DORMER PRAMET

可转位铣削的

2024

PRAMET

可转位铣削的一般内容

可转位铣削的									
端面铣削		负角刀片	SON06C 16 APMX 4	SHN06C 12 APMX 3	SHN09C 12 APMX 5	SPN13 10 APMX 10			7
		正角方形刀片	SSD13F 4 APMX 6.4	SSE09 4 APMX 4.5	SSN12Z 4 APMX 6.5	FSB22X 4 APMX 15			25
		正八边形和圆形刀片	SOD05 8 APMX 2.7	SOD06D 8 APMX 3.1	SOE06Z 8 APMX 3.3				41
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		正角A形刀片	SAD07D 2 APMX 5	SAD11E 2 APMX 9	SAD16E 2 APMX 13	SAP10D 2 APMX 9	SAP16D 2 APMX 13		89
		正角方形和三角形刀片	SSO09 4 APMX 8	SSD12 4 APMX 12	FTB27X 3 APMX 18				121
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		带定位平面的刀片座 (RC. 7°后角)	SRC10 8 a_p 1.46	SRC12 6 a_p 3	SRC16 8 a_p 2.3	SRC20 8 a_p 2.9			185
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		牛鼻	SVC22C 2 APMX 16	SCN05C 4 APMX 0.5	SWN04 6 APMX 0.5				239
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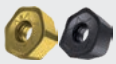
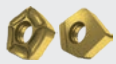
负角刀片

可转位铣刀 – 导航工具

平面铣

	SON06C	SHN06C	SHN09C	SPN13		
	43°	45°	45°	57°		
	APMX (mm) 4.0 (7.0)	APMX (mm) 3.0	APMX (mm) 5.0	APMX (mm) 10.0		
	DC (mm) 50 – 250	DC (mm) 25 – 125	DC (mm) 50 – 315	DC (mm) 100 – 315		
圆柱刀柄						
侧固刀柄		DC = 25, 32 (mm)				
模块式刀柄						
套式铣刀		DC = 40 – 125 (mm)				
页码	8	13	17	21		
ISO	P M K S H	P M K H	P M K H	P M K S H		
刀片形状						
刀片	ONMX 0605 SNMX 1705	HNGX 0604 XNGX 0604	HNGX 0906 XNGX 0906	PNM. 1308 XN.. 1308		
切削刃数量	16 / 8	12 / 1	12 / 1	10 / 1		
平面铣	■	■	■	■		
倒角铣	■	■	■			
连续钻铣		■	■			
坡走铣	◪	■	■			

■ 推荐使用　◪ 可以使用

SON06C

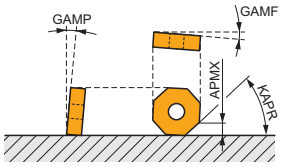
P M K S H

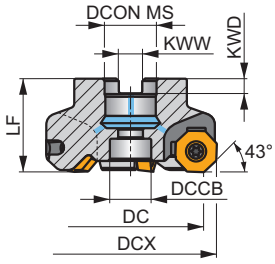
PRAMET

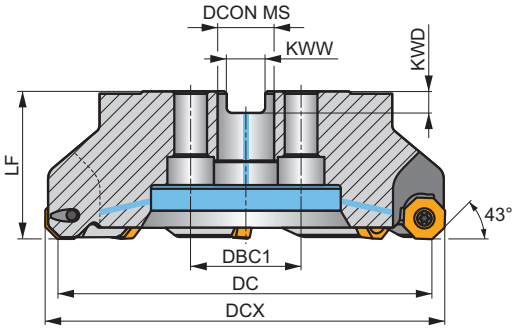
S

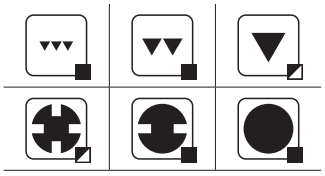
ECON ON06 43°面铣刀，具有双面负前角设计和内冷通道
高经济性高生产力面铣刀，可以使用两种型号的双面负前角刀片具有16个切削刃，最大切深为4mm的经济型八角形ON..06刀片，以及高生产力的立装方形刀片SN..17，有8个切削刃的刀片以及最大切深7mm可提供不等齿距的芯轴式刀盘。刀体经过处理，使用寿命更长。

KAPR	43°
APMX	4.0 (7.0) mm









h_m 0.04 - 0.25

	Product	DC (mm)	DCX (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
	50A04R-S45ON06-C	50	60.8	22	16.5	–	40	10.4	6.3	-10	-5	4	✓	9400	✓	0.42	GI342	C0621	–
	50A05R-S45ON06-C	50	60.8	22	16.5	–	40	10.4	6.3	-10	-5	5	–	9400	✓	0.39	GI342	C0621	–
	63A05R-S45ON06-C	63	73.8	22	18.1	–	40	10.4	6.3	-10	-5	5	✓	8400	✓	0.71	GI342	C0621	–
	63A06R-S45ON06-C	63	73.8	22	18.1	–	40	10.4	6.3	-10	-5	6	✓	8400	✓	0.55	GI342	C0621	–
	80A06R-S45ON06-C	80	90.8	27	22.1	–	50	12.4	7	-10	-5	6	✓	7500	✓	1.27	GI342	C0622	–
	80A08R-S45ON06-C	80	90.8	27	22.1	–	50	12.4	7	-10	-5	8	–	7500	✓	1.19	GI342	C0622	–
	100A08R-S45ON06-C	100	110.8	32	30.1	–	50	14.4	8	-10	-5	8	✓	6700	✓	1.88	GI342	C0620	AC002
	100A10R-S45ON06-C	100	110.8	32	30.1	–	50	14.4	8	-10	-5	10	–	6700	✓	1.81	GI342	C0620	AC002
ISO 6462 DIN 8030	**125A08R-S45ON06-C**	125	135.8	40	56.1	–	63	16.4	9	-10	-5	8	✓	6000	✓	3.80	GI342	C0620	AC003
	125A10R-S45ON06-C	125	135.8	40	56.1	–	63	16.4	9	-10	-5	10	✓	6000	✓	3.65	GI342	C0620	AC003
	125A12R-S45ON06-C	125	135.8	40	56.1	–	63	16.4	9	-11	-5	12	–	6000	✓	3.70	GI342	C0620	AC003
	160C08R-S45ON06-C	160	170.8	40	–	66.7	63	16.4	9.25	-10	-5	8	✓	5700	✓	6.48	GI342	C0623	–
	160C12R-S45ON06-C	160	170.8	40	–	66.7	63	16.4	9.25	-10	-5	12	✓	5700	✓	5.74	GI342	C0623	–
	160C14R-S45ON06-C	160	170.8	40	–	66.7	63	16.4	9.25	-11	-5	14	–	5700	✓	5.65	GI342	C0623	–
	200C12R-S45ON06-C	200	210.8	60	–	101.6	63	25.8	14.25	-10	-5	12	✓	4700	✓	9.06	GI342	C0624	–
	200C16R-S45ON06-C	200	210.8	60	–	101.6	63	25.8	14.25	-10	-5	16	–	4700	✓	9.02	GI342	C0624	–
	250C14R-S45ON06-C	250	260.8	60	–	101.6	63	25.8	14.25	-10	-5	14	✓	4300	✓	15.71	GI342	C0625	–
	250C18R-S45ON06-C	250	260.8	60	–	101.6	63	25.8	14.25	-10	-5	18	–	4300	✓	15.51	GI342	C0625	–

GI342	ONMX 0605..	ONMX 0605..-W..	SNMX 1705..

C0620	US 45013A-T20P	5.0 Nm	M 5	13	SDR T20P-T	–	–	–	–

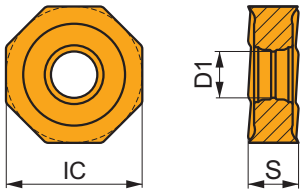
		Nm							
C0621	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1030C	–	–	–
C0622	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1230C	–	–	–
C0623	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5
C0624	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1655C	CAC 200C	HSD 1025C	HXK 7
C0625	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1655C	CAC 250C	HSD 1025C	HXK 7

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

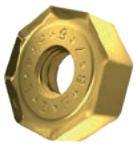
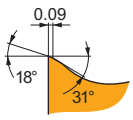
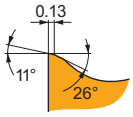
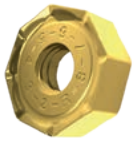
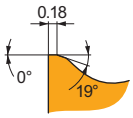
ONMX 06

PRAMET

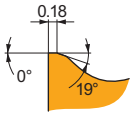
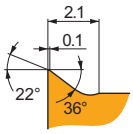
	IC (mm)	D1 (mm)	S (mm)
0605	17.000	5.70	7.08



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
F 型非常锋利，用于精加工，适合大悬伸，薄壁及细长工件应用。大正前角设计，窄T-型倒棱和圆角切削刃，用于轻载加工。																				
ONMX 060508SR-F:8215		0.8	275	0.10	2.0	165	0.09	2.0	–	–	–	–	–	–	65	0.07	1.6	–	–	–
ONMX 060508SR-F:M6330		0.8	230	0.10	2.0	165	0.09	2.0	–	–	–	–	–	–	65	0.07	1.6	–	–	–
ONMX 060508SR-F:M8330		0.8	270	0.10	2.0	160	0.09	2.0	–	–	–	–	–	–	65	0.07	1.6	–	–	–
ONMX 060508SR-F:M8340		0.8	245	0.10	2.0	145	0.09	2.0	–	–	–	–	–	–	60	0.07	1.6	–	–	–
ONMX 060508SR-F:M9340		0.8	320	0.10	2.0	190	0.09	2.0	–	–	–	–	–	–	80	0.07	1.6	–	–	–
																				
M 型用途广泛，适用于多种加工条件的通用选择。正前角设计，中等T-型倒棱和圆角切削刃，用于中等加工。																				
ONMX 060508SR-M:8215		0.8	230	0.20	2.0	135	0.18	2.0	–	–	–	–	–	–	55	0.14	1.6	45	0.14	1.0
ONMX 060508SR-M:M6330		0.8	195	0.20	2.0	140	0.18	2.0	–	–	–	–	–	–	55	0.14	1.6	–	–	–
ONMX 060508SR-M:M8330		0.8	230	0.20	2.0	135	0.18	2.0	–	–	–	–	–	–	55	0.14	1.6	45	0.14	1.0
ONMX 060508SR-M:M8340		0.8	210	0.20	2.0	125	0.18	2.0	–	–	–	–	–	–	50	0.14	1.6	–	–	–
ONMX 060508SR-M:M9325		0.8	285	0.20	2.0	–	–	–	–	–	–	–	–	–	–	–	–	55	0.14	1.0
ONMX 060508SR-M:M9340		0.8	255	0.20	2.0	150	0.18	2.0	–	–	–	–	–	–	60	0.14	1.6	–	–	–
 																				
R 型强壮坚固，用于粗加工和重载加工。小前角设计，宽T-型倒棱和圆角切削刃，用于粗加工。																				
ONMX 060508SR-R:8215		0.8	210	0.30	2.0	–	–	–	195	0.30	2.0	–	–	–	–	–	–	40	0.21	1.0
ONMX 060508SR-R:M5315		0.8	255	0.30	2.0	–	–	–	240	0.30	2.0	–	–	–	–	–	–	50	0.21	1.0
ONMX 060508SR-R:M8330		0.8	210	0.30	2.0	–	–	–	195	0.30	2.0	–	–	–	–	–	–	40	0.21	1.0

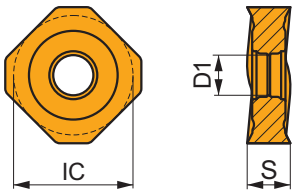
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
R 型强壮坚固，用于粗加工和重载加工。小前角设计，宽T-型倒棱和圆角切削刃，用于粗加工。																				
ONMX 060508SR-R:M8340		0.8	190	0.30	2.0	–	–	–	180	0.30	2.0	–	–	–	–	–	–	–	–	–
ONMX 060508SR-R:M9325		0.8	250	0.30	2.0	–	–	–	235	0.30	2.0	–	–	–	–	–	–	50	0.21	1.0
																				
W 修光刃设计，在大尺寸刀盘和大进给量应用场景下用于改善表面光洁度。																				
ONMX 060508SR-W:8215		0.8	340	0.10	0.3	200	0.09	0.3	–	–	–	–	–	–	–	–	–	–	–	–
ONMX 060508SR-W:M8330		0.8	325	0.10	0.3	195	0.09	0.3	–	–	–	–	–	–	–	–	–	–	–	–

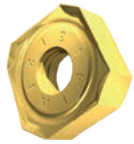
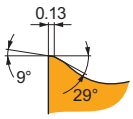
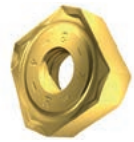
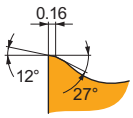
SNMX 17

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1705	17.000	5.70	5.56

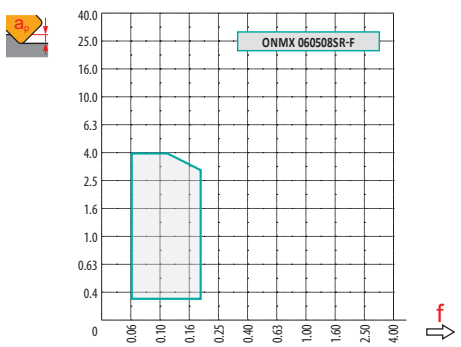


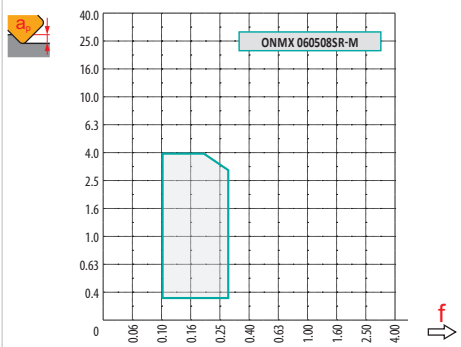
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

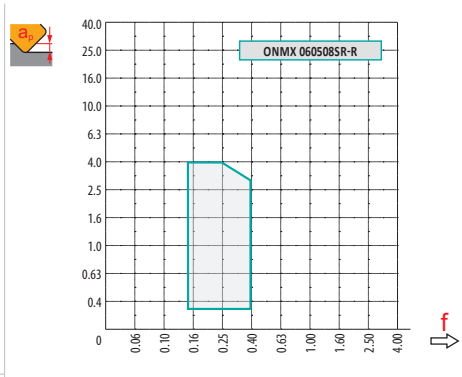
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
M 型用途广泛，适用于多种加工条件的通用选择。正前角设计，中等T-型倒棱和圆角切削刃，用于中等加工。																				
SNMX 170508SR-M:8215		0.8	265	0.20	4.0	155	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	50	0.14	1.0
SNMX 170508SR-M:M6330		0.8	225	0.20	4.0	160	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	–	–	–
SNMX 170508SR-M:M8330		0.8	265	0.20	4.0	155	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	50	0.14	1.0
SNMX 170508SR-M:M8340		0.8	240	0.20	4.0	140	0.18	4.0	–	–	–	–	–	–	60	0.14	3.2	–	–	–
SNMX 170508SR-M:M9325		0.8	325	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	65	0.14	1.0
SNMX 170508SR-M:M9340		0.8	295	0.20	4.0	175	0.18	4.0	–	–	–	–	–	–	70	0.14	3.2	–	–	–
 																				
R 型强壮坚固，用于粗加工和重载加工。小前角设计，宽T-型倒棱和圆角切削刃，用于粗加工。																				
SNMX 170508SR-R:8215		0.8	240	0.30	4.0	–	–	–	225	0.30	4.0	–	–	–	–	–	–	45	0.21	1.0
SNMX 170508SR-R:M5315		0.8	300	0.30	4.0	–	–	–	285	0.30	4.0	–	–	–	–	–	–	60	0.21	1.0
SNMX 170508SR-R:M8330		0.8	240	0.30	4.0	–	–	–	225	0.30	4.0	–	–	–	–	–	–	45	0.21	1.0
SNMX 170508SR-R:M8340		0.8	220	0.30	4.0	–	–	–	205	0.30	4.0	–	–	–	–	–	–	–	–	–
SNMX 170508SR-R:M9325		0.8	290	0.30	4.0	–	–	–	275	0.30	4.0	–	–	–	–	–	–	55	0.21	1.0

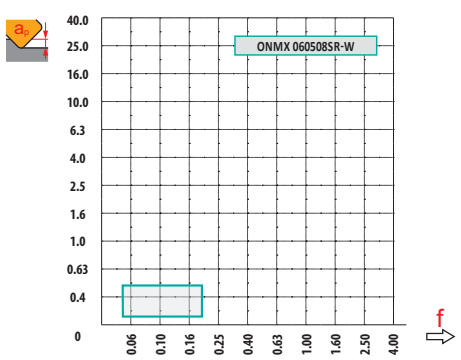
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

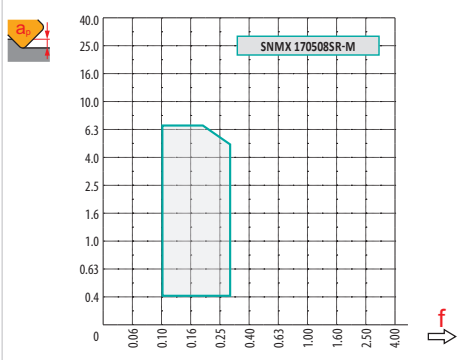
	ONMX 06-F	ONMX 06-M	ONMX 06-R	ONMX 06-W	SNMX 17-M	SNMX 17-R
RE	0.80	0.80	0.80	0.80	0.80	0.80
BS	0.75	0.75	0.75	4.30	0.70	0.70

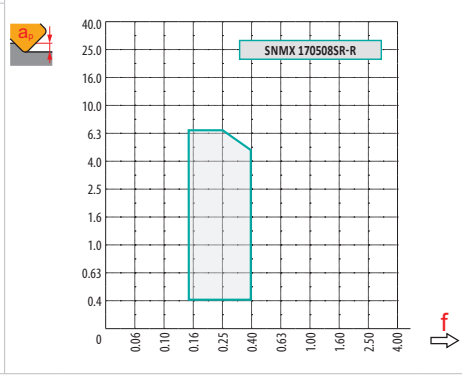












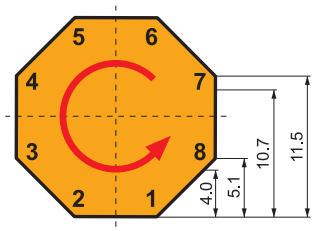
DC	a_p	0.50	1.00	1.50	2.00	2.50	3.00	3.50	4.00
50	DEF	51.06	52.11	53.19	54.27	55.35	56.43	57.51	58.59
63		64.06	65.11	66.19	67.27	68.35	69.43	70.51	71.59
80		81.06	82.11	83.19	84.27	85.35	86.43	87.51	88.59
100		101.06	102.11	103.19	104.27	105.35	106.43	107.51	108.59
125		126.06	127.11	128.19	129.27	130.35	131.43	132.51	133.59
160		161.06	162.11	163.19	164.27	165.35	166.43	167.51	168.59
200		201.06	202.11	203.19	204.27	205.35	206.43	207.51	208.59
250		251.06	252.11	253.19	254.27	255.35	256.43	257.51	258.59

DC	S							
	a_p	0.00	1.00	2.00	3.00	4.00	5.00	6.00	7.00
50	DEF	47.24	49.40	51.56	53.73	55.90	58.06	60.23	62.40
63		60.24	62.40	64.56	66.73	68.90	71.06	73.23	75.40
80		77.24	79.40	81.56	83.73	85.90	88.06	90.23	92.40
100		97.24	99.40	101.56	103.73	105.90	108.06	110.23	112.40
125		122.24	124.40	126.56	128.73	130.90	133.06	135.23	137.40
160		157.24	159.40	161.56	163.73	165.90	168.06	170.23	172.40
200		197.24	199.40	201.56	203.73	205.90	208.06	210.23	212.40
250		247.24	249.40	251.56	253.73	255.90	258.06	260.23	262.40

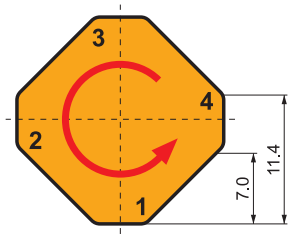
DC	X.V	f_{max}
50	1.35	0.36
63	1.39	0.40
80	1.44	0.45
100	1.48	0.51
125	1.53	0.57
160	1.58	0.64
200	1.63	0.72
250	1.68	0.80

O		
DC	RPMX	APMX/l
50	0.3	0.4/100
63	0.2	0.25/100
80	0.2	0.2/100
100	0.1	0.1/100
125	0.1	0.05/100

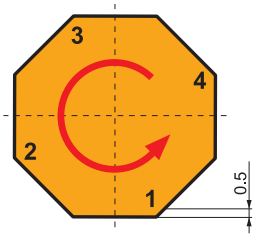
S		
DC	RPMX	APMX/l
47.24	0.1	0.1/100
60.24	0.1	0.05/100
77.24	0.1	0.05/100



a_p	
–> 4.0	16
–> 5.1	14
–> 10.7	8
–> 11.5	6



a_p	
–> 7.0	8
–> 11.4	4



ONMX 06-W	
a_p	
–> 0.5	8

SHN06C

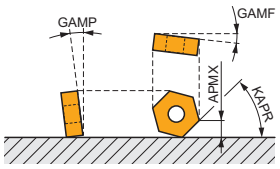
P M K H

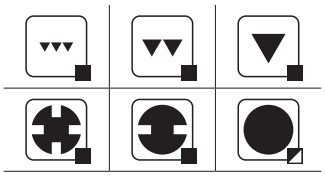
PRAMET

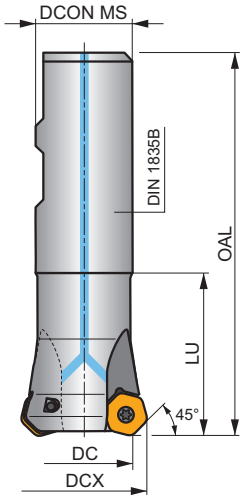
S

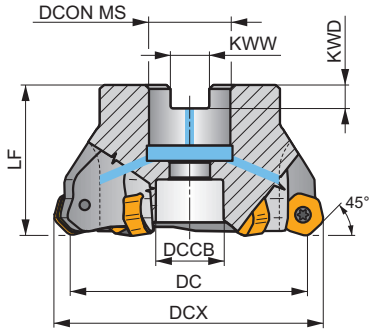
ECON HN06 45°面铣，具有双面负前角设计，带内冷
高效富有成效的45度⊠面铣，使用双面HN.. 06类型刀片，具有APMX(最大切深)3mm。粗加工，精加工和倒角加工。经济型刀片，具有12个切削刃。不等齿距，侧固柄，模块夹紧系统和心轴式接口。刀体经过处理，使用寿命更长。

KAPR	45°
APMX	3.0 mm









h_m	0.06 - 0.15
h_m	0.06 - 0.15

	Product	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	25N2R042B25-SHN06C-C	25	32.2	99	25	–	42	–	–	–	-7	-7	2	–	17400	✓	0.35	GI204	FA010	–
DIN 1835B	32N3R042B32-SHN06C-C	32	39.3	103	32	–	42	–	–	–	-7	-7	3	–	15400	✓	0.59	GI204	FA010	–
	40A05R-S45HN06C-C	40	47.3	–	16	14	–	40	8.4	5.6	-7	-7	5	✓	13800	✓	0.37	GI204	FA012	–
	50A04R-S45HN06C-C	50	57.3	–	22	18	–	40	10.4	6.3	-7	-7	4	✓	12300	✓	0.54	GI204	FA013	–
	50A06R-S45HN06C-C	50	57.3	–	22	18	–	40	10.4	6.3	-7	-7	6	✓	12300	✓	0.41	GI204	FA013	–
	63A06R-S45HN06C-C	63	70.3	–	22	18	–	40	10.4	6.3	-7	-7	6	✓	11000	✓	0.68	GI204	FA013	–
ISO 6462 DIN 8030	63A08R-S45HN06C-C	63	70.3	–	22	18	–	40	10.4	6.3	-7	-7	8	✓	11000	✓	0.68	GI204	FA013	–
	80A07R-S45HN06C-C	80	86.8	–	27	38	–	50	12.4	7	-7	-7	7	✓	9700	✓	1.10	GI204	FA011	AC001
	80A10R-S45HN06C-C	80	86.8	–	27	38	–	50	12.4	7	-7	-7	10	✓	9700	✓	1.10	GI204	FA011	AC001
	100A08R-S45HN06C-C	100	107.1	–	32	45	–	50	14.4	8	-7	-7	8	✓	8700	✓	2.00	GI204	FA011	AC002
	100A12R-S45HN06C-C	100	107.1	–	32	45	–	50	14.4	8	-7	-7	12	✓	8700	✓	1.82	GI204	FA011	AC002
	125A10R-S45HN06C-C	125	132.2	–	40	56	–	63	16.4	9	-7	-7	10	✓	7800	✓	3.53	GI204	FA011	AC003

GI204	HNGX 0604AN..	XNGX 0604AN..

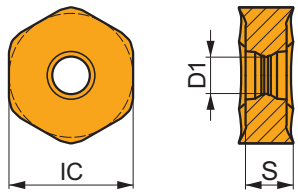
		Nm						
FA010	US 3007-T09P	2.0	M 3	7.3	–	–	Flag T09P	–
FA011	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	–
FA012	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 0830C
FA013	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

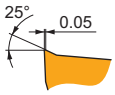
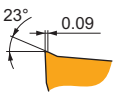
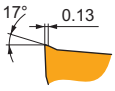
HNGX 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0604	10.500	3.70	4.76

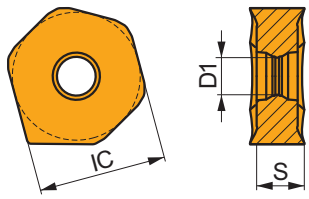


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

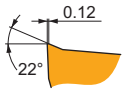
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F 型，具有大正前角设计，适用于轻载加工。																				
HNGX 0604ANSN-F:8215		–	■ 315	0.11	1.7	◪ 185	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M6330		–	■ 265	0.11	1.7	◪ 185	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M8330		–	■ 305	0.11	1.7	◪ 180	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M8340		–	■ 285	0.11	1.7	◪ 170	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M9340		–	■ 365	0.11	1.7	◪ 215	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
M 型，具有大正前角设计，适用于中等加工。																				
HNGX 0604ANSN-M:8215		–	■ 300	0.13	2.0	◪ 180	0.13	2.0	■ 285	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M5315		–	◪ 425	0.13	2.0	–	–	–	■ 400	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M6330		–	■ 255	0.13	2.0	◪ 180	0.13	2.0	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M8310		–	■ 325	0.13	2.0	◪ 165	0.13	2.0	■ 305	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M8330		–	■ 295	0.13	2.0	◪ 175	0.13	2.0	■ 280	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M8340		–	■ 265	0.13	2.0	◪ 155	0.13	2.0	◪ 250	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M9315		–	■ 410	0.13	2.0	–	–	–	■ 385	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M9325		–	■ 375	0.13	2.0	–	–	–	■ 355	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M9340		–	■ 345	0.13	2.0	◪ 205	0.13	2.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
R 型，具有大正前角设计，适用于中等加工到重载加工。																				
HNGX 0604ANSN-R:8215		–	■ 280	0.18	1.8	◪ 165	0.18	1.8	■ 265	0.18	1.8	–	–	–	–	–	–	◪ 55	0.12	1.0
HNGX 0604ANSN-R:M5315		–	◪ 370	0.18	1.8	–	–	–	■ 350	0.18	1.8	–	–	–	–	–	–	◪ 70	0.12	1.0
HNGX 0604ANSN-R:M8310		–	■ 300	0.18	1.8	◪ 150	0.18	1.8	■ 285	0.18	1.8	–	–	–	–	–	–	◪ 60	0.12	1.0
HNGX 0604ANSN-R:M8330		–	■ 275	0.18	1.8	◪ 165	0.18	1.8	■ 260	0.18	1.8	–	–	–	–	–	–	◪ 55	0.12	1.0
HNGX 0604ANSN-R:M8340		–	■ 250	0.18	1.8	◪ 150	0.18	1.8	◪ 235	0.18	1.8	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-R:M9325		–	■ 345	0.18	1.8	–	–	–	■ 325	0.18	1.8	–	–	–	–	–	–	◪ 65	0.12	1.0

XNGX 06

	IC (mm)	D1 (mm)	S (mm)
0604	10.500	3.70	4.76



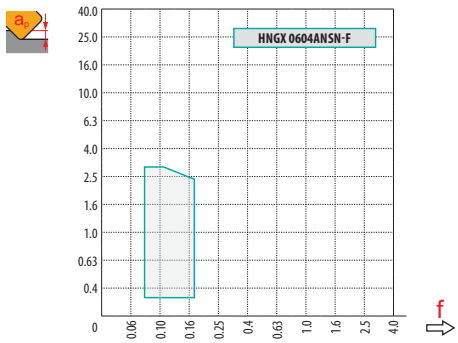
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

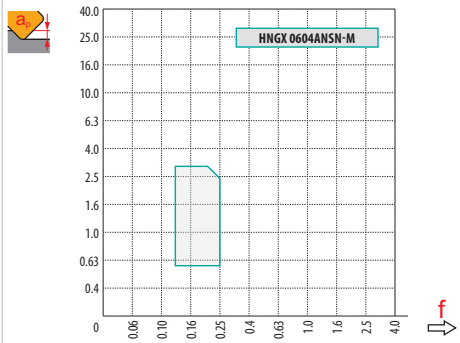
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 W S																			
XNGX 0604ANSN:8215	–	290	0.13	1.8	170	0.12	1.8	275	0.13	1.8	–	–	–	–	–	–	–	–	–

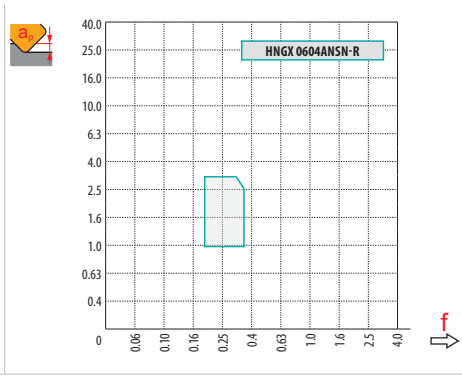
W 修光刃设计，适用于改善表面光洁度。

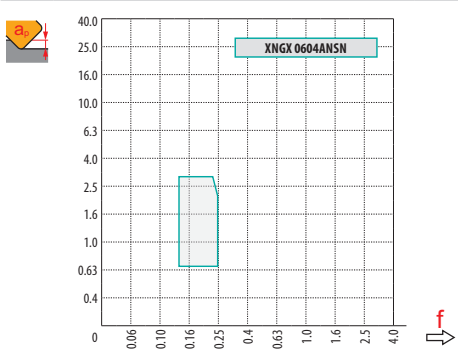
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	HNGX 06-F	HNGX 06-M	HNGX 06-R	XNGX 06
RE	–	–	–	–
BS	1.12	0.80	0.80	4.15









DC	X.V	f_{max} ⇨
25	1.31	0.24
32	1.36	0.28
40	1.40	0.31
50	1.45	0.35
63	1.49	0.39
80	1.54	0.44
100	1.59	0.49
125	1.64	0.55

DC	RPMX	APMX/I
25	2.7°	3.0/65
32	1.9°	3.0/89
40	1.5°	2.5/100
50	1.1°	1.9/100
63	0.9°	1.4/100
80	0.6°	1.0/100
100	0.5°	0.8/100
125	0.4°	0.6/100

a_p
0.9

SHN09C

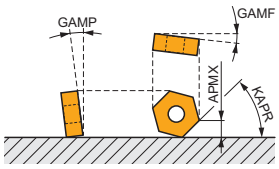
P M K H

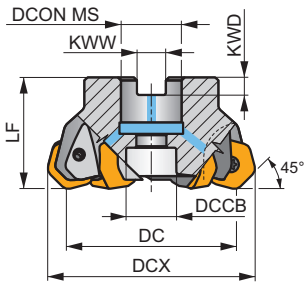
PRAMET

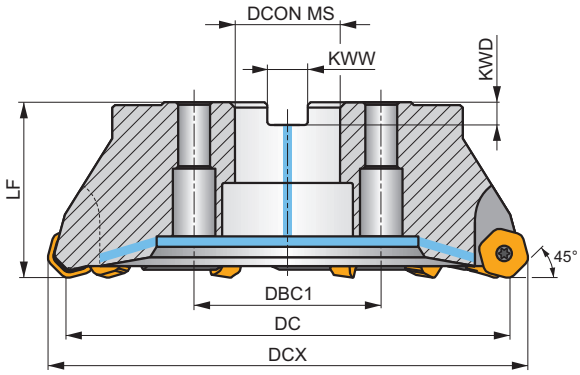
S

ECON HN09 45°面铣，具有双面负前角设计，带内冷
高效富有成效的45度⊠面铣，使用双面HN.. 09类型刀片，具有APMX(最大切深)5mm。粗加工，精加工和倒角加工。经济型刀片，具有12个切削刃。不等齿距，只提供心轴式接口。刀体经过处理，使用寿命更长。

KAPR	45°
APMX	5.0 mm







h_m 0.08 - 0.25

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**50A04R-S45HN09C-CF**	50	61.7	40	22	18	–	10.4	6.3	-7	-7	4	✓	7900	✓	0.38	GI252	FA023	–
	63A06R-S45HN09C-CF	63	74.7	40	22	18	–	10.4	6.3	-7	-7	6	✓	7000	✓	0.54	GI252	FA023	–
	80A06R-S45HN09C-CF	80	91.7	50	27	38	–	12.4	7	-7	-7	6	✓	6200	✓	1.06	GI252	FA021	AC001
	80A08R-S45HN09C-CF	80	91.7	50	27	38	–	12.4	7	-7	-7	8	✓	6200	✓	1.06	GI252	FA021	AC001
	100A06R-S45HN09C-CF	100	111.7	50	32	45	–	14.4	8	-7	-7	6	✓	5600	✓	1.95	GI252	FA021	AC002
	100A08R-S45HN09C-CF	100	111.7	50	32	45	–	14.4	8	-7	-7	8	✓	5600	✓	1.99	GI252	FA021	AC002
	100A10R-S45HN09C-CF	100	111.7	50	32	45	–	14.4	8	-8	-7	10	–	5600	✓	1.99	GI252	FA021	AC002
	125A06R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-7	-7	6	✓	5000	✓	3.36	GI252	FA021	AC003
	125A08R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-7	-7	8	✓	4900	✓	3.66	GI252	FA021	AC003
	125A10R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-7	-7	10	✓	5000	✓	3.52	GI252	FA021	AC003
	125A12R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-8	-7	12	–	5000	✓	3.36	GI252	FA021	AC003
	160C08R-S45HN09C-CF	160	171.7	63	40	–	66.7	16.4	9	-7	-7	8	✓	4400	✓	6.24	GI252	FA026	–
	160C12R-S45HN09C-CF	160	171.7	63	40	–	66.7	16.4	9	-7	-7	12	✓	4400	✓	6.45	GI252	FA026	–
	160C14R-S45HN09C-CF	160	171.7	63	40	–	66.7	16.4	9	-7	-7	14	✓	4400	✓	6.39	GI252	FA026	–
	200C10R-S45HN09C-CF	200	211.7	63	60	–	101.6	25.7	14	-7	-7	10	✓	3900	✓	11.37	GI252	FA027	–
	250C14R-S45HN09C-CF	250	261.7	63	60	–	101.6	25.7	14	-7	-7	14	✓	3500	✓	18.50	GI252	FA028	–
	315C16R-S45HN09C-CF	315	326.7	80	60	–	101.6	25.7	14	-7	-7	16	✓	3100	✓	37.00	GI252	FA029	–

GI252	HNGX 0906AN..	XNGX 0906AN..

