-6200	1200-1600	0.1-0.15	4	5000-5500	1000-1400	0.1-0.15	4	7000-8500	1600-1800	0.15-0.2	4
D6	4000-4500	1400-1800	0.15-0.2	6	4000-4500	1400-1600	0.15-0.2	6	5000-5500	1800-2000	0.2-0.25	6
D8	2700-3200	1800-2000	0.25-0.35	8	2700-3200	1600-1800	0.2-0.25	8	4500-5000	2000-2200	0.3-0.45	8
D10	2500-3000	2000-2200	0.4-0.5	10	2200-2700	1800-2000	0.25-0.3	10	3500-4500	2200-2500	0.5-0.6	10
D12	2200-2800	2200-2500	0.5-0.65	12	2000-2200	2000-2200	0.35-0.45	12	3000-3500	1800-2000	0.6-0.75	12
D14	2000-2500	1000-1200	0.5-0.7	14	2000-2200	1000-1200	0.4-0.5	14	2800-3000	1500-1800	0.65-0.8	14
D16	1800-2300	800-1000	0.65-0.8	16	1500-2000	600-800	0.45-0.55	16	2500-2800	1000-1500	0.75-0.9	16
D20	1300-1800	500-800	0.8-1	20	1300-1800	400-600	0.55-0.65	20	2000-2500	800-1000	1-1.2	20

通用系列·平头铣刀 侧铣 Universal Series·End Mills Side milling

加工材料 Workpiece material	铸铁、碳素钢 Cast iron, carbon steel S50C、HT250、Q235(-HRC22)				合金钢、工具钢 Alloyed steel, tool steel P20、H13、D2(HRC25-35)				热处理钢 Heat-treated steel SKD11、SKH51(HRC55-65)			
型号 Designation	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm
D1	18000-20000	600-800	1-1.5	0.03-0.05	15000-18000	600-800	1-1.5	0.03-0.05	20000-22000	800-1000	1-1.5	0.05-0.08
D1.5	18000-20000	600-800	1-1.5	0.03-0.05	15000-18000	600-800	1-1.5	0.03-0.05	20000-22000	800-1000	1-1.5	0.05-0.08
D2	13000-15000	800-1000	2-3	0.04-0.06	12000-13000	650-850	2-3	0.04-0.06	15000-18000	1000-1200	2-3	0.08-0.1
D2.5	13000-15000	800-1000	2-3	0.04-0.06	12000-13000	650-850	2-3	0.04-0.06	15000-18000	1000-1200	2-3	0.08-0.1
D3	10000-12000	800-1000	3-4.5	0.08-1.2	8000-10000	700-900	3-4.5	0.08-1.2	12000-14000	1200-1400	3-4.5	0.1-0.15
D4	8000-10000	900-1200	4-6	0.15-0.2	7000-8000	800-1000	4-6	0.15-0.2	10000-12000	1400-1600	4-6	0.15-0.2
D6	5000-6000	1300-1500	6-9	0.3-0.5	4500-5500	1000-1200	6-9	0.25-0.35	6500-8000	1600-1800	6-9	0.3-0.5
D8	4200-4500	1400-1600	8-12	0.5-0.8	4000-4200	1200-1400	8-12	0.35-0.45	5200-6500	1800-2000	8-12	0.5-0.8
D10	3000-3500	1600-1800	10	0.8-0.1	3000-3200	1400-1600	10	0.45-0.6	3800-4200	2000-2500	10	0.8-1
D12	2500-3000	1000-1400	12	1-1.2	2200-2600	800-1200	12	0.6-0.7	3000-3500	1800-2000	12	1-1.2
D14	2200-2500	800-1000	14	1-1.2	2000-2200	600-800	14	0.6-0.7	2500-2800	1000-1200	14	1-1.2
D16	2000-2200	600-800	16	1-1.5	1800-2000	500-600	16	0.7-0.8	2200-2500	800-1000	16	1-1.5
D20	1500-2000	500-600	20	1-1.5	1300-1800	400-500	20	0.8-1	2000-2500	600-800	20	1-1.5

切削参数

Cutting Parameters

通用系列·圆鼻铣刀 槽铣 Universal Series·End Mills with Corner Radius Slot Milling

加工材料 Workpiece material	铸铁、碳素钢 Cast iron, carbon steel S50C、HT250、Q235(-HRC22)				合金钢、工具钢 Alloyed steel, tool steel P20、H13、D2(HRC25-35)				热处理钢 Heat-treated steel SKD11、SKH51(HRC55-65)			
型号 Designation	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm
D1R0.2	12500-15000	800-1200	0.03-0.05	1	10000-12500	600-1000	0.03-0.05	1	15000-18000	1000-1200	0.05-0.08	1
D1.5R0.2	12500-15000	800-1200	0.03-0.05	1.5	10000-12500	600-1000	0.03-0.05	1.5	15000-18000	1000-1200	0.05-0.08	1.5
D2.0R0.2	10000-12500	1000-1400	0.05-0.08	2	8500-10000	800-1200	0.05-0.08	2	13000-15000	1200-1400	0.08-0.1	2
D3R0.2	8500-10000	1200-1600	0.08-0.1	3	7500-8500	1000-1400	0.08-0.1	3	10000-12000	1400-1600	0.1-0.12	3
D4R0.5	8000-8500	1600-1800	0.1-0.15	4	6500-7500	1400-1600	0.1-0.13	4	8500-10000	1600-2000	0.15-0.2	4
D6R0.5	5500-6500	1800-2000	0.15-0.2	6	5000-6000	1600-1800	0.13-0.15	6	6500-8000	2000-2200	0.2-0.25	6
D8R0.5	5000-5500	2000-2200	0.25-0.35	8	4500-5000	1800-2000	0.15-0.2	8	5500-6500	2200-2500	0.3-0.45	8
D10R0.5	4000-4500	2200-2400	0.4-0.5	10	3500-4000	2000-2200	0.25-0.35	10	4500-5500	2500-2800	0.5-0.6	10
D12R0.5	3000-3500	2400-2500	0.5-0.65	12	2800-3200	2200-2400	0.35-0.5	12	3500-4000	2600-3000	0.6-0.75	12

通用系列·圆鼻铣刀 仿形铣 Universal Series·End Mills with Corner Radius Profiling Milling

加工材料 Workpiece material	铸铁、碳素钢 Cast iron, carbon steel S50C、HT250、Q235(-HRC22)				合金钢、工具钢 Alloyed steel, tool steel P20、H13、D2(HRC25-35)				热处理钢 Heat-treated steel SKD11、SKH51(HRC55-65)			
型号 Designation	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm
D1R0.2	18000-20000	800-1000	0.02-0.03	0.02-0.03	16000-18000	650-850	0.02-0.03	0.02-0.03	20000-22000	1000-1200	0.02-0.03	0.02-0.03
D1.5R0.2	18000-20000	800-1000	0.02-0.03	0.02-0.03	16000-18000	650-850	0.02-0.03	0.02-0.03	20000-22000	1000-1200	0.02-0.03	0.02-0.03
D2.0R0.2	15000-18000	1000-1200	0.03-0.04	0.03-0.04	13000-15000	850-1000	0.03-0.04	0.03-0.04	18000-20000	1200-1400	0.03-0.04	0.03-0.04
D3R0.2	13000-15000	1200-1400	0.03-0.05	0.03-0.05	11000-13000	1000-1200	0.04-0.05	0.03-0.05	15000-18000	1400-1600	0.04-0.05	0.03-0.05
D4R0.5	10000-12000	1500-1800	0.05-0.08	0.05-0.08	8500-10000	1200-1500	0.05-0.08	0.05-0.08	12000-15000	1600-1800	0.05-0.08	0.05-0.08
D6R0.5	7000-8000	1800-2000	0.05-0.1	0.05-0.1	6000-7000	1500-1800	0.05-0.1	0.05-0.1	8500-10000	2000-2200	0.05-0.1	0.05-0.1
D8R0.5	6500-7500	1800-2200	0.05-0.12	0.05-0.12	5500-6000	1800-2000	0.08-0.15	0.08-0.12	7000-7500	2200-2500	0.08-0.15	0.08-0.12
D10R0.5	5500-6500	2200-2500	0.05-0.15	0.05-0.15	5000-6000	2000-2300	0.1-0.15	0.08-0.15	6000-7000	2500-2800	0.1-0.15	0.08-0.15
D12R0.5	4500-5500	2500-2800	0.08-0.2	0.08-0.2	4000-5000	2300-2500	0.1-0.2	0.1-0.15	5000-6000	2800-3000	0.1-0.2	0.1-0.15

切削参数

Cutting Parameters

通用系列·球头铣刀 仿形铣 Universal Series·End Mills with Ball-nose Profiling Milling

加工材料 Workpiece material	铸铁、碳素钢 Cast iron, carbon steel S50C、HT250、Q235(HRC22)				合金钢、工具钢 Alloyed steel, tool steel P20、H13、D2(HRC25-35)				热处理钢 Heat-treated steel SKD11、SKH51(HRC55-65)			
型号 Designation	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm
R0.5	18000-20000	1000-1200	0.02-0.03	0.03-0.05	15000-18000	800-1000	0.02-0.03	0.03-0.04	20000-22000	1200-1400	0.02-0.03	0.03-0.05
R0.75	18000-20000	1000-1200	0.02-0.03	0.03-0.05	15000-18000	800-1000	0.02-0.03	0.03-0.04	20000-22000	1200-1400	0.02-0.03	0.03-0.05
R1	15000-18000	1200-1400	0.03-0.05	0.05-0.08	13000-15000	1000-1200	0.03-0.04	0.03-0.05	18000-20000	1400-1600	0.03-0.05	0.05-0.08
R1.25	15000-18000	1200-1400	0.03-0.05	0.05-0.08	13000-15000	1000-1200	0.03-0.04	0.03-0.05	18000-20000	1400-1600	0.03-0.05	0.05-0.08
R1.5	15000-18000	1200-1400	0.03-0.05	0.05-0.08	13000-15000	1000-1200	0.03-0.04	0.03-0.05	18000-20000	1400-1600	0.03-0.05	0.05-0.08
R2	12000-15000	1400-1600	0.05-0.08	0.08-0.15	10000-12000	1200-1400	0.04-0.05	0.05-0.08	14000-16000	1600-1800	0.05-0.08	0.08-0.15
R3	10000-12000	1600-2000	0.05-0.1	0.1-0.15	8000-10000	1500-1800	0.05-0.08	0.08-0.1	12000-14000	1800-2000	0.05-0.1	0.1-0.15
R4	8000-10000	2200-2500	0.05-0.12	0.12-0.2	6500-8500	2000-2200	0.05-0.1	0.1-0.12	10000-12000	2200-2500	0.05-0.12	0.12-0.2
R5	6500-8000	2500-2800	0.08-0.15	0.15-0.22	6000-7000	2200-2500	0.08-0.12	0.12-0.15	7500-8500	2500-2800	0.08-0.15	0.15-0.22
R6	6000-7000	2800-3000	0.1-0.15	0.2-0.25	5500-6500	2500-2800	0.08-0.15	0.15-0.2	6500-7500	2800-3000	0.1-0.15	0.2-0.25
R8	5000-6000	2000-2500	0.12-0.18	0.2-0.3	4500-5500	1800-2200	0.1-0.15	0.2-0.25	5500-6500	2200-2500	0.12-0.18	0.2-0.3
R10	4000-5000	1800-2200	0.15-0.2	0.3-0.4	4000-5000	1800-2000	0.1-0.2	0.25-0.3	4500-5500	2000-2200	0.15-0.2	0.3-0.4

铝用系列·平头铣刀 槽铣 Aluminum Series·End Mills Slot Milling

加工材料 Workpiece material	铝合金 Aluminum alloy 5052、6061、7075 普通加工中心 General machining center (10000rpm Max)				铝合金 Aluminum alloy 5052、6061、7075 高速加工中心 High speed machining center (24000rpm Max)			
型号 Designation	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm
D1	9500-10000	900-1200	0.1-0.2	1	23000-24000	1200-1500	0.1-0.2	1
D1.5	9000-9500	1000-1300	0.2-0.4	1.5	21000-22000	1600-1900	0.2-0.4	1.5
D2	9000-9500	1100-1400	0.2-0.5	2	19000-20000	1400-1800	0.2-0.5	2
D3	8500-9000	1200-1600	0.4-0.8	3	18000-19000	1800-2000	0.4-0.8	3
D4	8500-9000	1200-1600	0.5-1	4	17000-18000	1800-2200	0.5-1	4
D6	8500-9000	1500-2000	0.8-2	6	11500-12500	2200-2600	0.8-2	6
D8	7800-8300	1600-2200	1-3	8	11000-12000	2500-2800	1-3	8
D10	7800-8300	2000-2500	2-4	10	9000-9500	2600-3000	2-4	10
D12	5800-6300	2200-2800	3-5	12	7800-8300	2600-3200	3-5	12

切削参数

Cutting Parameters

铝用系列·平头铣刀 侧铣 Aluminum Series·End Mills Side milling

加工材料 Workpiece material	铝合金 Aluminum alloy 5052、6061、7075 普通加工中心 General machining center (10000rpm Max)				铝合金 Aluminum alloy 5052、6061、7075 高速加工中心 High speed machining center (24000rpm Max)			
型号 Designation	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm
D1	9500-10000	800-1000	2	0.1-0.2	23000-24000	1200-1500	2	0.1-0.2
D1.5	9000-9500	1000-1200	2	0.2-0.4	21000-22000	1600-1900	2	0.2-0.4
D2	9000-9500	1100-1400	2	0.2-0.5	19000-20000	1400-1800	2	0.2-0.5
D3	8500-9000	1200-1600	3	0.4-0.8	18000-19000	1600-2000	3	0.4-0.8
D4	8500-9000	1200-1600	4	0.5-1	17000-18000	1800-2200	4	0.5-1
D6	8500-9000	1500-2000	6	0.8-2	11500-12500	2200-2600	6	0.8-2
D8	7800-8300	1600-2200	8	1-3	11000-12000	2500-2800	8	1-3
D10	7800-8300	2000-2500	10	2-4	9000-9500	2600-3000	10	2-4
D12	5800-6300	2200-2800	12	3-5	7800-8300	2600-3200	12	3-5

铝用系列·圆鼻铣刀 槽铣 Aluminum Series·End Mills with Corner Radius Slot Milling

加工材料 Workpiece material	铝合金 Aluminum alloy 5052、6061、7075 普通加工中心 General machining center (10000rpm Max)				铝合金 Aluminum alloy 5052、6061、7075 高速加工中心 High speed machining center (24000rpm Max)			
型号 Designation	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm
D4R0.5	8500-9000	1800-2200	0.5-1	4	14000-15000	2100-2500	0.5-1	4
D6R0.5	8500-9000	1700-2200	0.8-2	6	14000-15000	2400-2800	0.8-2	6
D8R0.5	7800-8300	3000-3500	1-3	8	12000-13000	3500-4000	1-3	8
D10R0.5	7800-8300	3000-3500	2-4	10	10000-11000	3500-4000	2-4	10
D12R0.5	7800-8300	2800-3200	4-8	12	7800-8300	2800-3200	4-8	12

铝用系列·球头铣刀 仿形铣 Aluminum Series·End Mills with Ballnose Profiling Milling

加工材料 Workpiece material	铝合金 Aluminum alloy 5052、6061、7075 普通加工中心 General machining center (10000rpm Max)				铝合金 Aluminum alloy 5052、6061、7075 高速加工中心 High speed machining center (24000rpm Max)			
型号 Designation	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm	转速 s/min-1	进给 Vf/mm/min	切深 ap/mm	切宽 ae/mm
R0.5	9500-10000	1400-1800	0.03-0.05	0.05-0.08	23000-24000	1800-2200	0.03-0.05	0.05-0.08
R1	9000-9500	2200-2600	0.04-0.06	0.06-0.1	20000-22000	2600-3000	0.04-0.06	0.06-0.1
R1.5	9000-9500	2400-2800	0.05-0.07	0.08-0.12	17000-19000	2800-3200	0.05-0.07	0.08-0.12
R2	9000-9500	2600-3000	0.06-0.08	0.1-0.13	16000-17000	3000-3400	0.06-0.08	0.1-0.13
R3	9000-9500	3000-3400	0.08-0.1	0.12-0.15	15000-16000	3400-3800	0.08-0.1	0.12-0.15
R4	9000-9500	3200-3600	0.08-0.13	0.15-0.2	13000-14000	4200-4600	0.08-0.13	0.15-0.2
R5	9000-9500	3200-3600	0.1-0.15	0.18-0.23	12000-13000	4200-4600	0.1-0.15	0.18-0.23
R6	7700-8200	3800-4200	0.13-0.16	0.2-0.25	11000-12000	4200-4600	0.13-0.16	0.2-0.25

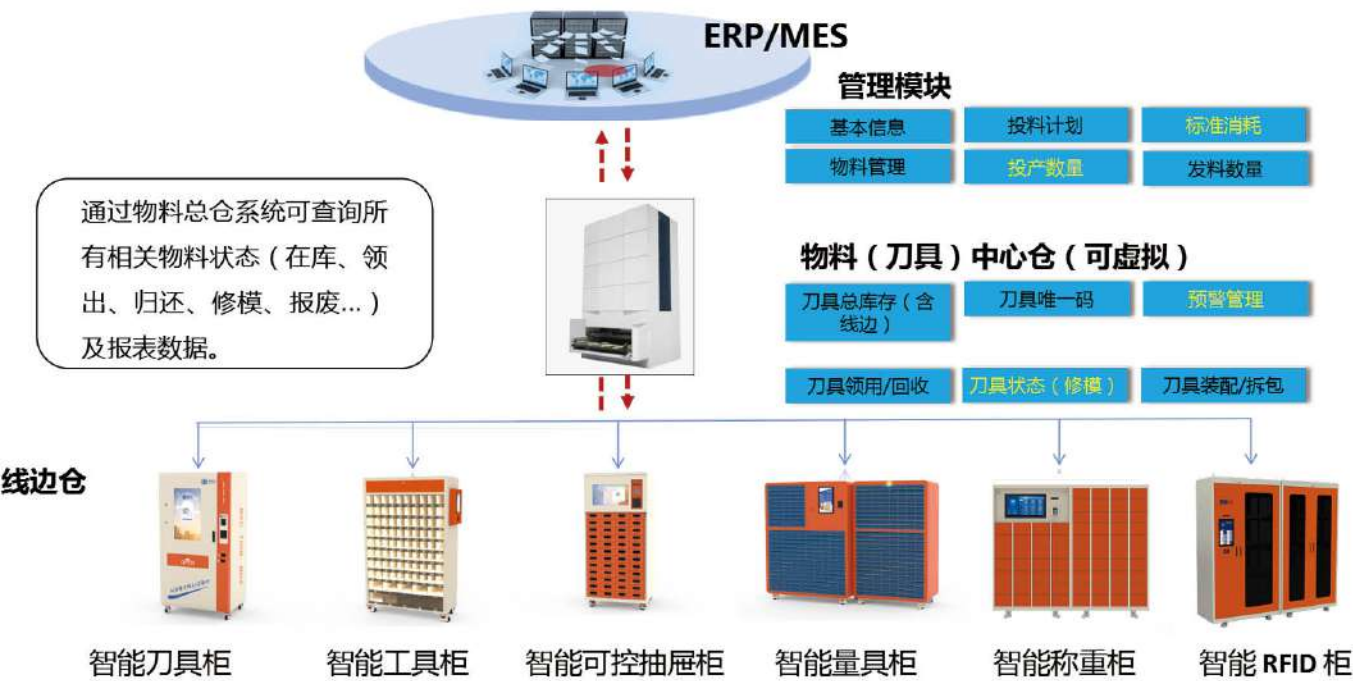
INTELLIGENT TOOL CABINET

智能刀具柜



智能刀具管理系统——整体架构

Intelligent tool management system - overall architecture



线边刀具管理

Tool mangement

01

管理痛点 / 难点

Management pain points / difficulties

- | | |
|--|--|
| 1、刀具领用耗时长、手续繁琐
It takes too long to get the cutting tool | 2、刀具领用后不知所踪
Easily missing in use |
| 3、以旧换新执行不彻底
Return old for new one cannot been dpne thoroughly | 4、刀具使用追溯困难
Too difficult for traceability when using cutting tool |
| 5、库存无法实时监管及预警
Cannot monitor and warning when stofage low | 6、夜班需提前领料或人员值守
Stand by for 24H or receive in advance for the night shift |
| 7、报表统计不准，单据处理繁琐
Diffcult for statistics and tedious for handling receipts | 8、使用成本过高，核算困难等
High cost and diffcult for accounting |



智能刀具柜的优势

Advantages of Intelligent Tool Cabinet



系统功能

System Function

- **无人值守**
Unattended
24小时无人值守,自助领料还料,操作信息详细记录可追溯,物流和信息流实时一致。
No one stand by for 24H and self-service. Information flow and logistics are generated at the same time.
- **多元登录**
Multi-Login
账号密码、刷卡、人脸识别,权责明确。
Multi-login including password、card and face identification.
- **快捷领取**
Quick collection
一键领用,快达10秒,批量购物车领取。
Receive through shopping cart quickly.
- **限权管理**
Authority management
管理员和员工不同权限,按需领取,可限制领取和未归还数量上限,避免浪费。
Receive based on management privileges and limit quantities to avoid waste.
- **归还审核**
Return review
分类回收,后台审核,以旧换新,快速凸显异常操作。
Return old for new and intelligent picking, highlight abnormal operations.
- **库存预警**
Automatic warning
设定安全库存,界面颜色提醒,邮件预警。
Automatic warning and purchasing notice by setting safety stock and email.
- **虚拟仓配置**
Virtual warehouse settings
大物料和不常用物料,可一并管控。
Large materials and infrequent materials can be controlled together.



系统功能

System Function

■ 系统接入

System access

Customized

定制化需求, 对接ERP、MES、WMS等客户系统, 数据互通。

Customization requirements, Easy connection with ERP/MES/WMS and etc.

■ 模块结构

Modular Design

流线型设计, 鲜亮的色彩搭配, 提升企业车间形象, 对柜机容量和配置可无限扩展。

Streamlined design, bright color matching, promote the image of enterprise workshop, and expand the capacity and configuration of cabinet machine infinitely.

■ 智能报表

Intelligent reports

自动实时生成领用、未归还、库存、物料上下架等数据记录和统计分析报告, 实时查看。

Automatically generate data records and statistical analysis reports such as collection, unreturned, inventory, loading and unloading of tools, and view them in real time.

■ 成本清晰

Clear cost

各成本中心消耗实时展现, 为整个工厂决策提供依据。

The consumption of each cost center is displayed in real time, which provides the basis for the decision of the whole factory.



数据报表
Data reports



可视化图表
Visual chart



工装量具管理

Tool management

02

管理痛点/难点

Management pain points / difficulties

1、工具使用频繁, 紧急情况找不到需要的工具

Tools are used frequently, and the required tools cannot be found in emergency.

2、员工存取工具时很难认真记录, 难以追踪

It is difficult for employees to carefully record and track when accessing tools.

3、量具需定期校准, 因数量较多, 容易造成超时漏检

The measuring tools need to be calibrated regularly. Due to the large number, it is easy to cause overtime and missed inspection.

解决方案

Solution

1、存取时责任到人, 并实时显示前一使用者和使用轨迹

When accessing, the responsibility is assigned to the person, and the previous user and usage track are displayed in real time.

2、检验到期提前预警, 后台可一键校验

Early warning of inspection expiration. One click verification is available in the background.

3、多种柜体搭配组合, 灵活存储

Multiple cabinet combinations for flexible storage.



系统功能

System Function

无人值守

Unattended

24小时无人值守,自助领料还料,操作信息详细记录可追溯

No one stand by for 24H and self-service .Information flow and logistics are generated at the same time.

多元登录

Multi-login

账号密码、刷卡、人脸识别,责任到人

Muti-login including password 、 card and face identification.

物料追溯

Traceability

实时显示前一使用者,权责到人

Trace the tools and the users

定期校验

Periodic verification

显示当前状态,提前检验预警

Display current status, early inspection alert

智能报表

Intelligent report

展示所有物料使用轨迹,频次和当前状态

Show the track, frequency and current status of all materials.

格口定制

Customized notch

抽屉格口大小可以根据客户物料尺寸定制,多种规格任意拼装

Drawer compartment size can be customized according to customer's material size, specifications can be assembled at will.



刀具室管理

Tool room management

管理痛点/难点

Management pain points / difficulties

1、刀具发放耗时长,种类繁多,查找不易

It takes a long time to distribute tools, and there are many kinds of tools, so it is difficult to find them

2、零星频繁领取、增加仓库人员工作量

Sporadic and frequent collection, increasing the workload of warehouse personnel

3、单据处理繁琐,报表录入工作量大,容易账实不符

The document processing is cumbersome, the report workload is heavy, and it is easy for the accounts to be inconsistent with the facts

解决方案

Solution

1、可全程无纸化作业,系统报表自动生成,缺料自动预警

Paperless operation throughout the whole process, automatic generation of system reports and automatic warning of material shortage

2、节省人工找料时间成本,操作简单便捷,无障碍上手

It saves the time and cost of manual material finding, and the operation is simple, convenient and accessible

3、智能化的管理模式,即提高企业的自身形象,又节省人员成本,提高工作效率

The intelligent management mode not only improves the self-image of the enterprise, but also saves personnel costs and improves work efficiency



系统功能

System Function

无人值守

Unattended

24小时无人值守,自助领料还料,操作信息详细记录可追溯,物流和信息流实时一致。

No one stand by for 24H and self-service .Information flow and logistics are generated at the same time.

多元登录

Multi-login

账号密码、刷卡、人脸识别,锁定责任人。

Muti-login including password 、 card and face identification.

智能报表

Intelligent report

自动生成领用、未归还、库存、物料上下架等数据,统计分析,实时查看。

Automatically generate data records and statistical analysis reports such as collection, unre-turned, inventory, loading and unloading of tools, and view them in real time.

限权限额

Limit permissions
and quantities

管理员和员工不同权限,按需领取,可限制领取和未归还数量上限,避免浪费。

Receive based on management privileges and limit quantities to avoid waste.

系统接入

System access
Customized

定制化需求,对接ERP,MES,WMS等客户系统,数据互通。

Customization requirements,Easy connection with ERP/MES/WMS ,etc.

归还审核

Return review

分类回收,后台审核,以旧换新,快速凸显异常操作。

Return old for new and intelligent picking,highlight abnormal opeartions.

库存预警

Automatic warning

设定安全库存,界面颜色提醒,邮件预警。

Automatic warning and purchasing notice by setting safety stock and email.

数量管控

Quantity control

格口出料数量可控,避免超限拿取。

The quantit can be controlled, so as to avoid over-limit taking.

格口定制

Customized notch

抽屉格口大小可以根据客户物料尺寸定制,多种规格任意拼装。

Drawer compartment size can be customized according to customer's needs and various specifications can be assembled arbitrarily.



仓库管理

Warehouse management

04

管理痛点/难点

Management pain points / difficulties

- 1、空间有限
Limited space
- 2、查找困难
Difficulty to find
- 3、搬进搬出,费时费力
Moving in and out is time
-consuming and laborious
- 4、盘点耗时
Counting time

解决方案

Solution

立体货柜
Vertical container

管理方式/管理效益:

Management mode / management benefit

- 1、现有仓库改造成立体仓库
The existing warehouse is transformed into vertical container
- 2、可系统对接ERP、MES等系统
It can connect ERP, MES and other systems
- 3、扫描工单,系统自动出料、扣账
Scan the work order, and the system will automatically issue materials
and deduct accounts

立体仓库
Automatic stereoscopic

管理方式/管理效益:

Management mode / management benefit

- 1、定制化立体仓库,管理仓库所有物料
Customized automatic stereoscopic, manage
all materials in the warehouse
- 2、根据现场尺寸和承重要求,量身定制
According to the site size and load-bearing
requirements, tailored
- 3、空间高度4M以上,使用性价比更高
The space height is more than 4m, which is more cost-effective

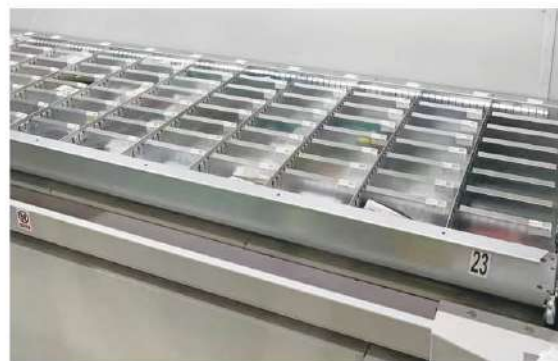
产品特点 / Product Features

- 1 充分利用垂直方向空间、
节省地面面积、洁净、安全、可靠、高效**
Make full use of vertical space,
save floor area, be clean, safe, reliable and efficient.
- 2 存取能力最大
可达 120个托盘/小时**
The access capacity
can be up to 120 trays/hour.
- 3 托盘间距可调
预塑化面板**
Preplasticized panel
Tray spacing is adjustable.
- 4 V形钢丝绳带
自支撑钢结构**
V-shaped steel belt
Self-supporting steel structure
- 5 友好的用户界面
触摸屏操作控制台**
Touch screen operation console
Friendly user interface
- 6 数据库自动维护，高级数据库备份管理，
可实现完整备份或增量备份**
Automatic database maintenance,
advanced database backup management,
Full backup or incremental backup can be realized.

适用场景 / Applicable Scenarios

- 1 地面面积小,高度高的场地**
Site with small ground area and high height
- 2 洁净度要求高的环境**
Environment with high cleanliness requirements
- 3 快速,高流量要求**
Fast, high flow requirements
- 5 不限行业**
Unlimited industry
- 4 存储要求防尘、防潮。**
The storage shall be dust-proof and moisture-proof.

案例 / Customer cases



系统功能 / System Function

- | | | |
|---|-----------------------------------|---------------------------------------|
| 1 指令管理
Instruction management | 2 作业调度
Job scheduling | 3 实时监控
Real time monitoring |
| 4 数据采集
Data collection | 5 故障报警
Fault alarm | 6 运行日志
Operation log |
| 7 异常处理
Exception handling | 8 用户权限
User permissions | 9 客户定制化
Customization |

产品特点 / Product Features

- | | |
|--|--|
| 1 轻型堆垛机, 重量轻、产品适用行业广, 水平运行速度最高可达到360m/min
Light stacker crane, light weight, wide range of products, The horizontal operating speed can reach up to 360m/min | 2 高度范围:2.5-13m
Height range: 2.5-13m |
| 3 模块化设计, 总重量轻, 噪音低, 震动小, 低扭转, 集成导轨
Modular design, total weight, low noise, low vibration, low torsion, integrated rail | 4 结构简洁美观, 使用简便, 维护方便。适用于高流量要求场合
The structure is simple and beautiful, easy to use and easy to maintain. Suitable for high flow requirements |

适用场景 / Applicable Scenarios

- | | |
|---|--|
| 1 轻载, 小尺寸的货物
Light load, small size cargo | 2 洁净度要求高的环境
Environments with high cleanliness requirements |
| 3 快速, 高流量要求
Fast, high flow requirements | 4 地面承载小, 高度低的场合, 可适应于多层厂房楼面使用。
The ground bearing is small, the height is low, and it can be adapted to the use of multi-storey factory floor. |

案例 / Customer cases





A

标准版智能刀具柜

Standard Edition Intelligent Tool Cabinet



B

C

D

基本参数 / Basic Parameter

E

型号： AHNO-TB-B2-Z90	显示器： 32 寸触摸屏
Type no: AHNO-TB-B2-Z90	Screen size: 32 inch touch screen
颜色： 米色 / 橘色（可定制）	外观尺寸： 1070*804*2012mm
Color: Beige/Orange(Customizable)	Dimensions: 1070*804*2012mm
电源： AC 220V	物料数量： 90MAX 108*20= 2160 件
Power: AC 220V	Tool Quantity: 90max 108*20= 2160 pieces
功率： 200W	管理品种： 90/108 品种 (varieties)
Power: 200W	Management Variety: 90/108 varieties
重量： 400kg	回收仓尺寸： 内径: 498*128*430mm
Weight: 400kg	Recycling bin size: 外径: 502*132*430mm

F

服务器： GK7000 i7-10510U 16G 内存 128G+32G 固态硬盘 带 WIFI

Server: GK7000 i7-10510U 16GB memory 128G+32G Solid-state with WiFi

物料参考尺寸： 最大尺寸 - 长 :140mm 宽 :60mm 厚 :15mm

Package size: maximum size - length: 140mm width: 60mm thickness: 15mm

G

H

新零售智能刀具柜

New retail smart knife cabinet



基本参数 / Basic Parameter

型号： AHNO-TB-E3-Z80

Type no: AHNO-TB-E3-Z80

颜色： 米白 / 橘色

Color: Beige/Orange

电源： AC 220V

Power: AC 220V

功率： 100W

Power: 100W

重量： 380kg

Weight: 380kg

显示器： 15.6 寸触摸屏

Screen size: 15.6 inch touch screen

外观尺寸： 1070*794*1900mm

Dimensions: 1070*794*1900mm

管理品种： 8*10 = 80 品种

Management Variety: 8*10 = 80 varieties

物料数量： MAX 80*16 = 1280 件

Recycling bin size: max 80*16 = 1280 pieces

回收仓尺寸： 138*498*425mm

Recovery bin size: 138*498*425mm

回收口尺寸： 70*40mm

Return port size: 70*40mm

服务器： GK7000 i5-8250U 16G 内存 128G+32G 固态硬盘 带 WIFI

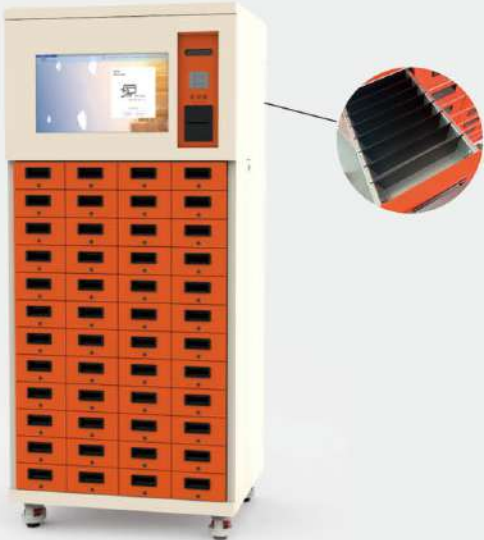
Server: GK7000 i5-8250U 16GB memory 128G+32G Solid-state with WiFi

物料参考尺寸： 最大尺寸 - 长:140mm 宽:60mm 厚:15mm

Package size: maximum size - length: 140mm width: 60mm thickness: 15mm

智能可控抽屉柜

Intelligent Controllable Drawer Cabinet

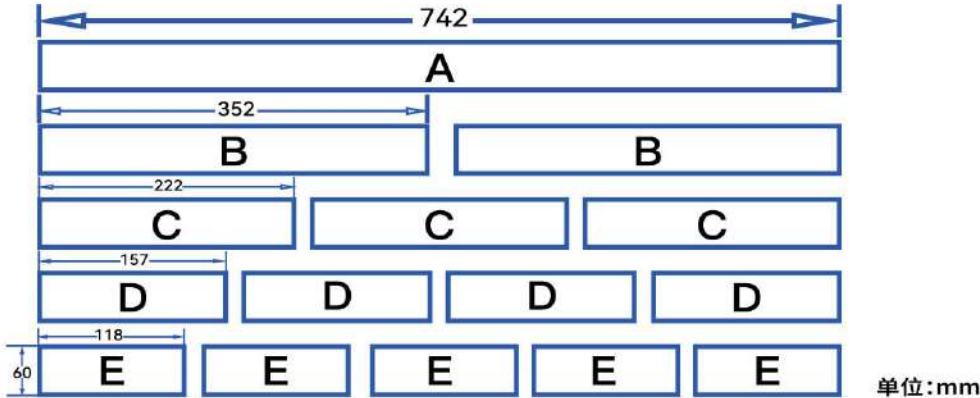


基本参数 / Basic Parameter

型号： AHNO-TB-K-Z60 Type no: AHNO-TB-K-Z60	显示器： 21.5 寸触摸屏 Screen size: 21.5 inch touch screen
颜色： 米色 / 橘色（可定制） Color: Beige/Orange(Customizable)	外观尺寸： 主柜尺寸： 866*760*1858mm 副柜尺寸： 866*760*1858mm Dimensions: Main cabinet size: 866*760*1856mm Auxiliary cabinet size: 866*760*1856mm
电源： AC 220V Power: AC 220V	管理品种： 主柜： 60(5*12) 副柜： 75(5*15) Management Variety: Main cabinet: 60(5*12) Auxiliary cabinet: 75(5*15)
功率： 100W Power: 100W	
重量： 480kg Weight: 480kg	

服务器： GK7000 i7-10510U 16G 内存 120G+32G 固态硬盘 带 WIFI
Server: GK7000 i7-10510U 16GB memory 120G+32G Solid-state with WiFi

常用格口尺寸： E:118*58*28mm D:157*58*28mm C:222*58*28mm （分格间距 28）
Lattice size: E:118*58*28mm D:157*58*28mm C:222*58*28mm （frame spacing 28）



智能灯锁柜

Smart light lock cabinet



基本参数 / Basic Parameter

型号： AHNO-TB-F-Z15
Type no: AHNO-TB-F-Z15

颜色： 橙红
Color: Orange red

电源： AC 220V
Power: AC 220V

功率： 200W
Power: 200W

重量： 主柜:630kg 副柜: 350kg
Weight: Main cabinet : 630kg
Auxiliary cabinet: 350kg

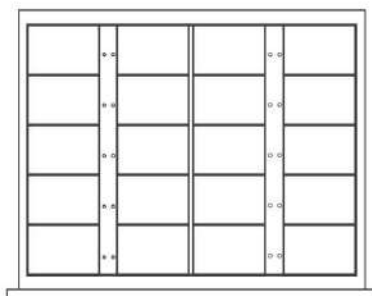
显示器： 21.5 寸触摸屏
Screen size: 21.5 inch touch screen

外观尺寸： 主柜尺寸: 737*730*1720mm
副柜尺寸: 737*730*1720mm
Dimensions: Main cabinet size: 737*730*1720mm
Dimension of auxiliary cabinet: 737*730*1720mm

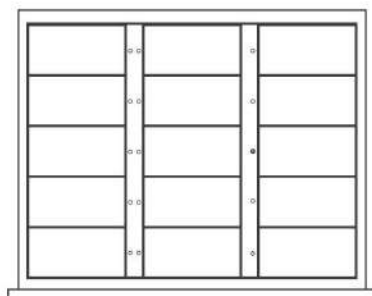
服务器： GK7000 i7-10510U 16G 内存 128G+32G 固态硬盘 带 WIFI
Server: GK7000 i7-10510U 16GB memory 128G+32G Solid-state with WiFi

格口尺寸： 130*88*70mm(一层 20 格口)
(可选格口尺寸) 180*88*70mm(一层 15 格口)
280*88*70mm(一层 10 格口)

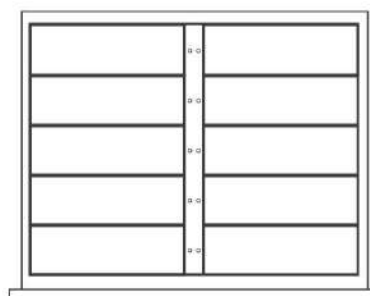
Lattice size: 130*88*70mm(A floor of 20 openings)
180*88*70mm(A floor of 15 openings)
280*88*70mm(A floor of 10 openings)



20格口



15格口



10格口

A

智能暂存回收柜

Intelligent temporary storage recycling cabinet



B

C

基本参数 / Basic Parameter

型号： AHNO-TB-ZI-Z100	显示器：	无
Type no: HNO-TB-ZI-Z100	Screen size:	without
颜色： 橘色	外观尺寸：	545*484*1590mm
Color: Orange	Dimensions:	545*484*1590mm
电源： AC 220V	管理品种：	100
Power: AC 220V	Management Variety:	100
功率： 50W	回收仓尺寸：	400*295*190mm
Power: 50W	size of recycling bin:	400*295*190mm
重量： 约 100kg	回收方式：	翻转扫描回收
Weight: About 100kg	Recycling method:	flip scanning recycling

智能回收柜

Smart Recycling Cabinet



基本参数 / Basic Parameter

型 号 : AHNO-TB-HS001

Type no: AHNO-TB-HS001

颜 色 : 橘色

Color: Orange

重 量 : 50kg

Weight: 50kg

外 观 尺 寸 : 600*450*788mm

Dimensions: 600*450*788mm

回收仓尺寸: 225*345*375mm

Recovery bin size: 225*345*375mm

回收口尺寸: 80*40

Return port size: 80*40

回 收 方 式: 手动分类回收

Recycling mode: Manual sorting and recycling

型号: AHNO-TB-HS002

Type no: AHNO-TB-HS002

颜色: 橘色

Color: Orange

重量: 50kg

Weight: 50kg

外观尺寸: 600*450*788mm

Dimensions: 600*450*788mm

回收仓尺寸: 237*347*345mm (2个)

Recovery bin size: 237*347*345mm(2 pieces)

回收方式: 翻转扫描回收 / 红外感应回收

Recycling mode: Flip scan recovery/Infrared induction recovery

回收最大物料尺寸: 80*30*180

Maximum material size to be recovered: 80*30*180

智能抽屉柜

Smart Chest Of Drawers



基本参数 / Basic Parameter

型号：AHNO-TB-CT-Z200	显示器：15.6 寸触摸屏
Type no: AHNO-TB-CT-Z200	Screen size: 15.6 inch touch screen
颜色：橘色	外观尺寸：主柜尺寸：1158*500*1650mm
Color: Orange	Dimensions: 副柜尺寸：942*500*1650mm
电源：AC 220V	Main cabinet size:1158*500*1650mm
Power: AC 220V	Sub cabinet size:942*500*1650mm
功率：100W	管理品种：200
Power: 100W	Management Variety: 200
重量：主柜约 145kg 副柜约 125kg	服务器：GK7000 i7-10510U 16G 内存 128G+32G 固态硬盘 带 WIFI
Weight: 145kg/125kg	Server: GK7000 i7-10510U 16GB memory 128G+32G Solid-state with WiFi
	常用格口尺寸：1 号：195*98*48mm 3 号：155*82*40mm
	size of recycling bin: 195*98*48mm 155*82*40mm

型号 type no	外尺寸 (mm) external dimensions	内尺寸 (mm) internal dimensions
0 号	150*90*44	130*78*35
1 号	220*110*55	195*96*47
2 号	240*130*75	212*115*65
3 号	180*95*50	155*80*40
4 号	185*108*60	155*95*50
5 号	204*133*77	175*122*68

型号 type no	外尺寸 (mm) external dimensions	内尺寸 (mm) internal dimensions
6 号	318*160*87	291*148*74
7 号	283*182*110	260*162*100
8 号	352*242*94	325*230*80
9 号	352*242*94	325*230*38
10 号	352*242*95	325*230*80

智能格子柜

Intelligent Lattice Cabinet



基本参数 / Basic Parameter

型号： AHNO-TB-G-Z90

Type no: AHNO-TB-G-Z90

颜色： 米白

Color: Beige

电源： AC 220V

Power: AC 220V

功率： 100W

Power: 100W

重量： 245kg

Weight: 245kg

显示器：

Screen size: :

15.6 寸触摸屏

15.6 inch touch screen

外观尺寸：

Dimensions:

1100*550*1800mm

1100*550*1800mm

格口数量：

Number of openings

90 格

90 lattice

格口尺寸

Lattice size

小格: 95*100*430 (共 80 格)

大格: 200*120*430 (共 10 格)

Small cell: 95*100*430(80 cells in total)

Big grid: 200*120*430 (10 grids in total)

服务器： GK7000 i7-10510U 16G 内存 128G+32G 固态盘 带 WIFI

Server: GK7000 i7-10510U 16GB memory 128G+32G Solid-state with WiFi

智能格口称重柜

Intelligent grid weighing cabinet



基本参数 / Basic Parameter

型号：AHNO-TB-P1-Z12	显示器：	15.6 寸触摸屏
Type no: AHNO-TB-P1-Z12	Screen size:	15.6 inch touch screen
颜色：米白 / 橘色	外观尺寸：	980*470*1780mm
Color: Beige/Orange	Dimensions:	980*470*1780mm
电源：AC 220V	格口数量：	9/12 格
Power: AC 220V	Number of openings:	9/12 grids
功率：100W	格口尺寸：	352*200*400mm
Power: 100W	Lattice size:	352*200*400mm
重量：330kg	单格称重极限：	20kg
Weight: 330kg	Single cell weighing limit:	20kg
	称重精度：	1g
	Weighing accuracy:	1g

智能抽屉称重柜

Smart drawer weighing cabinet



基本参数 / Basic Parameter

型号： AHNO-TB-P2-Z28

Type no: AHNO-TB-P2-Z28

颜色： 橙色

Color: Orange

电源： AC 220V

Power: AC 220V

功率： 200W

Power: 200W

重量： 主柜约 363kg 副柜约 350kg

Weight: 363kg/350kg

显示器：

Screen size:

21.5 寸触摸屏

21.5 inch touch screen

外观尺寸：

Dimensions:

1000*550*1730mm

1000*550*1730mm

格口数量：

Number of openings:

28/40 格

28/40 lattice

格口尺寸：

Lattice size:

200*170*70mm

200*170*70mm

单格称重极限：

Single cell weighing limit:

20kg

20kg

称重精度：

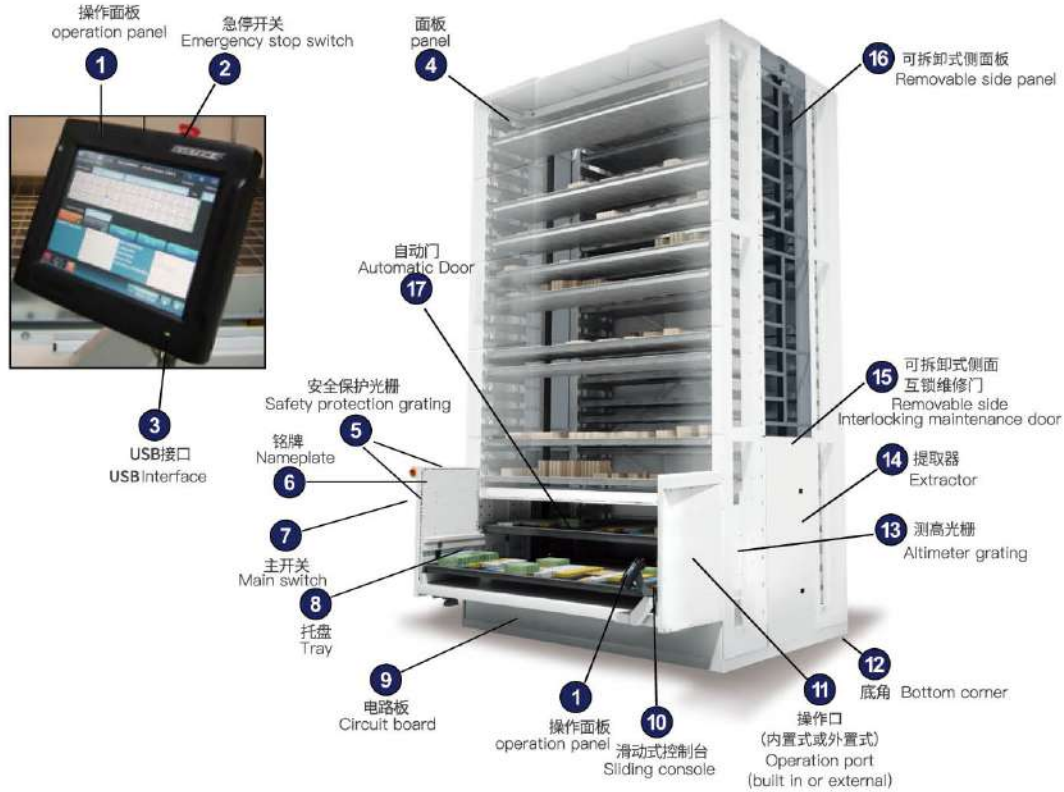
Weighing accuracy:

1g

1g

立体货柜

Vertical Container



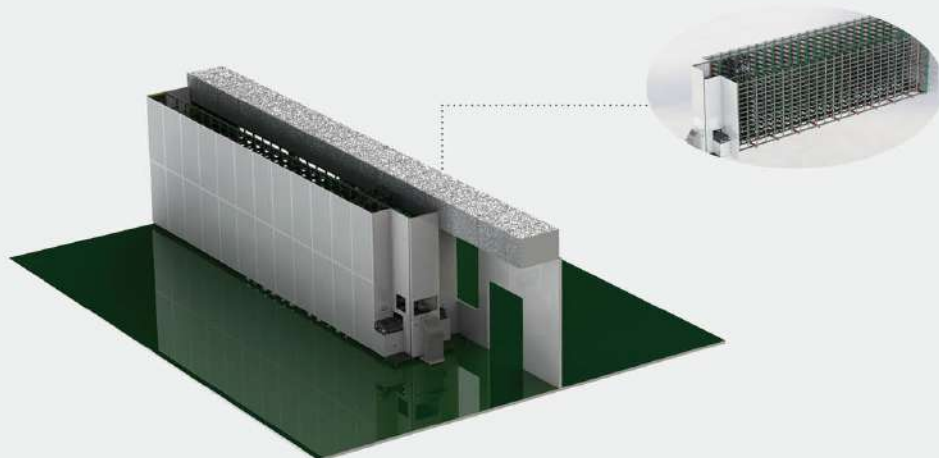
基本参数 / Basic Parameter

型号: Type no:	SLIM/MA/MA/MX/ML SLIM/MA/MA/MX/ML
托盘载重: Pallet load:	250-990kg 250-990kg
货柜高度: Container height:	2600mm-18, 000mm 2600mm-18, 000mm
货柜高度增加幅度: Container height increase:	200mm 200mm
托盘存储调节幅度: Pallet storage adjustment range:	25mm 25mm
托盘宽度: Pallet width	1500 至 4100mm 1500 至 4100mm
托盘深度: Pallet depth	654mm 至 857mm 654mm 至 857mm

托盘高度:	45mm/70mm/120mm
Tray height:	45mm/70mm/120mm
存储物料最大高度:	695mm
Maximum height of stored:	695mm
托盘装载货物净重:	250-500-750-1000kg
Net container loading capacity:	250-500-750-1000kg
货柜净装载能力:	60,000kg
Net container loading capacity:	60,000kg
货柜总装载能力:	70,000kg
Total container loading capacity:	70,000kg
存取能力:	最高 120 个托盘 / 小时 (视货柜置而定) 提取或托盘双提取
Access capability:	Up to 120 pallets / hour (depending on the container) Depending on the setting) extraction or tray double extraction
存取口类型:	内置式存取口或外置式存取口
Access port type:	Built in access port or external access port

立体仓库

Stereoscopic Warehouse



基本参数 / Basic Parameter

最大载荷： Maximum load:	50kg	存取机构 (LHD)： Access mechanism(LHD):	单深，双深 Single depth, double depth
高度： Height:	13m	存取机构数量： Number of access institutions:	1/2
立柱： Column:	铝合金 Aluminium alloy	驱动方式： Driving mode:	同步带，摩擦驱动 Synchronous belt, friction driven
货物尺寸： Cargo size:	W 360-600mm D 500-1000mm H 100-600MM	巷道最大长度： Maximum length of roadway:	70m(同步带) 70m synchronous belt
运行速度： Running speed:	240mm/360mm	工作温度： Operating temperature:	0-40°C (可选 -25) 0-40°C (optional -25)
运行加速度 (最大)： Lifting acceleration:	3.0m/s	环境相对湿度： Ambient relative humidity:	5% to 90% 无凝露 No condensation
起升速度： Fork speed:	80m/min	噪音： Noise:	76dB(A)
起升加速度： Fork acceleration:	1.6m/s	巷道宽度： Roadway width:	D+160mm(min.900)
货叉速度： Fork speed:	60m/min	第一层尺寸： First floor size:	450
货叉加速度： Fork acceleration:	1m/s	最上一层高度尺寸： Height dimension of the floor:	H+270(min.490)
		货架公差： Shelf tolerance:	货架等级：200 控制形式：C Shelf level:200 control form:C

A

客户案例

Customer cases

05

B

C

D

E

F

G

H



某台系企业、半导体行业

A Taiwan enterprise, semiconductor industry



VS



客户的痛点难点

Customer pain points and difficulties

- 1、智能化车间改善有要求
Requirements for improvement of intelligent workshop
- 2、加工铝件，一只刀具可用半年—两年不等，不易追踪寿命
For processing aluminum parts, one tool can be used for half a year to two years, which is not easy to track the service life
- 3、客户稽核要求追溯使用轨迹，无法查询
The customer audit requires tracing the use track, which cannot be queried
- 4、对应不到产品，成本核算不清楚
There is no corresponding product, and the cost accounting is not clear

实现价值

Realize value

- 1、一体化设计，美观大方
Integrated design, beautiful and elegant
- 2、管理到每一支刀具实时履历和剩余寿命
Manage the real-time resume and remaining life of each tool
- 3、精准核算每一个工单、每一个产品的刀具消耗成本
Accurately calculate the tool consumption cost of each work order and product
- 4、充分利用刀具，每支刀可反复多次使用
Make full use of the cutter, each cutter can be used repeatedly
- 5、对接企业MES和ERP系统，数据实时互通
Connect enterprise MES and ERP systems, and real-time data exchange

客户案例二 线边仓智能管理：螺旋C柜+暂存回收柜

Customer case 2

Intelligent management of line side warehouse: one main and one pair of spiral cabinets + temporary storage and recycling cabinets

华北区域某德系企业、仪器仪表行业

A German company, instrumentation industry in North China



使用工具柜前 Before

VS



使用工具柜后 After

客户的痛点难点

Customer pain points and difficulties

1、车间与仓库不在同一栋厂房，领用耗时长——领料一次约30分钟

The workshop and warehouse are not in the same building, so it takes a long time to collect materials—about 30 minutes at a time

2、夜班领料频繁，必须安排夜班仓库值班

The night shift picking is frequent, and the night shift warehouse must be arranged to be on duty

3、报表制作繁琐，需要仓库安排助理登账

The preparation of statements is tedious, and it is necessary for the warehouse to arrange assistants to book accounts

4、刀具种类过多，盘点查找不方便；经常紧急采购

There are too many types of tools, which makes it inconvenient to check and find; Frequent emergency procurement

5、呆滞库存较多，流转率低

There are more sluggish stocks and low turnover rate

实现价值

Realize value

1、线边放智能柜，领用归还快达10秒

Put smart tool cabinet at the edge of the line, collect and return quickly 10 seconds

2、24小时无人值守，随用随取

24-hour unattended, on-demand

3、自动记录，报表自动生成

Automatic recording and report generation

4、低于安全库存量自动预警，避免生产断料

lower than the safety stock automatic warning, to avoid production cut-off

5、人力+采购量+紧急采购+呆滞止损≈20万+/年

Manpower+purchase volume+emergency purchase+sluggish stop loss ≈ 200,000+/year

某美系企业、医疗行业

An American enterprise and medical industry



VS



客户的痛点难点

Customer pain points and difficulties

1、传统柜体配置，与公司整体形象不搭

The traditional cabinet configuration does not match the overall image of the company

2、客户稽核要求追溯使用轨迹，无法查询

The customer audit request traces the usage track and cannot be queried

3、仓库有三千多种刀具，常用一千种左右，物料大小不一，储存密集

There are more than 3,000 kinds of tools in the warehouse, and about 1,000 kinds of tools are commonly used. The materials are of different sizes and the storage is intensive

4、刀片拆包按“片”发放，且不定期领取，仓管需要另外记录使用单位，负担加重

Blades are unpacked and issued according to "pieces", and they are collected from time to time. The warehouse management needs to record the user unit separately, which increases the burden

5、为避免夜班和频繁领料，每个车间都有小仓库，且需专人管理

In order to avoid night shifts and frequent picking, each workshop has a small warehouse, which needs to be managed by special personnel

实现价值

Realize value

1、定制外形配合企业LOGO色

Customized shape with corporate LOGO color

2、定制领料流程，支持通过GZ号即物料号领取，支持从BOM单中领取

Customize the picking process, support receiving through GZ number, that is, material number, and support receiving from BOM list

3、刀具柜、虚拟仓、暂存柜统一管控出料，虚拟仓打印凭条去仓库领取

Tool cabinets, virtual warehouses, and temporary storage cabinets are uniformly controlled and discharged, and virtual warehouses print receipts and go to the warehouse to collect them

4、拆包的，反复领用的可存入暂存柜中集中管理

Unpacked, repeatedly used can be stored in the temporary storage cabinet for centralized management

5、刀具领取效率提高，晚间无人值守节省仓管人力，刀具采购量下降20%

The efficiency of tool collection is improved, unattended at night saves warehouse management manpower, and the amount of tool purchases decreases by 20%

某德系企业、热流体行业

A German enterprise, thermal fluid industry



使用工具柜前 Before

VS



使用工具柜后 After

客户的痛点难点

Customer pain points and difficulties

1、量具室管理所有量具，专人记录发放，对人员要求较高，难以及时准确登记

The measuring tool room manages all measuring tools, and special personnel are assigned to record and distribute them. It is difficult to register accurately and timely because of high requirements for personnel

2、量具使用频繁，夜班领取无人监管，紧急情况找不到需要的量具

The measuring tools are used frequently, and the night shift collection is not supervised, and the required measuring tools cannot be found in emergency

3、量具归还靠人力追踪，到期漏检验，盘点困难

The return of measuring tools is tracked by manpower, and the inspection is missed when due, which makes the inventory difficult

实现价值

Realize value

1、配备抽屉+格口智能量具柜，格口尺寸多种组合

Equipped with drawer+intelligent measuring tool cabinet with multiple combinations of grid sizes

2、员工人脸识别或账号密码登录，选中量具型号，格口自动弹开，节省查找时间

Employee face recognition or account password login, select the measuring tool model, and the grid automatically pops up, saving search time

3、实时显示前一使用者，方便查找和追溯

Real time display of the previous user, convenient for searching and tracing

4、管理员可根据物料的送检周期和上次送检日期，列出待送检列表

The administrator can list the materials to be inspected according to the inspection cycle and the last inspection date

5、存取记录自动生成，可查看领料记录、补料记录等

The access record is automatically generated, and you can view the picking record, replenishment record, etc

某内资企业、刀具行业

A domestic enterprise, cutting tool industry



使用工具柜前 Before

VS



使用工具柜后 After

客户的痛点难点

Customer pain points and difficulties

1、智能化车间改善有要求

There are requirements for the improvement of intelligent workshops

2、损坏找不到责任人，多次重复购买

The person responsible for the damage cannot be found, and the purchase is repeated many times

3、现场使用随意，手工登记，登记不到位；关键时候找不到要用工具

The on-site use is random, manual registration, and registration is not in place; the tools to be used cannot be found at critical times

实现价值

Realize value

1、定制外形组合，柜体内统一存放，美观大方

Customized shape combination, unified storage in the cabinet, beautiful and generous

2、多种格口大小，物料分类专属收纳，大屏幕搜索智能查找

Various grid sizes, exclusive storage for material classification, intelligent search on large screen

3、刷卡+账号密码+人脸识别登录；绑定人员，部门，设置领用权限，方便追溯

Swipe card + account password + face recognition login; bind personnel, departments, and set access rights, which is convenient for tracing

某上市企业、刀具行业

A listed enterprise and tool industry



使用工具柜前 Before

VS



使用工具柜后 After

客户的痛点难点

Customer pain points and difficulties

- 1、棒料仓库种类繁多，空间不够，管理繁琐
There are many kinds of bar stock warehouses, and the space is not enough. The management is cumbersome
- 2、棒料密度大，配货搬运人力消耗高
High bar density, high labor consumption for goods distribution and handling
- 3、专人单据处理，容易出错
Documents are handled by specially assigned person, which is easy to make mistakes

实现价值

Realize value

- 1、堆垛机立体库统一管理，充分利用高度空间
Stacker stereo library unified management, make full use of height space
- 2、自动出料，省去人工查找搬运
Automatic picking, search and transportation manually
- 3、对接MES和ERP，扫描单据即可自动出入库
Connect MES and ERP, and scan the documents to automatically enter and exit the warehouse
- 4、出料口配备激光指引和称重辅助，更精准配货
The discharge port is equipped with laser guidance and weighing aid, which makes more accurate distribution
- 5、无纸化办公，操作简单便捷
Paperless office, simple and convenient operation

客户案例七 仓库+线边一体化管理：立体库+智能刀具柜组合

Customer case 7
Warehouse+line edge integrated management: stereo warehouse+intelligent tool cabinet combination

某军工企业

A military enterprise



使用工具柜前 Before

VS



使用工具柜后 After



客户的痛点难点

Customer pain points and difficulties

- 1、军工企业，人工管理帐不符实
The manual management accounts of military enterprises are inconsistent with the facts
- 2、仓库和现场脱节，导致生产断料
The warehouse is disconnected from the site, resulting in production material interruption
- 3、呆滞库存多，无法一体化管理
Too many stale stocks to be managed in an integrated way

实现价值

Realize value

- 1、现场刀具柜+仓库立体货柜一体化管理，充分利用空间，客户现场整洁一新
On-site tool cabinet+warehouse three-dimensional container integrated management, make full use of space, and the customer site is clean and tidy.
- 2、管理员实时查询所有的库存、领用信息、领用数据、实时扣减数据互通、账目清晰
The administrator can query all the inventory, collecting information, collecting data and real-time deduction data in real time, and the accounts are clear.
- 3、刀具柜库存达到预警值推送给立体库实时补料
When the tool cabinet inventory reaches the warning value, push it to the stereo warehouse for real-time replenishment

某美系企业、医疗行业

An American enterprise and medical industry



VS



客户的痛点难点

Customer pain points and difficulties

- 1、说明书种类较多、每天使用量大；车间5S整理造成负担
There are many kinds of instructions, and the daily usage is large; 5S burden
- 2、临时更换产品，需要搜寻说明书；样式多不易找
For temporary replacement of products, you need to search for instructions; hard to find
- 3、想要管控好需要专人负责，增加工作量
If you want to control it well, you need someone to take charge of it and increase the workload
- 4、库存数量不容易管控，造成紧急采购
Inventory quantity is not easy to control, resulting in emergency procurement

实现价值

Realize value

- 1、柜体内统一存放，美观大方
The cabinet is stored in a unified way, which is beautiful and generous
- 2、系统自动匹配查找，选择要领的物料，格口打开，取走物料，操作简单便捷
The system automatically matches and searches, selects the essential materials, opens the grid, and takes away the materials. The operation is simple and convenient
- 3、系统根据物料单重自动扣减库存，报表自动生成
The system automatically deducts the inventory according to the material weight, and the report is automatically generated
- 4、低于安全库存量自动预警，避免生产断料
When automatic warning lower than the safety stock, to avoid production cut-off



TURNING

车削系列

车削用可转位刀片按照 ISO 1832 标准的符号说明

示例 1:

C	N	M	G	12	04	08	-	K	M	A
1	2	3	4	5	6	7		12	13	14

1、刀片形状

代号	图形	代号	图形
A		M	
B		O	
C		P	
D		R	
E		S	
H		T	
K		V	
L		W	

3、公差

允许公差 (mm)	d	m	s
	A	± 0,025	± 0,005
	C	± 0,025	± 0,013
	E	± 0,025	± 0,025
	F	± 0,013	± 0,005
	G	± 0,025	± 0,025
	H	± 0,013	± 0,013
	J ¹	± 0,05-0,15 ²	± 0,005
	K ¹	± 0,05-0,15 ²	± 0,013
	L ¹	± 0,05-0,15 ²	± 0,025
	M	± 0,05-0,15 ²	± 0,08-0,20 ²
	N	± 0,05-0,15 ²	± 0,08-0,20 ²
	U	± 0,08-0,25 ²	± 0,13-0,38 ²

¹ 刀片有精磨的副切削刃

² 视刀片尺寸而定 (见 ISO 1832 标准)

2、后角

代号	图形	代号	图形
A		N	
B		P	
C			
D			
E			
F			
G			

4、刀片加工和固定特征

代号	图形	代号	图形	代号	图形
A		H		R	
B		J		T	
C		M		U	
F		N		W	
G		Q		X	需要可转位刀片的图纸或准确说明

示例 2:

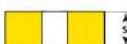
C	C	G	T	06	02	04	E	L
1	2	3	4	5	6	7	8	9

5、切削刃长度

刀片形状															
内切圆直径 d															
mm	英寸	规格	l	规格	l	规格	规格	l	规格	l	规格	l	规格	l	
3,97	5/32								06	6,9					
5	0,197					05							03	3,8	
5,56	7/32								09	9					
6	0,236					06									
6,35	2/8	06	6,4	07	7,7	06 ¹			11	11	11	11	04	4,3	
8	0,315					08							05	5,2	
9,525	3/8	09	9,6	11	11,6	09 ¹	09	9,5	16	16,5	16	16,5	06	6,5	
10	0,394					10									
12	0,472					12									
12,7	4/8	12	12,9	15	15,5	12 ¹	12	12,7	22	22	22	22,1	08	8,7	
15,875	5/8	16	16,1				15	15,8	27	27			10	10,8	
16	0,63					16									
17,46	11/16												12	11,6	
19,05	6/8	19	19,3			19 ¹	19	19,0							
20	0,787					20									
25	0,984					25									
25,4	8/8	25	25,8			25 ¹	25	25,4							
32	1,26					32									

¹ 英制规格 (00)

6、刀片厚度

图形	厚度 s(mm)
	01 1,59
	T1 1,98
	02 2,38
	T2 2,78
	03 3,18
	T3 3,97
	04 4,76
	05 5,56
	06 6,35
	07 7,94
	09 9,52

7、圆角半径

图形	半径 r(mm)
	01 0,1
	02 0,2
	04 0,4
	08 0,8
	12 1,2
	16 1,6
	24 2,4
	M0 公制规格 (直径以 mm 单位)
	00 英制规格 (英制尺寸换算以 mm 单位)

8、切削刃形状

代号	图形
F	
E	
T	
S	

9、切削方向

图形




硬质合金切削刀具材料符号说明

槽型索引

C

N

M

G

12

04

08

-

K

M

A

1

2

3

4

5

6

7

12

13

14

12、主要材料

代号	材料
P	钢
M	不锈钢
K	铸铁
N	有色金属
S	难加工材料
H	硬材料
U	通用

13、断屑区域

图表

代号	用途
F	精加工
S	半精加工
M	中等加工
R	粗加工
H	重切削

14、应用推荐

代号	推荐
A	第一推荐
B	第二推荐
C	第三推荐
X	断屑优先
W	Wiper

示例：

A	C	K	10	E
1	2	3	4	5

功能序号	说明	详情			
1	AHNO 阿诺				
2	基础材料及 涂层代码	C	硬质合金 +CVD	V	金属陶瓷 +PVD
		P	硬质合金 +PVD	I	塞隆陶瓷
		B	CBN	W	晶须陶瓷
		D	PCD	N	硬质合金
		T	金属陶瓷		
3	第一推荐应用	P	钢	N	有色金属
		M	不锈钢	S	难加工材料
		K	铸铁	H	硬材料
4	ISO 应用范围	01 10 20 30 40 耐磨性 韧性			
5	代次代码				