		Nm										
FA021	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	–	–	–	–	–	–
FA023	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1030C	–	–	–	–	–

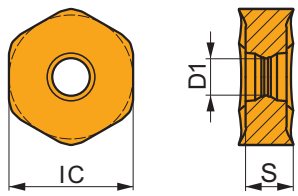
		Nm										
FA026	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1240C	CAC 160C	HSD 0825C	HXK 5	–	–
FA027	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 200C	HSD 1025C	HXK 7	–	–
FA028	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 250C	HSD 1025C	HXK 7	–	–
FA029	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 315C	HSD 1035C	HXK 7	CACP 315OC	RRH 34

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

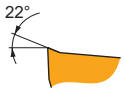
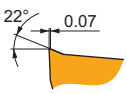
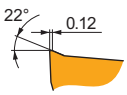
HNGX 09

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0906	16.500	4.90	6.35



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	⇕	✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 FF 型，具有大正前角设计，适用于轻载加工。																						
HNGX 0906ANEN-FF:8215	●	⇕	–		345	0.10	1.0		205	0.09	1.0		–	–	–		–	–	–		–	–	–		–	–	–
HNGX 0906ANEN-FF:M8330	●	⇕	–		335	0.10	1.0		200	0.09	1.0		–	–	–		–	–	–		–	–	–		–	–	–
HNGX 0906ANEN-FF:M9340	●	⇕	–		405	0.10	1.0		240	0.09	1.0		–	–	–		–	–	–		–	–	–		–	–	–
 F 型，具有大正前角设计，适用于轻载到中等加工。																						
HNGX 0906ANSN-F:8215	●	⇕	–		300	0.12	2.1		180	0.11	2.1		–	–	–		–	–	–		–	–	–		–	–	–
HNGX 0906ANSN-F:M6330	●	⇕	–		255	0.12	2.1		180	0.11	2.1		–	–	–		–	–	–		–	–	–		–	–	–
HNGX 0906ANSN-F:M8310	●	⇕	–		330	0.12	2.1		165	0.11	2.1		–	–	–		–	–	–		–	–	–		–	–	–
HNGX 0906ANSN-F:M8330	●	⇕	–		300	0.12	2.1		180	0.11	2.1		–	–	–		–	–	–		–	–	–		–	–	–
HNGX 0906ANSN-F:M8340	●	⇕	–		270	0.12	2.1		160	0.11	2.1		–	–	–		–	–	–		–	–	–		–	–	–
 M 型，具有大正前角设计，适用于中等加工。																						
HNGX 0906ANSN-M:8215	●	⇕	–		255	0.20	2.7		150	0.18	2.7		240	0.20	2.7		–	–	–		–	–	–		–	–	–
HNGX 0906ANSN-M:M5315	●	⇕	–		340	0.20	2.7		–	–	–		320	0.20	2.7		–	–	–		–	–	–		–	–	–

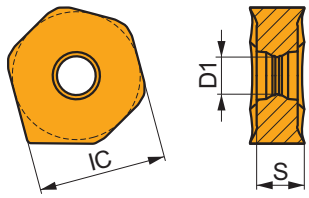
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
M 型，具有大正前角设计，适用于中等加工。																			
HNGX 0906ANSN-M:M6330	–	220	0.20	2.7	155	0.18	2.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M8310	–	280	0.20	2.7	140	0.18	2.7	265	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M8330	–	255	0.20	2.7	150	0.18	2.7	240	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M8340	–	235	0.20	2.7	140	0.18	2.7	220	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M9315	–	340	0.20	2.7	–	–	–	320	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M9325	–	315	0.20	2.7	–	–	–	295	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M9340	–	290	0.20	2.7	170	0.18	2.7	–	–	–	–	–	–	–	–	–	–	–	–
R 型，具有正前角设计，适用于中等加工到重载加工。																			
HNGX 0906ANSN-R:8215	–	240	0.25	3.0	140	0.25	3.0	225	0.25	3.0	–	–	–	–	–	–	45	0.13	1.0
HNGX 0906ANSN-R:M5315	–	305	0.25	3.0	–	–	–	285	0.25	3.0	–	–	–	–	–	–	60	0.13	1.0
HNGX 0906ANSN-R:M8310	–	260	0.25	3.0	130	0.25	3.0	245	0.25	3.0	–	–	–	–	–	–	50	0.13	1.0
HNGX 0906ANSN-R:M8330	–	240	0.25	3.0	140	0.25	3.0	225	0.25	3.0	–	–	–	–	–	–	45	0.13	1.0
HNGX 0906ANSN-R:M8340	–	220	0.25	3.0	130	0.25	3.0	205	0.25	3.0	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-R:M9315	–	310	0.25	3.0	–	–	–	290	0.25	3.0	–	–	–	–	–	–	60	0.13	1.0
HNGX 0906ANSN-R:M9325	–	295	0.25	3.0	–	–	–	280	0.25	3.0	–	–	–	–	–	–	55	0.13	1.0

XNGX 09

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0906	16.500	4.90	6.35

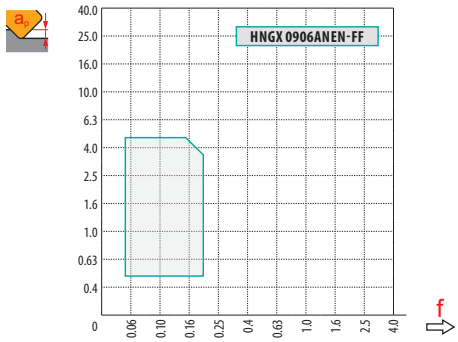


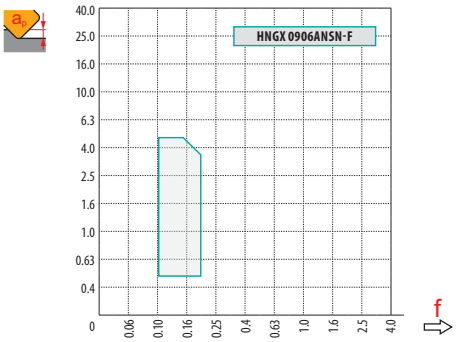
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

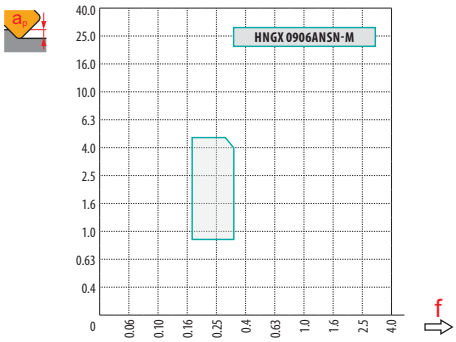
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
W 修光刃设计，适用于改善表面光洁度。																			
XNGX 0906ANSN:8215	–	245	0.20	2.7	145	0.18	2.7	230	0.20	2.7	–	–	–	–	–	–	–	–	–
XNGX 0906ANSN:M8330	–	245	0.20	2.7	145	0.18	2.7	230	0.20	2.7	–	–	–	–	–	–	–	–	–

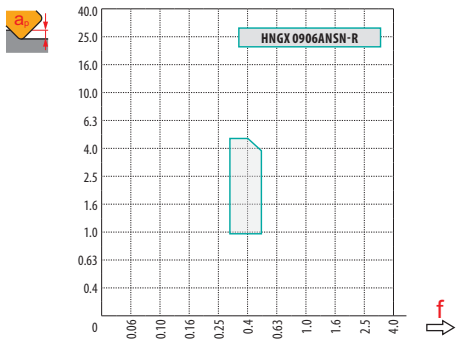
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

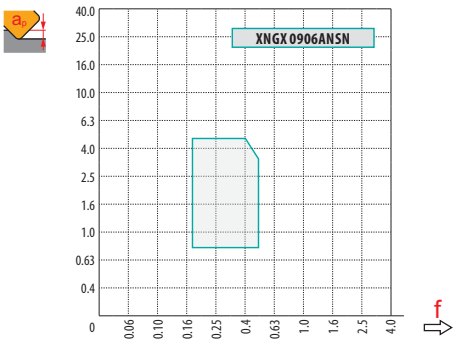
	HNGX 09-FF	HNGX 09-F	HNGX 09-M	HNGX 09-R	XNGX 09
RE	–	–	–	–	–
BS	1.50	1.17	1.17	1.17	7.53











DC	X.V	f_{max} ⇨
50	1.35	0.36
63	1.39	0.40
80	1.44	0.45
100	1.48	0.51
125	1.53	0.57
160	1.58	0.64
200	1.63	0.72
250	1.68	0.80
315	1.74	0.90

DC	RPMX	APMX/l
50	2.1°	3.5/100
63	1.5°	2.5/100
80	1.1°	1.8/100
100	0.9°	1.4/100
125	0.7°	1.1/100
160	0.5°	0.7/100

a_p
1.9

SPN13

P M K S H

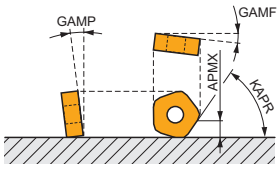
PRAMET

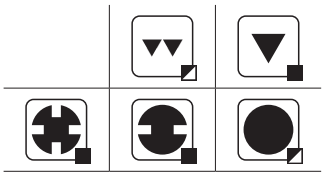
S

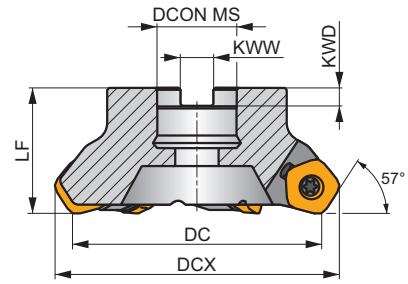
PENTA HD 57°面铣，具有双面负前角设计，适用于重载面铣削
高效富有成效的57⊠度面铣，使用双面PN.. 13和XN.. 13类型刀片，具有APMX(最大切深)10mm。适合面铣。提供心轴式接口。有垫片保护刀片座。刀体经过处理，使用寿命更长。

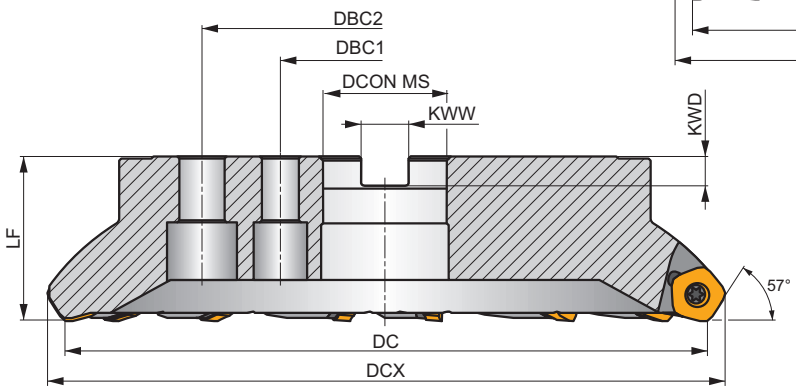
PENTA HD

KAPR	57°
APMX	10.0 mm









h_m 0.20 - 0.50

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DBC1 (mm)	DBC2 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**100A05R-S57PN13**	100	115.8	50	32	–	–	14.4	8	-8.2	-4	5	–	3400	–	1.22	GI261	FA081	AC002
	125A06R-S57PN13	125	140.8	63	40	–	–	16.4	9	-7	-4	6	–	3100	–	2.79	GI261	FA081	AC003
	160C08R-S57PN13	160	175.8	63	40	66.7	–	16.4	9	-6	-4	8	–	2700	–	3.58	GI261	FA081	–
	200C10R-S57PN13	200	215.8	63	60	101.6	–	25.7	14	-5	-4	10	–	2400	–	9.17	GI261	FA081	–
	250C12R-S57PN13	250	265.8	63	60	101.6	–	25.7	14	-5	-4	12	–	2200	–	15.39	GI261	FA081	–
	315C14R-S57PN13	315	330.8	80	60	101.6	177.8	25.7	14	-5	-4	14	–	1900	–	29.17	GI261	FA081	–

GI261	PNMU 1308DN..	XNGX 1308DNSN	PNMQ 1308DN..

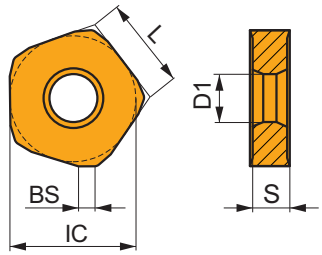
FA081	SPN 13T3DN	US 64010-T15P	SDR T15P	US 68026-T30P	15.0 Nm	M 8	26	SDR T30P-T

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

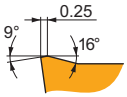
PNMU 13

PRAMET

	BS (mm)	IC (mm)	D1 (mm)	L (mm)	S (mm)
1308	3.00	24.400	10.00	13.00	7.94



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。



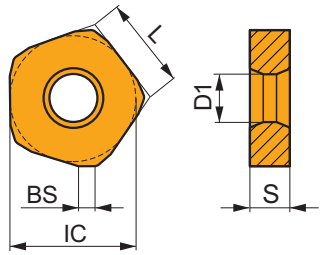
M 型，具有正前角设计，适用于粗加工。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
PNMU 1308DNSR-M:8215		–	165	0.35	6.5	95	0.32	6.5	155	0.35	6.5	–	–	–	40	0.28	5.2	30	0.18	2.0
PNMU 1308DNSR-M:M8330		–	190	0.35	6.5	110	0.32	6.5	180	0.35	6.5	–	–	–	45	0.28	5.2	35	0.18	2.0
PNMU 1308DNSR-M:M8345		–	135	0.35	6.5	80	0.32	6.5	–	–	–	–	–	–	30	0.28	5.2	–	–	–
PNMU 1308DNSR-M:M9315		–	210	0.35	6.5	–	–	–	195	0.35	6.5	–	–	–	–	–	–	40	0.18	2.0
PNMU 1308DNSR-M:M9340		–	170	0.35	6.5	100	0.32	6.5	–	–	–	–	–	–	40	0.28	5.2	–	–	–

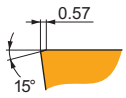
PNMQ 13

PRAMET

	BS (mm)	IC (mm)	D1 (mm)	L (mm)	S (mm)
1308	3.00	24.400	10.00	13.00	7.94



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

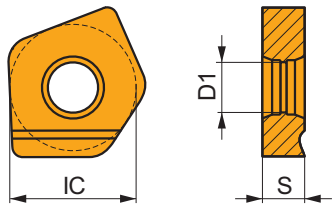


SN 平板设计特别适用于粗加工。

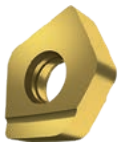
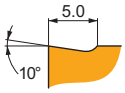
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
PNMQ 1308DNSN:M8330		–	165	0.60	6.5	–	–	–	155	0.60	6.5	–	–	–	–	–	–	30	0.30	2.0
PNMQ 1308DNSN:M8345		–	120	0.60	6.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

XNGX 13

	IC (mm)	D1 (mm)	S (mm)
1308	24.180	10.00	7.94



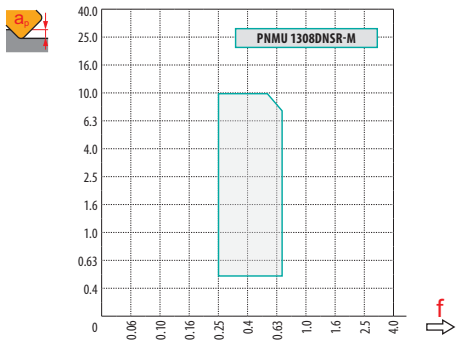
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

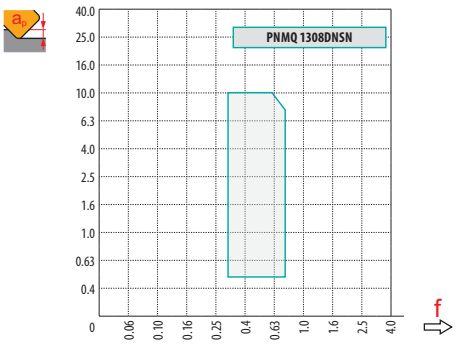
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
XNGX 1308DNSN:M8330		–	245	0.45	2.5	–	–	–	230	0.45	2.5	–	–	–	–	–	–	–	–	–

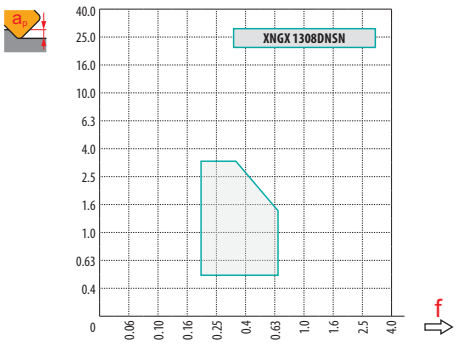
W 修光刃设计，适用于改善表面光洁度。

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	PNMU 13-M	PNMQ 13	XNGX 13
RE	–	–	–
BS	3.00	3.00	12.71







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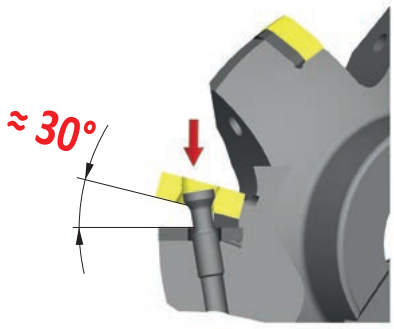
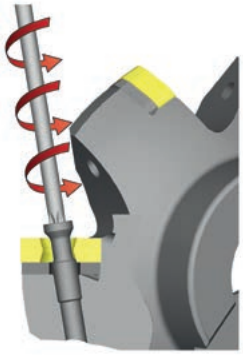


2

3



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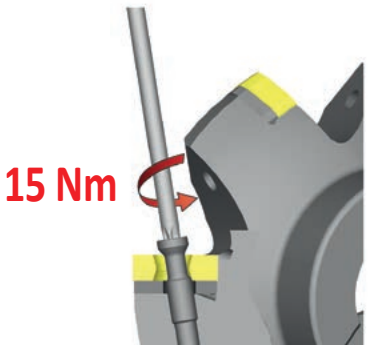


平面铣

	SSD13F	SSE09	SSN12Z	FSB22X		
	45°	45°	45°	60°		
	APMX (mm) 6.4	APMX (mm) 4.5	APMX (mm) 6.5	APMX (mm) 15.0		
	DC (mm) 32 – 250	DC (mm) 20 – 160	DC (mm) 63 – 125	DC (mm) 125 – 250		
圆柱刀柄						
侧固刀柄	DC = 32, 40 (mm)	DC = 20 – 32 (mm)				
模块式刀柄						
套式铣刀	DC = 40 – 250 (mm)	DC = 32 – 160 (mm)				
页码	26	31	35	38		
ISO	P M K N S H	P M K S	P M K S	P M K		
刀片形状						
刀片	SDET 13T3 SDMT 13T3 XDET 13T3	SE.T 09T3	SN.T 1205	SB.. 2207		
切削刃数量	4 / 4 / 1	4	4	4 / 1		
平面铣	■	■	■	■		
倒角铣	■	■	■			
螺旋插补	◪					
连续钻铣	◪					
坡走铣	◪					

■ 推荐使用　◪ 可以使用

SSD13F

P M K N S H

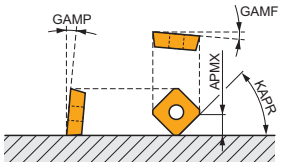
PRAMET

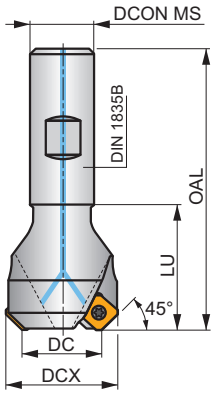
S

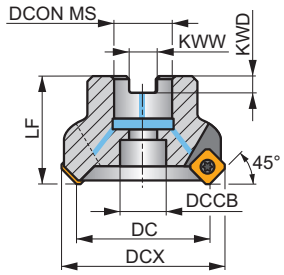
VER SD13 45°面铣刀，具有正前角设计和内冷通道

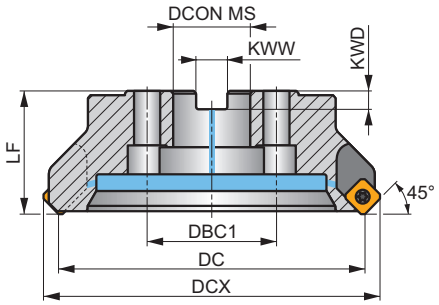
多用途45°面铣刀，采用单面刀片SD..13，最大切深6.4mm。适用范围广泛，可以加工任何一种工件材料。可提供不等齿距的侧固式和芯轴式刀盘。刀体经过处理，使用寿命更长，硬质合金刀垫保证了加工安全性。

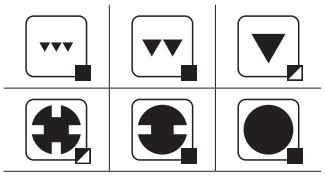
KAPR	45°
APMX	6.4 mm





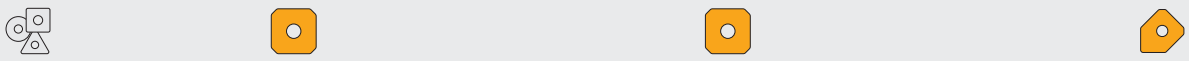






h_m	0.04 - 0.28
h_m	0.04 - 0.32

	Product	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	32N3R045B25-SSD13F-C	32	44.9	120	25	–	–	45	–	–	–	-15	15	3	–	16100	✓	0.43	GI341	C0610	–
DIN 1835B	40N3R045B32-SSD13F-C	40	53.5	120	32	–	–	45	–	–	–	-7	15	3	–	14400	✓	0.72	GI341	C0610	–
	40A03R-S45SD13F-C	40	53.5	–	16	14	–	–	40	8.4	5.6	-7	15	3	–	14400	✓	0.27	GI341	C0611	–
	50A04R-S45SD13F-C	50	63.5	–	22	18	–	–	40	10.4	6.3	-7	15	4	✓	12900	✓	0.51	GI341	C0612	–
	63A05R-S45SD13F-C	63	76.4	–	22	18	–	–	40	10.4	6.3	-7	15	5	✓	11500	✓	0.53	GI341	C0612	–
	80A07R-S45SD13F-C	80	93.4	–	27	22	–	–	50	12.4	7	-7	15	7	✓	10200	✓	1.21	GI341	C0613	AC001
	100A08R-S45SD13F-C	100	112.9	–	32	45	–	–	50	14.4	8	-12	15	8	✓	9100	✓	1.83	GI341	C0613	AC002
	100A10R-S45SD13F-C	100	112.9	–	32	45	–	–	50	14.4	8	-12	15	10	–	9100	✓	1.94	GI341	C0613	AC002
ISO 6462 DIN 8030	125A08R-S45SD13F-C	125	137.8	–	40	56	–	–	63	16.4	9	-12	15	8	✓	8100	✓	3.41	GI341	C0613	AC003
ISO 6462 DIN 8030	125A12R-S45SD13F-C	125	137.8	–	40	56	–	–	63	16.4	9	-12	15	12	–	8100	✓	3.31	GI341	C0613	AC003
	160C10R-S45SD13F-C	160	172.8	–	40	–	66.7	–	63	16.4	9	-12	15	10	✓	7200	✓	6.68	GI341	C0614	–
	160C14R-S45SD13F-C	160	172.8	–	40	–	66.7	–	63	16.4	9	-12	15	14	✓	7200	✓	6.62	GI341	C0614	–
	200C12R-S45SD13F-C	200	212.8	–	60	–	101.6	–	63	25.7	14	-12	15	12	✓	6400	✓	9.06	GI341	C0615	–
	200C16R-S45SD13F-C	200	212.8	–	60	–	101.6	–	63	25.7	14	-12	15	16	✓	6400	✓	11.85	GI341	C0615	–
	250C14R-S45SD13F-C	250	262.8	–	60	–	101.6	–	63	25.7	14	-12	15	14	✓	5700	✓	19.50	GI341	C0616	–
	250C20R-S45SD13F-C	250	262.8	–	60	–	101.6	–	63	25.7	14	-12	15	20	✓	5700	✓	19.20	GI341	C0616	–



GI341	SDET 13T3..	SDMT 13T3..	XDET 13T3..