车削材质一览

车削材料应用																					
阿诺车削 材质牌号	ISO 组别	涂层工艺	工件材料组别						应用范围												技术说明
			P	M	K	S	N	H	01	05	10	15	20	25	30	35	40	45	50		
ACP10E	P10	CVD	●																	钢件及球铁的连续加工的第一选择材质，新的 Al2O3 涂层及后处理技术增加了材料的耐磨性。	
	K20				●																
ACP10B	P10	CVD	●																	钢件及球铁的连续加工的升级材质，采用了全新开发的新一代钢件连续加工涂层。稳定工况高效率的选择。	
	K20				●																
ACP10D	P10	CVD	●																	钢件及球铁连续加工的升级材质，全新的定向晶粒技术提升了使用效率和寿命，优化了基体材质的稳定性，精加工时亦可适用于轻微断续场合。	
	K20				●																
ACP20E	P20	CVD	●																	钢件通用加工的第一选择材质，出色的通用性能胜任大多数场景。稳定工况下可从精加工到粗加工，亦可用于断续车削加工。	
	K30				●																
ACP20B	P20	CVD	●																	阿诺全新一代钢件通用材质，全新涂层实现了出色的通用性，可以胜任大多数场景，同时提高了切削效率和切削耐用度。	
	K30				●																
ACP20D	P20	CVD	●																	全新的钢件车削加工的通用材质，定向晶粒技术提升了使用效率和寿命，提升了基体强度及韧性，在连续及断续工况下加工稳定性得到了改善。	
	K30				●																
ACP30E	P30	CVD	●																	钢件及不锈钢的断续加工、重切削的推荐材质，满足粗加工及恶劣工况下的加工安全性需求。	
	M30			●																	
ACP30B	P30	CVD	●																	钢件及不锈钢车削在断续加工、重切削恶劣工况时的推荐材质，全新开发的新材质，提升了基体韧性。	
	M30			●																	
ACK05E	K05	CVD			●															铸铁连续高效加工的最新推荐材质，耐磨性最佳，也适用于淬硬材料的加工。	
	H20							●													
ACK10E	K10	CVD			●															铸铁连续加工的第一选择，耐磨性好，尤其适用于灰口铸铁的加工。	
	H30							●													
ACK20E	K20	CVD			●															铸铁通用加工的首选选择材质，出色的材质稳定性，综合性能优异，也适用于一般的断续加工，以及铸铁的中高速切削。	
	P05		●																		

车削材质一览

车削材料应用																					
阿诺车削 材质牌号	ISO 组别	涂层工艺	工件材料组别						应用范围												技术说明
			P	M	K	S	N	H	01	05	10	15	20	25	30	35	40	45	50		
ACK30E	K30	CVD			●															铸铁断续加工的推荐材质，主要针对断续的铸铁加工工况，综合性能优异。	
	P10		●																		
APS10C	S10	PVD				●														高温合金车削的首选材质，具有极强的耐磨性、高温耐受性且表面光滑的涂层结构以及高硬基体。亦可用于不锈钢加工。	
	M10			●																	
APM10C	M10	PVD		●																不锈钢车削在连续稳定工况下的首选材质，高光滑性、高致密性的涂层结构搭载高硬基体，用于不锈钢的精加工至半精加工。	
	S10					●															
APM20B	M20	PVD		●																不锈钢及高温合金连续加工的推荐材质，优异的耐磨性搭配高硅涂层，在通用加工及小零件加工中表现优异。	
	S20					●															
APS20C	S20	PVD				●														高温合金车削的通用材质，具有较强的耐磨性、高温耐受性且表面光滑的涂层结构以及稳定基体。亦可用于不锈钢加工。	
	M20			●																	
APM20C	M20	PVD		●																不锈钢车削加工的首选材质，光滑且致密的涂层结构及较高的基体韧性，适合不锈钢连续、断续工况下的半精至粗加工。	
	S20					●															
APM20E	M20	PVD		●																不锈钢通用加工的通用材质，适合不锈钢连续、断续切削条件下的半精加工到粗加工。	
	S20					●															
APU20B	M20	PVD		●																全新开发的通用加工材质，表面光滑结合高硅涂层适用于不锈钢及钢件的小零件加工。	
	P20		●																		

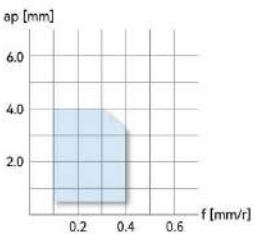
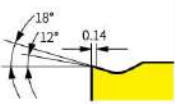
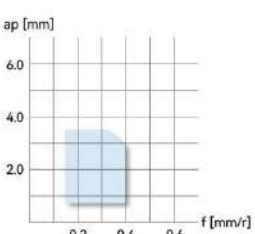
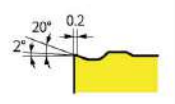
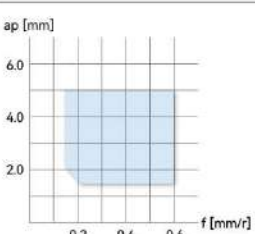
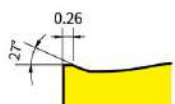
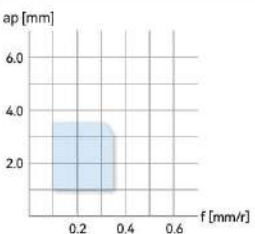
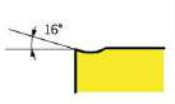
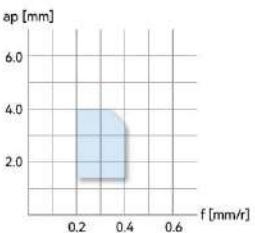
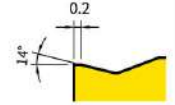
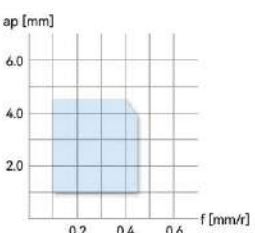
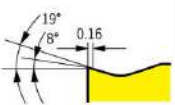
● 第一推荐 ● 第二推荐

车削材质一览

	工件材料组	刀具材质	涂层类别	应用类别				
				01	10	20	30	40
P	非合金钢 / 合金钢	硬质合金	CVD		ACP10E/B			
		硬质合金	CVD		ACP10D			
		硬质合金	CVD			ACP20E/B		
		硬质合金	CVD			ACP20D		
		硬质合金	CVD				ACP30E/B	
M	不锈钢	硬质合金	PVD		APS10C			
		硬质合金	PVD		APM10C			
		硬质合金	PVD		APM20B			
		硬质合金	PVD			APS20C		
		硬质合金	PVD			APM20C		
		硬质合金	PVD			APM20E		
		硬质合金	PVD			APU20B		
K	铸铁	硬质合金	CVD	ACK05E				
		硬质合金	CVD		ACK10E			
		硬质合金	CVD			ACK20E		
		硬质合金	CVD				ACK30E	
S	高温合金 / 钛合金	硬质合金	PVD		APS10C			
		硬质合金	PVD			APS20C		

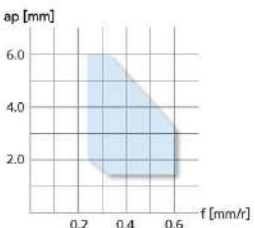
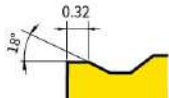
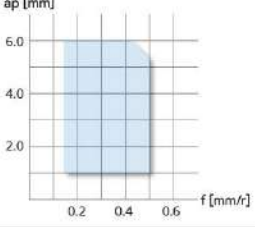
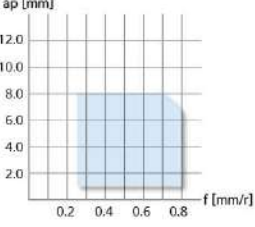
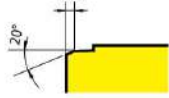
负型车削刀片槽型一览

负型压制刀片

应用	槽型	断屑槽	断屑范围示意	断屑槽剖面	CN	DN	SN	TN	VN	WN
半精加工槽型	-SSA				CNMG-SSA					
					 P.286					
中等加工槽型	-PMB				CNMG-PMB	DNMG-PMB			VNMG-PMB	WNMG-PMB
					 P.284	 P.287			 P.295	 P.296
	-PMD				CNMG-PMD	DNMG-PMD	SNMG-PMD	TNMG-PMD	VNMG-PMD	WNMG-PMD
					 P.284	 P.287	 P.289	 P.292	 P.295	 P.296
中等加工槽型	-MME				CNMG-MME		SNMG-MME	TNMG-MME	VNMG-MME	WNMG-MME
					 P.286		 P.291	 P.294	 P.295	 P.298
	-KMA				CNMG-KMA	DNMG-KMA	SNMG-KMA	TNMG-KMA	VNMG-KMA	WNMG-KMA
					 P.285	 P.288	 P.290	 P.293	 P.295	 P.297
	-SMA				CNMG-SMA					
					 P.286					

负型车削刀片槽型一览

负型压制刀片

应用	槽型	断屑槽	断屑范围示意	断屑槽剖面	CN	DN	SN	TN	VN	WN
粗加工槽型	-KRA				CNMG-KRA	DNMG-KRA	SNMG-KRA	TNMG-KRA		WNMG-KRA
										
	-KRB				CNMA-KRB	DNMA-KRB	SNMA-KRB	TNMA-KRB	VNMA-KRB	WNMA-KRB
										
	-KRC				CNMA-KRC		SNMA-KRC			WNMA-KRC
										
					P.285	P.288	P.290	P.293	P.295	P.297
					P.285		P.290			P.297

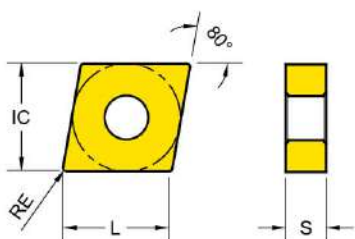
正型车削刀片槽型一览

正型压制刀片

应用	槽型	断屑槽	断屑范围示意	断屑槽剖面	CC	DC	SC	TC	VB
中等加工槽型	-UMA				CCMT-UMA	DCMT-UMA	SCMT-UMA	TCMT-UMA	
					P.300	P.301	P.302	P.303	
中等加工槽型	-MMA				CCMT-MMA	DCMT-MMA	SCMT-MMA	TCMT-MMA	
					P.300	P.301	P.302	P.303	
中等加工槽型	-KMA				CCMT-KMA	DCMT-KMA	SCMT-KMA	TCMT-KMA	
					P.299	P.301	P.302	P.303	

负型刀片 CN 系列

CNMG / CNMA (80° Negative)

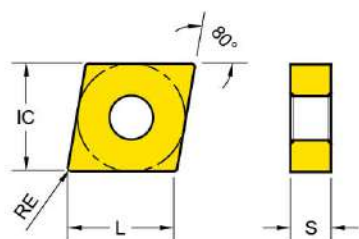


Series	L	IC	S
CN** 1204	12.9	12.7	4.76
CN** 1606	16.1	15.875	6.35
CN** 1906	19.3	19.05	6.35

					P								M			K				S		
CNMG/CNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-PMB  中等加工	CNMG120408-PMB	0.8	0.15-0.44	0.8-4.3	●	●					●	●										
	CNMG120412-PMB	1.2	0.23-0.66	1.2-4.3	●	●					●	●										
-PMD  中等加工	CNMG120404-PMD	0.4	0.12-0.36	0.4-4.8	◎				●													
	CNMG120408-PMD	0.8	0.15-0.40	0.8-4.8	◎				●		◎	●										
	CNMG120412-PMD	1.2	0.15-0.40	1.0-4.8	◎				●		◎	●										
	CNMG160608-PMD	0.8	0.20-0.48	1.5-7.0	◎				●													
	CNMG160612-PMD	1.2	0.23-0.48	1.5-7.0	◎				●													
	CNMG190608-PMD	0.8	0.25-0.60	2.0-8.0	◎				◎													
	CNMG190612-PMD	1.2	0.30-0.60	2.0-8.0	◎				●													
	CNMG190616-PMD	1.6	0.35-0.70	2.0-8.0	◎				●													

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						



Series	L	IC	S
CN** 1204	12.9	12.7	4.76
CN** 1606	16.1	15.875	6.35
CN** 1906	19.3	19.05	6.35

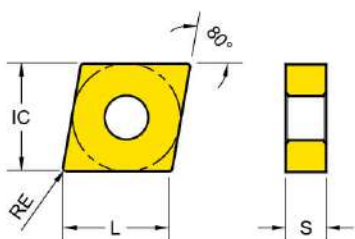
CNMG/CNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P								M				K				S	
					ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20C	APM30C	APM10E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-KMA  中等加工	CNMG120404-KMA	0.4	0.08-0.22	0.4-4.3													●	●	●	●		
	CNMG120408-KMA	0.8	0.15-0.44	0.6-5.0													●	●	●	●		
	CNMG120412-KMA	1.2	0.23-0.66	1.2-4.3													●	●	●	●		
	CNMG160608-KMA	0.8	0.15-0.44	0.5-7.0														●	●	●		
	CNMG160612-KMA	1.2	0.23-0.66	0.8-7.0														●	●	●		
	CNMG190608-KMA	0.8	0.15-0.44	0.5-8.5														●	●	●		
	CNMG190612-KMA	1.2	0.23-0.66	0.6-8.5														●	●	●		
	CNMG190616-KMA	1.6	0.25-0.80	1.0-8.5														●	●	●		
-KRA  粗加工	CNMG120408-KRA	0.8	0.8	0.8													●	●	●			
	CNMG120412-KRA	1.2	0.26-0.72	1.2-5.2													●	●	●			
-KRB  粗加工	CNMA120404-KRB	0.4	0.10-0.30	0.6-6.3													●	●	●			
	CNMA120408-KRB	0.8	0.20-0.60	1.2-6.3													●	●	●			
	CNMA120412-KRB	1.2	0.30-0.90	1.8-6.3													●	●	●			
-KRC  粗加工	CNMA120408-KRC	0.8	0.20-0.50	0.6-6.3													●	●	●			
	CNMA120412-KRC	1.2	0.25-0.50	1.2-6.3													●	●	●			
	CNMA120416-KRC	1.6	0.30-0.70	1.8-6.3													●	●	●			

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)																	
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10 Min Max	ACP20 Min Max	ACP30 Min Max	APM10 Min Max	APM20 Min Max	APS10 Min Max	APS20 Min Max	ACK05 Min Max	ACK10 Min Max	ACK20 Min Max	ACK30 Min Max							
P	低碳钢, 碳素钢	<600	<180	250 490	160 365	110 280															
		<950	<280	150 335	100 245	75 160															
	低合金钢	700-950	200-280	120 230	90 215	70 145															
	高合金钢	950-1200	280-355	90 210	75 180	65 140															
M	奥氏体不锈钢	675	200				125 240	100 225	125 240	100 225											
	双相不锈钢	778	230				100 160	90 150	100 160	90 150											
	沉淀硬化不锈钢	1013	300				90 150	80 125	90 150	80 125											
K	灰口铸铁	700	220	150 380	110 340						190 500	170 480	150 350	130 280							
	球墨铸铁	880	260	90 280	90 210						170 280	150 260	90 220	80 180							
	可锻铸铁	800	250	120 300	90 220						140 320	120 300	90 240	80 200							
S	钴基合金, 镍基合金	1100	250-320				32 48	30 45	32 48	30 45											
	钛合金	1260	370				36 50	32 48	36 50	32 48											
N	铝	260	75																		
	铝合金	447	130																		
H	淬硬钢	-	50-60HRC								45 55										
	淬硬铸铁	-	55HRC								45 55										

负型刀片 CN 系列

CNMG / CNMM (80° Negative)

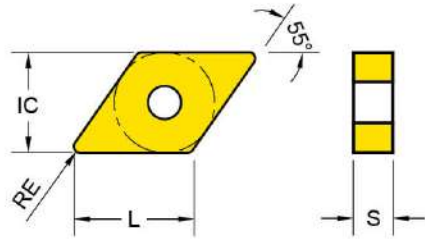


Series	L	IC	S
CN** 1204	12.9	12.7	4.76
CN** 1606	16.1	15.875	6.35
CN** 1906	19.3	19.05	6.35

CNMG/CNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P								M				K				S	
					ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-MME  中等加工	CNMG120404-MME	0.4	0.08-0.22	0.30-5.5										●	●	●						●
	CNMG120408-MME	0.8	0.15-0.42	0.60-5.5										●	●	●						●
-SSA  半精加工	CNMG120404-SSA	0.4	0.1-0.22	0.4-2.5										●	●						●	●
	CNMG120408-SSA	0.8	0.1-0.22	0.8-2.5										●	●						●	●
-SMA  中等加工	CNMG120408-SMA	0.8	0.15-0.3	0.8-3.0									●		●						●	●
	CNMG120412-SMA	1.2	0.15-0.3	1.0-3.0									●		●						●	●

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)																						
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30		
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																	
		<950	<280	150	335	100	245	75	160																	
	低合金钢	700-950	200-280	120	230	90	215	70	145																	
		950-1200	280-355	90	210	75	180	65	140																	
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																	
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225									
	双相不锈钢	778	230							100	160	90	150	100	160	90	150									
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125									
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280	
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180	
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200	
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45									
	钛合金	1260	370							36	50	32	48	36	50	32	48									
N	铝	260	75																							
	铝合金	447	130																							
H	淬硬钢	-	50-60HRC															45	55							
	淬硬铸铁	-	55HRC															45	55							



Series	L	IC	S
DN** 1104	11.6	9.525	4.76
DN** 1504	15.5	12.7	4.76
DN** 1506	15.5	12.7	6.35

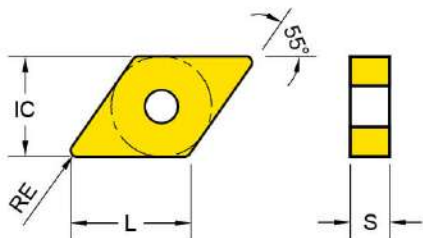
DNMG/DNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P								M				K				S	
					ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-PMB  中等加工	DNMG150408-PMB	0.8	0.15-0.44	0.8-3.9	●	●																
	DNMG150412-PMB	1.2	0.23-0.66	1.2-3.9		●																
	DNMG150604-PMB	0.4	0.08-0.22	0.4-3.9	●	●					●	●										
	DNMG150608-PMB	0.8	0.15-0.44	0.8-3.9	●	●					●	●										
	DNMG150612-PMB	1.2	0.23-0.66	1.2-3.9		●																
-PMD  中等加工	DNMG150404-PMD	0.4	0.12-0.36	0.5-5.3				◎														
	DNMG150408-PMD	0.8	0.18-0.40	0.9-5.3				◎														
	DNMG150412-PMD	1.2	0.20-0.50	1.3-5.3				◎														

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						

负型刀片 DN 系列

DNMG / DNMA (55° Negative)

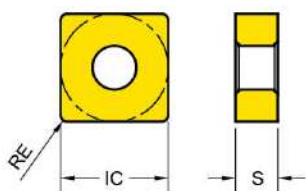


Series	L	IC	S
DN** 1104	11.6	9.525	4.76
DN** 1504	15.5	12.7	4.76
DN** 1506	15.5	12.7	6.35

					P								M			K			S				
DNMG/DNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APs10C	APs20C	
-KMA  中等加工	DNMG150404-KMA	0.4	0.08-0.22	0.4-3.9													●	●	●				
	DNMG150408-KMA	0.8	0.15-0.44	0.8-3.9														●	●	●	⊙		
	DNMG150412-KMA	1.2	0.23-0.66	1.2-3.9															●	●	⊙		
	DNMG150608-KMA	0.8	0.15-0.44	0.8-4.0															●	●	⊙		
	DNMG150612-KMA	1.2	0.23-0.66	1.2-4.0															●	●	⊙		
-KRA  粗加工	DNMG150608-KRA	0.8	0.18-0.48	0.8-4.6														●	●	⊙			
	DNMG150612-KRA	1.2	0.26-0.72	1.2-4.6																⊙	⊙		
-KRB  粗加工	DNMA150404-KRB	0.4	0.10-0.30	0.6-5.3														●	⊙				
	DNMA150408-KRB	0.8	0.20-0.60	1.2-5.3														⊙	●	●	⊙		
	DNMA150412-KRB	1.2	0.30-0.90	1.8-5.3															⊙	●	⊙		
	DNMA150608-KRB	0.8	0.20-0.60	1.2-5.3															●	●	⊙		

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						



Series	IC	S
SN** 1204	12.7	4.76
SN** 1506	15.875	6.35
SN** 1906	19.05	6.35

SNMG/SNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P								M				K				S	
					ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-PMD	SNMG120404-PMD	0.4	0.12-0.36	0.5-5.0					☉			☉										
	SNMG120408-PMD	0.8	0.18-0.40	0.8-5.0					●			☉										
	SNMG120412-PMD	1.2	0.20-0.50	1.0-5.0					●			☉										



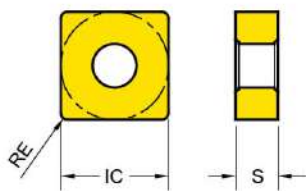
中等加工

● 常备库存 ☉ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						

负型刀片 SN 系列

SNMG / SNMA (90° Negative)

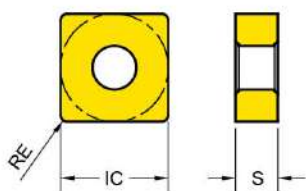


Series	IC	S
SN** 1204	12.7	4.76
SN** 1506	15.875	6.35
SN** 1906	19.05	6.35

SNMG/SNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P								M				K				S	
					ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20C	APM30C	APM10E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-KMA  中等加工	SNMG120404-KMA	0.4	0.08-0.22	0.4-4.2													●	●	●	●		
	SNMG120408-KMA	0.8	0.15-0.44	0.8-4.2													●	●	●	●		
	SNMG120412-KMA	1.2	0.23-0.66	1.2-4.2													●	●	●	●		
	SNMG150612-KMA	1.2	0.18-0.60	0.8-7.50														●	●	●		
	SNMG190608-KMA	0.8	0.15-0.44	0.6-9.0														●	●	●		
	SNMG190612-KMA	1.2	0.18-0.60	0.80-9.0														●	●	●		
-KRA  粗加工	SNMG120408-KRA	0.8	0.18-0.48	0.8-5.0													●	●	●	●		
	SNMG120412-KRA	1.2	0.26-0.72	1.2-5.0													●	●	●	●		
-KRB  粗加工	SNMA120404-KRB	0.4	0.1-0.3	0.6-6.3													●	●	●	●		
	SNMA120408-KRB	0.8	0.2-0.6	1.2-6.3													●	●	●	●		
	SNMA120412-KRB	1.2	0.3-0.9	1.8-6.3													●	●	●	●		
-KRC  粗加工	SNMA120408-KRC	0.8	0.20-0.50	0.8-5.0													●	●	●	●		
	SNMA120412-KRC	1.2	0.25-0.60	1.2-5.0													●	●	●	●		
	SNMA120416-KRC	1.6	0.30-0.70	1.5-5.0													●	●	●	●		

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						



Series	IC	S
SN** 1204	12.7	4.76
SN** 1506	15.875	6.35
SN** 1906	19.05	6.35

SNMG/SNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P								M				K				S	
					ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-MME	SNMG120408-MME	0.8	0.15-0.42	0.60-4.2											●	◎						
	SNMG120412-MME	1.2	0.22-0.65	0.90-4.2											●	◎						



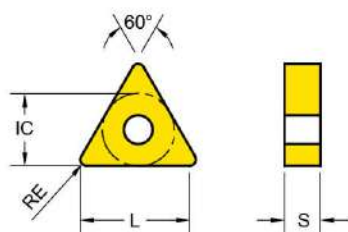
中等加工

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						

负型刀片 TN 系列

TNMG / TNMA (60° Negative)



Series	L	IC	S
TN** 1604	16.5	9.525	4.76
TN** 2204	22	12.7	4.76

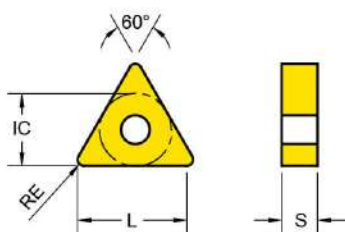
TNMG/TNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P								M				K				S	
					ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-PMD	TNMG160404-PMD	0.4	0.10-0.36	0.4-3.5					◎			◎										
	TNMG160408-PMD	0.8	0.10-0.40	0.8-3.5					●			◎										
	TNMG160412-PMD	1.2	0.15-0.40	1.0-3.5					●			◎										



中等加工

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		高合金钢	950-1200	280-355	90	210	75	180	65	140															
	1200-1400		355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						



Series	L	IC	S
TN** 1604	16.5	9.525	4.76
TN** 2204	22	12.7	4.76

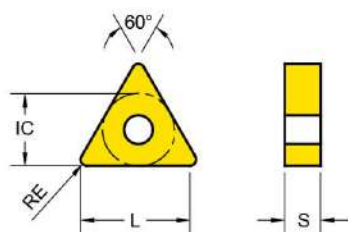
					P								M			K				S		
TNMG/TNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C	
-KMA  中等加工	TNMG160404-KMA	0.4	0.08-0.22	0.4-4.1												◎	●	●	◎			
	TNMG160408-KMA	0.8	0.15-0.44	0.8-4.1												◎	●	●	◎			
	TNMG160412-KMA	1.2	0.23-0.66	1.2-4.1														●	●	◎		
-KRA  粗加工	TNMG160408-KRA	0.8	0.18-0.48	0.8-4.8														●	◎			
	TNMG160412-KRA	1.2	0.26-0.72	1.2-4.8														●	◎			
	TNMG220404-KRA	0.4	0.09-0.24	0.4-6.0														●	◎			
	TNMG220408-KRA	0.8	0.18-0.48	0.8-6.0														●	◎			
	TNMG220412-KRA	1.2	0.26-0.72	1.2-6.0														●	◎			
	TNMG220416-KRA	1.6	0.35-0.96	1.6-6.0														●	◎			
-KRB  粗加工	TNMA160404-KRB	0.4	0.1-0.3	0.6-5.8													●	●	◎			
	TNMA160408-KRB	0.8	0.2-0.6	1.2-5.8														●	●	◎		
	TNMA160412-KRB	1.2	0.3-0.9	1.8-5.8														●	●	◎		

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢，碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		高合金钢	950-1200	280-355	90	210	75	180	65	140															
	1200-1400		355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金，镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						

负型刀片 TN 系列

TNMG / TNMA (60° Negative)



Series	L	IC	S
TN** 1604	16.5	9.525	4.76
TN** 2204	22	12.7	4.76

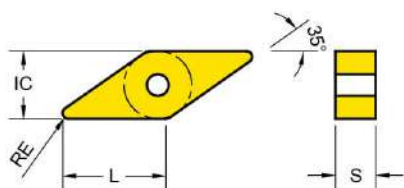
TNMG/TNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P								M				K				S	
					ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-MME	TNMG160408-MME	0.8	0.15-0.42	0.60-4.1												●						



中等加工

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						



Series	L	IC	S
VN** 1604	16.5	9.525	4.76

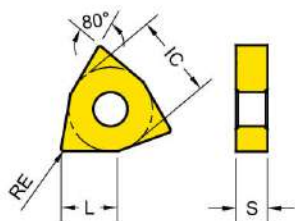
					P								M				K				S	
VNMG/VNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-PMB  中等加工	VNMG160404-PMB	0.4	0.08-0.22	0.4-3.3	●	●					◎	●										
	VNMG160408-PMB	0.8	0.15-0.44	0.8-3.3	●	●					◎	●										
-PMD  中等加工	VNMG160404-PMD	0.4	0.10-0.36	0.4-3.0					●			●										
	VNMG160408-PMD	0.8	0.10-0.40	0.8-3.0					●			●										
-KMA  中等加工	VNMG160404-KMA	0.4	0.08-0.22	0.4-3.3													●	●	●	◎		
	VNMG160408-KMA	0.8	0.15-0.44	0.8-3.3													●	●	●	◎		
	VNMG160412-KMA	1.2	0.23-0.66	1.2-3.3														●	●	◎		
-KRB  粗加工	VNMA160404-KRB	0.4	0.1-0.3	0.6-3.3													●	●	◎			
	VNMA160408-KRB	0.8	0.2-0.6	1.2-3.3													●	●	◎			
	VNMA160412-KRB	1.2	0.3-0.9	1.8-3.3													●	●	◎			
-MME  中等加工	VNMG160404-MME	0.4	0.08-0.22	0.30-4.1										●	●	●						
	VNMG160408-MME	0.8	0.15-0.42	0.60-4.1										●	●	●						

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						

负型刀片 WN 系列

WNMG / WNMA (80° Negative)

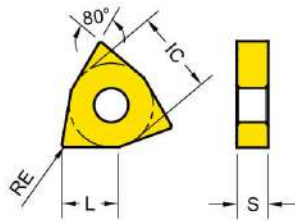


Series	L	IC	S
WN** 0804	8.69	12.7	4.76

WNMG/WNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P								M				K				S	
					ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-PMB  中等加工	WNMG080408-PMB	0.8	0.15-0.44	0.8-2.9	●	●					◎	●										
	WNMG080412-PMB	1.2	0.23-0.66	1.2-2.9	●	●					◎	●										
-PMD  中等加工	WNMG080404-PMD	0.4	0.10-0.36	0.4-3.0				●	●		◎											
	WNMG080408-PMD	0.8	0.10-0.40	0.8-3.0				●	●		◎	●										
	WNMG080412-PMD	1.2	0.15-0.45	1.0-3.0					●		◎	●										

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						



Series	L	IC	S
WN** 0804	8.69	12.7	4.76

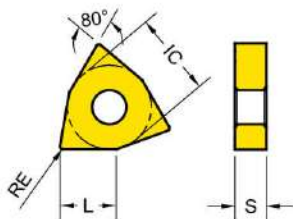
					P								M				K				S		
WNMG/WNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	AP510C	AP520C	
-KMA  中等加工	WNMG080404-KMA	0.4	0.08-0.22	0.4-2.9													●	●	●	◎			
	WNMG080408-KMA	0.8	0.15-0.44	0.8-2.9														●	●	●	●		
	WNMG080412-KMA	1.2	0.23-0.66	1.2-2.9															●	●	◎		
-KRA  粗加工	WNMG080408-KRA	0.8	0.18-0.48	0.8-3.5														●	●	●			
	WNMG080412-KRA	1.2	0.26-0.72	1.2-3.5															●	●	●		
-KRB  粗加工	WNMA080404-KRB	0.4	0.1-0.3	0.6-4.3														●	●	◎			
	WNMA080408-KRB	0.8	0.2-0.6	1.2-4.3															●	●	●		
	WNMA080412-KRB	1.2	0.3-0.9	1.8-4.3															●	●	●		
-KRC  粗加工	WNMA080408-KRC	0.8	0.20-0.45	0.8-4.5													●	◎	◎				
	WNMA080412-KRC	1.2	0.22-0.50	1.2-4.5														●	◎	◎			
	WNMA080416-KRC	1.6	0.25-0.60	1.5-4.5														●	◎	◎			

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		高合金钢	950-1200	280-355	90	210	75	180	65	140															
	1200-1400		355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						

负型刀片 WN 系列

WNMG / WNMA (80° Negative)



Series	L	IC	S
WN** 0804	8.69	12.7	4.76

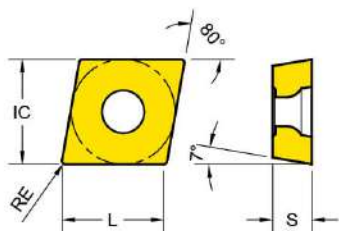
WNMG/WNMA	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P								M				K				S	
					ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-MME	WNMG080404-MME	0.4	0.08-0.22	0.30-3.0											●	●						◎
	WNMG080408-MME	0.8	0.15-0.42	0.60-3.0											●	●						◎



中等加工

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
		778	230							100	160	90	150	100	160	90	150								
	双相不锈钢	1013	300							90	150	80	125	90	150	80	125								
		沉淀硬化不锈钢																							
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50			36	50			32	48						
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						



Series	L	IC	S
CC** 0602	6.45	6.35	2.38
CC** 09T3	9.67	9.525	3.97
CC** 1204	12.9	12.7	4.76

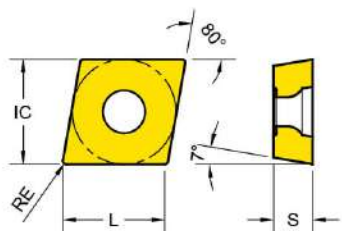
					P								M				K				S		
CCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C	
-KMA  中等加工	CCMT060204-KMA	0.4	0.08-0.20	0.4-2.0													☉	●	●	☉			
	CCMT060208-KMA	0.8	0.12-0.25	0.8-2.0															●	●	☉		
	CCMT09T304-KMA	0.4	0.08-0.25	0.4-3.0														☉	●	●	☉		
	CCMT09T308-KMA	0.8	0.12-0.32	0.8-3.0															●	●	●		
	CCMT120404-KMA	0.4	0.10-0.25	0.5-3.5														☉	●	●	☉		
	CCMT120408-KMA	0.8	0.12-0.32	0.8-3.5															●	●	●		

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						

正型刀片 CC 系列

CCMT (80° Positive)

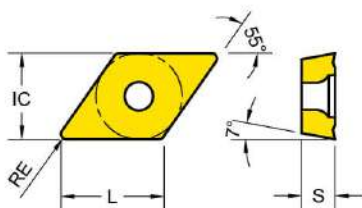


Series	L	IC	S
CC** 0602	6.45	6.35	2.38
CC** 09T3	9.67	9.525	3.97
CC** 1204	12.9	12.7	4.76

					P								M				K				S		
CCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	APU20B	ACK05E	ACK10E	ACK20E	ACK30E	APS10C	APS20C
-MMA  中等加工	CCMT09T304-MMA	0.4	0.06-0.23	0.3-2.5																			
	CCMT09T308-MMA	0.8	0.08-0.3	0.6-2.5																			
	CCMT120404-MMA	0.4	0.08-0.2	0.3-3.5																			
	CCMT120408-MMA	0.8	0.15-0.32	0.6-3.5																			
-UMA  中等加工	CCMT060204-UMA	0.4	0.06-0.18	0.4-2.1																			
	CCMT060208-UMA	0.8	0.10-0.35	0.8-2.1																			
	CCMT09T304-UMA	0.4	0.06-0.18	0.4-3.2																			
	CCMT09T308-UMA	0.8	0.10-0.35	0.8-3.2																			
	CCMT120404-UMA	0.4	0.06-0.18	0.4-4.3																			
	CCMT120408-UMA	0.8	0.10-0.35	0.8-4.3																			
	CCMT120412-UMA	1.2	0.15-0.50	1.2-4.3																			

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APS10		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280																
		<950	<280	150	335	100	245	75	160																
	低合金钢	700-950	200-280	120	230	90	215	70	145																
		950-1200	280-355	90	210	75	180	65	140																
	高合金钢	1200-1400	355-415	70	175	55	135	45	90																
M	奥氏体不锈钢	675	200							125	240	100	225	125	240	100	225								
	双相不锈钢	778	230							100	160	90	150	100	160	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	90	150	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	32	48	30	45								
	钛合金	1260	370							36	50	32	48	36	50	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						



Series	L	IC	S
DC** 0702	7.75	6.35	2.38
DC** 11T3	11.63	9.525	3.97

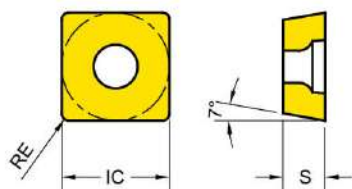
					P								M				K				S			
DCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	APU20B	ACK05E	ACK10E	ACK20E	ACK30E	AP10C	AP30C	
-KMA  中等加工	DCMT070204-KMA	0.4	0.08-0.20	0.4-2.0														◎	◎	●	◎			
	DCMT070208-KMA	0.8	0.12-0.25	0.5-2.0																◎	●	◎		
	DCMT11T304-KMA	0.4	0.08-0.25	0.4-3.0															◎	●	●	◎		
	DCMT11T308-KMA	0.8	0.12-0.32	0.8-3.0																●	●	●		
-MMA  中等加工	DCMT11T304-MMA	0.4	0.08-0.25	0.4-3.0									◎	◎	●	◎								
	DCMT11T308-MMA	0.8	0.12-0.32	0.8-3.0										◎	◎	●	◎							◎
-UMA  中等加工	DCMT070204-UMA	0.4	0.06-0.18	0.4-2.3				◎	◎				◎	●	●	●	●							
	DCMT070208-UMA	0.8	0.10-0.35	0.8-2.3	◎	◎		◎	●					◎	●	●	●	●						
	DCMT11T304-UMA	0.4	0.06-0.18	0.4-3.5				◎	◎					◎	●	●	●	●						
	DCMT11T308-UMA	0.8	0.10-0.35	0.8-3.5	◎	◎		●	●					◎	●	●	●	●						

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APU20		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280					110	280										
		<950	<280	150	335	100	245	75	160					75	160										
	低合金钢	700-950	200-280	120	230	90	215	70	145					70	145										
		950-1200	280-355	90	210	75	180	65	140					65	140										
	高合金钢	1200-1400	355-415	70	175	55	135	45	90					45	90										
M	奥氏体不锈钢	675	200							125	240	100	225	100	225	100	225								
	双相不锈钢	778	230							100	160	90	150	90	150	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	80	125	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	30	45	30	45								
	钛合金	1260	370							36	50	32	48	32	48	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						

正型刀片 SC 系列

SCMT (90° Positive)

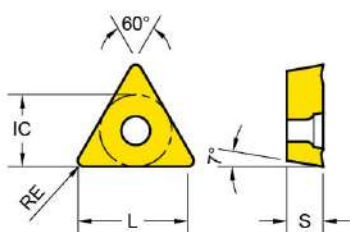


Series	IC	S
SC** 09T3	9.525	3.97
SC** 1204	12.7	4.76

					P								M				K				S			
SCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	APU20B	ACK05E	ACK10E	ACK20E	ACK30E	AP510C	AP520C	
-KMA  中等加工	SCMT09T304-KMA	0.4	0.08-0.25	0.4-3.0															●	●	◎			
	SCMT09T308-KMA	0.8	0.12-0.32	0.5-3.0																●	●	◎		
	SCMT120404-KMA	0.4	0.08-0.25	0.5-3.0																●	●	◎		
	SCMT120408-KMA	0.8	0.12-0.32	0.8-3.5																●	●	◎		
-MMA  中等加工	SCMT120404-MMA	0.4	0.08-0.25	0.5-3.0										●	◎									
	SCMT120408-MMA	0.8	0.12-0.32	0.8-3.5									◎	●	●	◎								
-UMA  中等加工	SCMT09T304-UMA	0.4	0.06-0.18	0.4-3.1				◎	◎	◎				●		●	●							
	SCMT09T308-UMA	0.8	0.10-0.35	0.8-3.1				●	●			◎			●	●	●	●						
	SCMT120404-UMA	0.4	0.06-0.18	0.4-4.2				◎	◎						●		●	●						
	SCMT120408-UMA	0.8	0.10-0.35	0.8-4.2				●	●			◎			●	●	●	●						

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)																					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10		ACP20		ACP30		APM10		APM20		APU20		APS20		ACK05		ACK10		ACK20		ACK30	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	<600	<180	250	490	160	365	110	280					110	280										
		<950	<280	150	335	100	245	75	160					75	160										
	低合金钢	700-950	200-280	120	230	90	215	70	145					70	145										
		950-1200	280-355	90	210	75	180	65	140					65	140										
	高合金钢	1200-1400	355-415	70	175	55	135	45	90					45	90										
M	奥氏体不锈钢	675	200							125	240	100	225	100	225	100	225								
	双相不锈钢	778	230							100	160	90	150	90	150	90	150								
	沉淀硬化不锈钢	1013	300							90	150	80	125	80	125	80	125								
K	灰口铸铁	700	220	150	380	110	340											190	500	170	480	150	350	130	280
	球墨铸铁	880	260	90	280	90	210											170	280	150	260	90	220	80	180
	可锻铸铁	800	250	120	300	90	220											140	320	120	300	90	240	80	200
S	钴基合金, 镍基合金	1100	250-320							32	48	30	45	30	45	30	45								
	钛合金	1260	370							36	50	32	48	32	48	32	48								
N	铝	260	75																						
	铝合金	447	130																						
H	淬硬钢	-	50-60HRC															45	55						
	淬硬铸铁	-	55HRC															45	55						



Series	L	IC	S
TC** 1102	11.0	6.35	2.38
TC** 16T3	16.5	9.525	3.97

					P								M				K			S				
TCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	ACP10E	ACP20E	ACP30E	ACP10B	ACP20B	ACP30B	ACP10D	ACP20D	APM10C	APM20B	APM20C	APM20E	APU20B	ACK05E	ACK10E	ACK20E	ACK30E	AP-S10C	AP-S20C	
-KMA  中等加工	TCMT110204-KMA	0.4	0.08-0.20	0.4-2.0															☉	●	☉			
	TCMT110208-KMA	0.8	0.12-0.30	0.5-2.0																☉	●	☉		
	TCMT16T304-KMA	0.4	0.08-0.25	0.5-3.0																●	●	☉		
	TCMT16T308-KMA	0.8	0.12-0.32	0.8-3.5																●	●	☉		
	TCMT16T312-KMA	1.2	0.15-0.44	1.2-3.5																●	●	☉		
-MMA  中等加工	TCMT110204-MMA	0.4	0.08-0.20	0.4-2.0									☉	☉	●	☉								
	TCMT110208-MMA	0.8	0.12-0.30	0.5-2.0										☉	☉	●	☉							
	TCMT16T304-MMA	0.4	0.08-0.25	0.5-3.0										☉	●	●	☉							
	TCMT16T308-MMA	0.8	0.12-0.32	0.8-3.5										●	●	●	☉							
-UMA  中等加工	TCMT110204-UMA	0.4	0.06-0.18	0.4-3.3				☉	☉				☉	●	●	●	●							
	TCMT110208-UMA	0.8	0.10-0.35	0.8-3.3				☉	●					●	●	●	●	●						
	TCMT16T304-UMA	0.4	0.06-0.18	0.4-4.9				☉	☉					☉	●	●	●							
	TCMT16T308-UMA	0.8	0.10-0.35	0.8-4.9				●	●					●	●	●	●							

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)															
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ACP10 Min Max	ACP20 Min Max	ACP30 Min Max	APM10 Min Max	APM20 Min Max	APS10 Min Max	APS20 Min Max	ACK05 Min Max	ACK10 Min Max	ACK20 Min Max	ACK30 Min Max					
P	低碳钢, 碳素钢	<600	<180	250 490	160 365	110 280													
		<950	<280	150 335	100 245	75 160													
	低合金钢	700-950	200-280	120 230	90 215	70 145													
		950-1200	280-355	90 210	75 180	65 140													
M	奥氏体不锈钢	675	200				125 240	100 225	125 240	100 225									
		778	230				100 160	90 150	100 160	90 150									
	沉淀硬化不锈钢	1013	300				90 150	80 125	90 150	80 125									
K	灰口铸铁	700	220	150 380	110 340						190 500	170 480	150 350	130 280					
	球墨铸铁	880	260	90 280	90 210						170 280	150 260	90 220	80 180					
	可锻铸铁	800	250	120 300	90 220						140 320	120 300	90 240	80 200					
S	钴基合金, 镍基合金	1100	250-320				32 48	30 45	32 48	30 45									
	钛合金	1260	370				36 50	32 48	36 50	32 48									
N	铝	260	75																
	铝合金	447	130																
H	淬硬钢	-	50-60HRC								45 55								
	淬硬铸铁	-	55HRC								45 55								

SWISS TOOL SERIES

小零件加工系列

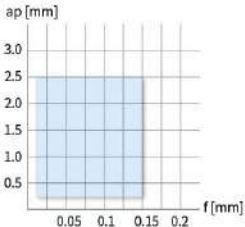
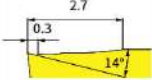
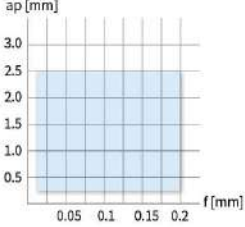
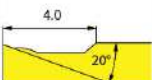
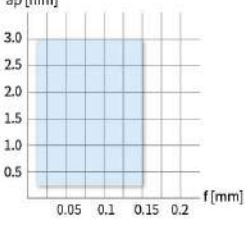
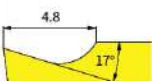


材质一览

车削材料应用																				
车削材质	ISO 组别	涂层工艺	工件材料组别						应用范围											技术说明
			P	M	K	S	N	H	01	05	10	15	20	25	30	35	40	45	50	
APM30D	M20~M35	PVD		●																超微粒硬质合金基体搭配致密的高硬纳米复合涂层，具有优异的耐磨性和抗崩刃性，适用于不锈钢小零件车削加工。
APU20D	P10~P25	PVD	☾																	超细微粒耐磨硬质合金基体搭配高硬PVD 涂层，具有高硬度、抗氧化性和高耐磨性，适用于稳定工况下连续加工。
	M10~M25			●																
APU30D	P20~P35	PVD	☾																	PVD 涂层结合高抗破损性的硬质合金基体，具有优异的耐热性和抗崩刃性，适用于稳定工况下连续和轻断续加工。
	M20~M35			●																

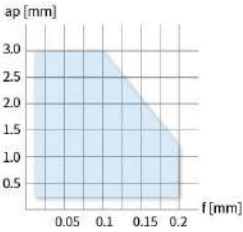
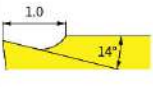
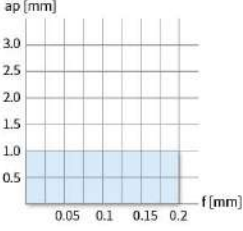
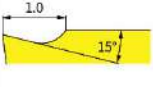
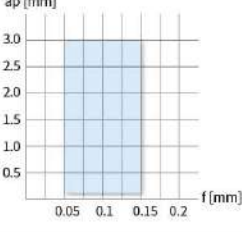
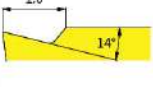
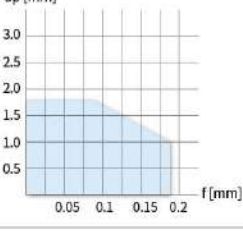
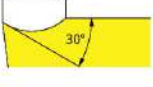
槽型一览

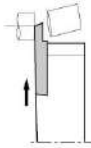
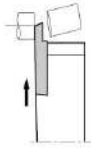
正型精磨刀片

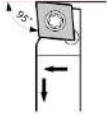
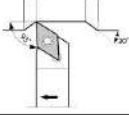
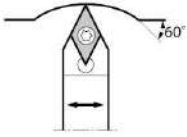
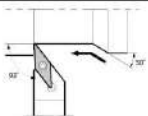
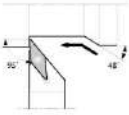
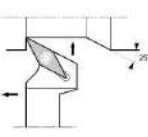
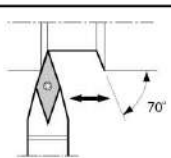
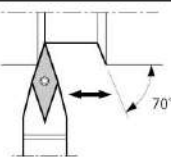
应用	槽型	断屑槽	断屑范围示意	断屑槽剖面	CC	DC	TB/TC/TP	TN	VB/VC/VP
精磨级刀片	UYL				CCGT	DCGT			VBGT/VCGT
									
	AUL				P.330	P.333			P.334
								TNGG	
	UCL							P.344	
					CCGT	DCGT			VBGT/VCGT
									
					P.330	P.333			P.334

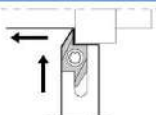
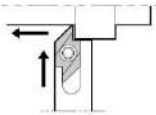
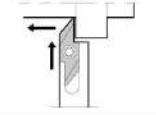
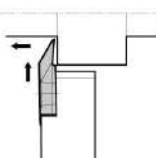
槽型一览

正型精磨刀片

应用	槽型	断屑槽	断屑范围示意	断屑槽剖面	CC	DC	TB/TC/TP	TN	VB/VC/VP
精磨级刀片	MR/L-J					DCGT/DCET			VPET
									
						P.332			P.341
	MR/L-S				CCGT	DCGT	TBET/TCGT/TPGH	TNGG	VBGT/VCET/VPET
精磨级刀片									
					P.328	P.332	P.343	P.344	P.334
	MR/L-Y								VBGT/VCET
									
精磨级刀片									P.334
	MR/L-U				CCGT	DCGT			VPET
									
					P.328	P.332			P.340

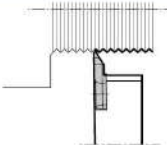
刀杆名称	刀柄形状	刀柄尺寸(mm) (高 * 宽 * 长)
KTKFR/L****JX-12 (45)		10*10*120
		12*12*120
		16*16*120
		20*20*120
KTKFR/L****JX-16 (45)		10*10*120
		12*12*120
		16*16*120
		20*20*120

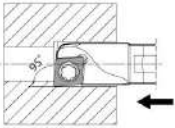
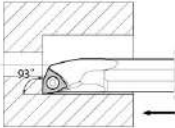
刀杆名称	刀柄形状	刀柄尺寸(mm) (高 * 宽 * 长)
SCLC (46)		10*10*120
		12*12*120
		16*16*120
SDJC (46)		10*10*120
		12*12*120
		16*16*120
SDNC (47)		10*10*100
		12*12*100
		14*14*100
		16*16*100
SVJB (47)		20*20*120
		10*10*120
		12*12*120
SVJC (48)		16*16*120
		12*12*120
		10*10*120
SVPP (48)		20*20*125
		16*16*120
		12*12*120
		10*10*120
SVVB (49)		20*20*125
		16*16*100
		12*12*100
		10*10*100
SVVC (49)		16*16*100
		12*12*100
		10*10*100

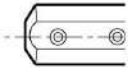
刀杆名称	刀柄形状	刀柄尺寸(mm) (高 * 宽 * 长)
SABSR****40F (50)		10*10*120
		12*12*120
		16*16*120
SABWR****JX-40F (50)		10*10*130
		12*12*120
		16*16*120
SABWR****JX-50F (51)		10*10*120
		12*12*120
		16*16*120
KTKFR/L****JX-12 (51)		10*10*120
		12*12*120
		16*16*120
		20*20*120
KTKFR/L****JX-16 (52)		10*10*120
		12*12*120
		16*16*120
		20*20*120

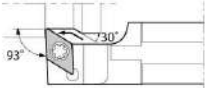
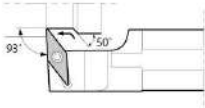
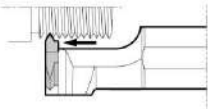
螺纹加工

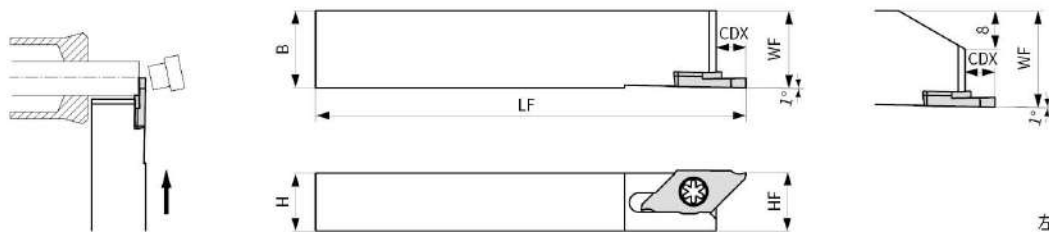
Threading

刀杆名称	刀柄形状	刀柄尺寸(mm) (高 * 宽 * 长)
KTKFR/L****JX-12 (52)		10*10*120
		12*12*120
		16*16*120
		20*20*120

刀杆名称	刀柄形状	刀柄尺寸 (DCOM) (mm)
S-SCLC (53)		4.5, 5, 6, 7, 8, 10
S-SWUB (53)		5, 6

刀杆名称	刀柄形状	刀柄尺寸 (DCOM) (mm)	夹持直径
RBH*** (58.59)		15.875/16/19.05/20/22/25/25.4	2, 3, 4, 5, 6, 7, 8

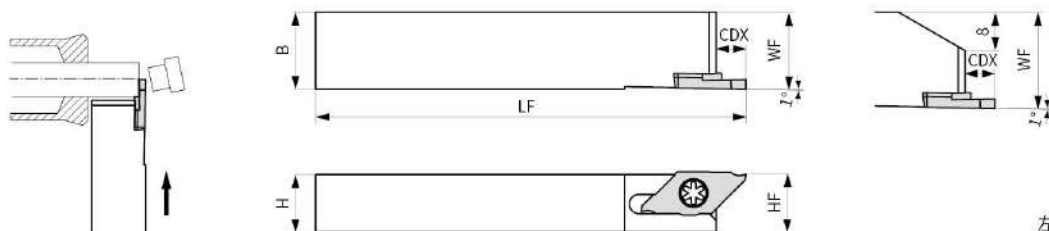
刀杆名称	刀柄形状	夹持直径(DCON) (mm)
DS-SCLCR/L (54)		14, 15.875, 16, 19.05, 20, 22, 25.4
DS-SDUCR/L (55)		14, 15.875, 16, 19.05, 20, 22, 25.4
DS-SVUBR/L (56)		14, 15.875, 16, 19.05, 20, 22, 25.4
DS-KTGFR/L (56)		14, 15.875, 16, 19.05, 20, 22, 25.4
DS-KTTXR/L (57)		14, 15.875, 16, 19.05, 20, 22, 25.4



本图为左手(L)
左手(L)刀杆适用左手(L)刀片

▶ 刀杆尺寸 Shank size

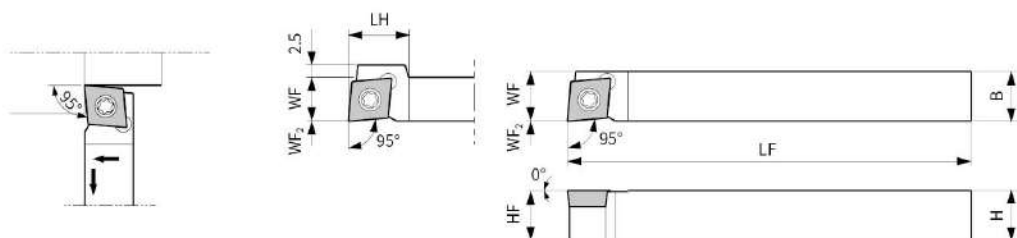
型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
KTKFR/L1010JX-12	TKF12R/L***	10	10	120	10	10	M4*10	T15	P.83
KTKFR/L1212JX-12	TKF12R/L***	12	12	120	12	12	M4*10	T15	P.83
KTKFR/L1616JX-12	TKF12R/L***	16	16	120	16	16	M4*10	T15	P.83
KTKFR/L2020JX-12	TKF12R/L***	20	20	120	20	20	M4*10	T15	P.83



本图为左手(L)
左手(L)刀杆适用左手(L)刀片

▶ 刀杆尺寸 Shank size

型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
KTKFR/L1010JX-16	TKF16R/L***	10	10	120	10	10	M4*10	T15	P.83
KTKFR/L1212JX-16	TKF16R/L***	12	12	120	12	12	M4*10	T15	P.83
KTKFR/L1616JX-16	TKF16R/L***	16	16	120	16	16	M4*10	T15	P.83
KTKFR/L2020JX-16	TKF16R/L***	20	20	120	20	20	M4*10	T15	P.83

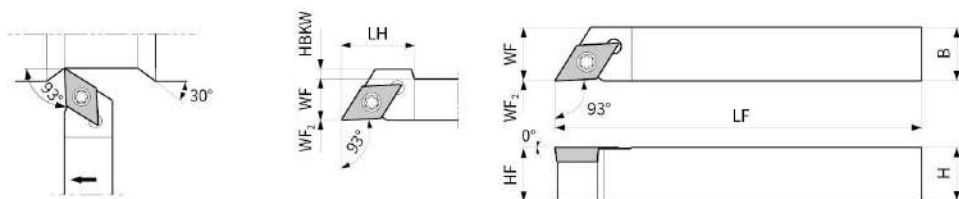


本图为右手(R)

► 刀杆尺寸 Shank size

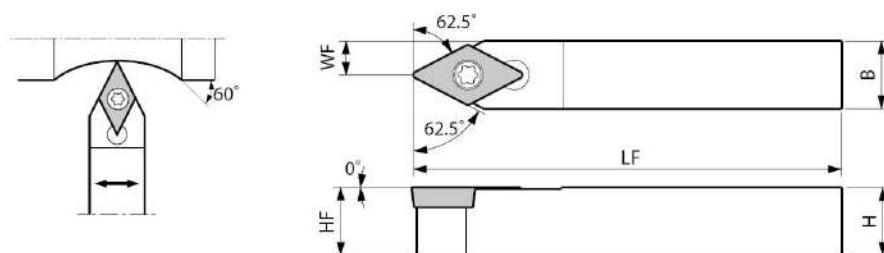
型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
SCLCR/L1010JX06N	CC**0602**	10	10	120	10	10	M2.5*7	T8	P.60
SCLCR/L1212JX06N	CC**0602**	12	12	120	12	12	M2.5*7	T8	P.60
SCLCR/L1010JX09N	CC**09T3**	10	10	120	10	10	M4*10	T15	P.60
SCLCR/L1212JX09N	CC**09T3**	12	12	120	12	12	M4*10	T15	P.60
SCLCR/L1616JX09N	CC**09T3**	16	16	120	16	16	M4*10	T15	P.60

SDJC-FF



► 刀杆尺寸 Shank size

型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
SDJCR/L1010JX07N	DC**0702**	10	10	120	10	10	M2.5*7	T8	P.63
SDJCR/L1212JX07N	DC**0702**	12	12	120	12	12	M2.5*7	T8	P.63
SDJCR/L1010JX11N	DC**11T3**	10	10	120	10	10	M4*10	T15	P.63
SDJCR/L1212JX11N	DC**11T3**	12	12	120	12	12	M4*10	T15	P.63
SDJCR/L1616JX11N	DC**11T3**	16	16	120	16	16	M4*10	T15	P.63

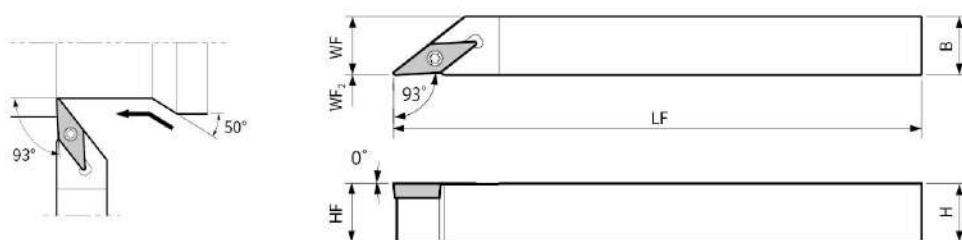


► 刀杆尺寸 Shank size

型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
SDNCN1010H07	DC**0702**	10	10	100	10	5	M2.5*7	T8	P.63
SDNCN1212H07	DC**0702**	12	12	100	12	6	M2.5*7	T8	P.63
SDNCN1212H11	DC**11T3**	12	12	100	12	6	M4*10	T15	P.63
SDNCN1414H11	DC**11T3**	14	14	100	14	7	M4*10	T15	P.63
SDNCN1616H11	DC**11T3**	16	16	100	16	8	M4*10	T15	P.63
SDNCN2020K11	DC**11T3**	20	20	125	20	10	M4*10	T15	P.63

外径 / 仿形加工, 螺钉紧固, 无偏头

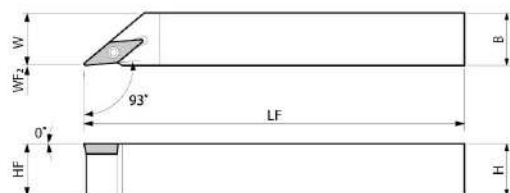
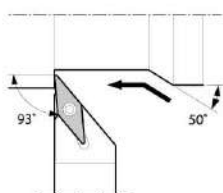
SVJB-FF



本图为右手 (R)

► 刀杆尺寸 Shank size

型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
SVJBR/L1010JX11N	VB**1103**	10	10	120	10	10	M2.5*7	T8	P.66
SVJBR/L1212JX11N	VB**1103**	12	12	120	12	12	M2.5*7	T8	P.66
SVJBR/L1616JX11N	VB**1103**	16	16	120	16	16	M2.5*7	T8	P.66



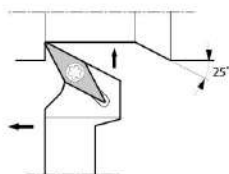
本图为右手(R)

▶ 刀杆尺寸 Shank size

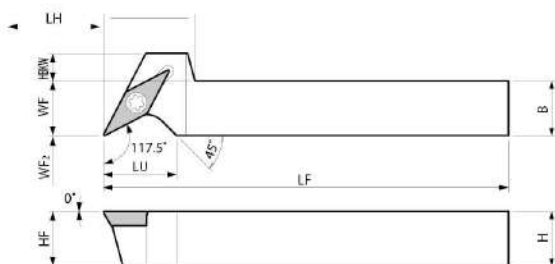
型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
SVJCR/L1010JX11N	VC**1103**	10	10	120	10	10	M2.5*7	T8	P.68
SVJCR/L1212JX11N	VC**1103**	12	12	120	12	12	M2.5*7	T8	P.68
SVJCR/L1616JX11N	VC**1103**	16	16	120	16	16	M2.5*7	T8	P.68

SVPP-FF

外径 / 端面 / 仿形 / 清角加工, 螺钉紧固, 无偏头



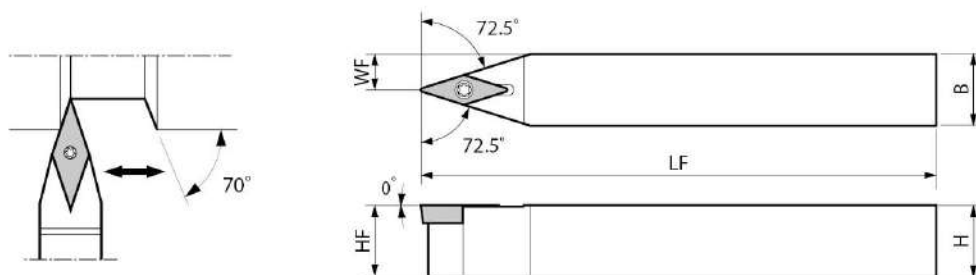
SVPPR1616...08FF



本图为右手(R)

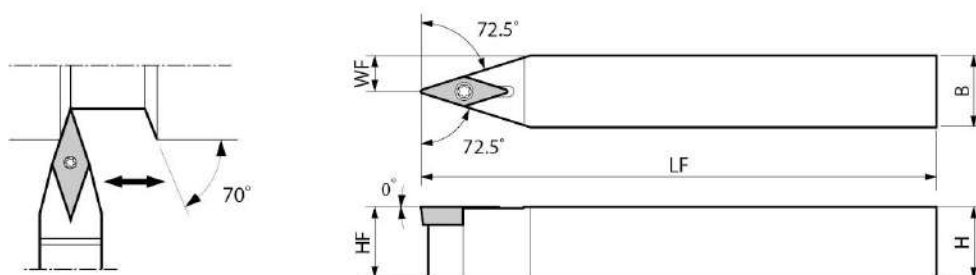
▶ 刀杆尺寸 Shank size

型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
SVPPR1010JX11N	VP*T1103**	10	10	120	10	10	M2.5*7	T8	P.70
SVPPR1212JX11N	VP*T1103**	12	12	120	12	12	M2.5*7	T8	P.70
SVPPR1616JX11N	VP*T1103**	16	16	120	16	16	M2.5*7	T8	P.70
SVPPR2020JX11N	VP*T1103**	20	20	125	20	20	M2.5*7	T8	P.70



► 刀杆尺寸 Shank size

型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
SVVBN1010H11	VB**1103**	10	10	120	10	5	M2.5*7	T8	P.66
SVVBN 1212H11	VB**1103**	12	12	120	12	6	M2.5*7	T8	P.66
SVVBN1616H11	VB**1103**	16	16	120	16	8	M2.5*7	T8	P.66
SVVBN2020H11	VB**1103**	20	20	125	20	10	M2.5*7	T8	P.66



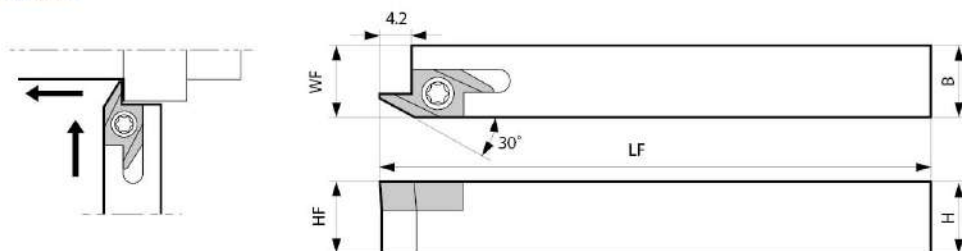
► 刀杆尺寸 Shank size

型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
SVVCN1010H11	VC**1103**	10	10	120	10	6	M2.5*7	T8	P.68
SVVCN 1212H11	VC**1103**	12	12	120	12	6	M2.5*7	T8	P.68
SVVCN1616H11	VC**1103**	16	16	120	16	8	M2.5*7	T8	P.68

SABS-40F

背车(外径)加工用, 螺钉紧固, 切刃宽度 2.8mm/ 最大深度 4mm

后肩面加工

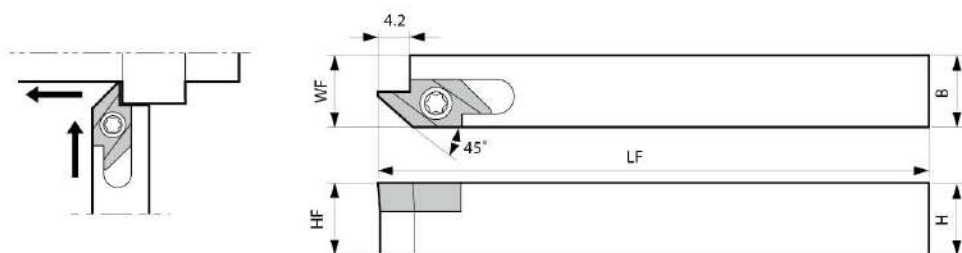


▶ 刀杆尺寸 Shank size

型号	刀片	R	H	B	LF	HF	WF	对应刀片页
SABSR1010JX-40F	ABS15R40...	●	10	10	120	10	10.2	P.89
SABSR1212JX-40F	ABS15R40...	●	12	12	120	10	12.2	P.89
SABSR1616JX-40F	ABS15R40...	●	16	16	120	10	16.2	P.89

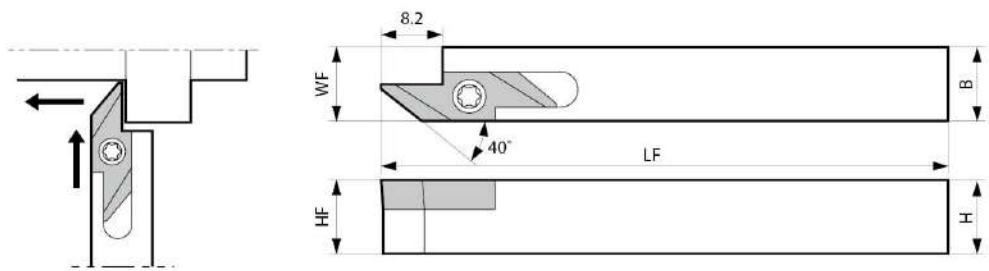
SABW-40F

背车(外径)加工用, 螺钉紧固, 切刃宽度 4.7mm/ 最大深度 4mm



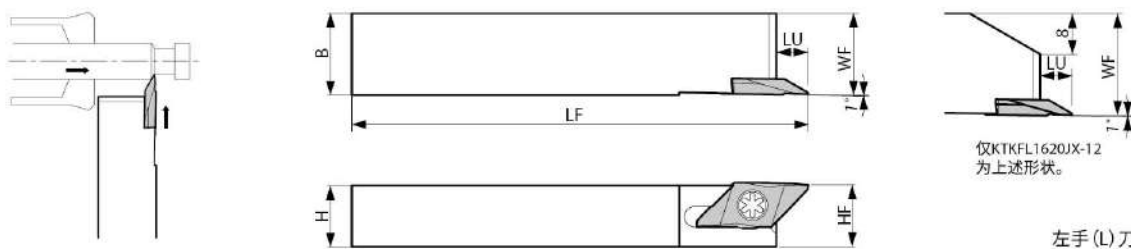
▶ 刀杆尺寸 Shank size

型号	刀片	R	H	B	LF	HF	WF	对应刀片页
SABWR1010JX-40F	ABW15R40...	●	10	10	120	10	10.2	P.89
SABWR1212JX-40F	ABW15R40...	●	12	12	120	10	12.2	P.89
SABWR1616JX-40F	ABW15R40...	●	16	16	120	10	16.2	P.89