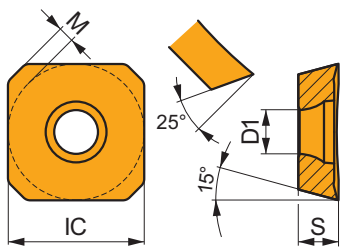
		Nm												
C0610	US 63513-T15P	3.0	M 3.5	13	Flag T15P	–	–	–	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0611	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 0830C	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0612	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HSD 1025C	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0613	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	–	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0614	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1240C	SDW 1103AF	MS 3507	HXK 3.5	CAC 160C	HSD 0825C	HXK 5
C0615	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1655C	SDW 1103AF	MS 3507	HXK 3.5	CAC 200C	HSD 1025C	HXK 7
C0616	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1655C	SDW 1103AF	MS 3507	HXK 3.5	CAC 250C	HSD 1025C	HXK 7

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

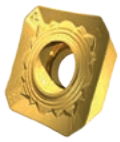
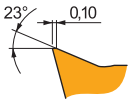
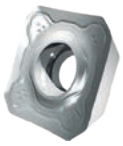
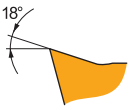
SDET 13

PRAMET

	IC (mm)	D1 (mm)	M (mm)	S (mm)
13T3	13.385	4.40	1.5	3.97



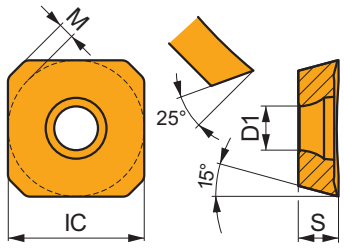
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
F 型非常锋利，用于精加工，适合大悬伸，薄壁及细长工件应用。大正前角设计，窄T-型倒棱和圆角切削刃，用于轻载加工。																				
SDET 13T3AFSN-F:M6330		–	250	0.15	3.0	175	0.14	3.0	–	–	–	–	–	–	70	0.11	2.4	–	–	–
SDET 13T3AFSN-F:M8310		–	315	0.15	3.0	160	0.14	3.0	295	0.15	3.0	–	–	–	–	–	–	–	–	–
SDET 13T3AFSN-F:M8330		–	285	0.15	3.0	170	0.14	3.0	270	0.15	3.0	855	0.18	3.0	70	0.11	2.4	–	–	–
SDET 13T3AFSN-F:M8340		–	265	0.15	3.0	155	0.14	3.0	250	0.15	3.0	–	–	–	65	0.11	2.4	–	–	–
SDET 13T3AFSN-F:M9340		–	330	0.15	3.0	195	0.14	3.0	–	–	–	–	–	–	80	0.11	2.4	–	–	–
 																				
FA 型非常锋利，用于有色金属合金材料的加工，适合大悬伸，薄壁及细长工件应用。大正前角设计，研磨和光亮表面处理。																				
SDET 13T3AFFN-FA:HF7		–	–	–	–	–	–	–	–	–	–	360	0.12	3.0	–	–	–	–	–	–
SDET 13T3AFFN-FA:M0315		–	–	–	–	–	–	–	–	–	–	840	0.12	3.0	–	–	–	–	–	–

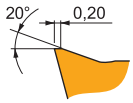
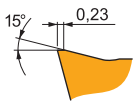
SDMT 13

PRAMET

	IC (mm)	D1 (mm)	M (mm)	S (mm)
13T3	13.385	4.40	1.5	3.97



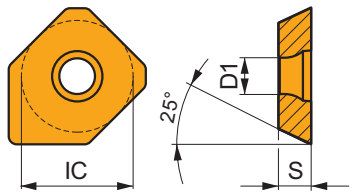
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
M 型用途广泛，适用于多种加工条件的通用选择。正前角设计，中等T-型倒棱和圆角切削刃，用于中等加工。																				
SDMT 13T3AFSN-M:8215		–	245	0.30	3.0	145	0.27	3.0	230	0.30	3.0	–	–	–	60	0.24	2.4	45	0.21	1.0
SDMT 13T3AFSN-M:M6330		–	215	0.30	3.0	150	0.27	3.0	–	–	–	–	–	–	60	0.24	2.4	–	–	–
SDMT 13T3AFSN-M:M8330		–	245	0.30	3.0	145	0.27	3.0	230	0.30	3.0	–	–	–	60	0.24	2.4	45	0.21	1.0
SDMT 13T3AFSN-M:M8340		–	225	0.30	3.0	135	0.27	3.0	210	0.30	3.0	–	–	–	55	0.24	2.4	–	–	–
SDMT 13T3AFSN-M:M9325		–	295	0.30	3.0	–	–	–	280	0.30	3.0	–	–	–	–	–	–	55	0.21	1.0
SDMT 13T3AFSN-M:M9340		–	265	0.30	3.0	155	0.27	3.0	–	–	–	–	–	–	65	0.24	2.4	–	–	–
																				
R 型强壮坚固，用于粗加工和重载加工。小前角设计，宽T-型倒棱和圆角切削刃，用于粗加工。																				
SDMT 13T3AFSN-R:M5315		–	285	0.35	3.0	–	–	–	270	0.35	3.0	–	–	–	–	–	–	55	0.25	1.0
SDMT 13T3AFSN-R:M8310		–	255	0.35	3.0	130	0.32	3.0	240	0.35	3.0	–	–	–	–	–	–	50	0.25	1.0
SDMT 13T3AFSN-R:M8330		–	240	0.35	3.0	140	0.32	3.0	225	0.35	3.0	–	–	–	–	–	–	45	0.25	1.0
SDMT 13T3AFSN-R:M8340		–	220	0.35	3.0	130	0.32	3.0	205	0.35	3.0	–	–	–	–	–	–	–	–	–
SDMT 13T3AFSN-R:M9325		–	280	0.35	3.0	–	–	–	265	0.35	3.0	–	–	–	–	–	–	55	0.25	1.0

XDET 13

PRAMET

	IC (mm)	D1 (mm)	S (mm)
13T3	13.385	4.40	3.97



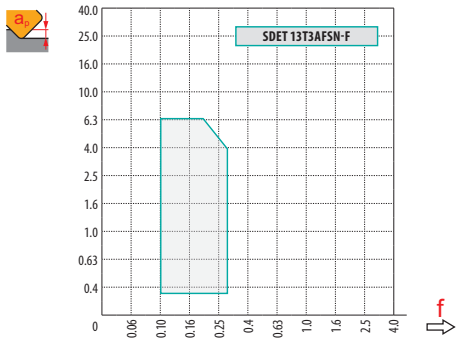
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

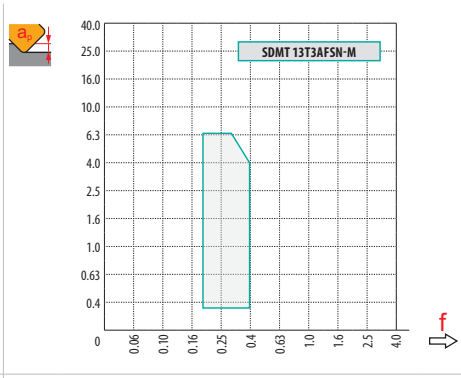
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
XDET 13T3AFER:8215		–	420	0.10	0.2	250	0.09	0.2	395	0.10	0.2	–	–	–	–	–	–	–	–	–
XDET 13T3AFER:M8330		–	395	0.10	0.2	235	0.09	0.2	375	0.10	0.2	–	–	–	–	–	–	–	–	–

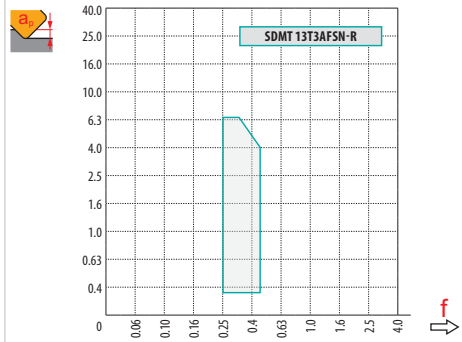
W 修光刃设计，在大尺寸刀盘和大进给量应用场景下用于改善表面光洁度。

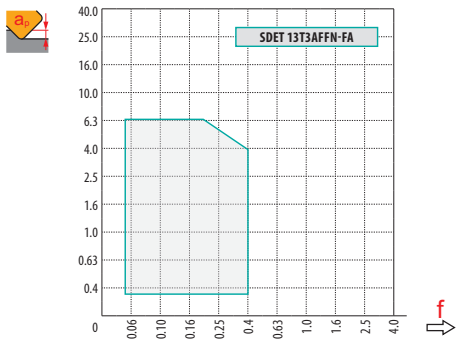
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

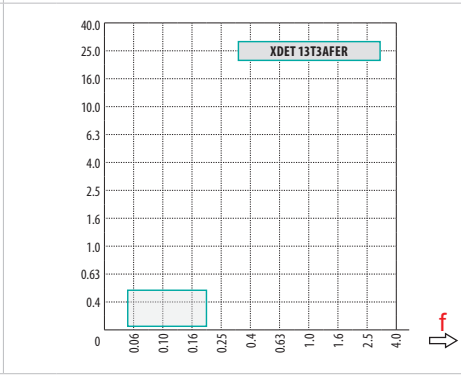
	SDET 13-F	SDMT 13-M	SDMT 13-R	SDET 13-FA	XDET 13
RE	–	–	–	–	–
BS	1.75	1.75	1.75	1.75	8.19











DC	X.V	f_{max}
32	1.22	0.15
40	1.26	0.16
50	1.30	0.18
63	1.34	0.20
80	1.39	0.22
100	1.43	0.24
125	1.48	0.26
160	1.53	0.29
200	1.58	0.33
250	1.63	0.36

DC	RPMX	APMX/I
32	14.1°	6.4/27
40	11.8°	6.4/32
50	9.8°	6.4/39
63	7.7°	6.4/49
80	5.2°	6.4/72
100	4.1°	6.4/91
125	3.2°	5.45/100
160	1.0°	1.6/100
200	0.4°	0.55/100
250	0.3°	0.4/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	60.0	89.8	1.7	1.7
40	75.0	107.0	1.7	1.7
50	94.0	127.0	1.7	1.7
63	120.0	152.8	1.7	1.7
80	155.0	186.8	1.7	1.7
100	193.0	225.8	1.7	1.7
125	245.0	275.6	1.7	1.7
160	322.0	345.6	1.7	1.7
200	405.0	425.6	1.7	1.7
250	505.0	525.6	1.7	1.7

a_p
1.5

SSE09

P M K S

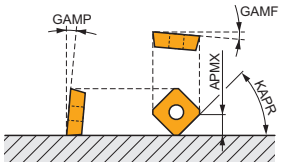
PRAMET

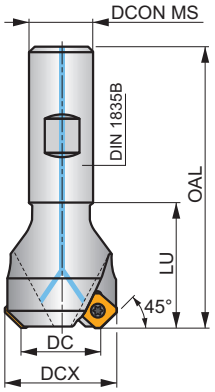
S

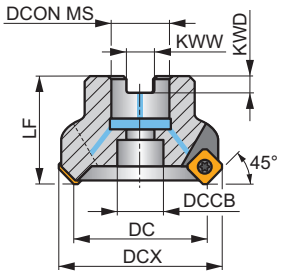
45°面铣，具有正前角设计，带内冷设计

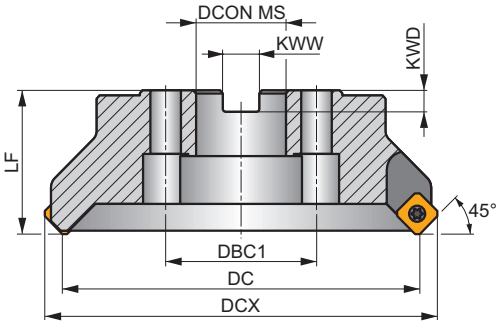
高效富有成效的45⊠度面铣，使用单面SE.. 09类型刀片，具有APMX(最大切深)4.5mm。适合面铣和倒角加工。侧固柄和心轴式接口可用，具有不等齿距，刀体经过处理，使用寿命更长。

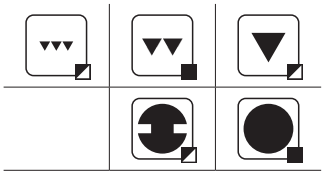
KAPR	45°
APMX	4.5 mm











h_m	0.06 - 0.18
h_m	0.06 - 0.2

	Product	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	20N2R032B20-SSE09-C	20	29.8	82	20	–	–	32	–	–	–	-5	20	2	–	24600	✓	0.26	GI147	FA010	–
DIN 1835B	25N3R042B25-SSE09-C	25	34.8	98	25	–	–	42	–	–	–	-5	20	3	–	22000	✓	0.44	GI147	FA010	–
DIN 1835B	32N4R042B32-SSE09-C	32	42	102	32	–	–	42	–	–	–	-5	20	4	–	19400	✓	0.68	GI147	FA010	–
	32A04R-S45SE09F-C	32	42	–	16	14	–	–	40	8.4	6.4	-5	20	4	✓	19400	✓	0.24	GI147	FA012	–
	40A04R-S45SE09F-C	40	53.2	–	16	14	–	–	40	8.4	6.4	-5	20	4	✓	17400	✓	0.30	GI147	FA012	–
	50A05R-S45SE09F-C	50	59.6	–	22	18	–	–	40	10.4	6.4	-5	20	5	✓	15600	✓	0.55	GI147	FA013	–
	63A05R-S45SE09F-C	63	75.8	–	22	18	–	–	40	10.4	6.4	-5	20	5	✓	13900	✓	0.66	GI147	FA013	–
	63A06R-S45SE09F-C	63	75.8	–	22	18	–	–	40	10.4	6.4	-5	20	6	✓	13900	✓	0.58	GI147	FA013	–
ISO 6462 DIN 8030	80A06R-S45SE09F-C	80	89.6	–	27	38	–	–	50	12.4	7	-5	20	6	✓	12300	✓	1.14	GI147	FA011	AC001
ISO 6462 DIN 8030	80A08R-S45SE09F-C	80	89.6	–	27	38	–	–	50	12.4	7	-5	20	8	✓	12300	✓	1.13	GI147	FA011	AC001
	100A08R-S45SE09F-C	100	110	–	32	45	–	–	50	14.4	8	-5	20	8	✓	11000	✓	1.83	GI147	FA011	AC002
	100A10R-S45SE09F-C	100	110	–	32	45	–	–	50	14.4	8	-5	20	10	✓	10900	✓	1.82	GI147	FA011	AC002
	125A09R-S45SE09F-C	125	134.5	–	40	60	–	–	63	16.4	9	-5	20	9	✓	9800	✓	3.87	GI147	FA011	AC003
	125A12R-S45SE09F-C	125	134.5	–	40	60	–	–	63	16.4	9	-5	20	12	✓	9800	✓	3.87	GI147	FA011	AC003
	160C10R-S45SE09F	160	169.6	–	40	–	66.7	–	63	16.4	9	-5	20	10	✓	8700	–	6.21	GI147	FA014	–

GI147	SEET 09T3AF..	SEMT 09T3AF..

		Nm						
FA010	US 3007-T09P	2.0	M 3	7.3	–	–	Flag T09P	–
FA011	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	–
FA012	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 0830C
FA013	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1030C

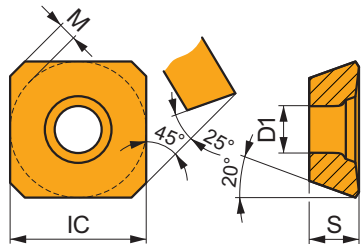
FA014	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1240C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

SEMT 09

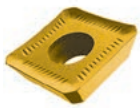
PRAMET

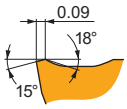
	IC (mm)	D1 (mm)	M (mm)	S (mm)
09T3	9.525	3.50	1.2	3.97



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
SEMT 09T3AFSN:8215	–	295	0.18	1.8	175	0.16	1.8	280	0.18	1.8	–	–	–	–	–	–	–	–	–
SEMT 09T3AFSN:M8330	–	290	0.18	1.8	170	0.16	1.8	275	0.18	1.8	–	–	–	–	–	–	–	–	–
SEMT 09T3AFSN:M8340	–	265	0.18	1.8	155	0.16	1.8	250	0.18	1.8	–	–	–	–	–	–	–	–	–
SEMT 09T3AFSN:M9325	–	365	0.18	1.8	–	–	–	345	0.18	1.8	–	–	–	–	–	–	–	–	–

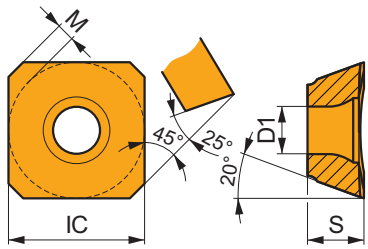




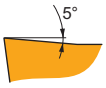
AFSN 正前角设计，适用于轻载到中等加工。

SEET 09

	IC (mm)	D1 (mm)	M (mm)	S (mm)
09T3	9.525	3.50	1.2	3.97

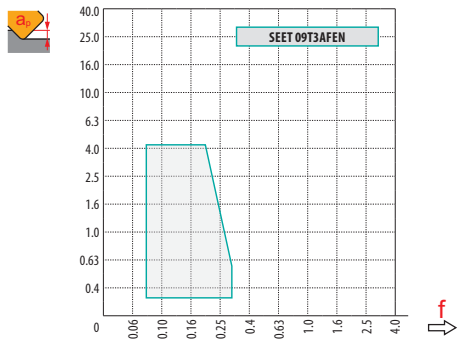


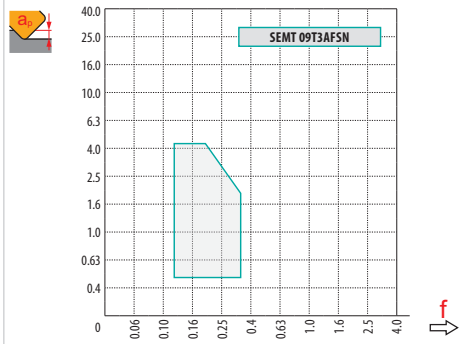
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
AFEN 正前角设计，适用于轻载到中等加工。																				
SEET 09T3AFEN:M6330		–	255	0.14	2.5	180	0.13	2.5	–	–	–	–	–	–	75	0.10	2.0	–	–	–
SEET 09T3AFEN:M8330		–	295	0.14	2.5	175	0.13	2.5	–	–	–	–	–	–	70	0.10	2.0	–	–	–
SEET 09T3AFEN:M8340		–	270	0.14	2.5	160	0.13	2.5	–	–	–	–	–	–	65	0.10	2.0	–	–	–
SEET 09T3AFEN:M9340		–	345	0.14	2.5	205	0.13	2.5	–	–	–	–	–	–	85	0.10	2.0	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SEET 09	SEMT 09
RE	–	–
BS	1.28	1.25





DC	X.V	f_{max} ⇨
20	1.20	0.18
25	1.24	0.20
32	1.29	0.23
40	1.33	0.25
50	1.37	0.28
63	1.41	0.32
80	1.46	0.36
100	1.50	0.40
125	1.55	0.45
160	1.60	0.51

SSN12Z

P M K S

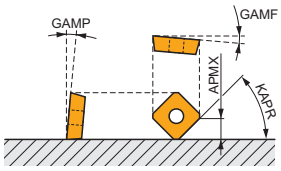
PRAMET

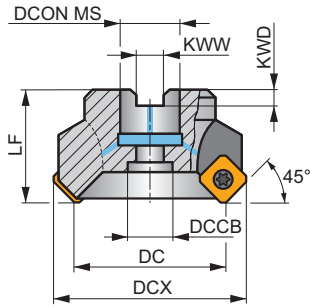
S

45°面铣，具有正前角设计，带内冷

高效富有成效的45°度面铣，使用单面SN.. 12类型刀片，具有APMX(最大切深)6.5mm。适合面铣和倒角加工。只提供心轴式类型。刀体经过处理，使用寿命更长。

KAPR	45°
APMX	6.5 mm





h_m 0.12 - 0.35

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**63A05R-S45SN12Z-C**	63	78	40	22	18	–	10.4	6.3	-5.5	7.5	5	–	8600	✓	0.62	GI156	FA071	–
	80A06R-S45SN12Z-C	80	95	50	27	38	–	12.4	7	-5.5	7.5	6	–	7700	✓	1.36	GI156	FA071	AC001
	100A07R-S45SN12Z-C	100	115	50	32	45	–	14.4	8	-5.5	7.5	7	–	6900	✓	1.70	GI156	FA071	AC002
	125A08R-S45SN12Z-C	125	140	63	40	56	–	16.4	9	-5.5	7.5	8	–	6100	✓	3.42	GI156	FA071	AC003

GI156	SNKT 1205AZ..	SNMT 1205AZ..

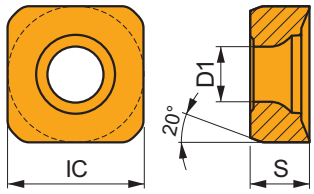
FA071	US 4511-T20	5.0 Nm	M 4.5	11	SDR T20-T

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

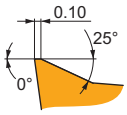
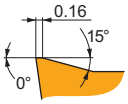
SNMT 12

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.20	5.56



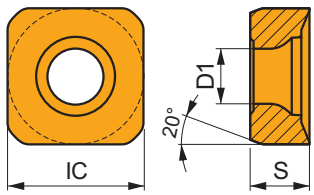
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
M 型，具有大正前角设计，适用于中等加工。																				
SNMT 1205AZSR-M:8215		–	300	0.25	3.2	180	0.23	3.2	285	0.25	3.2	–	–	–	75	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M8330		–	300	0.25	3.2	180	0.23	3.2	285	0.25	3.2	–	–	–	75	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M8340		–	275	0.25	3.2	165	0.23	3.2	260	0.25	3.2	–	–	–	65	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M9325		–	365	0.25	3.2	–	–	–	345	0.25	3.2	–	–	–	–	–	–	–	–	–
																				
R 型，具有正前角设计，适用于中等加工到重载加工。																				
SNMT 1205AZSR-R:8215		–	290	0.27	3.5	170	0.24	3.5	275	0.27	3.5	–	–	–	70	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M5315		–	365	0.27	3.5	–	–	–	345	0.27	3.5	–	–	–	–	–	–	–	–	–
SNMT 1205AZSR-R:M8330		–	290	0.27	3.5	170	0.24	3.5	275	0.27	3.5	–	–	–	70	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M8340		–	270	0.27	3.5	160	0.24	3.5	255	0.27	3.5	–	–	–	65	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M9325		–	355	0.27	3.5	–	–	–	335	0.27	3.5	–	–	–	–	–	–	–	–	–

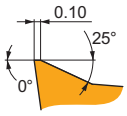
SNKT 12

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.20	5.56

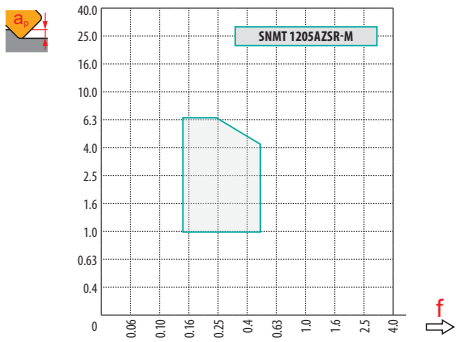


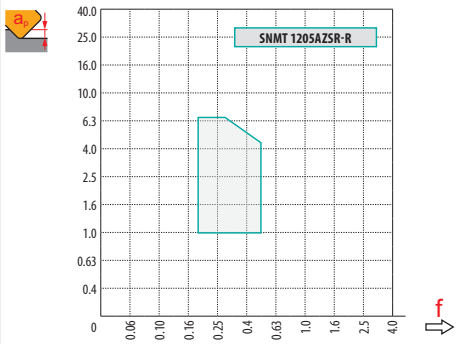
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

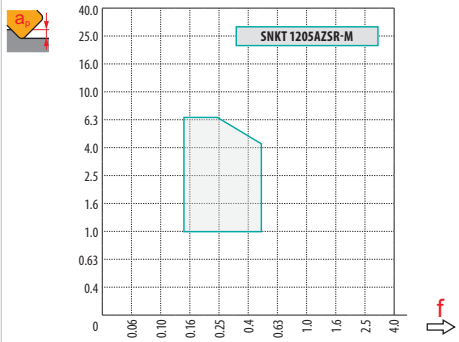
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
M 型，具有大正前角设计，适用于中等加工。																				
SNKT 1205AZSR-M:M8330		–	305	0.24	3.2	180	0.22	3.2	285	0.24	3.2	–	–	–	75	0.17	2.6	–	–	–
SNKT 1205AZSR-M:M8340		–	275	0.24	3.2	165	0.22	3.2	260	0.24	3.2	–	–	–	65	0.17	2.6	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SNMT 12-M	SNMT 12-R	SNKT 12-M
RE	–	–	–
BS	0.95	1.03	1.59







DC	X.V	f_{max} ⇨
63	1.34	0.53
80	1.39	0.60
100	1.43	0.67
125	1.47	0.74

FSB22X

P M K

PRAMET

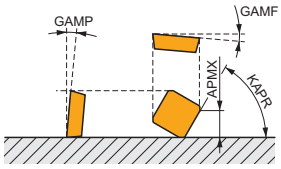
F

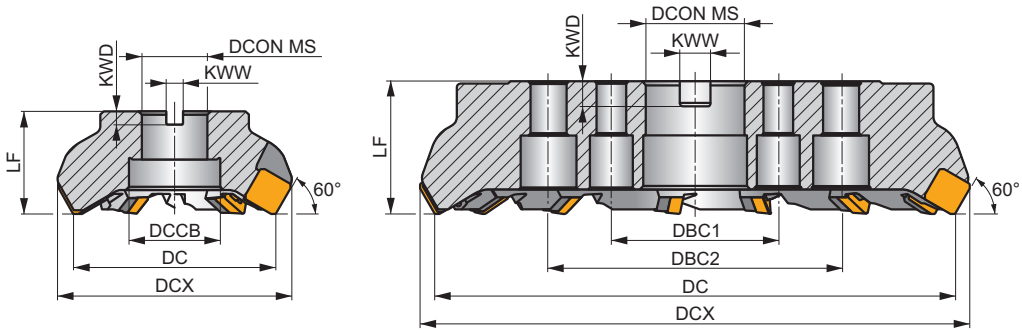
粗加工SB 60°面铣，具有正前角设计，适用于重载面铣削

高效富有成效的60度⊠面铣，使用单面SB..22类型刀片，具有APMX(最大切深)15mm。优化的重载面铣，可提供平顺的切削操作。不等齿距，只提供心轴式接口。刀体经过处理，使用寿命更长。

ROUGH SB

KAPR	60°
APMX	15.0 mm





h_m 0.15 - 0.5

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	DBC2 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**125B07R-F60SB22X**	125	144.4	63	40	56	–	–	16.4	9	-9	9	7	✓	–	–	3.73	GI144	FA111	AC003
	160C08R-F60SB22X	160	178.7	63	40	–	66.7	–	16.4	9	-9	9	8	✓	–	–	6.46	GI144	FA114	–
	200C08R-F60SB22X	200	217.9	63	60	–	101.6	–	25.7	14	-9	9	8	✓	–	–	10.59	GI144	FA115	–
	250C09R-F60SB22X	250	267.4	63	60	–	101.6	–	25.7	14	-9	9	9	✓	–	–	17.54	GI144	FA115	–

GI144	SBKX 2207DZ..	SBMR 2207DZ..

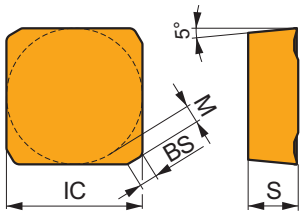
FA111	LNX 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	–
FA114	LNX 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	HS 1240
FA115	LNX 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	HS 1655

AC003	KS 2040	K.FMH40

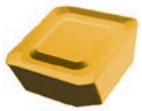
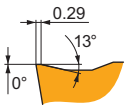
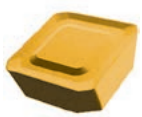
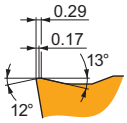
SBMR 22

PRAMET

	IC (mm)	M (mm)	S (mm)	BS (mm)
2207	22.000	2.8	8.00	1.99



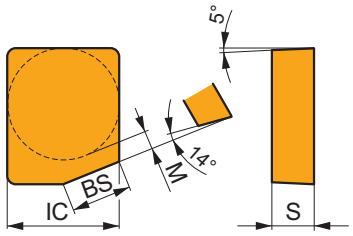
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
DZSR 稳定的设计，适用于重载加工。																				
SBMR 2207DZSR:M8326		–	140	0.38	8.5	–	–	–	130	0.38	8.5	–	–	–	–	–	–	–	–	–
SBMR 2207DZSR:M8346		–	120	0.38	8.5	70	0.38	8.5	–	–	–	–	–	–	–	–	–	–	–	–
 																				
R 型，具有稳定设计，适用于重载加工。																				
SBMR 2207DZSR-R:M5326		–	160	0.44	9.8	–	–	–	150	0.44	9.8	–	–	–	–	–	–	–	–	–
SBMR 2207DZSR-R:M8326		–	135	0.44	9.8	–	–	–	125	0.44	9.8	–	–	–	–	–	–	–	–	–
SBMR 2207DZSR-R:M8346		–	115	0.44	9.8	65	0.40	9.8	–	–	–	–	–	–	–	–	–	–	–	–

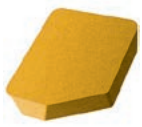
SBKX 22

PRAMET

	IC (mm)	M (mm)	S (mm)	BS (mm)
2207	22.000	3.2	8.00	11.84

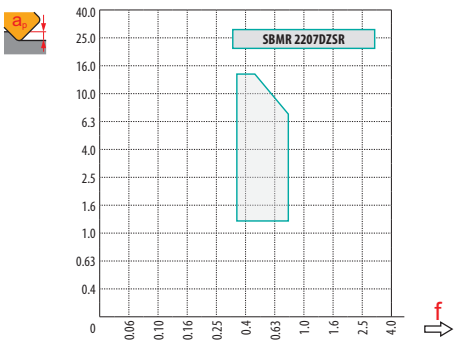


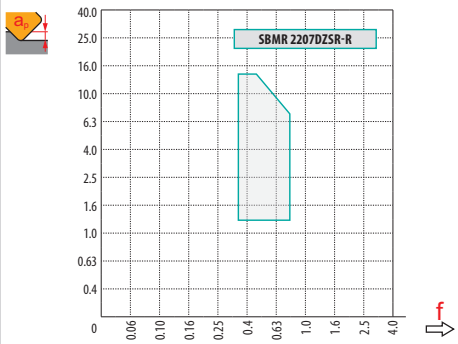
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

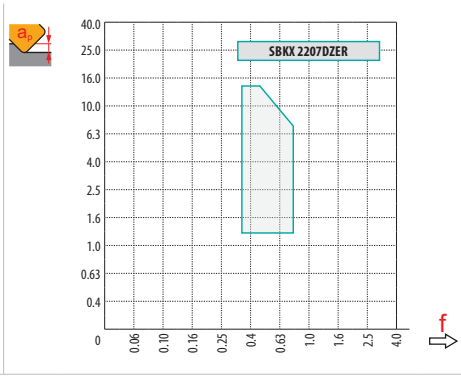
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
DZER 平板修光刃设计，适用于改善表面光洁度。																				
SBKX 2207DZER:M8326		–	100	0.60	8.5	–	–	–	95	0.60	8.5	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SBMR 22	SBMR 22-R	SBKX 22
RE	–	–	–
BS	1.99	1.99	11.84







平面铣

	SOD05	SOD06D	SOE06Z			
	45°	45°	43°			
	APMX (mm) 2.7 (10.0)	APMX (mm) 3.1 (8.6)	APMX (mm) 3.3 (9.9)			
	DCX (mm) 32 – 125	DC (mm) 63 – 160	DC (mm) 50 – 200			
圆柱刀柄	DC = 32, 40 (mm)					
侧固刀柄						
模块式刀柄						
套式铣刀	DC = 40 – 125 (mm)					
页码	42	51	55			
ISO	P M K N	P M K S H	P M N S			
刀片形状						
刀片	OD.. 0505 RD.. 1205 SD.. 1205	OD.. 0605 RPE. 1505	OEHT 0604 REHT 1604 XEHT 0604			
切削刃数量	8 / 8 / 4	8 / 8	8 / 8 / 1			
平面铣	■	■	■			
倒角铣	■	■	■			
螺旋插补	■		◪			
连续钻铣	■		◪			
坡走铣	■		◪			
形面铣（仿形铣）	■		◪			
浅方肩铣	■					
浅槽铣	■					
插铣	■					

■ 推荐使用　◪ 可以使用

SOD05

P M K N

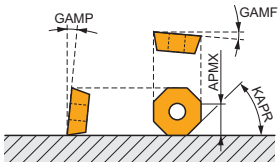
PRAMET

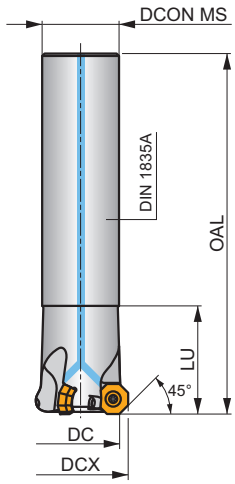
S

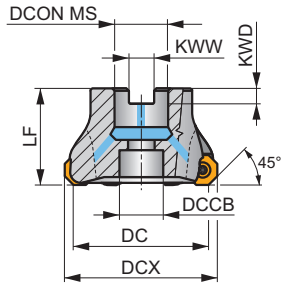
通用面铣，具有正前角设计，带内冷

Highly productive universal face mill utilising single-sided positive inserts with APMX up to 2.7 (10) mm. Unique insert seat fits OD.. 05, RD.. 12 and SD.. 12 style inserts, suited for wide range of applications. Differential tooth pitch. Arbor and cylindrical style. Body treated for longer tool life.

KAPR	45°
APMX	2.7 (10.0) mm







h_m	0.03 - 0.15
h_m	0.03 - 0.12

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	KAPR (°)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	32N3R045A25-SOD05-C	32	24.7	130	25	–	45	–	45	–	–	-10	8	3	–	17700	✓	0.41	GI326	FA049	–
	40N3R045A32-SOD05-C	40	32.6	150	32	–	45	–	45	–	–	-7	8	3	–	15800	✓	0.86	GI326	FA040	–
	40A03R-S450D05-C	40	32.7	–	16	14	–	40	45	8.4	5.6	-10	8	3	–	15800	✓	0.18	GI326	FA042	–
	50A04R-S450D05-C	50	42.6	–	22	18	–	40	45	10.4	6.3	-7	8	4	–	14100	✓	0.28	GI326	FA043	–
	50A05R-S450D05-C	50	42.6	–	22	18	–	40	45	10.4	6.3	-7	8	5	–	14100	✓	0.28	GI326	FA043	–
ISO 6462 DIN 8030	63A05R-S450D05-C	63	55.6	–	22	18	–	40	45	10.4	6.3	-7	8	5	✓	12600	✓	0.39	GI326	FA043	–
	63A06R-S450D05-C	63	55.6	–	22	18	–	40	45	10.4	6.3	-7	8	6	✓	12600	✓	0.50	GI326	FA043	–
	80A06R-S450D05-C	80	72.6	–	27	38	–	50	45	12.4	7	-7	8	6	✓	11100	✓	0.73	GI326	FA041	AC001
	80A08R-S450D05-C	80	72.6	–	27	38	–	50	45	12.4	7	-7	8	8	✓	11100	✓	0.66	GI326	FA041	AC001
	100A07R-S450D05-C	100	92.6	–	32	45	–	50	45	14.4	8	-7	8	7	✓	10000	✓	1.09	GI326	FA041	AC002
	125A08R-S450D05-C	125	117.6	–	40	56	–	63	45	16.4	9	-7	8	8	✓	8900	✓	2.20	GI326	FA041	AC003

GI326	OD.. 0505..	RD.. 1205..	SDKT 1205..	SDMT 1205..SN

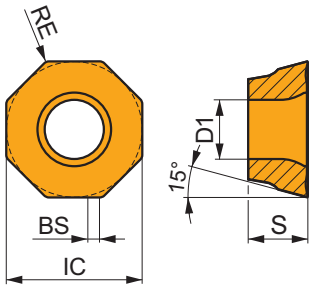
		Nm					
FA040	US 45014-T20P	5.0	M 5	13	Flag T20P	–	–
FA041	US 45014-T20P	5.0	M 5	13	–	SDR T20P-T	–
FA042	US 45014-T20P	5.0	M 5	13	–	SDR T20P-T	HS 90835
FA043	US 45014-T20P	5.0	M 5	13	–	SDR T20P-T	HS 1030C
FA049	US 45011-T20P	5.0	M 5	11	Flag T20P	–	–

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

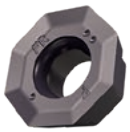
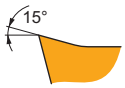
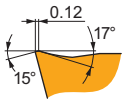
ODKT 05IM

PRAMET

	IC (mm)	D1 (mm)	S (mm)	BS (mm)
0505	12.700	5.50	5.56	1.00



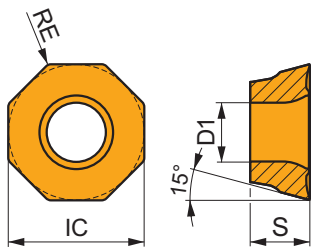
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 	**F 型，45°面铣削刀片，具有大正前角设计，适用于轻载加工。**																			
ODKT 0505ADFR-F:M8310	●	0.8	275	0.15	2.5	140	0.14	2.5	–	–	–	–	–	–	–	–	–	–	–	–
	**FM 型，45°面铣削刀片，具有前角设计，适用于轻载到中等加工。**																			
ODKT 0505ADSR-FM:M6330	⬌	0.8	190	0.25	2.5	135	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M8310	⬌	0.8	240	0.25	2.5	120	0.23	2.5	225	0.25	2.5	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M8330	⬌	0.8	225	0.25	2.5	135	0.23	2.5	210	0.25	2.5	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M8345	⬌	0.8	160	0.25	2.5	95	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M9340	⬌	0.8	245	0.25	2.5	145	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–

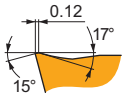
ODMT 05IM

PRAMET

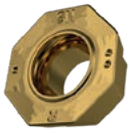
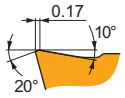
	IC (mm)	D1 (mm)	S (mm)
0505	12.700	5.50	5.56



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	⚙	✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																						
ODMT 0505ADSR-FM:M8340		⚙		0.8	200	0.25	2.5	120	0.23	2.5	190	0.25	2.5	–	–	–	–	–	–	–	–	–
ODMT 0505ADSR-FM:M9340		⚙		0.8	245	0.25	2.5	145	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–

FM 型，45°面铣削刀片，具有前角设计，适用于轻载到中等加工。

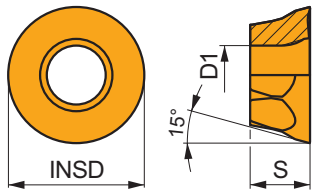
Product	●	⚙	✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																						
ODMT 050508SN-R:M8330			✱	0.8	190	0.25	2.5	–	–	–	180	0.25	2.5	–	–	–	–	–	–	–	–	–
ODMT 050508SN-R:M9340			✱	0.8	210	0.25	2.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

R 型，45°面铣削刀片，具有正前角设计，适用于不稳定的工况。

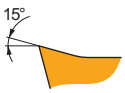
RDGT 12IM

PRAMET

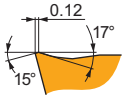
	INSD (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	⚙	✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																						
RDGT 120500FN-F:M8310	●			–	210	0.20	1.5	105	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

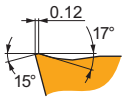
F 型，具有大正前角设计，适用于轻载加工。

Product	●	⚙	✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																						
RDGT 120500SN-FM:M8330	●			–	190	0.20	1.5	110	0.18	1.5	180	0.20	1.5	–	–	–	–	–	–	–	–	–

FM 型，具有前角设计，适用于轻载到中等加工。

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RDGT 120500SN-FM:M8345	●	–	140	0.20	1.5	80	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

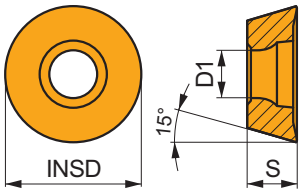


FM 型，具有前角设计，适用于轻载到中等加工。

RDMT 12IM

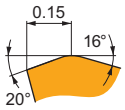
PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RDMT 120500SN-R:M8330	✱	–	175	0.30	1.5	–	–	–	165	0.30	1.5	–	–	–	–	–	–	–	–	–
RDMT 120500SN-R:M8340	✱	–	160	0.30	1.5	–	–	–	150	0.30	1.5	–	–	–	–	–	–	–	–	–

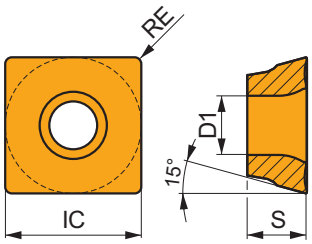


R 型，仿形和轮廓铣削刀片，具有正前角设计，适用于不稳定的工况。

SDKT 12IM

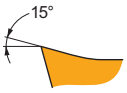
PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



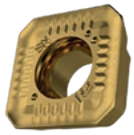
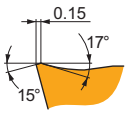
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
SDKT 1205PDFR-F:8215	●	0.8	285	0.10	4.0	170	0.09	4.0	–	–	–	855	0.12	4.0	–	–	–	–	–	–



F 型，90°方肩铣削刀片，具有大正前角设计，适用于轻载加工。

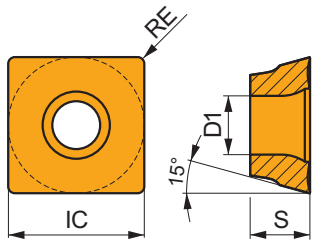
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
FM 型，90°方肩铣削刀片，具有前角设计，适用于轻载到中等加工。																				
SDKT 1205AESN-FM:M8330		–	280	0.15	4.0	165	0.15	4.0	265	0.15	4.0	–	–	–	–	–	–	–	–	–
SDKT 1205AESN-FM:M8345		–	205	0.15	4.0	120	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–
SDKT 1205PDSR-FM:M8330		0.8	255	0.15	4.0	150	0.15	4.0	240	0.15	4.0	–	–	–	–	–	–	–	–	–
SDKT 1205PDSR-FM:M8345		0.8	185	0.15	4.0	110	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–

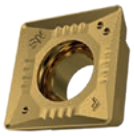
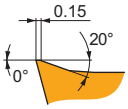
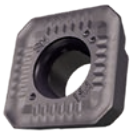
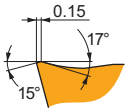
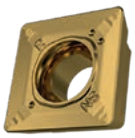
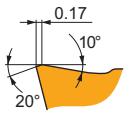
SDMT 12IM

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

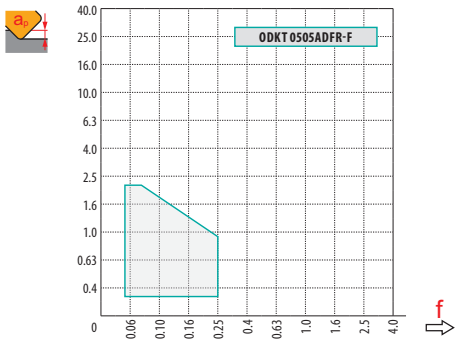
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
F 型，90°方肩铣削刀片，具有前角设计，适用于轻载到中等加工。																				
SDMT 120508SN-F:M8310		0.8	265	0.15	4.0	135	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–
SDMT 120508SN-F:M8330		0.8	245	0.15	4.0	145	0.15	4.0	–	–	–	735	0.18	4.0	–	–	–	–	–	–
 																				
FM 型，90°方肩铣削刀片，具有正前角设计，适用于中等加工。																				
SDMT 120508SN-FM:M8345		0.8	175	0.15	4.0	105	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–
 																				
R 型，90°方肩铣削刀片，具有正前角设计，适用于不稳定的工况。																				
SDMT 120508SN-R:M8330		0.8	225	0.20	4.0	–	–	–	210	0.20	4.0	–	–	–	–	–	–	–	–	–
SDMT 120508SN-R:M8345		0.8	165	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SDMT 1205AESN-R:M8330		–	265	0.20	4.0	–	–	–	250	0.20	4.0	–	–	–	–	–	–	–	–	–
SDMT 1205AESN-R:M8340		–	240	0.20	4.0	–	–	–	225	0.20	4.0	–	–	–	–	–	–	–	–	–

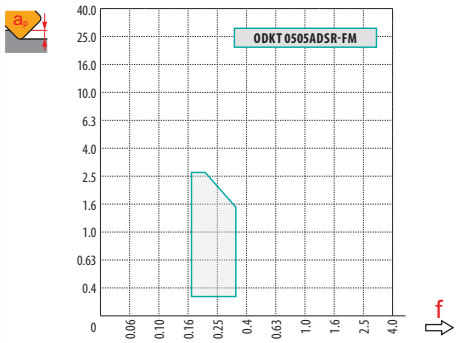
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

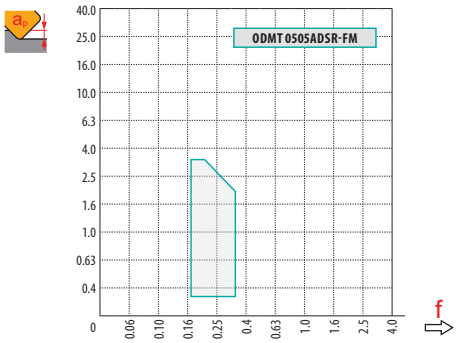
	ODKT 05-F	ODKT 05-FM	ODMT 05-FM	ODMT 05-R
RE	0.4	0.8	0.8	0.8
BS	1.00	1.00	–	–

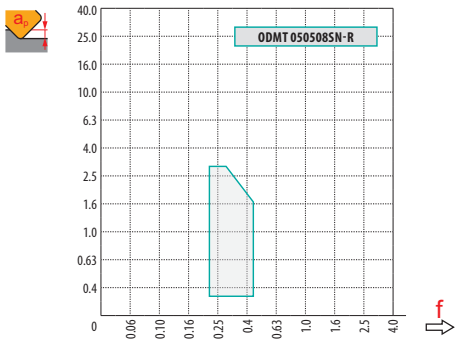
	RDGT 12-F	RDGT 12-FM	RDGT 12-R
RE	6.35	6.35	6.35
BS	–	–	–

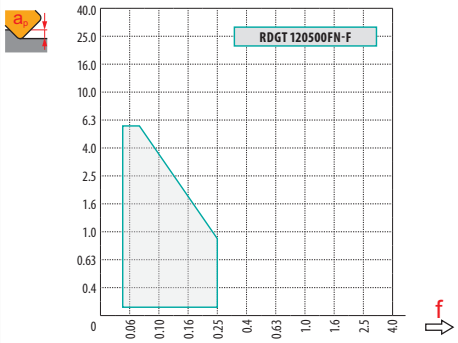
	SDKT 12-F	SDKT 12-FM	SDMT 12-F	SDMT 12-R
RE	0.8	0.8	0.8	0.8
BS	2.30	2.30	–	–

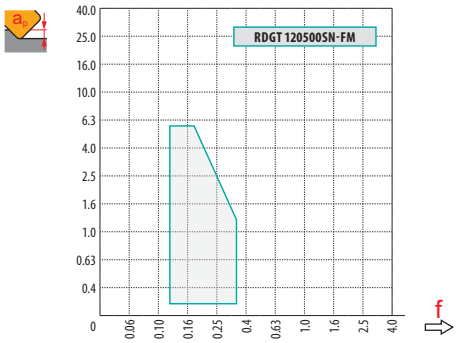


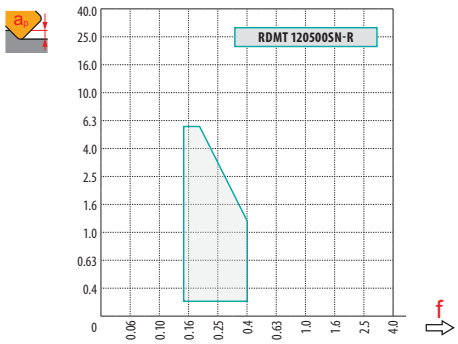


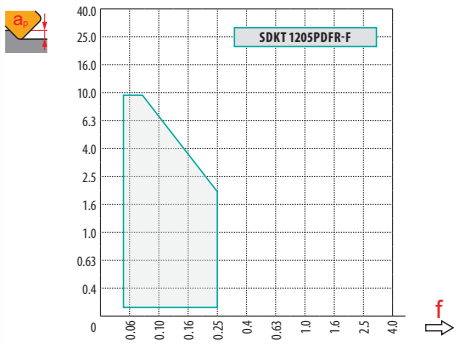


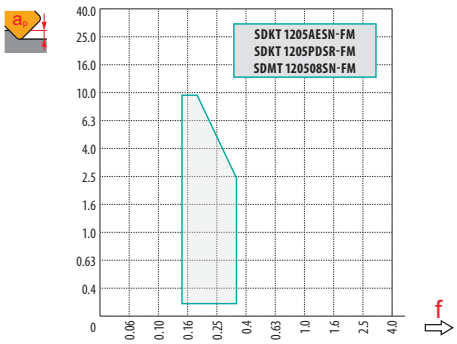


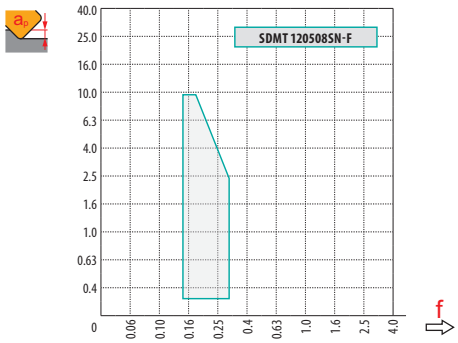


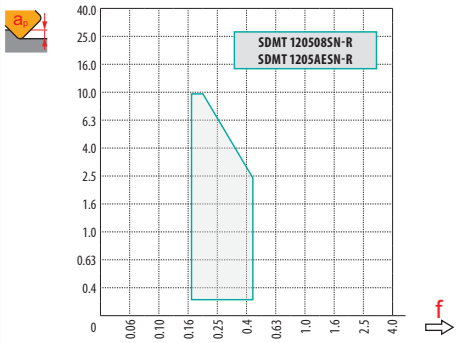












DCX	ap	R											
		0.25	0.50	0.60	0.70	0.80	1.00	1.25	1.50	2.00	3.00	4.00	5.00	6.00
32	DEF	23.43	24.80	25.23	25.62	25.99	26.63	27.33	27.94	28.94	30.39	31.31	31.83	32.00
40		31.43	32.80	33.23	33.62	33.99	34.63	35.33	35.94	36.94	38.39	39.31	39.83	40.00
50		41.43	42.80	43.23	43.62	43.99	44.63	45.33	45.94	46.94	48.39	49.31	49.83	50.00
63		54.43	55.80	56.23	56.62	56.99	57.63	58.33	58.94	59.94	61.39	62.31	62.83	63.00
80		71.43	72.80	73.23	73.62	73.99	74.63	75.33	75.94	76.94	78.39	79.31	79.83	80.00
100		91.43	92.80	93.23	93.62	93.99	94.63	95.33	95.94	96.94	98.39	99.31	99.83	100.00
125		116.43	117.80	118.23	118.62	118.99	119.63	120.33	120.94	121.94	123.39	124.31	124.83	125.00

DCX	X.V	f_{max}
32	1.36	0.28
40	1.40	0.31
50	1.43	0.33
63	1.47	0.37
80	1.52	0.42
100	1.57	0.47
125	1.62	0.52

S

$a_{e\,max}$
10.0

S

a_p	1.0	5.0	10.0
f	0.35	0.21	0.15

O

DCX	RPMX	APMX/I
50	4.1°	7.05/100
63	2.7°	4.6/100
80	1.8°	3/100
100	1.7°	2.85/100
125	0.7°	1.1/100

R

DCX	RPMX	APMX/I
50	3.8°	6.2/95
63	2.5°	4.25/100
80	1.7°	2.85/100
100	1.6°	2.65/100
125	0.3°	0.4/100

O

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
50	78.0	100.0	4.5	4.5
63	105.0	126.0	4.5	4.5
80	138.0	160.0	4.5	4.5
100	178.0	200.0	4.5	4.5
125	229.0	250.0	4.0	4.5

R

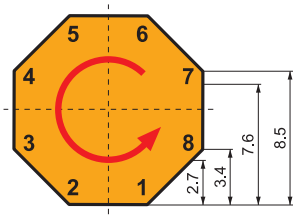
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
50	78.0	100.0	4.5	4.5
63	105.0	126.0	4.5	4.5
80	138.0	160.0	4.5	4.5
100	178.0	200.0	4.5	4.5
125	230.0	250.0	4.0	4.5

	O	R
a_p	2.4	2.3

DCX	µm	R										
		3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071

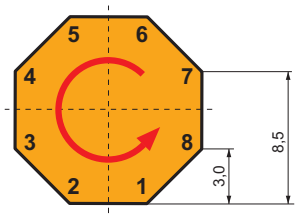
RE	µm	3	5	10	15	20	30	40	50	60	80	100
6.0	FE	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191

ODKT 05



a_p	
–> 2.7	8
–> 3.4	7
–> 7.6	4
–> 8.5	2

ODMT 05



a_p	
–> 3.0	8
–> 8.5	4

SOD06D

P M K S H

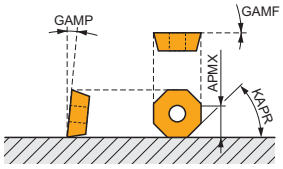
PRAMET

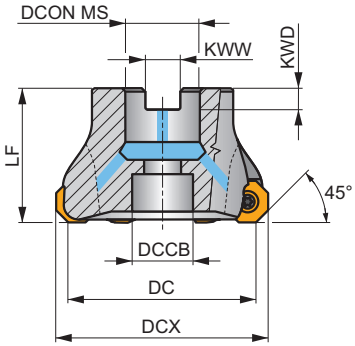
S

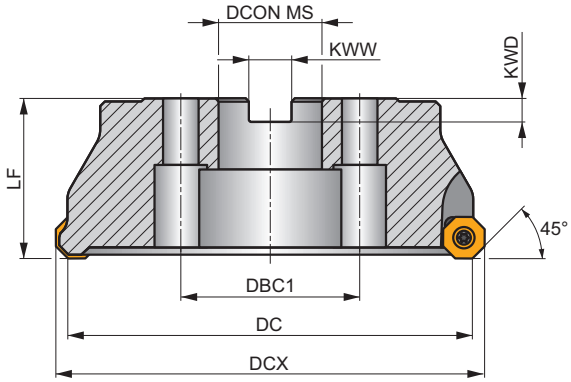
通用面铣，具有正前角设计，带内冷

Highly productive universal face mill utilising single sided positive inserts with APMX of up to 3.1 (8.6) mm. Unique insert seat fits OD.. 06 and RP.. 15 style inserts, suited for face milling and chamfering. Arbor style only with differential tooth pitch. Body treated for longer tool life.

KAPR	45°
APMX	3.1 (8.6) mm







h_m 0.12 - 0.22

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
ISO 6462 DIN 8030	**63A05R-S45OD06D**	63	72.5	40	22	18	–	10.4	6.3	0	5	5	✓	8800	✓	0.55	GI059	FA071
	80A06R-S45OD06D	80	89.5	50	27	20	–	12.4	7	0	5	6	✓	7800	✓	1.19	GI059	FA071
	100A07R-S45OD06D	100	109.5	50	32	27	–	14.4	8	0	5	7	✓	7000	✓	2.07	GI059	FA071
	125A08R-S45OD06D	125	134.5	63	40	33	–	16.4	9	0	5	8	✓	6300	✓	4.05	GI059	FA071
	160C09R-S45OD06D	160	169.5	63	40	56	66.7	16.4	9	0	5	9	✓	5500	–	6.49	GI059	FA071

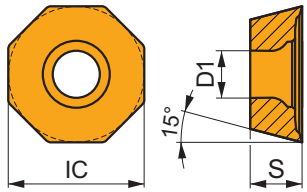
GI059	OD.. 0605ZZ..	RP.. 1505M0..

FA071	US 4511-T20	5.0 Nm	M 4.5	11	SDR T20-T

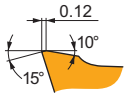
ODMT 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0605	15.875	5.50	5.56



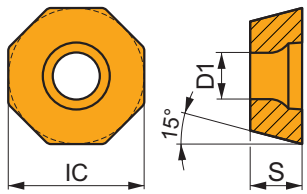
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ZZN 很小的正前角设计，45°面铣削刀片，适用于中等加工。																				
ODMT 0605ZZN:M5315		–	255	0.24	3.0	–	–	–	240	0.24	3.0	–	–	–	–	–	–	–	–	–
ODMT 0605ZZN:M8330		–	200	0.24	3.0	–	–	–	190	0.24	3.0	–	–	–	–	–	–	–	–	–
ODMT 0605ZZN:M8340		–	185	0.24	3.0	–	–	–	175	0.24	3.0	–	–	–	–	–	–	–	–	–
ODMT 0605ZZN:M9325		–	245	0.24	3.0	–	–	–	230	0.24	3.0	–	–	–	–	–	–	–	–	–

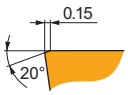
ODEW 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0605	15.875	5.50	5.56

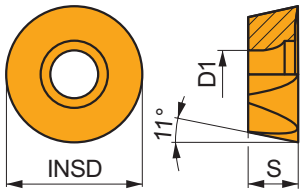


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

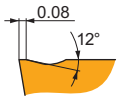
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ZZN 平板设计，45°面铣削刀片，适用于中等加工。																				
ODEW 0605ZZN:M8330		–	210	0.26	2.5	–	–	–	195	0.26	2.5	–	–	–	–	–	–	40	0.13	1.0

RPET 15

	INSD (mm)	D1 (mm)	S (mm)
1505	15.785	5.50	5.56

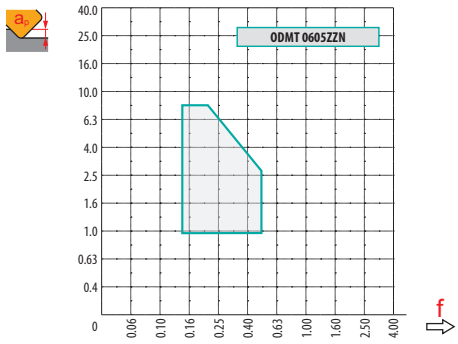


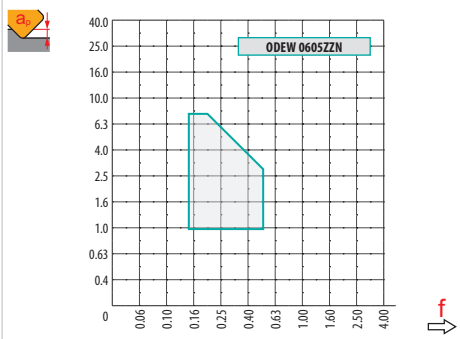
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

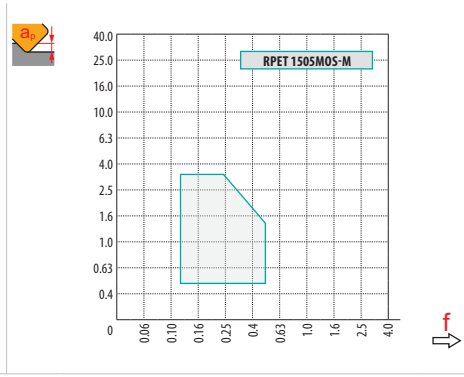
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 HFC S	M 型，仿形和轮廓铣削刀片，具有正前角设计，适用于轻载到粗加工。																			
RPET 1505MOS-M:M8330		–	230	0.40	1.0	135	0.36	1.0	215	0.40	1.0	–	–	–	55	0.28	0.8	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ODMT 06	ODEW 06	RPET 15-M
RE	–	–	7.89
BS	1.73	5.92	–

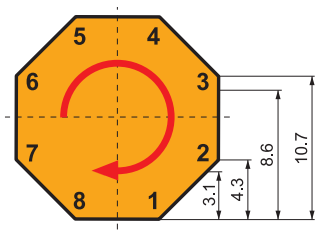






DC	R								
	a_p	0.00	0.50	0.75	1.25	1.50	2.00	2.50	3.00	4.00
63	DEF	56.63	62.17	63.36	65.18	65.91	67.16	68.19	69.05	70.41
80		73.63	79.17	80.36	82.18	82.91	84.16	85.19	86.05	87.41
100		93.63	99.17	100.36	102.18	102.91	104.16	105.19	106.05	107.41
125		118.63	124.17	125.36	127.18	127.91	129.16	130.19	131.05	132.41
160		153.63	159.17	160.36	162.18	162.91	164.16	165.19	166.05	167.41

DC	X.V	f_{max} ⇨
63	1.49	0.78
80	1.54	0.88
100	1.59	0.98
125	1.64	1.10
160	1.70	1.24



a_p	
–> 3.1	8
–> 4.3	7
–> 8.6	4
–> 10.7	2

SOE06Z

P M N S

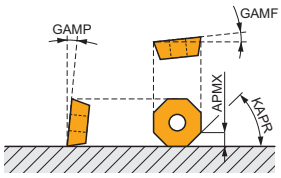
PRAMET

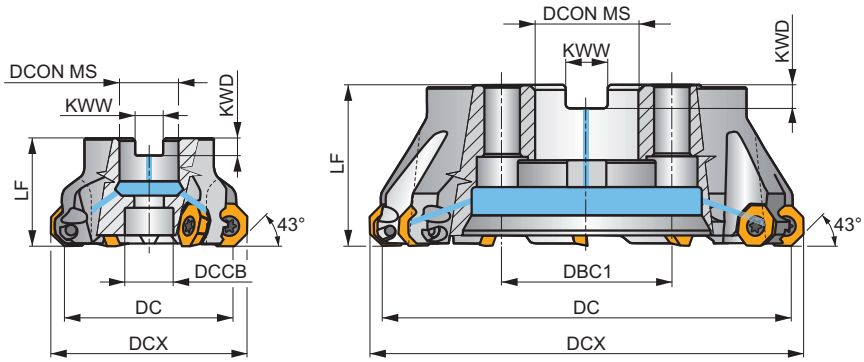
S

通用面铣，具有正前角设计，带内冷

高效富有成效的通用面铣，使用正前角单面刀片，具有APMX(最大切深)4mm，RE.. 16。独特的刀片座适合OE.. 06，RE.. 16和XE.. 06类型刀片，适用范围广泛。提供心轴式接口，具有不等齿距，刀体经过处理，使用寿命更长。

KAPR	43°
APMX	3.3 (9.9) mm





h_m 0.06 - 0.20

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
	50A04R-S450E06Z-C	50	60.2	40	22	18	–	10.4	6.3	6	10	4	✓	10700	✓	0.47	GI283	FA053	–
	50A05R-S450E06Z-C	50	60	40	22	18	–	10.4	6.3	1	10	5	✓	10700	✓	0.47	GI283	FA053	–
	56A05R-S450E06Z-C	56	66	40	22	18	–	10.4	6.3	6	10	5	✓	10100	✓	0.52	GI283	FA053	–
	63A04R-S450E06Z-C	63	73.2	40	22	18	–	10.4	6.3	6	10	4	✓	9600	✓	0.58	GI283	FA053	–
	63A06R-S450E06Z-C	63	73	40	22	18	–	10.4	6.3	1	10	6	✓	9600	✓	0.60	GI283	FA053	–
	70A06R-S450E06Z-C	70	80	40	22	18	–	10.4	6.3	6	10	6	✓	9100	✓	0.69	GI283	FA053	–
	80A05R-S450E06Z-C	80	90.2	50	27	38	–	12.4	7	6	10	5	✓	8500	✓	1.02	GI283	FA051	AC001
	80A06R-S450E06Z-C	80	90.2	50	27	38	–	12.4	7	6	10	6	✓	8500	✓	1.03	GI283	FA051	AC001
ISO 6462 DIN 8030	90A07R-S450E06Z-C	90	100	50	32	45	–	14.4	8	6	10	7	✓	8000	✓	1.59	GI283	FA051	AC002
	100A06R-S450E06Z-C	100	110.2	50	32	45	–	14.4	8	6	10	6	✓	7600	✓	1.85	GI283	FA051	AC002
	100A08R-S450E06Z-C	100	109.9	50	32	45	–	14.4	8	1	10	8	✓	7600	✓	1.87	GI283	FA051	AC002
	125A07R-S450E06Z-C	125	135.2	63	40	56	–	16.4	9	6	10	7	✓	6800	✓	3.31	GI283	FA051	AC003
	125A09R-S450E06Z-C	125	134.9	63	40	56	–	16.4	9	1	10	9	✓	6800	✓	3.35	GI283	FA051	AC003
	160C09R-S450E06Z-C	160	170.2	63	40	–	66.7	16.4	9	6	10	9	✓	6000	✓	6.08	GI283	FA056	–
	160C12R-S450E06Z-C	160	169.9	63	40	–	66.7	16.4	9	1	10	12	✓	6000	✓	7.06	GI283	FA056	–
	200C11R-S450E06Z-C	200	210.2	63	60	–	101.6	25.7	14	6	10	11	✓	5300	✓	10.80	GI283	FA057	–
	200C14R-S450E06Z-C	200	209.9	63	60	–	101.6	25.7	14	1	10	14	✓	5300	✓	11.15	GI283	FA057	–

GI283	OEHT 0604AE..	REHT 1604M0..	XEHT 0604AE..