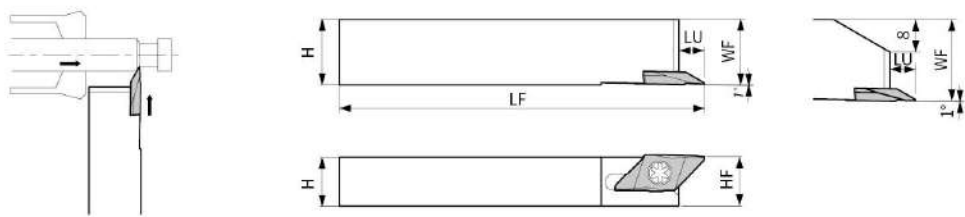
▶ 刀杆尺寸 Shank size

型号	刀片	R	H	B	LF	HF	WF	对应刀片页
SABWR1010JX-50F	ABW23R50...	●	10	10	120	10	10.2	P.90
SABWR1212JX-50F	ABW23R50...	●	12	12	120	12	12.2	P.90
SABWR1616JX-50F	ABW23R50...	●	16	16	120	16	16.2	P.90



▶ 刀杆尺寸 Shank size

型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
KTKFR/L1010JX-12	TKFB12R/L***	10	10	120	10	10	M4*10	T15	P.91
KTKFR/L1212JX-12	TKFB12R/L***	12	12	120	12	12	M4*10	T15	P.91
KTKFR/L1616JX-12	TKFB12R/L***	16	16	120	16	16	M4*10	T15	P.91
KTKFR/L2020JX-12	TKFB12R/L***	20	20	120	20	20	M4*10	T15	P.91

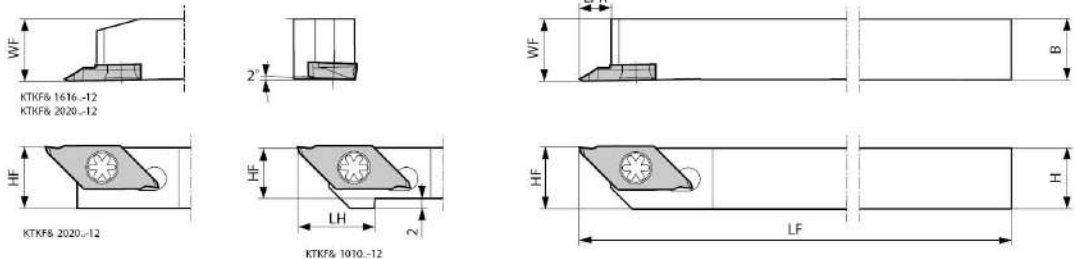


本图为左手(L)
左手(L)刀杆适用左手(L)刀片

刀杆尺寸 Shank size

型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
KTKFR/L1010JX-16	TKFB16R/L***	10	10	120	10	10	M4*10	T15	P.91
KTKFR/L1212JX-16	TKFB16R/L***	12	12	120	12	12	M4*10	T15	P.91
KTKFR/L1616JX-16	TKFB16R/L***	16	16	120	16	16	M4*10	T15	P.91
KTKFR/L2020JX-16	TKFB16R/L***	20	20	120	20	20	M4*10	T15	P.91

螺纹加工



刀杆尺寸 Shank size

型号	刀片	H	B	LF	HF	WF	螺钉	扳手	对应刀片页
KTKFR/L1010JX-12	TKFT12R/L***	10	10	120	10	10	M4*10	T15	P.92
KTKFR/L1212JX-12	TKFT12R/L***	12	12	120	12	12	M4*10	T15	P.92
KTKFR/L1616JX-12	TKFT12R/L***	16	16	120	16	16	M4*10	T15	P.92
KTKFR/L2020JX-12	TKFT12R/L***	20	20	120	20	20	M4*10	T15	P.92

内孔加工

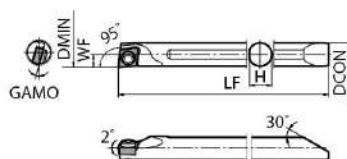
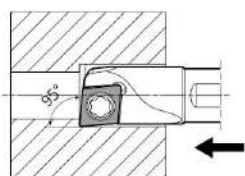


Fig. 1

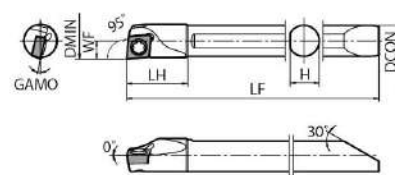


Fig. 2

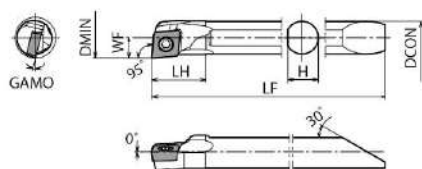


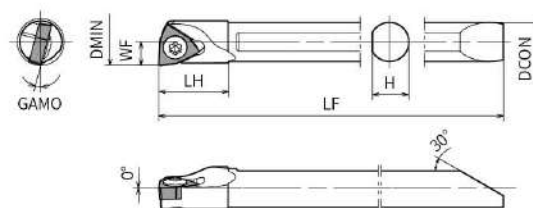
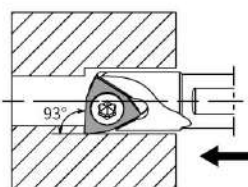
Fig. 3

本图为右手(R)
右手(R)刀杆适用左手(L)刀片
最大悬伸量 $L/D \approx 3$

▶ 刀杆尺寸 Shank size

型号	刀片	DMIN	DCON	LH	LF	WF	螺钉	扳手	对应刀片页
S045-SCLCR03-050	CC**0301**	5	4.5	-	42.4	2.5	M1.6*3.2	T6	P.60
S050-SCLCR03-060	CC**0301**	6	5	9	48.4	3	M1.6*3.2	T6	P.60
S060-SCLCR04-070	CC**0401**	7	6	10	54.4	3.5	M2*3.4	T6	P.60
S070-SCLCR04-080	CC**0401**	8	7	10.3	60.4	4	M2*3.4	T6	P.60
S080-SCLCR06-100	CC**0602**	10	8	13.3	69.5	5	M2.5*7	T8	P.60

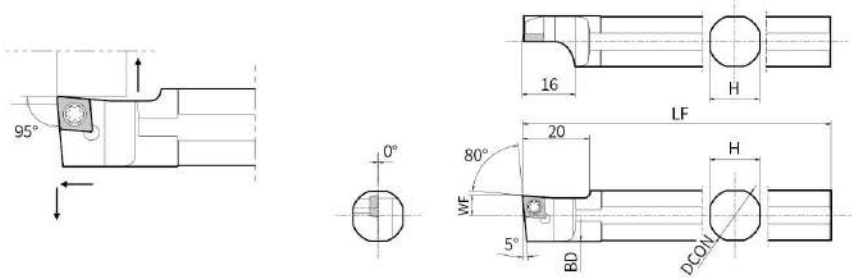
S-SWUB



本图为右手(R)
右手(R)刀杆适用左手(L)刀片
最大悬伸量 $L/D \approx 3$

▶ 刀杆尺寸 Shank size

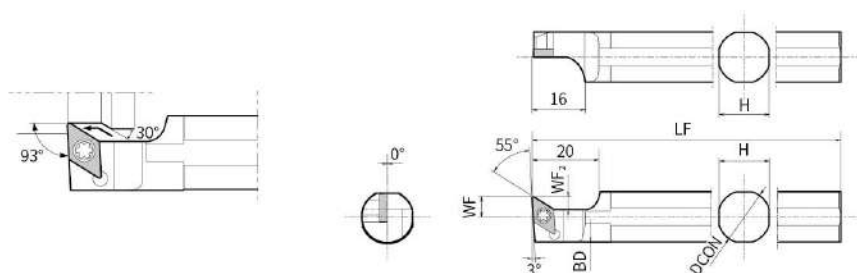
型号	刀片	DMIN	DCON	LH	LF	WF	螺钉	扳手	对应刀片页
S050-SWUBR06-060	WB**06**	6	5	9	48.4	3	M2*3.4	T6	-
S050-SWUBR06-060	WB**06**	7	6	10	54.4	3.5	M2*3.4	T6	-



本图为左手(L)
左手(L)刀杆适用右手(R)刀片

▶ 刀杆尺寸 Shank size

型号	刀片	DCON	H	BD	LF	WF	螺钉	扳手	对应刀片页
DS-SCLCR/L14F06	CC**0602**	14	13	13	80	6	M2.5*7	T8	P.60
DS-SCLCR/L15H06	CC**0602**	15.875	15	15	100	6	M2.5*7	T8	P.60
DS-SCLCR/L16F06	CC**0602**	16	15	15	80	6	M2.5*7	T8	P.60
DS-SCLCR/L19X06	CC**0602**	19.05	18	18	120	6	M2.5*7	T8	P.60
DS-SCLCR/L20X06	CC**0602**	20	19	19	120	6	M2.5*7	T8	P.60
DS-SCLCR/L22X06	CC**0602**	22	21	21	120	6	M2.5*7	T8	P.60
DS-SCLCR/L25M06	CC**0602**	25.4	24	24	150	6	M2.5*7	T8	P.60
DS-SCLCR/L14F09	CC**09T3**	14	13	13	80	10	M4*8	T15	P.60
DS-SCLCR/L15H09	CC**09T3**	15.875	15	15	100	10	M4*8	T15	P.60
DS-SCLCR/L16F09	CC**09T3**	16	15	15	80	10	M4*8	T15	P.60
DS-SCLCR/L19X09	CC**09T3**	19.05	18	18	120	10	M4*8	T15	P.60
DS-SCLCR/L20X09	CC**09T3**	20	19	19	120	10	M4*8	T15	P.60
DS-SCLCR/L22X09	CC**09T3**	22	21	21	120	10	M4*8	T15	P.60
DS-SCLCR/L25M09	CC**09T3**	25.4	24	24	150	10	M4*8	T15	P.60

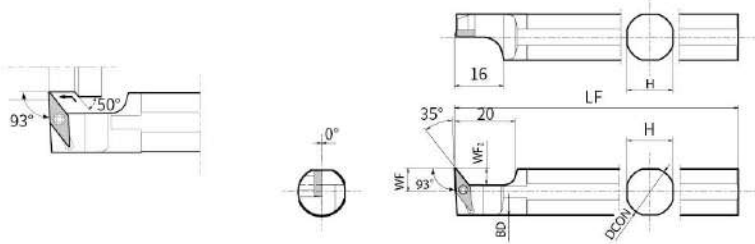


本图为左手(L)
左手(L)刀杆适用右手(R)刀片

▶ 刀杆尺寸 Shank size

型号	刀片	DCON	H	BD	LF	WF	螺钉	扳手	对应刀片页
DS-SDUCR/L14F07	DC**07T3**	14	13	13	80	6	M2.5*7	T8	P.63
DS-SDUCR/L15H07	DC**07T3**	15.875	15	15	100	6	M2.5*7	T8	P.63
DS-SDUCR/L16F07	DC**07T3**	16	15	15	80	6	M2.5*7	T8	P.63
DS-SDUCR/L19X07	DC**07T3**	19.05	18	18	120	6	M2.5*7	T8	P.63
DS-SDUCR/L20X07	DC**07T3**	20	19	19	120	6	M2.5*7	T8	P.63
DS-SDUCR/L22X07	DC**07T3**	22	21	21	120	6	M2.5*7	T8	P.63
DS-SDUCR/L25M07	DC**07T3**	25.4	24	24	150	6	M2.5*7	T8	P.63
DS-SDUCR/L14F11	DC**11T3**	14	13	13	80	10	M4*8	T15	P.63
DS-SDUCR/L15H11	DC**11T3**	15.875	15	15	100	10	M4*8	T15	P.63
DS-SDUCR/L16F11	DC**11T3**	16	15	15	80	10	M4*8	T15	P.63
DS-SDUCR/L19X11	DC**11T3**	19.05	18	18	120	10	M4*8	T15	P.63
DS-SDUCR/L20X11	DC**11T3**	20	19	19	120	10	M4*8	T15	P.63
DS-SDUCR/L22X11	DC**11T3**	22	21	21	120	10	M4*8	T15	P.63
DS-SDUCR/L25M11	DC**11T3**	25.4	24	24	150	10	M4*8	T15	P.63

DS-SVUBR/L

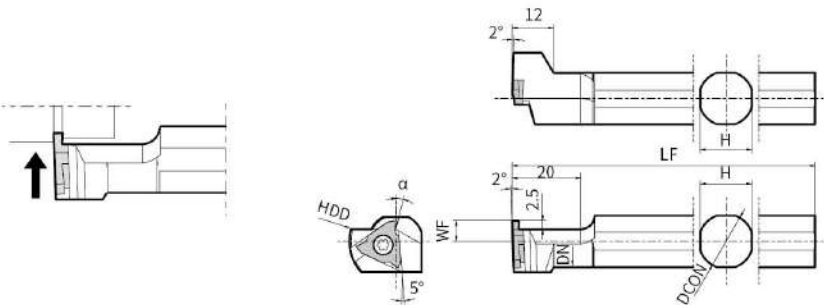


本图为左手(L)
左手(L)刀杆适用右手(R)刀片

▶ 刀杆尺寸 Shank size

型号	刀片	DCON	H	BD	LF	WF	螺钉	扳手	对应刀片页
DS-SVUBR/L14F11	VB**1103**	14	13	13	80	10	M2.5*7	T8	P.66
DS-SVUBR/L15H11	VB**1103**	15.875	15	15	100	10	M2.5*7	T8	P.66
DS-SVUBR/L16F11	VB**1103**	16	15	15	80	10	M2.5*7	T8	P.66
DS-SVUBR/L19X11	VB**1103**	19.05	18	18	120	10	M2.5*7	T8	P.66
DS-SVUBR/L20X11	VB**1103**	20	19	19	120	10	M2.5*7	T8	P.66
DS-SVUBR/L22X11	VB**1103**	22	21	21	120	10	M2.5*7	T8	P.66
DS-SVUBR/L25M11	VB**1103**	25.4	24	24	150	10	M2.5*7	T8	P.66

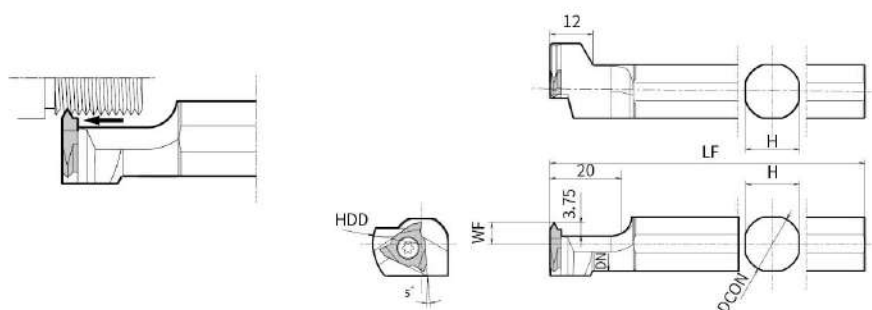
DS - 槽加工



本图为左手(L)
左手(L)刀杆适用右手(R)刀片

▶ 刀杆尺寸 Shank size

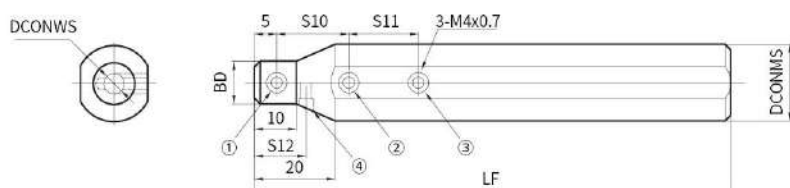
型号	刀片	DCON	H	DN	LF	WF	螺钉	扳手	对应刀片页
DS-KTGFR/L16-D14	TGF32***	14	13	13	100	6	M4*8	T15	P.81
DS-KTGFR/L16-D15	TGF32***	15.875	15	14.6	85	6	M4*8	T15	P.81
DS-KTGFR/L16-D16	TGF32***	16	15	14.6	85	6	M4*8	T15	P.81
DS-KTGFR/L16-D19	TGF32***	19.05	17	17.6	90	6	M4*8	T15	P.81
DS-KTGFR/L16-D20	TGF32***	20	18	18.6	90	6	M4*8	T15	P.81
DS-KTGFR/L16-D22	TGF32***	22	18	21	120	10	M4*8	T15	P.81
DS-KTGFR/L16-D25	TGF32***	25.4	23	23.6	120	10	M4*8	T15	P.81



可加工至螺纹根部
本图为左手 L, 左手 (L) 刀杆适用右手 (R) 刀片

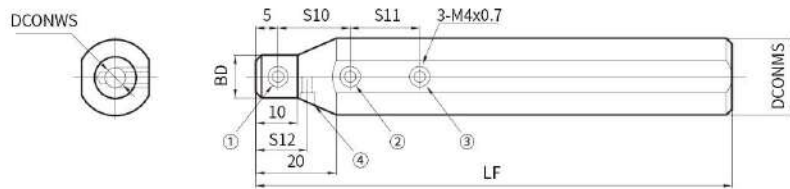
▶ 刀杆尺寸 Shank size

型号	刀片	DCON	H	DN	LF	WF	螺钉	扳手	对应刀片页
DS-KTTL16-D14	TTX32R***	14	13	13	100	6	M4*8	T15	-
DS-KTTL16-D15	TTX32R***	15.875	15	14.6	85	6	M4*8	T15	-
DS-KTTL16-D16	TTX32R***	16	15	14.6	85	6	M4*8	T15	-
DS-KTTL16-D19	TTX32R***	19.05	17	17.6	90	6	M4*8	T15	-
DS-KTTL16-D20	TTX32R***	20	18	18.6	90	6	M4*8	T15	-
DS-KTTL16-D22	TTX32R***	22	18	21	120	10	M4*8	T15	-
DS-KTTL16-D25.4	TTX32R***	25.4	23	23.6	120	10	M4*8	T15	-



▶ 刀杆尺寸 Shank size

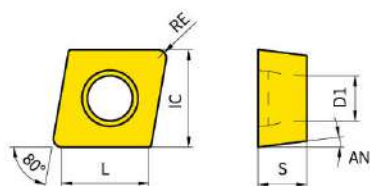
型号	DCOM(mm)	夹持直径	BD	LF	S10	S11	S12	夹紧螺钉	扳手 (内六角 mm)	锁紧扭矩 (N.m)
RBH15820	15.875	2	15	100	15	-	-	M4*0.7	2	2.0
RBH15830	15.875	3	15	100	15	10	-	M4*0.7	2	2.0
RBH15840	15.875	4	15	100	15	15	-	M4*0.7	2	2.0
RBH15850	15.875	5	15	100	15	15	-	M4*0.7	2	2.0
RBH15860	15.875	6	15	100	15	15	-	M4*0.7	2	2.0
RBH15870	15.875	7	15	100	20	20	-	M4*0.7	2	2.0
RBH15880	15.875	8	15	100	20	20	-	M4*0.7	2	2.0
RBH1620N	16	2	15	100	15	-	-	M4*0.7	2	2.0
RBH1630N	16	3	15	100	15	10	-	M4*0.7	2	2.0
RBH1640N	16	4	15	100	15	15	-	M4*0.7	2	2.0
RBH1650N	16	5	15	100	15	15	-	M4*0.7	2	2.0
RBH1660N	16	6	15	100	15	15	-	M4*0.7	2	2.0
RBH1670N	16	7	15	100	20	20	-	M4*0.7	2	2.0
RBH1680N	16	8	15	100	20	20	-	M4*0.7	2	2.0
RBH19020N	19.05	2	18	125	15	-	-	M4*0.7	2	2.0
RBH19030N	19.05	3	18	125	15	10	-	M4*0.7	2	2.0
RBH19040N	19.05	4	18	125	15	15	-	M4*0.7	2	2.0
RBH19050N	19.05	5	18	125	15	15	-	M4*0.7	2	2.0
RBH19060N	19.05	6	18	125	15	15	-	M4*0.7	2	2.0
RBH19070N	19.05	7	18	125	20	20	-	M4*0.7	2	2.0
RBH19080N	19.05	8	18	125	20	20	-	M4*0.7	2	2.0
RBH2020N	20	2	11	125	10	-	-	M4*0.7	2	2.0
RBH2030N	20	3	12	125	10	10	-	M4*0.7	2	2.0
RBH2040N	20	4	13	125	15	15	-	M4*0.7	2	2.0
RBH2050N	20	5	14	125	15	15	-	M4*0.7	2	2.0
RBH2060N	20	6	15	125	15	15	-	M4*0.7	2	2.0
RBH2070N	20	7	16	125	20	20	-	M4*0.7	2	2.0
RBH2080N	20	8	17	125	20	20	-	M4*0.7	2	2.0
RBH2220N	22	2	11	125	10	-	10	M4*0.7	2	2.0
RBH2230N	22	3	12	125	10	10	10	M4*0.7	2	2.0
RBH2240N	22	4	13	125	15	15	12.5	M4*0.7	2	2.0
RBH2250N	22	5	14	125	15	15	12.5	M4*0.7	2	2.0



型号	DCOM(mm)	夹持直径	BD	LF	S10	S11	S12	夹紧螺钉	扳手 (内六角 mm)	锁紧扭矩 (N.m)
RBH2260N	22	6	15	125	15	15	15	M4*0.7	2	2.0
RBH2270N	22	7	16	125	20	20	15	M4*0.7	2	2.0
RBH2280N	22	8	17	125	20	20	15	M4*0.7	2	2.0
RBH2520N	25	2	11	150	10	-	-	M4*0.7	2	2.0
RBH2530N	25	3	12	150	10	10	-	M4*0.7	2	2.0
RBH2540N	25	4	13	150	15	15	-	M4*0.7	2	2.0
RBH2550N	25	5	14	150	15	15	-	M4*0.7	2	2.0
RBH2560N	25	6	15	150	15	15	-	M4*0.7	2	2.0
RBH2570N	25	7	16	150	20	20	-	M4*0.7	2	2.0
RBH2580N	25	8	17	150	20	20	-	M4*0.7	2	2.0
RBH25420N	25.4	2	11	150	10	-	-	M4*0.7	2	2.0
RBH25430N	25.4	3	12	150	10	10	-	M4*0.7	2	2.0
RBH25440N	25.4	4	13	150	15	15	-	M4*0.7	2	2.0
RBH25450N	25.4	5	14	150	15	15	-	M4*0.7	2	2.0
RBH25460N	25.4	6	15	150	15	15	-	M4*0.7	2	2.0
RBH25470N	25.4	7	16	150	20	20	-	M4*0.7	2	2.0
RBH25480N	25.4	8	17	150	20	20	-	M4*0.7	2	2.0

正型刀片 CC 系列

CCGT (80° Positive)

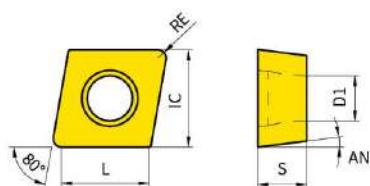


Series	L	IC	S
CC**0301	3	3.5	1.4
CC**0401	4	4.3	1.8
CC**0602	6.45	6.35	2.38
CC**09T3	9.67	9.525	3.97

CCGT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-S	CCGT030101ML-S	0.1	0.01-0.15	0.1-1			●	
	CCGT030102ML-S	0.2	0.01-0.15	0.1-1			●	
	CCGT040101ML-S	0.1	0.01-0.15	0.1-1			●	
	CCGT040102ML-S	0.2	0.01-0.15	0.1-1			●	
-S	CCGT0602005ML-S	0.05	0.01-0.15	0.1-1			●	
	CCGT060201ML-S	0.1	0.01-0.15	0.1-1			●	
	CCGT060202ML-S	0.2	0.01-0.15	0.1-1			●	
	CCGT060204ML-S	0.4	0.01-0.15	0.4-1			●	
	CCGT09T3005ML-S	0.05	0.02-0.2	0.1-1			●	
	CCGT09T301ML-S	0.1	0.01-0.15	0.1-1			●	
	CCGT09T302ML-S	0.2	0.01-0.15	0.1-1			●	
	CCGT09T304ML-S	0.4	0.01-0.15	0.4-1			●	
-U	CCGT0602005MFL-U	0.05	0.01-0.15	0.1-1.5			●	
	CCGT060201MFL-U	0.1	0.02-0.18	0.1-1.5			●	
	CCGT060202MFL-U	0.2	0.02-0.18	0.2-1.5			●	
	CCGT060204MFL-U	0.4	0.02-0.18	0.2-1.5			●	
	CCGT09T3005MFL-U	0.05	0.02-0.2	0.1-1.5			●	
	CCGT09T301MFL-U	0.1	0.02-0.2	0.1-1.5			●	
	CCGT09T302MFL-U	0.2	0.02-0.2	0.2-1.5			●	
	CCGT09T304MFL-U	0.4	0.02-0.2	0.1-1.5			●	

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



Series	L	IC	S
CC**0301	3	3.5	1.4
CC**0401	4	4.3	1.8
CC**0602	6.45	6.35	2.38
CC**09T3	9.67	9.525	3.97

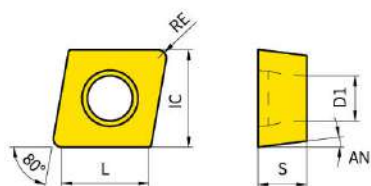
CCGT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APP30D	APU30D	APM30D	
	CCGT030101MR-S	0.1	0.01-0.15	0.1-1			●	
	CCGT030102MR-S	0.2	0.01-0.15	0.1-1			●	
	CCGT040101MR-S	0.1	0.01-0.15	0.1-1			●	
	CCGT040102MR-S	0.2	0.01-0.15	0.1-1			●	
	CCGT0602005MR-S	0.05	0.01-0.15	0.1-1			●	
	CCGT060201MR-S	0.1	0.01-0.15	0.1-1			●	
	CCGT060202MR-S	0.2	0.01-0.15	0.1-1			●	
	CCGT060204MR-S	0.4	0.01-0.15	0.4-1			●	
	CCGT09T3005MR-S	0.05	0.02-0.2	0.1-1			●	
	CCGT09T301MR-S	0.1	0.01-0.15	0.1-1			●	
	CCGT09T302MR-S	0.2	0.01-0.15	0.1-1			●	
	CCGT09T304MR-S	0.4	0.01-0.15	0.4-1			●	
	CCGT0602005MFR-U	0.05	0.01-0.15	0.1-1.5			●	
	CCGT060201MFR-U	0.1	0.02-0.18	0.1-1.5			●	
	CCGT060202MFR-U	0.2	0.02-0.18	0.2-1.5			●	
	CCGT060204MFR-U	0.4	0.02-0.18	0.2-1.5			●	
	CCGT09T3005MFR-U	0.05	0.02-0.2	0.1-1.5			●	
	CCGT09T301MFR-U	0.1	0.02-0.2	0.1-1.5			●	
	CCGT09T302MFR-U	0.2	0.02-0.2	0.2-1.5			●	
	CCGT09T304MFR-U	0.4	0.02-0.2	0.1-1.5			●	

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
M		1200-1400	355-415	75	100	75	100	75	100
	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

正型刀片 CC 系列

CCGT (80° Positive)

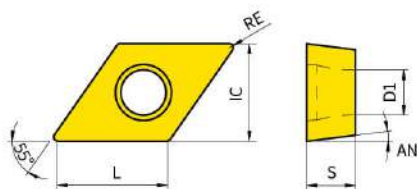


Series	L	IC	S
CC**0301	3	3.5	1.4
CC**0401	4	4.3	1.8
CC**0602	6.45	6.35	2.38
CC**09T3	9.67	9.525	3.97

CCGT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-UCL	CCGT09T3005M-UCL	0.05	0.02-0.2	0.1-1.5			●	
	CCGT09T301M-UCL	0.1	0.02-0.2	0.1-1.5			●	
	CCGT09T302M-UCL	0.2	0.02-0.2	0.2-1.5			●	
	CCGT09T304M-UCL	0.4	0.02-0.2	0.4-1.5			●	
	CCGT09T304M-UCL	0.4	0.02-0.2	0.4-1.5			●	
-UYL	CCGT09T3005M-UYL	0.05	0.02-0.2	0.1-1.5			●	
	CCGT09T301M-UYL	0.1	0.02-0.2	0.1-1.5			●	
	CCGT09T302M-UYL	0.2	0.02-0.2	0.2-1.5			●	
	CCGT09T304M-UYL	0.4	0.02-0.2	0.4-1.5			●	

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



Series	L	IC	S
DC**0702	7.75	6.35	2.38
DC**11T3	11.63	9.525	3.97

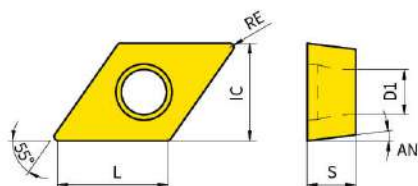
DCGT/DCET	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-J	DCET0702005MFL-J	0.05	0.01-0.15	0.1-2.5			●	
	DCET070201MFL-J	0.1	0.01-0.15	0.1-2.5			●	
	DCET070202MFL-J	0.2	0.01-0.15	0.2-2.5			●	
	DCET070204MFL-J	0.4	0.01-0.15	0.4-2.5			●	
	DCGT11T301MFL-J	0.1	0.01-0.15	0.1-3			●	
	DCGT11T302MFL-J	0.2	0.01-0.15	0.2-3			●	
-U	DCGT11T304MFL-J	0.4	0.01-0.15	0.4-3			●	
	DCGT070201MFL-U	0.1	0.01-0.15	0.1-1.5			●	
	DCGT070202MFL-U	0.2	0.01-0.15	0.2-1.5			●	
	DCGT070204MFL-U	0.4	0.01-0.15	0.4-1.5			●	
	DCGT11T3005MFL-U	0.05	0.01-0.15	0.1-1.5			●	
	DCGT11T301MFL-U	0.1	0.01-0.15	0.1-1.5			●	
-S	DCGT11T302MFL-U	0.2	0.01-0.15	0.2-1.5			●	
	DCGT11T304MFL-U	0.4	0.01-0.15	0.4-1.5			●	
	DCGT0702005ML-S	0.05	0.01-0.15	0.1-1			●	
	DCGT070201ML-S	0.1	0.01-0.15	0.1-1			●	
	DCGT070202ML-S	0.2	0.01-0.15	0.1-1			●	
	DCGT070204ML-S	0.4	0.01-0.15	0.4-1			●	

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

正型刀片 DC 系列

DCGT/DCET (55° Positive)

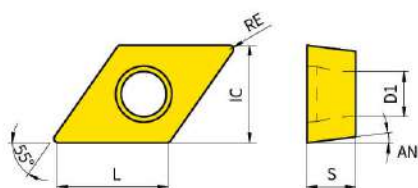


Series	L	IC	S
DC**0702	7.75	6.35	2.38
DC**11T3	11.63	9.525	3.97

DCGT/DCET	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-J	DCET0702005MFR-J	0.05	0.01-0.15	0.1-2.5			●	
	DCET070201MFR-J	0.1	0.01-0.15	0.1-2.5			●	
	DCET070202MFR-J	0.2	0.01-0.15	0.2-2.5			●	
	DCET070204MFR-J	0.4	0.01-0.15	0.4-2.5			●	
	DCGT11T301MFR-J	0.1	0.01-0.15	0.1-3			●	
	DCGT11T302MFR-J	0.2	0.01-0.15	0.2-3			●	
	DCGT11T304MFR-J	0.4	0.01-0.15	0.4-3			●	
-U	DCGT070201MFR-U	0.1	0.01-0.15	0.1-1.5			●	
	DCGT070202MFR-U	0.2	0.01-0.15	0.2-1.5			●	
	DCGT070204MFR-U	0.4	0.01-0.15	0.4-1.5			●	
	DCGT11T3005MFR-U	0.05	0.01-0.15	0.1-1.5			●	
	DCGT11T301MFR-U	0.1	0.01-0.15	0.1-1.5			●	
	DCGT11T302MFR-U	0.2	0.01-0.15	0.2-1.5			●	
	DCGT11T304MFR-U	0.4	0.01-0.15	0.4-1.5			●	
-S	DCGT0702005MR-S	0.05	0.01-0.15	0.1-1			●	
	DCGT070201MR-S	0.1	0.01-0.15	0.1-1			●	
	DCGT070202MR-S	0.2	0.01-0.15	0.1-1			●	
	DCGT070204MR-S	0.4	0.01-0.15	0.4-1			●	

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



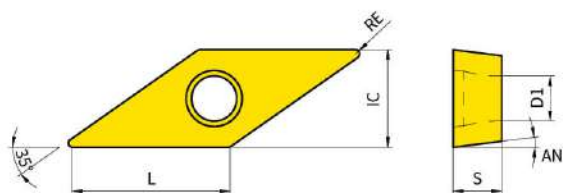
Series	L	IC	S
DC**0702	7.75	6.35	2.38
DC**11T3	11.63	9.525	3.97

DCGT/DCET	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-S	DCGT11T3005ML-S	0.05	0.01-0.15	0.1-1			●	
	DCGT11T301ML-S	0.1	0.01-0.15	0.1-1			●	
	DCGT11T302ML-S	0.2	0.01-0.15	0.1-1			●	
	DCGT11T304ML-S	0.4	0.01-0.15	0.4-1			●	
-S	DCGT11T3005MR-S	0.05	0.01-0.15	0.1-1			●	
	DCGT11T301MR-S	0.1	0.01-0.15	0.1-1			●	
	DCGT11T302MR-S	0.2	0.01-0.15	0.1-1			●	
	DCGT11T304MR-S	0.4	0.01-0.15	0.4-1			●	
-UCL	DCGT070201M-UCL	0.1	0.01-0.15	0.1-1.5			●	
	DCGT070202M-UCL	0.2	0.01-0.15	0.2-1.5			●	
	DCGT070204M-UCL	0.4	0.01-0.15	0.4-1.5			●	
	DCGT11T3005M-UCL	0.05	0.01-0.15	0.01-1.5			●	
	DCGT11T301M-UCL	0.1	0.01-0.15	0.1-1.5			●	
	DCGT11T302M-UCL	0.2	0.01-0.15	0.2-1.5			●	
	DCGT11T304M-UCL	0.4	0.01-0.15	0.4-1.5			●	
-UYL	DCGT070201M-UYL	0.1	0.01-0.15	0.1-1.5			●	
	DCGT070202M-UYL	0.2	0.01-0.15	0.2-1.5			●	
	DCGT11T3005M-UYL	0.05	0.01-0.15	0.01-1.5			●	
	DCGT11T301M-UYL	0.1	0.01-0.15	0.1-1.5			●	
	DCGT11T302M-UYL	0.2	0.01-0.15	0.2-1.5			●	
	DCGT11T304M-UYL	0.4	0.01-0.15	0.4-1.5			●	

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
		778	230	100	160	100	160	100	160
	双相不锈钢	1013	300	80	150	80	150	80	150
	沉淀硬化不锈钢	1200-1400	355-415	75	100	75	100	75	100
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

正型刀片 VB 系列

VBGT (35° Positive)

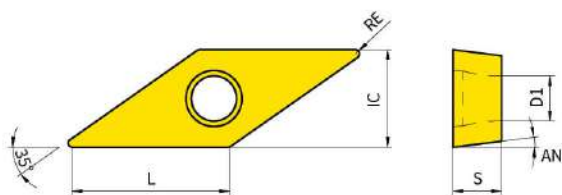


Series	L	IC	S
VB**1103	11.1	6.35	3.18
VB**1604	16.6	9.525	4.76

VBGT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-UCL	VBGT110301M-UCL	0.1	0.05-0.3	0.1-1.5			●	
	VBGT110302M-UCL	0.2	0.05-0.3	0.2-1.5			●	
-UYL	VBGT110301M-UYL	0.1	0.05-0.2	0.1-1.5			●	
	VBGT110302M-UYL	0.2	0.05-0.2	0.2-1.5			●	
	VBGT110304M-UYL	0.4	0.05-0.2	0.4-1.5			●	
-S	VBGT1103005ML-S	0.05	0.05-0.15	0.1-1			●	
	VBGT110301ML-S	0.1	0.01-0.15	0.1-1			●	
	VBGT110302ML-S	0.2	0.01-0.15	0.1-1			●	
	VBGT110304ML-S	0.4	0.01-0.15	0.4-1			●	
-Y	VBGT1103005ML-Y	0.05	0.01-0.15	0.1-3			●	
	VBGT110301ML-Y	0.1	0.01-0.15	0.1-3			●	
	VBGT110302ML-Y	0.2	0.01-0.15	0.2-3			●	
	VBGT110304ML-Y	0.4	0.01-0.15	0.4-3			●	
	VBGT160401ML-Y	0.1	0.01-0.2	0.1-3			●	
	VBGT160402ML-Y	0.2	0.01-0.2	0.2-3			●	
	VBGT160404ML-Y	0.4	0.01-0.2	0.4-4			●	
	VBGT160408ML-Y	0.8	0.01-0.2	0.8-4			●	

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



Series	L	IC	S
VB**1103	11.1	6.35	3.18
VB**1604	16.6	9.525	4.76

VBGT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-S	VBGT1103005MR-S	0.05	0.05-0.15	0.1-1			●	
	VBGT110301MR-S	0.1	0.01-0.15	0.1-1			●	
	VBGT110302MR-S	0.2	0.01-0.15	0.1-1			●	
	VBGT110304MR-S	0.4	0.01-0.15	0.4-1			●	
-Y	VBGT1103005MR-Y	0.05	0.01-0.15	0.1-3			●	
	VBGT110301MR-Y	0.1	0.01-0.15	0.1-3			●	
	VBGT110302MR-Y	0.2	0.01-0.15	0.2-3			●	
	VBGT110304MR-Y	0.4	0.01-0.15	0.4-3			●	
	VBGT160401MR-Y	0.1	0.01-0.2	0.1-3			●	
	VBGT160402MR-Y	0.2	0.01-0.2	0.2-3			●	
	VBGT160404MR-Y	0.4	0.01-0.2	0.4-4			●	
	VBGT160408MR-Y	0.8	0.01-0.2	0.8-4			●	

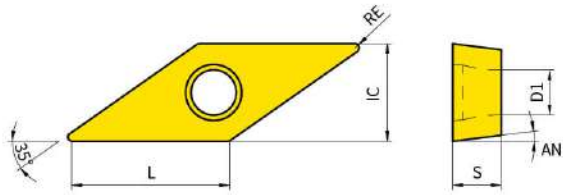
● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
		778	230	100	160	100	160	100	160
	双相不锈钢	1013	300	80	150	80	150	80	150
	沉淀硬化不锈钢	1200-1400	355-415	75	100	75	100	75	100
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

正型刀片 VC 系列

VC/GT/VCET (35° Positive)

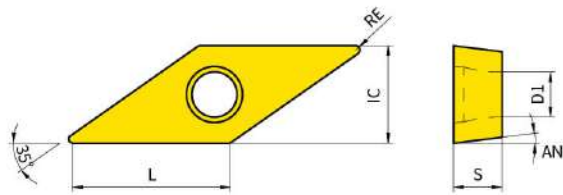
Series	L	IC	S
VC**1103	11.1	6.35	3.18



VC/GT/VCET	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-UCL	VC/GT110301M-UCL	0.1	0.01-0.15	0.1-1.5			●	
	VC/GT110302M-UCL	0.2	0.01-0.15	0.2-1.5			●	
-UYL	VC/GT110301M-UYL	0.1	0.01-0.15	0.1-1.5			●	
	VC/GT110302M-UYL	0.2	0.01-0.15	0.2-1.5			●	
	VC/GT110304M-UYL	0.4	0.01-0.15	0.4-1.5			●	
-Y	VCET1103005ML-Y	0.05	0.01-0.15	0.1-3			●	
	VCET110301ML-Y	0.1	0.01-0.15	0.1-3			●	
	VCET110302ML-Y	0.2	0.01-0.15	0.2-3			●	
	VCET110304ML-Y	0.4	0.01-0.15	0.4-3			●	
-S	VCET1103005ML-S	0.05	0.01-0.15	0.1-1			●	
	VCET110301ML-S	0.1	0.01-0.15	0.1-1			●	
	VCET110302ML-S	0.2	0.01-0.15	0.1-1			●	
	VCET110304ML-S	0.4	0.01-0.15	0.4-1			●	

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
		高合金钢	950-1200	280-355	80	125	80	125	80
	1200-1400		355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

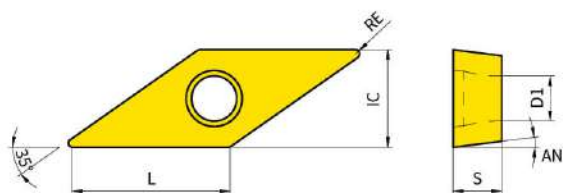


Series	L	IC	S
VC**1103	11.1	6.35	3.18

VCGT/VCET	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-Y	VCET1103005MR-Y	0.05	0.01-0.15	0.1-3			●	
	VCET110301MR-Y	0.1	0.01-0.15	0.1-3			●	
	VCET110302MR-Y	0.2	0.01-0.15	0.2-3			●	
	VCET110304MR-Y	0.4	0.01-0.15	0.4-3			●	
-S	VCET1103005MR-S	0.05	0.01-0.15	0.1-1			●	
	VCET110301MR-S	0.1	0.01-0.15	0.1-1			●	
	VCET110302MR-S	0.2	0.01-0.15	0.1-1			●	
	VCET110304MR-S	0.4	0.01-0.15	0.4-1			●	

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
M	奥氏体不锈钢	1200-1400	355-415	75	100	75	100	75	100
		675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



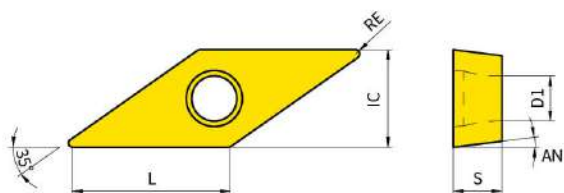
Series	L	IC	S
VP**1103	11.1	6.35	3.18

VPET	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-S	VPET1103005ML-S	0.05	0.01-0.15	0.1-1			●	
	VPET110301ML-S	0.1	0.01-0.15	0.1-1			●	
	VPET110302ML-S	0.2	0.01-0.15	0.1-1			●	
	VPET110304ML-S	0.4	0.01-0.15	0.4-1			●	
-J	VPET1103005MFL-J	0.05	0.01-0.15	0.1-3			●	
	VPET110301MFL-J	0.1	0.01-0.15	0.1-3			●	
	VPET110302MFL-J	0.2	0.01-0.15	0.2-3			●	
	VPET110304MFL-J	0.4	0.01-0.15	0.4-3			●	
-U	VPET1103005MFL-U	0.05	0.01-0.15	0.1-1.5			●	
	VPET110301MFL-U	0.1	0.01-0.15	0.1-1.5			●	
	VPET110302MFL-U	0.2	0.01-0.15	0.2-1.5			●	
	VPET110304MFL-U	0.4	0.01-0.15	0.4-1.5			●	

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
1200-1400		355-415	75	100	75	100	75	100	
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

Series	L	IC	S
VP**1103	11.1	6.35	3.18



VPET	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-S	VPET1103005MR-S	0.05	0.01-0.15	0.1-1			●	
	VPET110301MR-S	0.1	0.01-0.15	0.1-1			●	
	VPET110302MR-S	0.2	0.01-0.15	0.1-1			●	
	VPET110304MR-S	0.4	0.01-0.15	0.4-1			●	
-J	VPET1103005MFR-J	0.05	0.01-0.15	0.1-3			●	
	VPET110301MFR-J	0.1	0.01-0.15	0.1-3			●	
	VPET110302MFR-J	0.2	0.01-0.15	0.2-3			●	
	VPET110304MFR-J	0.4	0.01-0.15	0.4-3			●	
-U	VPET1103005MFR-U	0.05	0.01-0.15	0.1-1.5			●	
	VPET110301MFR-U	0.1	0.01-0.15	0.1-1.5			●	
	VPET110302MFR-U	0.2	0.01-0.15	0.2-1.5			●	
	VPET110304MFR-U	0.4	0.01-0.15	0.4-1.5			●	

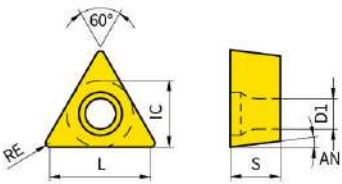
● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
		1260	370	40	80	40	80	40	80
N	钛合金	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

A
B
C
D
E
F
G
H

正型刀片 TB/TC 系列

TBET/TCGT/(60° Positive)

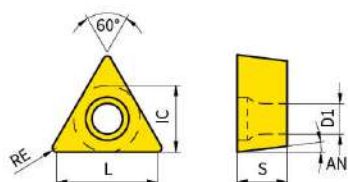


Series	L	IC	S
TB**0601	6	3.97	1.59
TC**1102	11.0	6.35	2.38

					P		M	
TBET/TCGT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	APU20D	APU30D	APM30D	
-S	 TBET0601005ML-S	0.05	0.01-0.15	0.1-1			●	
	TBET060101ML-S	0.1	0.01-0.15	0.1-1			●	
	TBET060102ML-S	0.2	0.01-0.15	0.1-1			●	
	TBET060104ML-S	0.4	0.01-0.15	0.4-1			●	
-S	 TCGT1102005ML-S	0.05	0.01-0.15	0.1-1			●	
	TCGT110201ML-S	0.1	0.01-0.15	0.1-1			●	
	TCGT110202ML-S	0.2	0.01-0.15	0.1-1			●	
	TCGT110204ML-S	0.4	0.01-0.15	0.4-1			●	

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢，碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
		950-1200	280-355	80	125	80	125	80	125
M	高合金钢	1200-1400	355-415	75	100	75	100	75	100
		奥氏体不锈钢	675	200	120	240	120	200	120
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金，镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



Series	L	IC	S
TB**0601	6	3.97	1.59
TC**1102	11.0	6.35	2.38

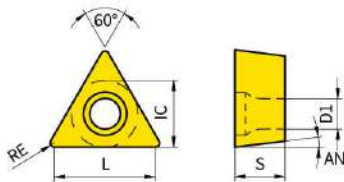
TBET/TCGT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-S	TBET0601005MR-S	0.05	0.01-0.15	0.1-1			●	
	TBET060101MR-S	0.1	0.01-0.15	0.1-1			●	
	TBET060102MR-S	0.2	0.01-0.15	0.1-1			●	
	TBET060104MR-S	0.4	0.01-0.15	0.4-1			●	
-S	TCGT1102005MR-S	0.05	0.01-0.15	0.1-1			●	
	TCGT110201MR-S	0.1	0.01-0.15	0.1-1			●	
	TCGT110202MR-S	0.2	0.01-0.15	0.1-1			●	
	TCGT110204MR-S	0.4	0.01-0.15	0.4-1			●	

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
M	奥氏体不锈钢	1200-1400	355-415	75	100	75	100	75	100
		675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

正型刀片 TP 系列

TPGH (60° Positive)

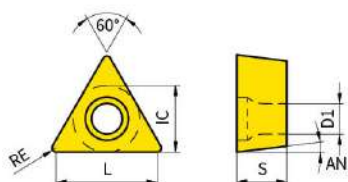


Series	L	IC	S
TP**0601	6	3.97	1.59
TP**0802	8	4.76	2.38
TP**0902	9	5.56	2.38
TP**1102	11	6.35	2.38
TP**1604	16	9.525	4.76

TPGH	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-S	TPGH0601005ML-S	0.05	0.01-0.15	0.1-1			●	
	TPGH060101ML-S	0.1	0.01-0.15	0.1-1			●	
	TPGH060102ML-S	0.2	0.01-0.15	0.1-1			●	
	TPGH060104ML-S	0.4	0.01-0.15	0.1-1			●	
-S	TPGH0902005ML-S	0.05	0.01-0.15	0.1-1			●	
	TPGH090201ML-S	0.1	0.01-0.15	0.1-1			●	
	TPGH090202ML-S	0.2	0.01-0.15	0.1-1			●	
	TPGH090204ML-S	0.4	0.01-0.15	0.4-1			●	
-S	TPGH1102005ML-S	0.05	0.01-0.15	0.1-1			●	
	TPGH110201ML-S	0.1	0.01-0.15	0.1-1			●	
	TPGH110202ML-S	0.2	0.01-0.15	0.1-1			●	
	TPGH110204ML-S	0.4	0.01-0.15	0.4-1			●	
-S	TPGT160401ML-S	0.1	0.01-0.15	0.1-1			●	
	TPGT160402ML-S	0.2	0.01-0.15	0.1-1			●	
	TPGT160404ML-S	0.4	0.01-0.15	0.4-1			●	
	TPGT160408ML-S	0.8	0.01-0.15	0.8-1			●	

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
		高合金钢	950-1200	280-355	80	125	80	125	80
	1200-1400		355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



Series	L	IC	S
TP**0601	6	3.97	1.59
TP**0802	8	4.76	2.38
TP**0902	9	5.56	2.38
TP**1102	11	6.35	2.38
TP**1604	16	9.525	4.76

TPGH	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-S	TPGH0601005MR-S	0.05	0.01-0.15	0.1-1			●	
	TPGH060101MR-S	0.1	0.01-0.15	0.1-1			●	
	TPGH060102MR-S	0.2	0.01-0.15	0.1-1			●	
	TPGH060104MR-S	0.4	0.01-0.15	0.1-1			●	
-S	TPGH0902005MR-S	0.05	0.01-0.15	0.1-1			●	
	TPGH090201MR-S	0.1	0.01-0.15	0.1-1			●	
	TPGH090202MR-S	0.2	0.01-0.15	0.1-1			●	
	TPGH090204MR-S	0.4	0.01-0.15	0.4-1			●	
-S	TPGH1102005MR-S	0.05	0.01-0.15	0.1-1			●	
	TPGH110201MR-S	0.1	0.01-0.15	0.1-1			●	
	TPGH110202MR-S	0.2	0.01-0.15	0.1-1			●	
	TPGH110204MR-S	0.4	0.01-0.15	0.4-1			●	
-S	TPGT160401MR-S	0.1	0.01-0.15	0.1-1			●	
	TPGT160402MR-S	0.2	0.01-0.15	0.1-1			●	
	TPGT160404MR-S	0.4	0.01-0.15	0.4-1			●	
	TPGT160408MR-S	0.8	0.01-0.15	0.8-1			●	

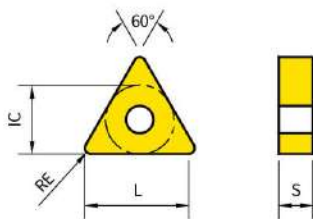
● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
M		1200-1400	355-415	75	100	75	100	75	100
	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

负型刀片 TN 系列

TNGG(60° Negative)

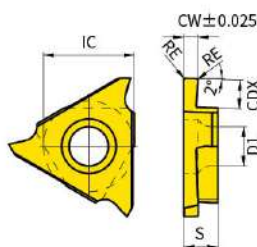
Series	L	IC	S
TN**1604	16.5	9.525	4.76



TNGG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P		M	
					APU20D	APU30D	APM30D	
-AUL	TNGG160401MFN-AUL	0.1	0.05-0.2	0.1-3			●	
	TNGG160402MFN-AUL	0.2	0.05-0.2	0.2-3			●	
-S	TNGG160401L-S	0.1	0.05-0.2	0.1-1			●	
	TNGG160402L-S	0.2	0.05-0.2	0.1-1			●	
	TNGG160404L-S	0.4	0.05-0.2	0.4-1			●	
	TNGG160408L-S	0.8	0.05-0.2	0.8-1			●	
-S	TNGG160401R-S	0.1	0.05-0.2	0.1-1			●	
	TNGG160402R-S	0.2	0.05-0.2	0.1-1			●	
	TNGG160404R-S	0.4	0.05-0.2	0.4-1			●	
	TNGG160408R-S	0.8	0.05-0.2	0.8-1			●	

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢，碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金，镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



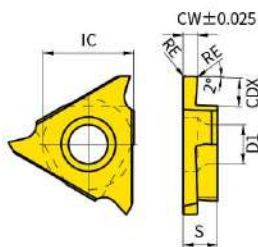
Series	IC	S	D
GBA43	12.7	4.76	5.5

GBA	型号 Type	CW (mm)	RE (mm)	CDX (mm)	IC (mm)	S (mm)	D (mm)	P		M	
								APU20D	APU30D	APM30D	
	GBA43L075-020	0.75	0.2	2	12.7	4.76	5.5		☉		
	GBA43L100-020	1	0.2	2	12.7	4.76	5.5		☉		
	GBA43L120-020	1.2	0.2	2	12.7	4.76	5.5		☉		
	GBA43L125-020	1.25	0.2	2	12.7	4.76	5.5		☉		
	GBA43L130-020	1.3	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L140-020	1.4	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L145-020	1.45	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L150-020	1.5	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L160-020	1.6	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43R/L170-020	1.7	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L175-020	1.75	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L180-020	1.8	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L185-020	1.85	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L195-020	1.95	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L200-020	2	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L210-020	2.1	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L220-020	2.2	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L225-020	2.25	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L230-020	2.3	0.2	3.5	12.7	4.76	5.5		☉		
	GBA43L240-020	2.4	0.2	3.5	12.7	4.76	5.5		☉		

● 常备库存 ☉ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
		1260	370	40	80	40	80	40	80
N	钛合金	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

GBA 槽刀片

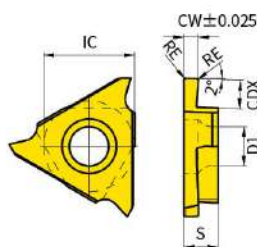


Series	IC	S	D
GBA43	12.7	4.76	5.5

GBA	型号 Type	CW (mm)	RE (mm)	CDX (mm)	IC (mm)	S (mm)	D (mm)	P		M	
								APU20D	APU30D	APM30D	
	GBA43R075-020	0.75	0.2	2	12.7	4.76	5.5		●		
	GBA43R100-020	1	0.2	2	12.7	4.76	5.5		●		
	GBA43R120-020	1.2	0.2	2	12.7	4.76	5.5		●		
	GBA43R125-020	1.25	0.2	2	12.7	4.76	5.5		●		
	GBA43R130-020	1.3	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R140-020	1.4	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R145-020	1.45	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R150-020	1.5	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R160-020	1.6	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R170-020	1.7	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R175-020	1.75	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R180-020	1.8	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R185-020	1.85	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R195-020	1.95	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R200-020	2	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R210-020	2.1	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R220-020	2.2	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R225-020	2.25	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R230-020	2.3	0.2	3.5	12.7	4.76	5.5		●		
	GBA43R240-020	2.4	0.2	3.5	12.7	4.76	5.5		●		

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
		950-1200	280-355	80	125	80	125	80	125
	高合金钢	1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



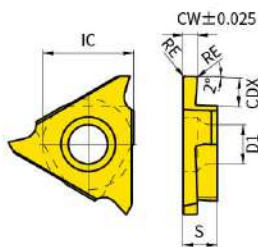
Series	IC	S	D
GBA43	12.7	4.76	5.5

GBA	型号 Type	CW (mm)	RE (mm)	CDX (mm)	IC (mm)	S (mm)	D (mm)	P		M	
								APU20D	APU30D	APM30D	
	GBA43L250-030	2.5	0.3	5	12.7	4.76	5.5		◎		
	GBA43L265-030	2.65	0.3	5	12.7	4.76	5.5		◎		
	GBA43L270-030	2.7	0.3	5	12.7	4.76	5.5		◎		
	GBA43L280-030	2.8	0.3	5	12.7	4.76	5.5		◎		
	GBA43L300-030	3	0.3	5	12.7	4.76	5.5		◎		
	GBA43L320-030	3.2	0.3	5	12.7	4.76	5.5		◎		
	GBA43L325-030	3.25	0.3	5	12.7	4.76	5.5		◎		
	GBA43L330-030	3.3	0.3	5	12.7	4.76	5.5		◎		
	GBA43L350-030	3.5	0.3	5	12.7	4.76	5.5		◎		
	GBA43L400-040	4	0.4	5	12.7	4.76	5.5		◎		
	GBA43L100-050R	1	0.5	2	12.7	4.76	5.5		◎		
	GBA43L150-075R	1.5	0.75	3.5	12.7	4.76	5.5		◎		
	GBA43L200-100R	2	1	3.5	12.7	4.76	5.5		◎		
	GBA43L250-125R	2.5	1.25	4	12.7	4.76	5.5		◎		
	GBA43L300-125R	2.5	1.5	4	12.7	4.76	5.5		◎		
	GBA43L350-175R	3.5	1.75	4	12.7	4.76	5.5		◎		
	GBA43L400-200R	4	2	5	12.7	4.76	5.5		◎		

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
		1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

GBA 槽刀片

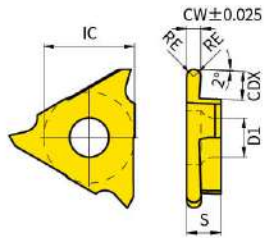


Series	IC	S	D
GBA43	12.7	4.76	5.5

GBA	型号 Type	CW (mm)	RE (mm)	CDX (mm)	IC (mm)	S (mm)	D (mm)	P		M	
								APU20D	APU30D	APM30D	
	GBA43R250-030	2.5	0.3	5	12.7	4.76	5.5		●		
	GBA43R265-030	2.65	0.3	5	12.7	4.76	5.5		●		
	GBA43R270-030	2.7	0.3	5	12.7	4.76	5.5		●		
	GBA43R280-030	2.8	0.3	5	12.7	4.76	5.5		●		
	GBA43R300-030	3	0.3	5	12.7	4.76	5.5		●		
	GBA43R320-030	3.2	0.3	5	12.7	4.76	5.5		●		
	GBA43R325-030	3.25	0.3	5	12.7	4.76	5.5		●		
	GBA43R330-030	3.3	0.3	5	12.7	4.76	5.5		●		
	GBA43R350-030	3.5	0.3	5	12.7	4.76	5.5		●		
	GBA43R400-040	4	0.4	5	12.7	4.76	5.5		●		
	GBA43R100-050R	1	0.5	2	12.7	4.76	5.5		●		
	GBA43R150-075R	1.5	0.75	3.5	12.7	4.76	5.5		●		
	GBA43R200-100R	2	1	3.5	12.7	4.76	5.5		●		
	GBA43R250-125R	2.5	1.25	4	12.7	4.76	5.5		●		
	GBA43R300-125R	2.5	1.5	4	12.7	4.76	5.5		●		
	GBA43R350-175R	3.5	1.75	4	12.7	4.76	5.5		●		
	GBA43R400-200R	4	2	5	12.7	4.76	5.5		●		

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
1200-1400		355-415	75	100	75	100	75	100	
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钛基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



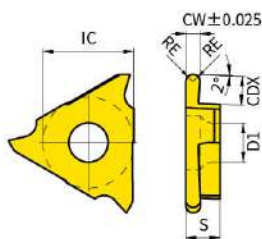
Series	IC	S	D
TGF32	9.525	3.18	4.6

TGF	型号 Type	CW (mm)	RE (mm)	CDX (mm)	IC (mm)	S (mm)	D (mm)	P		M	
								APU20D	APU30D	APM30D	
	TGF32L033-005	0.33	0.05	0.8	9.525	3.18	4.6	☉			
	TGF32L050-005	0.5	0.05	1.2	9.525	3.18	4.6	☉			
	TGF32L075-010	0.75	0.1	2	9.525	3.18	4.6	☉			
	TGF32L095-010	0.95	0.1	2	9.525	3.18	4.6	☉			
	TGF32L100-010	1	0.1	2	9.525	3.18	4.6	☉			
	TGF32L120-010	1.2	0.1	2	9.525	3.18	4.6	☉			
	TGF32L125-010	1.25	0.1	2	9.525	3.18	4.6	☉			
	TGF32L140-010	1.4	0.1	2	9.525	3.18	4.6	☉			
	TGF32L145-010	1.45	0.1	2	9.525	3.18	4.6	☉			
	TGF32L150-010	1.5	0.1	2	9.525	3.18	4.6	☉			
	TGF32L175-010	1.75	0.1	2	9.525	3.18	4.6	☉			
	TGF32L200-010	2	0.1	2.5	9.525	3.18	4.6	☉			
	TGF32L250-010	2.5	0.1	2.5	9.525	3.18	4.6	☉			
	TGF32L100-050R	1	0.5	2	9.525	3.18	4.6	☉			
	TGF32L120-R060R	1.2	0.6	2	9.525	3.18	4.6	☉			
	TGF32L150-R075R	1.5	0.75	2	9.525	3.18	4.6	☉			
	TGF32L180-R090R	1.8	0.9	2.5	9.525	3.18	4.6	☉			
	TGF32L200-R100R	2	1	2.5	9.525	3.18	4.6	☉			
	TGF32L250-R125R	2.5	1.25	2.5	9.525	3.18	4.6	☉			
	TGF32L300-R150R	3	1.5	2.5	9.525	3.18	4.6	☉			

● 常备库存 ☉ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

TGF 槽刀片

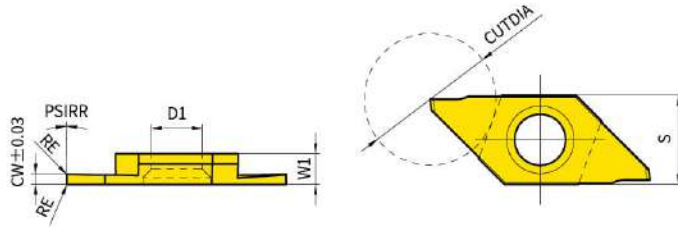


Series	IC	S	D
TGF32	9.525	3.18	4.6

TGF	型号 Type	CW (mm)	RE (mm)	CDX (mm)	IC (mm)	S (mm)	D (mm)	P		M	
								APU20D	APU30D	APM30D	
	TGF32R033-005	0.33	0.05	0.8	9.525	3.18	4.6	●			
	TGF32R050-005	0.5	0.05	1.2	9.525	3.18	4.6	●			
	TGF32R075-010	0.75	0.1	2	9.525	3.18	4.6	●			
	TGF32R095-010	0.95	0.1	2	9.525	3.18	4.6	●			
	TGF32R100-010	1	0.1	2	9.525	3.18	4.6	●			
	TGF32R120-010	1.2	0.1	2	9.525	3.18	4.6	●			
	TGF32R125-010	1.25	0.1	2	9.525	3.18	4.6	●			
	TGF32R140-010	1.4	0.1	2	9.525	3.18	4.6	●			
	TGF32R145-010	1.45	0.1	2	9.525	3.18	4.6	●			
	TGF32R150-010	1.5	0.1	2	9.525	3.18	4.6	●			
	TGF32R175-010	1.75	0.1	2	9.525	3.18	4.6	●			
	TGF32R200-010	2	0.1	2.5	9.525	3.18	4.6	●			
	TGF32R250-010	2.5	0.1	2.5	9.525	3.18	4.6	●			
	TGF32R100-050R	1	0.5	2	9.525	3.18	4.6	●			
	TGF32R120-R060R	1.2	0.6	2	9.525	3.18	4.6	●			
	TGF32R150-R075R	1.5	0.75	2	9.525	3.18	4.6	●			
	TGF32R180-R090R	1.8	0.9	2.5	9.525	3.18	4.6	●			
	TGF32R200-R100R	2	1	2.5	9.525	3.18	4.6	●			
	TGF32R250-R125R	2.5	1.25	2.5	9.525	3.18	4.6	●			
	TGF32R300-R150R	3	1.5	2.5	9.525	3.18	4.6	●			

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



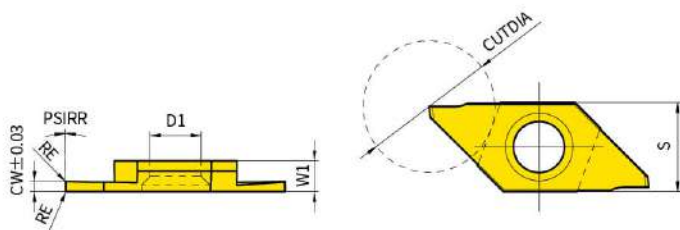
Series	S	D1	W1
TKF12	8.7	5	3
TKF16	9.5	5	4

TKF	型号 Type	CW	S	D1	RE	W1	CUTDIA	PSIRR	CW min	CW max	P		M	
											APU20D	APU30D	APM30D	
	TKF12L050-NB	0.50	8.7	5	0	3	5	0	-0.03	+0.03		◎		
	TKF12L070-NB	0.70	8.7	5	0	3	8	0	-0.03	+0.03		◎		
	TKF12L100-NB	1.00	8.7	5	0	3	12	0	-0.03	+0.03		◎		
	TKF12L150-NB	1.50	8.7	5	0	3	12	0	-0.03	+0.03		◎		
	TKF12L200-NB	2.00	8.7	5	0	3	12	0	-0.03	+0.03		◎		
	TKF16L100-NB	1.00	9.5	5	0	4	16	0	-0.03	0.03		◎		
	TKF16L150-NB	1.50	9.5	5	0	4	16	0	-0.03	0.03		◎		
	TKF16L200-NB	2.00	9.5	5	0	4	16	0	-0.03	0.03		◎		
	TKF16L250-NB	2.50	9.5	5	0	4	16	0	-0.03	0.03		◎		
	TKF12L070-T	0.70	8.7	5	0.08	3	8	0	-0.03	+0.03		◎		
	TKF12L100-T	1.00	8.7	5	0.08	3	12	0	-0.03	+0.03		◎		
	TKF12L150-T	1.50	8.7	5	0.08	3	12	0	-0.03	+0.03		◎		
	TKF12L200-T	2.00	8.7	5	0.08	3	12	0	-0.03	+0.03		◎		
	TKF16L150-T	1.50	9.5	5	0.08	4	16	0	-0.03	0.03		◎		
	TKF16L200-T	2.00	9.5	5	0.08	4	16	0	-0.03	0.03		◎		
	TKF12L050-S	0.50	8.7	5	0.03	3	5	0	-0.03	0.03		◎		
	TKF12L070-S	0.70	8.7	5	0.03	3	8	0	-0.03	0.03		◎		
	TKF12L100-S	1.00	8.7	5	0.03	3	12	0	-0.03	0.03		◎		
	TKF12L125-S	1.25	8.7	5	0.03	3	12	0	-0.03	0.03		◎		
	TKF12L150-S	1.50	8.7	5	0.03	3	12	0	-0.03	0.03		◎		

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
		1260	370	40	80	40	80	40	80
N	钛合金	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

TKF 槽刀片

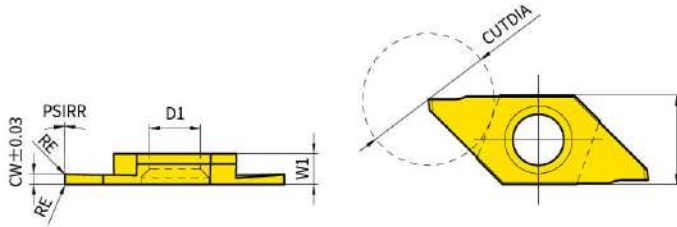


Series	S	D1	W1
TKF12	8.7	5	3
TKF16	9.5	5	4

TKF	型号 Type	CW	S	D1	RE	W1	CUTDIA	PSIRR	CW min	CW max	P		M	
											APU20D	APU30D	APM30D	
	TKF12R050-NB	0.50	8.7	5	0	3	5	0	-0.03	+0.03		●		
	TKF12R070-NB	0.70	8.7	5	0	3	8	0	-0.03	+0.03		●		
	TKF12R100-NB	1.00	8.7	5	0	3	12	0	-0.03	+0.03		●		
	TKF12R150-NB	1.50	8.7	5	0	3	12	0	-0.03	+0.03		●		
	TKF12R200-NB	2.00	8.7	5	0	3	12	0	-0.03	+0.03		●		
	TKF16R100-NB	1.00	9.5	5	0	4	16	0	-0.03	0.03		●		
	TKF16R150-NB	1.50	9.5	5	0	4	16	0	-0.03	0.03		●		
	TKF16R200-NB	2.00	9.5	5	0	4	16	0	-0.03	0.03		●		
	TKF16R250-NB	2.50	9.5	5	0	4	16	0	-0.03	0.03		●		
	TKF16R300-NB	3.00	9.5	5	0	4	16	0	-0.03	0.03		●		
	TKF12R070-T	0.70	8.7	5	0.08	3	8	0	-0.03	+0.03		●		
	TKF12R100-T	1.00	8.7	5	0.08	3	12	0	-0.03	+0.03		●		
	TKF12R150-T	1.50	8.7	5	0.08	3	12	0	-0.03	+0.03		●		
	TKF12R200-T	2.00	8.7	5	0.08	3	12	0	-0.03	+0.03		●		
	TKF16R150-T	1.50	9.5	5	0.08	4	16	0	-0.03	0.03		●		
	TKF16R200-T	2.00	9.5	5	0.08	4	16	0	-0.03	0.03		●		
	TKF12R050-S	0.50	8.7	5	0.03	3	5	0	-0.03	0.03		●		
	TKF12R070-S	0.70	8.7	5	0.03	3	8	0	-0.03	0.03		●		
	TKF12R100-S	1.00	8.7	5	0.03	3	12	0	-0.03	0.03		●		
	TKF12R125-S	1.25	8.7	5	0.03	3	12	0	-0.03	0.03		●		
	TKF12R150-S	1.50	8.7	5	0.03	3	12	0	-0.03	0.03		●		