		Nm							
FA051	US 5011-T20P	5.0	M 5	11	SDR T20P-T	–	–	–	–
FA053	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1030C	–	–	–

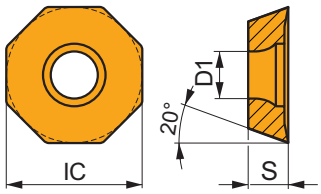
		Nm							
FA056	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5
FA057	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1655C	CAC 200C	HSD 1025C	HXK 7

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

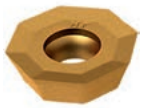
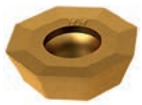
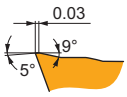
OEHT 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0604	16.050	5.50	4.76



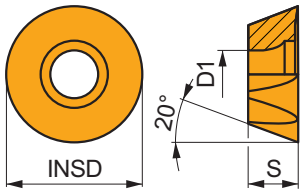
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
MF 型，45°面铣削刀片，具有锋利正前角设计，适用于轻载到中等和潜在的精加工。																				
OEHT 0604AEER-MF:M6330		–	255	0.12	2.2	180	0.11	2.2	–	–	–	–	–	–	75	0.10	1.8	–	–	–
OEHT 0604AEER-MF:M8330		–	295	0.12	2.2	175	0.11	2.2	–	–	–	885	0.14	2.2	70	0.10	1.8	–	–	–
OEHT 0604AEER-MF:M8340		–	275	0.12	2.2	165	0.11	2.2	–	–	–	–	–	–	65	0.10	1.8	–	–	–
																				
MM 型，45°面铣削刀片，具有锋利的正前角设计，适用于轻载到中等加工。																				
OEHT 0604AEER-MM:M6330		–	245	0.16	2.2	170	0.14	2.2	–	–	–	–	–	–	70	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M8330		–	280	0.16	2.2	165	0.14	2.2	–	–	–	840	0.19	2.2	70	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M8340		–	255	0.16	2.2	150	0.14	2.2	–	–	–	–	–	–	60	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M8345		–	205	0.16	2.2	120	0.14	2.2	–	–	–	–	–	–	50	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M9340		–	320	0.16	2.2	190	0.14	2.2	–	–	–	–	–	–	80	0.11	1.8	–	–	–
																				
M 型，45°面铣削刀片，具有很小的正前角设计，适用于轻载到中等加工。																				
OEHT 0604AESR-M:M6330		–	210	0.24	3.2	150	0.22	3.2	–	–	–	–	–	–	60	0.17	2.6	–	–	–
OEHT 0604AESR-M:M8310		–	265	0.24	3.2	135	0.22	3.2	–	–	–	–	–	–	–	–	–	–	–	–
OEHT 0604AESR-M:M8330		–	245	0.24	3.2	145	0.22	3.2	–	–	–	–	–	–	60	0.17	2.6	–	–	–
OEHT 0604AESR-M:M8340		–	220	0.24	3.2	130	0.22	3.2	–	–	–	–	–	–	55	0.17	2.6	–	–	–
OEHT 0604AESR-M:M9325		–	295	0.24	3.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

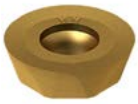
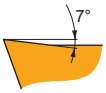
REHT 16

PRAMET

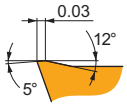
	INSD (mm)	D1 (mm)	S (mm)
1604	16.000	5.50	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  E																				
REHT 1604M0EN-MM:M6330	✱	–	255	0.20	2.0	180	0.18	2.0	–	–	–	–	–	–	75	0.14	1.6	–	–	–
REHT 1604M0EN-MM:M8340	✱	–	270	0.20	2.0	160	0.18	2.0	–	–	–	–	–	–	65	0.14	1.6	–	–	–
REHT 1604M0EN-MM:M9340	✱	–	330	0.20	2.0	195	0.18	2.0	–	–	–	–	–	–	80	0.14	1.6	–	–	–

MM 型，仿形和轮廓铣削刀片，具有很小的正前角设计，适用于轻载到中等加工。

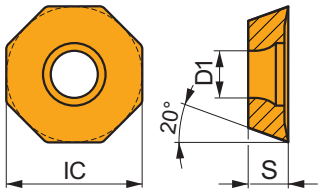
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 S																				
REHT 1604M0SN-M:M8310	✱	–	285	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–
REHT 1604M0SN-M:M8330	✱	–	270	0.30	2.0	160	0.27	2.0	–	–	–	–	–	–	65	0.21	1.6	–	–	–
REHT 1604M0SN-M:M8340	✱	–	245	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	60	0.21	1.6	–	–	–

M 型，仿形和轮廓铣削刀片，具有前角设计，适用于轻载到中等加工。

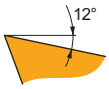
OEHT 06-FA

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0604	16.050	5.50	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

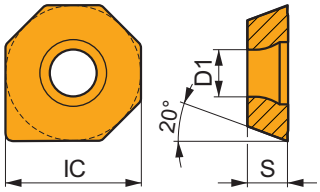
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 1 F																				
OEHT 0604AEFR-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	330	0.18	2.0	–	–	–	–	–	–
OEHT 0604AEFR-FA:M0315	●	–	–	–	–	–	–	–	–	–	–	765	0.18	2.0	–	–	–	–	–	–

FA 型，45°面铣削刀片，具有大正前角设计，适用于精加工到中等加工。

XEHT 06

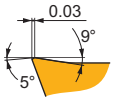
PRAMET

	IC (mm)	D1 (mm)	S (mm)
0604	16.050	5.50	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

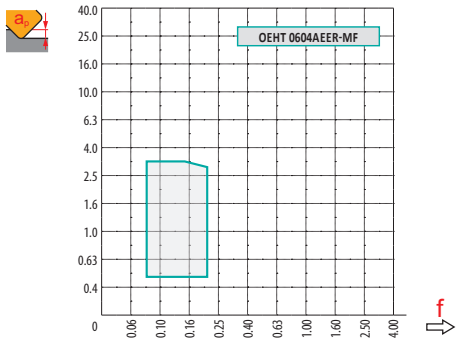
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
XEHT 0604AESR:M8310		–	265	0.24	3.2	135	0.22	3.2	–	–	–	–	–	–	–	–	–	–	–	–
XEHT 0604AESR:M8330		–	245	0.24	3.2	145	0.22	3.2	–	–	–	–	–	–	–	–	–	–	–	–

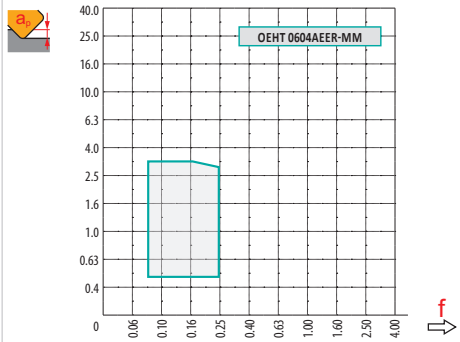


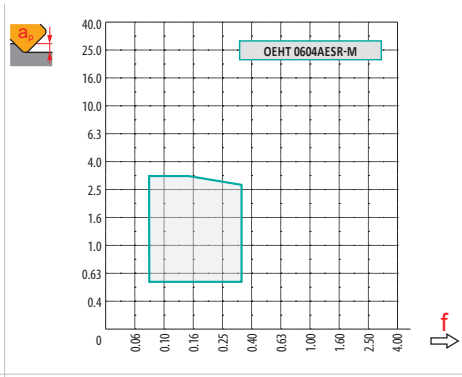
W 很小的正前角修光刃设计，适用于改善表面光洁度。

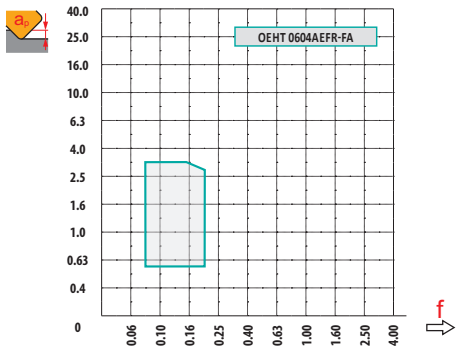
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

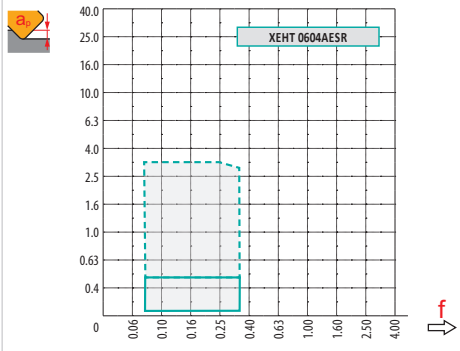
	OEHT 06-MF	OEHT 06-MM	OEHT 06-M	OEHT 06-FA	XEHT 06	REHT 16-MM	REHT 16-M
RE	–	–	–	–	–	8.00	8.00
BS	1.36	1.36	1.36	1.36	9.91	–	–

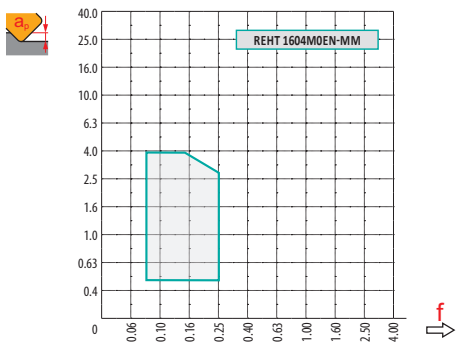


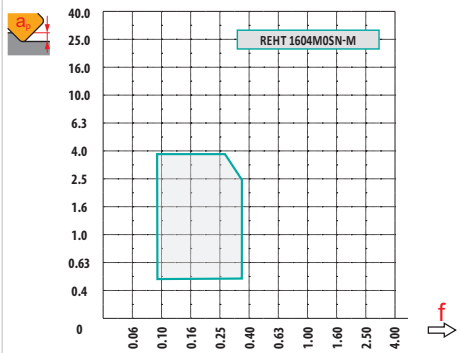












DC	R								
	a_p	0.00	0.50	0.75	1.25	1.50	2.00	2.50	3.00	4.00
50	DEF	43.90	49.47	50.66	52.49	53.23	54.48	55.52	56.39	57.76
56		49.80	55.37	56.56	58.39	59.13	60.38	61.42	62.29	63.66
63		56.90	62.47	63.66	65.49	66.23	67.48	68.52	69.39	70.76
70		63.80	69.37	70.56	72.39	73.13	74.38	75.42	76.29	77.66
80		73.90	79.47	80.66	82.49	83.23	84.48	85.52	86.39	87.76
90		83.80	89.37	90.56	92.39	93.13	94.38	95.42	96.29	97.66
100		93.90	99.47	100.66	102.49	103.23	104.48	105.52	106.39	107.76
125		118.90	124.47	125.66	127.49	128.23	129.48	130.52	131.39	132.76
160		153.90	159.47	160.66	162.49	163.23	164.48	165.52	166.39	167.76
200		193.90	199.47	200.66	202.49	203.23	204.48	205.52	206.39	207.76

DC	X.V	f_{max}
50	1.43	0.33
56	1.45	0.35
63	1.47	0.37
70	1.49	0.39
80	1.52	0.42
90	1.55	0.44
100	1.57	0.47
125	1.62	0.52
160	1.68	0.59
200	1.73	0.66

O		
DC	RPMX	APMX/l
50	4.9°	8.4/100
56	4.2°	7.2/100
63	3.6°	6.1/100
70	3.1°	5.3/100
80	2.6°	4.4/100
90	2.3°	3.9/100
100	2.0°	3.3/100
125	1.5°	2.5/100

R		
DCX	RPMX	APMX/l
59.9	4.6°	7.9/100
65.8	4.0°	6.8/100
72.9	3.0°	5.1/100
79.8	2.7°	4.6/100
89.9	2.2°	3.7/100
99.8	2.0°	3.3/100
109.9	1.8°	3.0/100
134.9	1.3°	2.1/100

O				
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
50	91.5	120.0	5.9	5.9
56	103.2	131.5	5.9	5.9
63	117.4	146.0	5.9	5.9
70	131.2	159.5	5.9	5.9
80	151.4	180.0	5.9	5.9
90	171.2	199.5	5.9	5.9
100	191.4	220.0	5.9	5.9
125	241.3	270.0	5.9	5.9

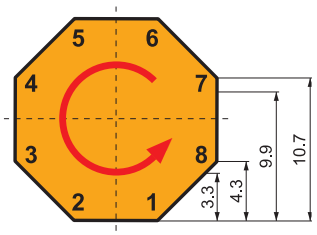
R				
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
59.9	91.5	119.5	5.9	5.9
65.8	103.5	131.0	5.9	5.9
72.9	118.0	145.5	5.9	5.9
79.8	131.5	159.0	5.9	5.9
89.9	151.5	179.5	5.9	5.9
99.8	171.5	199.0	5.9	5.9
109.9	191.5	219.5	5.9	5.9
134.9	241.5	269.5	5.9	5.9

	O	R
a_p	3.1	3.0

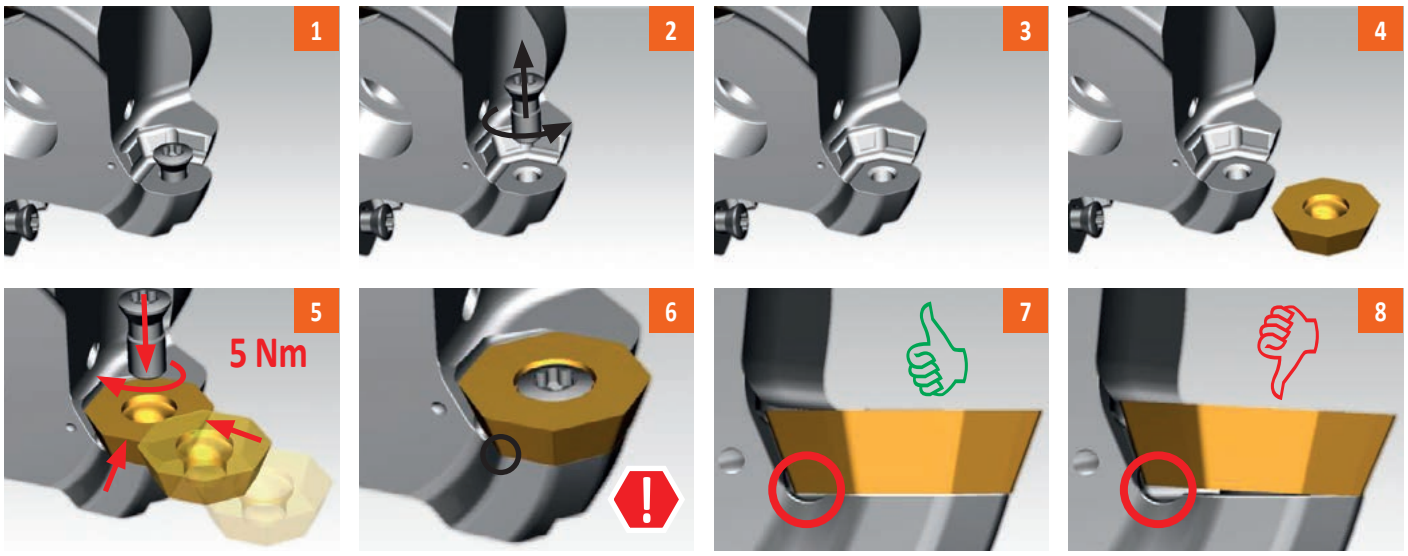
R

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
59.9	FE	0.848	1.095	1.548	1.896	2.189	2.681	3.096	3.461	3.792	4.378	4.895
65.8		0.889	1.147	1.622	1.987	2.294	2.810	3.245	3.628	3.974	4.589	5.130
72.9		0.935	1.207	1.708	2.091	2.415	2.958	3.415	3.818	4.183	4.830	5.400
79.8		0.979	1.263	1.787	2.188	2.527	3.095	3.573	3.995	4.376	5.053	5.650
89.9		1.039	1.341	1.896	2.322	2.682	3.285	3.793	4.240	4.645	5.364	5.997
99.8		1.094	1.413	1.998	2.447	2.826	3.461	3.996	4.468	4.894	5.651	6.318

RE	µm	3	5	10	15	20	30	40	50	60	80	100
8.0	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530



a_p	
–> 3.3	8
–> 4.3	7
–> 9.9	4
–> 10.7	2



方肩铣削

可转位铣刀 – 导航工具

平面铣

	STN10	STN16	SLN12	SLN16	SLN12X
	90°	90°	90°	90°	90°
	APMX (mm) 5.0	APMX (mm) 10.0	APMX (mm) 9.0	APMX (mm) 13.0	APMX (mm) 10.0
	DC (mm) 18 – 80	DC (mm) 25 – 175	DC (mm) 25 – 125	DC (mm) 63 – 175	DC (mm) 25 – 125
圆柱刀柄	DC = 18 – 35 (mm)	DC = 25 – 35 (mm)	DC = 25, 32 (mm)		DC = 25 – 40 (mm)
侧固刀柄	DC = 20 – 32 (mm)	DC = 25 – 40 (mm)	DC = 25 – 40 (mm)		DC = 25 – 40 (mm)
模块式刀柄	DC = 20 – 32 (mm)	DC = 25 – 40 (mm)	DC = 25 – 40 (mm)		
套式铣刀	DC = 40 – 80 (mm)	DC = 40 – 175 (mm)	DC = 40 – 125 (mm)		DC = 40 – 125 (mm)
页码	66	70	75	81	85
ISO	P M K N	P M K N	P M K N	P K N H	P M K H
刀片形状					
刀片	TNGX 1004	TNGX 1606	LNG. 1205	LN.U 1607	LNEX 1210
切削刃数量	6	6	4	4	4
平面铣	■	■	■	■	■
倒角铣	◪	◪	◪		◪
螺旋插补	■	■	■	■	■
连续钻铣	◪		■	■	■
坡走铣	◪		◪		
形面铣（仿形铣）	◪		◪		◪
浅方肩铣	■	■	◪		■
浅槽铣			◪	◪	

■ 推荐使用　◪ 可以使用

STN10

P M K N S

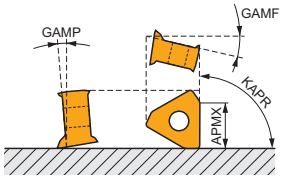
PRAMET

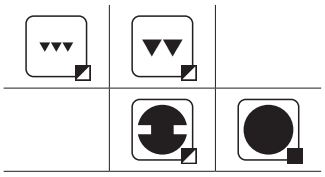
S

ECON TN10带内冷的方肩铣刀

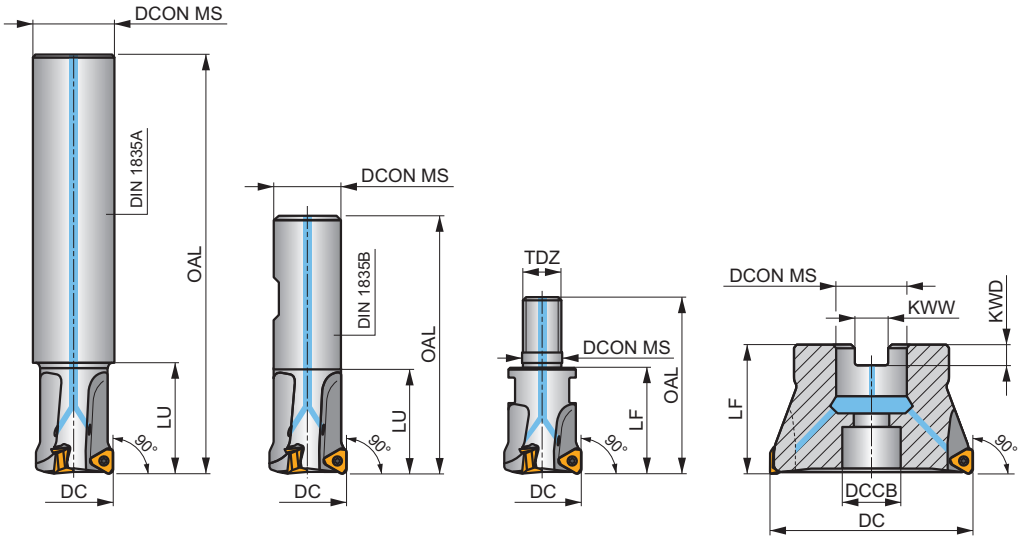
90⊠方肩铣刀和面铣刀，使用双面TNGX 10刀片，具有6个切削刃和APMX(最大切深)5mm。应用范围广泛。可提供圆柱柄，侧固柄，模块夹紧系统和芯轴式类型，有或没有不等齿距。刀体经过处理，使用寿命更长。

KAPR	90°
APMX	5.0 mm





ECON TN



h_m	0.03 - 0.06
h_m	0.03 - 0.08

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	18A2R050A20-STN10-C	18	180	20	–	50	–	–	–	–	-17.1	-11	2	–	29100	✓	0.39	GI292	SQ300	–
	20A2R029A20-STN10-C	20	150	20	–	29	–	–	–	–	-16.5	-11	2	–	27600	✓	0.35	GI292	SQ300	–
	20A3R029A20-STN10-C	20	150	20	–	29	–	–	–	–	-16.5	-11	3	–	27600	✓	0.34	GI292	SQ300	–
	22A3R050A25-STN10-C	22	180	25	–	50	–	–	–	–	-16.5	-11	3	–	26300	✓	0.58	GI292	SQ300	–
	25A3R034A25-STN10-C	25	170	25	–	34	–	–	–	–	-16	-11	3	–	24700	✓	0.58	GI292	SQ300	–
	25A4R034A25-STN10-C	25	170	25	–	34	–	–	–	–	-16	-11	4	✓	24700	✓	0.58	GI292	SQ300	–
	30A4R050A32-STN10-C	30	200	32	–	50	–	–	–	–	-16	-11	4	✓	22500	✓	1.06	GI292	SQ300	–
	32A4R037A32-STN10-C	32	195	32	–	37	–	–	–	–	-16	-11	4	✓	21800	✓	1.08	GI292	SQ300	–
	32A5R037A32-STN10-C	32	195	32	–	37	–	–	–	–	-16	-11	5	✓	21800	✓	1.08	GI292	SQ300	–
	35A5R080A32-STN10-C	35	200	32	–	80	–	–	–	–	-16	-11	5	✓	20800	✓	1.07	GI292	SQ300	–
DIN 1835B	20A2R032B20-STN10-C	20	90	20	–	32	–	–	–	–	-16.5	-11	2	–	27600	✓	0.20	GI292	SQ300	–
	20A3R032B20-STN10-C	20	90	20	–	32	–	–	–	–	-16.5	-11	3	–	27600	✓	0.19	GI292	SQ300	–
	25A3R042B25-STN10-C	25	100	25	–	42	–	–	–	–	-16	-11	3	–	24700	✓	0.31	GI292	SQ300	–
	25A4R042B25-STN10-C	25	100	25	–	42	–	–	–	–	-16	-11	4	✓	24700	✓	0.31	GI292	SQ300	–
	32A4R042B32-STN10-C	32	110	32	–	42	–	–	–	–	-16	-11	4	✓	21800	✓	0.57	GI292	SQ300	–
	32A5R042B32-STN10-C	32	110	32	–	42	–	–	–	–	-16	-11	5	✓	21800	✓	0.56	GI292	SQ300	–
MODULAR	20A2R026M10-STN10-C	20	45	10.5	–	–	26	M10	–	–	-16.5	-11	2	–	–	✓	0.06	GI292	SQ300	–
	20A3R026M10-STN10-C	20	45	10.5	–	–	26	M10	–	–	-16.5	-11	3	–	–	✓	0.06	GI292	SQ300	–
	25A3R033M12-STN10-C	25	55	12.5	–	–	33	M12	–	–	-16	-11	3	–	–	✓	0.10	GI292	SQ300	–
	25A4R033M12-STN10-C	25	55	12.5	–	–	33	M12	–	–	-16	-11	4	✓	–	✓	0.10	GI292	SQ300	–
	32A4R043M16-STN10-C	32	66	17	–	–	43	M16	–	–	-16	-11	4	✓	–	✓	0.21	GI292	SQ300	–
	32A5R043M16-STN10-C	32	66	17	–	–	43	M16	–	–	-16	-11	5	✓	–	✓	0.21	GI292	SQ300	–
ISO 6462 DIN 8030	40A04R-S90TN10-C	40	–	16	14	–	40	–	8.4	5.6	-15	-11	4	✓	19500	✓	0.34	GI292	SQ302	–
	40A06R-S90TN10-C	40	–	16	14	–	40	–	8.4	5.6	-15	-11	6	✓	19500	✓	0.34	GI292	SQ302	–
	50A05R-S90TN10-C	50	–	22	18	–	40	–	10.4	6.3	-15	-11	5	✓	17400	✓	0.48	GI292	SQ303	–
	50A07R-S90TN10-C	50	–	22	18	–	40	–	10.4	6.3	-15	-11	7	✓	17400	✓	0.49	GI292	SQ303	–
	63A06R-S90TN10-C	63	–	22	18	–	40	–	10.4	6.3	-15	-11	6	✓	15500	✓	0.63	GI292	SQ303	–

产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
63A09R-S90TN10-C	63	–	22	18	–	40	–	10.4	6.3	-15	-11	9	✓	15500	✓	0.63	GI292	SQ303	–
80A10R-S90TN10-C	80	–	27	38	–	50	–	12.4	7	-15	-11	10	✓	13800	✓	1.03	GI292	SQ301	AC001

GI292	TNGX 1004..

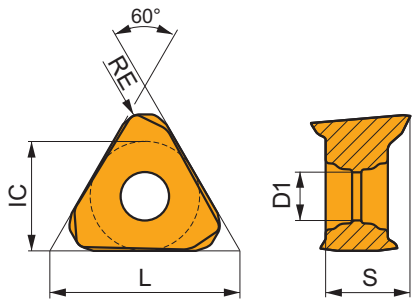
		Nm						
SQ300	US 52506-T07P	0.8	M 2.5	6	–	–	Flag T07P	–
SQ301	US 52506-T07P	0.8	M 2.5	6	D-T07P/T09P	FG-15	–	–
SQ302	US 52506-T07P	0.8	M 2.5	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ303	US 52506-T07P	0.8	M 2.5	6	D-T07P/T09P	FG-15	–	HS 1030C

AC001	KS 1230	K.FMH27

TNGX 10

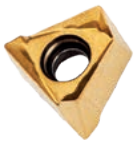
PRAMET

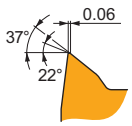
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1004	6.000	2.80	10.39	4.69



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

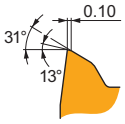
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
TNGX 100402SR-F:M8330	●	0.2	205	0.09	2.0	120	0.08	2.0	190	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100402SR-F:M8340	●	0.2	190	0.09	2.0	110	0.08	2.0	180	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100404SR-F:8215	●	0.4	225	0.09	2.0	135	0.08	2.0	210	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100404SR-F:M6330	●	0.4	190	0.09	2.0	135	0.08	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TNGX 100404SR-F:M8330	●	0.4	220	0.09	2.0	130	0.08	2.0	205	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100404SR-F:M8340	●	0.4	200	0.09	2.0	120	0.08	2.0	190	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100404SR-F:M9340	●	0.4	270	0.09	2.0	160	0.08	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TNGX 100408SR-F:8215	●	0.8	270	0.09	2.0	160	0.08	2.0	255	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100408SR-F:M6330	●	0.8	225	0.09	2.0	160	0.08	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TNGX 100408SR-F:M8330	●	0.8	260	0.09	2.0	155	0.08	2.0	245	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100408SR-F:M8340	●	0.8	240	0.09	2.0	140	0.08	2.0	225	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100408SR-F:M9340	●	0.8	320	0.09	2.0	190	0.08	2.0	–	–	–	–	–	–	–	–	–	–	–	–





F 型，具有大正前角设计，适用于轻载加工。

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。



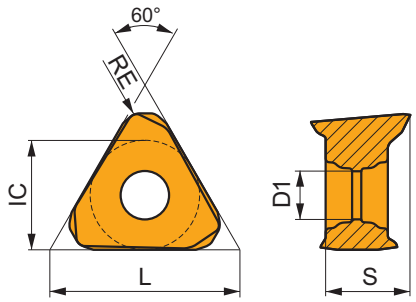
M 型，具有前角设计，适用于轻载到中等加工。

产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
TNGX 100404SR-M:8215	●	0.4	205	0.13	2.0	120	0.12	2.0	190	0.13	2.0	–	–	–	50	0.09	1.6	–	–	–
TNGX 100404SR-M:M6330	●	0.4	175	0.13	2.0	125	0.12	2.0	–	–	–	–	–	–	50	0.09	1.6	–	–	–
TNGX 100404SR-M:M8330	●	0.4	205	0.13	2.0	120	0.12	2.0	190	0.13	2.0	–	–	–	50	0.09	1.6	–	–	–
TNGX 100404SR-M:M8340	●	0.4	185	0.13	2.0	110	0.12	2.0	175	0.13	2.0	–	–	–	45	0.09	1.6	–	–	–
TNGX 100404SR-M:M9340	●	0.4	240	0.13	2.0	140	0.12	2.0	–	–	–	–	–	–	60	0.09	1.6	–	–	–
TNGX 100408SR-M:8215	●	0.8	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	–	–	–	60	0.09	1.6	–	–	–
TNGX 100408SR-M:M6330	⇕	0.8	210	0.13	2.0	150	0.12	2.0	–	–	–	–	–	–	60	0.09	1.6	–	–	–
TNGX 100408SR-M:M8310	●	0.8	270	0.13	2.0	135	0.12	2.0	255	0.13	2.0	–	–	–	–	–	–	–	–	–
TNGX 100408SR-M:M8330	⇕	0.8	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	–	–	–	60	0.09	1.6	–	–	–
TNGX 100408SR-M:M8340	⇕	0.8	220	0.13	2.0	130	0.12	2.0	205	0.13	2.0	–	–	–	55	0.09	1.6	–	–	–
TNGX 100408SR-M:M8345	⇕	0.8	180	0.13	2.0	105	0.12	2.0	–	–	–	–	–	–	45	0.09	1.6	–	–	–
TNGX 100408SR-M:M9340	●	0.8	285	0.13	2.0	170	0.12	2.0	–	–	–	–	–	–	70	0.09	1.6	–	–	–
TNGX 100412SR-M:M8330	⇕	1.2	255	0.13	2.0	150	0.12	2.0	240	0.13	2.0	–	–	–	60	0.09	1.6	–	–	–
TNGX 100412SR-M:M8340	⇕	1.2	230	0.13	2.0	135	0.12	2.0	215	0.13	2.0	–	–	–	55	0.09	1.6	–	–	–
TNGX 100416SR-M:M8310	⇕	1.6	300	0.13	2.0	150	0.12	2.0	285	0.13	2.0	–	–	–	–	–	–	–	–	–
TNGX 100416SR-M:M8330	⇕	1.6	270	0.13	2.0	160	0.12	2.0	255	0.13	2.0	–	–	–	65	0.09	1.6	–	–	–
TNGX 100416SR-M:M8340	⇕	1.6	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	–	–	–	60	0.09	1.6	–	–	–

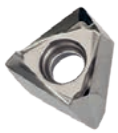
TNGX 10-FA

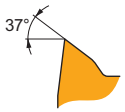
PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1004	6.000	2.80	10.39	4.69



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。



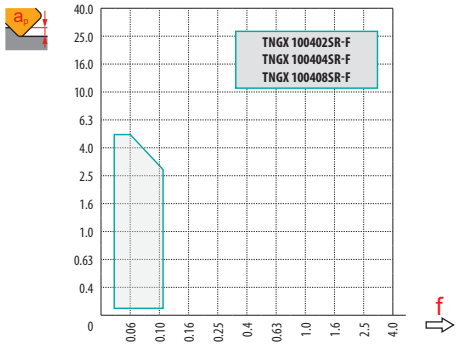


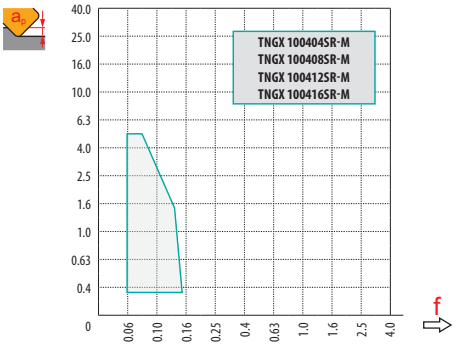
FA 型，具有大正前角设计，适用于精加工到中等加工。

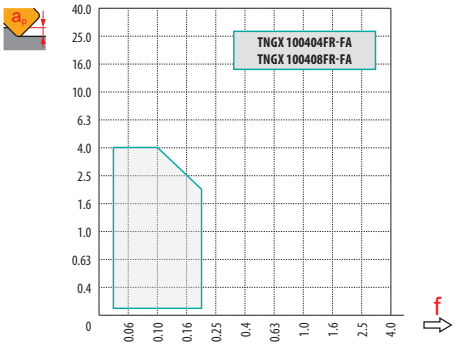
产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
TNGX 100404FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	345	0.10	1.5	–	–	–	–	–	–
TNGX 100404FR-FA:M0315	●	0.4	–	–	–	–	–	–	–	–	–	780	0.10	1.5	–	–	–	–	–	–
TNGX 100408FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	345	0.10	1.5	–	–	–	–	–	–
TNGX 100408FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	780	0.10	1.5	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TNGX 10-F			TNGX 10-M				TNGX 10-FA	
RE	0.2	0.4	0.8	0.4	0.8	1.2	1.6	0.4	0.8
BS	1.53	1.34	0.92	1.34	0.92			1.33	0.93







max

1.5

a_p	1.0	3.0	5.0
1 ⇨ f	0.10	0.08	0.04

a_p

0.2

DC	RPMX	APMX/I
18	1.80°	3.05/100
20	1.60°	2.70/100
22	1.20°	2.00/100
25	1.00°	1.70/100
30	0.90°	1.45/100
32	0.80°	1.30/100
35	0.65°	1.00/100
40	0.60°	0.90/100
50	0.50°	0.70/100
63	0.40°	0.50/100
80	0.25°	0.30/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
18	33	36	1.2	1.2
20	37	40	1.2	1.2
22	41	44	1.0	1.0
25	47	50	1.0	1.0
30	57	60	1.0	1.0
32	61	64	1.0	1.0
35	67	70	0.9	0.9
40	77	80	0.9	0.9
50	97	100	0.9	0.9
63	123	126	0.9	0.9
80	157	160	0.9	0.9

STN16

P M K N S

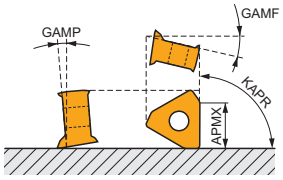
PRAMET

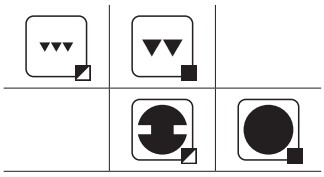
S

ECON TN16带内冷的方肩铣刀

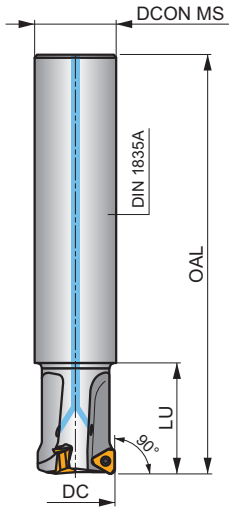
90°方肩铣刀和面铣刀，使用双面TNGX 16刀片，具有6个切削刃和APMX(最大切深)10mm。应用范围广泛。可提供圆柱直柄，侧固柄，模块夹紧系统和心轴式(具有不等齿距)接口。刀体经过处理，使用寿命更长。

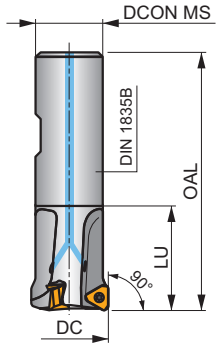
KAPR	90°
APMX	10.0 mm

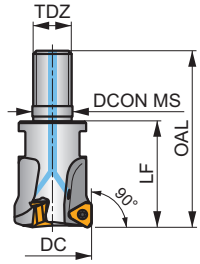


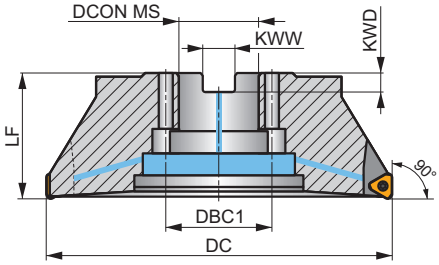


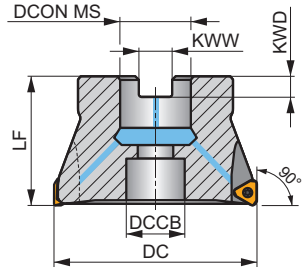
ECON TN











h_m	0.03 - 0.13
h_m	0.03 - 0.15

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	25A2R034A25-STN16-C	25	170	25	–	–	34	–	–	–	–	-18.5	-9.5	2	–	20000	✓	0.54	GI340	C0382
	32A2R034A32-STN16-C	32	195	32	–	–	34	–	–	–	–	-16	-9.5	2	–	17500	✓	1.05	GI340	C0382
	25A2R080A25-STN16-C	25	170	25	–	–	80	–	–	–	–	-18.5	-9.5	2	–	20000	✓	0.48	GI340	C0382
	32A2R080A32-STN16-C	32	195	32	–	–	80	–	–	–	–	-16	-9.5	2	–	17500	✓	0.96	GI340	C0382
	32A3R034A32-STN16-C	32	195	32	–	–	34	–	–	–	–	-16	-9.5	3	–	17500	✓	1.04	GI340	C0382
	35A3R034A32-STN16-C	35	195	32	–	–	34	–	–	–	–	-16	-9.5	3	–	17000	✓	1.07	GI340	C0382
DIN 1835B	25A2R042B25-STN16-C	25	110	25	–	–	42	–	–	–	–	-18.5	-9.5	2	–	20000	✓	0.29	GI340	C0382
	32A3R042B32-STN16-C	32	110	32	–	–	42	–	–	–	–	-16	-9.5	3	–	17500	✓	0.52	GI340	C0382
	40A4R050B32-STN16-C	40	120	32	–	–	50	–	–	–	–	-16	-9.5	4	–	16000	✓	0.68	GI340	C0382
MODULAR	25A2R033M12-STN16-C	25	55	12.5	–	–	–	33	M12	–	–	-18.5	-9.5	2	–	20000	✓	0.10	GI340	C0382
	32A2R043M16-STN16-C	32	66	17	–	–	–	43	M16	–	–	-16	-9.5	2	–	17500	✓	0.18	GI340	C0382
	32A3R043M16-STN16-C	32	66	17	–	–	–	43	M16	–	–	-16	-9.5	3	–	17500	✓	0.17	GI340	C0382
	40A3R043M16-STN16-C	40	66	17	–	–	–	43	M16	–	–	-16	-9.5	3	–	16000	✓	0.20	GI340	C0382
	40A4R043M16-STN16-C	40	66	17	–	–	–	43	M16	–	–	-16	-9.5	4	–	16000	✓	0.21	GI340	C0382
ISO 6462 DIN 8030	40A03R-S90TN16-C	40	40	16	12.4	–	–	40	–	8.4	5.6	-16	-9.5	3	–	16000	✓	0.32	GI340	C0384
	40A04R-S90TN16-C	40	40	16	12.4	–	–	40	–	8.4	5.6	-16	-9.5	4	–	16000	✓	0.31	GI340	C0384
	50A04R-S90TN16-C	50	40	22	18.1	–	–	40	–	10.4	6.3	-16	-9.5	4	✓	14000	✓	0.34	GI340	C0386
	50A05R-S90TN16-C	50	40	22	18.1	–	–	40	–	10.4	6.3	-16	-9.5	5	✓	14000	✓	0.32	GI340	C0386
	63A04R-S90TN16-C	63	40	22	18.1	–	–	40	–	10.4	6.3	-16	-9.5	4	✓	12500	✓	0.47	GI340	C0386
	63A06R-S90TN16-C	63	40	22	18.1	–	–	40	–	10.4	6.3	-16	-9.5	6	✓	12500	✓	0.48	GI340	C0386
	80A05R-S90TN16-C	80	50	27	22.1	–	–	50	–	12.4	7	-16	-9.5	5	✓	11000	✓	1.15	GI340	C0388
	80A07R-S90TN16-C	80	50	27	22.1	–	–	50	–	12.4	7	-16	-9.5	7	✓	11000	✓	1.17	GI340	C0388
	100A06R-S90TN16-C	100	50	32	45.1	–	–	50	–	14.4	8	-16	-9.5	6	✓	10000	✓	1.79	GI340	C0390
	100A08R-S90TN16-C	100	50	32	45.1	–	–	50	–	14.4	8	-16	-9.5	8	✓	10000	✓	1.66	GI340	C0390
	115A06R-S90TN16-C	115	50	32	45.1	–	–	50	–	14.4	8	-16	-9.5	6	✓	9500	✓	2.21	GI340	C0390
	125A07R-S90TN16-C	125	63	40	56.1	–	–	63	–	16.4	9	-16	-9.5	7	✓	9000	✓	3.05	GI340	C0390
	125A09R-S90TN16-C	125	63	40	56.1	–	–	63	–	16.4	9	-16	-9.5	9	✓	9000	✓	3.14	GI340	C0390

产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
140A08R-S90TN16-C	140	63	40	56.1	–	–	63	–	16.4	9	-16	-9.5	8	✓	8500	✓	3.69	GI340	C0390
160C10R-S90TN16-C	160	63	40	–	66.7	–	63	–	16.4	9.2	-16	-9.5	10	✓	8000	✓	5.16	GI340	C0394
175C10R-S90TN16-C	175	63	40	–	66.7	–	63	–	16.4	9.2	-16	-9.5	10	✓	7500	✓	6.89	GI340	C0394

ISO 6462 DIN 8030

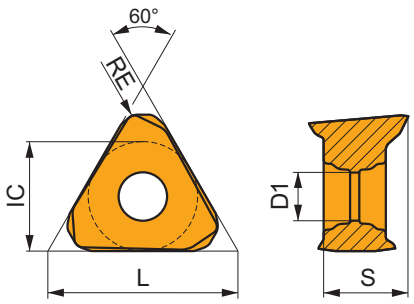
GI340	TNGX 1606..

		Nm								
C0382	US 44010-T15P	3.5	M 4	10	–	–	Flag T15P	–	–	–
C0384	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	–	HS 90835	–	–
C0386	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	–	HS 1030C	–	–
C0388	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	–	HS 1230C	–	–
C0390	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	–	–	–	–
C0394	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	–	HS 1240C	HSD 0825C	CAC 160C

TNGX 16

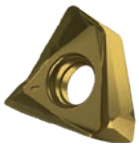
PRAMET

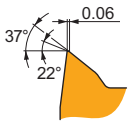
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.525	4.40	16.50	6.58



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

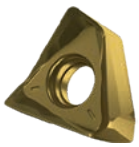
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
TNGX 160604SR-F:M8330	●	0.4	205	0.10	3.0	120	0.09	3.0	190	0.10	3.0	–	–	–	–	–	–	–	–	–
TNGX 160604SR-F:M8340	●	0.4	190	0.10	3.0	110	0.09	3.0	180	0.10	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-F:8215	●	0.8	250	0.10	3.0	150	0.09	3.0	235	0.10	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-F:M6330	●	0.8	215	0.10	3.0	150	0.09	3.0	–	–	–	–	–	–	–	–	–	–	–	–
TNGX 160608SR-F:M8310	●	0.8	280	0.10	3.0	140	0.09	3.0	265	0.10	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-F:M8330	●	0.8	245	0.10	3.0	145	0.09	3.0	230	0.10	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-F:M8340	●	0.8	225	0.10	3.0	135	0.09	3.0	210	0.10	3.0	–	–	–	–	–	–	–	–	–

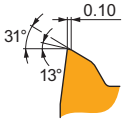




F 型，具有大正前角设计，适用于轻载加工。

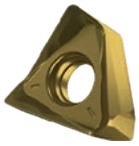
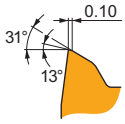
TNGX 160604SR-M:8215	●	0.4	180	0.18	3.0	105	0.16	3.0	170	0.18	3.0	–	–	–	45	0.13	2.4	–	–	–
TNGX 160604SR-M:M6330	●	0.4	155	0.18	3.0	110	0.16	3.0	–	–	–	–	–	–	45	0.13	2.4	–	–	–
TNGX 160604SR-M:M8310	●	0.4	205	0.15	3.0	100	0.14	3.0	190	0.15	3.0	–	–	–	–	–	–	–	–	–
TNGX 160604SR-M:M8330	●	0.4	180	0.18	3.0	105	0.16	3.0	170	0.18	3.0	–	–	–	45	0.13	2.4	–	–	–





M 型，具有前角设计，适用于轻载到中等加工。

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

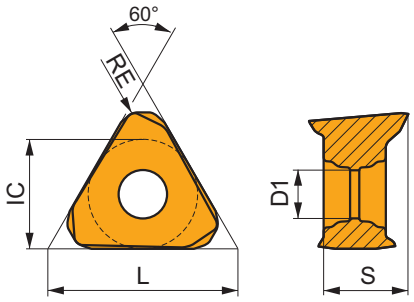
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
TNGX 160604SR-M:M8340	●	0.4	165	0.18	3.0	95	0.16	3.0	155	0.18	3.0	–	–	–	40	0.13	2.4	–	–	–
TNGX 160608SR-M:8215	⇕	0.8	215	0.18	3.0	125	0.16	3.0	200	0.18	3.0	–	–	–	50	0.13	2.4	–	–	–
TNGX 160608SR-M:M6330	⇕	0.8	185	0.18	3.0	130	0.16	3.0	–	–	–	–	–	–	55	0.13	2.4	–	–	–
TNGX 160608SR-M:M8310	●	0.8	245	0.15	3.0	120	0.14	3.0	230	0.15	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-M:M8330	⇕	0.8	215	0.18	3.0	125	0.16	3.0	200	0.18	3.0	–	–	–	50	0.13	2.4	–	–	–
TNGX 160608SR-M:M8340	⇕	0.8	195	0.18	3.0	115	0.16	3.0	185	0.18	3.0	–	–	–	45	0.13	2.4	–	–	–
TNGX 160608SR-M:M8345	⇕	0.8	155	0.18	3.0	90	0.16	3.0	–	–	–	–	–	–	35	0.13	2.4	–	–	–
TNGX 160608SR-M:M9325	●	0.8	285	0.15	3.0	–	–	–	270	0.15	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-M:M9340	⇕	0.8	245	0.18	3.0	145	0.16	3.0	–	–	–	–	–	–	60	0.13	2.4	–	–	–
TNGX 160612SR-M:M8330	⇕	1.2	230	0.18	3.0	135	0.16	3.0	215	0.18	3.0	–	–	–	55	0.13	2.4	–	–	–
TNGX 160612SR-M:M8340	⇕	1.2	205	0.18	3.0	120	0.16	3.0	190	0.18	3.0	–	–	–	50	0.13	2.4	–	–	–
TNGX 160616SR-M:M8310	⇕	1.6	275	0.15	3.0	140	0.14	3.0	260	0.15	3.0	–	–	–	–	–	–	–	–	–
TNGX 160616SR-M:M8330	⇕	1.6	240	0.18	3.0	140	0.16	3.0	225	0.18	3.0	–	–	–	60	0.13	2.4	–	–	–
TNGX 160616SR-M:M8340	⇕	1.6	220	0.18	3.0	130	0.16	3.0	205	0.18	3.0	–	–	–	55	0.13	2.4	–	–	–

M 型，具有前角设计，适用于轻载到中等加工。

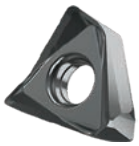
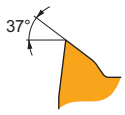
TNGX 16-FA

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.525	4.40	16.50	6.58



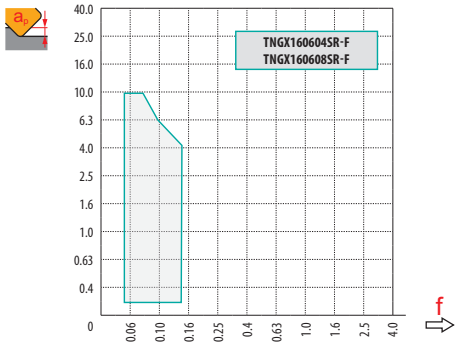
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

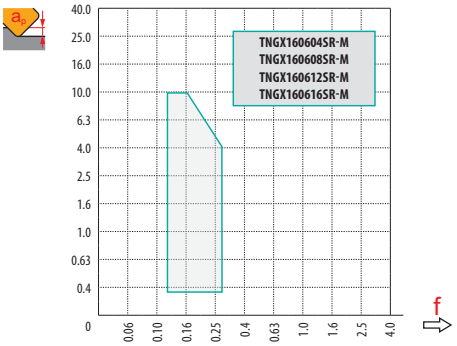
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
TNGX 160604FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	255	0.14	2.0	–	–	–	–	–	–
TNGX 160604FR-FA:M0315	●	0.4	–	–	–	–	–	–	–	–	–	585	0.14	2.0	–	–	–	–	–	–
TNGX 160608FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	300	0.14	2.0	–	–	–	–	–	–
TNGX 160608FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	690	0.14	2.0	–	–	–	–	–	–

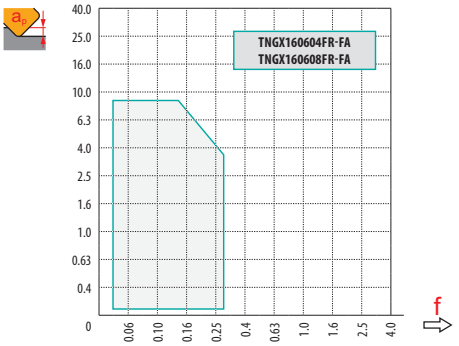
FA 型，具有大正前角设计，适用于精加工到中等加工。

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TNGX 16-F		TNGX 16-M				TNGX 16-FA	
RE	0.4	0.8	0.4	0.8	1.2	1.6	0.4	0.8
BS	2.10	1.9	2.10	1.90	1.73	1.14	2.10	1.90



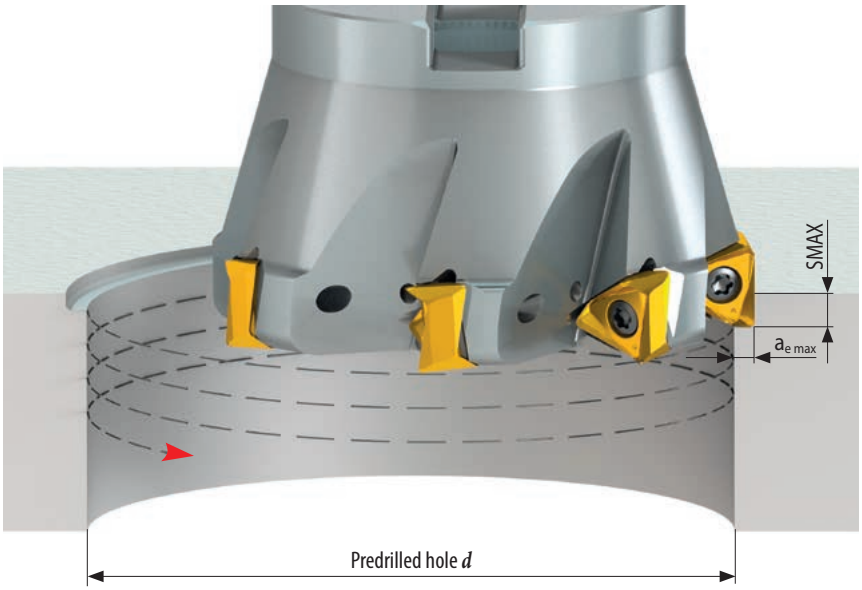




a_p	3.0	4.5	6.0
1 ⇨ f	0.18	0.14	0.10

DC	min	d_{min} = DC *		d = 1.25 DC		d = 1.5 DC		d = 1.75 DC		d ≥ 2 DC	
		SMAX	$a_{e\,max}$	SMAX	$a_{e\,max}$	SMAX	$a_{e\,max}$	SMAX	$a_{e\,max}$	SMAX	$a_{e\,max}$
25	25	0.14	1.3	31	0.22	2.2	38	0.33	3.0	44	0.60	4.0	50	0.70	5.0
32	32	0.16	1.5	40	0.33	2.8	48	0.44	4.0	56	0.70	5.0	64	0.90	6.5
40	40	0.22	2.0	50	0.38	3.5	60	0.55	5.0	70	0.90	6.5	80	1.15	8.0
50	50	0.27	2.5	63	0.50	4.5	75	0.70	6.5	88	1.00	8.0	100	1.40	10.0
63	63	0.33	3.2	80	0.60	5.5	95	0.90	8.0	110	1.45	10.0	125	1.80	12.5
80	80	0.55	4.0	100	1.00	7.0	120	1.45	10.0	140	2.15	13.0	160	2.60	16.0
100	100	0.70	5.0	125	1.20	9.0	150	1.80	12.5	175	2.70	16.5	200	3.30	20.0
115	115	0.85	6.0	145	1.50	10.0	175	1.90	14.5	200	2.80	19.0	230	3.80	23.0
125	125	0.90	6.5	155	1.60	11.0	190	2.30	15.5	220	3.10	20.0	250	4.10	25.0
140	140	1.00	7.0	175	1.80	12.5	210	2.60	17.5	245	3.70	23.0	280	4.60	28.0
160	160	1.20	8.0	200	2.00	14.0	240	2.90	20.0	280	4.30	26.0	320	5.30	32.0
175	175	1.30	8.8	220	2.20	15.5	265	3.20	22.0	305	4.70	29.0	350	5.80	35.0

* Check feed rate reduction when hole diameter is between d_{min} - 1.5 *DC*.



SLN12

P M K N

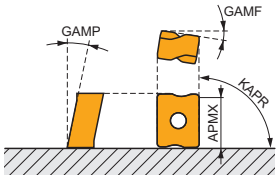
PRAMET

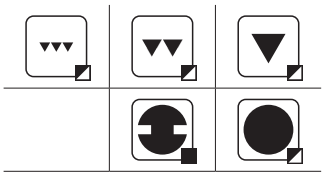
S

ECON LN12带内冷的方肩铣刀

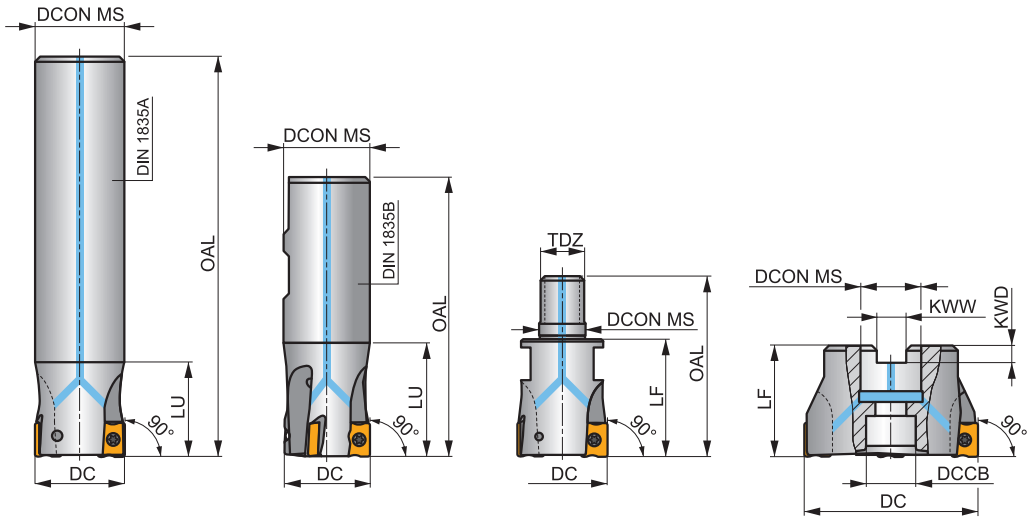
90⊠方肩铣刀和面铣刀，使用双面LN..　12刀片，具有APMX(最大切深)9mm。应用范围广泛。可提供圆柱柄，侧固柄，模块夹紧系统和芯轴式(具有不等齿距)类型。刀体经过处理，使用寿命更长。

KAPR	90°
APMX	9.0 mm

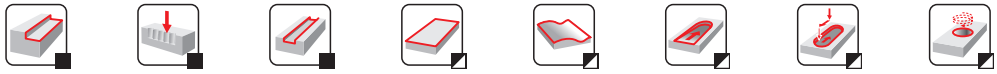




ECON LN



h_m	0.06 - 0.15
h_m	0.06 - 0.13



	产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	25A2R034A25-SLN12-C	25	170	25	–	34	–	–	–	–	-23	-8	2	–	19500	✓	0.58	GI205	SQ340	–
	25A2R080A25-SLN12-C	25	170	25	–	80	–	–	–	–	-23	-8	2	–	19500	✓	0.54	GI205	SQ340	–
	32A2R034A32-SLN12-C	32	195	32	–	34	–	–	–	–	-15	-6	2	–	17300	✓	1.05	GI205	SQ340	–
	32A2R090A32-SLN12-C	32	195	32	–	90	–	–	–	–	-15	-6	2	–	17300	✓	0.98	GI205	SQ340	–
DIN 1835B	25A2R042B25-SLN12-C	25	99	25	–	42	–	–	–	–	-23	-8	2	–	19500	✓	0.30	GI205	SQ340	–
	32A3R042B32-SLN12-C	32	103	32	–	42	–	–	–	–	-15	-6	3	–	17300	✓	0.50	GI205	SQ340	–
	40A4R050B32-SLN12-C	40	111	32	–	50	–	–	–	–	-15	-6	4	✓	15500	✓	0.62	GI205	SQ340	–
MODULAR	25A2R033M12-SLN12-C	25	55	12.5	–	–	33	–	–	–	-22	-6	2	–	–	✓	0.11	GI205	SQ340	–
	32A2R043M16-SLN12-C	32	66	17	–	–	43	–	–	–	-15	-6	2	–	–	✓	0.22	GI205	SQ340	–
	32A3R043M16-SLN12-C	32	66	17	–	–	43	–	–	–	-15	-6	3	–	–	✓	0.22	GI205	SQ340	–
	40A3R043M16-SLN12-C	40	66	17	–	–	43	–	–	–	-15	-6	3	–	–	✓	0.28	GI205	SQ340	–
ISO 6462 DIN 8030	40A04R-S90LN12-C	40	–	16	14	–	40	–	8.4	5.6	-15	-6	4	✓	15500	✓	0.33	GI205	SQ342	–
	50A04R-S90LN12-C	50	–	22	18	–	40	–	10.4	6.3	-14.5	-6	4	✓	13800	✓	0.47	GI205	SQ343	–
	50A05R-S90LN12-C	50	–	22	18	–	40	–	10.4	6.3	-14.5	-6	5	✓	13800	✓	0.40	GI205	SQ343	–
	63A04R-S90LN12-C	63	–	22	18	–	40	–	10.4	6.3	-14	-6	4	✓	12300	✓	0.55	GI205	SQ343	–
	63A06R-S90LN12-C	63	–	22	18	–	40	–	10.4	6.3	-14	-6	6	✓	12300	✓	0.50	GI205	SQ343	–
	80A05R-S90LN12-C	80	–	27	38	–	50	–	12.4	7	-14	-6	5	✓	10900	✓	1.16	GI205	SQ341	AC001
	80A07R-S90LN12-C	80	–	27	38	–	50	–	12.4	7	-14	-6	7	✓	10900	✓	1.11	GI205	SQ341	AC001
	100A06R-S90LN12-C	100	–	32	45	–	50	–	14.4	8	-14	-6	6	✓	9800	✓	1.78	GI205	SQ341	AC002
	100A08R-S90LN12-C	100	–	32	45	–	50	–	14.4	8	-14	-6	8	✓	9800	✓	1.93	GI205	SQ341	AC002
	110A06R-S90LN12-C	110	–	32	45	–	50	–	14.4	8	-14	-6	6	✓	9300	✓	2.09	GI205	SQ341	AC002
	125A07R-S90LN12-C	125	–	40	56	–	63	–	16.4	9	-14	-6	7	✓	8700	✓	3.40	GI205	SQ341	AC003
	125A09R-S90LN12-C	125	–	40	56	–	63	–	16.4	9	-14	-6	9	✓	8700	✓	3.35	GI205	SQ341	AC003

GI205	LNGX 1205..	LNGU 1205..

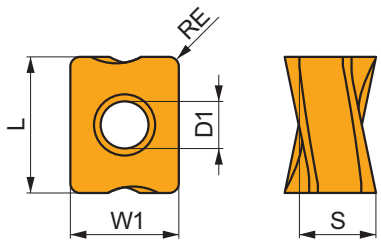
		Nm						
SQ340	US 44012-T15P	3.5	M 4	12	–	–	Flag T15P	–
SQ341	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–
SQ342	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 0830C
SQ343	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

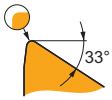
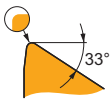
LNGX 12

PRAMET

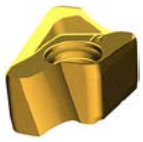
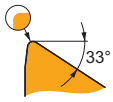
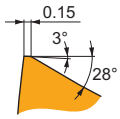
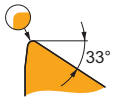
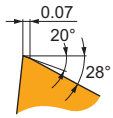
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1205	9.500	4.50	12.00	5.96



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F 型，具有大正前角设计，适用于轻载加工。																				
LNGX 120504ER-F:8215	●	0.4	200	0.15	1.5	–	–	–	190	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120504ER-F:M8330	●	0.4	200	0.15	1.5	–	–	–	190	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120504ER-F:M8340	●	0.4	180	0.15	1.5	–	–	–	170	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120508ER-F:8215	⬌	0.8	240	0.15	1.5	–	–	–	225	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120508ER-F:M8310	⬌	0.8	260	0.15	1.5	–	–	–	245	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120508ER-F:M8330	⬌	0.8	235	0.15	1.5	–	–	–	220	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120508ER-F:M8340	⬌	0.8	215	0.15	1.5	–	–	–	200	0.15	1.5	–	–	–	–	–	–	–	–	–
																				
M 型，具有前角设计，适用于轻载到中等加工。																				
LNGX 120504ER-M:M8330	●	0.4	185	0.15	3.0	–	–	–	175	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120504ER-M:M8340	⬌	0.4	170	0.15	3.0	–	–	–	160	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:8215	⬌	0.8	220	0.15	3.0	–	–	–	205	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M8310	⬌	0.8	240	0.15	3.0	–	–	–	225	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M8330	⬌	0.8	220	0.15	3.0	–	–	–	205	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M8340	⬌	0.8	200	0.15	3.0	–	–	–	190	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M9315	⬌	0.8	300	0.15	3.0	–	–	–	285	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M9325	⬌	0.8	280	0.15	3.0	–	–	–	265	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M9340	⬌	0.8	250	0.15	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120510ER-M:M8330	⬌	1.0	230	0.15	3.0	–	–	–	215	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120512ER-M:M8330	⬌	1.2	230	0.15	3.0	–	–	–	215	0.15	3.0	–	–	–	–	–	–	–	–	–

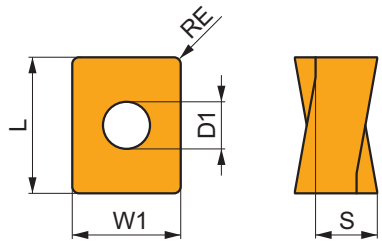
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
M 型，具有前角设计，适用于轻载到中等加工。																				
LNGX 120512ER-M:M8340	✱	1.2	■	210	0.15	3.0	–	–	–	◪	195	0.15	3.0	–	–	–	–	–	–	–	–	–	–
LNGX 120516ER-M:M8330	⚙	1.6	■	240	0.15	3.0	–	–	–	■	225	0.15	3.0	–	–	–	–	–	–	–	–	–	–
LNGX 120516ER-M:M8340	✱	1.6	■	220	0.15	3.0	–	–	–	◪	205	0.15	3.0	–	–	–	–	–	–	–	–	–	–
LNGX 120520ER-M:M8310	⚙	2.0	■	280	0.15	3.0	–	–	–	■	265	0.15	3.0	–	–	–	–	–	–	–	–	–	–
LNGX 120520ER-M:M8330	✱	2.0	■	255	0.15	3.0	–	–	–	■	240	0.15	3.0	–	–	–	–	–	–	–	–	–	–
LNGX 120520ER-M:M8340	✱	2.0	■	230	0.15	3.0	–	–	–	◪	215	0.15	3.0	–	–	–	–	–	–	–	–	–	–
																				
R 型，具有正前角设计，适用于不稳定的工况。																				
LNGX 120508SR-R:8215	⚙	0.8	■	205	0.20	3.5	–	–	–	■	190	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M5315	⚙	0.8	◪	265	0.20	3.5	–	–	–	■	250	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M8310	⚙	0.8	■	220	0.20	3.5	–	–	–	■	205	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M8330	⚙	0.8	■	205	0.20	3.5	–	–	–	■	190	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M8340	✱	0.8	■	185	0.20	3.5	–	–	–	◪	175	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M9315	⚙	0.8	■	265	0.20	3.5	–	–	–	■	250	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M9325	⚙	0.8	■	250	0.20	3.5	–	–	–	■	235	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M9340	⚙	0.8	■	225	0.20	3.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120516SR-R:8215	✱	1.6	■	225	0.20	3.5	–	–	–	■	210	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNGX 120516SR-R:M8330	✱	1.6	■	225	0.20	3.5	–	–	–	■	210	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNGX 120516SR-R:M8340	✱	1.6	■	205	0.20	3.5	–	–	–	◪	190	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNGX 120516SR-R:M9325	⚙	1.6	■	275	0.20	3.5	–	–	–	■	260	0.20	3.5	–	–	–	–	–	–	–	–	–	–
																				
MF 型，具有大正前角设计，适用于轻载加工。																				
LNGX 120504ER-MF:M6330	●	0.4	◪	175	0.15	1.0	■	125	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120504ER-MF:M9340	●	0.4	◪	240	0.15	1.0	■	140	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508ER-MF:M6330	⚙	0.8	◪	210	0.15	1.0	■	150	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508ER-MF:M8340	⚙	0.8	◪	225	0.15	1.0	■	135	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508ER-MF:M9340	⚙	0.8	◪	285	0.15	1.0	■	170	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
MM 型，具有前角设计，适用于轻载到中等加工。																				
LNGX 120508SR-MM:M6330	✱	0.8	■	190	0.15	2.8	■	135	0.14	2.8	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-MM:M8340	✱	0.8	■	200	0.15	2.8	■	120	0.14	2.8	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-MM:M8345	✱	0.8	■	160	0.15	2.8	■	95	0.14	2.8	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-MM:M9340	⚙	0.8	■	255	0.15	2.8	■	150	0.14	2.8	–	–	–	–	–	–	–	–	–	–	–	–	–

LNGU 12

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1205	9.500	4.50	12.00	5.96



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

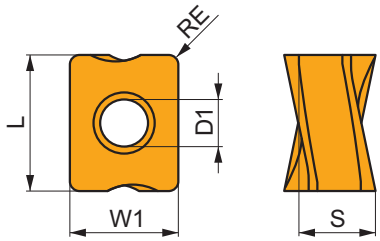
产品	● ✱ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
LNGU 120525ER-M:M8330	✱	2.5	■ 255	0.15	3.0	–	–	–	■ 240	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGU 120525ER-M:M8340	✱	2.5	■ 230	0.15	3.0	–	–	–	◪ 215	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGU 120530ER-M:M8330	✱	3.0	■ 255	0.15	3.0	–	–	–	■ 240	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGU 120530ER-M:M8340	✱	3.0	■ 230	0.15	3.0	–	–	–	◪ 215	0.15	3.0	–	–	–	–	–	–	–	–	–