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



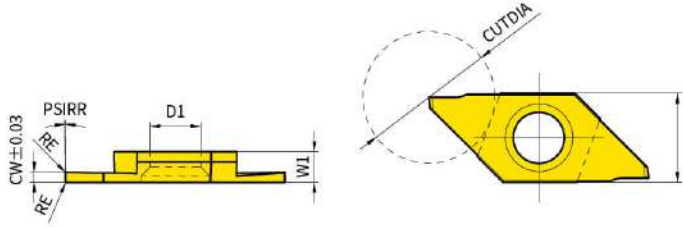
Series	S	D1	W1
TKF12	8.7	5	3
TKF16	9.5	5	4

TKF	型号 Type	CW	S	D1	RE	W1	CUTDIA	PSIRR	CW min	CW max	P		M	
											APU20D	APU30D	APM30D	
	TKF12L200-S	2.00	8.7	5	0.03	3	12	0	-0.03	0.03		◎		
	TKF16L100-S	1.00	9.5	5	0.05	4	16	0	-0.03	0.03		◎		
	TKF16L150-S	1.50	9.5	5	0.05	4	16	0	-0.03	0.03		◎		
	TKF16L200-S	2.00	9.5	5	0.05	4	16	0	-0.03	0.03		◎		
	TKF16L250-S	2.50	9.5	5	0.05	4	16	0	-0.03	0.03		◎		
	TKF16L300-S	3.00	9.5	5	0.05	4	16	0	-0.03	0.03		◎		
	TKF12L050-NB-20DR	0.50	8.7	5	0	3	5	20	-0.03	+0.03		◎		
	TKF12L070-NB-20DR	0.70	8.7	5	0	3	8	20	-0.03	+0.03		◎		
	TKF12L100-NB-20DR	1.00	8.7	5	0	3	12	20	-0.03	+0.03		◎		
	TKF12L150-NB-20DR	1.50	8.7	5	0	3	12	20	-0.03	+0.03		◎		
	TKF12L200-NB-20DR	2.00	8.7	5	0	3	12	20	-0.03	+0.03		◎		
	TKF16L100-NB-20DR	1.00	9.5	5	0	4	16	20	-0.03	0.03		◎		
	TKF16L150-NB-20DR	1.50	9.5	5	0	4	16	20	-0.03	0.03		◎		
	TKF16L200-NB-20DR	2.00	9.5	5	0	4	16	20	-0.03	0.03		◎		
	TKF16L250-NB-20DR	2.50	9.5	5	0	4	16	20	-0.03	0.03		◎		
	TKF16L300-NB-20DR	2.00	9.5	5	0	4	16	20	-0.03	0.03		◎		

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
M		1200-1400	355-415	75	100	75	100	75	100
	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

TKF 槽刀片

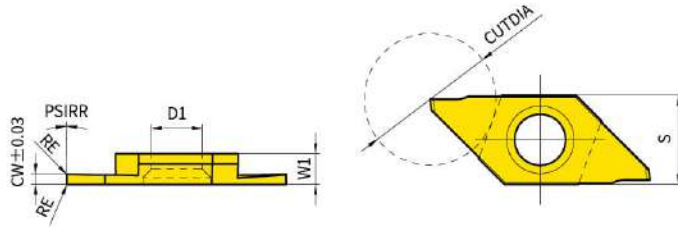


Series	S	D1	W1
TKF12	8.7	5	3
TKF16	9.5	5	4

TKF	型号 Type	CW	S	D1	RE	W1	CUTDIA	PSIRR	CW min	CW max	P		M	
											APU20D	APU30D	APM30D	
	TKF12R200-S	2.00	8.7	5	0.03	3	12	0	-0.03	0.03		●		
	TKF16R100-S	1.00	9.5	5	0.05	4	16	0	-0.03	0.03		●		
	TKF16R150-S	1.50	9.5	5	0.05	4	16	0	-0.03	0.03		●		
	TKF16R200-S	2.00	9.5	5	0.05	4	16	0	-0.03	0.03		●		
	TKF16R250-S	2.50	9.5	5	0.05	4	16	0	-0.03	0.03		●		
	TKF16R300-S	3.00	9.5	5	0.05	4	16	0	-0.03	0.03		●		
	TKF12R050-NB-20DR	0.50	8.7	5	0	3	5	20	-0.03	+0.03		●		
	TKF12R070-NB-20DR	0.70	8.7	5	0	3	8	20	-0.03	+0.03		●		
	TKF12R100-NB-20DR	1.00	8.7	5	0	3	12	20	-0.03	+0.03		●		
	TKF12R150-NB-20DR	1.50	8.7	5	0	3	12	20	-0.03	+0.03		●		
	TKF12R200-NB-20DR	2.00	8.7	5	0	3	12	20	-0.03	+0.03		●		
	TKF16R100-NB-20DR	1.00	9.5	5	0	4	16	20	-0.03	0.03		●		
	TKF16R150-NB-20DR	1.50	9.5	5	0	4	16	20	-0.03	0.03		●		
	TKF16R200-NB-20DR	2.00	9.5	5	0	4	16	20	-0.03	0.03		●		
	TKF16R250-NB-20DR	2.50	9.5	5	0	4	16	20	-0.03	0.03		●		
	TKF16R300-NB-20DR	2.00	9.5	5	0	4	16	20	-0.03	0.03		●		

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



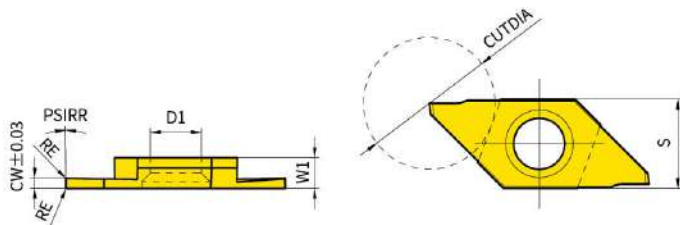
Series	S	D1	W1
TKF12	8.7	5	3
TKF16	9.5	5	4

TKF	型号 Type	CW	S	D1	RE	W1	CUTDIA	PSIRR	CW min	CW max	P		M	
											APU20D	APU30D	APM30D	
	TKF12L100-T-16DR	1.00	8.7	5	0.08	3	12	16	-0.03	+0.03		◎		
	TKF12L150-T-16DR	1.50	8.7	5	0.08	3	12	16	-0.03	+0.03		◎		
	TKF12L200-T-16DR	2.00	8.7	5	0.08	3	12	16	-0.03	+0.03		◎		
	TKF16L150-T-16DR	1.50	9.5	5	0.08	4	16	16	-0.03	0.03		◎		
	TKF16L200-T-16DR	2.00	9.5	5	0.08	4	16	16	-0.03	0.03		◎		
	TKF12L050-S-16DR	0.50	8.7	5	0.03	3	5	16	-0.03	+0.03		◎		
	TKF12L070-S-16DR	0.70	8.7	5	0.03	3	8	16	-0.03	+0.03		◎		
	TKF12L100-S-16DR	1.00	8.7	5	0.03	3	12	16	-0.03	+0.03		◎		
	TKF12L125-S-16DR	1.25	8.7	5	0.03	3	12	16	-0.03	+0.03		◎		
	TKF12L150-S-16DR	1.50	8.7	5	0.03	3	12	16	-0.03	+0.03		◎		
	TKF12L200-S-16DR	2.00	8.7	5	0.03	3	12	16	-0.03	+0.03		◎		
	TKF16L100-S-16DR	1.00	9.5	5	0.05	4	16	16	-0.03	0.03		◎		
	TKF16L150-S-16DR	1.50	9.5	5	0.05	4	16	16	-0.03	0.03		◎		
	TKF16L200-S-16DR	2.00	9.5	5	0.05	4	16	16	-0.03	0.03		◎		
	TKF16L250-S-16DR	2.50	9.5	5	0.05	4	16	16	-0.03	0.03		◎		
	TKF16L300-S-16DR	3.00	9.5	5	0.05	4	16	16	-0.03	0.03		◎		

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
		1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

TKF 槽刀片



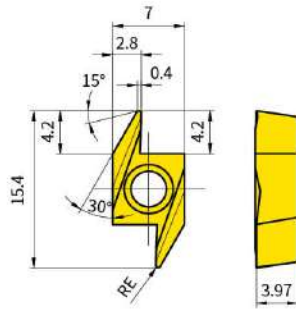
Series	S	D1	W1
TKF12	8.7	5	3
TKF16	9.5	5	4

TKF	型号 Type	CW	S	D1	RE	W1	CUTDIA	PSIRR	CW min	CW max	P		M	
											APU20D	APU30D	APM30D	
	TKF12R100-T-16DR	1.00	8.7	5	0.08	3	12	16	-0.03	+0.03		●		
	TKF12R150-T-16DR	1.50	8.7	5	0.08	3	12	16	-0.03	+0.03		●		
	TKF12R200-T-16DR	2.00	8.7	5	0.08	3	12	16	-0.03	+0.03		●		
	TKF16R150-T-16DR	1.50	9.5	5	0.08	4	16	16	-0.03	0.03		●		
	TKF16R200-T-16DR	2.00	9.5	5	0.08	4	16	16	-0.03	0.03		●		
	TKF12R050-S-16DR	0.50	8.7	5	0.03	3	5	16	-0.03	+0.03		●		
	TKF12R070-S-16DR	0.70	8.7	5	0.03	3	8	16	-0.03	+0.03		●		
	TKF12R100-S-16DR	1.00	8.7	5	0.03	3	12	16	-0.03	+0.03		●		
	TKF12R125-S-16DR	1.25	8.7	5	0.03	3	12	16	-0.03	+0.03		●		
	TKF12R150-S-16DR	1.50	8.7	5	0.03	3	12	16	-0.03	+0.03		●		
	TKF12R200-S-16DR	2.00	8.7	5	0.03	3	12	16	-0.03	+0.03		●		
	TKF16R100-S-16DR	1.00	9.5	5	0.05	4	16	16	-0.03	0.03		●		
	TKF16R150-S-16DR	1.50	9.5	5	0.05	4	16	16	-0.03	0.03		●		
	TKF16R200-S-16DR	2.00	9.5	5	0.05	4	16	16	-0.03	0.03		●		
	TKF16R250-S-16DR	2.50	9.5	5	0.05	4	16	16	-0.03	0.03		●		
	TKF16R300-S-16DR	3.00	9.5	5	0.05	4	16	16	-0.03	0.03		●		

● 常备库存 ○ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钛基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
		1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

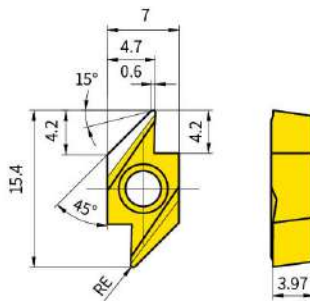
ABS/ABW 后扫刀片



Series	AP(MAX)	L
ABS15	4.2	15.4

ABS	型号 Type	RE	AP(MAX)	P		M	
				APU20D	APU30D	APM30D	
	ABS15R4005M	< 0.05	4.2		●		
	ABS15R4015M	< 0.15	4.2		●		

● 常备库存 ◎ 可选库存



Series	AP(MAX)	L
ABW15	4.2	15.4

ABW	型号 Type	RE	AP(MAX)	P		M	
				APU20D	APU30D	APM30D	
	ABW15R4005M	< 0.05	4.2		●		
	ABW15R4015M	< 0.15	4.2		●		

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
		1260	370	40	80	40	80	40	80
N	钛合金	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

A

B

C

D

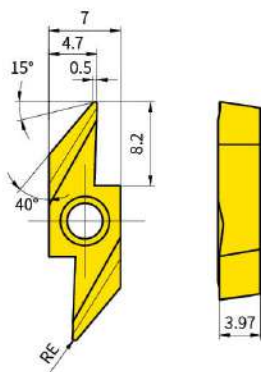
E

F

G

H

ABS/ABW 后扫刀片



Series	AP(MAX)	L
ABS23	8.2	23.4

ABW	型号 Type	RE	AP(MAX)	P		M	
				APU20D	APU30D	APM30D	
	ABW23R5005M	< 0.05	8,2		●		
	ABW23R5015M	< 0.15	8.2		●		

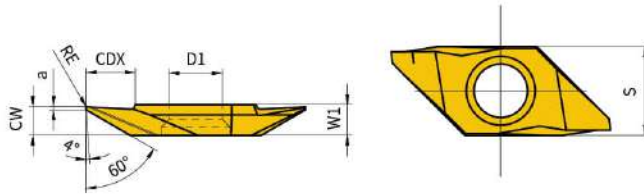
● 常备库存 ◎ 可选库存

切削参数

Vc(m/min.)

ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

Series	S	D1
TKF12	8.7	5.2
TKF16	9.5	5.2



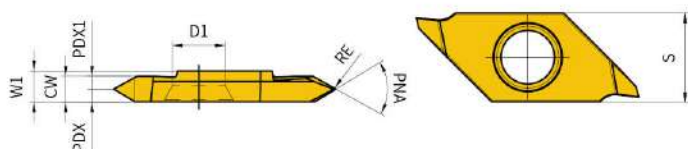
TKFB	型号 Type	CW	CDX	S	D1	RE	a	P		M	
								APU20D	APU30D	APM30D	
	TKFB12R15005M	1.5	2.6	8.7	5.2	< 0.05	0.25		●		
	TKFB12R15010M	1.5	2.6	8.7	5.2	< 0.10	0.3		●		
	TKFB12R28005M	2.8	4.6	8.7	5.2	< 0.05	0.3		●		
	TKFB12R28010M	2.8	4.6	8.7	5.2	< 0.10	0.3		●		
	TKFB16R38005M	3.8	6.3	9.5	5.2	< 0.05	0.3		●		
	TKFB16R38010M	3.8	6.3	9.5	5.2	< 0.10	0.3		●		
	TKFB12L28005MR	2.8	4.6	8.7	5.2	< 0.05	0.3		●		
	TKFB12L28010MR	2.8	4.6	8.7	5.2	< 0.10	0.3		●		
	TKFB16L38005MR	3.8	6.3	9.5	5.2	< 0.05	0.3		●		
	TKFB16L38010MR	3.8	6.3	9.5	5.2	< 0.10	0.3		●		

● 常备库存 ◎ 可选库存

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
	高合金钢	950-1200	280-355	80	125	80	125	80	125
		1200-1400	355-415	75	100	75	100	75	100
M	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
K	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
		1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40

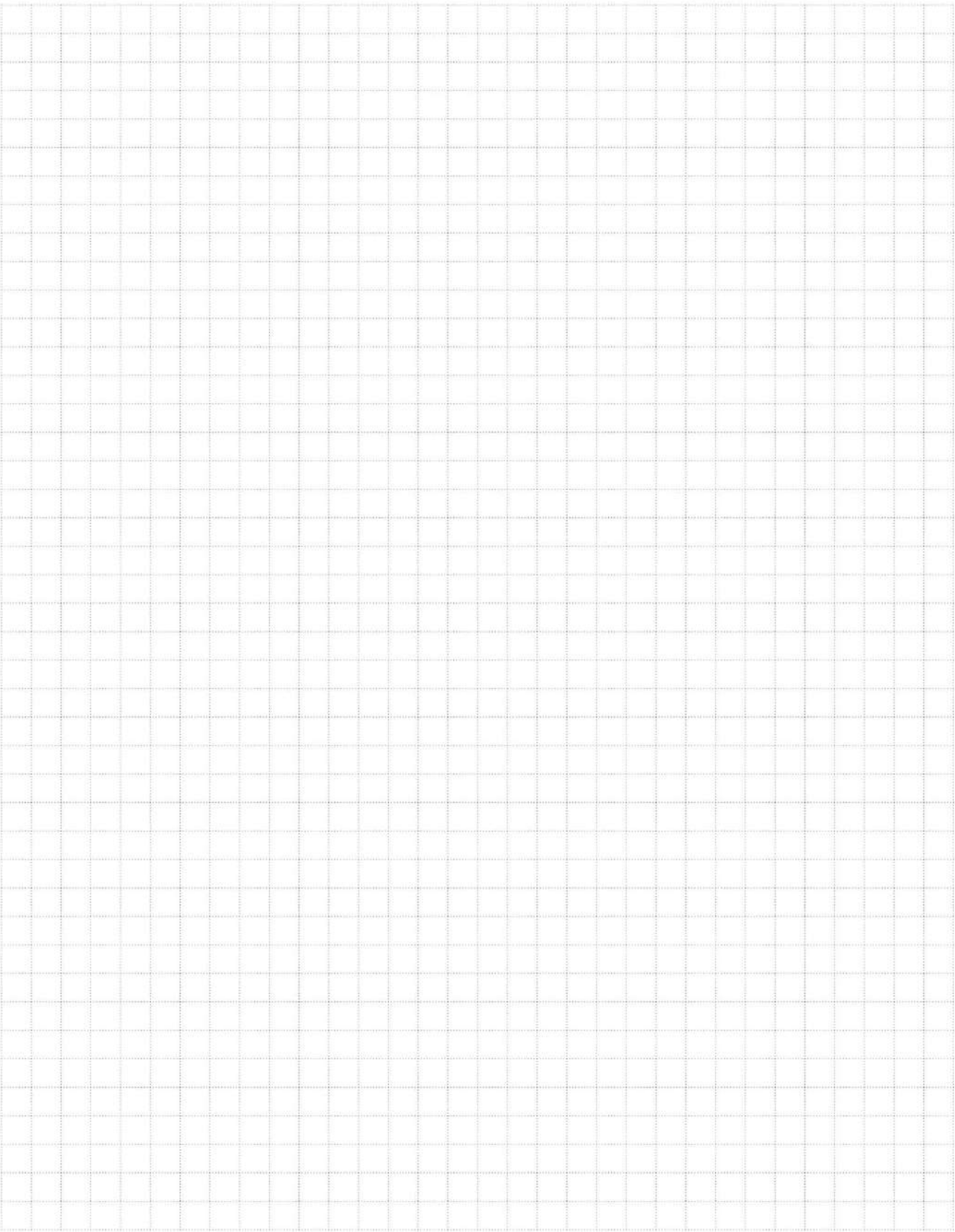
TKFT 螺纹刀片

Series	CW	S	W1
TKFT	2.5	8.7	3



TKFT	型号 Type	CW	S	D1	RE	W1	PDX	PDX1	P		M	
									APU20D	APU30D	APM30D	
	TKFT12RA6000	2.5	8.7	5.2	0	3	0.4	2.1		●		
	TKFT12RB6000	2.5	8.7	5.2	0	3	2.1	0.4		●		
	TKFT12LA6000	2.5	8.7	5.2	0	3	2.1	0.4		●		
	TKFT12LB6000	2.5	8.7	5.2	0	3	0.4	2.1		●		
	TKFT12RA60005	2.5	8.7	5.2	0.05	3	0.8	1.7		●		
	TKFT12RB60005	2.5	8.7	5.2	0.05	3	1.7	0.8		●		
	TKFT12LA60005	2.5	8.7	5.2	0.05	3	1.7	0.8		●		
	TKFT12LB60005	2.5	8.7	5.2	0.05	3	0.8	1.7		●		
	TKFT12RN6001	2.5	8.7	5.2	0.1	3	1.25	1.25		●		
	TKFT12LN6001	2.5	8.7	5.2	0.1	3	1.25	1.25		●		
	TKFT12RA55005	2.5	8.7	5.2	0.05	3	0.8	1.7		●		
	TKFT12RB55005	2.5	8.7	5.2	0.05	3	1.7	0.8		●		
	TKFT12LA55005	2.5	8.7	5.2	0.05	3	1.7	0.8		●		
	TKFT12LB55005	2.5	8.7	5.2	0.05	3	0.8	1.7		●		

切削参数				Vc(m/min.)					
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	APM30D		APU20D		APU30D	
				Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢	< 600	< 180	80	200	80	200	80	200
		< 950	< 280	80	180	80	180	80	180
	低合金钢	700-950	200-280	80	160	80	160	80	160
		950-1200	280-355	80	125	80	125	80	125
M	高合金钢	1200-1400	355-415	75	100	75	100	75	100
	奥氏体不锈钢	675	200	120	240	120	200	120	200
	双相不锈钢	778	230	100	160	100	160	100	160
K	沉淀硬化不锈钢	1013	300	80	150	80	150	80	150
	灰口铸铁	700	220	180	240	180	240	180	240
	球墨铸铁	880	260	160	200	160	200	160	200
	可锻铸铁	800	250	-	-	-	-	-	-
S	钴基合金, 镍基合金	1100	320-250	45	90	45	90	45	90
	钛合金	1260	370	40	80	40	80	40	80
N	铝	260	75						
	铝合金	447	130						
H	淬硬钢	-	50-60HRC	30	45	30	45	30	45
	淬硬铸铁	-	55HRC	30	40	30	40	30	40



A

B

C

D

E

F

G

H

A

B

C

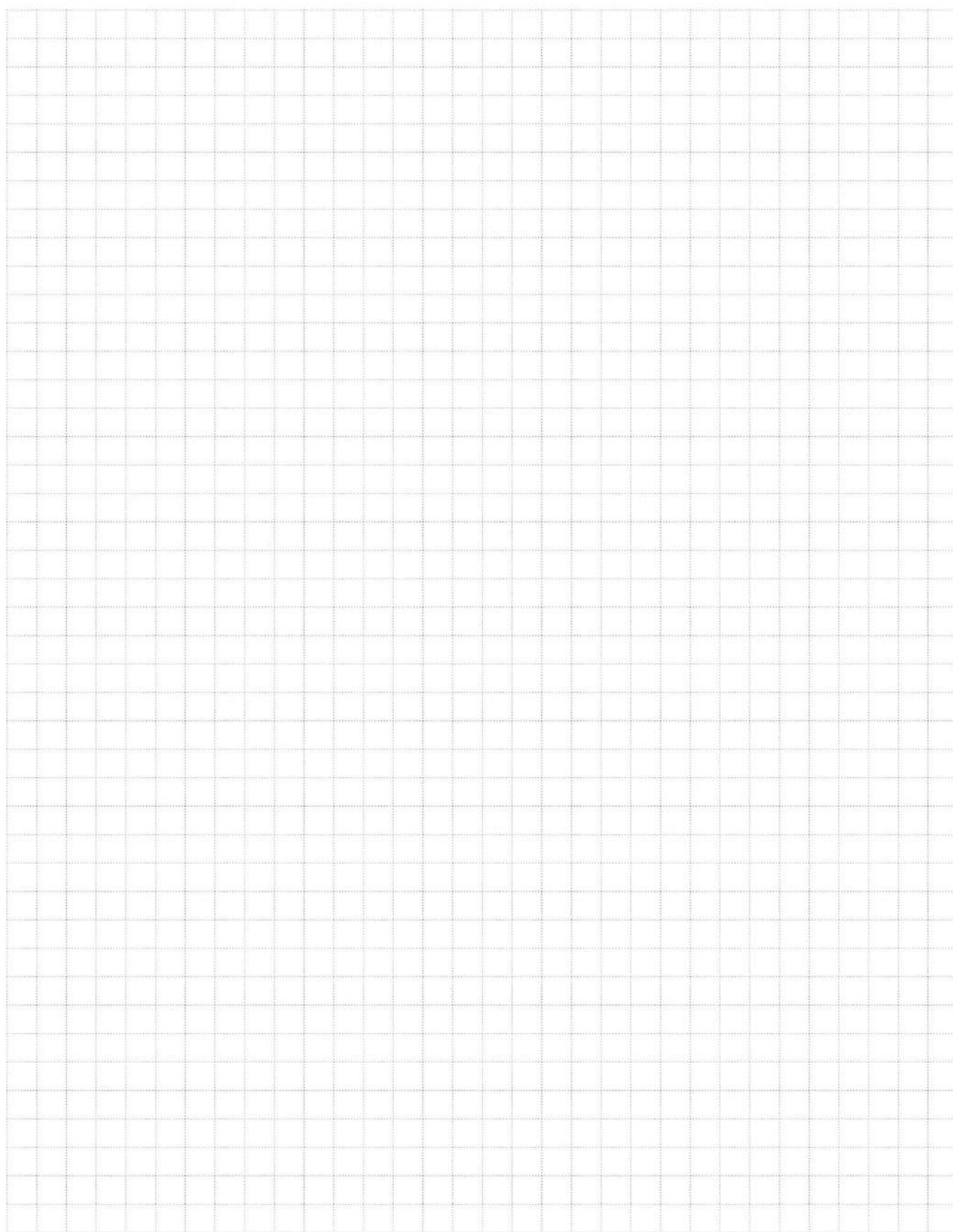
D

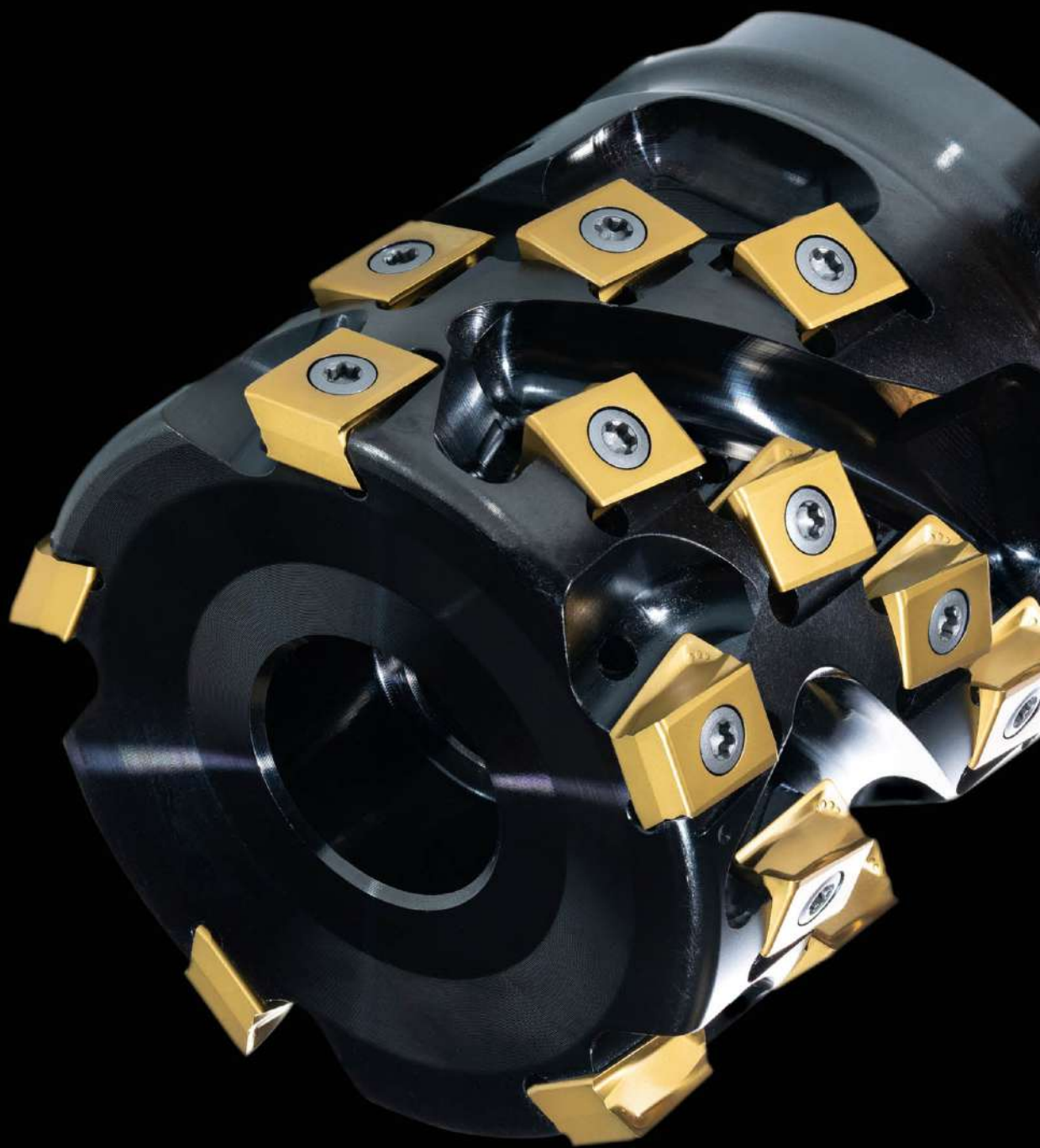
E

F

G

H





MILLING

铣削系列

铣削用可转位刀片按照
ISO 1832 标准的符号说明

示例:

H	N	G	X	09	06	ANSN
1	2	3	4	5	6	7

1、刀片形状

代号	图形	代号	图形
A		M	
B		O	
C		P	
D		R	
E		S	
H		T	
K		V	
L		W	

3、公差

允许公差 (mm)	d	m	s
	A	± 0,025	± 0,005
	C	± 0,025	± 0,013
	E	± 0,025	± 0,025
	F	± 0,013	± 0,005
	G	± 0,025	± 0,025
	H	± 0,013	± 0,013
	J ¹	± 0,05-0,15 ²	± 0,005
	K ¹	± 0,05-0,15 ²	± 0,013
	L ¹	± 0,05-0,15 ²	± 0,025
	M	± 0,05-0,15 ²	± 0,08-0,20 ²
	N	± 0,05-0,15 ²	± 0,08-0,20 ²
	U	± 0,08-0,25 ²	± 0,13-0,38 ²

¹ 刀片有精磨的副切削刃 ² 视刀片尺寸而定 (见 ISO 1832 标准)

2、后角

代号	图形	代号	图形
A		N	
B		P	
C			
D			
E			
F			
G			

4、刀片加工和固定特征

代号	图形	代号	图形	代号	图形
A		H		R	
B		J		T	
C		M		U	
F		N		W	
G		Q		X	需要可转位 刀片的图纸 或准确说明



5、切削刃长度

刀片形状													
内切圆直径 d													
mm	英寸	规格	l	规格	l	规格	规格	规格	l	规格	l	规格	l
3,97	5/32									06	6,9		
5	0,197					05				09	9		
5,56	7/32											03	3,8
6	0,236					06							
6,35	2/8	06	6,4	07	7,7	06 ¹				11	11	11	11
8	0,315					08						05	5,2
9,525	3/8	09	9,6	11	11,6	09 ¹	09	9,5		16	16,5	16	16,5
10	0,394					10						06	6,5
12	0,472					12							
12,7	4/8	12	12,9	15	15,5	12 ¹	12	12,7		22	22	22	22,1
15,875	5/8	16	16,1				15	15,8		27	27		
16	0,63					16							
17,46	11/16											12	11,6
19,05	6/8	19	19,3			19 ¹	19	19,0					
20	0,787					20							
25	0,984					25							
25,4	8/8	25	25,8			25 ¹	25	25,4					
32	1,26					32							

¹ 英制规格 (00)

6、刀片厚度

图形	厚度 s(mm)
	01 1,59
	T1 1,98
	02 2,38
	T2 2,78
	03 3,18
	T3 3,97
	04 4,76
	05 5,56
	06 6,35
	07 7,94
	09 9,52

7-1、刀尖圆角半径

图形	半径 r(mm)
	01 0,1
	02 0,2
	04 0,4
	08 0,8
	12 1,2
	16 1,6
	24 2,4
	M0 用于公制直径尺寸
	00 用于已转换为 mm 的英制直径尺寸

7-2、主偏角

代号	角度
P	90°
A	45°
D	60°
E	75°
F	85°
Z	其他主偏角

7-3、副切削刃后角

代号	角度
N	0°
P	11°
D	15°
E	20°
F	25°
Z	后角

7-4、切削刃形状

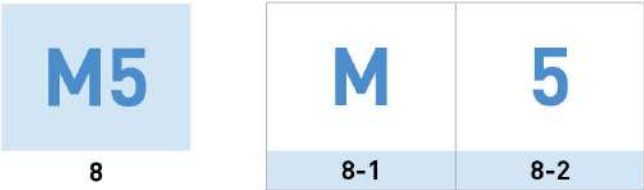
代号	图形
F	
E	
T	
S	

7-5、切削方向

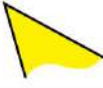
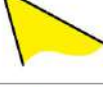
代号	图形
R	
L	
N	

槽型介绍

示例：



8、槽型索引

铣削槽型	刃口示意	槽型说明	铣削槽型	刃口示意	槽型说明
-F2		轻切削加工槽型	-M6		刃口倒圆槽型
-F5		粗糙度优先型	-R5		通用高强度加工槽型
-M4		低阻力型	-R6		刃口负倒棱槽型
-M5		通用中等加工	-M7		通用中高强度加工

8-1、槽型代号

代号	用途
F	精加工
	轻切削 / 切削力优先
S	半精加工
M	中等加工
R	粗加工
	寿命优先
H	重切削
W	Wiper 修光刃

8-2、功能代号

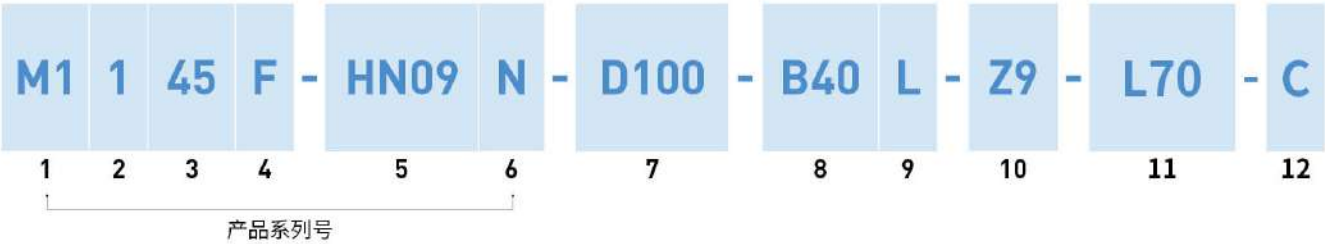
代号
2
4
5
6
7

示例：

A	P	M	25	E
1	2	3	4	5

功能序号	说明	详情			
1	AHNO 阿诺				
2	基础材料及 涂层代码	C	硬质合金 +CVD	V	金属陶瓷 +PVD
		P	硬质合金 +PVD	I	塞隆陶瓷
		B	CBN	W	晶须陶瓷
		D	PCD	N	硬质合金无涂层
		T	金属陶瓷		
3	第一推荐应用	P	钢	S	难加工材料
		M	不锈钢	H	硬材料
		K	铸铁	U	通用
		N	有色金属		
4	ISO 应用范围	0515253545 耐磨性 韧性			
5	代次代码				

示例：



1、刀具产品系列

代号	切削方式	系列号
MF	面铣	M1
MS	方肩铣刀	M2
MH	快进给	M3
MP	仿形	M4
MD	三面刃	M5
MT	螺纹铣刀	M6
MC	倒角	M7
PE	玉米铣	M9

2、代次

系列代次

3、主偏角 (Kr)

数值	角度
90	90
88	88
75	75
60	60
.	.
.	.
15	15
00	圆刀片

4、刀刃类型

代号	微调节刃
F	带微调节刃

5、刀片

刀片型号

6、刀盘类型

代号	楔块式刀盘
N	带楔块式刀盘

7、直径

刀具直径

8、接口

代号	连接方式
B	芯轴式
W	侧固式
A	圆柱式
M	螺纹接口

9、切削方向

代号	旋向
R	右手（缺省）
L	左手

10、齿数

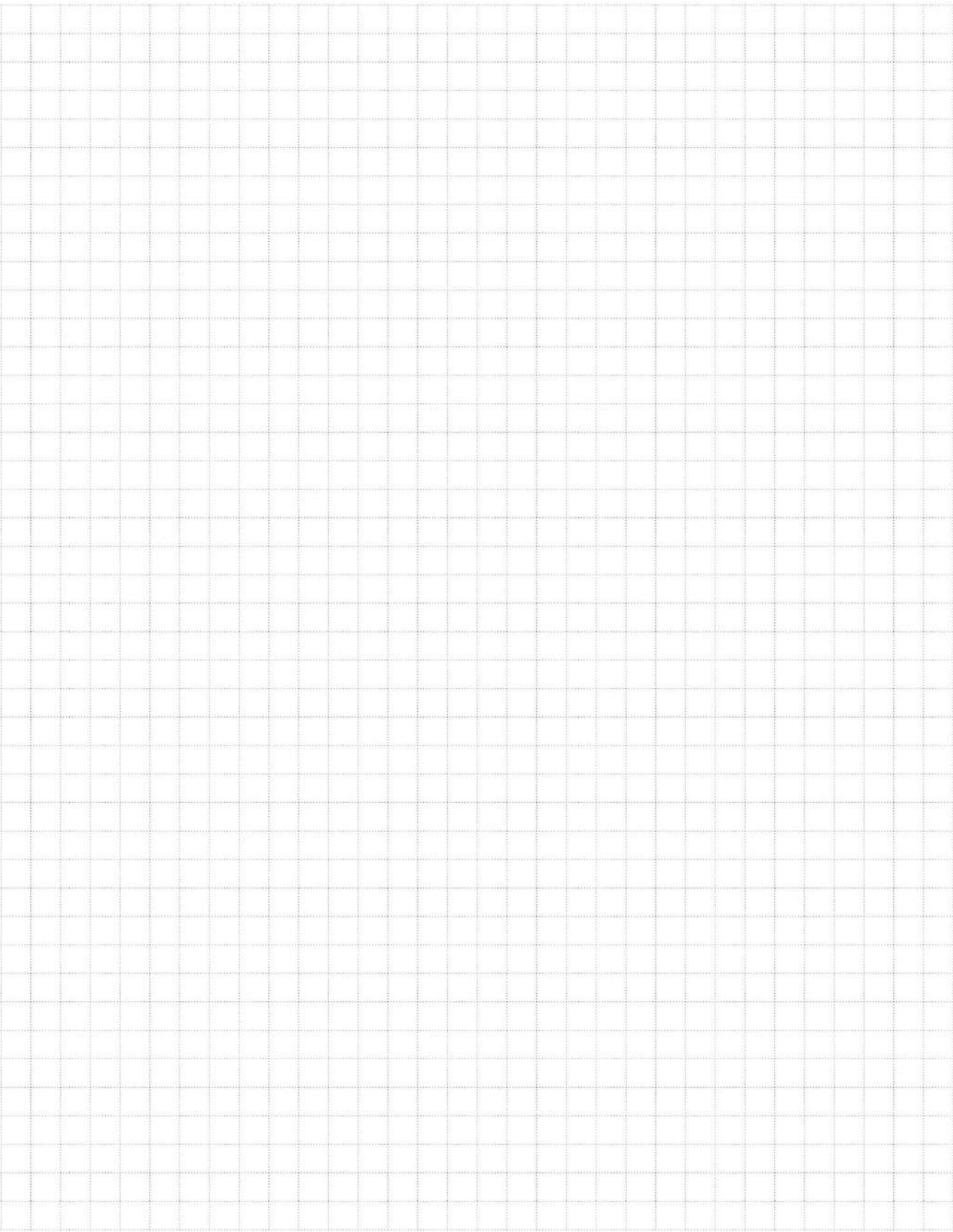
刀体齿数

11、长度

特殊长度

12、其他

代号	类型
C	带内冷
无标记	不带内冷



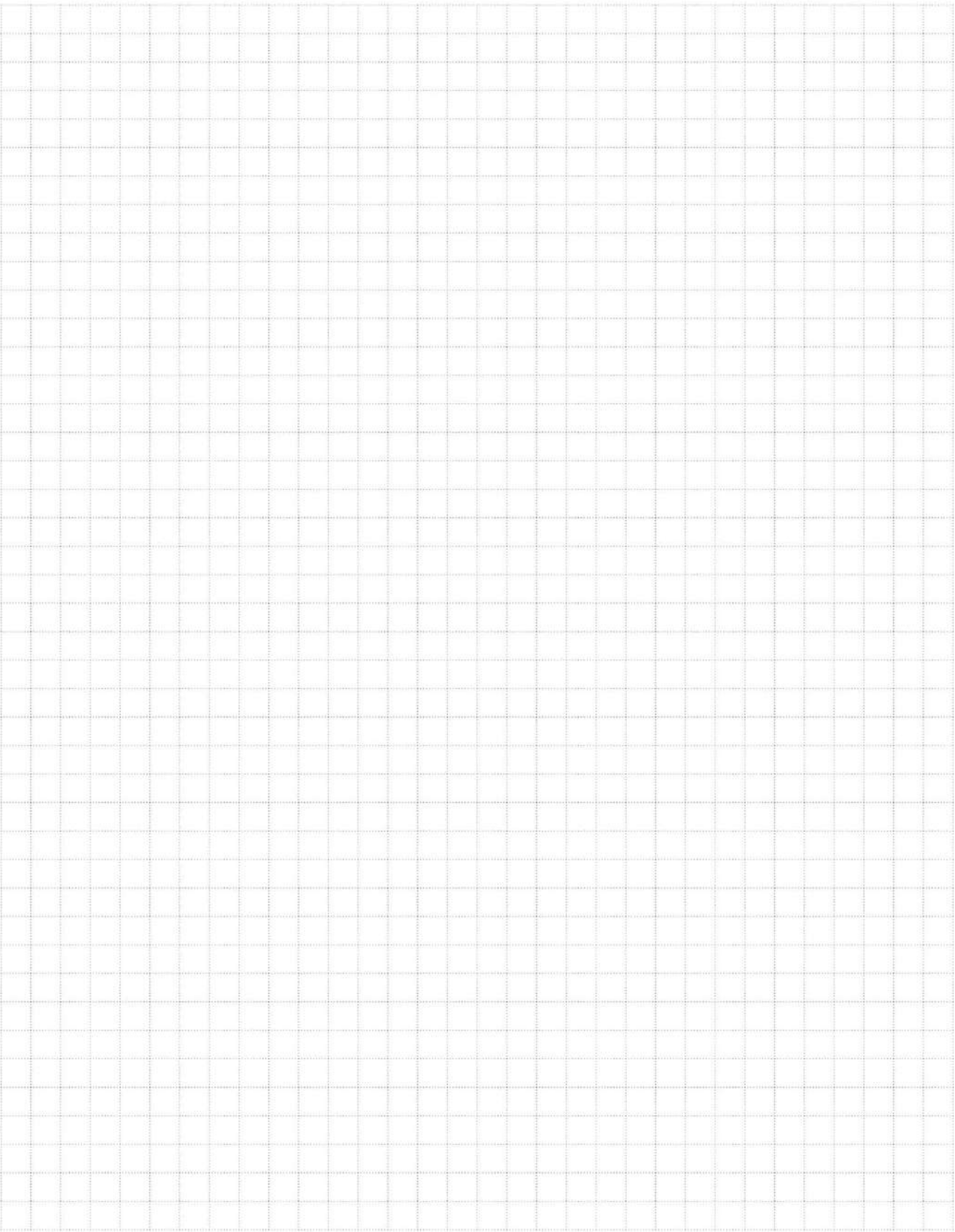
铣削材质一览

铣削材质应用														
阿诺铣削 材质牌号	ISO 组别	涂层工艺	工件材料组别						应用范围					技术说明
			P	M	K	S	N	H	05	15	25	35	45	
APK15E/B	K15	PVD			●					■				铸铁专用铣削材质，极具耐磨性的基体，搭载高性能的 PVD 涂层，广泛应用于各类铸铁的加工。
ACK15E	K15	CVD			●					■				铸铁专用铣削材质，极具耐磨性的基体，搭载 MT-CVD 涂层，适用于较高线速度的应用。
ACK25E	K25	CVD			●					■				铸铁中等铣削材质，凭借全新一代的基体和 MT-CVD 涂层，有效覆盖了铸铁的半精加工至粗加工。
ACK35E	K35	CVD			●						■			铸铁粗铣材质，凭借高强度的韧性基体和 MT-CVD 涂层，具有良好的可靠性，是应对恶劣工况的最佳选择。
APS25C	S25	PVD				●				■				难加工材料专用材质，采用全新一代的 PVD 涂层技术，具有良好的耐磨性和热稳定性，同时也适用于不锈钢和部分铸铁的加工。
	M25			●					■					
	K25				◐					■				
APS35C	S35	PVD				●					■			难加工材料专用材质，采用全新一代的 PVD 涂层技术，具有良好的韧性和热稳定性，同样也能覆盖不锈钢的加工。
	M35			●						■				

● 第一推荐 ● 第二推荐

铣削材质一览

	被加工材料组	刀具材质	涂层类型	应用类别				
				05	10	20	30	40
P	碳素钢 / 合金钢	硬质合金	PVD		APU25C			
		硬质合金	PVD		APU25E/B			
		硬质合金	CVD			ACP35E		
		硬质合金	PVD			APP45E		
M	不锈钢	硬质合金	PVD		APM25C			
		硬质合金	PVD		APM25E/B			
		硬质合金	PVD			APM35C		
		硬质合金	PVD			APM35E/B		
		硬质合金	PVD			APP45E		
K	铸铁	硬质合金	PVD		APK15E/B			
		硬质合金	CVD		ACK15E			
		硬质合金	CVD			ACK25E		
		硬质合金	CVD			ACK35E		
S	高温合金 / 钛合金	硬质合金	PVD		APS25C			
		硬质合金	PVD			APS35C		
		硬质合金	-		ANN15			



A

B

C

D

E

F

G

H

铣削材质一览

铣削材质应用														
阿诺铣削 材质牌号	ISO 组别	涂层工艺	工件材料组别						应用范围					技术说明
			P	M	K	S	N	H	05	15	25	35	45	
APU25C	P25	PVD	●								■			通用性极佳的铣削材质，均衡的基体搭载全新的 PVD 涂层技术，兼顾了耐磨性和韧性，全面覆盖钢、不锈钢以及铸铁类材料。
	M25		◐								■			
	K25			◐							■			
APU25E/B	P25	PVD	●								■			铣削的多功能材质，采用了优良韧性的基体，具有均衡的抗弯强度，通用的 PVD 涂层实现了良好的热稳定性，适用于钢、不锈钢以及铸铁类材料。
	M25		◐								■			
	K25			◐							■			
ACP35E	P35	CVD	●								■	■		铣削的多功能材质，高强度的基体搭载 MT-CVD 涂层，即便在较高的线速度下依然兼顾了耐磨性，适用于钢和铸铁的粗加工。
	K35				●						■	■		
APP45E	P45	PVD	●									■	■	铣削专用材质，优秀的韧性特别适用于低线速度或恶劣的加工条件，面对高强度钢和不锈钢能够保持良好的可靠性。
	M45			●								■	■	
APM25C	M25	PVD		●							■			铣削的多功能材质，高强度的基体搭载全新的 PVD 涂层技术，具有卓越的耐磨性，尤其适用于不锈钢加工、以及部分工况的铸铁铣削和难加工材料铣削。
	K25				◐						■			
	S25					◐					■			
APM25E/B	M25	PVD		●							■			铣削的多功能材质，高强度的基体搭载通用的 PVD 涂层，具有良好的抗热冲击性能，尤其适用于不锈钢和钛合金的加工、以及部分钢的铣削。
	P25		◐								■			
	S25					◐					■			
APM35C	M35	PVD		●							■			适用于不锈钢加工，凭借高韧性的基体以及全新的 PVD 涂层技术，实现了最佳的可靠性，同样能够覆盖部分钢和难加工材料的铣削。
	P35		◐								■			
	S35					◐					■			
APM35E/B	M35	PVD		●							■			适用于不锈钢加工，凭借高韧性的基体以及通用的 PVD 涂层技术，实现了良好的稳定性，同样能够覆盖部分钢和难加工材料的铣削。
	P35		◐								■			
	S35					◐					■			

合金刀片类

系列			M1145-OD05	M1145-ON05	M1145-SN12	M1188-SN12	M2190-LN09	M9190-LN09	M2190-LN13	M9190-LN13
										
页码			P.376	P.378	P.380	P.382	P.384	P.386	P.388	P.390
主偏角			43°	42°	45°	88°	90°	90°	90°	90°
最大切深			3.0	3.0	6.0	10.0	8.0	32~48	12.0	32~54
直径范围			42~125	50~125	50~160	50~160	25~63	25~40	40~125	40~80
刀片										
			OD0504	ON0504	SN12T5	SN12T5	LN0904	LN0904	LN1306	LN1306
应用	面铣		√	√	√	√	√	√	√	√
	方肩铣					√	√	√	√	√
	槽铣						√	√	√	√
	坡铣		√				√	√		
	螺旋插补铣		√				√	√		
	插铣									
	仿形铣									
	倒角铣				√					
	型腔铣		√				√	√		

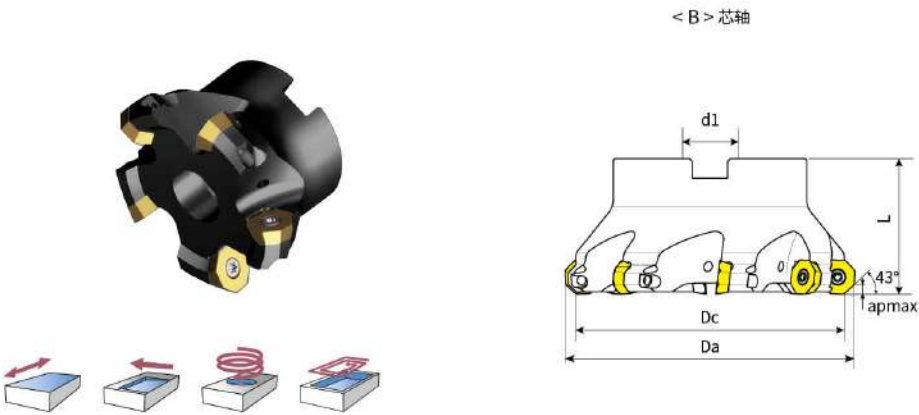
合金刀片类

系列			M2290-WN08	M2290-SO09	M2290-SO12	M3215-SO09	M3215-SO12	M7145-SO09	M7145-SO12
									
页码			P.392	P.394	P.396	P.398	P.400	P.402	P.404
主偏角			90°	90°	90°	12.5°	12.5°	45°	45
最大切深			7.5	7.5	10.0	1.0	1.5	5.0	7.5
直径范围			50~160	32~80	40~125	32~63	32~80	12~32	25~40
刀片									
			WN0806	SO09T3	SO1204	SO09T3	SO1204	SO09T3	SO1204
应用	面铣		√	√	√	√	√		
	方肩铣		√	√	√				
	槽铣		√	√	√				
	坡铣					√	√		
	螺旋插补铣					√	√		
	插铣					√	√		
	仿形铣					√	√		
	倒角铣							√	√
	型腔铣					√	√		

A
B
C
D
E
F
G
H

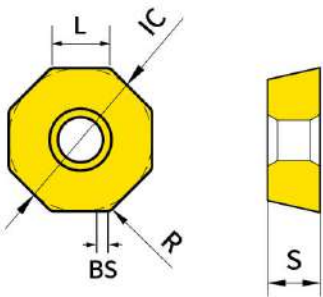
43°主偏角面铣刀

M1145-OD05 Series



单位: mm

Series B	型号 Type	Dc	Da	d1	L	apmax	内冷	Z
OD** 0504	M1145-OD05-D050-B16-Z4-C	42	50	16	40	3.0	有	4
	M1145-OD05-D058-B16-Z4-C	50	58	16	40	3.0	有	4
	M1145-OD05-D063-B22-Z5-C	55	63	22	40	3.0	有	5
	M1145-OD05-D071-B22-Z6-C	63	71	22	40	3.0	有	6
	M1145-OD05-D080-B27-Z6-C	72	80	27	50	3.0	有	6
	M1145-OD05-D088-B27-Z7-C	80	88	27	50	3.0	有	7
	M1145-OD05-D100-B32-Z8-C	92	100	32	50	3.0	有	8
	M1145-OD05-D108-B32-Z8-C	100	108	32	50	3.0	有	8
	M1145-OD05-D125-B40-Z10-C	117	125	40	63	3.0	有	10
	M1145-OD05-D133-B40-Z10-C	125	133	40	63	3.0	有	10



	IC	L	S
OD**0504**	12.7	5.26	4.76

Series	型号 Type	R	BS	P			M				K					S	
				APU2SE	ACP3SE	APP4SE	APM2SC	APM2SE	APM3SC	APP4SE	ACK1SE	APK1SE	ACK2SE	APM2SC	ACK3SE	APS2SC	APS3SC
-M5	ODET050408-M5	0.8	-	●			●	◎						●		◎	
	ODET0504ZZN-M5	0.8	1.2	●			●	●						●		●	

● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1071
	刀片螺丝刀	AF2031

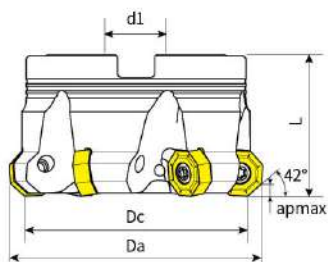
A
B
C
D
E
F
G
H

42°主偏角面铣刀

M1145-ON05 Series

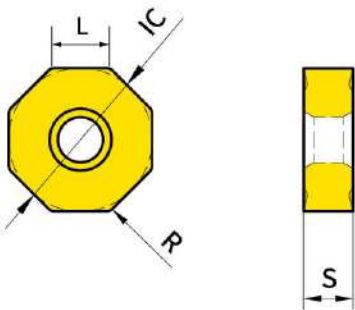


< B > 芯轴



单位: mm

Series B	型号 Type	Dc	Da	d1	L	apmax	内冷	Z
ON** 0504	M1145-ON05-D050-B22-Z5-C	50	56.2	22	40	3.0	有	5
	M1145-ON05-D050-B22-Z6-C	50	56.2	22	40	3.0	有	6
	M1145-ON05-D063-B22-Z6-C	63	69.2	22	40	3.0	有	6
	M1145-ON05-D063-B22-Z8-C	63	69.2	22	40	3.0	有	8
	M1145-ON05-D080-B27-Z6-C	80	86.2	27	50	3.0	有	6
	M1145-ON05-D080-B27-Z9-C	80	86.2	27	50	3.0	有	9
	M1145-ON05-D100-B32-Z8-C	100	106.2	32	50	3.0	有	8
	M1145-ON05-D100-B32-Z10-C	100	106.2	32	50	3.0	有	10
	M1145-ON05-D125-B40-Z9-C	125	131.2	40	63	3.0	有	9
	M1145-ON05-D125-B40-Z12-C	125	131.2	40	63	3.0	有	12



	IC	L	S
ON**0504**	12.7	5.26	4.76

Series	型号 Type	R	BS						M				K					S	
				APU25E	APP25B	APP35E	APP45E	APM25C	APM25E	APM25B	APM35E	APP45E	ACK15E	APK15E	APM25C	APK25B	APK35E	APS25C	APS35C
-M5	ONMU050408-M5	0.8	-	●			◎	●	●			◎	◎	●	●			●	
	ONEU050408ZNN-M5	0.8	1.6		●	◎				●	◎					●	◎		

● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1032
	刀片螺丝刀	AF2062

A

B

C

D

E

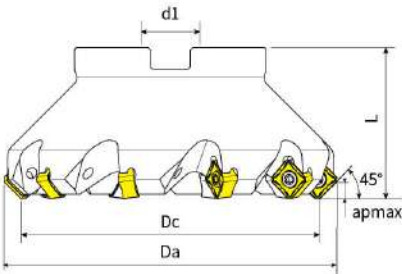
F

G

H

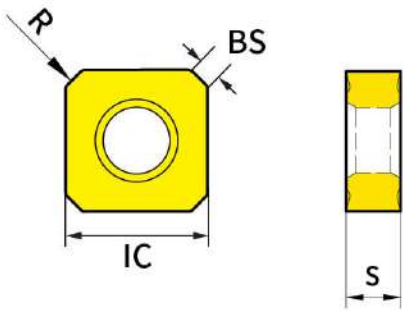


< B > 芯轴



单位: mm

Series B	型号 Type	Dc	Da	d1	L	apmax	内冷	Z
SN** 12T5	M1145-SN12-D050-B22-Z04-C	50	63.9	22	40	6.0	有	4
	M1145-SN12-D050-B22-Z06-C	50	63.9	22	40	6.0	有	6
	M1145-SN12-D063-B22-Z05-C	63	76.9	22	40	6.0	有	5
	M1145-SN12-D063-B22-Z07-C	63	76.9	22	40	6.0	有	7
	M1145-SN12-D080-B27-Z06-C	80	93.9	27	50	6.0	有	6
	M1145-SN12-D080-B27-Z08-C	80	93.9	27	50	6.0	有	8
	M1145-SN12-D100-B32-Z08-C	100	113.9	32	50	6.0	有	8
	M1145-SN12-D100-B32-Z10-C	100	113.9	32	50	6.0	有	10
	M1145-SN12-D125-B40-Z10-C	125	138.9	40	63	6.0	有	10
	M1145-SN12-D125-B40-Z12-C	125	138.9	40	63	6.0	有	12
	M1145-SN12-D160-B40-Z12	160	173.9	40	63	6.0	无	12
	M1145-SN12-D160-B40-Z15	160	173.9	40	63	6.0	无	15



	IC	S
SN**12T5**	12.7	5.95

Series	型号 Type	R	BS	P			M				K					S	
				APU2SE	ACP3SE	APP4SE	APM2SC	APM2SE	APM3SC	APP4SE	ACK1SE	APK1SE	ACK2SE	APM2SC	ACK3SE	APS2SC	APS3SC
-M5	SNMX12T512-M5	1.2	-	●	●		●	●					●	●	●		
-M5	SNMX12T5ANN-M5	-	1.5	●			●	●			◎	●		●	◎		

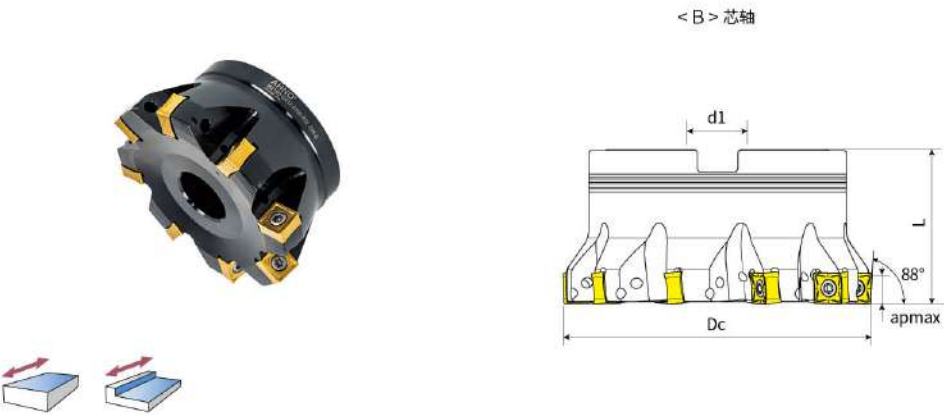
● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1021
	刀片螺丝刀	AF2072

A
B
C
D
E
F
G
H

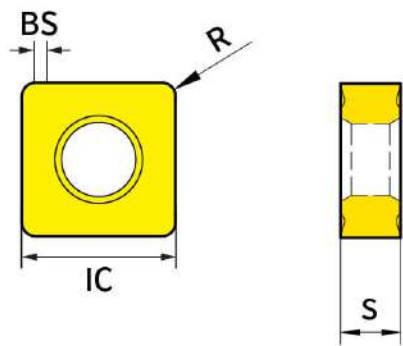
88°主偏角面铣刀

M1188-SN12 Series



单位: mm

Series B	型号 Type	Dc	d1	L	apmax	内冷	Z
SN** 12T5	M1188-SN12-D050-B22-Z04-C	50	22	40	10.0	有	4
	M1188-SN12-D063-B22-Z05-C	63	22	40	10.0	有	5
	M1188-SN12-D063-B22-Z06-C	63	22	40	10.0	有	6
	M1188-SN12-D080-B27-Z06-C	80	27	50	10.0	有	6
	M1188-SN12-D080-B27-Z07-C	80	27	50	10.0	有	7
	M1188-SN12-D100-B32-Z08-C	100	32	50	10.0	有	8
	M1188-SN12-D100-B32-Z10-C	100	32	50	10.0	有	10
	M1188-SN12-D125-B40-Z10-C	125	40	63	10.0	有	10
	M1188-SN12-D125-B40-Z12-C	125	40	63	10.0	有	12
	M1188-SN12-D160-B40-Z12	160	40	63	10.0	无	12
	M1188-SN12-D160-B40-Z14	160	40	63	10.0	无	14

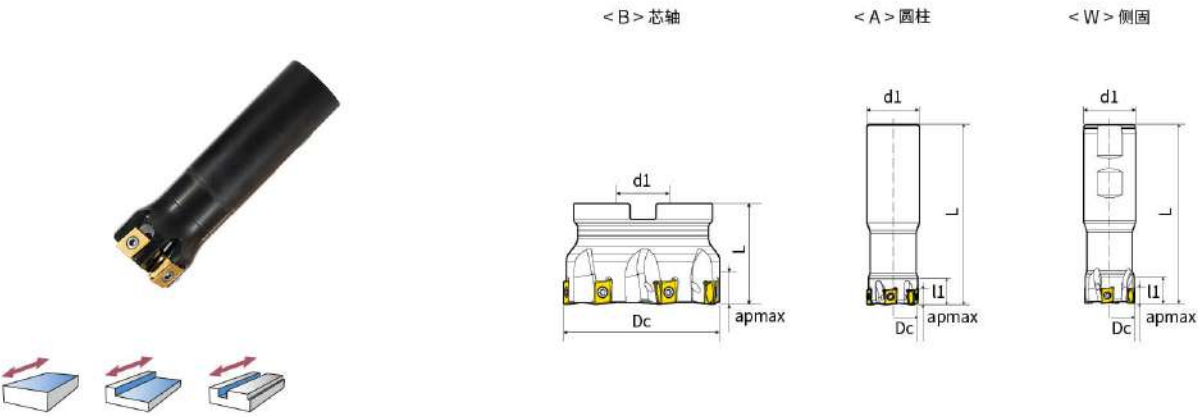


	IC	S
SN**12T5**	12.7	5.95

Series	型号 Type	R	BS	P			M				K					S	
				APU2SE	ACP3SE	APP4SE	APM2SC	APM2SE	APM3SC	APP4SE	ACK1SE	APK1SE	ACK2SE	APM2SC	ACK3SE	APS2SC	APS3SC
-M5	SNMX12T512-M5	1.2	-	●	●		●	●					●	●	●		
-M5	SNMX12T5ZNN-M5	0.8	1.2	●			●	●			◎	●		●	◎		

● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1021
	刀片螺丝刀	AF2072



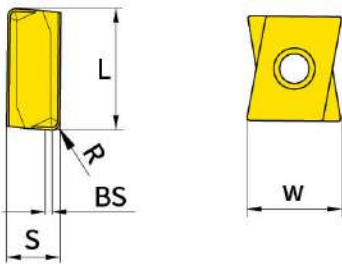
单位: mm

Series A	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
LN** 0904	M2190-LN09-D025-A25-Z3-C	25	25	150	40	8	有	3
	M2190-LN09-D025-A25-Z4-C	25	25	150	40	8	有	4
	M2190-LN09-D032-A32-Z4-C	32	32	200	50	8	有	4
	M2190-LN09-D032-A32-Z5-C	32	32	200	50	8	有	5

Series W	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
LN** 0904	M2190-LN09-D025-W25-Z3-C	25	25	100	43	8	有	3
	M2190-LN09-D025-W25-Z4-C	25	25	100	43	8	有	4
	M2190-LN09-D032-W32-Z4-C	32	32	110	50	8	有	4
	M2190-LN09-D032-W32-Z5-C	32	32	110	50	8	有	5

Series B	型号 Type	Dc	d1	L	apmax	内冷	Z	
LN** 0904	M2190-LN09-D040-B16-Z4-C	40	16	40	8	有	4	
	M2190-LN09-D040-B16-Z6-C	40	16	40	8	有	6	
	M2190-LN09-D050-B22-Z5-C	50	22	40	8	有	5	
	M2190-LN09-D050-B22-Z7-C	50	22	40	8	有	7	
	M2190-LN09-D063-B22-Z7-C	63	22	40	8	有	7	
	M2190-LN09-D063-B22-Z10-C	63	22	40	8	有	10	

	L	W	S
LN**0904**	9	8.5	4.5

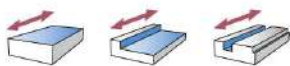
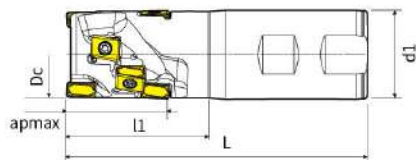


Series	型号 Type	R	BS	P			M				K					S	
				APU25C	ACP35E	APP45E	APM25C	APM25E	APM35C	APP45E	ACK15E	APK15E	ACK25E	APM25C	ACK35E	APS25C	APS35C
-M5	LNHU090408R-M5	0.8	1.0	●		◎	●	◎		◎		●		●		●	

● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1082
	刀片螺丝刀	AF2082

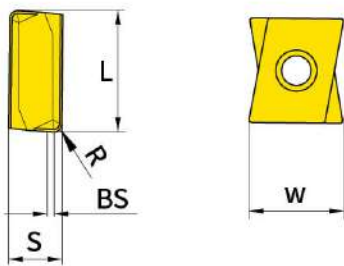
< W > 侧固



单位: mm

Series W	型号 Type	Dc	d1	L	l1	apmax	内冷	Z	刀片数量
LN** 0904	M9190-LN09-D25-W25-Z2-L32-C	25	25	100	45	32	有	2	8
	M9190-LN09-D32-W32-Z2-L40-C	32	32	110	50	40	有	2	10
	M9190-LN09-D40-W40-Z3-L48-C	40	40	130	60	48	有	3	18

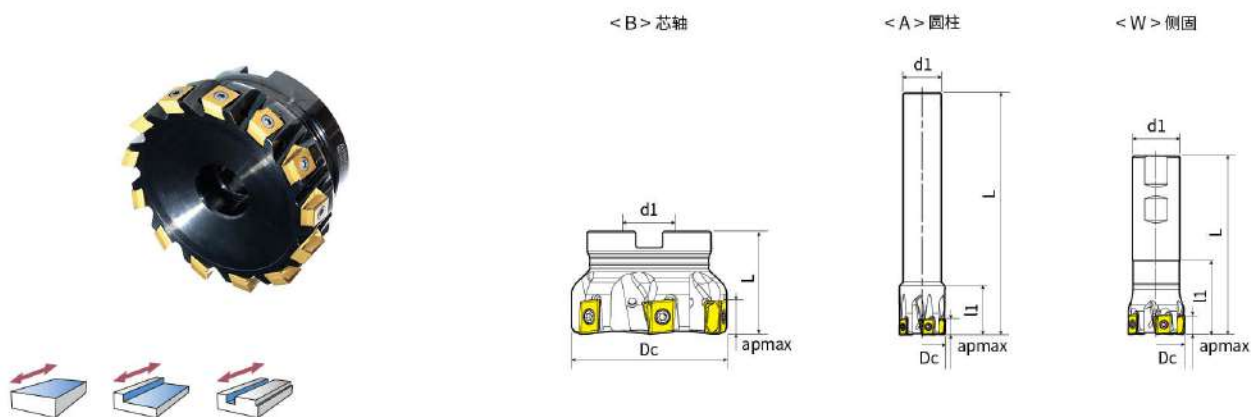
	L	W	S
LN**0904**	9	8.5	4.5



Series	型号 Type	R	BS	P			M				K					S	
				APU25C	ACP35E	APP45E	APM25C	APM25E	APM35C	APP45E	ACK15E	APK15E	ACK25E	APM25C	ACK35E	APS25C	APS35C
-M5	LNHU090408PER-M5	0.8	1.0	●		◎	●	◎		◎		●		●		●	

● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1101
	刀片螺丝刀	AF2062



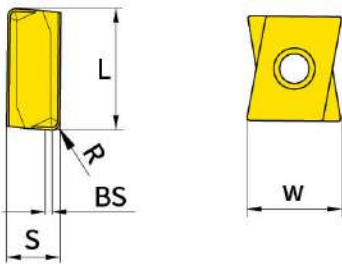
单位: mm

Series A	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
LN** 1306	M2190-LN13-D040-A32-Z5-C	40	32	200	44	12	有	5

Series W	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
LN** 1306	M2190-LN13-D040-W32-Z5-C	40	32	120	50	12	有	5

Series B	型号 Type	Dc	d1	L	apmax	内冷	Z
LN** 1306	M2190-LN13-D040-B16-Z4-C	40	16	40	12	有	4
	M2190-LN13-D040-B16-Z5-C	40	16	40	12	有	5
	M2190-LN13-D050-B22-Z5-C	50	22	40	12	有	5
	M2190-LN13-D050-B22-Z6-C	50	22	40	12	有	6
	M2190-LN13-D063-B22-Z6-C	63	22	40	12	有	6
	M2190-LN13-D063-B22-Z8-C	63	22	40	12	有	8
	M2190-LN13-D080-B27-Z7-C	80	27	50	12	有	7
	M2190-LN13-D080-B27-Z10-C	80	27	50	12	有	10
	M2190-LN13-D100-B32-Z9-C	100	32	50	12	有	9
	M2190-LN13-D100-B32-Z13-C	100	32	50	12	有	13
	M2190-LN13-D125-B40-Z11-C	125	40	63	12	有	11
	M2190-LN13-D125-B40-Z16-C	125	40	63	12	有	16

	L	W	S
LN**1306**	13	12	6.8



Series	型号 Type	R	BS	P			M				K					S	
				APU25C	ACP35E	APP45E	APM25C	APM25E	APM35C	APP45E	ACK15E	APK15E	ACK25E	APM25C	ACK35E	APS25C	APS35C
-M5	LNHU130608PER-M5	0.8	2.25	●		◎	●	●		◎		●		●		●	

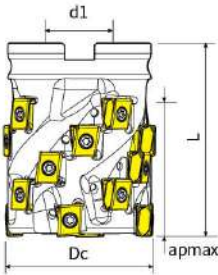


● 常备库存 ◎ 可选库存

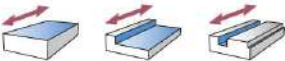
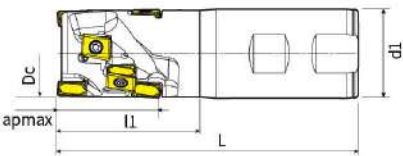
配件		
	刀片安装螺丝	AF1101
	刀片螺丝刀	AF2062



< B > 芯轴



< W > 侧图

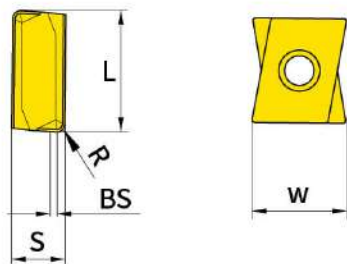


单位: mm

Series W	型号 Type	Dc	d1	L	l1	apmax	内冷	Z	刀片数量
LN** 1306	M9190-LN13-D040-W40-Z2-L34-C	40	40	120	54	32	有	2	6
	M9190-LN13-D040-W40-Z2-L45-C	40	40	135	64	45	有	2	8

Series B	型号 Type	Dc	d1	L	l1	apmax	内冷	Z	刀片数量
LN** 1306	M9190-LN13-D040-B16-Z2-L34-C	40	16	55	-	32	有	2	6
	M9190-LN13-D040-B16-Z2-L45-C	40	16	65	-	45	有	2	8
	M9190-LN13-D050-B22-Z3-L34-C	50	22	55	-	32	有	3	9
	M9190-LN13-D050-B22-Z3-L45-C	50	22	65	-	45	有	3	12
	M9190-LN13-D063-B27-Z4-L45-C	63	27	70	-	45	有	4	16
	M9190-LN13-D063-B27-Z4-L56-C	63	27	80	-	54	有	4	20
	M9190-LN13-D080-B32-Z5-L56-C	80	32	85	-	54	有	5	25

	L	W	S
LN**1306**	13	12	6.8



Series	型号 Type	R	BS	P			M				K					S	
				APU25C	ACP35E	APP45E	APM25C	APM25E	APM35C	APP45E	ACK15E	APK15E	ACK25E	APM25C	ACK35E	APS25C	APS35C
-M5	LNHU130608PER-M5	0.8	2.25	●		◎	●	●		◎		●		●		●	

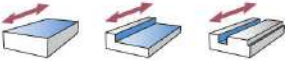
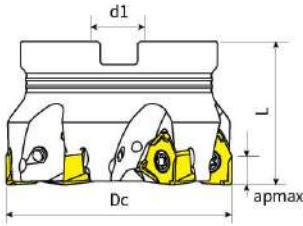


● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1101
	刀片螺丝刀	AF2062



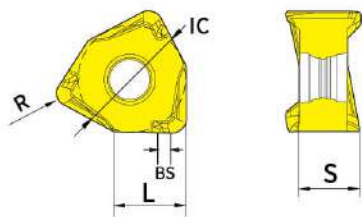
< B > 芯轴



单位: mm

Series B	型号 Type	Dc	d1	L	apmax	内冷	Z
WN*X 0806	M2290-WN08-D050-B22-Z4-C	50	22	50	7.5	有	4
	M2290-WN08-D050-B22-Z5-C	50	22	50	7.5	有	5
	M2290-WN08-D063-B22-Z5-C	63	22	50	7.5	有	5
	M2290-WN08-D063-B22-Z6-C	63	22	50	7.5	有	6
	M2290-WN08-D080-B27-Z7-C	80	27	50	7.5	有	7
	M2290-WN08-D080-B27-Z8-C	80	27	50	7.5	有	8
	M2290-WN08-D100-B32-Z8-C	100	32	50	7.5	有	8
	M2290-WN08-D100-B32-Z10-C	100	32	50	7.5	有	10
	M2290-WN08-D125-B40-Z10-C	125	40	63	7.5	有	10
	M2290-WN08-D125-B40-Z12-C	125	40	63	7.5	有	12
	M2290-WN08-D160-B40-Z12	160	40	63	7.5	无	12
	M2290-WN08-D160-B40-Z15	160	40	63	7.5	无	15

	IC	L	S
WN**0806**	12.48	7.5	6.45



Series	型号 Type	R	BS	P			M				K					S	
				APU2SE	ACP3SE	APP4SE	APM2SC	APM2SE	APM3SC	APP4SE	ACK1SE	APK1SE	ACK2SE	APM2SC	ACK3SE	APS2SC	APS3SC
-F7	WNGX080608R-F7	0.8	1.4				●	◎				●		●		◎	
-M4	WNEX080608R-M4	0.8	1.4				●	●	◎					●		●	
-M5	WNEX080608R-M5	0.8	1.4	●		◎	●	●		◎		●		●	◎		
-R5	WNEX080608R-R5	0.8	1.4	●	●						●	◎	●		◎		

● 常备库存 ◎ 可选库存

配件



刀片安装螺丝

AF1052

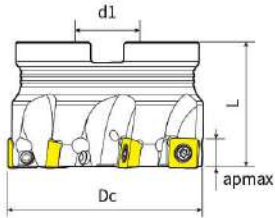


刀片螺丝刀

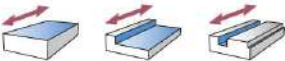
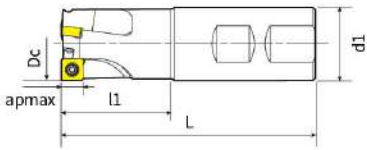
AF2031



< B > 芯轴



< W > 侧固

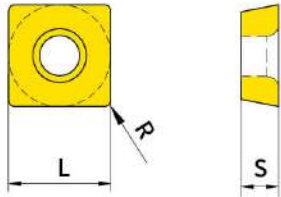


单位: mm

Series W	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
SO** 09T3	M2290-SO09-D032-W32-Z3-C	32	32	110	49	7.5	有	3
	M2290-SO09-D032-W32-Z4-C	32	32	110	49	7.5	有	4
	M2290-SO09-D040-W40-Z4-C	40	40	125	49	7.5	有	4
	M2290-SO09-D040-W40-Z5-C	40	40	125	49	7.5	有	5

Series B	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
SO** 09T3	M2290-SO09-D040-B16-Z4-C	40	16	40	-	7.5	有	4
	M2290-SO09-D040-B16-Z5-C	40	16	40	-	7.5	有	5
	M2290-SO09-D050-B22-Z5-C	50	22	40	-	7.5	有	5
	M2290-SO09-D050-B22-Z6-C	50	22	40	-	7.5	有	6
	M2290-SO09-D063-B22-Z6-C	63	22	40	-	7.5	有	6
	M2290-SO09-D063-B22-Z8-C	63	22	40	-	7.5	有	8
	M2290-SO09-D080-B27-Z6-C	80	27	50	-	7.5	有	6
	M2290-SO09-D080-B27-Z9-C	80	27	50	-	7.5	有	9

	L	S
SO**09T3	9.52	3.97



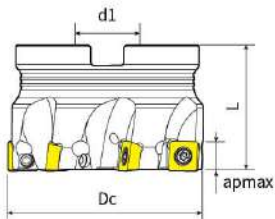
				P			M				K				S			
Series		型号 Type	R	BS	APU2SE	ACP3SE	APP4SE	APM2SC	APM2SE	APM3SC	APP4SE	ACK1SE	APK1SE	ACK2SE	APM2SC	ACK3SE	APS2SC	APS3SC
-M5		SOMT09T308-M5	0.8	-	●		◎	●	●		◎				●		◎	
		SOMT09T320-M5	2.0	-	◎		●		◎	●	●						◎	●
-M7		SOMT09T308-M7	0.8	-	●		◎				◎				●	◎		

● 常备库存 ◎ 可选库存

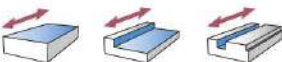
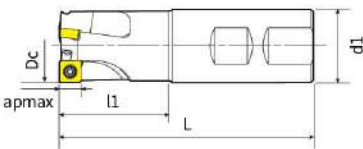
配件		
	刀片安装螺丝	AF1071
	刀片螺丝刀	AF2031



< B > 芯轴



< W > 侧固

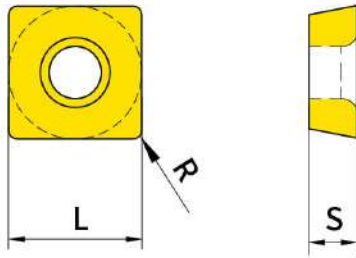


单位: mm

Series W	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
SO** 1204	M2290-SO12-D040-W40-Z3-C	40	40	125	49	10.0	有	3
	M2290-SO12-D040-W40-Z4-C	40	40	125	49	10.0	有	4

Series B	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
SO** 1204	M2290-SO12-D050-B22-Z4-C	50	22	40	-	10.0	有	4
	M2290-SO12-D050-B22-Z5-C	50	22	40	-	10.0	有	5
	M2290-SO12-D063-B22-Z5-C	63	22	40	-	10.0	有	5
	M2290-SO12-D063-B22-Z6-C	63	22	40	-	10.0	有	6
	M2290-SO12-D080-B27-Z6-C	80	27	50	-	10.0	有	6
	M2290-SO12-D080-B27-Z8-C	80	27	50	-	10.0	有	8
	M2290-SO12-D100-B32-Z8-C	100	32	50	-	10.0	有	8
	M2290-SO12-D100-B32-Z10-C	100	32	50	-	10.0	有	10
	M2290-SO12-D125-B40-Z9-C	125	40	63	-	10.0	有	9
	M2290-SO12-D125-B40-Z12-C	125	40	63	-	10.0	有	12

	L	S
SO**1204	12.7	4.76



Series	型号 Type	R	BS	P			M				K					S	
				APU2SE	ACP3SE	APP4SE	APM2SC	APM2SE	APM3SC	APP4SE	ACK1SE	ACK1SE	ACK2SE	APM2SC	ACK3SE	APS2SC	APS3SC
-M5	SOMT120408-M5	0.8	-	●		◎	●	●		◎				●		◎	
	SOMT120425-M5	2.5	-	◎		●		◎	●	●					◎	◎	●
-M7	SOMT120408-M7	0.8	-	●		◎				◎				●	◎		

● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1032
	刀片螺丝刀	AF2062

A

B

C

D

E

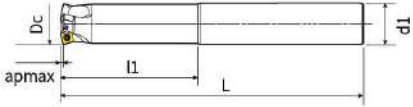
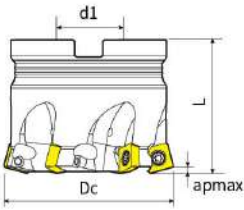
F

G

H

< B > 芯轴

< A > 圆柱

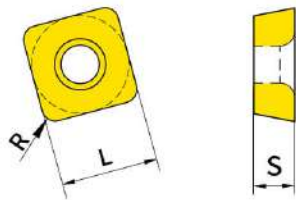


单位: mm

Series A	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
SO** 09T3	M3215-SO09-D032-A32-Z4-C	32	32	200	90	1.0	有	4
	M3215-SO09-D035-A32-Z4-C	35	32	200	-	1.0	有	4
	M3215-SO09-D040-A32-Z5-C	40	32	200	100	1.0	有	5

Series B	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
SO** 09T3	M3215-SO09-D040-B16-Z5-C	40	16	40	-	1.0	有	5
	M3215-SO09-D050-B22-Z6-C	50	22	40	-	1.0	有	6
	M3215-SO09-D063-B22-Z7-C	63	22	50	-	1.0	有	7

	L	S
SO**09T3	9.52	3.97



							M				K				S			
Series		型号 Type	R	BS	APU2SE	ACP3SE	APP4SE	APM2SC	APM2SE	APM3SC	APP4SE	ACK1SE	APK1SE	ACK2SE	APM2SC	ACK3SE	APS2SC	APS3SC
-M5		SOMT09T308-M5	0.8	-	●		◎	●	●		◎				●		◎	
		SOMT09T320-M5	2.0	-	◎		●		◎	●	●						◎	●
-M7		SOMT09T308-M7	0.8	-	●		◎				◎				●	◎		

● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1091
	刀片螺丝刀	AF2091

A

B

C

D

E

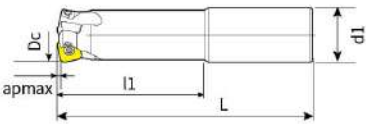
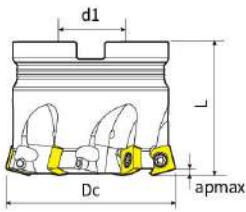
F

G

H

< B > 芯轴

< A > 圆柱

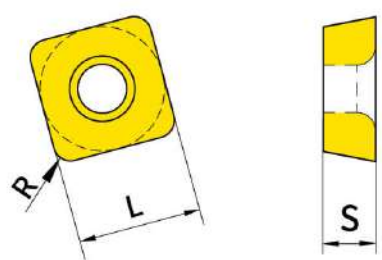


单位: mm

Series A	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
SO** 1204	M3215-SO12-D032-A32-Z3-C	32	32	150	89	1.5	有	3
	M3215-SO12-D040-A32-Z4-C	40	32	175	114	1.5	有	4

Series B	型号 Type	Dc	d1	L	l1	apmax	内冷	Z
SO** 1204	M3215-SO12-D050-B22-Z5-C	50	22	40	-	1.5	有	5
	M3215-SO12-D063-B22-Z6-C	63	22	50	-	1.5	有	6
	M3215-SO12-D080-B27-Z8-C	80	27	50	-	1.5	有	8

	L	S
SO**1204	12.7	4.76



							M				K				S			
Series	型号 Type	R	BS	APU2SE	ACP3SE	APP4SE	APM2SC	APM2SE	APM3SC	APP4SE	ACK1SE	APP1SE	ACK2SE	APM2SC	ACK3SE	APS2SC	APS3SC	
-M5		SOMT120408-M5	0.8	-	●		◎	●	●		◎				●		◎	
		SOMT120425-M5	2.5	-	◎		●		◎	●	●					◎	◎	●
-M7		SOMT120408-M7	0.8	-	●		◎				◎				●	◎		

● 常备库存 ◎ 可选库存

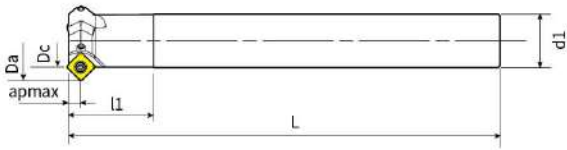
配件		
	刀片安装螺丝	AF1032
	刀片螺丝刀	AF2062

A
B
C
D
E
F
G
H

45°正反倒角铣刀

M7145-S009 Series

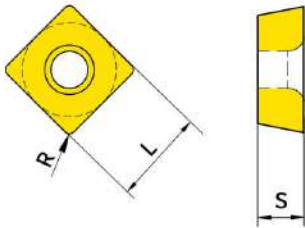
< A > 圆柱



单位: mm

Series A	型号 Type	Dc	Da	d1	L	l1	apmax	内冷	Z
SO** 09T3	M7145-SO09-D012-A16-Z1-C	12	24.8	16	160	40	5.0	有	1
	M7145-SO09-D016-A16-Z2-C	16	28.8	16	160	40	5.0	有	2
	M7145-SO09-D020-A20-Z2-C	20	32.8	20	200	40	5.0	有	2
	M7145-SO09-D025-A25-Z3-C	25	37.8	25	200	40	5.0	有	3
	M7145-SO09-D032-A32-Z3-C	32	44.8	32	250	40	5.0	有	3

	L	S
SO**09T3	9.52	3.97



							M				K				S			
Series		型号 Type	R	BS	APU2SE	ACP3SE	APP4SE	APM2SC	APM2SE	APM3SC	APP4SE	ACK1SE	APK1SE	ACK2SE	APM2SC	ACK3SE	APS2SC	APS3SC
-M5		SOMT09T308-M5	0.8	-	●		◎	●	●		◎				●		◎	
-M7		SOMT09T308-M7	0.8	-	●		◎				◎				●	◎		

● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1091
	刀片螺丝刀	AF2091

A

B

C

D

E

F

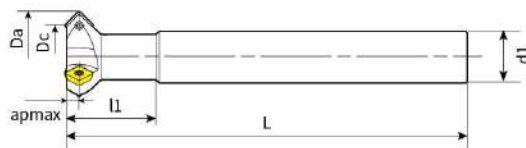
G

H

45°正反倒角铣刀

M7145-S012 Series

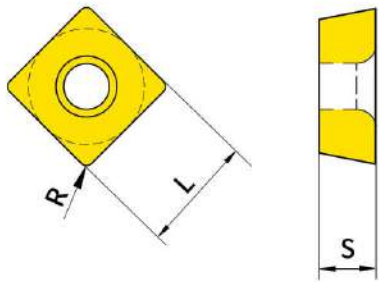
<A> 圆柱



单位: mm

Series A	型号 Type	Dc	Da	d1	L	l1	apmax	内冷	Z
SO** 1204	M7145-S012-D025-A25-Z02-C	25	41.6	25	200	40	7.5	有	2
	M7145-S012-D032-A32-Z03-C	32	48.6	32	250	40	7.5	有	3
	M7145-S012-D040-A32-Z03-C	40	56.6	32	250	40	7.5	有	3

	L	S
SO**1204	12.7	4.76



				P			M				K				S			
Series		型号 Type	R	BS	APU2SE	ACP3SE	APP4SE	APM2SC	APM2SE	APM3SC	APP4SE	ACK1SE	APK1SE	ACK2SE	APM2SC	ACK3SE	APS2SC	APS3SC
-M5		SOMT120408-M5	0.8	-	●		◎	●	●		◎				●		◎	
-M7		SOMT120408-M7	0.8	-	●		◎				◎				●	◎		

● 常备库存 ◎ 可选库存

配件		
	刀片安装螺丝	AF1032
	刀片螺丝刀	AF2062

M1145-OD05 Series

进给参数				ap(mm)		fz(mm/z)	
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ap		M5	
				Min	Max	Min	Max
P	非合金钢	430	125	0.5	3.0	0.12	0.32
		640-1010	190-300	0.5	3.0	0.1	0.3
	低合金钢	700-950	200-280	0.5	3.0	0.1	0.3
	高合金钢	950-1200	280-355	0.5	3.0	0.08	0.24
		1200-1400	355-415	0.5	3.0	0.08	0.24
M	双相不锈钢	780	230	0.5	3.0	0.08	0.24
	奥氏体不锈钢	680	200	0.5	3.0	0.08	0.24
	沉淀硬化不锈钢	1010	300	0.5	3.0	0.06	0.2
K	灰口铸铁	200-350	180-245	0.5	3.0	0.15	0.32
	球墨铸铁	400-700	155-265	0.5	3.0	0.12	0.3
	蠕墨铸铁	400	230	0.5	3.0	0.1	0.24
S	镍基 / 钴基合金	840-1180	250-350	0.5	3.0	0.05	0.15
	钛合金	1260-1400	375-410	0.5	3.0	0.05	0.15
N	铝合金	260-450	75-130				
H	淬硬钢	-	HRC50-60				
	淬硬铸铁	-	HRC55				

M1145-ON05 Series

进给参数				ap(mm)		fz(mm/z)	
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ap		M5	
				Min	Max	Min	Max
P	非合金钢	430	125	0.5	3.0	0.15	0.36
		640-1010	190-300	0.5	3.0	0.12	0.32
	低合金钢	700-950	200-280	0.5	3.0	0.12	0.32
	高合金钢	950-1200	280-355	0.5	3.0	0.1	0.3
		1200-1400	355-415	0.5	3.0	0.1	0.3
M	双相不锈钢	780	230	0.5	3.0	0.1	0.3
	奥氏体不锈钢	680	200	0.5	3.0	0.1	0.3
	沉淀硬化不锈钢	1010	300	0.5	3.0	0.08	0.25
K	灰口铸铁	200-350	180-245	0.5	3.0	0.16	0.4
	球墨铸铁	400-700	155-265	0.5	3.0	0.15	0.36
	蠕墨铸铁	400	230	0.5	3.0	0.12	0.32
S	镍基 / 钴基合金	840-1180	250-350	0.5	3.0	0.06	0.2
	钛合金	1260-1400	375-410	0.5	3.0	0.06	0.2
N	铝合金	260-450	75-130				
H	淬硬钢	-	HRC50-60				
	淬硬铸铁	-	HRC55				

M1145-SN12 Series

进给参数				ap(mm)		fz(mm/z)	
ISO	材料组	抗拉强度 (N/mm ²)	布氏硬度 (HB)	ap		M5	
				Min	Max	Min	Max
P	非合金钢	430	125	0.5	6.0	0.16	0.4
		640-1010	190-300	0.5	6.0	0.15	0.36
	低合金钢	700-950	200-280	0.5	6.0	0.15	0.36
		950-1200	280-355	0.5	6.0	0.12	0.32
		1200-1400	355-415	0.5	6.0	0.12	0.32
M	双相不锈钢	780	230				
	奥氏体不锈钢	680	200				
	沉淀硬化不锈钢	1010	300				
K	灰口铸铁	200-350	180-245	0.5	6.0	0.18	0.45
	球墨铸铁	400-700	155-265	0.5	6.0	0.16	0.4
	蠕墨铸铁	400	230	0.5	6.0	0.15	0.36
S	镍基 / 钴基合金	840-1180	250-350				
	钛合金	1260-1400	375-410				
N	铝合金	260-450	75-130				
H	淬硬钢	-	HRC50-60				
	淬硬铸铁	-	HRC55				

M1188-SN12 Series

进给参数				ap(mm)		fz(mm/z)	
ISO	材料组	抗拉强度 (N/mm ²)	布氏硬度 (HB)	ap		M5	
				Min	Max	Min	Max
P	非合金钢	430	125	0.5	10.0	0.16	0.36
		640-1010	190-300	0.5	10.0	0.15	0.32
	低合金钢	700-950	200-280	0.5	10.0	0.15	0.32
		950-1200	280-355	0.5	10.0	0.12	0.3
		1200-1400	355-415	0.5	10.0	0.12	0.3
M	双相不锈钢	780	230			0.12	0.24
	奥氏体不锈钢	680	200			0.12	0.24
	沉淀硬化不锈钢	1010	300			0.1	0.2
K	灰口铸铁	200-350	180-245	0.5	10.0	0.18	0.4
	球墨铸铁	400-700	155-265	0.5	10.0	0.16	0.36
	蠕墨铸铁	400	230	0.5	10.0	0.15	0.32
S	镍基 / 钴基合金	840-1180	250-350				
	钛合金	1260-1400	375-410				
N	铝合金	260-450	75-130				
H	淬硬钢	-	HRC50-60				
	淬硬铸铁	-	HRC55				

M2190-LN09 Series

进给参数				ap(mm)		fz(mm/z)	
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ap		M5	
				Min	Max	Min	Max
P	非合金钢	430	125	0.5	12.0	0.16	0.32
		640-1010	190-300	0.5	12.0	0.12	0.24
	低合金钢	700-950	200-280	0.5	12.0	0.12	0.24
	高合金钢	950-1200	280-355	0.5	12.0	0.1	0.2
		1200-1400	355-415	0.5	12.0	0.1	0.2
M	双相不锈钢	780	230	0.5	12.0	0.08	0.16
	奥氏体不锈钢	680	200	0.5	12.0	0.08	0.18
	沉淀硬化不锈钢	1010	300	0.5	12.0	0.06	0.12
K	灰口铸铁	200-350	180-245	0.5	12.0	0.18	0.36
	球墨铸铁	400-700	155-265	0.5	12.0	0.16	0.32
	蠕墨铸铁	400	230	0.5	12.0	0.12	0.24
S	镍基 / 钴基合金	840-1180	250-350	0.5	12.0	0.05	0.1
	钛合金	1260-1400	375-410	0.5	12.0	0.05	0.1
N	铝合金	260-450	75-130	0.5	12.0	0.05	0.2
H	淬硬钢	-	HRC50-60				
	淬硬铸铁	-	HRC55				

M9190-LN09 Series

进给参数				ap(mm)		fz(mm/z)	
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ap		M5	
				Min	Max	Min	Max
P	非合金钢	430	125	0.5	32-54	0.12	0.2
		640-1010	190-300	0.5	32-54	0.1	0.16
	低合金钢	700-950	200-280	0.5	32-54	0.1	0.16
	高合金钢	950-1200	280-355	0.5	32-54	0.08	0.15
		1200-1400	355-415	0.5	32-54	0.08	0.15
M	双相不锈钢	780	230	0.5	32-54	0.05	0.12
	奥氏体不锈钢	680	200	0.5	32-54	0.06	0.15
	沉淀硬化不锈钢	1010	300	0.5	32-54	0.04	0.1
K	灰口铸铁	200-350	180-245	0.5	32-54	0.15	0.25
	球墨铸铁	400-700	155-265	0.5	32-54	0.12	0.2
	蠕墨铸铁	400	230	0.5	32-54	0.1	0.16
S	镍基 / 钴基合金	840-1180	250-350	0.5	32-54	0.03	0.08
	钛合金	1260-1400	375-410	0.5	32-54	0.03	0.08
N	铝合金	260-450	75-130				
H	淬硬钢	-	HRC50-60				
	淬硬铸铁	-	HRC55				

A

B

C

D

E

F

G

H

M2190-LN13 Series

进给参数				ap(mm)		fz(mm/z)	
ISO	材料组	抗拉强度 (N/mm ²)	布氏硬度 (HB)	ap		M5	
				Min	Max	Min	Max
P	非合金钢	430	125	0.5	12.0	0.16	0.32
		640-1010	190-300	0.5	12.0	0.12	0.24
	低合金钢	700-950	200-280	0.5	12.0	0.12	0.24
		950-1200	280-355	0.5	12.0	0.1	0.2
		1200-1400	355-415	0.5	12.0	0.1	0.2
M	双相不锈钢	780	230	0.5	12.0	0.08	0.16
	奥氏体不锈钢	680	200	0.5	12.0	0.08	0.18
	沉淀硬化不锈钢	1010	300	0.5	12.0	0.06	0.12
K	灰口铸铁	200-350	180-245	0.5	12.0	0.18	0.36
	球墨铸铁	400-700	155-265	0.5	12.0	0.16	0.32
	蠕墨铸铁	400	230	0.5	12.0	0.12	0.24
S	镍基 / 钴基合金	840-1180	250-350	0.5	12.0	0.05	0.1
	钛合金	1260-1400	375-410	0.5	12.0	0.05	0.1
N	铝合金	260-450	75-130	0.5	12.0	0.05	0.2
H	淬硬钢	-	HRC50-60				
	淬硬铸铁	-	HRC55				

M9190-LN13 Series

进给参数				ap(mm)		fz(mm/z)	
ISO	材料组	抗拉强度 (N/mm ²)	布氏硬度 (HB)	ap		M5	
				Min	Max	Min	Max
P	非合金钢	430	125	0.5	32-54	0.12	0.2
		640-1010	190-300	0.5	32-54	0.1	0.16
	低合金钢	700-950	200-280	0.5	32-54	0.1	0.16
		950-1200	280-355	0.5	32-54	0.08	0.15
		1200-1400	355-415	0.5	32-54	0.08	0.15
M	双相不锈钢	780	230	0.5	32-54	0.05	0.12
	奥氏体不锈钢	680	200	0.5	32-54	0.06	0.15
	沉淀硬化不锈钢	1010	300	0.5	32-54	0.04	0.1
K	灰口铸铁	200-350	180-245	0.5	32-54	0.15	0.25
	球墨铸铁	400-700	155-265	0.5	32-54	0.12	0.2
	蠕墨铸铁	400	230	0.5	32-54	0.1	0.16
S	镍基 / 钴基合金	840-1180	250-350	0.5	32-54	0.03	0.08
	钛合金	1260-1400	375-410	0.5	32-54	0.03	0.08
N	铝合金	260-450	75-130				
H	淬硬钢	-	HRC50-60				
	淬硬铸铁	-	HRC55				

M2290-WN08 Series

进给参数				ap(mm)		fz(mm/z)							
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ap		F7		M4		M5		R5	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	非合金钢	430	125	0.5	7.5	0.15	0.3	0.12	0.24	0.15	0.3	0.16	0.32
		640-1010	190-300	0.5	7.5	0.12	0.24	0.1	0.2	0.12	0.24	0.15	0.3
	低合金钢	700-950	200-280	0.5	7.5	0.12	0.24	0.1	0.2	0.12	0.24	0.15	0.3
		950-1200	280-355	0.5	7.5	0.1	0.2	0.08	0.18	0.1	0.2	0.12	0.24
		1200-1400	355-415	0.5	7.5	0.1	0.2	0.08	0.18	0.1	0.2	0.12	0.24
M	双相不锈钢	780	230	0.5	7.5	0.08	0.15	0.06	0.12	0.08	0.15		
	奥氏体不锈钢	680	200	0.5	7.5	0.08	0.18	0.06	0.15	0.08	0.18		
	沉淀硬化不锈钢	1010	300	0.5	7.5	0.06	0.12	0.05	0.1	0.06	0.12		
K	灰口铸铁	200-350	180-245	0.5	7.5	0.16	0.32	0.15	0.3	0.16	0.32	0.2	0.4
	球墨铸铁	400-700	155-265	0.5	7.5	0.15	0.3	0.12	0.24	0.15	0.3	0.18	0.36
	蠕墨铸铁	400	230	0.5	7.5	0.12	0.24	0.1	0.2	0.12	0.24	0.15	0.3
S	镍基 / 钴基合金	840-1180	250-350	0.5	7.5	0.05	0.1	0.04	0.08	0.05	0.1		
	钛合金	1260-1400	375-410	0.5	7.5	0.05	0.1	0.04	0.08	0.05	0.1		
N	铝合金	260-450	75-130										
H	淬硬钢	-	HRC50-60										
	淬硬铸铁	-	HRC55										

M2290-S009 Series

进给参数				ap(mm)		fz(mm/z)			
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ap		M5		M7	
				Min	Max	Min	Max	Min	Max
P	非合金钢	430	125	0.5	7.5	0.1	0.2	0.12	0.24
		640-1010	190-300	0.5	7.5	0.08	0.18	0.1	0.2
	低合金钢	700-950	200-280	0.5	7.5	0.08	0.18	0.1	0.2
		950-1200	280-355	0.5	7.5	0.06	0.15	0.08	0.16
		1200-1400	355-415	0.5	7.5	0.06	0.15	0.08	0.16
M	双相不锈钢	780	230	0.5	7.5	0.06	0.12		
	奥氏体不锈钢	680	200	0.5	7.5	0.06	0.12		
	沉淀硬化不锈钢	1010	300	0.5	7.5	0.05	0.1		
K	灰口铸铁	200-350	180-245	0.5	7.5	0.12	0.24	0.15	0.3
	球墨铸铁	400-700	155-265	0.5	7.5	0.1	0.2	0.12	0.24
	蠕墨铸铁	400	230	0.5	7.5	0.08	0.18	0.1	0.2
S	镍基 / 钴基合金	840-1180	250-350	0.5	7.5	0.04	0.08		
	钛合金	1260-1400	375-410	0.5	7.5	0.04	0.08		
N	铝合金	260-450	75-130						
H	淬硬钢	-	HRC50-60						
	淬硬铸铁	-	HRC55						

M2290-S012 Series

进给参数				ap(mm)		fz(mm/z)			
ISO	材料组	抗拉强度 (N/mm ²)	布氏硬度 (HB)	ap		M5		M7	
				Min	Max	Min	Max	Min	Max
P	非合金钢	430	125	0.5	10.0	0.1	0.2	0.12	0.24
		640-1010	190-300	0.5	10.0	0.08	0.18	0.1	0.2
	低合金钢	700-950	200-280	0.5	10.0	0.08	0.18	0.1	0.2
	高合金钢	950-1200	280-355	0.5	10.0	0.06	0.15	0.08	0.16
		1200-1400	355-415	0.5	10.0	0.06	0.15	0.08	0.16
M	双相不锈钢	780	230	0.5	10.0	0.06	0.12		
	奥氏体不锈钢	680	200	0.5	10.0	0.06	0.12		
	沉淀硬化不锈钢	1010	300	0.5	10.0	0.05	0.1		
K	灰口铸铁	200-350	180-245	0.5	10.0	0.12	0.24	0.15	0.3
	球墨铸铁	400-700	155-265	0.5	10.0	0.1	0.2	0.12	0.24
	蠕墨铸铁	400	230	0.5	10.0	0.08	0.18	0.1	0.2
S	镍基 / 钴基合金	840-1180	250-350	0.5	10.0	0.04	0.08		
	钛合金	1260-1400	375-410	0.5	10.0	0.04	0.08		
N	铝合金	260-450	75-130						
H	淬硬钢	-	HRC50-60						
	淬硬铸铁	-	HRC55						

M3215-S009 Series

进给参数				ap(mm)		fz(mm/z)			
ISO	材料组	抗拉强度 (N/mm ²)	布氏硬度 (HB)	ap		M5		M7	
				Min	Max	Min	Max	Min	Max
P	非合金钢	430	125	0.4	1.0	0.75	1.2	0.8	1.5
		640-1010	190-300	0.4	1.0	0.6	1.0	0.75	1.2
	低合金钢	700-950	200-280	0.4	1.0	0.6	1.0	0.75	1.2
	高合金钢	950-1200	280-355	0.4	1.0	0.5	0.9	0.6	1.0
		1200-1400	355-415	0.4	1.0	0.5	0.9	0.6	1.0
M	双相不锈钢	780	230	0.4	1.0	0.5	0.9		
	奥氏体不锈钢	680	200	0.4	1.0	0.5	0.9		
	沉淀硬化不锈钢	1010	300	0.4	1.0	0.45	0.8		
K	灰口铸铁	200-350	180-245	0.4	1.0	0.75	1.5	0.8	1.6
	球墨铸铁	400-700	155-265	0.4	1.0	0.6	1.2	0.75	1.5
	蠕墨铸铁	400	230	0.4	1.0	0.5	1.0	0.6	1.2
S	镍基 / 钴基合金	840-1180	250-350	0.4	1.0	0.4	0.75		
	钛合金	1260-1400	375-410	0.4	1.0	0.4	0.75		
N	铝合金	260-450	75-130						
H	淬硬钢	-	HRC50-60						
	淬硬铸铁	-	HRC55						

M3215-S012 Series

进给参数				ap(mm)		fz(mm/z)			
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ap		M5		M7	
				Min	Max	Min	Max	Min	Max
P	非合金钢	430	125	0.5	1.5	0.75	1.2	0.8	1.5
		640-1010	190-300	0.5	1.5	0.6	1.0	0.75	1.2
	低合金钢	700-950	200-280	0.5	1.5	0.6	1.0	0.75	1.2
		950-1200	280-355	0.5	1.5	0.5	0.9	0.6	1.0
		1200-1400	355-415	0.5	1.5	0.5	0.9	0.6	1.0
M	双相不锈钢	780	230	0.5	1.5	0.5	0.9		
	奥氏体不锈钢	680	200	0.5	1.5	0.5	0.9		
	沉淀硬化不锈钢	1010	300	0.5	1.5	0.45	0.8		
K	灰口铸铁	200-350	180-245	0.5	1.5	0.75	1.5	0.8	1.6
	球墨铸铁	400-700	155-265	0.5	1.5	0.6	1.2	0.75	1.5
	蠕墨铸铁	400	230	0.5	1.5	0.5	1.0	0.6	1.2
S	镍基 / 钴基合金	840-1180	250-350	0.5	1.5	0.4	0.75		
	钛合金	1260-1400	375-410	0.5	1.5	0.4	0.75		
N	铝合金	260-450	75-130						
H	淬硬钢	-	HRC50-60						
	淬硬铸铁	-	HRC55						

M7145-S009 Series

进给参数				ap(mm)		fz(mm/z)			
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ap		M5		M7	
				Min	Max	Min	Max	Min	Max
P	非合金钢	430	125	0.5	5.0	0.15	0.25	0.15	0.3
		640-1010	190-300	0.5	5.0	0.12	0.2	0.12	0.25
	低合金钢	700-950	200-280	0.5	5.0	0.12	0.2	0.12	0.25
		950-1200	280-355	0.5	5.0	0.1	0.16	0.1	0.2
		1200-1400	355-415	0.5	5.0	0.1	0.16	0.1	0.2
M	双相不锈钢	780	230	0.5	5.0	0.08	0.15		
	奥氏体不锈钢	680	200	0.5	5.0	0.08	0.15		
	沉淀硬化不锈钢	1010	300	0.5	5.0	0.06	0.12		
K	灰口铸铁	200-350	180-245	0.5	5.0	0.2	0.3	0.2	0.4
	球墨铸铁	400-700	155-265	0.5	5.0	0.15	0.25	0.15	0.3
	蠕墨铸铁	400	230	0.5	5.0	0.12	0.2	0.12	0.25
S	镍基 / 钴基合金	840-1180	250-350	0.5	5.0	0.05	0.1		
	钛合金	1260-1400	375-410	0.5	5.0	0.05	0.1		
N	铝合金	260-450	75-130						
H	淬硬钢	-	HRC50-60						
	淬硬铸铁	-	HRC55						

M7145-S012 Series

进给参数				ap(mm)		fz(mm/z)			
ISO	材料组	抗拉强度 (N/mm²)	布氏硬度 (HB)	ap		M5		M7	
				Min	Max	Min	Max	Min	Max
P	非合金钢	430	125	0.5	7.5	0.15	0.25	0.15	0.3
		640-1010	190-300	0.5	7.5	0.12	0.2	0.12	0.25
	低合金钢	700-950	200-280	0.5	7.5	0.12	0.2	0.12	0.25
	高合金钢	950-1200	280-355	0.5	7.5	0.1	0.16	0.1	0.2
		1200-1400	355-415	0.5	7.5	0.1	0.16	0.1	0.2
M	双相不锈钢	780	230	0.5	7.5	0.08	0.15		
	奥氏体不锈钢	680	200	0.5	7.5	0.08	0.15		
	沉淀硬化不锈钢	1010	300	0.5	7.5	0.06	0.12		
K	灰口铸铁	200-350	180-245	0.5	7.5	0.2	0.3	0.2	0.4
	球墨铸铁	400-700	155-265	0.5	7.5	0.15	0.25	0.15	0.3
	蠕墨铸铁	400	230	0.5	7.5	0.12	0.2	0.12	0.25
S	镍基 / 钴基合金	840-1180	250-350	0.5	7.5	0.05	0.1		
	钛合金	1260-1400	375-410	0.5	7.5	0.05	0.1		
N	铝合金	260-450	75-130						
H	淬硬钢	-	HRC50-60						
	淬硬铸铁	-	HRC55						

切削参数						Vc(m/min)												
ISO	材料组		抗拉强度 N/mm ²	抗拉强度 HB	APU25			ACP35			APP45			APM25		APM35		
					1/5	1/2	1/1	1/5	1/2	1/1	1/5	1/2	1/1	1/5	≥ 1/2	1/5	≥ 1/2	
P	非合金钢	C ≤ 0.25%	退火	430	125	270	240	225	270	240	225	250	225	200				
		0.25% < C ≤ 0.55%	退火	640	190	250	200	180	250	200	180	225	180	160				
		0.25% < C ≤ 0.55%	调质	710	210	240	180	160	240	180	160	200	160	150				
		C > ≤ 0.55%	退火	640	190	250	200	180	250	200	180	225	180	160				
		C > ≤ 0.55%	调质	1010	300	160	125	100	160	125	100	125	100	90				
		易切削钢 (短屑)	退火	750	220	225	180	160	225	180	160	200	160	150				
	低合金钢	退火		590	175	250	225	200	250	225	200	225	200	180				
		调质		960	285	180	160	150	180	160	150	125	100	90				
		调质		1280	380	125	100	90	125	100	90	100	90	75				
		调质		1480	430	120	90	75	120	90	75	75	60	50				
	高合金钢 / 工具钢	退火		680	200	150	125	100	150	125	100	125	100	90				
		淬火并回火		1010	300	80	75	60	80	75	60	75	60	50				
		淬火并回火			380	60	50	45	60	50	45	50	45	40				
	不锈钢	铁素体	退火	680	200	150	125	100	150	125	100	125	100	90	160	150	150	125
		铁素体 / 马氏体	调质	1110	330	75	60	50	75	60	50	60	50	45	90	75	75	60
M	不锈钢	奥氏体	淬火	680	200							100	90	75	150	125	125	100
		奥氏体 (PH)	沉淀弥散硬化	1010	300							75	60	50	100	80	80	75
		奥氏体 - 铁素体	双相	780	230							90	75	60	125	100	100	80
K	灰口铸铁	低抗拉强度		200	180													
		高抗拉强度		350	245													
	球墨铸铁	铁素体		400	155													
		珠光体		700	265													
	蠕墨铸铁	GGV (CGI)			230													
S	高温合金	铁基	退火	680	200													
			时效处理	940	280													
		镍基 / 钴基	退火	840	250													
			时效处理	1180	350													
			铸造	1080	320													
	钛合金	TA 系列 / TC 系列	α 相 / α 相 +β 相	1260	375													
		TB 系列	β 相	1400	410													
N	锻造铝合金	Si ≤ 1%	非时效处理	-	30													
		Si ≤ 1%	时效处理	340	100													
	铸造铝合金	Si ≤ 12%	非时效处理	260	75													
		Si ≤ 12%	时效处理	310	90													
		Si>12%	非时效处理	450	130													
H	淬硬钢	淬火并回火		50 HRC														
		淬火并回火		55 HRC														
		淬火并回火		60 HRC														
		淬硬铸铁		55 HRC														

B

G

A

B

C

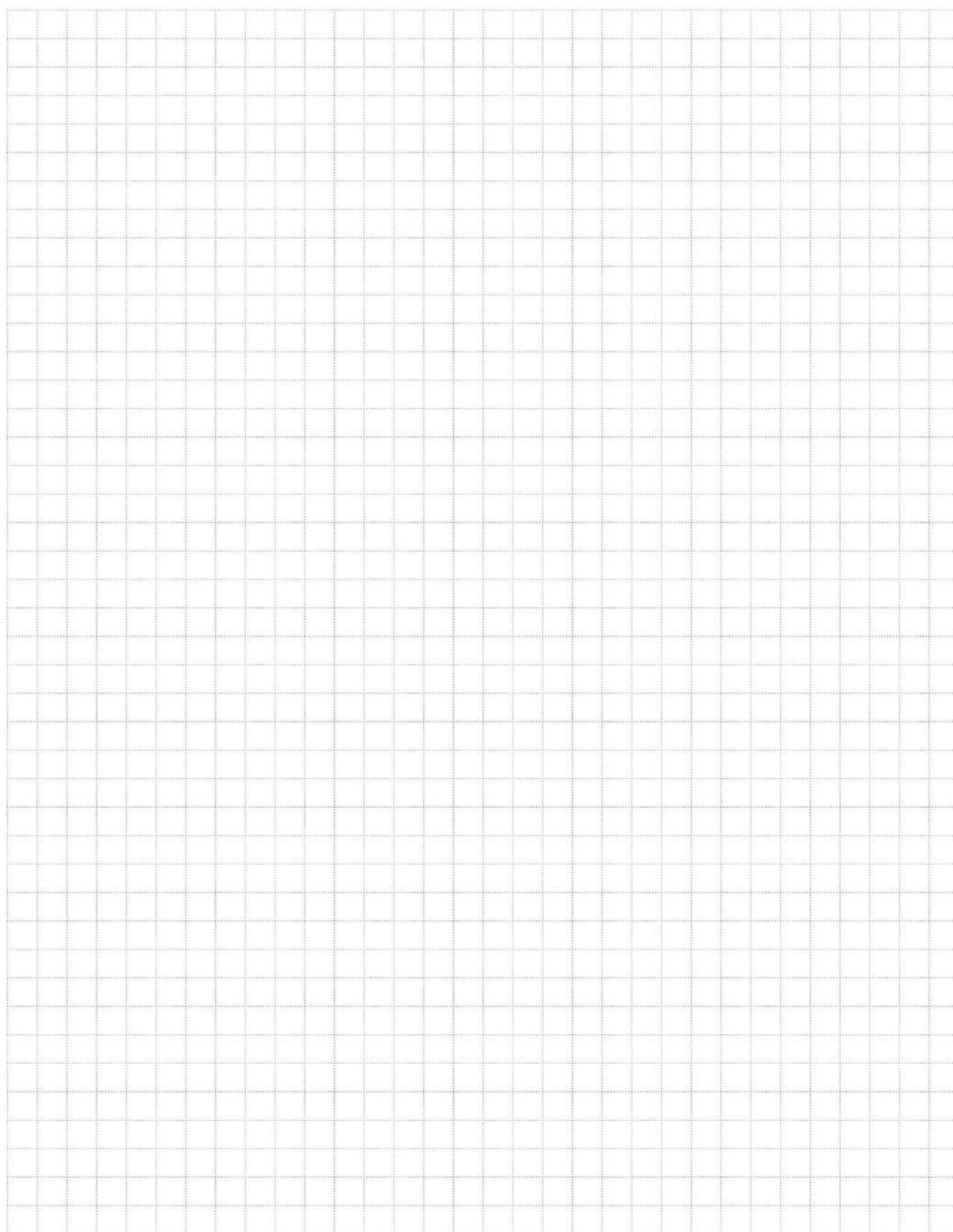
D

E

F

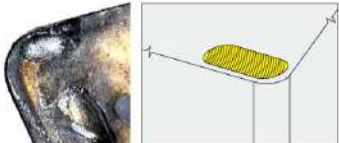
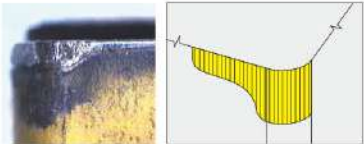
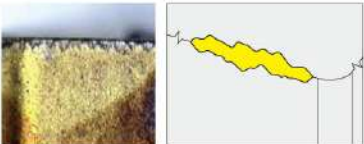
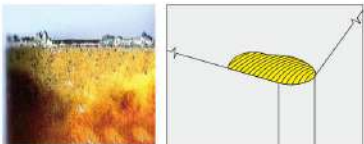
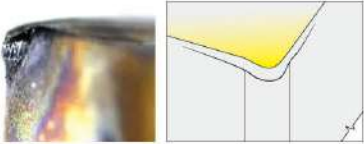
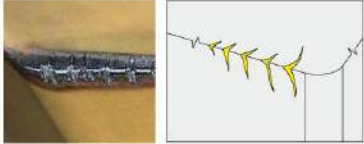
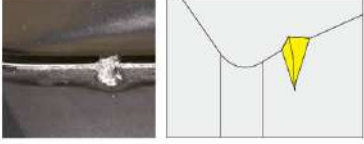
G

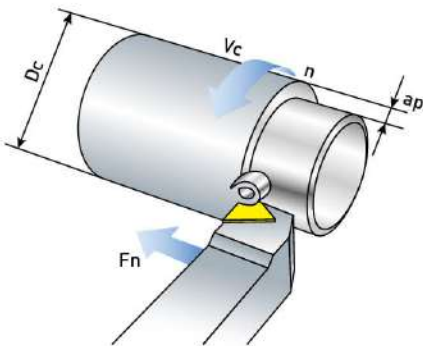
H



TECHNICAL INFORMATION

技术信息

失效类型	表现形式		原因分析	改进措施
月牙洼磨损		刀片前刀面有凹陷状磨损	切屑与刀片前刀面的接触导致扩散磨损； 刀片材质过软； 线速度过高；	选择更耐磨材质（Al2O3 含量更高的涂层）刀片； 降低线速度； 使用更开放槽型； 优化冷却；
后刀面磨损		主要位于刀片后刀面的磨损	刀片材质过软； 切削线速度过高； 进给量太小；	选择更耐磨材质的刀片； 降低线速度； 提高进给量； 优化冷却；
崩刃		刀片切削刃或刀尖处崩口	刀片材料过硬； 进给量太大； 刀片槽型刃口不够稳固； 刀杆、刀柄刚性不足；	使用韧性更好的刀片； 减小进给量； 使用更稳固的槽型； 加强刀杆结构，减少悬长；
积屑瘤		刀片前刀面沿切削刃有工件材料粘结堆积	切削线速度低； 刀片刃口不够锋利； 刀具材料或涂层不合适；	提高切削线速度； 使用更加锋利的槽型； 选择亲和力小的刀具材料或涂层； 优化冷却；
塑性变形		刀尖或者切削刃塌陷变形	刀具材料过软； 切削速度过高； 切削深度，进给太大； 切削温度过高；	使用更耐磨材质的刀具； 降低切削速度； 减小切削深度，进给量； 优化冷却；
热龟裂		刀片切削刃上有梳齿状龟裂	切削热引起的膨胀和收缩波动导致； 刀具材料过硬；	采用干式切削或者精密充分的冷却； 使用韧性更好的刀具材质；
沟槽磨损		刀片切削刃上有缺口状磨损	加工硬材料； 工件表面有氧化皮；	选择较小的主偏角； 使用变化的切深； 使用韧性更好的刀具材质； 使用更稳固的槽型； 优化冷却；

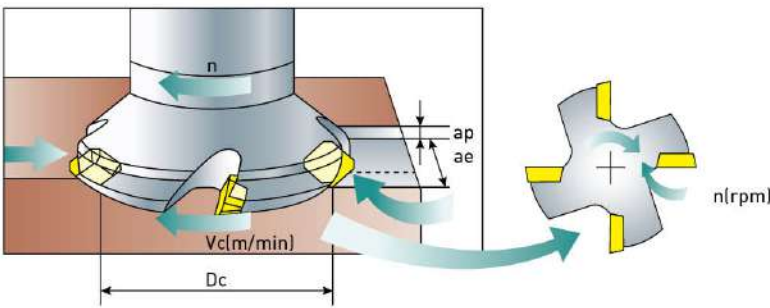


公式

切削速度	$V_c = (D_c \times \pi \times n) \div 1000$
转速	$n = (V_c \times 1000) \div (D_c \times \pi)$
进给速度	$V_f = n \times F_n$
每转进给量	$F_n = V_f \div n$
金属去除率	$Q = V_c \times V_f \times A_p$
加工时间	$T = L \div V_f$

释义

n	主轴转速	rpm
Vc	切削速度	m/min
Vf	进给速度	mm/min
Fn	每转进给量	mm
Dc	零件加工直径	mm
ap	零件切深	mm
Q	金属去除率	cm ³ /min
L	零件加工长度	mm
T	加工时间	min
π	圆周率 3.14	

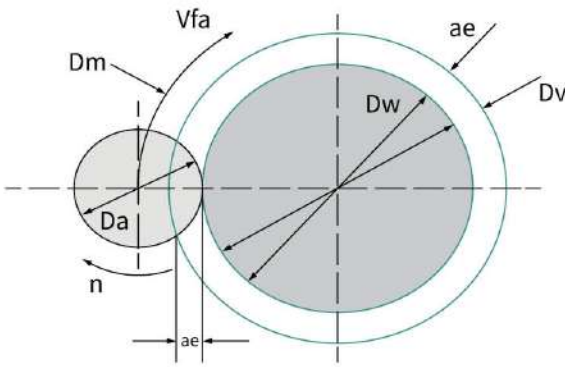


公式

切削速度	$V_c = (D_c \times \pi \times n) \div 1000$
转速	$n = (V_c \times 1000) \div (D_c \times \pi)$
进给速度	$V_f = f_z \times n \times Z$
每齿进给量	$f_z = V_f \div (n \times Z)$
金属去除率	$Q = (a_p \times a_e \times V_f) \div 1000$
加工时间	$T = L \div V_f$

释义

n	主轴转速	rpm
V_c	切削速度	m/min
V_f	进给速度	mm/min
f_z	每齿进给量	mm
D_c	铣刀直径	mm
Z	铣刀齿数	
a_p	切深	mm
a_e	切宽	mm
Q	金属去除率	cm ³ /min
L	零件铣削长度	mm
T	加工时间	min
π	圆周率 3.14	

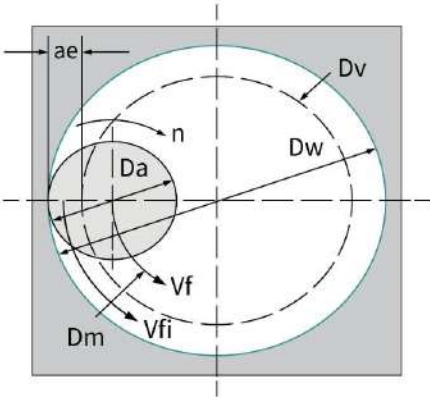


外圆插补铣切削比例

外部轮廓进给速度	$V_{fa} = \left(1 + \frac{D_c}{D_w + a_e} \right) \times V_f \quad [\text{mm/min}]$		
圆周插补铣加工时间	$T_{rev} = \frac{D_m \times \pi}{n \times f_z \times z} \quad [\text{min}]$	$T_{rev} = \frac{(D_w + D_a) D_a \times \pi^2 \times 60}{V_c \times f_z \times z \times 1000} \quad [\text{s}]$	
圆周插补铣切削宽度	$a_e = \frac{(D_v^2 - D_w^2)}{4(D_w + D_a)} \quad [\text{mm}]$		

外部轮廓

Vfa	刀具中心轨迹进给速度	mm/min
Da	铣刀外径	m/min
Dm	中心轨迹直径	mm/min
Dv	工件毛坯直径	mm
Dw	工件成品直径	mm
ae	切削宽度	mm
n	转速	mm
fz	每齿进给量	rpm
Z	齿数	mm



插补铣孔的切削比例

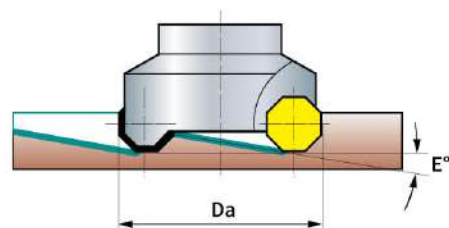
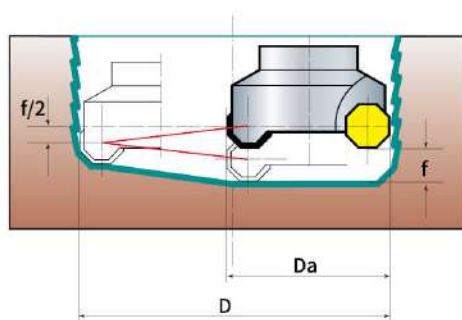
内部轮廓进给速度 $V_{fi} = \left(1 - \frac{D_c}{D_w} \right) \times V_f \quad [\text{mm/min}]$

圆周插补铣加工时间 $T_{rev} = \frac{D_m \times \pi}{n \times f_z \times z} \quad [\text{min}]$ $T_{rev} = \frac{(D_w - D_a) D_a \times \pi^2 \times 60}{V_c \times f_z \times z \times 1000} \quad [\text{s}]$

圆周插补铣切削宽度 $ae = \frac{(D^2_w - D^2_v)}{4 (D_w - D_a)} \quad [\text{mm}]$

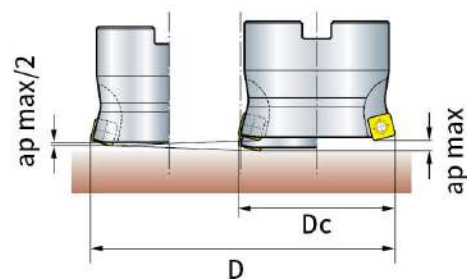
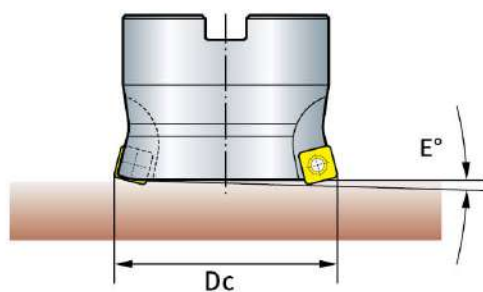
内部轮廓

Vf	进给速度	mm/min
Vfi	刀具中心轨迹进给速度	mm/min
Da	铣刀外径	mm
Dm	中心轨迹直径	mm
Dv	工件毛坯直径	mm
Dw	工件成品直径	mm
ae	加工余量	mm
n	转速	rpm
fz	每齿进给量	mm
Z	齿数	
Trev	圆周插补铣加工时间	s



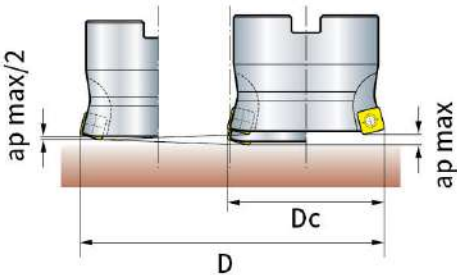
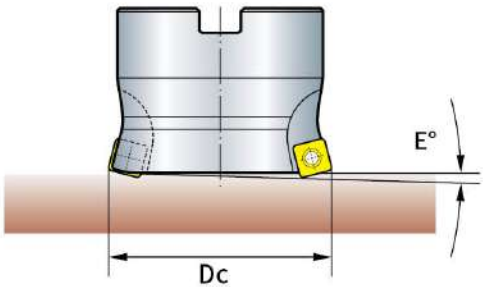
铣刀直径 Da	直线坡铣	螺旋插补铣		
	最大坡铣角度 E	最小直径 Dmin	最大直径 Dmax	最大螺距 fmax
Ø50	5.4	78		4.5
			100	4.5
Ø58	4.5	94		4.5
			116	4.5
Ø63	3.6	104		4.5
			125	4.5
Ø71	3.2	120		4.5
			140	4.5
Ø80	2.7	138		4.5
			160	4.5
Ø88	2.4	154		4.5
			175	4.5
Ø100	2.0	178		4.5
			200	4.5
Ø108	2.0	194		4.5
			215	4.5
Ø125	1.5	228		4.5
			250	4.5
Ø133	1.5	245		4.5
			266	4.5

刀片	编程圆角 R
SO09T308	R2.4
SO09T320	R3.2



铣刀直径 D	直线坡铣		螺旋插补铣	
	最大坡铣角度 E	最大切深 ap max	最小直径 Dmin	最大直径 Dmax
Ø32	4.5	1.0	48	
				64
Ø35	4.0	1.0	54	
				72
Ø40	2.7	1.0	64	
				80
Ø50	1.8	1.0	84	
				100
Ø63	1.5	1.0	110	
				125

刀片	编程圆角 R
SO120408	R3.4
SO120425	R4.2



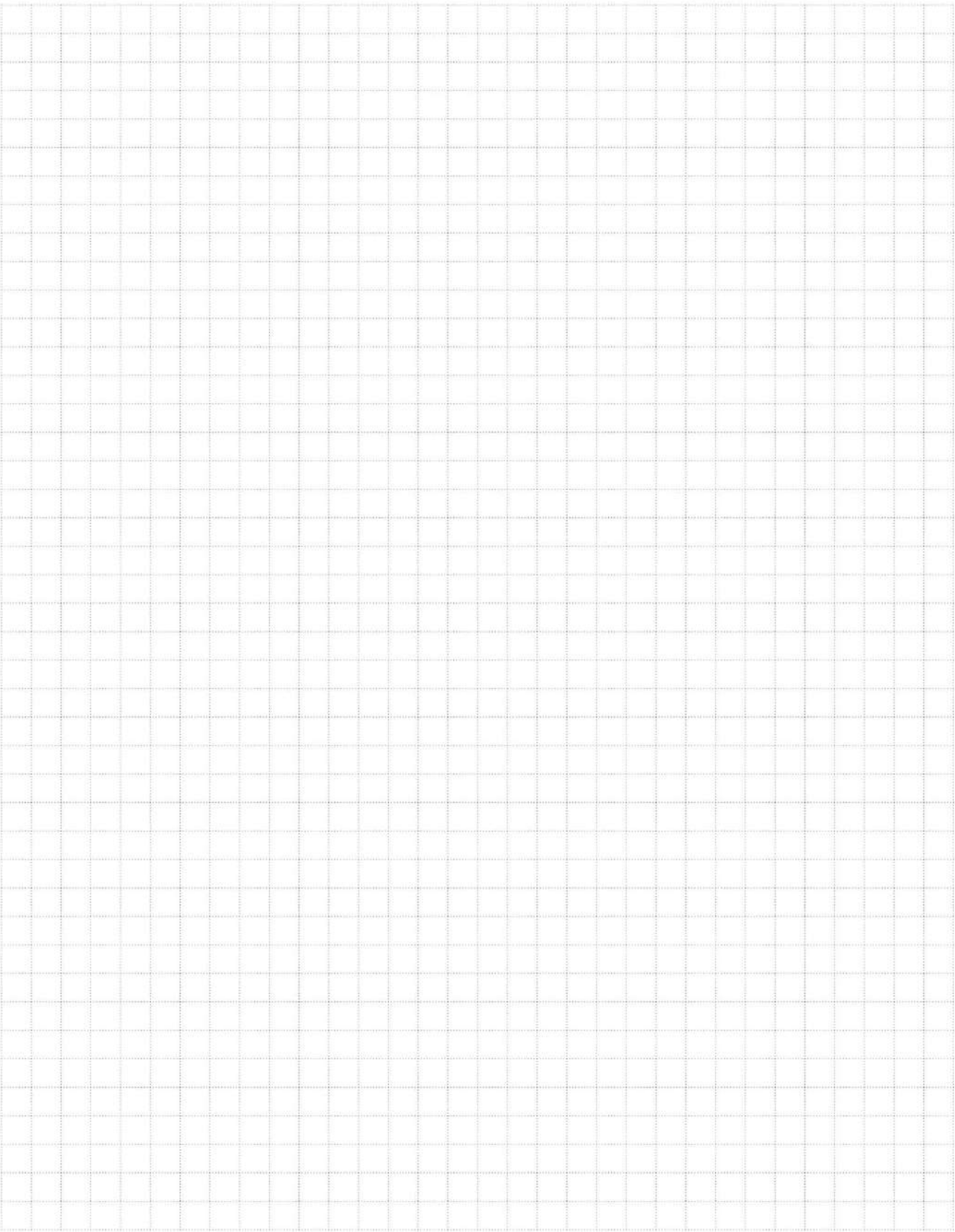
铣刀直径 D	直线坡铣		螺旋插补铣	
	最大坡铣角度 E	最大切深 ap max	最小直径 Dmin	最大直径 Dmax
Ø32	3.2	1.5	48	
				64
Ø40	3.0	1.5	63	
				80
Ø50	2.7	1.5	80	
				100
Ø63	1.8	1.5	106	
				125
Ø80	1.2	1.5	140	
				160

刀片 R 角与进给关系可达到的表面粗糙度

Ra / Rz μm	刀片 R 角 ISO					
	02	04	08	12	16	24
	进给 f(mm)					
0.4/1.6	0.05	0.07	0.1	0.12	0.14	0.18
1.6/6.3	0.1	0.14	0.2	0.25	0.28	0.35
3.2/12.5	0.14	0.2	0.28	0.35	0.4	0.49
6.3/25	-	0.28	0.4	0.49	0.57	0.69
8/32	-	-	0.45	0.55	0.64	0.78

硬度换算对照表

布氏硬度 (HB)	维氏硬度 (HV)	洛氏硬度		抗拉强度 (N/mm ²)
		150kg 金钢石锥 (HRC)	100kg 钢球 (HRB)	
208	198	-	93	667
212	201	-	94	680
217	206	(16.0)	95	696
220	209	(17.5)	95	706
222	211	(18.7)	96	716
235	223	(19.1)	97	755
242	230	20.2	97	775
248	236	22.1	99	794
257	244	23.1	100	824
262	249	24.1	100	838
266	253	24.8	101	853
272	258	25.7	101	870
275	261	26.4	102	880
277	263	27.0	103	892
291	276	29.1	104	941
302	287	29.9	105	971
308	293	30.9	106	990
315	299	32.1	107	1020
322	306	32.3	107	1035
325	309	32.4	107	1049
338	321	33.6	107	1089
343	326	35.4	108	1118
361	343	36.6	109	1157
369	351	37.6	110	1187
383	364	39.4	-	1236
392	372	40.3	-	1265
408	388	41.7	-	1314
425	404	42.9	-	1363
433	411	43.6	-	1390
441	419	44.6	-	1422
447	425	45.0	-	1447
455	432	45.8	-	1471
470	447	46.9	-	1520
485	461	48.1	-	1569



A

B

C

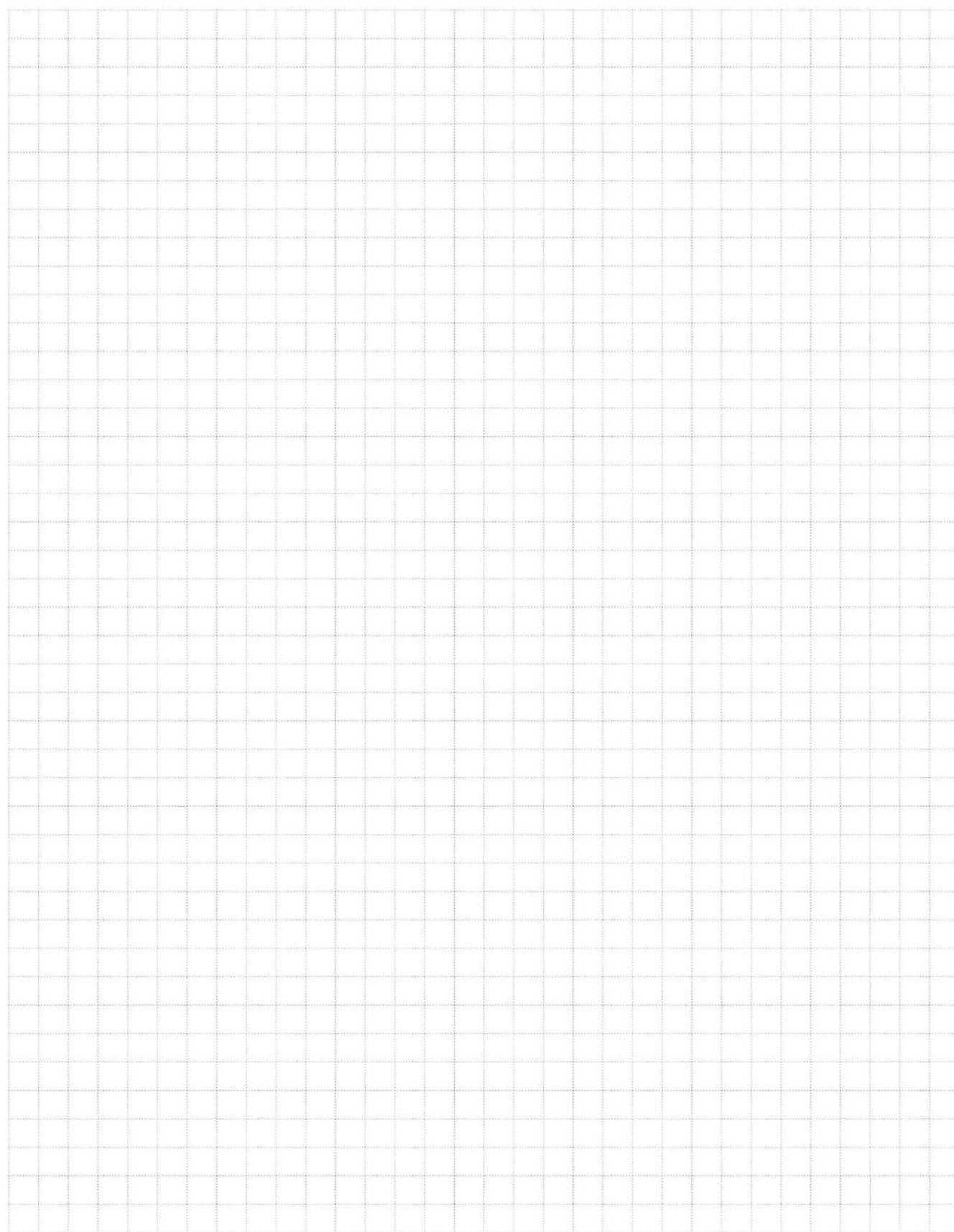
D

E

F

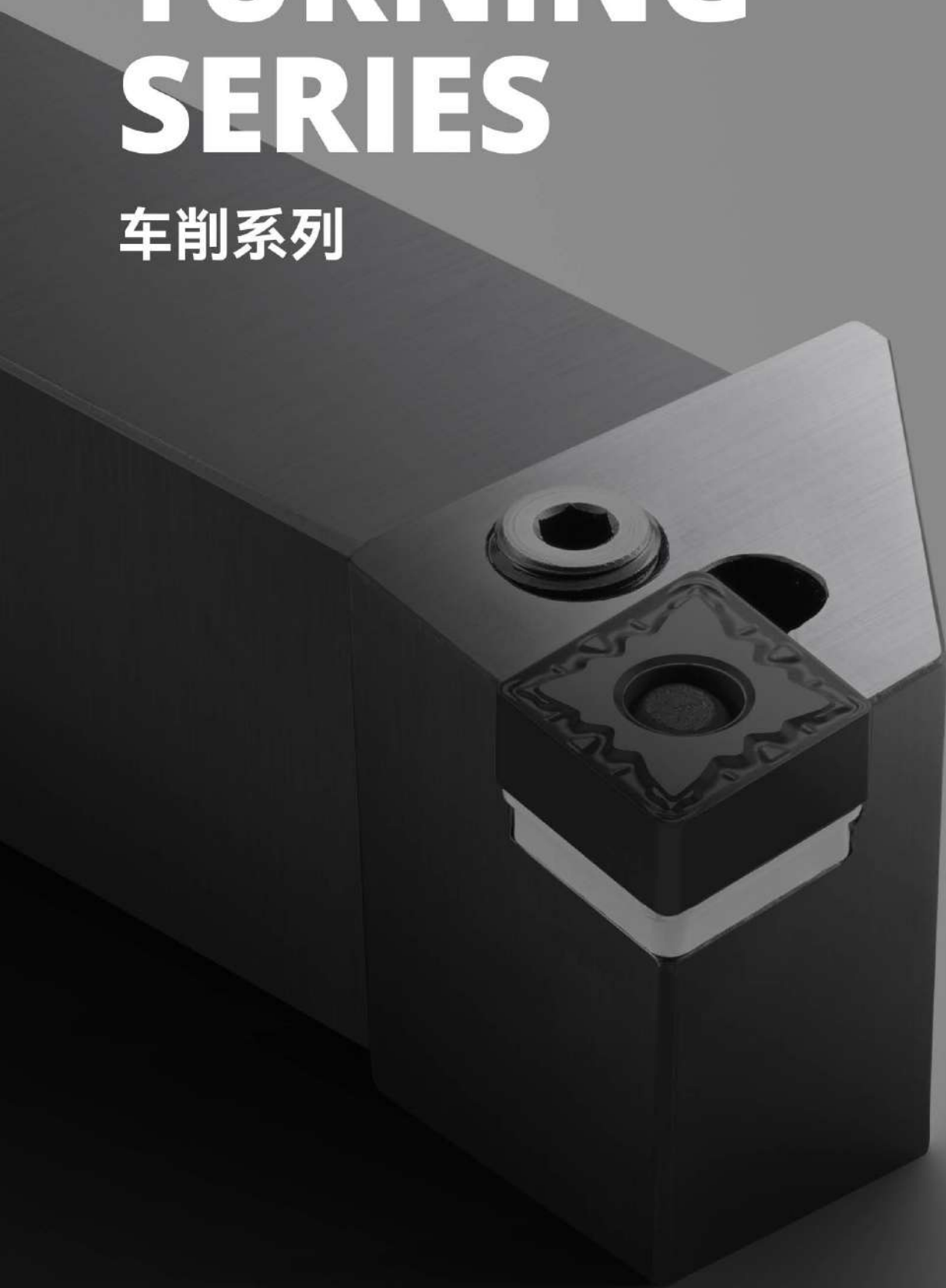
G

H



TURNING SERIES

车削系列



ISO Turning

车削用可转位刀片按照 ISO 1832 标准的符号说明

Turning Inserts according to ISO 1832 Standard Code System

示例 1:

Example 1:

C	N	M	G	12	04	08	-	P	M	A
1	2	3	4	5	6	7		12	13	14

1、刀片形状

1. Insert shape

代号 Symbol	图形 Shape	代号 Symbol	图形 Shape
A		M	
B		O	
C		P	
D		R	
E		S	
H		T	
K		V	
L		W	

2、后角

2. Relief Angle

代号 Symbol	图形 Shape	代号 Symbol	图形 Shape
A		N	
B		P	
C			
D			
E			
F			
G			

3、公差

3. Tolerance

允许公差 (mm) Tolerance	d	m	s	
	A	± 0,025	± 0,005	± 0,025
	C	± 0,025	± 0,013	± 0,025
	E	± 0,025	± 0,025	± 0,025
	F	± 0,013	± 0,005	± 0,025
	G	± 0,025	± 0,025	± 0,130
	H	± 0,013	± 0,013	± 0,025
	J ¹	± 0,05-0,15 ²	± 0,005	± 0,025
	K ¹	± 0,05-0,15 ²	± 0,013	± 0,025
	L ¹	± 0,05-0,15 ²	± 0,025	± 0,025
	M	± 0,05-0,15 ²	± 0,08-0,20 ²	± 0,130
	N	± 0,05-0,15 ²	± 0,08-0,20 ²	± 0,025
	U	± 0,08-0,25 ²	± 0,13-0,38 ²	± 0,130

¹ 刀片有精磨的副切削刃
The insert has finishing minor cutting edge.