M 型，具有正前角设计，适用于中等加工。

LNGX 12-FA

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1205	9.500	4.50	12.00	5.96



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

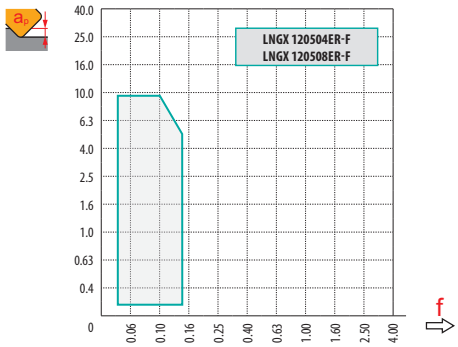
产品	● ✱ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
LNGX 120504FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 270	0.30	2.0	–	–	–	–	–	–
LNGX 120508FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 315	0.30	2.0	–	–	–	–	–	–
LNGX 120508FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 720	0.30	2.0	–	–	–	–	–	–

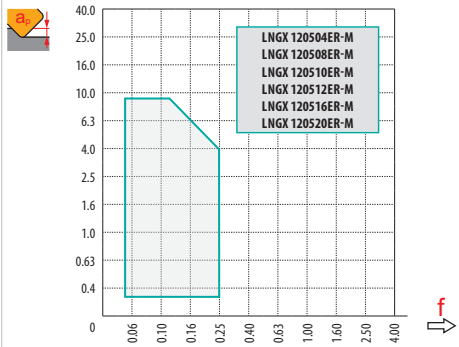
FA 型，具有大正前角设计，适用于精加工到中等加工。

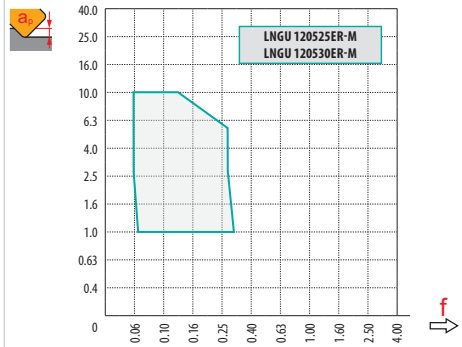
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

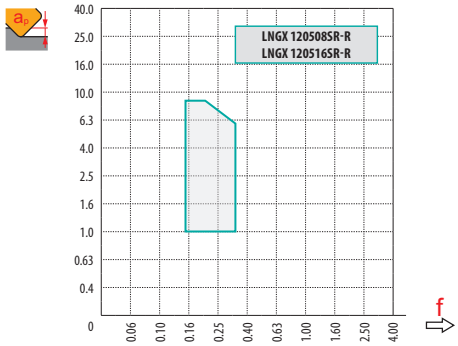
	LNGX 12-F		LNGX 12-M						LNGU 12-M	
RE	0.4	0.8	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0
BS	2.29	1.89	2.29	1.89	1.69	1.49	1.09	0.68	0.87	0.36

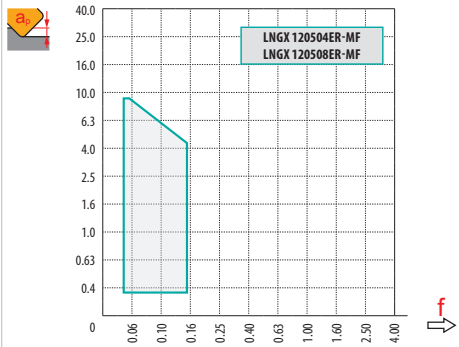
	LNGX 12-R		LNGX 12-MF		LNGX 12-MM	LNGX 12-FA	
RE	0.8	1.6	0.4	0.8	0.8	0.4	0.8
BS	1.88	1.08	2.28	1.88	1.88	2.30	1.89

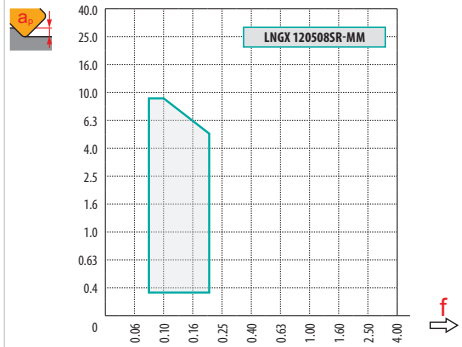


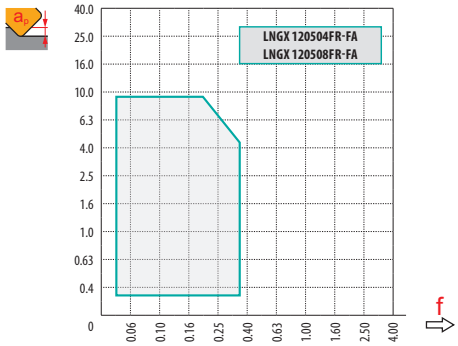












max
3.5

a_p	1.0	5.0	9.0
f	0.19	0.13	0.08

LNGX 12		
DC	RPMX	APMX/I
25	1.3°	2.1/100
32	0.7°	1.1/100
40	0.5°	0.7/100
50	0.4°	0.5/100
63	0.2°	0.3/100
80	0.2°	0.2/100

LNGX 12				
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	35.0	50.0	0.7	1.7
32	49.0	64.0	0.6	1.2
40	65.0	80.0	0.6	1.0
50	85.0	100.0	0.7	1.0
63	111.0	126.0	0.6	0.8
80	145.0	160.0	0.7	0.8

a_p
0.2

DC	µm	3	5	10	15	20	30	40	50	60	80	100
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

RE	µm	3	5	10	15	20	30	40	50	60	80	100
1.6	FE	0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.5		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549

SLN16

P K N H

PRAMET

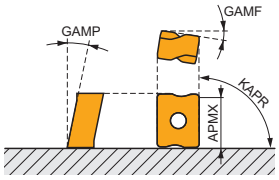
S

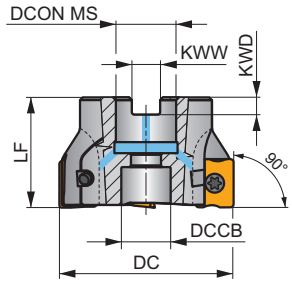
ECON LN16带内冷的方肩铣刀

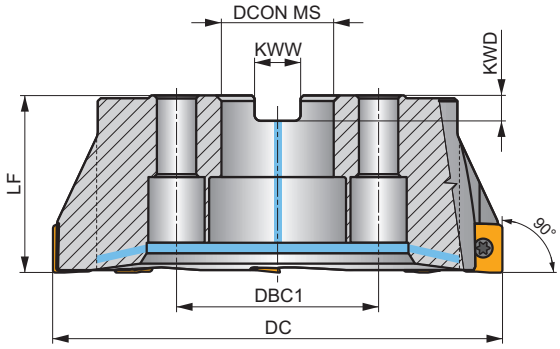
90⊠面铣，使用双面LN..　16刀片，具有APMX(最大切深)13mm。应用范围广泛。可提供芯轴式类型，具有不等齿距。刀体经过处理，使用寿命更长。

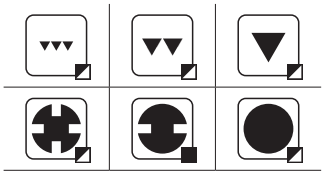
ECON LN

KAPR	90°
APMX	13.0 mm









h_m 0.08 - 0.2

	产品	DC (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	63A04R-S90LN16-C	63	40	22	18	–	10.4	6.3	-10.5	-6	4	✓	7600	✓	0.46	GI207	SQ353	–
	63A05R-S90LN16-C	63	40	22	18	–	10.4	6.3	-10.5	-6	5	✓	7600	✓	0.46	GI207	SQ353	–
	80A04R-S90LN16-C	80	50	27	38	–	12.4	7	-10.5	-6	4	✓	6800	✓	0.98	GI207	SQ351	AC001
	80A06R-S90LN16-C	80	50	27	38	–	12.4	7	-10.5	-6	6	✓	6800	✓	0.89	GI207	SQ351	AC001
	100A05R-S90LN16-C	100	50	32	45	–	14.4	8	-10.5	-6	5	✓	6100	✓	0.98	GI207	SQ351	AC002
	100A07R-S90LN16-C	100	50	32	45	–	14.4	8	-10.5	-6	7	✓	6100	✓	1.78	GI207	SQ351	AC002
	125A06R-S90LN16-C	125	63	40	56	–	16.4	9	-10.5	-6	6	✓	5400	✓	3.39	GI207	SQ351	AC003
	125A08R-S90LN16-C	125	63	40	56	–	16.4	9	-10.5	-6	8	✓	5400	✓	3.28	GI207	SQ351	AC003
	140A06R-S90LN16-C	140	63	40	56	–	16.4	9	-10.5	-6	6	✓	5100	✓	3.91	GI207	SQ351	AC003
	160C08R-S90LN16-C	160	63	40	–	66.7	16.4	9	-10.5	-6	8	✓	4700	✓	6.19	GI207	SQ356	–
	175C08R-S90LN16-C	175	63	40	–	66.7	16.4	9	-10.5	-6	8	✓	4500	✓	7.11	GI207	SQ356	–

GI207	LNMU 1607..	LNGU 1607..

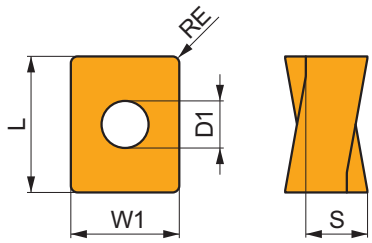
		Nm							
SQ351	US 45012-T20P	5.0	M 5	12	SDR T20P-T	–	–	–	–
SQ353	US 45012-T20P	5.0	M 5	12	SDR T20P-T	HS 1030C	–	–	–
SQ356	US 45012-T20P	5.0	M 5	12	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

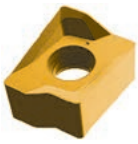
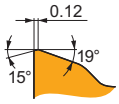
LNGU 16

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1607	13.200	5.70	16.60	7.50



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

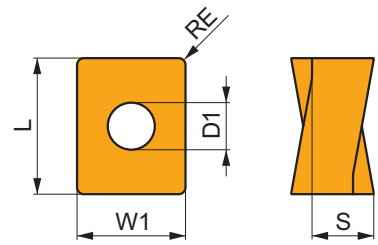
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
LNGU 160708SR-M:8215		0.8	200	0.18	5.0	–	–	–	190	0.18	5.0	–	–	–	–	–	–	40	0.12	1.0
LNGU 160708SR-M:M8340		0.8	180	0.18	5.0	–	–	–	170	0.18	5.0	–	–	–	–	–	–	–	–	–
LNGU 160708SR-M:M9315		0.8	265	0.18	5.0	–	–	–	250	0.18	5.0	–	–	–	–	–	–	50	0.12	1.0
LNGU 160708SR-M:M9325		0.8	250	0.18	5.0	–	–	–	235	0.18	5.0	–	–	–	–	–	–	50	0.12	1.0

M 型，具有大正前角设计，适用于中等加工。

LNMU 16

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1607	13.200	5.70	16.60	7.50

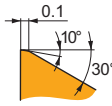
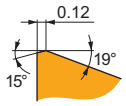


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
LNMU 160708ER-F:M8330		0.8	230	0.16	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNMU 160708ER-F:M8340		0.8	210	0.16	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

F 型，具有大正前角设计，适用于轻载加工。

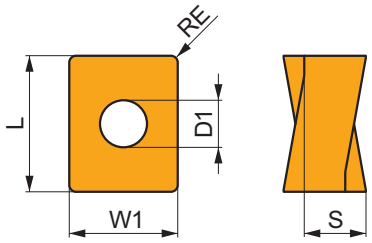
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
M 型，具有正前角设计，适用于中等加工。																				
LNMU 160708SR-M:8215		0.8	■	200	0.18	5.0	–	–	–	■	190	0.18	5.0	–	–	–	–	–	–	–	–	–	–
LNMU 160708SR-M:M6330		0.8	■	170	0.18	5.0	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–	–
LNMU 160708SR-M:M8330		0.8	■	200	0.18	5.0	–	–	–	■	190	0.18	5.0	–	–	–	–	–	–	–	–	–	–
LNMU 160708SR-M:M8340		0.8	■	180	0.18	5.0	–	–	–	◪	170	0.18	5.0	–	–	–	–	–	–	–	–	–	–
LNMU 160708SR-M:M9325		0.8	■	250	0.18	5.0	–	–	–	■	235	0.18	5.0	–	–	–	–	–	–	–	–	–	–
LNMU 160720SR-M:M8330		2.0	■	230	0.18	5.0	–	–	–	■	215	0.18	5.0	–	–	–	–	–	–	–	–	–	–
LNMU 160720SR-M:M8340		2.0	■	210	0.18	5.0	–	–	–	◪	195	0.18	5.0	–	–	–	–	–	–	–	–	–	–
LNMU 160730SR-M:M8330		3.0	■	230	0.18	5.0	–	–	–	■	215	0.18	5.0	–	–	–	–	–	–	–	–	–	–
LNMU 160730SR-M:M8340		3.0	■	210	0.18	5.0	–	–	–	◪	195	0.18	5.0	–	–	–	–	–	–	–	–	–	–
LNMU 160740SR-M:M8340		4.0	■	210	0.18	5.0	–	–	–	◪	195	0.18	5.0	–	–	–	–	–	–	–	–	–	–
																				
R 型，具有正前角稳定设计，适用于中等加工。																				
LNMU 160708SR-R:M5315		0.8	◪	265	0.18	6.3	–	–	–	■	250	0.18	6.3	–	–	–	–	–	–	◪	50	0.12	1.0
LNMU 160708SR-R:M8330		0.8	■	195	0.18	6.3	–	–	–	■	185	0.18	6.3	–	–	–	–	–	–	◪	35	0.12	1.0
LNMU 160708SR-R:M8340		0.8	■	175	0.18	6.3	–	–	–	◪	165	0.18	6.3	–	–	–	–	–	–		–	–	–
LNMU 160708SR-R:M9315		0.8	■	260	0.18	6.3	–	–	–	■	245	0.18	6.3	–	–	–	–	–	–	◪	50	0.12	1.0
LNMU 160708SR-R:M9325		0.8	■	240	0.18	6.3	–	–	–	■	225	0.18	6.3	–	–	–	–	–	–	◪	45	0.12	1.0
LNMU 160716SR-R:M8330		1.6	■	215	0.18	6.3	–	–	–	■	200	0.18	6.3	–	–	–	–	–	–	◪	40	0.12	1.1
LNMU 160716SR-R:M8340		1.6	■	195	0.18	6.3	–	–	–	◪	185	0.18	6.3	–	–	–	–	–	–		–	–	–
LNMU 160716SR-R:M9315		1.6	■	285	0.18	6.3	–	–	–	■	270	0.18	6.3	–	–	–	–	–	–	◪	55	0.12	1.1
LNMU 160716SR-R:M9325		1.6	■	265	0.18	6.3	–	–	–	■	250	0.18	6.3	–	–	–	–	–	–	◪	50	0.12	1.1

LNGU 16-FA

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1607	13.200	5.70	16.60	7.50

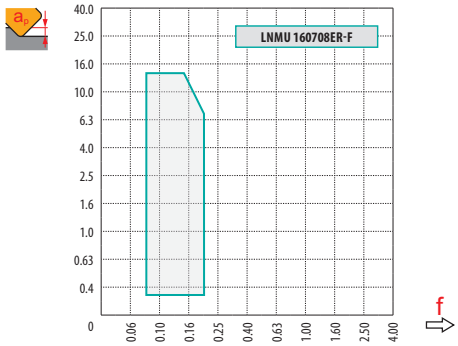


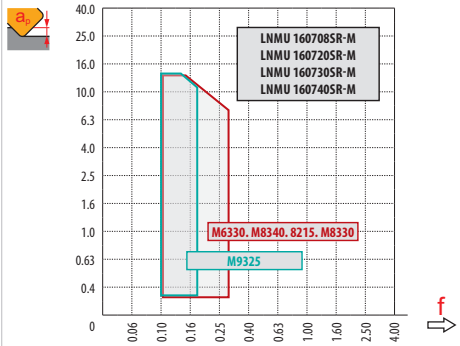
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

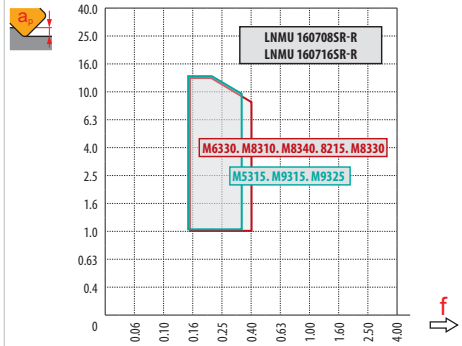
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
FA 型，具有大正前角设计，适用于精加工到中等加工。																				
LNGU 160708FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■	300	0.30	3.0	–	–	–	–	–	–

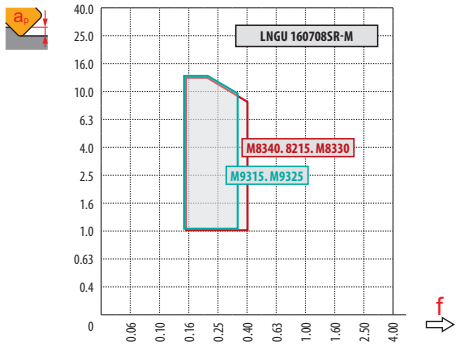
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

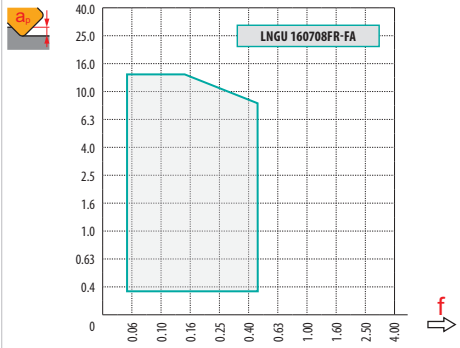
	LNMU 16-F	LNMU 16-M				LNMU 16-R		LNGU 16-M	LNGU 16-FA
RE	0.8	0.8	2.0	3.0	4.0	0.8	1.6	0.8	0.8
BS	3.30	3.30	2.11	1.12	0.10	3.30	2.50	3.24	3.30











max.

7.0

a_p	1.0	6.0	13.0
⇨ f	0.31	0.24	0.13

SLN12X

P K H

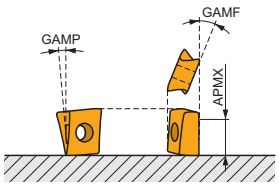
PRAMET

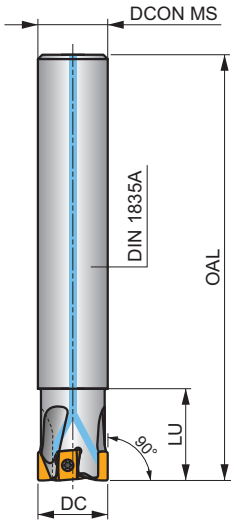
S

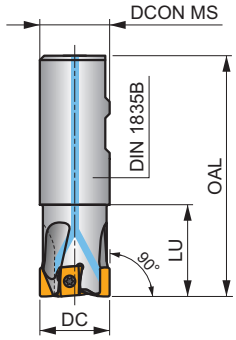
PROD LN12 90°立装方肩铣刀，具有内冷通道

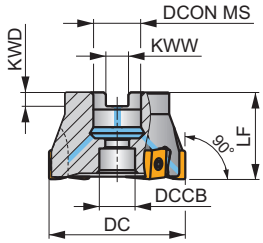
高生产力的90°方肩铣刀，采用LNEX 12立装刀片，具有4个切削刃和最大切深10mm。应用范围非常广泛。可提供圆柄式、侧固式和芯轴式刀柄。坚固的刀杆延长了刀具寿命，并提供出色的抗断裂能力。

KAPR	90°
APMX	10.0 mm









h_m	0.06 - 0.18
h_m	0.06 - 0.20

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	25A2R042A25-SLN12X-C	25	170	25	–	42	–	–	–	-30	-5	2	–	17300	✓	0.55	GI206	C0382
	25A2R080A25-SLN12X-C	25	170	25	–	80	–	–	–	-30	-5	2	–	17300	✓	0.50	GI206	C0382
	32A3R042A32-SLN12X-C	32	195	32	–	42	–	–	–	-22.5	-5	3	–	15300	✓	1.08	GI206	SQ340
	32A3R090A32-SLN12X-C	32	195	32	–	90	–	–	–	-22.5	-5	3	–	15300	✓	1.02	GI206	SQ340
	40A4R050A32-SLN12X-C	40	195	32	–	50	–	–	–	-22.5	-5	4	–	13700	✓	1.17	GI206	SQ340
DIN 1835B	25A2R042B25-SLN12X-C	25	100	25	–	42	–	–	–	-30	-5	2	–	17300	✓	0.29	GI206	C0382
	32A3R042B32-SLN12X-C	32	110	32	–	42	–	–	–	-22.5	-5	3	–	15300	✓	0.58	GI206	SQ340
	40A4R050B32-SLN12X-C	40	120	32	–	50	–	–	–	-22.5	-5	4	–	13700	✓	0.73	GI206	SQ340
ISO 6462 DIN 8030	40A03R-S90LN12X-C	40	–	16	12.4	–	40	8.4	5.6	-22.5	-5	3	–	13700	✓	0.15	GI206	SQ345
	40A04R-S90LN12X-C	40	–	16	12.4	–	40	8.4	5.6	-22.5	-5	4	✓	13700	✓	0.23	GI206	SQ345
	50A05R-S90LN12X-C	50	–	22	16.5	–	40	10.4	6.3	-19.5	-5	5	–	12300	✓	0.34	GI206	SQ343
	50A06R-S90LN12X-C	50	–	22	16.5	–	40	10.4	6.3	-19.5	-5	6	–	12300	✓	0.34	GI206	SQ343
	52A05R-S90LN12X-C	52	–	22	16.5	–	40	10.4	6.3	-19.5	-5	5	–	12300	✓	0.37	GI206	SQ343
	63A06R-S90LN12X-C	63	–	22	16.5	–	40	10.4	6.3	-19.5	-5	6	✓	10900	✓	0.61	GI206	SQ343
	63A08R-S90LN12X-C	63	–	22	16.5	–	40	10.4	6.3	-19.5	-5	8	–	10900	✓	0.50	GI206	SQ343
	66A06R-S90LN12X-C	66	–	22	16.5	–	40	10.4	6.3	-19.5	-5	6	✓	10900	✓	0.54	GI206	SQ343
	80A07R-S90LN12X-C	80	–	27	38.1	–	50	12.4	7	-19.5	-5	7	✓	9700	✓	1.00	GI206	SQ341
	80A10R-S90LN12X-C	80	–	27	38.1	–	50	12.4	7	-19.5	-5	10	–	9700	✓	0.98	GI206	SQ341
	100A08R-S90LN12X-C	100	–	32	45.1	–	50	14.4	8	-17.5	-5	8	✓	8700	✓	1.90	GI206	SQ341
	100A11R-S90LN12X-C	100	–	32	45.1	–	50	14.4	8	-17.5	-5	11	–	8700	✓	1.88	GI206	SQ341
	125A12R-S90LN12X-C	125	–	40	56.1	–	63	16.4	9	-17.5	-5	12	✓	7800	✓	3.39	GI206	SQ341

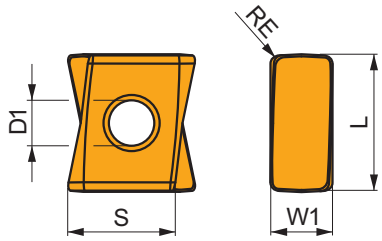
GI206	LNEX 1210..

		Nm						
C0382	US 44010-T15P	3.5	M 4	10	–	–	Flag T15P	–
SQ340	US 44012-T15P	3.5	M 4	12	–	–	Flag T15P	–
SQ341	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–
SQ343	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 1030C
SQ345	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 90835

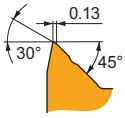
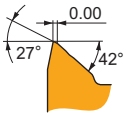
LNEX 12

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1210	6.000	4.40	13.30	10.26

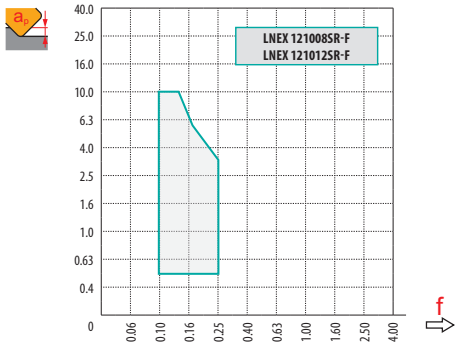


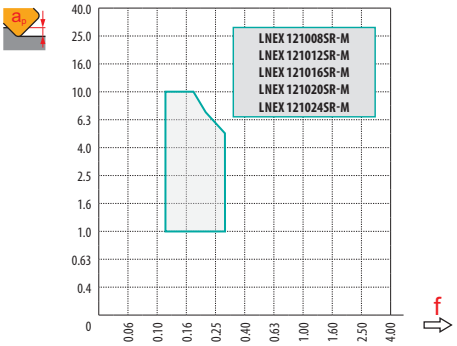
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F 型非常锋利，用于轻载加工和中等加工，适合大悬伸应用。大正前角设计，窄T-型倒棱和圆角切削刃，用于轻载加工到中等加工。																				
LNEX 121008SR-F:M6330		0.8	220	0.17	3.0	155	0.15	3.0	–	–	–	–	–	–	–	–	–	–	–	–
LNEX 121008SR-F:M8310		0.8	280	0.17	3.0	140	0.15	3.0	265	0.17	3.0	–	–	–	–	–	–	55	0.11	1.0
LNEX 121008SR-F:M8330		0.8	260	0.17	3.0	155	0.15	3.0	245	0.17	3.0	–	–	–	–	–	–	50	0.11	1.0
LNEX 121008SR-F:M8340		0.8	235	0.17	3.0	140	0.15	3.0	220	0.17	3.0	–	–	–	–	–	–	–	–	–
LNEX 121012SR-F:M6330		1.2	230	0.17	3.0	165	0.15	3.0	–	–	–	–	–	–	–	–	–	–	–	–
LNEX 121012SR-F:M8310		1.2	295	0.17	3.0	150	0.15	3.0	280	0.17	3.0	–	–	–	–	–	–	55	0.11	1.0
LNEX 121012SR-F:M8330		1.2	270	0.17	3.0	160	0.15	3.0	255	0.17	3.0	–	–	–	–	–	–	50	0.11	1.0
																				
M 型用途广泛，适用于多种加工条件的通用选择。正前角设计，中等T-型倒棱和圆角切削刃，用于中等加工到半粗加工。																				
LNEX 121008SR-M:M6330		0.8	210	0.20	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNEX 121008SR-M:M8310		0.8	265	0.20	3.5	–	–	–	250	0.20	3.5	–	–	–	–	–	–	50	0.16	1.0
LNEX 121008SR-M:M8330		0.8	245	0.20	3.5	–	–	–	230	0.20	3.5	–	–	–	–	–	–	45	0.16	1.0
LNEX 121008SR-M:M8340		0.8	220	0.20	3.5	–	–	–	205	0.20	3.5	–	–	–	–	–	–	–	–	–
LNEX 121008SR-M:M9315		0.8	320	0.20	3.5	–	–	–	300	0.20	3.5	–	–	–	–	–	–	60	0.16	1.0
LNEX 121008SR-M:M9325		0.8	300	0.20	3.5	–	–	–	285	0.20	3.5	–	–	–	–	–	–	60	0.16	1.0
LNEX 121008SR-M:M9340		0.8	270	0.20	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNEX 121012SR-M:M8310		1.2	280	0.20	3.5	–	–	–	265	0.20	3.5	–	–	–	–	–	–	55	0.16	1.0
LNEX 121012SR-M:M8330		1.2	255	0.20	3.5	–	–	–	240	0.20	3.5	–	–	–	–	–	–	50	0.16	1.0
LNEX 121012SR-M:M8340		1.2	235	0.20	3.5	–	–	–	220	0.20	3.5	–	–	–	–	–	–	–	–	–
LNEX 121016SR-M:M8310		1.6	295	0.20	3.5	–	–	–	280	0.20	3.5	–	–	–	–	–	–	55	0.16	1.0
LNEX 121016SR-M:M8330		1.6	270	0.20	3.5	–	–	–	255	0.20	3.5	–	–	–	–	–	–	50	0.16	1.0
LNEX 121016SR-M:M8340		1.6	245	0.20	3.5	–	–	–	230	0.20	3.5	–	–	–	–	–	–	–	–	–
LNEX 121020SR-M:M8330		2.0	285	0.20	3.5	–	–	–	270	0.20	3.5	–	–	–	–	–	–	55	0.16	1.0
LNEX 121020SR-M:M8340		2.0	255	0.20	3.5	–	–	–	240	0.20	3.5	–	–	–	–	–	–	–	–	–
LNEX 121024SR-M:M8330		2.4	285	0.20	3.5	–	–	–	270	0.20	3.5	–	–	–	–	–	–	55	0.16	1.0
LNEX 121024SR-M:M8340		2.4	255	0.20	3.5	–	–	–	240	0.20	3.5	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	LNEX 12-F		LNEX 12-M				
RE	0.8	1.2	0.8	1.2	1.6	2.0	2.4
BS	2.25	1.73	2.25	1.73	1.33	1.15	0.79





max

2.5

a_p	2.0	3.0	4.0	5.0
1 ⇨ f	0.30	0.20	0.20	0.15

DC	RPMX	APMX/I
25	0.80°	1.40/100
32	0.60°	1.00/100
40	0.35°	0.60/100
50	0.30°	0.50/100
52	0.30°	0.50/100
63	0.20°	0.35/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	44.0	48.0	0.6	0.7
32	58.0	62.0	0.8	1.0
40	74.0	78.0	0.7	0.8
50	94.0	98.0	0.7	0.8
52	98.0	102.0	0.7	0.8
63	120.0	124.0	0.3	0.4

DC	µm	3	5	10	15	20	30	40	50	60	80	100
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40	FE	0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
63		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

RE	µm	3	5	10	15	20	30	40	50	60	80	100
0.8		0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.894
1.2		0.170	0.219	0.310	0.379	0.438	0.537	0.620	0.693	0.759	0.876	0.980
1.6	FE	0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.4		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414

可转位铣刀 – 导航工具

平面铣

	SAD07D	SAD11E	SAD16E	SAP10D	SAP16D
	90°	90°	90°	90°	90°
	APMX (mm) 5.0	APMX (mm) 9.0	APMX (mm) 13.0	APMX (mm) 9.0	APMX (mm) 13.0
	DC (mm) 10 – 32	DC (mm) 16 – 125	DC (mm) 25 – 175	DC (mm) 10 – 25	DC (mm) 25 – 125
圆柱刀柄	DC = 10 – 25 (mm)	DC = 16 – 35 (mm)	DC = 25, 32 (mm)		
侧固刀柄		DC = 16 – 32 (mm)	DC = 25 – 40 (mm)	DC = 10 – 25 (mm)	DC = 25 – 40 (mm)
模块式刀柄	DC = 12 – 32 (mm)	DC = 16 – 40 (mm)	DC = 32, 40 (mm)		
套式铣刀		DC = 40 – 125 (mm)	DC = 40 – 175 (mm)		DC = 40 – 125 (mm)
页码	90	97	106	114	117
ISO	P M K N S	P M K N S H	P M K N S H	P M K N S	P M K N S
刀片形状					
刀片	AD.X 0702	AD.X 11T3	AD.X 1606	APKT 1003	AP.T 1604
切削刃数量	2	2	2	2	2
平面铣	■	■	■	■	■
倒角铣	■	■	■	■	■
螺旋插补	■	■	■	■	■
连续钻铣	■	■	■	■	■
坡走铣	■	■	■	■	■
形面铣(仿形铣)	■	■	■	■	■
浅方肩铣	◪	◪	◪	◪	◪
浅槽铣	◪	■	■		
插铣					