² 视刀片尺寸而定 (见 ISO 1832 标准)
Tolerance is different by insert size. Please see ISO 1832.

4、刀片加工和固定特征

4. Insert Machining and Figure

代号 Symbol	图形 Shape	代号 Symbol	图形 Shape	代号 Symbol	图形 Shape
A		H		R	
B		J		T	
C		M		U	
F		N		W	
G		Q		X	需要可转位刀片的图纸 或准确说明 Indexable insert drawing or detailed description is needed

示例 2:

Example 2:

C	C	G	T	06	02	04	E	L
1	2	3	4	5	6	7	8	9

5、切削刃长度

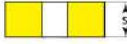
5. Cutting Edge Length

¹ 英制规格 (00) Inch

刀片形状 Insert Shape													
内切圆直径 d IC Diameter d													
mm	Inch	规格 Size	l	规格 Size	l	规格 Size	l	规格 Size	l	规格 Size	l	规格 Size	l
3,97	5/32									06	6,9		
5	0,197					05				09	9		
5,56	7/32											03	3,8
6	0,236					06							
6,35	2/8	06	6,4	07	7,7	06 ¹				11	11	11	11
8	0,315					08						05	5,2
9,525	3/8	09	9,6	11	11,6	09 ¹				16	16,5	16	16,5
10	0,394					10						06	6,5
12	0,472					12							
12,7	4/8	12	12,9	15	15,5	12 ¹				22	22	22	22,1
15,875	5/8	16	16,1					15	15,8	27	27		
16	0,63					16							
17,46	11/16												
19,05	6/8	19	19,3			19 ¹		19	19,0				
20	0,787					20							
25	0,984					25							
25,4	8/8	25	25,8			25 ¹		25	25,4				
32	1,26					32							

6、刀片厚度

6. Insert Thickness

图形 Figure	厚度 s(mm) Thickness
	01 1,59
	T1 1,98
	02 2,38
	T2 2,78
	03 3,18
	T3 3,97
	04 4,76
	05 5,56
	06 6,35
	07 7,94
	09 9,52

7、圆角半径

7. Corner Radius

图形 Shape	半径 r(mm) Radius
	01 0,1
	02 0,2
	04 0,4
	08 0,8
	12 1,2
	16 1,6
	24 2,4
	M0 公制规格 (直径以 mm 单位) Metric (Diameter unit is mm)
	00 英制规格 (英制尺寸换算以 mm 单位) Inch (Inch converts to mm)

8、切削刃形状

8. Cutting Shape

代号 Symbol	图形 Shape
F	
E	
T	
S	

9、切削方向

9. Cutting Direction

图形 Figure




ISO Turning

硬质合金切削刀具材料符号说明

Carbide Cutting Tool Material Name Code

槽型索引

Chipbreaker Index

C	N	M	G	12	04	08	-	P	M	A
1	2	3	4	5	6	7		12	13	14

12、主要材料

12. Main Materials

代号 Symbol	材料 Material
P	钢 Steel
M	不锈钢 Stainless Steel
K	铸铁 Cast Iron
N	有色金属 Nonferrous Metals
S	难加工材料 Hard-to-machine Materials
H	硬材料 Hard Materials
U	通用 General

13、断屑区域

13. Chip Area

图表 Material	代号 Symbol	用途 Application
	F	精加工 Finishing
	S	半精加工 Semi Finishing
	M	中等加工 Medium Roughing
	R	粗加工 Roughing
	H	重切削 Heavy Roughing

14、应用推荐

14. Application

代号 Symbol	推荐 Recommendation
A	第一推荐 1 st choice
B	第二推荐 2 nd choice
C	第三推荐 3 rd choice
X	断屑优先 Chip First
W	Wiper

示例:

Example :

A	C	P	10	A
1	2	3	4	5

功能序号 Function No.	说明 Description	详情 Details			
1	AHNO 阿诺				
2	基础材料及 涂层代码 Basic Materials & Coating Code	C	硬质合金 +CVD Carbide +CVD	V	金属陶瓷 +PVD Cermet +PVD
		P	硬质合金 +PVD Carbide + PVD	I	塞隆陶瓷 Sialon Ceramics
		B	CBN	W	晶须陶瓷 Whisker Ceramics
		D	PCD	N	硬质合金 Carbide
		T	金属陶瓷 Cermet		
3	第一推荐应用 First Recommended Application	P	钢 Steel	N	有色金属 Nonferrous Metals
		M	不锈钢 Stainless Steel	S	难加工材料 Hard-to-machine Materials
		K	铸铁 Cast Iron	H	硬材料 Hard Materials
4	ISO 应用范围 ISO Application Range	01 10 20 30 40 耐磨性 Wear Resistance 韧性 Toughness			
5	代代代码 Generation Code	A: 阿诺 -Loong 龍系列材质 A: AHNO-Loong series grade			

ISO Turning

阿诺 - Loong 龍系列 - 车削材质一览

AHNO Loong Series-Turning Materials Overview

车削材料应用 Turning Materials Application																	
车削材质 Turning Materials	ISO 组别 ISO Group	涂层工艺 Coating Technology	工件材料组别 Workpiece Material Group						应用范围 Application Range								技术说明 Technology Description
			P	M	K	S	N	H	05	10	15	20	25	30	35	40	
ACP05A	P05~P20	CVD	●							■							高耐磨性的钢件车削材质，适用于精加工和半精加工，在系统刚性较好的场合能够应用于轻微断续加工。另外，也适用于部分铸铁和淬火材料的加工。 The high wear resistance of steel turning materials, suitable for finishing and semi-finishing, can be used for slight intermittent machining in the case of good rigidity. In addition, it is also suitable for the processing of some cast iron and quenched materials.
	K10~K20				●					■							
	H10~H20							●			■						
ACP10A	P10~P25	CVD	●							■							钢件车削的首选，出色的耐磨性和良好的韧性，是极具平衡性的通用材质。 The first choice for steel turning, with excellent wear resistance and good toughness, which is a highly balanced general material.
	K15~K25				●					■							
ACP20A	P15~P30	CVD	●								■						即使面对不利的加工条件，依然具有较高的可靠性，在钢件的连续车削或断续车削应用中，均能实现稳定加工。 It has a high level of reliability even in the face of unfavorable machining conditions, and can achieve stable machining in both continuous and intermittent turning applications of steel.
	K20~K30				●						■						
ACP30A	P25~P40	CVD	●										■				针对恶劣加工条件的首选材质，凭借良好的基体韧性，广泛应用于强断续或重载车削，尤其是钢件或马氏体不锈钢的加工。 The first choice for harsh machining conditions. With good matrix toughness, it is widely used for strong intermittent or heavy-duty turning, especially in the machining of steel or martensite stainless steel.
	M20~M30			●							■						
APS05A	S05~S15	PVD				●				■							极细颗粒的低钴含量基体，搭载均匀且光滑的超薄物理涂层，实现了极致的耐磨性，是难加工材料的优选材质，亦可覆盖不锈钢和淬火材料、以及铸铁材料的精加工。 The matrix with a low cobalt content of very fine particles and an ultra-thin physical coating that is uniform and smooth achieves extreme wear resistance, which is the preferred material for difficult-to-machine materials, as well as covering the finishing of stainless steel, quenched materials, and cast iron materials.
	M05~M15			●					■								
	K05~K15				●					■							
	H05~H15						●			■							
ACM20A	M15~M25	CVD		●							■						不锈钢加工的通用材质，尤其是高线速度的切削应用，适用于连续或断续条件的半精加工至粗加工。 A general material for stainless steel machining, especially for high linear speed cutting applications, and for semi-finishing to roughing in continuous or intermittent conditions.
	P20~P30		●							■							
	S10~S20					●				■							
ACM30A	M20~M30	CVD		●							■						不锈钢的粗加工材质，凭借良好的可靠性，在严重断续或重载车削领域有比较广泛的应用。 Stainless steel roughing material, with good reliability, has a wide range of applications in the field of severe intermittent or heavy-duty turning.
	P25~P35		●							■							
	S15~S25					●				■							

阿诺 - Loong 龍系列 - 车削材质一览

AHNO Loong Series-Turning Materials Overview

工件材料组 Workpiece Material Group		刀具材质 Tool Material	涂层类别 Coating Class	应用类别 Application Category				
				05	10	20	30	40
P	碳素钢 / 合金钢 Carbon Steel / Alloy Steel	硬质合金 Carbide	CVD		ACP05A			
		硬质合金 Carbide	CVD		ACP10A			
		硬质合金 Carbide	CVD			ACP20A		
		硬质合金 Carbide	CVD				ACP30A	
M	不锈钢 Stainless Steel	硬质合金 Carbide	PVD	APS05A				
		硬质合金 Carbide	CVD		ACM20A			
		硬质合金 Carbide	CVD			ACM30A		
K	铸铁 Cast Iron	硬质合金 Carbide	PVD	APS05A				
		硬质合金 Carbide	CVD		ACP05A			
		硬质合金 Carbide	CVD		ACP10A			
		硬质合金 Carbide	CVD			ACP20A		
N	铝合金 Aluminum Alloy	硬质合金 Carbide	-					
S	高温合金 / 钛合金 High Temperature Alloy Titanium Alloy	硬质合金 Carbide	PVD	APS05A				
		硬质合金 Carbide	CVD		ACM20A			
		硬质合金 Carbide	CVD			ACM30A		
H	硬材料 Hard Materials	硬质合金 Carbide	PVD	APS05A				

ISO Turning

阿诺 - Loong 龍系列 - 负型车削刀片槽型一览

AHNO Loong Series-Negative Turning Insert Chipbreaker Overview

负型压制刀片

Negative Inserts

应用 Application	槽型 Type	断屑槽 Chipbreaker	断屑范围示意 Chipbreaker Range Diagram	断屑槽剖面 Chipbreaker Section	CN	DN	SN	TN	VN	WN
精加工槽型 Finishing	-PFA				CNMG-PFA	DNMG-PFA	SNMG-PFA	TNMG-PFA	VNMG-PFA	WNMG-PFA
	-MFA				CNMG-MFA	DNMG-MFA	SNMG-MFA	TNMG-MFA	VNMG-MFA	WNMG-MFA
半精加工槽型 Semi Finishing	-PSA				CNMG-PSA	DNMG-PSA	SNMG-PSA	TNMG-PSA	VNMG-PSA	WNMG-PSA
	-PMA				CNMG-PMA	DNMG-PMA	SNMG-PMA	TNMG-PMA	VNMG-PMA	WNMG-PMA
中等加工槽型 Medium Machining	-MMA				CNMG-MMA	DNMG-MMA	SNMG-MMA	TNMG-MMA	VNMG-MMA	WNMG-MMA
	-PMA				CNMG-PMA	DNMG-PMA	SNMG-PMA	TNMG-PMA	VNMG-PMA	WNMG-PMA

阿诺 - Loong 龍系列 - 负型车削刀片槽型一览
AHNO Loong Series-Negative Turning Insert Chipbreaker Overview

负型压制刀片
Negative Inserts

应用 Application	槽型 Type	断屑槽 Chipbreaker	断屑范围示意 Chipbreaker Range Diagram	断屑槽剖面 Chipbreaker Section	CN	DN	SN	TN	VN	WN
粗加工槽型 Roughing	-PRA				CNMG-PRA	DNMG-PRA	SNMG-PRA	TNMG-PRA		WNMG-PRA
					P.442	P.445	P.447	P.449		P.451
	-MRA				CNMG-MRA	DNMG-MRA	SNMG-MRA			WNMG-MRA
					P.443	P.446	P.448			P.452

A
B
C
D
E
F
G
H

ISO Turning

阿诺 -Loong 龍系列 - 正型车削刀片槽型一览

AHNO Loong Series-Positive Turning Insert Chipbreaker Overview

正型压制刀片

Positive Inserts

应用 Application	槽型 Type	断屑槽 Chipbreaker	断屑范围示意 Chipbreaker Range Diagram	断屑槽剖面 Chipbreaker Section	CC	DC	SC	TC	VB/VC	RC
精加工槽型 Finishing	-PFA				CCMT-PFA	DCMT-PFA	SCMT-PFA	TCMT-PFA	VBMT-PFA	
					P.453	P.455	P.458	P.459	P.461	
	-UFA				CCMT-UFA	DCMT-UFA	SCMT-UFA	TCMT-UFA	VB/VCMT-UFA	
					P.454	P.456	P.458	P.460	P.461 / P.462	
半精加工槽型 Semi Finishing	-UFA (RCMT)									RCMT-UFA
										P.457
	-USA				CCMT-USA	DCMT-USA	SCMT-USA	TCMT-USA	VB/VCMT-USA	
					P.454	P.456	P.458	P.460	P.461 / P.462	
	-USA (RCMT)									RCMT-USA
										P.457

阿诺 -Loong 龍系列 - 正型车削刀片槽型一览
AHNO Loong Series-Positive Turning Insert Chipbreaker Overview

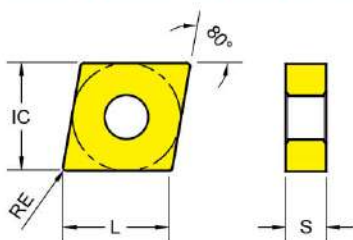
正型压制刀片
Positive Inserts

应用 Application	槽型 Type	断屑槽 Chipbreaker	断屑范围示意 Chipbreaker Range Diagram	断屑槽剖面 Chipbreaker Section	CC	DC	SC	TC	VB/VC	RC
Medium Machining 中等加工槽型	-PMA				CCMT-PMA	DCMT-PMA	SCMT-PMA	TCMT-PMA	VBMT-PMA	
					P.453	P.455	P.458	P.459	P.461	
Roughing 粗加工槽型	-PRA				CCMT-PRA	DCMT-PRA	SCMT-PRA	TCMT-PRA	VBMT-PRA	
					P.453	P.455	P.458	P.459	P.461	
	-URA				CCMT-URA	DCMT-URA	SCMT-URA	TCMT-URA	VBMT-URA	
					P.454	P.456	P.458	P.460	P.461	

阿诺 - Loong 龍系列 - 负型 CN 刀片

CNMG (80° Negative)

AHNO Loong Series-Negative Insert CN Series



Series	L	IC	S
CN**1204	12.9	12.7	4.76
CN**1606	16.1	15.875	6.35
CN**1906	19.3	19.05	6.35

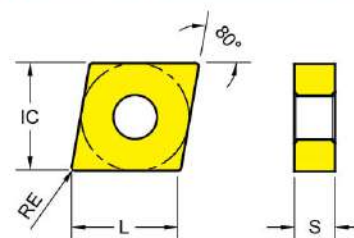
CNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PFA	CNMG120404-PFA	0.4	0.15 - 0.30	0.4 - 3.0		●	●		●	●	●	●
	CNMG120408-PFA	0.8	0.15 - 0.30	0.8 - 3.5		●	●		●	●	●	●
	CNMG120412-PFA	1.2	0.15 - 0.35	1.2 - 4.0		●	●		●	●	●	●
-PSA	CNMG120404-PSA	0.4	0.15 - 0.30	0.5 - 3.0	●	●	●			●	●	
	CNMG120408-PSA	0.8	0.15 - 0.45	0.8 - 3.0	●	●	●			●	●	
	CNMG120412-PSA	1.2	0.15 - 0.45	1.2 - 4.0		●	●			●		
-PMA	CNMG120404-PMA	0.4	0.15 - 0.26	0.5 - 6.0	●	●	●	●				
	CNMG120408-PMA	0.8	0.17 - 0.52	0.8 - 6.0	●	●	●	●				
	CNMG120412-PMA	1.2	0.15 - 0.56	1.2 - 6.0	●	●	●	●				
	CNMG120416-PMA	1.6	0.17 - 0.80	1.6 - 6.0			●	●				
	CNMG160608-PMA	0.8	0.17 - 0.52	0.8 - 7.0	●	●	●	●				
	CNMG160612-PMA	1.2	0.17 - 0.60	1.2 - 7.0	●	●	●	●				
	CNMG160616-PMA	1.6	0.17 - 0.60	1.6 - 7.0			●	●				
	CNMG190608-PMA	0.8	0.17 - 0.52	0.8 - 8.0		●	●	●				
	CNMG190612-PMA	1.2	0.17 - 0.70	1.2 - 8.0	●	●	●	●				
-PRA	CNMG190616-PMA	1.6	0.17 - 0.80	1.6 - 8.0	●	●	●	●				
	CNMG120408-PRA	0.8	0.25 - 0.60	2.0 - 6.0	●	●	●	●				
	CNMG120412-PRA	1.2	0.25 - 0.68	2.0 - 6.0	●	●	●	●				
	CNMG120416-PRA	1.6	0.30 - 0.80	2.0 - 6.0				●				
	CNMG160608-PRA	0.8	0.25 - 0.60	3.0 - 7.0		●	●					
	CNMG160612-PRA	1.2	0.25 - 0.70	3.0 - 7.0	●	●	●	●				
	CNMG190612-PRA	1.2	0.25 - 0.70	3.0 - 8.0		●	●	●				
	CNMG190616-PRA	1.6	0.25 - 0.70	2.0 - 9.0	●	●	●	●				

CNMG (80° Negative)

阿诺 - Loong 龍系列 - 负型 CN 刀片

AHNO Loong Series-Negative Insert CN Series

Series	L	IC	S
CN**1204	12.9	12.7	4.76
CN**1606	16.1	15.875	6.35
CN**1906	19.3	19.05	6.35



CNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-MFA	CNMG120404-MFA	0.4	0.18 - 0.30	0.4 - 4.0		●	●	●	●	●	●	●
	CNMG120408-MFA	0.8	0.20 - 0.45	0.8 - 4.0		●	●		●	●	●	●
	CNMG120412-MFA	1.2	0.22 - 0.45	1.2 - 4.5					●	●		●
-MMA	CNMG120404-MMA	0.4	0.18 - 0.30	0.4 - 4.0		●	●		●	●	●	●
	CNMG120408-MMA	0.8	0.20 - 0.45	0.8 - 4.0		●	●		●	●	●	●
	CNMG120412-MMA	1.2	0.22 - 0.45	1.2 - 4.5		●	●		●	●	●	●
	CNMG160608-MMA	0.8	0.22 - 0.50	0.8 - 5.0			●			●	●	
	CNMG160612-MMA	1.2	0.25 - 0.55	1.2 - 5.5		●	●		●	●	●	●
-MRA	CNMG120408-MRA	0.8	0.25 - 0.47	0.8 - 7.0		●				●	●	
	CNMG120412-MRA	1.2	0.28 - 0.63	1.2 - 7.0		●				●	●	
	CNMG120416-MRA	1.6	0.33 - 0.68	1.6 - 7.0		●				●	●	
	CNMG160608-MRA	0.8	0.30 - 0.47	0.8 - 8.0		●				●	●	
	CNMG160612-MRA	1.2	0.31 - 0.63	1.2 - 8.0		●				●	●	
	CNMG160616-MRA	1.6	0.33 - 0.72	1.6 - 8.0		●				●	●	

切削参数 Cutting Parameters

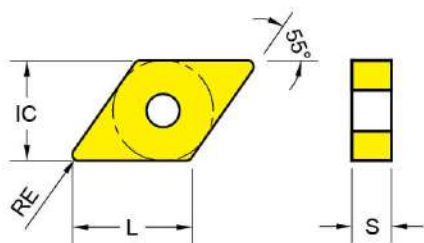
Vc(m/min.)

ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

阿诺 - Loong 龍系列 - 负型 DN 刀片

DNMG (55° Negative)

AHNO Loong Series-Negative Insert DN Series



Series	L	IC	S
DN**1104	11.6	9.525	4.76
DN**1504	15.5	12.7	4.76
DN**1506	15.5	12.7	6.35

DNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PFA	DNMG110404-PFA	0.4	0.10 - 0.24	0.4 - 3.0		●	●		●	●	●	●
	DNMG110408-PFA	0.8	0.15 - 0.30	0.8 - 3.0		●	●		●	●	●	●
	DNMG150404-PFA	0.4	0.15 - 0.24	0.4 - 3.0		●	●		●	●	●	●
	DNMG150408-PFA	0.8	0.15 - 0.30	0.8 - 3.0		●	●		●	●	●	●
	DNMG150604-PFA	0.4	0.15 - 0.24	0.4 - 3.0		●	●		●	●	●	●
	DNMG150608-PFA	0.8	0.15 - 0.30	0.8 - 3.0	●	●	●		●	●	●	●
	DNMG150612-PFA	1.2	0.15 - 0.35	1.2 - 3.5			●		●			●
-PSA	DNMG110404-PSA	0.4	0.15 - 0.24	0.5 - 3.0	●	●	●			●		
	DNMG110408-PSA	0.8	0.15 - 0.35	0.8 - 3.0	●	●	●			●		
	DNMG150404-PSA	0.4	0.15 - 0.25	0.5 - 3.0		●	●			●		
	DNMG150408-PSA	0.8	0.15 - 0.45	0.8 - 3.0		●	●			●		
	DNMG150604-PSA	0.4	0.15 - 0.25	0.5 - 3.0	●	●	●			●	●	
	DNMG150608-PSA	0.8	0.15 - 0.45	0.8 - 3.0	●	●	●	●		●	●	
	DNMG150612-PSA	1.2	0.15 - 0.45	1.2 - 3.0	●	●	●			●		
	DNMG150616-PSA	1.6	0.17 - 0.50	1.6 - 3.5		●	●					

切削参数 Cutting Parameters

Vc(m/min.)

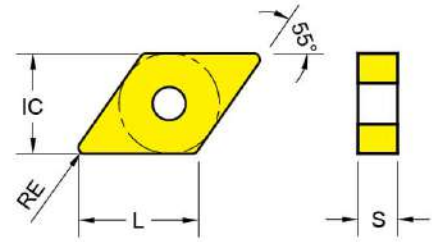
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
M	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
S	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
N	铝 Aluminum	260	75														
	铝合金 Aluminum Alloy	447	130														
H	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

DNMG (55° Negative)

阿诺 - Loong 龍系列 - 负型 DN 刀片

AHNO Loong Series-Negative Insert DN Series

Series	L	IC	S
DN**1104	11.6	9.525	4.76
DN**1504	15.5	12.7	4.76
DN**1506	15.5	12.7	6.35



DNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PMA	DNMG110404-PMA	0.4	0.15 - 0.26	0.5 - 3.0		●	●	●				
	DNMG110408-PMA	0.8	0.17 - 0.52	0.8 - 3.0		●	●	●				
	DNMG110412-PMA	1.2	0.15 - 0.56	1.2 - 3.0		●	●	●				
	DNMG150404-PMA	0.4	0.15 - 0.26	0.5 - 3.0		●	●	●				
	DNMG150408-PMA	0.8	0.17 - 0.52	0.8 - 4.5		●	●	●				
	DNMG150412-PMA	1.2	0.15 - 0.56	1.2 - 4.5		●	●	●				
	DNMG150604-PMA	0.4	0.15 - 0.26	0.5 - 3.0		●	●	●				
	DNMG150608-PMA	0.8	0.17 - 0.52	0.8 - 4.5	●	●	●	●				
-PRA	DNMG150612-PMA	1.2	0.15 - 0.56	1.2 - 4.5	●	●	●	●				
	DNMG150608-PRA	0.8	0.25 - 0.48	2.0 - 4.5	●	●	●					
	DNMG150612-PRA	1.2	0.25 - 0.70	2.0 - 4.5	●	●	●					
	DNMG150616-PRA	1.6	0.30 - 0.80	2.0 - 4.5			●					

切削参数 Cutting Parameters

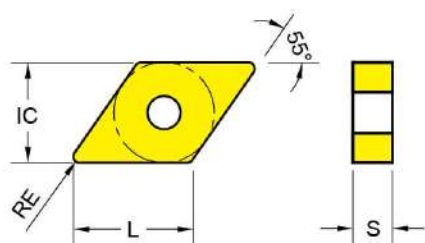
Vc(m/min.)

ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

阿诺 - Loong 龍系列 - 负型 DN 刀片

DNMG (55° Negative)

AHNO Loong Series-Negative Insert DN Series



Series	L	IC	S
DN**1104	11.6	9.525	4.76
DN**1504	15.5	12.7	4.76
DN**1506	15.5	12.7	6.35

DNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-MFA	DNMG110404-MFA	0.4	0.10 - 0.24	0.4 - 2.0		●	●		●	●		●
	DNMG110408-MFA	0.8	0.15 - 0.27	0.8 - 2.0			●		●	●		●
	DNMG150404-MFA	0.4	0.15 - 0.24	0.4 - 2.5			●		●			●
	DNMG150408-MFA	0.8	0.15 - 0.30	0.8 - 3.0		●	●		●			●
	DNMG150604-MFA	0.4	0.15 - 0.24	0.4 - 2.5		●	●		●	●	●	●
	DNMG150608-MFA	0.8	0.15 - 0.30	0.8 - 3.0		●	●		●	●	●	●
-MMA	DNMG150612-MFA	1.2	0.15 - 0.30	1.2 - 3.0		●			●	●		●
	DNMG110404-MMA	0.4	0.15 - 0.24	0.4 - 3.0			●		●	●	●	●
	DNMG110408-MMA	0.8	0.18 - 0.35	0.8 - 3.3			●		●	●	●	●
	DNMG150404-MMA	0.4	0.15 - 0.24	0.4 - 3.5					●			●
	DNMG150408-MMA	0.8	0.20 - 0.40	0.8 - 4.0					●			●
	DNMG150604-MMA	0.4	0.18 - 0.24	0.4 - 3.5		●	●		●	●	●	●
-MRA	DNMG150608-MMA	0.8	0.20 - 0.40	0.8 - 4.0		●	●		●	●	●	●
	DNMG150612-MMA	1.2	0.22 - 0.40	1.2 - 4.0		●	●		●	●	●	●
	DNMG150408-MRA	0.8	0.25 - 0.36	0.8 - 4.0		●				●	●	
	DNMG150604-MRA	0.4	0.17 - 0.18	0.4 - 4.0		●				●	●	
	DNMG150608-MRA	0.8	0.25 - 0.36	0.8 - 4.0		●				●	●	
	DNMG150612-MRA	1.2	0.26 - 0.54	1.2 - 4.0		●				●	●	

切削参数 Cutting Parameters

Vc(m/min.)

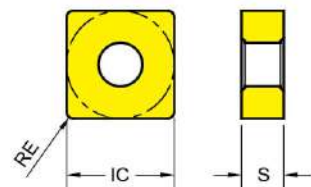
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

SNMG (90° Negative)

阿诺 - Loong 龍系列 - 负型 SN 刀片

AHNO Loong Series-Negative Insert SN Series

Series	L	IC	S
SN**1204	12.7	12.7	4.76
SN**1906	19.05	19.05	6.35



SNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PFA	SNMG120404-PFA	0.4	0.15 - 0.30	0.4 - 3.0		●	●		●	●	●	●
	SNMG120408-PFA	0.8	0.15 - 0.35	0.8 - 3.5		●	●		●	●	●	●
-PSA	SNMG120404-PSA	0.4	0.15 - 0.25	0.5 - 3.0		●	●			●		
	SNMG120408-PSA	0.8	0.15 - 0.45	0.8 - 3.0	●	●	●			●		
	SNMG120412-PSA	1.2	0.15 - 0.45	1.2 - 3.0		●	●					
	SNMG120416-PSA	1.6	0.15 - 0.45	1.6 - 5.0			●					
-PMA	SNMG120408-PMA	0.8	0.17 - 0.52	0.8 - 6.0	●	●	●	●				
	SNMG120412-PMA	1.2	0.15 - 0.56	1.2 - 6.0		●	●	●				
	SNMG120416-PMA	1.6	0.17 - 0.80	1.6 - 6.0			●					
	SNMG190612-PMA	1.2	0.15 - 0.80	1.2 - 8.0		●	●	●				
-PRA	SNMG190616-PMA	1.6	0.17 - 0.80	1.6 - 8.0		●	●	●				
	SNMG120408-PRA	0.8	0.25 - 0.60	2.0 - 6.0	●	●	●	●				
	SNMG120412-PRA	1.2	0.25 - 0.68	2.0 - 6.0	●		●	●				
	SNMG120416-PRA	1.6	0.30 - 0.80	2.0 - 6.0		●	●					
	SNMG190612-PRA	1.2	0.25 - 0.70	2.0 - 9.0	●	●	●					
	SNMG190616-PRA	1.6	0.30 - 0.80	2.0 - 9.0	●	●	●	●				

切削参数 Cutting Parameters

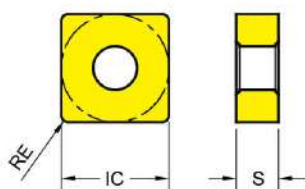
Vc(m/min.)

ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

阿诺 - Loong 龍系列 - 负型 SN 刀片

SNMG (90° Negative)

AHNO Loong Series-Negative Insert SN Series



Series	L	IC	S
SN**1204	12.7	12.7	4.76
SN**1906	19.05	19.05	6.35

SNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-MFA	SNMG120404-MFA	0.4	0.15 - 0.30	0.4 - 3.0			●			●		
	SNMG120408-MFA	0.8	0.15 - 0.30	0.8 - 3.0			●		●	●	●	●
	SNMG120412-MFA	1.2	0.15 - 0.35	1.2 - 3.0					●	●		●
-MMA	SNMG120408-MMA	0.8	0.20 - 0.45	0.8 - 4.5		●	●		●	●	●	●
	SNMG120412-MMA	1.2	0.22 - 0.50	1.2 - 5.0		●	●			●	●	
-MRA	SNMG120408-MRA	0.8	0.25 - 0.40	0.8 - 7.0		●				●	●	
	SNMG120412-MRA	1.2	0.28 - 0.59	1.2 - 7.0		●				●	●	

切削参数 Cutting Parameters

Vc(m/min.)

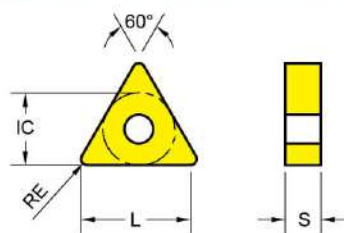
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

TNMG (60° Negative)

阿诺 - Loong 龍系列 - 负型 TN 刀片

Series	L	IC	S
TN**1604	16.5	9.525	4.76

AHNO Loong Series-Negative Insert TN Series



TNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PFA	TNMG160404-PFA	0.4	0.15 - 0.24	0.4 - 3.0		●	●		●	●	●	●
	TNMG160408-PFA	0.8	0.15 - 0.30	0.8 - 3.0		●	●		●	●	●	●
-PSA	TNMG160404-PSA	0.4	0.15 - 0.25	0.5 - 3.0	●	●	●			●	●	
	TNMG160408-PSA	0.8	0.15 - 0.45	0.8 - 3.0	●	●	●			●	●	
	TNMG160412-PSA	1.2	0.15 - 0.45	1.2 - 3.0	●	●	●			●		
-PMA	TNMG160404-PMA	0.4	0.15 - 0.24	0.5 - 3.0		●	●	●				
	TNMG160408-PMA	0.8	0.17 - 0.52	0.8 - 5.0	●	●	●	●				
	TNMG160412-PMA	1.2	0.15 - 0.56	1.2 - 5.0		●	●	●				
-PRA	TNMG160408-PRA	0.8	0.25 - 0.48	0.8 - 5.3	●	●	●	●				
	TNMG160412-PRA	1.2	0.25 - 0.70	2.0 - 6.0	●	●	●	●				
-MFA	TNMG160404-MFA	0.4	0.18 - 0.24	0.4 - 2.5		●	●		●	●	●	●
	TNMG160408-MFA	0.8	0.12 - 0.28	0.8 - 3.0		●	●		●	●	●	●
	TNMG160412-MFA	1.2	0.15 - 0.28	1.2 - 3.0			●		●	●		●
-MMA	TNMG160404-MMA	0.4	0.18 - 0.24	0.4 - 4.0		●	●		●	●	●	●
	TNMG160408-MMA	0.8	0.20 - 0.40	0.8 - 4.0		●	●		●	●	●	●
	TNMG160412-MMA	1.2	0.20 - 0.40	1.2 - 4.0			●		●	●	●	●

切削参数 Cutting Parameters

Vc(m/min.)

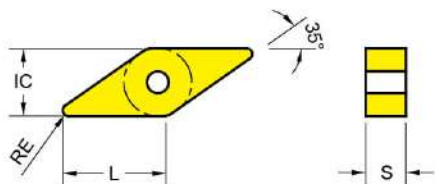
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

阿诺 - Loong 龍系列 - 负型 VN 刀片

VNMG (35° Negative)

AHNO Loong Series-Negative Insert VN Series

Series	L	IC	S
VN**1604	16.5	9.525	4.76



VNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PFA	VNMG160404-PFA	0.4	0.15 - 0.20	0.4 - 2.5	●	●	●		●	●	●	●
	VNMG160408-PFA	0.8	0.15 - 0.30	0.8 - 3.0		●	●		●	●	●	●
-PSA	VNMG160404-PSA	0.4	0.15 - 0.20	0.5 - 3.0	●	●	●			●		
	VNMG160408-PSA	0.8	0.15 - 0.35	0.8 - 3.0	●	●	●			●		
	VNMG160412-PSA	1.2	0.15 - 0.45	1.2 - 3.0		●	●			●		
-PMA	VNMG160404-PMA	0.4	0.05 - 0.20	0.8 - 3.0		●	●	●				
	VNMG160408-PMA	0.8	0.15 - 0.40	0.8 - 3.0	●	●	●	●				
	VNMG160412-PMA	1.2	0.15 - 0.56	1.2 - 3.0			●					
-MFA	VNMG160404-MFA	0.4	0.15 - 0.20	0.4 - 2.0		●	●		●	●		●
	VNMG160408-MFA	0.8	0.12 - 0.25	0.8 - 2.5		●	●		●			●
	VNMG160412-MFA	1.2	0.15 - 0.28	1.2 - 3.0					●	●		●
-MMA	VNMG160404-MMA	0.4	0.15 - 0.20	0.4 - 3.0		●	●		●	●	●	●
	VNMG160408-MMA	0.8	0.20 - 0.30	0.8 - 3.5		●	●		●	●		●
	VNMG160412-MMA	1.2	0.22 - 0.40	1.2 - 3.5					●			●

切削参数 Cutting Parameters

Vc(m/min.)

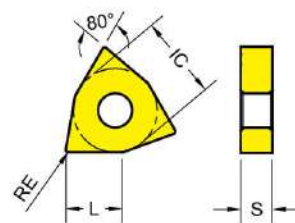
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

WNMG (80° Negative)

阿诺 - Loong 龍系列 - 负型 WN 刀片

AHNO Loong Series-Negative Insert WN Series

Series	L	IC	S
WN**06T3	6.5	9.525	3.97
WN**0604	6.5	9.525	4.76
WN**0804	8.69	12.7	4.76

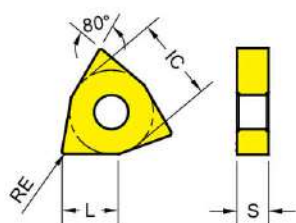


WNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PFA	WNMG060404-PFA	0.4	0.15 - 0.30	0.4 - 3.0		●	●		●	●	●	●
	WNMG060408-PFA	0.8	0.15 - 0.30	0.8 - 3.0		●	●		●	●	●	●
	WNMG080404-PFA	0.4	0.15 - 0.30	0.4 - 3.0	●	●	●		●	●	●	●
	WNMG080408-PFA	0.8	0.15 - 0.35	0.8 - 3.5		●	●		●	●	●	●
	WNMG080412-PFA	1.2	0.15 - 0.35	0.8 - 3.5		●	●		●	●	●	●
-PSA	WNMG06T304-PSA	0.4	0.15 - 0.30	0.5 - 3.0			●			●		
	WNMG06T308-PSA	0.8	0.15 - 0.45	0.8 - 3.0			●					
	WNMG060404-PSA	0.4	0.15 - 0.30	0.5 - 3.0		●	●			●		
	WNMG060408-PSA	0.8	0.15 - 0.35	0.8 - 3.0		●	●			●		
	WNMG060412-PSA	1.2	0.15 - 0.45	1.2 - 3.0		●						
	WNMG080404-PSA	0.4	0.15 - 0.30	0.5 - 3.0	●	●	●			●	●	
	WNMG080408-PSA	0.8	0.15 - 0.45	0.8 - 3.0		●	●			●	●	
	WNMG080412-PSA	1.2	0.15 - 0.45	1.2 - 3.0	●	●	●			●	●	
-PMA	WNMG060404-PMA	0.4	0.15 - 0.26	0.8 - 3.0		●	●	●				
	WNMG060408-PMA	0.8	0.17 - 0.52	0.8 - 4.0	●	●	●	●				
	WNMG080404-PMA	0.4	0.15 - 0.26	0.8 - 3.0		●	●	●				
	WNMG080408-PMA	0.8	0.17 - 0.52	0.8 - 5.6	●	●	●	●				
	WNMG080412-PMA	1.2	0.15 - 0.56	1.2 - 5.6	●	●	●	●				
-PRA	WNMG080408-PRA	0.8	0.25 - 0.60	2.0 - 5.6	●	●	●	●				
	WNMG080412-PRA	1.2	0.25 - 0.68	2.0 - 5.6	●	●	●	●				

阿诺 - Loong 龍系列 - 负型 WN 刀片

WNMG (80° Negative)

AHNO Loong Series-Negative Insert WN Series



Series	L	IC	S
WN**06T3	6.5	9.525	3.97
WN**0604	6.5	9.525	4.76
WN**0804	8.69	12.7	4.76

WNMG	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-MFA	WNMG060404-MFA	0.4	0.15 - 0.28	0.4 - 2.5			●		●	●	●	●
	WNMG060408-MFA	0.8	0.15 - 0.28	0.8 - 3.0		●	●		●	●	●	●
	WNMG080404-MFA	0.4	0.10 - 0.30	0.4 - 2.7		●	●		●	●	●	●
	WNMG080408-MFA	0.8	0.12 - 0.30	0.8 - 3.0		●	●		●	●	●	●
	WNMG080412-MFA	1.2	0.15 - 0.30	1.2 - 3.0						●		
-MMA	WNMG060404-MMA	0.4	0.18 - 0.30	0.4 - 3.0		●	●			●	●	
	WNMG060408-MMA	0.8	0.18 - 0.35	0.8 - 3.5			●		●	●	●	●
	WNMG060412-MMA	1.2	0.20 - 0.40	1.2 - 4.0			●			●		
	WNMG080404-MMA	0.4	0.18 - 0.30	0.4 - 4.0		●	●		●	●	●	●
	WNMG080408-MMA	0.8	0.20 - 0.45	0.8 - 4.0		●	●		●	●	●	●
-MRA	WNMG080412-MMA	1.2	0.22 - 0.45	1.2 - 4.5		●	●		●	●	●	●
	WNMG080404-MRA	0.4	0.17 - 0.23	0.4 - 4.0		●				●	●	
	WNMG080408-MRA	0.8	0.25 - 0.47	0.8 - 5.0		●				●	●	
	WNMG080412-MRA	1.2	0.28 - 0.63	1.2 - 5.0		●				●	●	

切削参数 Cutting Parameters

Vc(m/min.)

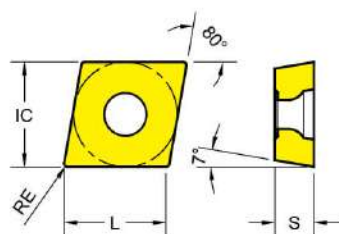
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
M	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
S	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
N	铝 Aluminum	260	75														
	铝合金 Aluminum Alloy	447	130														
H	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

CCGT/CCMT (80° Positive)

阿诺 - Loong 龍系列 - 正型 CC 刀片

AHNO Loong Series-Positive Insert CC Series

Series	L	IC	S
CC**0602	6.45	6.35	2.38
CC**09T3	9.67	9.525	3.97
CC**1204	12.9	12.7	4.76



CCGT/CCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PFA	CCGT09T302-PFA	0.2	0.04 - 0.15	0.2 - 2.5			●			●		
	CCMT060202-PFA	0.2	0.02 - 0.12	0.2 - 1.5		●	●			●		
	CCMT060204-PFA	0.4	0.05 - 0.20	0.3 - 2.5		●	●	●		●		
	CCMT09T304-PFA	0.4	0.06 - 0.24	0.3 - 3.0		●	●	●		●		
-PMA	CCMT09T308-PFA	0.8	0.08 - 0.28	0.6 - 3.0		●	●			●		
	CCMT09T304-PMA	0.4	0.04 - 0.25	0.4 - 3.0		●	●		●			●
	CCMT09T308-PMA	0.8	0.10 - 0.35	0.8 - 4.0		●	●	●	●	●		●
	CCMT120408-PMA	0.8	0.15 - 0.35	0.8 - 4.5		●	●	●		●		
-PRA	CCMT09T304-PRA	0.4	0.15 - 0.30	1.0 - 4.0		●	●					
	CCMT09T308-PRA	0.8	0.20 - 0.40	1.5 - 4.0		●	●	●				
	CCMT120408-PRA	0.8	0.20 - 0.40	1.5 - 4.5		●	●					
	CCMT120412-PRA	1.2	0.20 - 0.50	1.5 - 4.5		●	●	●				

切削参数 Cutting Parameters

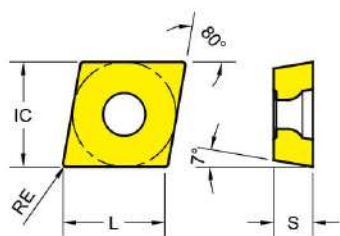
Vc(m/min.)

ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

阿诺 - Loong 龍系列 - 正型 CC 刀片

CCGT/CCMT (80° Positive)

AHNO Loong Series-Positive Insert CC Series



Series	L	IC	S
CC**0602	6.45	6.35	2.38
CC**09T3	9.67	9.525	3.97
CC**1204	12.9	12.7	4.76

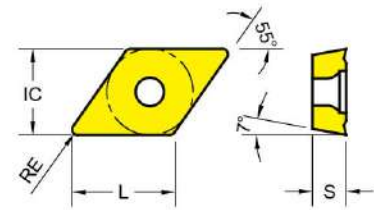
CCGT/CCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-UFA	CCMT060202-UFA	0.2	0.10 - 0.15	0.2 - 2.0		●	●			●	●	
	CCMT060204-UFA	0.4	0.15 - 0.26	0.4 - 2.0		●	●			●	●	
	CCMT060208-UFA	0.8	0.15 - 0.50	0.8 - 2.0		●	●			●	●	
	CCMT09T304-UFA	0.4	0.15 - 0.26	0.4 - 2.0	●	●	●			●	●	
	CCMT09T308-UFA	0.8	0.15 - 0.50	0.8 - 3.0	●	●	●			●	●	
	CCMT120404-UFA	0.4	0.15 - 0.26	0.4 - 3.0		●	●			●	●	
	CCMT120408-UFA	0.8	0.15 - 0.50	0.8 - 4.0		●	●			●	●	
	CCMT120412-UFA	1.2	0.15 - 0.50	1.2 - 4.0		●	●			●	●	
-USA	CCMT060202-USA	0.2	0.10 - 0.15	0.2 - 1.0		●	●			●	●	
	CCMT060204-USA	0.4	0.12 - 0.18	0.3 - 1.5		●	●			●	●	
	CCMT060208-USA	0.8	0.15 - 0.30	0.5 - 2.0		●	●	●		●	●	
	CCMT09T302-USA	0.2	0.10 - 0.15	0.2 - 3.0		●	●			●	●	
	CCMT09T304-USA	0.4	0.15 - 0.26	0.3 - 3.0		●	●			●	●	
	CCMT09T308-USA	0.8	0.15 - 0.35	0.5 - 3.0		●	●			●	●	
	CCMT120404-USA	0.4	0.15 - 0.26	0.4 - 4.0		●	●			●	●	
	CCMT120408-USA	0.8	0.15 - 0.35	0.5 - 4.0		●	●			●	●	
-URA	CCMT120412-USA	1.2	0.15 - 0.45	0.8 - 4.0			●					
	CCMT09T304-URA	0.4	0.15 - 0.30	1.0 - 4.0							●	
	CCMT09T308-URA	0.8	0.20 - 0.40	1.5 - 4.0							●	
	CCMT120408-URA	0.8	0.20 - 0.40	1.5 - 4.5							●	

DCGT/DCMT (55° Positive)

阿诺 - Loong 龍系列 - 正型 DC 刀片

Series	L	IC	S
DC**0702	7.75	6.35	2.38
DC**11T3	11.63	9.525	3.97

AHNO Loong Series-Positive Insert DC Series



DCGT/DCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PFA	DCGT11T302-PFA	0.2	0.02 - 0.15	0.2 - 2.5			●			●		
	DCMT070202-PFA	0.2	0.02 - 0.12	0.2 - 1.5			●			●		
	DCMT070204-PFA	0.4	0.05 - 0.20	0.3 - 2.0		●	●			●		
	DCMT070208-PFA	0.8	0.06 - 0.25	0.6 - 2.0		●	●			●		
	DCMT11T304-PFA	0.4	0.05 - 0.24	0.3 - 2.5		●	●	●		●		
	DCMT11T308-PFA	0.8	0.08 - 0.25	0.6 - 3.0		●	●			●		
-PMA	DCMT070204-PMA	0.4	0.04 - 0.24	0.2 - 2.1		●	●		●	●		●
	DCMT11T304-PMA	0.4	0.04 - 0.28	0.2 - 2.8		●	●	●	●	●		●
	DCMT11T308-PMA	0.8	0.10 - 0.30	0.6 - 2.8		●	●	●	●	●		●
	DCMT11T312-PMA	1.2	0.12 - 0.30	1.0 - 2.8			●					
	DCMT150408-PMA	0.8	0.10 - 0.30	0.6 - 3.5		●						
-PRA	DCMT11T304-PRA	0.4	0.15 - 0.24	1.0 - 3.3		●	●					
	DCMT11T308-PRA	0.8	0.15 - 0.40	1.0 - 3.3		●	●					
	DCMT11T312-PRA	1.2	0.15 - 0.45	1.5 - 3.3		●	●					

切削参数 Cutting Parameters

Vc(m/min.)

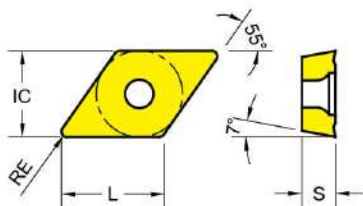
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

阿诺 - Loong 龍系列 - 正型 DC 刀片

DCGT/DCMT (55° Positive)

AHNO Loong Series-Positive Insert DC Series

Series	L	IC	S
DC**0702	7.75	6.35	2.38
DC**11T3	11.63	9.525	3.97



DCGT/DCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-UFA	DCMT070202-UFA	0.2	0.08 - 0.12	0.2 - 1.0		●	●			●		
	DCMT070204-UFA	0.4	0.15 - 0.24	0.4 - 2.0		●	●			●		
	DCMT11T302-UFA	0.2	0.08 - 0.12	0.2 - 2.0		●	●			●		
	DCMT11T304-UFA	0.4	0.15 - 0.24	0.4 - 2.0		●	●		●	●	●	●
	DCMT11T308-UFA	0.8	0.15 - 0.30	0.8 - 2.0		●	●			●	●	
	DCMT11T312-UFA	1.2	0.15 - 0.30	1.2 - 2.0		●	●					
-USA	DCMT070202-USA	0.2	0.08 - 0.12	0.2 - 1.0		●	●			●		
	DCMT070204-USA	0.4	0.15 - 0.24	0.2 - 2.0		●	●			●	●	
	DCMT11T302-USA	0.2	0.08 - 0.12	0.2 - 2.0		●	●			●		
	DCMT11T304-USA	0.4	0.15 - 0.24	0.3 - 3.0	●	●	●			●	●	
	DCMT11T308-USA	0.8	0.15 - 0.30	0.5 - 3.0	●	●	●			●	●	
	DCMT11T312-USA	1.2	0.20 - 0.40	0.9 - 3.3		●	●					
-URA	DCMT11T304-URA	0.4	0.15 - 0.24	1.0 - 3.3							●	
	DCMT11T308-URA	0.8	0.15 - 0.40	1.0 - 3.3							●	
	DCMT11T312-URA	1.2	0.15 - 0.45	1.5 - 3.3							●	

切削参数 Cutting Parameters

Vc(m/min.)

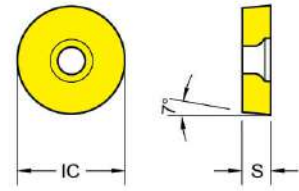
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

RCMT (Positive)

Series	IC	S
RC**0602	6.0	2.38
RC**0803	8.0	3.18
RC**10T3	10.0	3.97
RC**1204	12.0	4.76

阿诺 - Loong 龍系列 - 正型 RC 刀片

AHNO Loong Series-Positive Insert RC Series



RCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-UFA	RCMT0602M0-UFA	-	0.15 - 0.40	0.2 - 1.5		●	●		●	●		●
	RCMT0803M0-UFA	-	0.15 - 0.50	0.3 - 3.0		●	●		●	●		●
	RCMT10T3M0-UFA	-	0.15 - 0.60	0.4 - 4.0		●	●		●	●		●
	RCMT1204M0-UFA	-	0.17 - 1.00	0.5 - 4.8		●	●		●	●		●
-USA	RCMT0602M0-USA	-	0.15 - 0.60	0.3 - 2.4		●	●			●		
	RCMT0803M0-USA	-	0.15 - 0.80	0.5 - 3.0		●	●			●		
	RCMT10T3M0-USA	-	0.30 - 1.00	0.7 - 4.0		●	●			●		
	RCMT1204M0-USA	-	0.30 - 1.00	0.7 - 4.8		●	●			●		

切削参数 Cutting Parameters

Vc(m/min.)

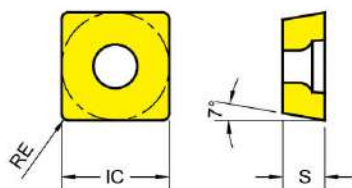
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

阿诺 - Loong 龍系列 - 正型 SC 刀片

SCMT (90° Positive)

AHNO Loong Series-Positive Insert SC Series

Series	L	IC	S
SC**09T3	9.525	9.525	3.97
SC**1204	12.7	12.7	4.76



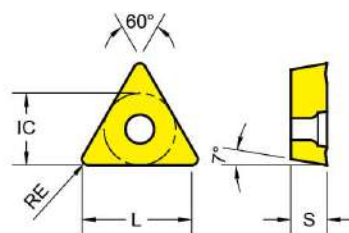
SCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	
-PFA	SCMT09T304-PFA	0.4	0.06 - 0.24	0.3 - 3.0			●					
	SCMT09T308-PFA	0.8	0.08 - 0.28	0.6 - 3.0			●					
-PMA	SCMT09T304-PMA	0.4	0.06 - 0.25	0.4 - 3.0			●			●		
	SCMT09T308-PMA	0.8	0.10 - 0.35	0.8 - 3.5		●	●	●		●		
-PRA	SCMT09T308-PRA	0.8	0.20 - 0.40	1.5 - 4.0		●	●					
	SCMT120408-PRA	0.8	0.20 - 0.40	1.5 - 4.5		●	●					
-UFA	SCMT09T304-UFA	0.4	0.15 - 0.30	0.4 - 3.0		●	●			●		
	SCMT09T308-UFA	0.8	0.15 - 0.50	0.8 - 3.0		●	●			●		
	SCMT120408-UFA	0.8	0.15 - 0.50	0.8 - 4.0		●	●			●		
	SCMT120412-UFA	1.2	0.15 - 0.50	1.2 - 4.0			●					
-USA	SCMT09T304-USA	0.4	0.15 - 0.30	0.3 - 3.0		●	●			●	●	
	SCMT09T308-USA	0.8	0.15 - 0.35	0.5 - 3.0		●	●			●	●	
	SCMT120404-USA	0.4	0.15 - 0.30	0.4 - 4.0		●	●			●		
	SCMT120408-USA	0.8	0.15 - 0.30	0.5 - 4.0		●	●			●	●	
	SCMT120412-USA	1.2	0.15 - 0.45	0.8 - 4.0		●	●			●		
-URA	SCMT09T308-URA	0.8	0.20 - 0.40	1.5 - 4.0							●	
	SCMT120408-URA	0.8	0.20 - 0.40	1.5 - 4.5							●	

TCMT (60° Positive)

阿诺 - Loong 龍系列 - 正型 TC 刀片

Series	L	IC	S
TC**06T1	6.87	3.97	1.98
TC**0902	9.62	5.56	2.38
TC**1102	11.0	6.35	2.38
TC**16T3	16.5	9.525	3.97

AHNO Loong Series-Positive Insert TC Series



TCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PFA	TCMT06T102-PFA	0.2	0.04 - 0.12	0.2 - 1.5		●						
	TCMT06T104-PFA	0.4	0.04 - 0.12	0.3 - 2.0		●	●			●		
	TCMT090204-PFA	0.4	0.06 - 0.23	0.3 - 2.5		●	●			●		
	TCMT110204-PFA	0.4	0.06 - 0.24	0.3 - 3.0		●	●	●		●		
	TCMT110208-PFA	0.8	0.08 - 0.28	0.6 - 3.0		●	●			●		
	TCMT16T304-PFA	0.4	0.06 - 0.24	0.3 - 3.0		●	●	●		●		
	TCMT16T308-PFA	0.8	0.08 - 0.28	0.6 - 3.0		●	●	●		●		
-PMA	TCMT110204-PMA	0.4	0.04 - 0.24	0.3 - 2.5			●					
	TCMT110208-PMA	0.8	0.10 - 0.30	0.6 - 3.0			●	●				
	TCMT16T308-PMA	0.8	0.10 - 0.35	0.8 - 3.5			●	●		●		
-PRA	TCMT16T308-PRA	0.8	0.15 - 0.40	1.0 - 4.0		●	●	●				
	TCMT16T312-PRA	1.2	0.15 - 0.45	1.5 - 4.5		●	●					

切削参数 Cutting Parameters

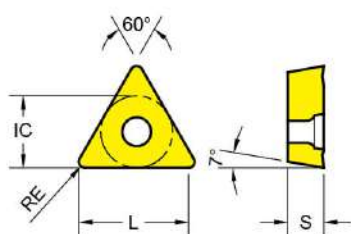
Vc(m/min.)

ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
M		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
S	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
	铝 Aluminum	260	75														
N	铝合金 Aluminum Alloy	447	130														
	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
H	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

阿诺 - Loong 龍系列 - 正型 TC 刀片

TCMT (60° Positive)

AHNO Loong Series-Positive Insert TC Series



Series	L	IC	S
TC**06T1	6.87	3.97	1.98
TC**0902	9.62	5.56	2.38
TC**1102	11.0	6.35	2.38
TC**16T3	16.5	9.525	3.97

TCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-UFA	TCMT110204-UFA	0.4	0.15 - 0.24	0.4 - 2.0		●	●			●		
	TCMT16T304-UFA	0.4	0.15 - 0.24	0.4 - 3.0		●	●			●		
	TCMT16T308-UFA	0.8	0.15 - 0.30	0.8 - 3.0		●	●			●		
-USA	TCMT110202-USA	0.2	0.08 - 0.12	0.2 - 2.0		●	●			●	●	
	TCMT110204-USA	0.4	0.15 - 0.24	0.2 - 2.0		●	●			●	●	
	TCMT110208-USA	0.8	0.15 - 0.30	0.5 - 2.5		●	●			●		
	TCMT16T304-USA	0.4	0.15 - 0.24	0.3 - 3.0		●	●			●	●	
-URA	TCMT16T308-USA	0.8	0.15 - 0.30	0.5 - 3.0		●	●			●	●	
	TCMT16T308-URA	0.8	0.15 - 0.40	1.0 - 4.0							●	

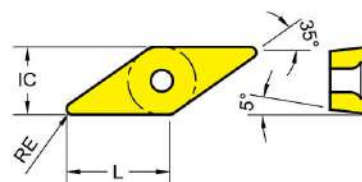
切削参数 Cutting Parameters				Vc(m/min.)													
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
M	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
S	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
N	铝 Aluminum	260	75														
	铝合金 Aluminum Alloy	447	130														
H	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

VBMT/VCMT (35° Positive)

阿诺 - Loong 龍系列 - 正型 VB 刀片

AHNO Loong Series-Positive Insert VB Series

Series	L	IC	S
VB**1102	11.1	6.35	2.38
VB**1103	11.1	6.35	3.18
VB**1604	16.6	9.525	4.76

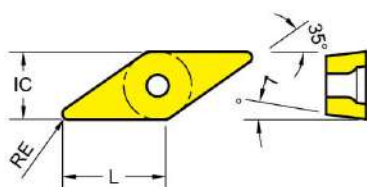


VBMT/VCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-PFA	VBMT160404-PFA	0.4	0.06 - 0.20	0.3 - 2.5		●	●	●		●		
-PMA	VBMT160404-PMA	0.4	0.04 - 0.20	0.2 - 2.8		●	●	●	●	●		●
	VBMT160408-PMA	0.8	0.10 - 0.25	0.6 - 3.0		●	●	●	●	●		●
	VBMT160412-PMA	1.2	0.20 - 0.40	1.0 - 3.0		●	●					
-PRA	VBMT160404-PRA	0.4	0.15 - 0.20	0.8 - 3.6		●	●					
	VBMT160408-PRA	0.8	0.15 - 0.35	1.0 - 3.6		●	●					
	VBMT160412-PRA	1.2	0.15 - 0.40	1.2 - 3.6		●	●					
-UFA	VBMT110204-UFA	0.4	0.15 - 0.20	0.4 - 2.0						●		
	VBMT160404-UFA	0.4	0.15 - 0.20	0.4 - 2.0	●	●	●			●		
	VBMT160408-UFA	0.8	0.15 - 0.30	0.8 - 3.0	●	●	●		●	●		●
	VBMT160412-UFA	1.2	0.15 - 0.30	1.2 - 3.0	●	●	●			●		
-USA	VBMT110302-USA	0.2	0.07 - 0.10	0.2 - 2.0			●			●		
	VBMT110304-USA	0.4	0.15 - 0.20	0.4 - 2.0		●	●			●	●	
	VBMT110308-USA	0.8	0.15 - 0.25	0.8 - 2.5		●	●			●		
	VBMT160402-USA	0.2	0.07 - 0.10	0.2 - 2.0		●	●			●		
	VBMT160404-USA	0.4	0.15 - 0.20	0.4 - 2.0		●	●			●	●	
	VBMT160408-USA	0.8	0.15 - 0.30	0.8 - 2.5	●	●	●	●	●	●	●	●
	VBMT160412-USA	1.2	0.20 - 0.40	1.2 - 3.0		●	●			●		
-URA	VBMT160404-URA	0.4	0.15 - 0.20	0.8 - 3.6							●	
	VBMT160408-URA	0.8	0.15 - 0.35	1.0 - 3.6							●	
	VBMT160412-URA	1.2	0.15 - 0.40	1.2 - 3.6							●	

阿诺 - Loong 龍系列 - 正型 VC 刀片

VCMT (35° Positive)

AHNO Loong Series-Positive Insert VC Series



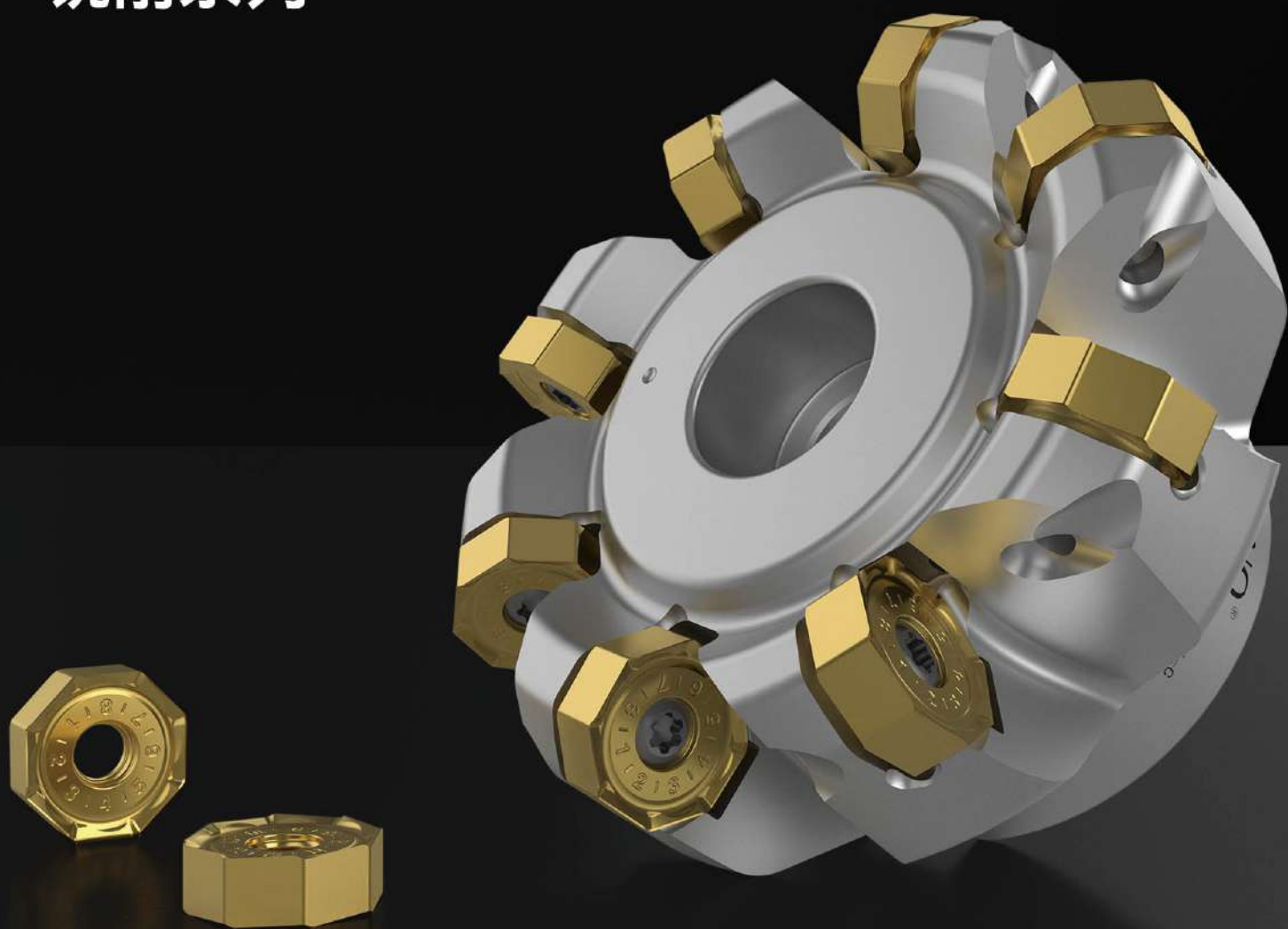
Series	L	IC	S
VC**1103	11.1	6.35	3.18
VC**1604	16.6	9.525	4.76

VBMT/VCMT	型号 Type	RE	Fn (mm/rev.)	Ap (mm)	P				M			S
					ACP05A	ACP10A	ACP20A	ACP30A	APS05A	ACM20A	ACM30A	APS05A
-UFA	VCMT110304-UFA	0.4	0.15 - 0.20	0.4 - 2.0		●	●			●		
	VCMT110308-UFA	0.8	0.15 - 0.25	0.8 - 2.0		●	●			●		
	VCMT160404-UFA	0.4	0.15 - 0.20	0.4 - 2.0		●	●			●		
	VCMT160408-UFA	0.8	0.15 - 0.30	0.8 - 3.0		●	●			●		
-USA	VCMT160404-USA	0.4	0.15 - 0.20	0.4 - 2.0		●	●			●		
	VCMT160408-USA	0.8	0.15 - 0.30	0.8 - 2.5		●	●			●		

切削参数 Cutting Parameters				Vc(m/min.)													
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm²)	布氏硬度 (HB)	ACP05A		ACP10A		ACP20A		ACP30A		APS05A		ACM20A		ACM30A	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	低碳钢, 碳素钢 Low Carbon Steel, Carbon Steel	<600	<180	250	500	200	450	180	400	160	360						
		<950	<280	225	360	200	320	150	300	100	240						
	低合金钢 Low-alloyed Steel	700-950	200-280	120	320	90	300	75	270	60	200						
	高合金钢 High-alloyed Steel	950-1200	280-355	120	240	100	225	75	180	50	150	80	125	60	100	50	80
		1200-1400	355-415	60	80	55	75	40	60	-	-	75	100	40	75	-	-
M	奥氏体不锈钢 Austenitic	675	200									120	240	150	240	125	225
	双相不锈钢 Duplex Stainless Steel	778	230									100	160	125	160	105	150
	沉淀硬化不锈钢 PH Stainless Steel	1013	300									80	150	120	150	100	125
K	灰口铸铁 Grey Cast Iron	700	220	270	500	240	450	225	400	200	360	180	240				
	球墨铸铁 Nodular Cast Iron	880	260	240	500	200	450	180	400	160	360	160	200				
	可锻铸铁 Malleable Cast Iron	800	250	225	360	200	320	150	300	100	240	-	-				
S	钴基合金, 镍基合金 Cobalt Base Alloy, Nickel Base Alloy	1100	250-320									45	90	40	75	-	-
	钛合金 Titanium Alloy	1260	370									40	80	30	60	-	-
N	铝 Aluminum	260	75														
	铝合金 Aluminum Alloy	447	130														
H	淬硬钢 Hardened Steel	-	50-60HRC									30	45				
	淬硬铸铁 Hardened Cast Iron	-	55HRC									30	40				

MILLING SERIES

铣削系列



Milling Insert Name Code

铣削用可转位刀片按照 ISO 1832 标准的符号说明

Turning Inserts according to ISO 1832 Standard Code System

示例 1:

Example 1:

H	N	G	X	09	06	ANSN
1	2	3	4	5	6	7

1、刀片形状

1. Insert shape

代号 Symbol	图形 Shape	代号 Symbol	图形 Shape
A		M	
B		O	
C		P	
D		R	
E		S	
H		T	
K		V	
L		W	

3、公差

3. Tolerance

允许公差 (mm) Tolerance	d	m	s
	A	± 0,025	± 0,005
	C	± 0,025	± 0,013
	E	± 0,025	± 0,025
	F	± 0,013	± 0,005
	G	± 0,025	± 0,025
	H	± 0,013	± 0,013
	J ¹	± 0,05-0,15 ²	± 0,005
	K ¹	± 0,05-0,15 ²	± 0,013
	L ¹	± 0,05-0,15 ²	± 0,025
	M	± 0,05-0,15 ²	± 0,08-0,20 ²
	N	± 0,05-0,15 ²	± 0,08-0,20 ²
	U	± 0,08-0,25 ²	± 0,13-0,38 ²

¹ 刀片有精磨的副切削刃
The insert has finishing minor cutting edge

² 视刀片尺寸而定 (见 ISO 1832 标准)
Tolerance is different by insert size. Please see ISO 1832

2、后角

2. Relief Angle

代号 Symbol	图形 Shape	代号 Symbol	图形 Shape
A		N	
B		P	
C			
D			
E			
F			
G			

4、刀片加工和固定特征

4. Insert Machining and Figure

代号 Symbol	图形 Shape	代号 Symbol	图形 Shape	代号 Symbol	图形 Shape
A		H		R	
B		J		T	
C		M		U	
F		N		W	
G		Q		X	需要可转位刀片的图纸 或准确说明 Indexable insert drawing or detailed description is needed

- M5

8

5、切削刃长度

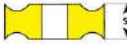
5. Cutting Edge Length

¹ 英制规格 (00) Inch

刀片形状 Insert Shape															
内切圆直径 d IC Diameter d															
mm	英寸	规格 Size	I	规格 Size	I	规格 Size	I	规格 Size	I	规格 Size	I	规格 Size	I	规格 Size	I
3,97	5/32									06	6,9				
5	0,197					05								03	3,8
5,56	7/32									09	9				
6	0,236					06									
6,35	2/8	06	6,4	07	7,7	06 ¹				11	11	11	11	04	4,3
8	0,315					08								05	5,2
9,525	3/8	09	9,6	11	11,6	09 ¹		09	9,5	16	16,5	16	16,5	06	6,5
10	0,394					10									
12	0,472					12									
12,7	4/8	12	12,9	15	15,5	12 ¹		12	12,7	22	22	22	22,1	08	8,7
15,875	5/8	16	16,1					15	15,8	27	27			10	10,8
16	0,63					16									
17,46	11/16													12	11,6
19,05	6/8	19	19,3			19 ¹		19	19,0						
20	0,787					20									
25	0,984					25									
25,4	8/8	25	25,8			25 ¹		25	25,4						
32	1,26					32									

6、刀片厚度

6. Insert Thickness

图形 Figure	厚度 s(mm) Thickness
	01 1,59
	T1 1,98
	02 2,38
	T2 2,78
	03 3,18
	T3 3,97
	04 4,76
	05 5,56
	06 6,35
	07 7,94
	09 9,52

7-1、刀尖圆角半径

7-1. Corner Radius

图形 Shape	半径 r(mm) Radius
	01 0,1
	02 0,2
	04 0,4
	08 0,8
	12 1,2
	16 1,6
	24 2,4
	M0 用于公制直径尺寸 For metric diameter
	00 用于已转换为 mm 的英制直径尺寸 For inch diameter converted to mm

7-2、主偏角

7-2. Cutting Edge Angle

代号 Symbol	角度 Angle
P	90°
A	45°
D	60°
E	75°
F	85°
Z	其他主偏角 Other Cutting Edge Angles

7-3、副切削刃后角

7-3. Wiper Edge Relief Angle

代号 Symbol	角度 Angle
N	0°
P	11°
D	15°
E	20°
F	25°
Z	后角 Relief Angle

7-4、切削刃形状

7-4. Cutting Edge Shape

代号 Symbol	图形 Figure
F	
E	
T	
S	

7-5、切削方向

7-5. Feed Direction

代号 Symbol	图形 Figure
R	
L	
N	

Milling Insert Name Code

槽型介绍

Chipbreaker Introduction

示例 1:

Example 1:



8、槽型索引

8. Type Index

铣削槽型 Milling Chipbreaker	刃口示意 Edge Geometry	槽型说明 Chipbreaker Description	铣削槽型 Milling Chipbreaker	刃口示意 Edge Geometry	槽型说明 Chipbreaker Description
-F2		轻切削加工槽型 Light Cutting Chipbreaker	-M6		刃口倒圆槽型 Cutting Edge Rounding Chipbreaker
-F5		粗糙度优先型 Roughness First	-R5		通用高强度加工槽型 Universal High Strength Machining Chipbreaker
-M4		低阻力型 Low Resistance	-R6		刃口负倒棱槽型 Cutting Edge Negative Chamfered Chipbreaker
-M5		通用中等加工 General Medium Machining	-M7		通用中高强度加工 General Medium & High Strength Machining

8-1、槽型代号

8-1. Chipbreaker Code

代号 Symbol	用途 Application
F	精加工 Finishing
	轻切削 / 切削力优先 Light Cutting / Cutting Strength First
S	半精加工 Semi Finishing
M	中等加工 Medium Machining
R	粗加工 Roughing
	寿命优先 Service Life First
H	重切削 Heavy Machining
W	Wiper 修光刃 Wiper Edge

8-2、功能代号

8-2. Function Code

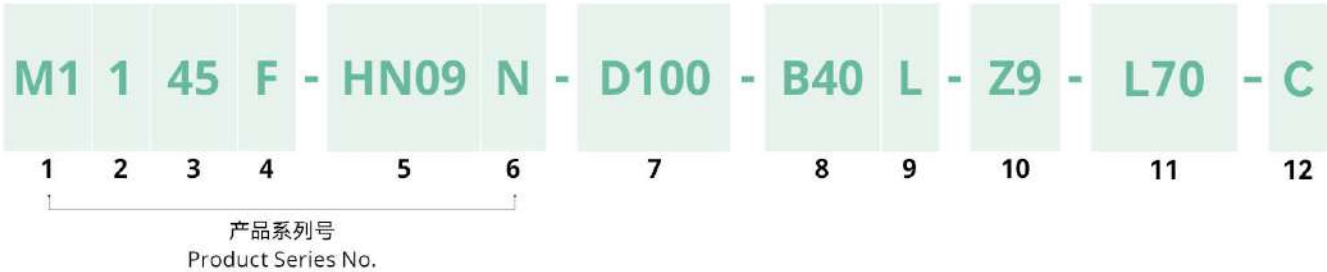
代号 Symbol
2
4
5
6
7

A	P	P	25	A
1	2	3	4	5

功能序号 Function No.	说明 Description	详情 Details			
1	AHNO 阿诺				
2	基础材料及 涂层代码 Basic Materials & Coating Code	C	硬质合金 +CVD Carbide +CVD	V	金属陶瓷 +PVD Cermet +PVD
		P	硬质合金 +PVD Carbide + PVD	I	塞隆陶瓷 Sialon Ceramics
		B	CBN	W	晶须陶瓷 Whisker Ceramics
		D	PCD	N	硬质合金无涂层 Cemented Carbide Uncoated
		T	金属陶瓷 Cermet		
3	第一推荐应用 First Recommended Application	P	钢 Steel	S	难加工材料 Hard-to-machine Materials
		M	不锈钢 Stainless Steel	H	硬材料 Hard Materials
		K	铸铁 Cast Iron	U	通用 General
	ISO 应用范围 ISO Application Range	N	有色金属 Nonferrous Metals		
4	ISO 应用范围 ISO Application Range	0515253545 耐磨性 Wear Resistance 韧性 Toughness			
	代次代码 Generation Code				
5	代次代码	A: 阿诺 -Loong 龍系列材质 A: AHNO-Loong series grade			

Milling Name Code

示例 1:
Example 1:



1、刀具产品系列
1. Product Series

代号 Symbol	切削方式 Cutting Method	系列号 Series Number
MF	面铣 Face Milling	M1
MS	方肩铣刀 Shoulder Milling	M2
MH	快进给 High Feed	M3
MP	仿形 Profiling	M4
MD	三面刃 Three-side Edge	M5
MT	螺纹铣刀 Thread Milling	M6
MC	倒角 Chamfer	M7
PE	玉米铣 Corn Milling	M9

2、代次
2. Generation

系列代次 Method

3、主偏角 (Kr)
3. Cutting Edge Angle

数值 Value	角度 Angle
90	90
88	88
75	75
60	60
.	.
.	.
15	15
00	圆刀片 Circular Insert

4、刀刃类型
4. Cutting Edge Type

代号 Symbol	微调节刃 Micro Adjusting Edge
F	带微调节刃 With Micro Adjusting Edge

5、刀片
5. Insert

刀片型号 Insert Type

6、刀盘类型
6. Milling Cutter Type

代号 Symbol	楔块式刀盘 Wedge Milling Cutter
N	带楔块式刀盘 With Wedge Milling Cutter

7、直径
7. Diameter

刀具直径 Tool Diameter

8、接口
8. Interface

代号 Symbol	连接方式 Connection Method
B	芯轴式 Arbor
W	侧固式 Weldon
A	圆柱式 Cylindrical
M	螺纹接口 Threading Interface

9、切削方向
9. Cutting Direction

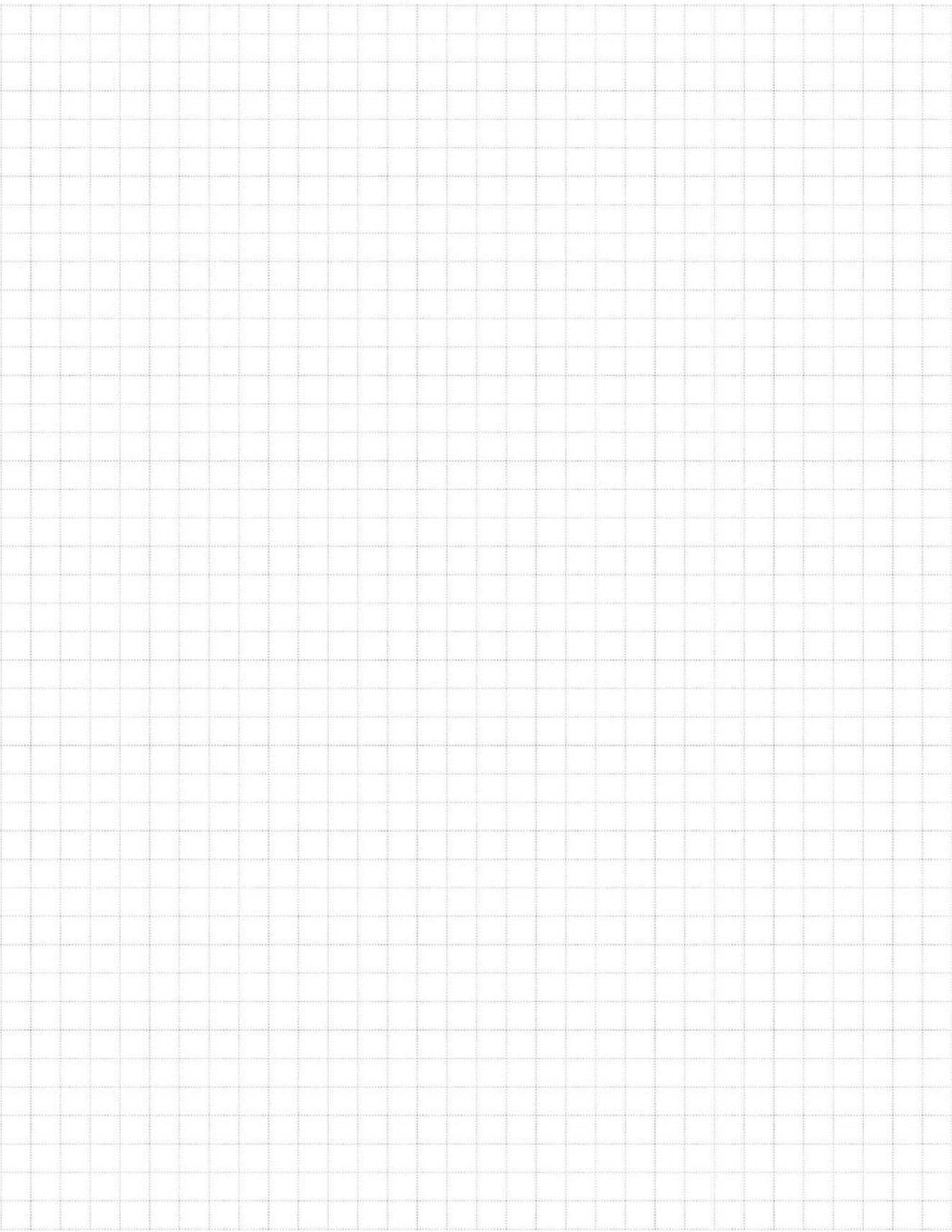
代号 Symbol	旋向 Rotation Direction
R	右手(缺省) Right-hand (Default)
L	左手 Left-hand

10、齿数
10. Number of Teeth

刀体齿数 Milling Cutter Number of Teeth

11、长度
11. Length

代号 Symbol	类型 Type
C	带内冷 With internal coolant
无标记 Unmarked	不带内冷 Without internal coolant



AHNO Loong Series-Milling Materials

铣削材质一览

Milling Materials Overview

铣削材料应用 Turning Materials Application														
铣削材质 Milling Materials	ISO 组别 ISO Group	涂层工艺 Coating Technology	工件材料组别 Workpiece Material Group						应用范围 Application Range					技术说明 Technology Description
			P	M	K	S	N	H	05	15	25	35	45	
ACP25A	P15~P25	CVD	●							●			铣削通用材质，高强度基体搭载中温化学涂层，实现了耐磨性和韧性的均衡结合，适用于加工钢和铸铁材料，尤其是较高线速度的应用场合。 Milling general materials and high-strength matrix with medium-temperature chemical coatings achieve a balanced combination of wear resistance and toughness, which are used in the machining of steel and cast iron, especially for high linear speeds cutting applications.	
	K20~K30				●					●				
APP25A	P25~P35	PVD	●							●			多功能的铣削材质，具有良好的热稳定性，广泛应用于各类钢、球铁以及不锈钢材料，是通用铣削的最佳选择。 The multifunctional milling material with good thermal stability is widely used in all kinds of steel, ductile iron and stainless steel materials, the best choice for general milling.	
	M20~M30			●						●				
	K25~K35				●					●				
APU35A	P30~P40	PVD	●							●			多功能的铣削材质，凭借高韧性的基体以及领先的物理涂层技术，即使面对不利的加工条件，依然能够保持良好的可靠性，有效覆盖了钢、不锈钢以及部分难加工材料的切削。 The multifunctional milling material, with high-toughness matrix and leading physical coating technology, can maintain good reliability even in the face of adverse processing conditions, covering the cutting of steel, stainless steel and some difficult-to-machine materials.	
	M25~M35			●						●				
	S20~S30					●				●				

● 第一推荐 1st choice ● 第一推荐 2nd choice

铣削材质一览

Milling Materials Overview

被加工材料组 Work Material Group		刀具材质 Tool Material	涂层类型 Coating Class	应用类别 Application Category				
				05	15	25	35	45
P	碳素钢 / 合金钢 Carbon Steel / Alloyed Steel	硬质合金 Carbide	CVD		ACP25A			
		硬质合金 Carbide	PVD			APP25A		
		硬质合金 Carbide	PVD			APU35A		
M	不锈钢 Stainless Steel	硬质合金 Carbide	PVD		APP25A			
		硬质合金 Carbide	PVD			APU35A		
K	铸铁 Cast Iron	硬质合金 Carbide	CVD		ACP25A			
		硬质合金 Carbide	PVD			APP25A		
S	铝合金 Aluminum Alloy	-	-					
	高温合金 / 钛合金 High Temperature Alloy Titanium Alloys	硬质合金 Carbide	PVD		APU35A			
	硬材料 Hard Materials	-	-					

AHNO Loong Series-Milling Catalog

合金刀片类

Alloy Insert Series

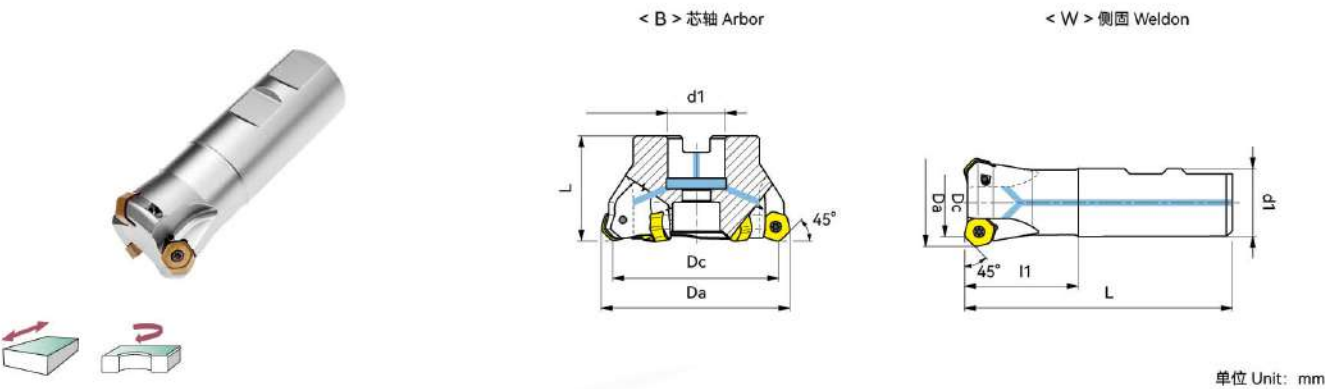
系列 Series			M1345-HN06	M1345-HN09	M1345-ON06		M2390-TN11	M2390-SX09	M2390-SX12
									
页码 Page			P.474	P.476	P.478		P.480	P.484	P.486
主偏角 Approach Angle			45°	45°	43°		90°	90°	90°
最大切深 Maximum Cutting Depth			3.0	5.0	4.0 / 7.0		5.0	8.0	10.0
直径范围 Diameter Range			25~125	50~315	50~250		18~63	20~125	50~160
刀片 Insert									
			HN0604	HN0906	ON0605	SN1705	TN1104	SX09T3	SX1205
应用 Application	面铣 Face Milling		✓	✓	✓	✓	✓	✓	✓
	方肩铣 Shoulder Milling						✓	✓	✓
	槽铣 Slot Milling						✓	✓	✓
	坡铣 Slope Milling								
	螺旋插补铣 Spiral Interpolation Milling						✓		
	插铣 Plunge Milling								
	仿形铣 Profiling Milling								
	倒角铣 Chamfer Milling		✓	✓					
	型腔铣 Cavity Milling								

合金刀片类

Alloy Insert Series

系列 Series			M2390-XO10	M2390-XO16	M1300-RC10	M1300-RC12	M1300-RC16	M1300-RC20
								
页码 Page			P.488	P.490	P.492	P.494	P.496	P.498
主偏角 Approach Angle			90°	90°	-	-	-	-
最大切深 Maximum Cutting Depth			9.0	15.0	5.0	6.0	8.0	10.0
直径范围 Diameter Range			16~50	25~160	25~66	40~100	63~160	80~160
刀片 Insert								
			XO1003	XO1606	RC10T3	RC1204	RC1606	RC2006
应用 Application	面铣 Face Milling		√	√	√	√	√	√
	方肩铣 Shoulder Milling		√	√				
	槽铣 Slot Milling		√	√				
	坡铣 Slope Milling		√	√	√	√	√	√
	螺旋插补铣 Spiral Interpolation Milling		√	√	√	√	√	√
	插铣 Plunge Milling							
	仿形铣 Profiling Milling				√	√	√	√
	倒角铣 Chamfer Milling							
	型腔铣 Cavity Milling		√	√	√	√	√	√

AHNO Loong Series-45° Approach Angle Face Milling

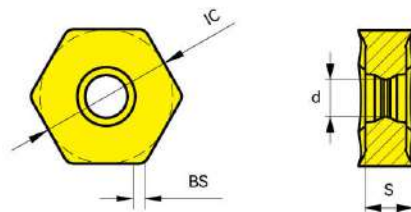


单位 Unit: mm

Series W	型号 Type	Dc	Da	d1	l1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
HN0604	M1345-HN06-D025-W25-Z2-C	25	32.2	25	42	99	3.0	2	有 Yes
	M1345-HN06-D032-W32-Z3-C	32	39.3	32	42	103	3.0	3	有 Yes

Series B	型号 Type	Dc	Da	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
HN0604	M1345-HN06-D040-B16-Z5-C	40	47.3	16	40	3.0	5	有 Yes
	M1345-HN06-D050-B22-Z4-C	50	57.3	22	40	3.0	4	有 Yes
	M1345-HN06-D050-B22-Z6-C	50	57.3	22	40	3.0	6	有 Yes
	M1345-HN06-D063-B22-Z6-C	63	70.3	22	40	3.0	6	有 Yes
	M1345-HN06-D063-B22-Z8-C	63	70.3	22	40	3.0	8	有 Yes
	M1345-HN06-D080-B27-Z7-C	80	86.8	27	50	3.0	7	有 Yes
	M1345-HN06-D080-B27-Z10-C	80	86.8	27	50	3.0	10	有 Yes
	M1345-HN06-D100-B32-Z8-C	100	107.1	32	50	3.0	8	有 Yes
	M1345-HN06-D100-B32-Z12-C	100	107.1	32	50	3.0	12	有 Yes
	M1345-HN06-D125-B40-Z10-C	125	132.2	40	63	3.0	10	有 Yes

	IC	d	S
HN0604 XN0604	10.5	3.7	4.76



Series	型号 Type	R	BS	P			M		K		S
				ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-F5	 HNGX0604ANSN-F5	-	1.1	●	●	●	●	●	●	●	●
-M5	 HNGX0604ANSN-M5	-	0.8	●	●	●	●	●	●	●	●
-R5	 HNGX0604ANSN-R5	-	0.8	●		●		●	●		
-W5	 XNGX0604ANSN-W5	-	4.15	●	●		●		●	●	

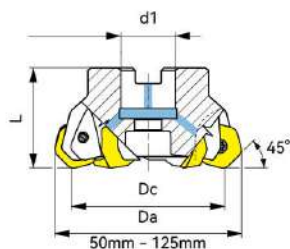
附件 Number of		D25~D32	D40~D125
	刀片锁紧螺钉 Milling	AF9021 (Torx 09IP) - 2.0 Nm	AF9021 (Torx 09IP) - 2.0 Nm
	旗形扳手 Flag-shaped Wrench	AF8010-T09IP	
	钥匙形扳手 Key-shaped Wrench		AF8020-T09IP

备件 Spare Part		D40	D50~D63	D80	D100	D125
	内六角螺栓 Hexagon Socket Bolt	AF5111	AF5112			
	十字螺栓 Cross Bolt			AF5201	AF5202	AF5203
	十字螺栓扳手 Cross Bolt Wrench			AF6201	AF6202	AF6203

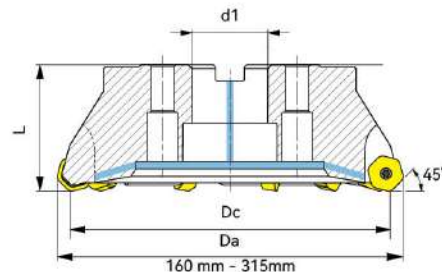
AHNO Loong Series-45° Approach Angle Face Milling



< B > 芯轴 Arbor



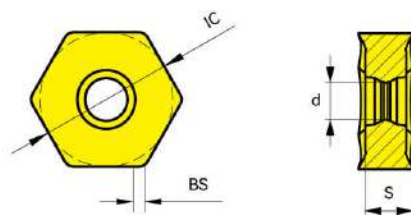
< B > 芯轴 Arbor



单位 Unit: mm

Series B	型号 Type	Dc	Da	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
HN0906	M1345-HN09-D050-B22-Z4-C	50	61.7	22	40	5.0	4	有 Yes
	M1345-HN09-D063-B22-Z6-C	63	74.7	22	40	5.0	6	有 Yes
	M1345-HN09-D080-B27-Z6-C	80	91.7	27	50	5.0	6	有 Yes
	M1345-HN09-D080-B27-Z8-C	80	91.7	27	50	5.0	8	有 Yes
	M1345-HN09-D100-B32-Z6-C	100	111.7	32	50	5.0	6	有 Yes
	M1345-HN09-D100-B32-Z8-C	100	111.7	32	50	5.0	8	有 Yes
	M1345-HN09-D100-B32-Z10-C	100	111.7	32	50	5.0	10	有 Yes
	M1345-HN09-D125-B40-Z6-C	125	136.7	40	63	5.0	6	有 Yes
	M1345-HN09-D125-B40-Z8-C	125	136.7	40	63	5.0	8	有 Yes
	M1345-HN09-D125-B40-Z10-C	125	136.7	40	63	5.0	10	有 Yes
	M1345-HN09-D125-B40-Z12-C	125	136.7	40	63	5.0	12	有 Yes
	M1345-HN09-D160-B40-Z8-C	160	171.7	40	63	5.0	8	有 Yes
	M1345-HN09-D160-B40-Z12-C	160	171.7	40	63	5.0	12	有 Yes
	M1345-HN09-D160-B40-Z14-C	160	171.7	40	63	5.0	14	有 Yes
	M1345-HN09-D200-B60-Z10-C	200	211.7	60	63	5.0	10	有 Yes
	M1345-HN09-D250-B60-Z14-C	250	261.7	60	63	5.0	14	有 Yes
	M1345-HN09-D315-B60-Z16-C	315	326.7	60	80	5.0	16	有 Yes

	IC	d	S
HN0906 XN0906	16.5	4.9	6.35

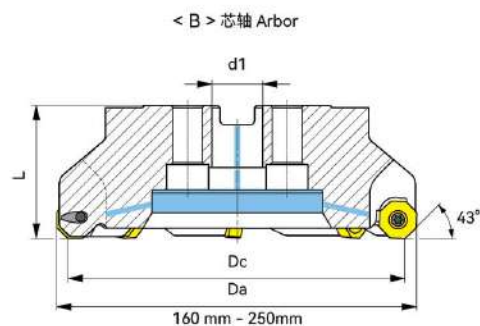
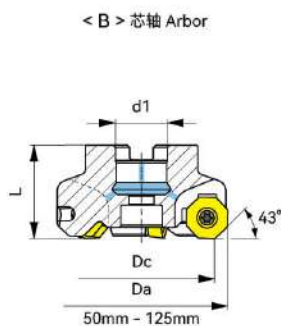


Series	型号 Type	R	BS	P			M		K		S
				ACP25A	AP25A	APU35A	AP25A	APU35A	ACP25A	AP25A	APU35A
-F1	 HNGX0906ANEN-F1	-	1.5		●	●	●	●		●	●
-F5	 HNGX0906ANSN-F5	-	1.2	●	●	●	●	●	●	●	●
-M5	 HNGX0906ANSN-M5	-	1.2	●	●	●	●	●	●	●	●
-R5	 HNGX0906ANSN-R5	-	1.2	●	●	●	●	●	●	●	●
-W5	 XNGX0906ANSN-W5	-	7.5	●	●		●		●	●	

附件 Number of		D50~D160	D200~D315
	刀片锁紧螺钉 Insert Locking Screw	AF9022 (Torx 15IP) - 5.0 Nm	AF9022 (Torx 15IP) - 5.0 Nm
	钥匙形扳手 Key-shaped Wrench	AF8020-T15IP	
	螺丝刀 Screwdriver		AF8030-T15IP

备件 Spare Part		D50~D63	D80	D100	D125	D160	D200	D250	D315
	内六角螺栓 Hexagon Socket Bolt	AF5112				AF5114	AF5115	AF5115	AF5115
	十字螺栓 Cross Bolt		AF5201	AF5202	AF5203				
	十字螺栓扳手 Cross Bolt Wrench		AF6201	AF6202	AF6203				
	内冷端盖 Internal Coolant End Cover					AF5311	AF5312	AF5313	AF5314
	端盖锁紧内六角螺钉 Lock the End Cover with the Hex Socket Screw					AF5121	AF5122	AF5122	AF5123
	端盖锁紧内六角扳手 Lock the End Cover with the Hex Wrench					AF6100-05	AF6100-07	AF6100-07	AF6100-07
	堵头 Plug								AF5501

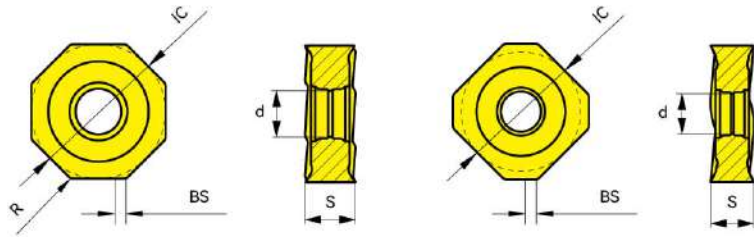
AHNO Loong Series-43° Approach Angle Face Milling



单位 Unit: mm

Series B	型号 Type	Dc	Da	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
ON0605	M1345-ON06-D050-B22-Z4-C	50	60.8	22	40	4.0	4	有 Yes
	M1345-ON06-D050-B22-Z5-C	50	60.8	22	40	4.0	5	有 Yes
	M1345-ON06-D063-B22-Z5-C	63	73.8	22	40	4.0	5	有 Yes
	M1345-ON06-D063-B22-Z6-C	63	73.8	22	40	4.0	6	有 Yes
	M1345-ON06-D080-B27-Z6-C	80	90.8	27	50	4.0	6	有 Yes
	M1345-ON06-D080-B27-Z8-C	80	90.8	27	50	4.0	8	有 Yes
	M1345-ON06-D100-B32-Z8-C	100	110.8	32	50	4.0	8	有 Yes
	M1345-ON06-D100-B32-Z10-C	100	110.8	32	50	4.0	10	有 Yes
	M1345-ON06-D125-B40-Z8-C	125	135.8	40	63	4.0	8	有 Yes
	M1345-ON06-D125-B40-Z10-C	125	135.8	40	63	4.0	10	有 Yes
	M1345-ON06-D125-B40-Z12-C	125	135.8	40	63	4.0	12	有 Yes
	M1345-ON06-D160-B40-Z8-C	160	170.8	40	63	4.0	8	有 Yes
	M1345-ON06-D160-B40-Z12-C	160	170.8	40	63	4.0	12	有 Yes
	M1345-ON06-D160-B40-Z14-C	160	170.8	40	63	4.0	14	有 Yes
	M1345-ON06-D200-B60-Z12-C	200	210.8	60	63	4.0	12	有 Yes
	M1345-ON06-D200-B60-Z16-C	200	210.8	60	63	4.0	16	有 Yes
	M1345-ON06-D250-B60-Z14-C	250	260.8	60	63	4.0	14	有 Yes
	M1345-ON06-D250-B60-Z18-C	250	260.8	60	63	4.0	18	有 Yes

	IC	d	S
ON0605 SN1705	17	5.7	5.56



Series	型号 Type	R	BS	P			M		K		S
				ACP25A	AP25A	APJ35A	AP25A	APJ35A	ACP25A	AP25A	APJ35A
-F5	ONMX060508SR-F5	0.8	0.75	●	●	●	●	●	●	●	●
-M5	ONMX060508SR-M5	0.8	0.75	●	●	●	●	●	●	●	●
-R5	ONMX060508SR-R5	0.8	0.75	●	●	●	●	●	●	●	●
-W5	ONMX060508SR-W5	0.8	4.3	●	●	●	●	●	●	●	●
-M5	SNMX170508SR-M5	0.8	0.7	●	●	●	●	●	●	●	●
-R5	SNMX170508SR-R5	0.8	0.7	●	●	●	●	●	●	●	●

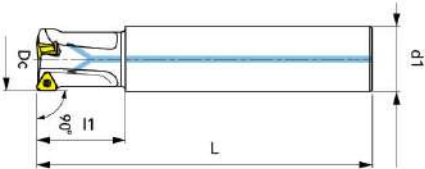
附件 Number of		D50~D160	D200~D250
	刀片锁紧螺钉 Insert Locking Screw	AF9031 (Torx 20IP) - 5.0 Nm	AF9031 (Torx 20IP) - 5.0 Nm
	钥匙形扳手 Key-shaped Wrench	AF8020-T20IP	
	螺丝刀 Screwdriver		AF8030-T20IP

备件 Spare Part		D50~D63	D80	D100	D125	D160	D200	D250
	内六角螺栓 Hexagon Socket Bolt	AF5112	AF5113			AF5114	AF5115	AF5115
	十字螺栓 Cross Bolt			AF5202	AF5203			
	十字螺栓扳手 Cross Bolt Wrench			AF6202	AF6203			
	内冷端盖 Internal Coolant End Cover					AF5311	AF5312	AF5313
	端盖锁紧内六角螺钉 Lock the End Cover with the Hex Socket Screw					AF5121	AF5122	AF5122
	端盖锁紧内六角扳手 Lock the End Cover with the Hex Wrench					AF6100-05	AF6100-07	AF6100-07

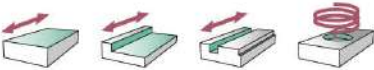
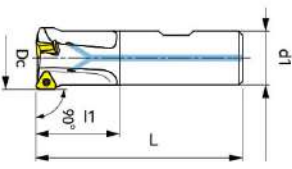
AHNO Loong Series 90° Approach Angle Shoulder Millings



< A > 圆柱 Cylinder



< W > 侧固 Weldon

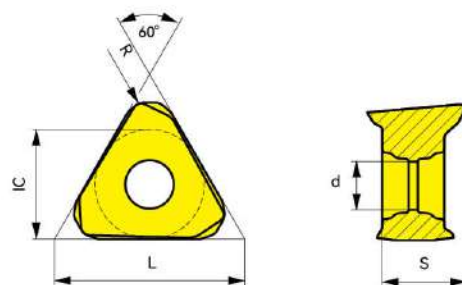


单位 Unit: mm

Series A	型号 Type	Dc	d1	l1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
	M2390-TN11-D020-A20-Z2-C	20	20	29	150	5.0	2	有 Yes
	M2390-TN11-D022-A25-Z3-C	22	25	50	180	5.0	3	有 Yes
	M2390-TN11-D025-A25-Z3-C	25	25	34	170	5.0	3	有 Yes
	M2390-TN11-D025-A25-Z4-C	25	25	34	170	5.0	4	有 Yes
	M2390-TN11-D030-A32-Z4-C	30	32	50	200	5.0	4	有 Yes
	M2390-TN11-D032-A32-Z4-C	32	32	37	195	5.0	4	有 Yes
	M2390-TN11-D032-A32-Z5-C	32	32	37	195	5.0	5	有 Yes
	M2390-TN11-D035-A32-Z5-C	35	32	80	200	5.0	5	有 Yes

Series W	型号 Type	Dc	d1	l1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
TN1104	M2390-TN11-D020-W20-Z2-C	20	20	32	90	5.0	2	有 Yes
	M2390-TN11-D025-W25-Z3-C	25	25	42	100	5.0	3	有 Yes
	M2390-TN11-D025-W25-Z4-C	25	25	42	100	5.0	4	有 Yes
	M2390-TN11-D032-W32-Z4-C	32	32	42	110	5.0	4	有 Yes
	M2390-TN11-D032-W32-Z5-C	32	32	42	110	5.0	5	有 Yes

	IC	d	L	S
TN1104	6.35	2.8	11	4.69

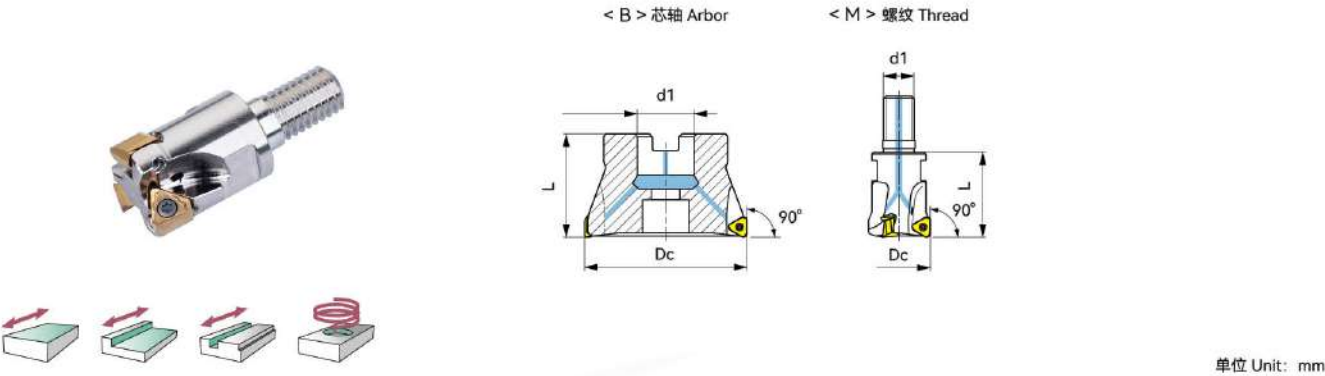
AHNO Loong Series
90° Approach Angle Shoulder Millings


Series	型号 Type	R	BS	P			M		K		S
				ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-F5	TNEX110404SR-F5	0.4	1.3	●	●	●	●	●	●	●	●
-F5	TNEX110408SR-F5	0.8	0.9	●	●	●	●	●	●	●	●
-M5	TNEX110404SR-M5	0.4	1.3	●	●	●	●	●	●	●	●
-M5	TNEX110408SR-M5	0.8	0.9	●	●	●	●	●	●	●	●

附件 Number of		D20~D35	D40~D63
	刀片锁紧螺钉 Insert Locking Screw	AF9041 (Torx 07IP) - 0.8 Nm	AF9041 (Torx 07IP) - 0.8 Nm
	旗形扳手 Flag-shaped Wrench	AF8010-T07IP	
	钥匙形扳手 Key-shaped Wrench		AF8020-T07IP

备件 Spare Part		D40	D50~D63
	内六角螺栓 Hexagon Socket Bolt	AF5111	AF5112

AHNO Loong Series 90°Approach Angle Shoulder Millings



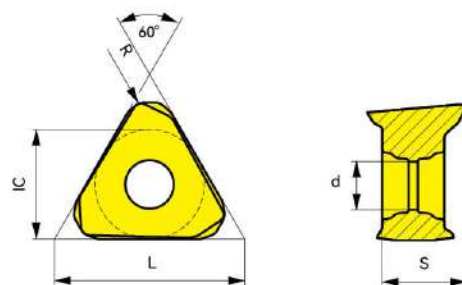
单位 Unit: mm

Series M	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
TN1104	M2390-TN11-D020-M10-Z2-C	20	M10	26	5.0	2	有 Yes
	M2390-TN11-D025-M12-Z3-C	25	M12	33	5.0	3	有 Yes
	M2390-TN11-D025-M12-Z4-C	25	M12	33	5.0	4	有 Yes
	M2390-TN11-D032-M16-Z4-C	32	M16	43	5.0	4	有 Yes
	M2390-TN11-D032-M16-Z5-C	32	M16	43	5.0	5	有 Yes

Series B	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
TN1104	M2390-TN11-D040-B16-Z4-C	40	16	40	5.0	4	有 Yes
	M2390-TN11-D040-B16-Z6-C	40	16	40	5.0	6	有 Yes
	M2390-TN11-D050-B22-Z5-C	50	22	40	5.0	5	有 Yes
	M2390-TN11-D050-B22-Z7-C	50	22	40	5.0	7	有 Yes
	M2390-TN11-D063-B22-Z6-C	63	22	40	5.0	6	有 Yes
	M2390-TN11-D063-B22-Z9-C	63	22	40	5.0	9	有 Yes

	IC	d	L	S
TN1104	6.35	2.8	11	4.69

AHNO Loong Series
90° Approach Angle Shoulder Millings

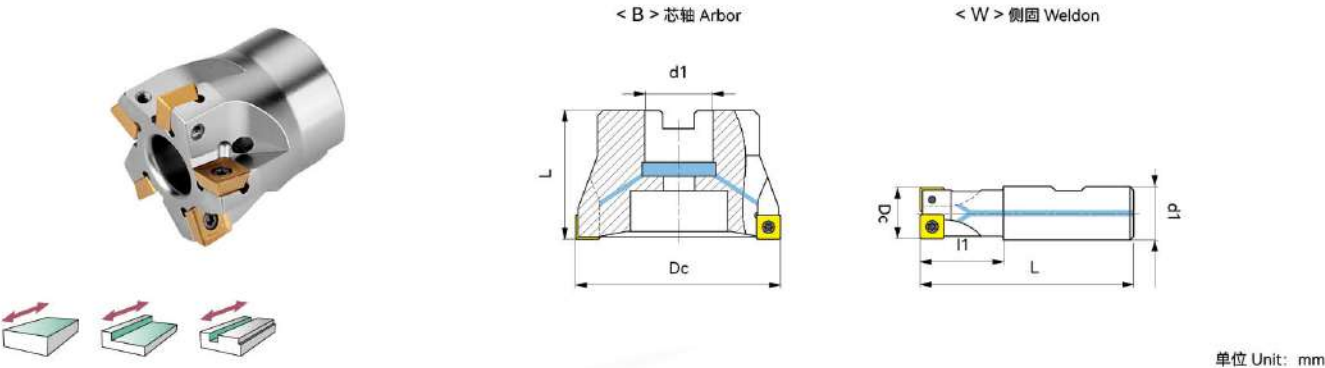


Series	型号 Type	R	BS	P			M		K		S
				ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-F5	TNEX110404SR-F5	0.4	1.3	●	●	●	●	●	●	●	●
-F5	TNEX110408SR-F5	0.8	0.9	●	●	●	●	●	●	●	●
-M5	TNEX110404SR-M5	0.4	1.3	●	●	●	●	●	●	●	●
-M5	TNEX110408SR-M5	0.8	0.9	●	●	●	●	●	●	●	●

附件 Number of		D20~D35	D40~D63
	刀片锁紧螺钉 Insert Locking Screw	AF9041 (Torx 07IP) - 0.8 Nm	AF9041 (Torx 07IP) - 0.8 Nm
	旗形扳手 Flag-shaped Wrench	AF8010-T07IP	
	钥匙形扳手 Key-shaped Wrench		AF8020-T07IP

备件 Spare Part		D40	D50~D63
	内六角螺栓 Hexagon Socket Bolt	AF5111	AF5112

AHNO Loong Series 90° Approach Angle Shoulder Millings

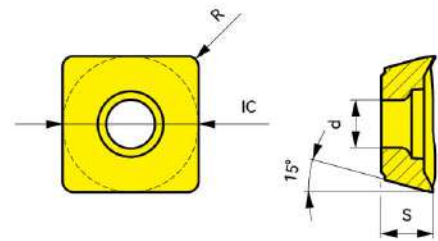


Series A	型号 Type	Dc	d1	l1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
SX09T3	M2390-SX09-D020-W20-Z2-C	20	20	32	82	8.0	2	有 Yes
	M2390-SX09-D025-W25-Z3-C	25	25	42	98	8.0	3	有 Yes
	M2390-SX09-D032-W32-Z4-C	32	32	42	102	8.0	4	有 Yes

Series B	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
SX09T3	M2390-SX09-D040-B16-Z5-C	40	16	40	8.0	5	有 Yes
	M2390-SX09-D050-B22-Z6-C	50	22	40	8.0	6	有 Yes
	M2390-SX09-D063-B22-Z7-C	63	22	40	8.0	7	有 Yes
	M2390-SX09-D080-B27-Z9-C	80	27	50	8.0	9	有 Yes
	M2390-SX09-D100-B32-Z10-C	100	32	50	8.0	10	有 Yes
	M2390-SX09-D125-B40-Z12-C	125	40	63	8.0	12	有 Yes

	IC	d	S
SX09T3	9.55	3.5	3.97

AHNO Loong Series
90° Approach Angle Shoulder Millings

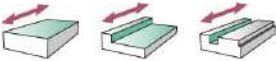


Series	型号 Type	R	BS	P			M		K		S
				ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-M3	 SXMT09T304SR-M3	0.4	1.3	●	●	●	●	●	●	●	●
-M4	 SXMT09T304SR-M4	0.4	1.3	●	●	●	●	●	●	●	●
-M5	 SXMT09T308SR-M5	0.8	0.9	●	●	●	●	●	●	●	●

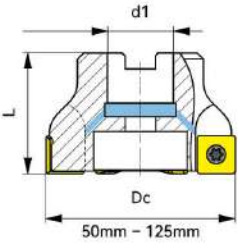
附件 Number of		D20~D32	D40~D125
	刀片锁紧螺钉 Insert Locking Screw	AF9051 (Torx 09IP) - 2.0 Nm	AF9051 (Torx 09IP) - 2.0 Nm
	旗形扳手 Flag-shaped Wrench	AF8010-T09IP	
	钥匙形扳手 Key-shaped Wrench		AF8020-T09IP

备件 Spare Part		D40	D50~D63	D80	D100	D125
	内六角螺栓 Hexagon Socket Bolt	AF5111	AF5112			
	十字螺栓 Cross Bolt			AF5201	AF5202	AF5203
	十字螺栓扳手 Cross Bolt Wrench			AF6201	AF6202	AF6203

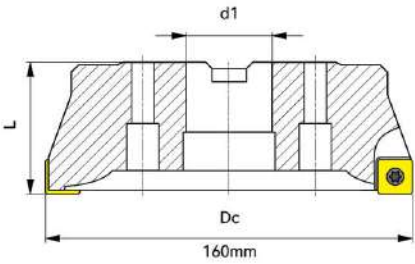
AHNO Loong Series 90° Approach Angle Shoulder Millings



< B > 芯轴 Arbor



< B > 芯轴 Arbor

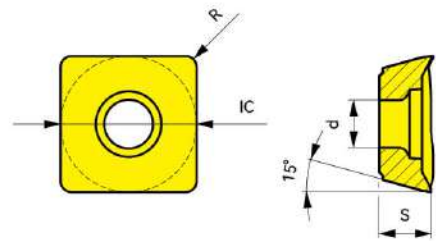


单位 Unit: mm

Series B	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
SX1205	M2390-SX12-D050-B22-Z5-C	50	22	40	10	5	有 Yes
	M2390-SX12-D063-B22-Z6-C	63	22	40	10	6	有 Yes
	M2390-SX12-D080-B27-Z6-C	80	27	50	10	6	有 Yes
	M2390-SX12-D100-B32-Z8-C	100	32	50	10	8	有 Yes
	M2390-SX12-D125-B40-Z9-C	125	40	63	10	9	有 Yes
	M2390-SX12-D160-B40-Z12	160	40	63	10	12	无 No

	IC	d	S
SX1205	12.7	4.4	5

AHNO Loong Series
90° Approach Angle Shoulder Millings



Series	型号 Type	R	BS	P			M		K		S
				ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-F5	 SXMT120508SR-F5	0.8	-	●	●	●	●	●	●	●	●
-M5	 SXMT120508SR-M5	0.8	-	●	●	●	●	●	●	●	●
-R5	 SXMT120508PR-R5	0.8	-	●	●	●	●	●	●	●	●

附件 Number of		D50~D160
	刀片锁紧螺钉 Insert Locking Screw	AF9052 (Torx 15) - 3.0 Nm
	钥匙形扳手 Key-shaped Wrench	AF8020-T15

备件 Spare Part		D50~D63	D80	D100	D125	D160
	内六角螺栓 Hexagon Socket Bolt	AF5112				AF5114
	十字螺栓 Cross Bolt		AF5201	AF5202	AF5203	
	十字螺栓扳手 Cross Bolt Wrench		AF6201	AF6202	AF6203	
	刀片垫片 Insert Gasket		AF5510-SX12	AF5510-SX12	AF5510-SX12	AF5510-SX12
	垫片内六角螺钉 Hex Socket Screw for Gasket		AF5401	AF5401	AF5401	AF5401
	垫片内六角扳手 Hex Wrench for Gasket		AF6100-3.5	AF6100-3.5	AF6100-3.5	AF6100-3.5

AHNO Loong Series

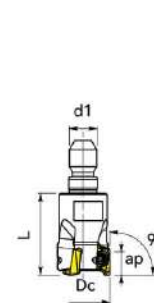
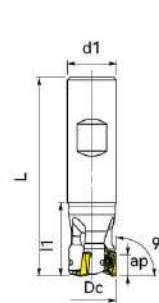
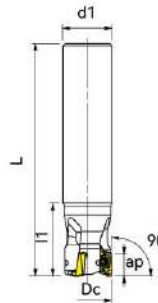
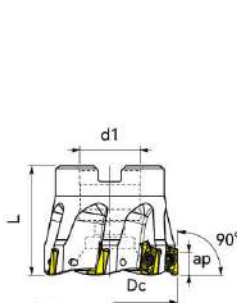
90° Approach Angle Shoulder Millings

< B > 芯轴 Arbor

< A > 圆柱 Cylinder

< W > 侧固 Weldon

< M > 螺纹 Thread



单位 Unit: mm

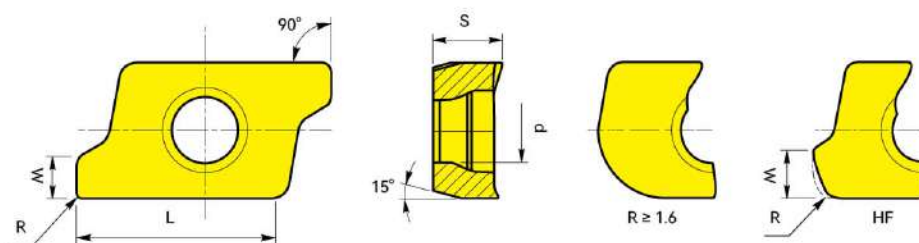
Series A	型号 Type	Dc	d1	l1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
XO1003 XO10T3	M2390-XO10-D016-A16-Z2-C	16	16	30	100	9.0	2	有 Yes
	M2390-XO10-D020-A16-Z2-C	20	16	30	100	9.0	2	有 Yes
	M2390-XO10-D020-A20-Z3-C	20	20	30	110	9.0	3	有 Yes
	M2390-XO10-D025-A20-Z3-C	25	20	40	110	9.0	3	有 Yes
	M2390-XO10-D025-A25-Z4-C	25	25	40	120	9.0	4	有 Yes
	M2390-XO10-D032-A25-Z3-C	32	25	50	120	9.0	3	有 Yes
	M2390-XO10-D032-A32-Z5-C	32	32	50	130	9.0	5	有 Yes

Series W	型号 Type	Dc	d1	l1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
XO1003 XO10T3	M2390-XO10-D016-W16-Z2-C	16	16	30	79	9.0	2	有 Yes
	M2390-XO10-D020-W20-Z3-C	20	20	30	81	9.0	3	有 Yes
	M2390-XO10-D025-W25-Z4-C	25	25	40	97	9.0	4	有 Yes
	M2390-XO10-D032-W32-Z5-C	32	32	50	111	9.0	5	有 Yes

Series M	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
XO1003 XO10T3	M2390-XO10-D016-M08-Z2	16	M8	25	9.0	2	无 No
	M2390-XO10-D020-M10-Z3	20	M10	30	9.0	3	无 No
	M2390-XO10-D025-M12-Z4	25	M12	35	9.0	4	无 No
	M2390-XO10-D032-M16-Z5	32	M16	43	9.0	5	无 No

Series B	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
XO1003 XO10T3	M2390-XO10-D040-B16-Z6-C	40	16	40	9.0	6	有 Yes
	M2390-XO10-D050-B22-Z7-C	50	22	40	9.0	7	有 Yes

	d
XO1003	2.9



Series	型号 Type	L	S	R	W	P			M		K		S
						ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-F5	XOMT100304R-F5	9.1	3.4	0.4	1.8		●	●	●	●		●	●
-M4	XOGT1003PER-M4	6.7	3.4	0.8	1.8	●	●	●	●	●	●	●	●
-M4	XOMT100302R-M4	9.1	3.4	0.2	1.8		●	●	●	●		●	●
	XOMT100304R-M4	9.1	3.4	0.4	1.8		●	●	●	●		●	●
	XOMT100308R-M4	9.1	3.4	0.8	1.8	●	●	●	●	●	●	●	●
	XOMT100310R-M4	9.1	3.4	1.0	1.8	●	●	●	●	●	●	●	●
	XOMT100312R-M4	9.1	3.4	1.2	1.8	●	●	●	●	●	●	●	●
	XOMT100316R-M4*	7.8	3.32	1.6	-	●	●	●	●	●	●	●	●
	XOMT100320R-M4*	7.7	3.28	2.0	-		●	●	●	●		●	●
	XOMT100330R-M4*	7.5	3.19	3.0	-		●	●	●	●		●	●
-M5	XOMT100304R-M5	9.1	3.4	0.4	1.6	●	●	●	●	●	●	●	●
	XOMT100308R-M5	9.1	3.4	0.8	1.6	●	●	●	●	●	●	●	●
-R5	XOMT100304R-R5	9.1	3.4	0.4	1.6	●	●	●	●	●	●	●	●
	XOMT100308R-R5	9.1	3.4	0.8	1.6	●	●	●	●	●	●	●	●
-HF	XOMT100310-HF	8.3	3.38	1.0	2.2	●	●	●	●	●	●	●	●
				编程圆角 Programming Corners	刃口宽度 Edge Width								

* 刀体必须经过改造: R(刀体)=R(刀片)-0.5

* The tool body must be modified: R(tool body) = R(insert) - 0.5

附件 Number of		D16~D32	D40~D50
 	刀片锁紧螺钉 Insert Locking Screw	AF9011 (Torx 08IP) - 1.2 Nm	AF9011 (Torx 08IP) - 1.2 Nm
	旗形扳手 Flag-shaped Wrench	AF8010-T08IP	
	钥匙形扳手 Key-shaped Wrench		AF8020-T08IP
备件 Spare Part		D40	D50
	内六角螺栓 Hexagon Socket Bolt	AF5111	AF5112

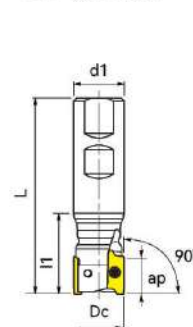
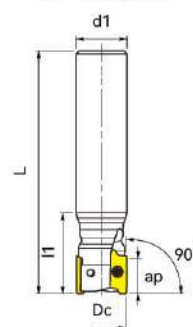
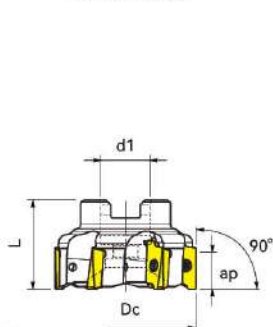
AHNO Loong Series

90° Approach Angle Shoulder Millings

< B > 芯轴 Arbor

< A > 圆柱 Cylinder

< W > 侧固 Weldon



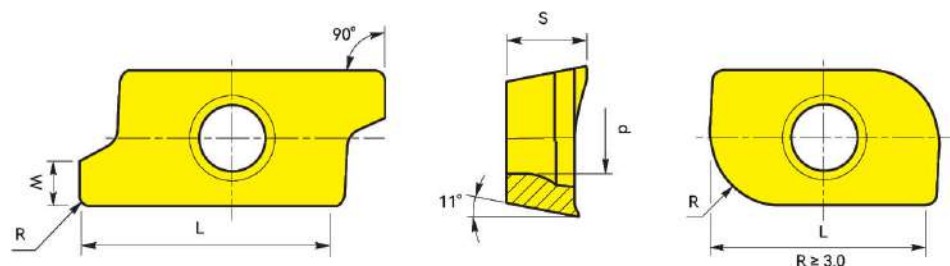
单位 Unit: mm

Series A	型号 Type	Dc	d1	l1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
XO1606	M2390-XO16-D025-A25-Z2-C	25	25	40	120	15	2	有 Yes
	M2390-XO16-D032-A25-Z2-C	32	25	50	120	15	2	有 Yes
	M2390-XO16-D032-A32-Z3-C	32	32	50	130	15	3	有 Yes
	M2390-XO16-D040-A25-Z3-C	40	25	50	120	15	3	有 Yes
	M2390-XO16-D040-A32-Z4-C	40	32	50	130	15	4	有 Yes

Series W	型号 Type	Dc	d1	l1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
XO1606	M2390-XO16-D025-W25-Z2-C	25	25	40	97	15	2	有 Yes
	M2390-XO16-D032-W32-Z3-C	32	32	50	111	15	3	有 Yes
	M2390-XO16-D040-W32-Z4-C	40	32	50	111	15	4	有 Yes

Series B	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
XO1606	M2390-XO16-D040-B16-Z4-C	40	16	40	15	4	有 Yes
	M2390-XO16-D050-B22-Z5-C	50	22	40	15	5	有 Yes
	M2390-XO16-D063-B22-Z6-C	63	22	40	15	6	有 Yes
	M2390-XO16-D080-B27-Z7-C	80	27	50	15	7	有 Yes
	M2390-XO16-D100-B32-Z8-C	100	32	50	15	8	有 Yes
	M2390-XO16-D125-B40-Z9-C	125	40	63	15	9	有 Yes
	M2390-XO16-D160-B40-Z10	160	40	63	15	10	无 No

	d
XO1606	4.7



Series	型号 Type	L	S	R	W	P			M		K		S
						ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-F5	XOMT160608R-F5	18	6.42	0.8	3.3	●	●	●	●	●	●	●	●
	XOMT160604R-M4	18	6.48	0.4	3.0	●	●	●	●	●	●	●	●
-M4	XOMT160608R-M4	18	6.44	0.8	3.0	●	●	●	●	●	●	●	●
	XOMT160612R-M4	18	6.40	1.2	3.0	●	●	●	●	●	●	●	●
	XOMT160616R-M4	18	6.36	1.6	3.0	●	●	●	●	●	●	●	●
	XOMT160630R-M4*	15.9	6.10	3.0	-	●	●	●	●	●	●	●	●
	XOMT160640R-M4*	15.8	6.03	4.0	-	●	●	●	●	●	●	●	●
	XOMT160650R-M4*	15.7	5.96	5.0	-	●	●	●	●	●	●	●	●
	XOMT160660R-M4*	15.6	5.89	6.0	-	●	●	●	●	●	●	●	●
-R5	XOMT160608R-R5	18	6.40	0.8	2.9	●	●	●	●	●	●	●	●
-R7	XOMT160608R-R7	18	6.40	0.8	2.9	●	●	●	●	●	●	●	●

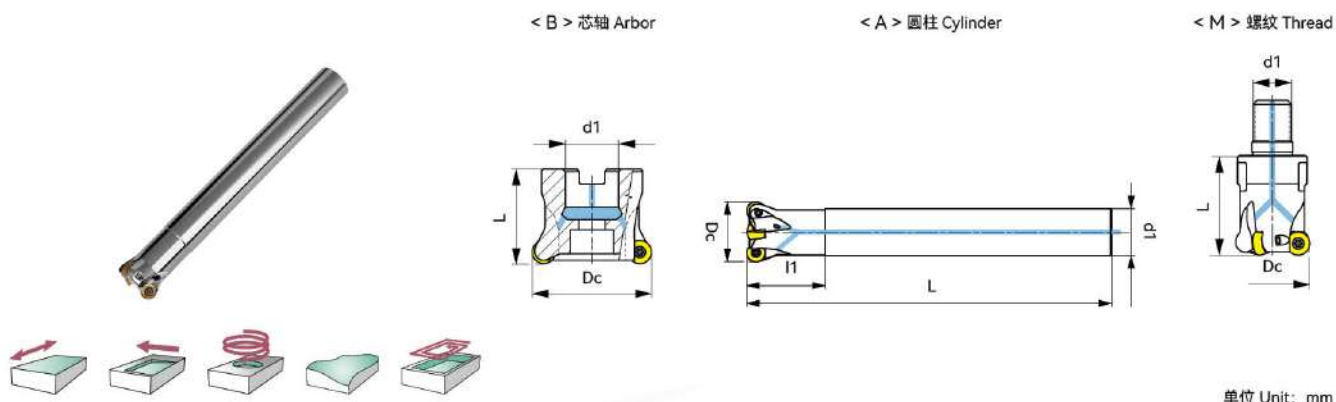
* 刀体必须经过改造: R(刀体)=R(刀片)-0.5

* The tool body must be modified: R (tool body) = R (insert) - 0.5

附件 Number of		D25~D40	D40~D160
 	刀片锁紧螺钉 Insert Locking Screw	AF9012 (Torx 15IP) - 3.0 Nm	AF9012 (Torx 15IP) - 3.0 Nm
	旗形扳手 Flag-shaped Wrench	AF8010-T15IP	
	钥匙形扳手 Key-shaped Wrench		AF8020-T15IP

备件 Spare Part	D40	D50~D63	D80	D100	D125	D160
 内六角螺栓 Hexagon Socket Bolt	AF5111	AF5112	AF5113	—	AF5117	AF5114

AHNO Loong Series-Profiling Millings



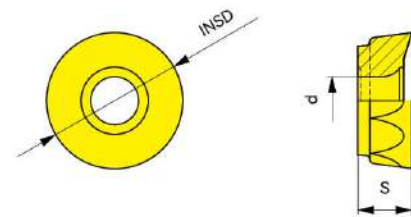
单位 Unit: mm

Series A	型号 Type	Dc	d1	l1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
RC10T3	M1300-RC10-D025-A20-Z2-C	25	20	34	170	5.0	2	有 Yes
	M1300-RC10-D025-A20-Z3-C	25	20	34	170	5.0	3	有 Yes
	M1300-RC10-D032-A25-Z3-C	32	25	42	200	5.0	3	有 Yes
	M1300-RC10-D032-A25-Z4-C	32	25	42	200	5.0	4	有 Yes

Series M	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
RC10T3	M1300-RC10-D025-M12-Z2-C	25	M12	32	5.0	2	有 Yes
	M1300-RC10-D025-M12-Z3-C	25	M12	32	5.0	3	有 Yes
	M1300-RC10-D032-M16-Z4-C	32	M16	42	5.0	4	有 Yes
	M1300-RC10-D035-M16-Z4-C	35	M16	42	5.0	4	有 Yes

Series B	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
RC10T3	M1300-RC10-D040-B16-Z5-C	40	16	40	5.0	5	有 Yes
	M1300-RC10-D050-B22-Z5-C	50	22	40	5.0	5	有 Yes
	M1300-RC10-D050-B22-Z6-C	50	22	40	5.0	6	有 Yes
	M1300-RC10-D052-B22-Z5-C	52	22	40	5.0	5	有 Yes
	M1300-RC10-D052-B22-Z6-C	52	22	40	5.0	6	有 Yes
	M1300-RC10-D063-B22-Z6-C	63	22	40	5.0	6	有 Yes
	M1300-RC10-D063-B22-Z7-C	63	22	40	5.0	7	有 Yes
	M1300-RC10-D066-B27-Z6-C	66	27	50	5.0	6	有 Yes
	M1300-RC10-D066-B27-Z7-C	66	27	50	5.0	7	有 Yes

	INSD	d	S
RC10T3	10	3.9	3.97

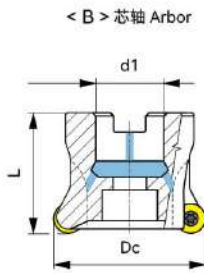


Series	型号 Type	P			M		K		S
		ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-F5	 RCMT10T3M0SN-F5		●	●	●	●		●	●
-M5	 RCMT10T3M0SN-M5	●	●	●	●	●	●	●	●
-R5	 RCMT10T3M0SN-R5	●		●		●	●		●

附件 Number of		D25~D35	D40~D66
	刀片锁紧螺钉 Insert Locking Screw	AF9061 (Torx 10IP) - 3.0 Nm	AF9061 (Torx 10IP) - 3.0 Nm
	旗形扳手 Flag-shaped Wrench	AF8010-T10IP	
	钥匙形扳手 Key-shaped Wrench		AF8020-T10IP

备件 Spare Part		D40	D50~D63	D66
	内六角螺栓 Hexagon Socket Bolt	AF5111	AF5112	AF5113

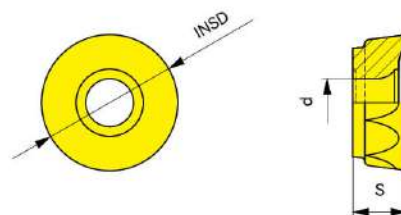
AHNO Loong Series-Profiling Millings



单位 Unit: mm

Series B	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
RC1204	M1300-RC12-D040-B16-Z3-C	40	16	40	6.0	3	有 Yes
	M1300-RC12-D050-B22-Z4-C	50	22	40	6.0	4	有 Yes
	M1300-RC12-D052-B22-Z5-C	52	22	40	6.0	5	有 Yes
	M1300-RC12-D063-B22-Z5-C	63	22	40	6.0	5	有 Yes
	M1300-RC12-D066-B27-Z6-C	66	27	50	6.0	6	有 Yes
	M1300-RC12-D080-B27-Z5-C	80	27	50	6.0	5	有 Yes
	M1300-RC12-D100-B32-Z6-C	100	32	50	6.0	6	有 Yes

	INSD	d	S
RC1204	12	4.4	4.76



Series	型号 Type	P			M		K		S
		ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-F5	 RCMT1204M0EN-F5	●	●	●	●	●	●	●	●
-M5	 RCMT1204M0SN-M5	●	●	●	●	●	●	●	●
-R5	 RCMT1204M0EN-R5	●	●	●	●	●	●	●	●

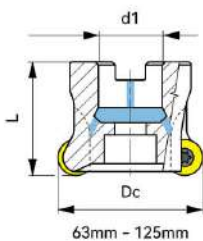
附件 Number of		D40~D100
	刀片锁紧螺钉 Insert Locking Screw	AF9062 (Torx 15IP) - 3.0 Nm
	钥匙形扳手 Key-shaped Wrench	AF8020-T15IP

备件 Spare Part		D40	D50~D63	D66~D80	D100
	内六角螺栓 Hexagon Socket Bolt	AF5116	AF5112	AF5113	
	十字螺栓 Cross Bolt				AF5202
	十字螺栓扳手 Cross Bolt Wrench				AF6202

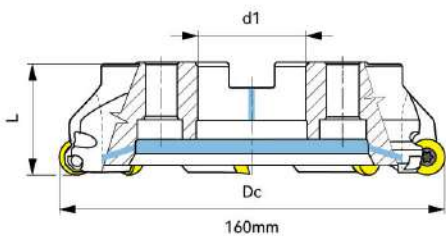
AHNO Loong Series-Profiling Millings



< B > 芯轴 Arbor



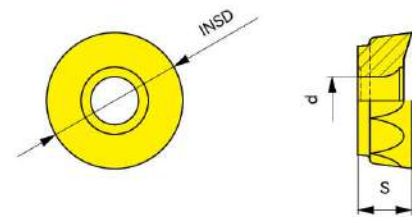
< B > 芯轴 Arbor



单位 Unit: mm

Series B	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
RC1606	M1300-RC16-D063-B22-Z4-C	63	22	50	8.0	4	有 Yes
	M1300-RC16-D066-B27-Z5-C	66	27	50	8.0	5	有 Yes
	M1300-RC16-D080-B27-Z5-C	80	27	50	8.0	5	有 Yes
	M1300-RC16-D100-B32-Z6-C	100	32	50	8.0	6	有 Yes
	M1300-RC16-D125-B40-Z7-C	125	40	63	8.0	7	有 Yes
	M1300-RC16-D160-B40-Z8-C	160	40	63	8.0	8	有 Yes

	INSD	d	S
RC1606	16	5.5	6.35



Series	型号 Type	P			M		K		S
		ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-F5	 RCMT1606M0EN-F5	●	●	●	●	●	●	●	●
-M5	 RCMT1606M0SN-M5	●	●	●	●	●	●	●	●
-R5	 RCMT1606M0SN-R5	●	●	●	●	●	●	●	●

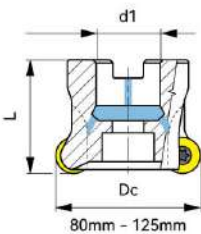
附件 Number of		D63~D160
	刀片锁紧螺钉 Insert Locking Screw	AF9063 (Torx 20IP) - 5.0 Nm
	钥匙形扳手 Key-shaped Wrench	AF8020-T20IP

备件 Spare Part		D63	D66~D80	D100	D125	D160
	内六角螺栓 Hexagon Socket Bolt	AF5112	AF5113		AF5117	AF5114
	十字螺栓 Cross Bolt			AF5202		
	十字螺栓扳手 Cross Bolt Wrench			AF6202		

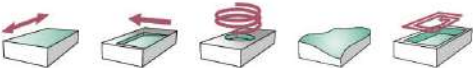
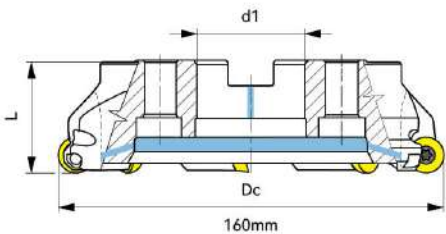
AHNO Loong Series-Profiling Millings



< B > 芯轴 Arbor



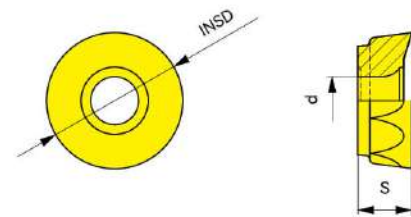
< B > 芯轴 Arbor



单位 Unit: mm

Series B	型号 Type	Dc	d1	L	apmax	齿数 Number of Teeth	内冷 Internal Coolant
RC2006	M1300-RC20-D080-B27-Z4-C	80	27	50	10	4	有 Yes
	M1300-RC20-D100-B32-Z5-C	100	32	50	10	5	有 Yes
	M1300-RC20-D125-B40-Z6-C	125	40	63	10	6	有 Yes
	M1300-RC20-D160-B40-Z7-C	160	40	63	10	7	有 Yes

	INSD	d	S
RC2006	20	6.5	6.35



Series	型号 Type	P			M		K		S
		ACP25A	APP25A	APU35A	APP25A	APU35A	ACP25A	APP25A	APU35A
-F5	 RCMT2006M0SN-F5	●	●	●	●	●	●	●	●
-M5	 RCMT2006M0SN-M5	●	●	●	●	●	●	●	●
-R5	 RCMT2006M0SN-R5	●		●		●	●		●

附件 Number of		D80~D160
	刀片锁紧螺钉 Insert Locking Screw	AF9064 (Torx 25IP) - 7.5 Nm
	T形扳手 T-shaped Wrench	AF8040-T25IP

备件 Spare Part		D80	D100	D125	D160
	内六角螺栓 Hexagon Socket Bolt	AF5113		AF5117	AF5114
	十字螺栓 Cross Bolt		AF5202		
	十字螺栓扳手 Cross Bolt Wrench		AF6202		

AHNO Loong Series-Cutting Parameters

M1345-HN06 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)			
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F5	M5	R5	W5
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.24	0.27	0.32	0.12
		640-1010	190-300	160~250	150~240	125~225	0.2	0.24	0.27	0.12
	低合金钢 Low-alloyed Steel	700-950	200-280	150~240	125~225	100~200	0.2	0.24	0.27	0.12
	高合金钢 High-alloyed Steel	950-1200	280-355	120~160	100~150	80~120	0.18	0.2	0.24	0.1
M		1200-1400	355-415	80~100	75~90	60~75	0.18	0.2	0.24	0.1
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.18	0.2	0.24	0.1
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.18	0.2	0.24	0.1
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.15	0.18	0.2	0.1
K	灰口铸铁 Grey Cast Iron	200-350	180-245	180~320	160~240		0.27	0.3	0.36	0.12
	球墨铸铁 Nodular Cast Iron	400-700	155-265	125~225	120~200		0.24	0.27	0.32	0.12
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.2	0.24	0.27	0.12
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840-1180	250-350			40~60	0.12	0.15	0.18	0.1
	钛合金 Titanium Alloy	1260-1400	375-410			30~50	0.12	0.15	0.18	0.1
N	铝合金 Aluminium Alloy	260-450	75-130							
H	淬硬钢 Hardened Steel	-	HRC50-60							
	淬硬铸铁 Hardened Cast Iron	-	HRC55							

M1345-HN09 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)				
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F1	F5	M5	R5	W5
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.24	0.27	0.32	0.36	0.12
		640~1010	190~300	160~250	150~240	125~225	0.2	0.24	0.27	0.3	0.12
	低合金钢 Low-alloyed Steel	700~950	200~280	150~240	125~225	100~200	0.2	0.24	0.27	0.3	0.12
	高合金钢 High-alloyed Steel	950~1200	280~355	120~160	100~150	80~120	0.18	0.2	0.24	0.27	0.1
		1200~1400	355~415	80~100	75~90	60~75	0.18	0.2	0.24	0.27	0.1
M	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.18	0.2	0.24	0.27	0.1
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.18	0.2	0.24	0.27	0.1
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.15	0.18	0.2	0.24	0.1
K	灰口铸铁 Grey Cast Iron	200~350	180~245	180~320	160~240		0.27	0.3	0.36	0.4	0.12
	球墨铸铁 Nodular Cast Iron	400~700	155~265	125~225	120~200		0.24	0.27	0.32	0.36	0.12
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.2	0.24	0.27	0.3	0.12
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840~1180	250~350			40~60	0.12	0.15	0.18	0.2	0.1
	钛合金 Titanium Alloy	1260~1400	375~410			30~50	0.12	0.15	0.18	0.2	0.1
N	铝合金 Aluminium Alloy	260~450	75~130								
H	淬硬钢 Hardened Steel	-	HRC50~60								
	淬硬铸铁 Hardened Cast Iron	-	HRC55								

M1345-ON06 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)			
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F5	M5	R5	W5
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.27	0.32	0.36	0.1
		640-1010	190-300	160~250	150~240	125~225	0.24	0.27	0.3	0.1
	低合金钢 Low-alloyed Steel	700-950	200-280	150~240	125~225	100~200	0.24	0.27	0.3	0.1
	高合金钢 High-alloyed Steel	950-1200	280-355	120~160	100~150	80~120	0.2	0.24	0.27	0.08
M		1200-1400	355-415	80~100	75~90	60~75	0.2	0.24	0.27	0.08
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.2	0.24	0.27	0.08
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.2	0.24	0.27	0.08
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.18	0.2	0.24	0.08
K	灰口铸铁 Grey Cast Iron	200-350	180-245	180~320	160~240		0.3	0.36	0.4	0.1
	球墨铸铁 Nodular Cast Iron	400~700	155-265	125~225	120~200		0.27	0.32	0.36	0.1
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.24	0.27	0.3	0.1
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840-1180	250-350			40~60	0.15	0.18	0.2	0.08
	钛合金 Titanium Alloy	1260-1400	375-410			30~50	0.15	0.18	0.2	0.08
N	铝合金 Aluminium Alloy	260-450	75-130							
H	淬硬钢 Hardened Steel	-	HRC50-60							
	淬硬铸铁 Hardened Cast Iron	-	HRC55							

M2390-TN11 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)		
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F5	M5	R5
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.24	0.27	
		640-1010	190-300	160~250	150~240	125~225	0.2	0.24	
	低合金钢 Low-alloyed Steel	700-950	200-280	150~240	125~225	100~200	0.2	0.24	
	高合金钢 High-alloyed Steel	950-1200	280-355	120~160	100~150	80~120	0.18	0.2	
M		1200-1400	355-415	80~100	75~90	60~75	0.18	0.2	
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.18	0.2	
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.18	0.2	
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.15	0.18	
K	灰口铸铁 Grey Cast Iron	200-350	180-245	180~320	160~240		0.27	0.3	
	球墨铸铁 Nodular Cast Iron	400~700	155-265	125~225	120~200		0.24	0.27	
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.2	0.24	
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840-1180	250-350			40~60	0.12	0.15	
	钛合金 Titanium Alloy	1260-1400	375-410			30~50	0.12	0.15	
N	铝合金 Aluminium Alloy	260-450	75-130						
H	淬硬钢 Hardened Steel	-	HRC50-60						
	淬硬铸铁 Hardened Cast Iron	-	HRC55						

AHNO Loong Series-Cutting Parameters

M2390-SX09 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)		
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	M3	M4	M5
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.2	0.24	0.27
		640-1010	190-300	160~250	150~240	125~225	0.18	0.2	0.24
	低合金钢 Low-alloyed Steel	700-950	200-280	150~240	125~225	100~200	0.18	0.2	0.24
	高合金钢 High-alloyed Steel	950-1200	280-355	120~160	100~150	80~120	0.16	0.18	0.2
M		1200-1400	355-415	80~100	75~90	60~75	0.16	0.18	0.2
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.16	0.18	0.2
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.16	0.18	0.2
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.12	0.15	0.18
K	灰口铸铁 Grey Cast Iron	200-350	180-245	180~320	160~240		0.24	0.27	0.3
	球墨铸铁 Nodular Cast Iron	400-700	155-265	125~225	120~200		0.2	0.24	0.27
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.18	0.2	0.24
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840-1180	250-350			40~60	0.1	0.12	0.15
	钛合金 Titanium Alloy	1260-1400	375-410			30~50	0.1	0.12	0.15
N	铝合金 Aluminium Alloy	260-450	75-130						
H	淬硬钢 Hardened Steel	-	HRC50-60						
	淬硬铸铁 Hardened Cast Iron	-	HRC55						

M2390-SX12 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)		
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F5	M5	R5
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.2	0.24	0.27
		640-1010	190-300	160~250	150~240	125~225	0.18	0.2	0.24
	低合金钢 Low-alloyed Steel	700-950	200-280	150~240	125~225	100~200	0.18	0.2	0.24
	高合金钢 High-alloyed Steel	950-1200	280-355	120~160	100~150	80~120	0.16	0.18	0.2
M		1200-1400	355-415	80~100	75~90	60~75	0.16	0.18	0.2
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.16	0.18	0.2
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.16	0.18	0.2
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.12	0.15	0.18
K	灰口铸铁 Grey Cast Iron	200-350	180-245	180~320	160~240		0.24	0.27	0.3
	球墨铸铁 Nodular Cast Iron	400-700	155-265	125~225	120~200		0.2	0.24	0.27
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.18	0.2	0.24
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840-1180	250-350			40~60	0.1	0.12	0.15
	钛合金 Titanium Alloy	1260-1400	375-410			30~50	0.1	0.12	0.15
N	铝合金 Aluminium Alloy	260-450	75-130						
H	淬硬钢 Hardened Steel	-	HRC50-60						
	淬硬铸铁 Hardened Cast Iron	-	HRC55						

M2390-XO10 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)				
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F5	M4	M5	R5	HF
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.2	0.24	0.24	0.27	0.8
		640-1010	190-300	160~250	150~240	125~225	0.18	0.2	0.2	0.24	0.75
	低合金钢 Low-alloyed Steel	700-950	200-280	150~240	125~225	100~200	0.18	0.2	0.2	0.24	0.75
	高合金钢 High-alloyed Steel	950-1200	280-355	120~160	100~150	80~120	0.16	0.18	0.18	0.2	0.6
M		1200-1400	355-415	80~100	75~90	60~75	0.16	0.18	0.18	0.2	0.6
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.16	0.18	0.18	0.2	0.6
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.16	0.18	0.18	0.2	0.6
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.12	0.15	0.15	0.18	0.5
K	灰口铸铁 Grey Cast Iron	200-350	180-245	180~320	160~240		0.24	0.27	0.27	0.3	1.0
	球墨铸铁 Nodular Cast Iron	400~700	155-265	125~225	120~200		0.2	0.24	0.24	0.27	0.8
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.18	0.2	0.2	0.24	0.75
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840-1180	250-350			40~60	0.1	0.12	0.12	0.15	0.45
	钛合金 Titanium Alloy	1260-1400	375-410			30~50	0.1	0.12	0.12	0.15	0.45
N	铝合金 Aluminium Alloy	260-450	75-130								
H	淬硬钢 Hardened Steel	-	HRC50-60								
	淬硬铸铁 Hardened Cast Iron	-	HRC55								

M2390-XO16 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)			
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F5	M4	R5	R7
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.2	0.24	0.27	0.27
		640-1010	190-300	160~250	150~240	125~225	0.18	0.2	0.24	0.24
	低合金钢 Low-alloyed Steel	700-950	200-280	150~240	125~225	100~200	0.18	0.2	0.24	0.24
	高合金钢 High-alloyed Steel	950-1200	280-355	120~160	100~150	80~120	0.16	0.18	0.2	0.2
M		1200-1400	355-415	80~100	75~90	60~75	0.16	0.18	0.2	0.2
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.16	0.18	0.2	0.2
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.16	0.18	0.2	0.2
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.12	0.15	0.18	0.18
K	灰口铸铁 Grey Cast Iron	200-350	180-245	180~320	160~240		0.24	0.27	0.3	0.3
	球墨铸铁 Nodular Cast Iron	400~700	155-265	125~225	120~200		0.2	0.24	0.27	0.27
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.18	0.2	0.24	0.24
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840-1180	250-350			40~60	0.1	0.12	0.15	0.15
	钛合金 Titanium Alloy	1260-1400	375-410			30~50	0.1	0.12	0.15	0.15
N	铝合金 Aluminium Alloy	260-450	75-130							
H	淬硬钢 Hardened Steel	-	HRC50-60							
	淬硬铸铁 Hardened Cast Iron	-	HRC55							

AHNO Loong Series-Cutting Parameters

M1300-RC10 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)		
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F5	M5	R5
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.2~0.75	0.24~0.8	0.27~1.0
		640-1010	190-300	160~250	150~240	125~225	0.18~0.6	0.2~0.75	0.24~0.8
	低合金钢 Low-alloyed Steel	700-950	200-280	150~240	125~225	100~200	0.18~0.6	0.2~0.75	0.24~0.8
	高合金钢 High-alloyed Steel	950-1200	280-355	120~160	100~150	80~120	0.16~0.5	0.18~0.6	0.2~0.75
M		1200-1400	355-415	80~100	75~90	60~75	0.16~0.5	0.18~0.6	0.2~0.75
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.16~0.5	0.18~0.6	0.2~0.75
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.16~0.5	0.18~0.6	0.2~0.75
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.12~0.45	0.15~0.5	0.18~0.6
K	灰口铸铁 Grey Cast Iron	200-350	180-245	180~320	160~240		0.24~0.8	0.27~1.0	0.3~1.2
	球墨铸铁 Nodular Cast Iron	400~700	155~265	125~225	120~200		0.2~0.75	0.24~0.8	0.27~1.0
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.18~0.6	0.2~0.75	0.24~0.8
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840-1180	250-350			40~60	0.1~0.4	0.12~0.45	0.15~0.5
	钛合金 Titanium Alloy	1260-1400	375~410			30~50	0.1~0.4	0.12~0.45	0.15~0.5
N	铝合金 Aluminium Alloy	260~450	75~130						
H	淬硬钢 Hardened Steel	-	HRC50-60						
	淬硬铸铁 Hardened Cast Iron	-	HRC55						

M1300-RC12 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)		
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F5	M5	R5
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.2~0.75	0.24~0.8	0.27~1.0
		640-1010	190-300	160~250	150~240	125~225	0.18~0.6	0.2~0.75	0.24~0.8
	低合金钢 Low-alloyed Steel	700-950	200-280	150~240	125~225	100~200	0.18~0.6	0.2~0.75	0.24~0.8
	高合金钢 High-alloyed Steel	950-1200	280-355	120~160	100~150	80~120	0.16~0.5	0.18~0.6	0.2~0.75
M		1200-1400	355-415	80~100	75~90	60~75	0.16~0.5	0.18~0.6	0.2~0.75
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.16~0.5	0.18~0.6	0.2~0.75
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.16~0.5	0.18~0.6	0.2~0.75
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.12~0.45	0.15~0.5	0.18~0.6
K	灰口铸铁 Grey Cast Iron	200-350	180-245	180~320	160~240		0.24~0.8	0.27~1.0	0.3~1.2
	球墨铸铁 Nodular Cast Iron	400~700	155~265	125~225	120~200		0.2~0.75	0.24~0.8	0.27~1.0
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.18~0.6	0.2~0.75	0.24~0.8
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840-1180	250-350			40~60	0.1~0.4	0.12~0.45	0.15~0.5
	钛合金 Titanium Alloy	1260-1400	375~410			30~50	0.1~0.4	0.12~0.45	0.15~0.5
N	铝合金 Aluminium Alloy	260~450	75~130						
H	淬硬钢 Hardened Steel	-	HRC50-60						
	淬硬铸铁 Hardened Cast Iron	-	HRC55						

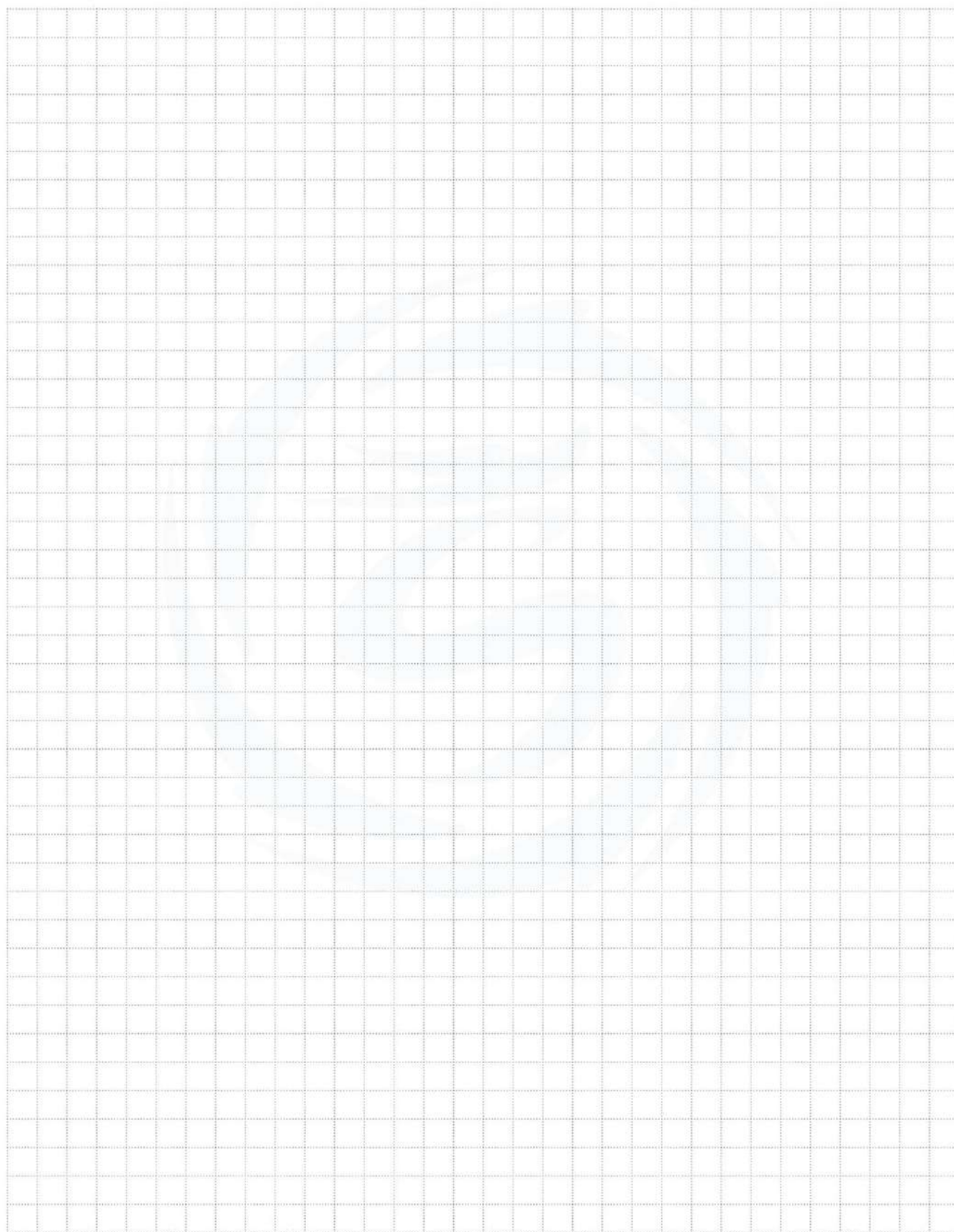
M1300-RC16 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)		
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F5	M5	R5
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.24~0.8	0.27~1.0	0.32~1.2
		640~1010	190~300	160~250	150~240	125~225	0.2~0.75	0.24~0.8	0.27~1.0
	低合金钢 Low-alloyed Steel	700~950	200~280	150~240	125~225	100~200	0.2~0.75	0.24~0.8	0.27~1.0
	高合金钢 High-alloyed Steel	950~1200	280~355	120~160	100~150	80~120	0.18~0.6	0.2~0.75	0.24~0.8
M		1200~1400	355~415	80~100	75~90	60~75	0.18~0.6	0.2~0.75	0.24~0.8
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.18~0.6	0.2~0.75	0.24~0.8
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.18~0.6	0.2~0.75	0.24~0.8
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.15~0.5	0.18~0.6	0.2~0.75
K	灰口铸铁 Grey Cast Iron	200~350	180~245	180~320	160~240		0.27~1.0	0.3~1.2	0.36~1.5
	球墨铸铁 Nodular Cast Iron	400~700	155~265	125~225	120~200		0.24~0.8	0.27~1.0	0.32~1.2
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.2~0.75	0.24~0.8	0.27~1.0
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840~1180	250~350			40~60	0.12~0.45	0.15~0.5	0.18~0.6
	钛合金 Titanium Alloy	1260~1400	375~410			30~50	0.12~0.45	0.15~0.5	0.18~0.6
N	铝合金 Aluminium Alloy	260~450	75~130						
H	淬硬钢 Hardened Steel	-	HRC50~60						
	淬硬铸铁 Hardened Cast Iron	-	HRC55						

M1300-RC20 Series

切削参数 Cutting Parameters				Vc (m/min)			fz(mm/z)		
ISO	材料组 Material Group	抗拉强度 Tensile Strength (N/mm ²)	布氏硬度 (HB)	ACP25A	APP25A	APU35A	F5	M5	R5
P	非合金钢 Unalloyed steel	430	125	225~270	180~270	160~240	0.24~0.8	0.27~1.0	0.32~1.2
		640~1010	190~300	160~250	150~240	125~225	0.2~0.75	0.24~0.8	0.27~1.0
	低合金钢 Low-alloyed Steel	700~950	200~280	150~240	125~225	100~200	0.2~0.75	0.24~0.8	0.27~1.0
	高合金钢 High-alloyed Steel	950~1200	280~355	120~160	100~150	80~120	0.18~0.6	0.2~0.75	0.24~0.8
M		1200~1400	355~415	80~100	75~90	60~75	0.18~0.6	0.2~0.75	0.24~0.8
	双相不锈钢 Duplex Stainless Steel	780	230		100~150	90~120	0.18~0.6	0.2~0.75	0.24~0.8
	奥氏体不锈钢 Austenitic Stainless Steel	680	200		120~160	100~125	0.18~0.6	0.2~0.75	0.24~0.8
	沉淀硬化不锈钢 PH Stainless Steel	1010	300		80~120	75~100	0.15~0.5	0.18~0.6	0.2~0.75
K	灰口铸铁 Grey Cast Iron	200~350	180~245	180~320	160~240		0.27~1.0	0.3~1.2	0.36~1.5
	球墨铸铁 Nodular Cast Iron	400~700	155~265	125~225	120~200		0.24~0.8	0.27~1.0	0.32~1.2
	蠕墨铸铁 Vermicular graphite cast iron	400	230	120~160	100~150		0.2~0.75	0.24~0.8	0.27~1.0
S	镍基 / 钴基合金 Cobalt Base Nickel Base Alloy	840~1180	250~350			40~60	0.12~0.45	0.15~0.5	0.18~0.6
	钛合金 Titanium Alloy	1260~1400	375~410			30~50	0.12~0.45	0.15~0.5	0.18~0.6
N	铝合金 Aluminium Alloy	260~450	75~130						
H	淬硬钢 Hardened Steel	-	HRC50~60						
	淬硬铸铁 Hardened Cast Iron	-	HRC55						

AHNO Loong Series-Cutting Parameters

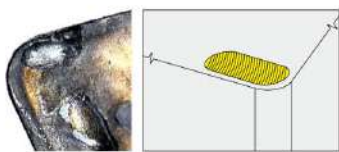
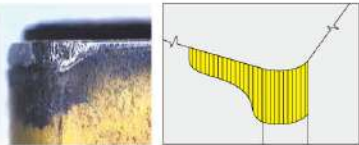
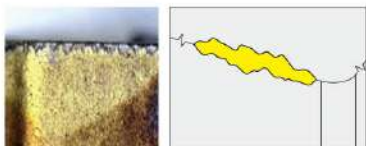
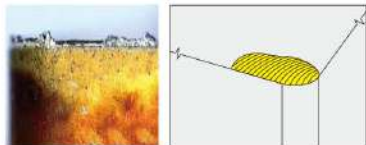
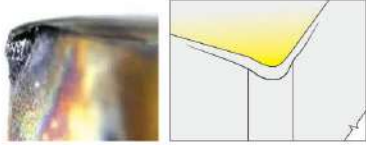
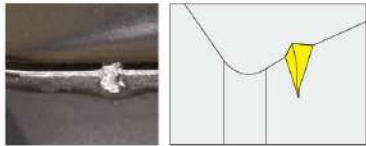


TECHNICAL INFORMATION

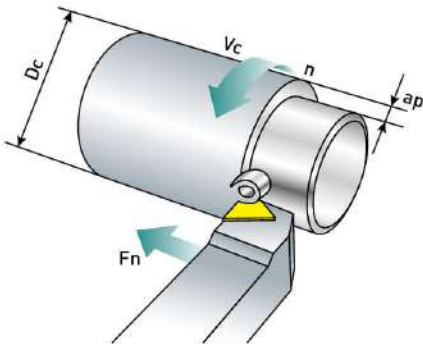
技术信息



Insert Failure Forms and Analysis

失效类型 Failure Type	表现形式 Patterns	原因分析 Reasons	改进措施 Solutions
月牙洼磨损 Crater Wear		刀片前刀面有凹陷状磨损 Oncave wear on the front edge of the insert 切屑与刀片前刀面的接触导致扩散磨损; 刀片材质过软; 线速度过高; The contact between the chip and the front edge of the insert leads to diffuse wear. Insert material is too soft. The linear velocity is too high.	选择更耐磨材质 (Al ₂ O ₃ 含量更高的涂层) 刀片; 降低线速度; 使用更开放槽型; 优化冷却; Choose more wear-resistant material (coating with higher Al ₂ O ₃ content) insert. Reduce the line speed. Use more open grooves. Optimized cooling.
后刀面磨损 Flank Face Wear		主要位于刀片后刀面的磨损 The wear is mainly on the back of the insert 刀片材质过软; 切削线速度过高; 进给量太小; Insert material is too soft. Cutting line speed is too high. The feed is too small.	选择更耐磨材质的刀片; 降低线速度; 提高进给量; 优化冷却; Choose Inserts with more wear resistant materials. Reduce the line speed. Increase the feed rate. Optimized cooling.
崩刃 Chipping		刀片切削刃或刀尖处崩口 The cutting edge or tip of the insert is broken 刀片材料过硬; 进给量太大; 刀片槽型刃口不够稳固; 刀杆、刀柄刚性不足; The insert material is excellent. The feed is too large. The groove edge of the insert is not stable enough. The tool bar and handle are not rigid enough.	使用韧性更好的刀片; 减小进给量; 使用更稳固的槽型; 加强刀杆结构, 减少悬长; Use inserts with better toughness. Reduce the feed rate. Use a more stable chipbreaker. Strengthen the tool bar structure to reduce the overhang length.
积屑瘤 Built-up Edge		刀片前刀面沿切削刃有工件材料粘结堆积 Oncave wear on the front edge of the insert The workpiece material is bonded and deposited along the cutting edge of the front cutter face of the insert.	提高切削线速度; 使用更加锋利的槽型; 选择亲和力小的刀具材料或涂层; 优化冷却; Improve cutting line speed. Use sharper grooves. Select tool materials or coatings with low affinity. Optimized cooling.
塑性变形 Plastic Deformation		刀尖或者切削刃塌陷变形 Tip or cutting edge collapse deformation 刀具材料过软; 切削速度过高; 切削深度, 进给太大; 切削温度过高; Tool material is too soft. Cutting speed is too high. Cutting depth, feed is too large. Cutting temperature is too high.	使用更耐磨材质的刀具; 降低切削速度; 减小切削深度, 进给量; 优化冷却; Use more wear-resistant tools. Reduce cutting speed. Reduce cutting depth and feed rate. Optimized cooling.
热龟裂 Thermal Crack		刀片切削刃上有梳齿状龟裂 There is a comb crack on the cutting edge of the insert 切削热引起的膨胀和收缩波动导致; 刀具材料过硬; Expansion and contraction fluctuation caused by cutting heat. The tool material is excellent.	采用干式切削或者精密充分的冷却; 使用韧性更好的刀具材质; Use dry cutting or precise and sufficient cooling. Use tool materials with better toughness.
沟槽磨损 Groove Wear		刀片切削刃上有缺口状磨损 Here is notched wear on the cutting edge of the insert 加工硬材料; 工件表面有氧化皮; Processing hard materials. The workpiece surface has oxide skin.	选择较小的主偏角; 使用变化的切深; 使用韧性更好的刀具材质; 使用更稳固的槽型; 优化冷却; Select the smaller main declination Angle. Use varying depth of cut. Use tool materials with better toughness. Use a more stable chipbreaker. Optimized cooling.

公式
Formulas



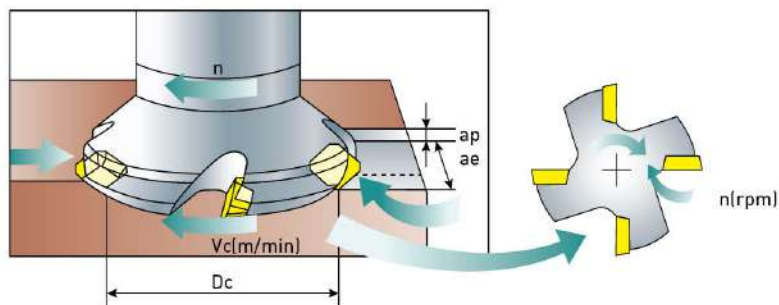
切削速度 Cutting Speed	$V_c = (D_c \times \pi \times n) \div 1000$
转速 Spindle Speed	$n = (V_c \times 1000) \div (D_c \times \pi)$
进给速度 Feed Rate	$V_f = n \times F_n$
每转进给量 Feed per Revolution	$F_n = V_f \div n$
金属去除率 Metal Removal Rate	$Q = V_c \times V_f \times A_p$
加工时间 Cutting Time	$T = L \div V_f$

释义
Terms

n	主轴转速 Spindle Speed	rpm
Vc	切削速度 Cutting Speed	m/min
Vf	进给速度 Feed Rate	mm/min
Fn	每转进给量 Feed per Revolution	mm
Dc	零件加工直径 Work Diameter	mm
ap	零件切深 Depth of Cut	mm
Q	金属去除率 Metal Removal Rate	cm ³ /min
L	零件加工长度 Length of Cut	mm
T	加工时间 Cutting Time	min
π	圆周率 3.14 π 3.14	

Milling Formulas

公式 Formulas

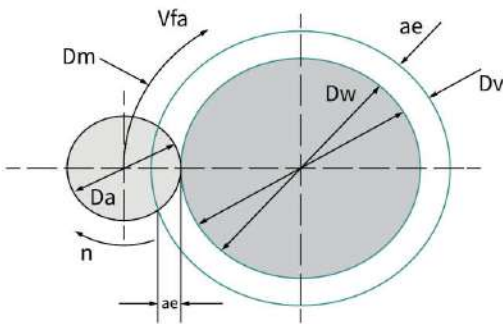


切削速度 Cutting Speed	$V_c = (D_c \times \pi \times n) \div 1000$
转速 Spindle Speed	$n = (V_c \times 1000) \div (D_c \times \pi)$
进给速度 Feed Rate	$V_f = f_z \times n \times Z$
每齿进给量 Feed per Revolution	$f_z = V_f \div (n \times Z)$
金属去除率 Metal Removal Rate	$Q = (a_p \times a_e \times V_f) \div 1000$
加工时间 Cutting Time	$T = L \div V_f$

释义 Terms

n	主轴转速 Spindle Speed	rpm
Vc	切削速度 Cutting Speed	m/min
Vf	进给速度 Feed Rate	mm/min
fz	每齿进给量 Feed per Tooth	mm
Dc	铣刀直径 Milling Diameter	mm
Z	铣刀齿数 Number of Milling Teeth	
ap	切深 Depth of Cut	mm
ae	切宽 Width of Cut	mm
Q	金属去除率 Metal Removal Rate	cm ³ /min
L	零件铣削长度 Cutting Edge Length	mm
T	加工时间 Cutting Time	min
π	圆周率 3.14 π 3.14	

外圆插补铣切削比例
Cylindrical Interpolation Milling Cutting Ratio



外部轮廓进给速度
External Profile Feed Speed

$$V_{fa} = \left(1 + \frac{D_c}{D_w + a_e} \right) \times V_f \quad [\text{mm/min}]$$

圆周插补铣加工时间
Circumferential Interpolation
Milling Time

$$T_{rev} = \frac{D_m \times \pi}{n \times f_z \times z} \quad [\text{min}] \quad T_{rev} = \frac{(D_w + D_a) D_a \times \pi^2 \times 60}{V_c \times f_z \times z \times 1000} \quad [\text{s}]$$

圆周插补铣切削宽度
Circumference Interpolation
Milling Cutting Width

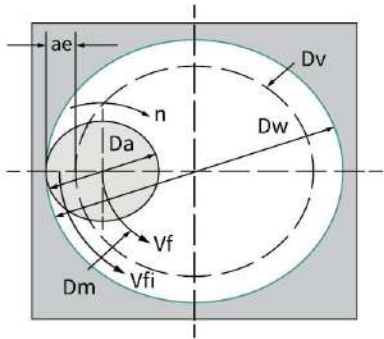
$$a_e = \frac{(D_v^2 - D_w^2)}{4(D_w + D_a)} \quad [\text{mm}]$$

外部轮廓
External Contour

Vfa	刀具中心轨迹进给速度 Tool Center Path Feed Speed	mm/min
Da	铣刀外径 Outside Diameter of Milling	m/min
Dm	中心轨迹直径 Center Track Diameter	mm/min
Dv	工件毛坯直径 The Blank Diameter of the Workpiece	mm
Dw	工件成品直径 Finished Diameter of Workpiece	mm
ae	切削宽度 Cutting Width	mm
n	转速 Rotational Speed	mm
fz	每齿进给量 Feed per Tooth	rpm
z	齿数 Number of Teeth	mm

Milling Formulas

插补铣孔的切削比例
Interpolation Cutting Ratio of the Milling Hole



内部轮廓进给速度
Internal Profile Feed Speed

$$V_{fi} = \left(1 - \frac{D_c}{D_w} \right) \times V_f \quad [\text{mm/min}]$$

圆周插补铣加工时间
Circumferential Interpolation
Milling Time

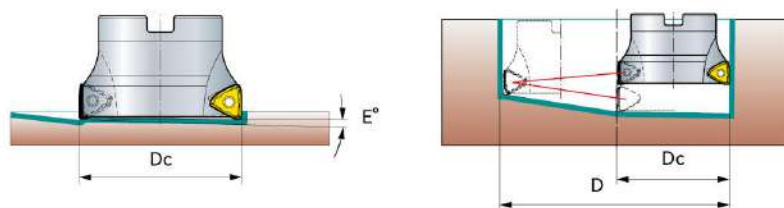
$$T_{rev} = \frac{D_m \times \pi}{n \times f_z \times z} \quad [\text{min}] \quad T_{rev} = \frac{(D_w - D_a) D_a \times \pi^2 \times 60}{V_c \times f_z \times z \times 1000} \quad [\text{s}]$$

圆周插补铣切削宽度
Circumference Interpolation
Milling Cutting Width

$$ae = \frac{(D^2_w - D^2_v)}{4 (D_w - D_a)} \quad [\text{mm}]$$

内部轮廓
Internal Contour

Vf	进给速度 Feed Rate	mm/min
Vfi	刀具中心轨迹进给速度 Tool Center Path Feed Speed	mm/min
Da	铣刀外径 Outside Diameter of Milling	mm
Dm	中心轨迹直径 Center Track Diameter	mm
Dv	工件毛坯直径 The Blank Diameter of the Workpiece	mm
Dw	工件成品直径 Finished Diameter of Workpiece	mm
ae	加工余量 Machining Allowance	mm
n	转速 Rotational Speed	rpm
fz	每齿进给量 Feed per Tooth	mm
z	齿数 Number of Teeth	
Trev	圆周插补铣加工时间 Circumferential Interpolation Milling Time	s



坡铣信息 Slope Milling

铣刀切削直径 Dc Milling Diameter	最大坡铣角度 E max Maximum Slope Milling Angle	最大坡铣深度 ap max Maximum Slope Milling Depth
18	1.8	3.05
20	1.6	2.7
22	1.2	2.0
25	1.0	1.7
30	0.9	1.45
32	0.8	1.3
35	0.65	1.0
40	0.6	0.9
50	0.5	0.7
63	0.4	0.5

螺旋插补铣(实心材料) Spiral Interpolation Milling (Solid material)

铣刀切削直径 D Milling Diameter	最小铣削孔径 D min Minimum Milling Diameter	最大铣削孔径 D max Maximum Milling Diameter	最大切深 ap max Maximum Depth of Cut
18	33	36	1.2
20	37	40	1.2
22	41	44	1.0
25	47	50	1.0
30	57	60	1.0
32	61	64	1.0
35	67	70	0.9
40	77	80	0.9
50	97	100	0.9
63	123	126	0.9

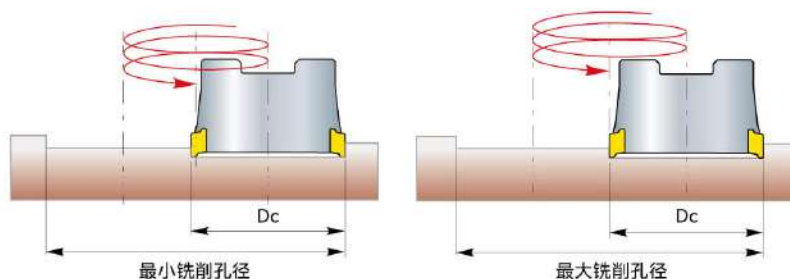
AHNO Milling Technology Application



坡铣信息

Slope Milling

铣刀切削直径 Dc Milling Diameter	XO10 (R ≤ 1.2)		XO16 (R ≤ 2.4)	
	最大坡铣角度 Maximum Slope Milling Angle	最大坡铣深度 Maximum Slope Milling Depth	最大坡铣角度 Maximum Slope Milling Angle	最大坡铣深度 Maximum Slope Milling Depth
16	11.7°	6		
20	8.3°	6		
25	6.1°	6	12°	15
32	4.4°	6	8°	15
40	3.4°	6	5°	15
50	2.6°	6	4°	15
63			3°	15
80			2°	15
100			1.5°	15
125			1°	15
160			1°	15



螺旋插补铣（实心材料）- XO10 系列

Spiral Interpolation Milling (Solid material) - XO10 Series

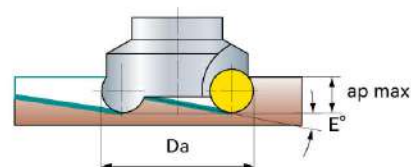
铣刀切削直径 Milling Diameter Dc	XO10	XO10-R0.2	XO10-R0.4	XO10-R0.8	XO10-R1.0	XO10-R1.2
	最小铣削孔径 Minimum Milling Diameter	最大铣削孔径 Maximum Milling Diameter				
16	28.4	31.6	31.2	30.4	30	29.6
20	36.4	39.6	39.2	38.4	38	37.6
25	46.4	49.6	49.2	48.4	48	47.6
32	60.4	63.6	63.2	62.4	62	61.6
40	76.4	79.6	79.2	78.4	78	77.6
50	96.4	99.6	99.2	98.4	98	97.6

螺旋插补铣（实心材料）- XO16 系列

Spiral Interpolation Milling (Solid material) - XO16 Series

铣刀切削直径 Milling Diameter Dc	XO16	XO16-R0.4	XO16-R0.8	XO16-R1.2	XO16-R1.6	XO16-R2.0
	最小铣削孔径 Minimum Milling Diameter	最小铣削孔径 Minimum Milling Diameter				
25	43.6	49.2	48.4	47.6	46.8	46
32	57.6	63.2	62.4	61.6	60.8	60
40	73.6	79.2	78.4	77.6	76.8	76
50	93.6	99.2	98.4	97.6	96.8	96
63	119.6	125.2	124.4	123.6	122.8	122
80	153.6	159.2	158.4	157.6	156.8	156
100	193.6	199.2	198.4	197.6	196.8	196
125	243.6	249.2	248.4	247.6	246.8	246
160	313.6	319.2	318.4	317.6	316.8	316

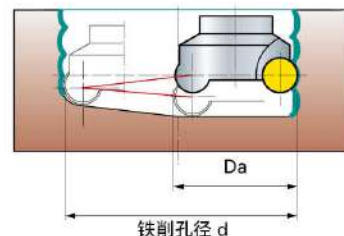
AHNO Milling Technology Application



坡铣信息

Slope Milling

铣刀切削直径 Milling Diameter D_a	RC10		RC12		RC16		RC20	
	最大坡铣角度 Maximum Slope Milling Angle	最大坡铣深度 Maximum Slope Milling Depth	最大坡铣角度 Maximum Slope Milling Angle	最大坡铣深度 Maximum Slope Milling Depth	最大坡铣角度 Maximum Slope Milling Angle	最大坡铣深度 Maximum Slope Milling Depth	最大坡铣角度 Maximum Slope Milling Angle	最大坡铣深度 Maximum Slope Milling Depth
25	13.2°	5.0						
32	12.6°	5.0						
35	12.3°	5.0						
40	9.5°	5.0	9.0°	6.0				
50	6.4°	5.0	7.0°	6.0				
52	6.1°	5.0	6.5°	6.0				
63	4.7°	5.0	5.0°	6.0	7.0°	8.0		
66	4.4°	5.0	4.5°	6.0	6.5°	8.0		
80			3.0°	5.1	5.0°	8.0	7.0°	10
100			2.0°	3.3	4.0°	6.8	5.0°	8.6



螺旋插补铣（实心材料）

Spiral Interpolation Milling (Solid material)

铣刀切削直径 Milling Diameter Da	RC10		RC12		RC16		RC20	
	最小铣削孔径 Minimum Milling Diameter	最大铣削孔径 Maximum Milling Diameter	最小铣削孔径 Minimum Milling Diameter	最大铣削孔径 Maximum Milling Diameter	最小铣削孔径 Minimum Milling Diameter	最大铣削孔径 Maximum Milling Diameter	最小铣削孔径 Minimum Milling Diameter	最大铣削孔径 Maximum Milling Diameter
25	32	50						
32	45	64						
35	51	70						
40	61	80	56	80				
50	81	100	76	100				
52	85	104	80	104				
63	107	126	102	126	94	126		
66	113	132	108	132	100	132		
80			136	160	128	160	120	160
100			176	200	168	200	160	200

AHNO Loong Series-Indexable Millings Attachment

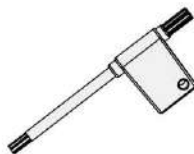
刀片锁紧螺钉
Insert Locking Screw

序号 No.	螺钉型号 Screw Type	Torx	紧固扭矩 Fastening Torque	尺寸 Diameter
1	AF9041	7IP	0.8 Nm	M2.5*6
2	AF9011	8IP	1.2 Nm	M2.5*7.3
3	AF9051	9IP	2.0 Nm	M3*6
4	AF9021	9IP	2.0 Nm	M3*7.3
5	AF9061	10IP	3.0 Nm	M3.5*9
6	AF9062	15IP	3.0 Nm	M3.5*10
7	AF9052	15	3.0 Nm	M3.5*11
8	AF9012	15IP	3.0 Nm	M4*8.5
9	AF9042	15IP	3.5 Nm	M4*10
10	AF9022	15IP	5.0 Nm	M4.5*11
11	AF9031	20IP	5.0 Nm	M5*13
12	AF9063	20IP	5.0 Nm	M5*14
13	AF9064	25IP	7.5 Nm	M6*15

阿诺 - Loong 龍系列产品 - 旗形扳手



AHNO Loong Series-Flag-shaped Wrench

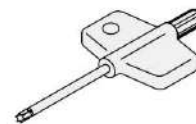


序号 No.	螺丝刀型号 Screwdriver Type	Torx
1	AF8010-T07IP	T07IP
2	AF8010-T08IP	T08IP
3	AF8010-T09IP	T09IP
4	AF8010-T10IP	T10IP
5	AF8010-T15IP	T15IP

阿诺 - Loong 龍系列产品 - 钥匙形扳手



AHNO Loong Series-Key-shaped Wrench



序号 No.	螺丝刀型号 Screwdriver Type	Torx
1	AF8020-T07IP	T07IP
2	AF8020-T08IP	T08IP
3	AF8020-T09IP	T09IP
4	AF8020-T10IP	T10IP
5	AF8020-T15	T15
6	AF8020-T15IP	T15IP

阿诺 - Loong 龍系列产品 - 螺丝刀



AHNO Loong Series-Screwdriver

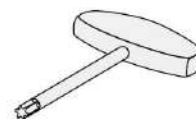


序号 No.	螺丝刀型号 Screwdriver Type	Torx
1	AF8030-T15IP	T15IP
2	AF8030-T20IP	T20IP

阿诺 - Loong 龍系列产品 - T 型扳手



AHNO Loong Series-T-shaped Wrench

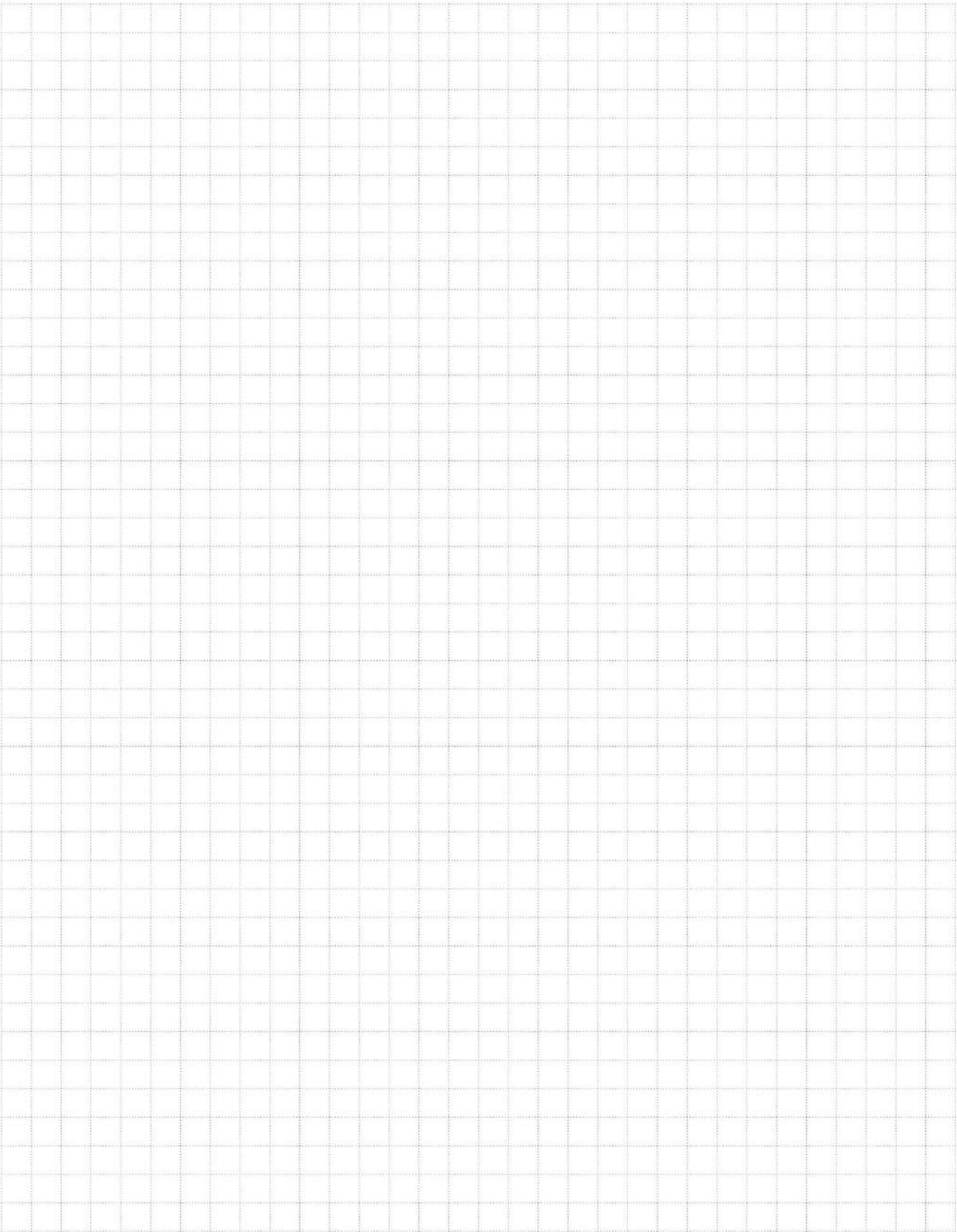


序号 No.	螺丝刀型号 Screwdriver Type	Torx
1	AF8040-T25IP	T25IP

硬度换算对照表

Hardness Conversion Table

布氏硬度 (HB)	维氏硬度 (HV)	洛氏硬度 (HR)		抗拉强度 Tensile Strength (N/mm ²)
		150kg 金钢石锥 Diamond Cone (HRC)	100kg 钢球 Steel Ball (HRB)	
208	198	-	93	667
212	201	-	94	680
217	206	(16.0)	95	696
220	209	(17.5)	95	706
222	211	(18.7)	96	716
235	223	(19.1)	97	755
242	230	20.2	97	775
248	236	22.1	99	794
257	244	23.1	100	824
262	249	24.1	100	838
266	253	24.8	101	853
272	258	25.7	101	870
275	261	26.4	102	880
277	263	27.0	103	892
291	276	29.1	104	941
302	287	29.9	105	971
308	293	30.9	106	990
315	299	32.1	107	1020
322	306	32.3	107	1035
325	309	32.4	107	1049
338	321	33.6	107	1089
343	326	35.4	108	1118
361	343	36.6	109	1157
369	351	37.6	110	1187
383	364	39.4	-	1236
392	372	40.3	-	1265
408	388	41.7	-	1314
425	404	42.9	-	1363
433	411	43.6	-	1390
441	419	44.6	-	1422
447	425	45.0	-	1447
455	432	45.8	-	1471
470	447	46.9	-	1520
485	461	48.1	-	1569



A

B

C

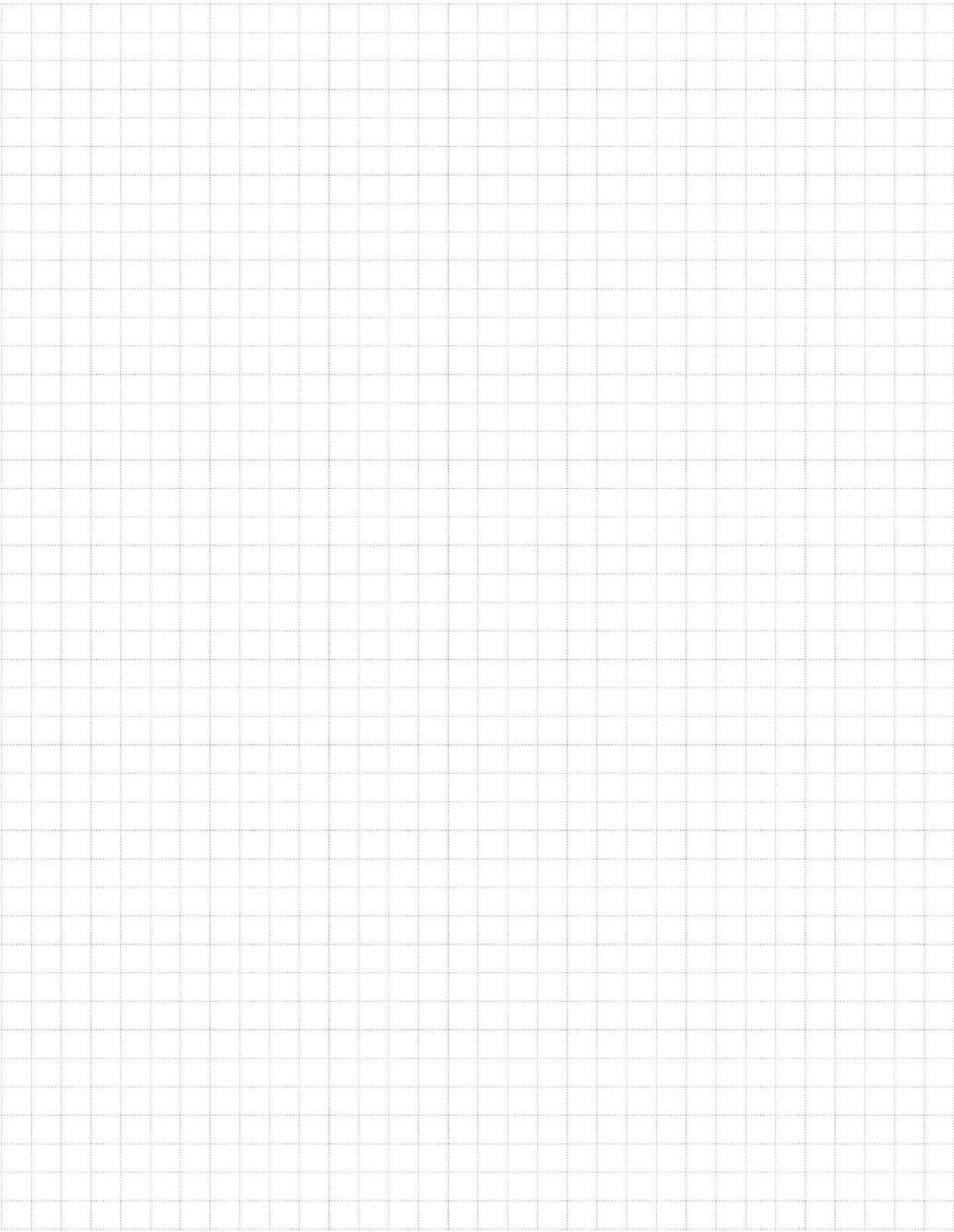
D

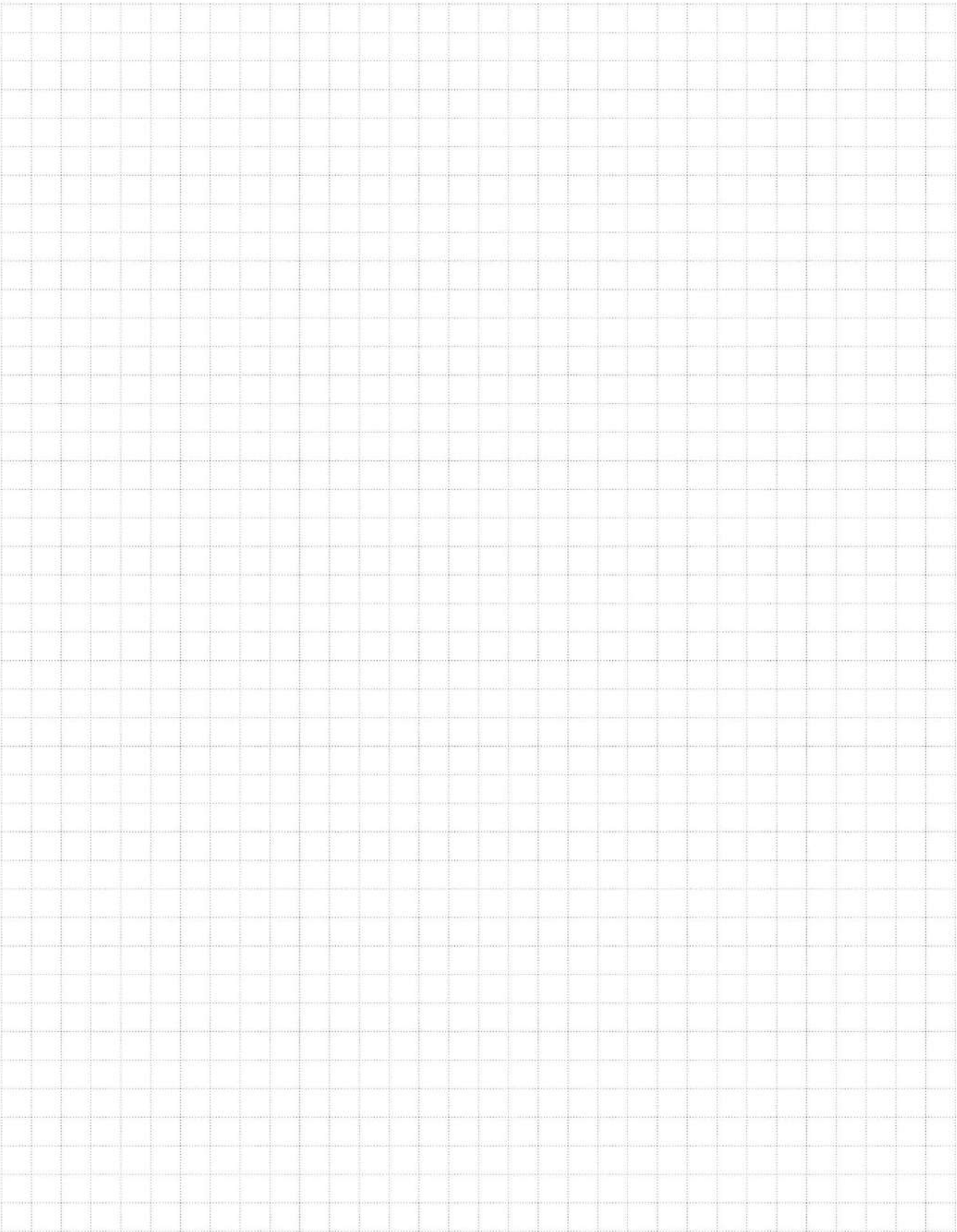
E

F

G

H





A

B

C

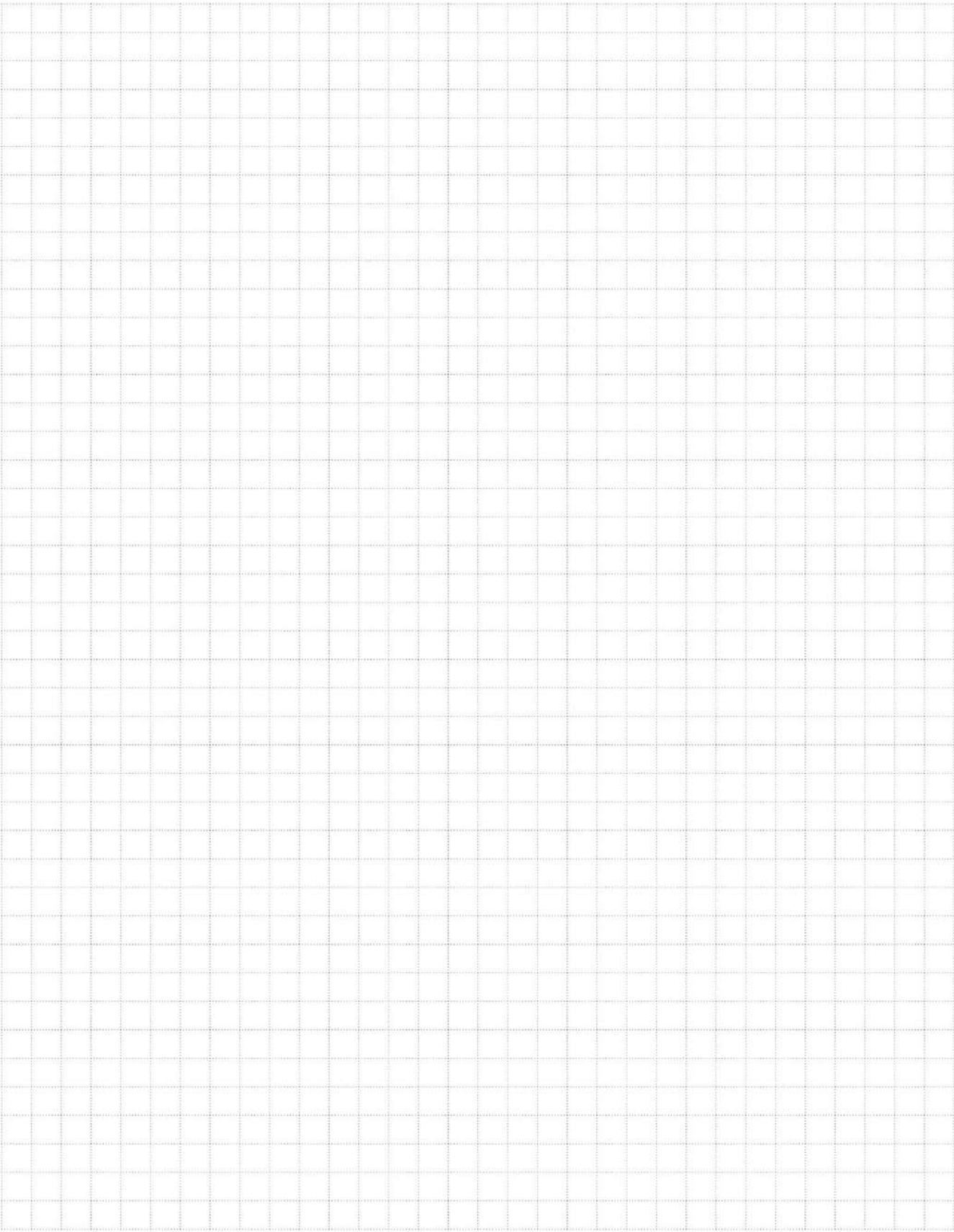
D

E

F

G

H





苏州阿诺精密切削技术有限公司

地址：江苏省苏州市工业园区科智路9号
邮编：215122 网址: www.ahno-tool.com



阿诺微信公众号



阿诺官网