■ 推荐使用　◪ 可以使用

SAD07D

P M K N S

PRAMET

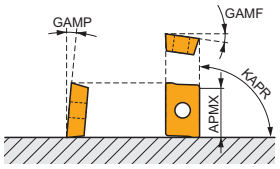
S

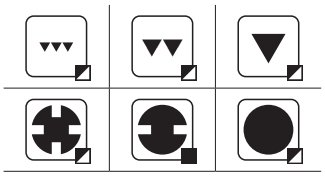
FORCE AD07带内冷的方肩铣刀

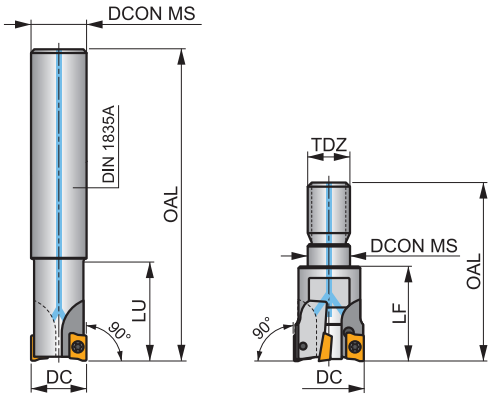
90⊠方肩铣刀，使用正前角AD.. 07类型刀片，具有APMX(最大切深)5mm。适用于面铣，方肩铣，铣槽，螺旋铣削，摆线加工，坡走铣和插铣。可提供圆柱柄和模块夹紧系统类型，具有不等齿距。刀体经过处理，使用寿命更长。

FORCE AD

KAPR	90°
APMX	5.0 mm







h_m 0.03 - 0.08

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	10A2R016A08-SAD07D-C	10	100	8	16	–	–	-12	8	2	–	61600	✓	0.05	GI276	SQ010
	10A2R016A10-SAD07D-C	10	80	10	16	–	–	-12	8	2	–	61600	✓	0.05	GI276	SQ010
	10A2R018A08-SAD07D-CF	10	100	8	18	–	–	-12	8	2	–	61600	✓	0.06	GI276	SQ010
	10A2R018A10-SAD07D-CF	10	80	10	18	–	–	-12	8	2	–	61600	✓	0.05	GI276	SQ010
	12A2R018A10-SAD07D-C	12	120	10	18	–	–	-10	8	2	–	56300	✓	0.09	GI276	SQ010
	12A2R018A12-SAD07D-C	12	90	12	18	–	–	-10	8	2	–	56300	✓	0.09	GI276	SQ010
	12A3R018A12-SAD07D-C	12	90	12	18	–	–	-10	8	3	–	56200	✓	0.09	GI276	SQ010
	12A3R020A12-SAD07D-CF	12	90	12	20	–	–	-10	8	3	–	56200	✓	0.09	GI276	SQ010
	14A3R018A12-SAD07D-C	14	140	12	18	–	–	-9	8	3	–	52100	✓	0.13	GI276	SQ010
	14A3R018A14-SAD07D-C	14	90	14	18	–	–	-9	8	3	–	52100	✓	0.11	GI276	SQ010
	14A3R020A12-SAD07D-CF	14	140	12	20	–	–	-9	8	3	–	52100	✓	0.14	GI276	SQ010
	14A3R020A14-SAD07D-CF	14	90	14	20	–	–	-9	8	3	–	52100	✓	0.11	GI276	SQ010
	16A3R019A14-SAD07D-C	16	160	14	19	–	–	-8	8	3	–	48700	✓	0.21	GI276	SQ011
	16A3R019A16-SAD07D-C	16	110	16	19	–	–	-8	8	3	–	48700	✓	0.18	GI276	SQ011
	16A4R019A16-SAD07D-C	16	110	16	19	–	–	-8	8	4	–	48700	✓	0.18	GI276	SQ011
	18A4R019A16-SAD07D-C	18	180	16	19	–	–	-7.5	8	4	✓	45900	✓	0.28	GI276	SQ011
	18A4R019A18-SAD07D-C	18	110	18	19	–	–	-7.5	8	4	✓	45900	✓	0.22	GI276	SQ011
	20A4R020A18-SAD07D-C	20	200	18	20	–	–	-7	8	4	✓	43600	✓	0.37	GI276	SQ011
	20A4R020A20-SAD07D-C	20	125	20	20	–	–	-7	8	4	✓	43600	✓	0.29	GI276	SQ011
	20A5R020A20-SAD07D-C	20	125	20	20	–	–	-7	8	5	✓	43600	✓	0.30	GI276	SQ011
	25A5R024A25-SAD07D-C	25	140	25	24	–	–	-6.5	8	5	✓	39000	✓	0.51	GI276	SQ011
	25A6R024A25-SAD07D-C	25	140	25	24	–	–	-6.5	8	6	✓	39000	✓	0.51	GI276	SQ011
MODULAR	12A2R020M06-SAD07D-C	12	35	6.5	–	20	M6	-10	8	2	–	–	✓	0.04	GI276	SQ010
	14A3R020M08-SAD07D-C	14	38	8.5	–	20	M8	-9	8	3	–	–	✓	0.04	GI276	SQ010
	14A3R023M08-SAD07D-CF	14	41	8.5	–	23	M8	-9	8	3	–	–	✓	0.05	GI276	SQ010
	16A4R023M08-SAD07D-C	16	41	8.5	–	23	M8	-8	8	4	✓	–	✓	0.05	GI276	SQ011
	20A5R030M10-SAD07D-C	20	49	10.5	–	30	M10	-7	8	5	✓	–	✓	0.08	GI276	SQ011

产品	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
25A6R035M12-SAD07D-C	25	57	12.5	–	35	M12	-6.5	8	6	✓	–	✓	0.13	GI276	SQ011
32A8R043M16-SAD07D-C	32	66	17	–	43	M16	-6	8	8	✓	–	✓	0.24	GI276	SQ011

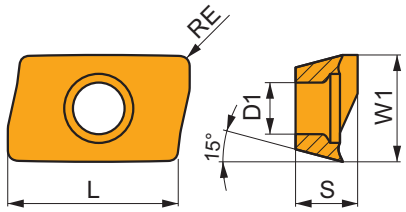
GI276	ADMX 0702..	ADEX 0702..

		Nm			
SQ010	US 62003A-T06P	0.6	M 2	3	Flag T06P
SQ011	US 62004A-T06P	0.6	M 2	4	Flag T06P

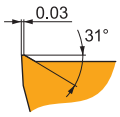
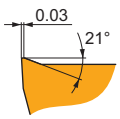
ADMX 07

PRAMET

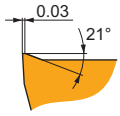
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
0702	4.482	2.20	6.95	2.48



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F 型，具有非常锋利正前角设计，适用于轻载加工。																				
ADMX 070202SR-F:M8330	●	0.2	220	0.07	2.0	130	0.06	2.0	–	–	–	660	0.08	2.0	55	0.05	1.6	–	–	–
ADMX 070204SR-F:M6330	●	0.4	200	0.07	2.0	140	0.06	2.0	–	–	–	–	–	–	60	0.05	1.6	–	–	–
ADMX 070204SR-F:M8330	●	0.4	235	0.07	2.0	140	0.06	2.0	–	–	–	705	0.08	2.0	55	0.05	1.6	–	–	–
ADMX 070204SR-F:M8340	●	0.4	215	0.07	2.0	125	0.06	2.0	–	–	–	–	–	–	50	0.05	1.6	–	–	–
ADMX 070208SR-F:M8310	⇕	0.8	320	0.07	2.0	160	0.06	2.0	–	–	–	–	–	–	–	–	–	–	–	–
ADMX 070208SR-F:M8330	⇕	0.8	280	0.07	2.0	165	0.06	2.0	–	–	–	840	0.08	2.0	70	0.05	1.6	–	–	–
ADMX 070208SR-F:M8340	⇕	0.8	255	0.07	2.0	150	0.06	2.0	–	–	–	–	–	–	60	0.05	1.6	–	–	–
																				
M 型，具有前角设计，适用于轻载到中等加工。																				
ADMX 070202SR-M:M8330	●	0.2	205	0.09	2.2	120	0.08	2.2	190	0.09	2.2	615	0.11	2.2	50	0.06	1.8	–	–	–
ADMX 070202SR-M:M8340	●	0.2	185	0.09	2.2	110	0.08	2.2	175	0.09	2.2	–	–	–	45	0.06	1.8	–	–	–
ADMX 070204SR-M:8215	●	0.4	225	0.09	2.2	135	0.08	2.2	210	0.09	2.2	675	0.11	2.2	55	0.06	1.8	–	–	–
ADMX 070204SR-M:M6330	●	0.4	190	0.09	2.2	135	0.08	2.2	–	–	–	–	–	–	55	0.06	1.8	–	–	–
ADMX 070204SR-M:M8310	●	0.4	245	0.09	2.2	120	0.08	2.2	230	0.09	2.2	–	–	–	–	–	–	–	–	–
ADMX 070204SR-M:M8330	●	0.4	220	0.09	2.2	130	0.08	2.2	205	0.09	2.2	660	0.11	2.2	55	0.06	1.8	–	–	–
ADMX 070204SR-M:M8340	●	0.4	200	0.09	2.2	120	0.08	2.2	190	0.09	2.2	–	–	–	50	0.06	1.8	–	–	–
ADMX 070204SR-M:M9340	●	0.4	265	0.09	2.2	155	0.08	2.2	–	–	–	–	–	–	65	0.06	1.8	–	–	–
ADMX 070208SR-M:8215	⇕	0.8	270	0.09	2.2	160	0.08	2.2	255	0.09	2.2	810	0.11	2.2	65	0.06	1.8	–	–	–

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

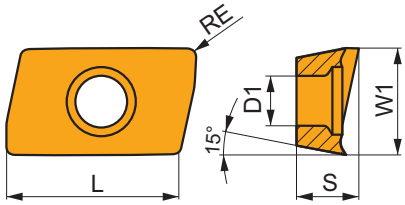
产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ADMX 070208SR-M:M6330	●	0.8	225	0.09	2.2	160	0.08	2.2	–	–	–	–	–	–	65	0.06	1.8	–	–	–
ADMX 070208SR-M:M8310	●	0.8	290	0.09	2.2	145	0.08	2.2	275	0.09	2.2	–	–	–	–	–	–	–	–	–
ADMX 070208SR-M:M8330	●	0.8	260	0.09	2.2	155	0.08	2.2	245	0.09	2.2	780	0.11	2.2	65	0.06	1.8	–	–	–
ADMX 070208SR-M:M8340	●	0.8	240	0.09	2.2	140	0.08	2.2	225	0.09	2.2	–	–	–	60	0.06	1.8	–	–	–
ADMX 070208SR-M:M9340	●	0.8	315	0.09	2.2	185	0.08	2.2	–	–	–	–	–	–	75	0.06	1.8	–	–	–
ADMX 070216SR-M:M8330	●	1.6	290	0.09	2.2	170	0.08	2.2	275	0.09	2.2	870	0.11	2.2	70	0.06	1.8	–	–	–
ADMX 070220SR-M:M8310	●	2.0	340	0.09	2.2	170	0.08	2.2	320	0.09	2.2	–	–	–	–	–	–	–	–	–
ADMX 070220SR-M:M8330	●	2.0	300	0.09	2.2	180	0.08	2.2	285	0.09	2.2	900	0.11	2.2	75	0.06	1.8	–	–	–
ADMX 070220SR-M:M8340	●	2.0	275	0.09	2.2	165	0.08	2.2	260	0.09	2.2	–	–	–	65	0.06	1.8	–	–	–

M 型，具有前角设计，适用于轻载到中等加工。

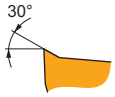
ADEX 07-FA

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
0702	4.497	2.20	6.95	2.48



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

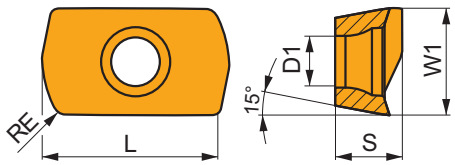
产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ADEX 070204FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	240	0.18	3.0	–	–	–	–	–	–
ADEX 070204FR-FA:M0315	●	0.4	–	–	–	–	–	–	–	–	–	555	0.18	3.0	–	–	–	–	–	–
ADEX 070208FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	285	0.18	3.0	–	–	–	–	–	–

FA 型，具有大正前角设计，适用于精加工到中等加工。

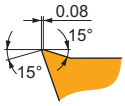
ADEX 07-HF

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
0702	4.439	2.20	6.45	2.48



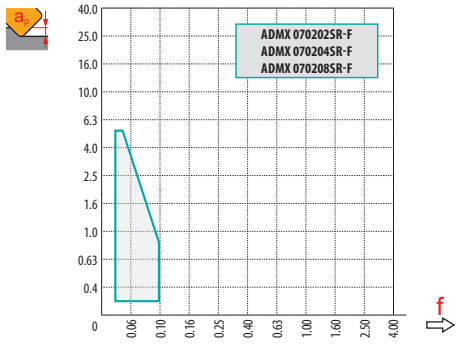
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

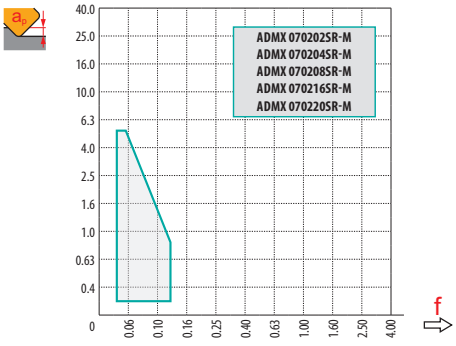
产品	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 HFC S																			
ADEX 070206SR-HF:M6330	0.6	200	0.60	0.3	140	0.54	0.3	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 070206SR-HF:M8330	0.6	225	0.60	0.3	135	0.54	0.3	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 070206SR-HF:M8340	0.6	215	0.60	0.3	125	0.54	0.3	–	–	–	–	–	–	–	–	–	–	–	–

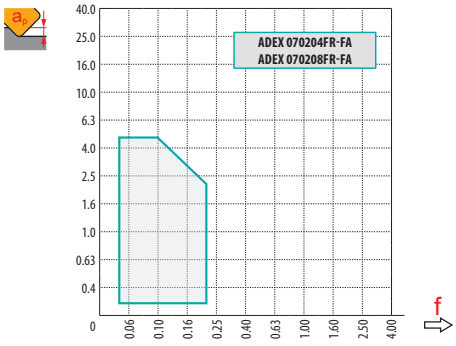
HF 型，具有大正前角设计，适用于快进给。

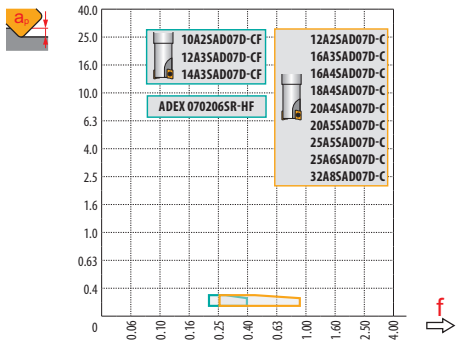
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ADMX 07-F			ADMX 07-M					ADEX 07-HF	ADEX 07-FA	
RE	0.2	0.4	0.8	0.2	0.4	0.8	1.6	2.0	0.6	0.4	0.8
BS	1.38	0.89	0.54	1.38	0.89	0.54	0.7	0.33	–	0.94	0.55









ADEX 07-HF

DC	a_p	0	0.1	0.2	0.3
10	DEF	5.6	7.8	8.7	9.4
12		7.6	9.8	10.7	11.4
14		9.6	11.8	12.7	13.4
16		11.6	13.8	14.7	15.4
18		13.6	15.8	16.7	17.4
20		15.6	17.8	18.7	19.4
25		20.6	22.8	23.7	24.4
32		27.6	29.8	30.7	31.4

HFC

a_p	0.1	0.2	0.3
1 ⇨ f	0.9	0.8	0.6

max.
3.0

a_p	1.0	3.0	5.0
f	0.13	0.08	0.05

	HFC		
a_p	0.1	0.2	0.3
f	0.7	0.6	0.4

DC	RPMX	APMX/l
10	5.2°	5.0/56
12	3.4°	5.0/86
14	2.5°	4.2/100
16	1.9°	3.2/100
18	1.7°	2.8/100
20	1.5°	2.5/100
25	1.1°	1.8/100
32	0.8°	1.2/100

	HFC	
DC	RPMX	APMX/l
10	3.5°	0.3/6
12	2.2°	0.3/9
14	1.6°	0.3/12
16	1.3°	0.3/15
18	1.1°	0.3/17
20	0.9°	0.3/21
25	0.7°	0.3/26
32	0.5°	0.3/36

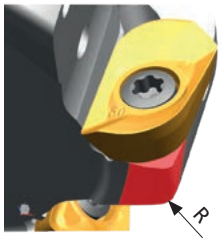
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
10	12.0	20.0	0.5	2.8
12	16.0	24.0	0.7	2.2
14	20.0	28.0	0.8	1.9
16	24.0	32.0	0.8	1.6
18	28.0	36.0	0.9	1.6
20	32.0	40.0	0.9	1.6
25	42.0	50.0	1.0	1.5
32	56.0	64.0	1.0	1.4

	HFC			
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
10	12	20	0.30	0.30
12	16	24	0.30	0.30
14	20	28	0.30	0.30
16	24	32	0.30	0.30
18	28	36	0.30	0.30
20	32	40	0.30	0.30
25	42	50	0.30	0.30
32	56	64	0.30	0.30

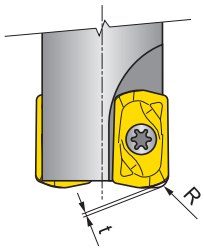
a_p
0.5

a_p	HFC
	0.3

DC	µm	3	5	10	15	20	30	40	50	60	80	100
10	FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
14		0.410	0.529	0.748	0.917	1.058	1.296	1.497	1.673	1.833	2.117	2.366
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578



ADMX 07	R
ADMX 070216SR-M	1
ADMX 070220SR-M	1.5
ADEX 070206SR-HF	1



ADEX 07	R	t
ADEX 070206SR-HF	0.8	0.18

SAD11E

P M K N S H

PRAMET

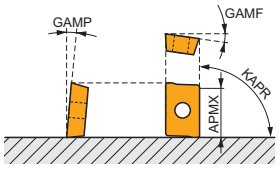
S

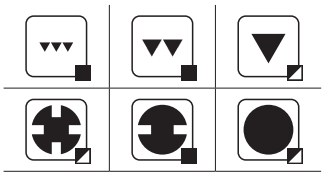
FORCE AD11带内冷的方肩铣刀

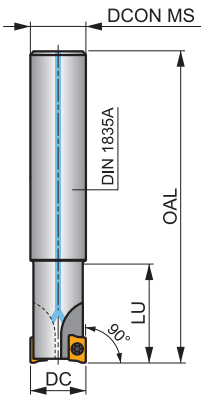
90°方肩铣刀和面铣刀，使用正前角AD..　11类型刀片，具有APMX(最大切深)9mm。适用于面铣，方肩铣，铣槽，螺旋铣削，摆线加工，坡走铣和插铣。可提供圆柱柄，侧固柄，莫氏锥柄，模块夹紧系统和芯轴式(具有不等齿距)类型。刀体经过处理，使用寿命更长。

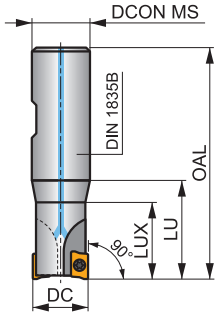
FORCE AD

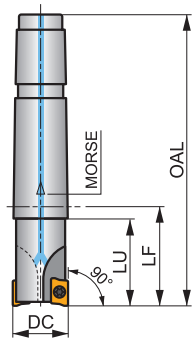
KAPR	90°
APMX	9.0 mm

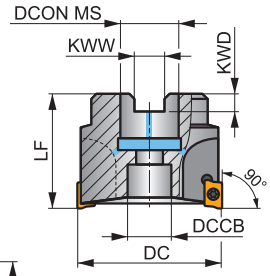


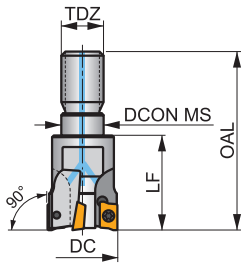












h_m	0.06 – 0.13
h_m	0.08 – 0.16

	产品型号	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	16A2R024A14-SAD11E-C	16	160	14	–	24	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.19	GI169	SQ025	–
	16A2R024A16-SAD11E-C	16	135	16	–	24	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.19	GI169	SQ025	–
	16A2R050A16-SAD11E-C	16	135	16	–	50	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.20	GI169	SQ025	–
	18A2R029A20-SAD11E-C	18	150	20	–	29	–	–	–	–	–	–	-12	4.5	2	–	28400	✓	0.35	GI169	SQ025	–
	20A2R029A20-SAD11E-C	20	150	20	–	29	–	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.33	GI169	SQ020	–
	20A2R070A20-SAD11E-C	20	150	20	–	70	–	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.32	GI169	SQ020	–
	20A3R029A18-SAD11E-C	20	200	18	–	29	–	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.36	GI169	SQ025	–
	20A3R029A20-SAD11E-C	20	150	20	–	29	–	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.31	GI169	SQ025	–
	22A3R029A20-SAD11E-C	22	200	20	–	29	–	–	–	–	–	–	-11.5	5	3	–	25600	✓	0.45	GI169	SQ025	–
	25A3R034A25-SAD11E-C	25	170	25	–	34	–	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.42	GI169	SQ020	–
	25A3R080A25-SAD11E-C	25	170	25	–	80	–	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.52	GI169	SQ020	–
	25A4R034A25-SAD11E-C	25	170	25	–	34	–	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.56	GI169	SQ025	–
	25A4R040A25-SAD11E-C	25	250	25	–	40	–	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.85	GI169	SQ025	–
	30A3R080A32-SAD11E-C	30	200	32	–	80	–	–	–	–	–	–	-9.3	7	3	–	22000	✓	0.98	GI169	SQ020	–
	32A3R090A32-SAD11E-C	32	195	32	–	90	–	–	–	–	–	–	-9	5	3	–	21300	✓	0.99	GI169	SQ020	–
	32A5R034A32-SAD11E-C	32	195	32	–	34	–	–	–	–	–	–	-9	8	5	–	21300	✓	1.03	GI169	SQ025	–
	35A5R025A32-SAD11E-C	35	200	32	–	25	–	–	–	–	–	–	-9	8	5	–	20300	✓	1.11	GI169	SQ020	–
DIN 1835B	16A2R027B16-SAD11E-C	16	75	16	–	–	27	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.11	GI169	SQ025	–
	20A2R032B20-SAD11E-C	20	82	20	–	–	32	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.13	GI169	SQ020	–
	20A3R032B20-SAD11E-C	20	82	20	–	–	32	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.13	GI169	SQ025	–
	25A3R042B25-SAD11E-C	25	98	25	–	–	42	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.29	GI169	SQ020	–
	25A4R042B25-SAD11E-C	25	98	25	–	–	42	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.31	GI169	SQ025	–
	32A4R042B32-SAD11E-C	32	102	32	–	–	42	–	–	–	–	–	-9	8	4	–	21300	✓	0.27	GI169	SQ020	–
	32A5R042B32-SAD11E-C	32	102	32	–	–	42	–	–	–	–	–	-9	8	5	–	21300	✓	0.32	GI169	SQ025	–
DIN 228A	16A2R030E02-SAD11E-C	16	94	–	–	25	–	30	–	2	–	–	-12.8	4	2	–	30100	✓	0.13	GI169	SQ025	–
	20A3R035E03-SAD11E-C	20	116	–	–	30	–	35	–	3	–	–	-11.5	5	3	–	27000	✓	0.27	GI169	SQ025	–
	25A4R043E03-SAD11E-C	25	124	–	–	38	–	43	–	3	–	–	-10.2	5	4	–	24100	✓	0.31	GI169	SQ025	–

	产品型号	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
MODULAR	16A2R024M08-SAD11E-C	16	38	8.5	–	–	–	24	M8	–	–	–	-12.8	4	2	–	–	✓	0.04	GI169	SQ025	–
	20A2R026M10-SAD11E-C	20	45	11	–	–	–	26	M10	–	–	–	-11.5	5	2	–	–	✓	0.06	GI169	SQ020	–
	20A3R026M10-SAD11E-C	20	45	10.5	–	–	–	26	M10	–	–	–	-11.5	5	3	–	–	✓	0.06	GI169	SQ025	–
	25A3R033M12-SAD11E-C	25	55	12.5	–	–	–	33	M12	–	–	–	-10.2	5	3	–	–	✓	0.10	GI169	SQ020	–
	25A4R033M12-SAD11E-C	25	55	12.5	–	–	–	33	M12	–	–	–	-10.2	5	4	–	–	✓	0.09	GI169	SQ025	–
	32A4R043M16-SAD11E-C	32	66	17	–	–	–	43	M16	–	–	–	-9	8	4	–	–	✓	0.20	GI169	SQ020	–
	32A5R043M16-SAD11E-C	32	66	17	–	–	–	43	M16	–	–	–	-9	8	5	–	–	✓	0.20	GI169	SQ025	–
	40A4R043M16-SAD11E-C	40	66	17	–	–	–	43	M16	–	–	–	-8.1	11	4	–	–	✓	0.27	GI169	SQ020	–
	40A6R043M16-SAD11E-C	40	66	17	–	–	–	43	M16	–	–	–	-8.1	11	6	–	–	✓	0.21	GI169	SQ020	–
ISO 6462 DIN 8030	40A04R-S90AD11E-C	40	–	16	14	–	–	40	–	–	8.4	5.6	-8.1	11	4	✓	19100	✓	0.16	GI169	SQ022	–
	40A05R-S90AD11E-C	40	–	16	14	–	–	40	–	–	8.4	5.6	-8.1	11	5	✓	19000	✓	0.31	GI169	SQ022	–
	40A06R-S90AD11E-C	40	–	16	14	–	–	40	–	–	8.4	5.6	-8.1	11	6	✓	19100	✓	0.20	GI169	SQ022	–
	50A05R-S90AD11E-C	50	–	22	18	–	–	40	–	–	10.4	6.3	-7.2	12	5	✓	17000	✓	0.31	GI169	SQ023	–
	50A07R-S90AD11E-C	50	–	22	18	–	–	40	–	–	10.4	6.3	-7.2	12	7	✓	17000	✓	0.44	GI169	SQ023	–
	63A06R-S90AD11E-C	63	–	22	18	–	–	40	–	–	10.4	6.3	-6.5	12	6	✓	15200	✓	0.54	GI169	SQ023	–
	63A09R-S90AD11E-C	63	–	22	18	–	–	40	–	–	10.4	6.3	-6.5	12	9	✓	15200	✓	0.61	GI169	SQ023	–
	80A10R-S90AD11E-C	80	–	27	38	–	–	50	–	–	12.4	7	-6	12	10	✓	13500	✓	1.04	GI169	SQ021	AC001
	100A11R-S90AD11E-C	100	–	32	45	–	–	50	–	–	14.4	8	-5.5	12	11	✓	12100	✓	1.89	GI169	SQ021	AC002
	125A12R-S90AD11E-C	125	–	40	56	–	–	63	–	–	16.4	9	-5.2	12	12	✓	10800	✓	2.97	GI169	SQ021	AC003

GI169	ADMX 11T3..	ADEX 11T3..

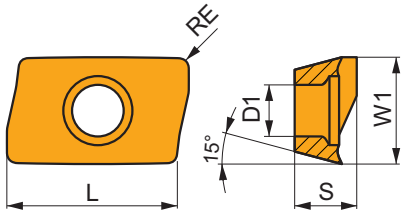
		Nm						
SQ020	US 62506-T07P	1.2	M 2.5	6	–	–	Flag T07P	–
SQ021	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	–
SQ022	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ023	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	HS 1030C
SQ025	US 62505-T07P	1.2	M 2.5	5	–	–	Flag T07P	–

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

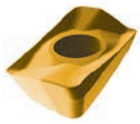
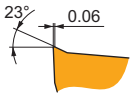
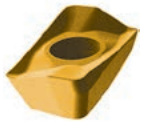
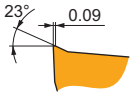
ADMX 11

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.530	2.90	11.00	3.97



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  **F 型，具有非常锋利正前角设计，适用于轻载加工。**																				
ADMX 11T304SR-F:8215	●	0.4	245	0.10	2.0	145	0.09	2.0	230	0.10	2.0	735	0.12	2.0	60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8330	●	0.4	240	0.10	2.0	140	0.09	2.0	225	0.10	2.0	720	0.12	2.0	60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8340	●	0.4	220	0.10	2.0	130	0.09	2.0	205	0.10	2.0	–	–	–	55	0.08	1.6	–	–	–
ADMX 11T304SR-F:M9340	●	0.4	285	0.10	2.0	170	0.09	2.0	–	–	–	–	–	–	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:8215	⬌	0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8330	⬌	0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8340	⬌	0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	–	–	–	65	0.08	1.6	–	–	–
ADMX 11T308SR-F:M9340	⬌	0.8	340	0.10	2.0	200	0.09	2.0	–	–	–	–	–	–	85	0.08	1.6	–	–	–
  **M 型，具有前角设计，适用于轻载到中等加工。**																				
ADMX 11T302SR-M:M8330	●	0.2	190	0.15	4.0	110	0.14	4.0	180	0.15	4.0	–	–	–	45	0.12	3.2	–	–	–
ADMX 11T302SR-M:M8340	⬌	0.2	170	0.15	4.0	100	0.14	4.0	160	0.15	4.0	–	–	–	40	0.12	3.2	–	–	–
ADMX 11T304SR-M:8215	●	0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	–	–	–	50	0.12	3.2	–	–	–
ADMX 11T304SR-M:M8310	●	0.4	220	0.15	4.0	110	0.14	4.0	205	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T304SR-M:M8330	⬌	0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	–	–	–	50	0.12	3.2	–	–	–
ADMX 11T304SR-M:M8340	⬌	0.4	185	0.15	4.0	110	0.14	4.0	175	0.15	4.0	–	–	–	45	0.12	3.2	–	–	–
ADMX 11T304SR-M:M9325	●	0.4	255	0.15	4.0	–	–	–	240	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T304SR-M:M9340	●	0.4	235	0.15	4.0	140	0.14	4.0	–	–	–	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T308SR-M:8215	⬌	0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T308SR-M:M5315	⬌	0.8	335	0.15	4.0	–	–	–	315	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M8310	⬌	0.8	265	0.15	4.0	135	0.14	4.0	250	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M8330	⬌	0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T308SR-M:M8340	⬌	0.8	220	0.15	4.0	130	0.14	4.0	205	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T308SR-M:M9315	⬌	0.8	330	0.15	4.0	–	–	–	310	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M9325	⬌	0.8	305	0.15	4.0	–	–	–	285	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M9340	⬌	0.8	275	0.15	4.0	165	0.14	4.0	–	–	–	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T310SR-M:M8330	⬌	1.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T310SR-M:M8340	✱	1.0	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T312SR-M:8215	⬌	1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T312SR-M:M8330	✱	1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T312SR-M:M8340	✱	1.2	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T316SR-M:8215	⬌	1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M6330	✱	1.6	230	0.15	4.0	165	0.14	4.0	–	–	–	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M8310	⬌	1.6	295	0.15	4.0	150	0.14	4.0	280	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T316SR-M:M8330	✱	1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M8340	✱	1.6	240	0.15	4.0	140	0.14	4.0	225	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T320SR-M:M6330	✱	2.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T320SR-M:M8330	✱	2.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T320SR-M:M8340	✱	2.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–

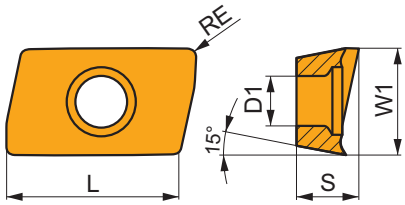
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
M 型，具有前角设计，适用于轻载到中等加工。																				
ADMX 11T325SR-M:M6330	✱	2.5	■ 240	0.15	4.0	■ 170	0.14	4.0	–	–	–	–	–	–	◪ 70	0.12	3.2	–	–	–
ADMX 11T325SR-M:M8340	✱	2.5	■ 255	0.15	4.0	■ 150	0.14	4.0	◪ 240	0.15	4.0	–	–	–	◪ 60	0.12	3.2	–	–	–
ADMX 11T330SR-M:M6330	✱	3.0	■ 240	0.15	4.0	■ 170	0.14	4.0	–	–	–	–	–	–	◪ 70	0.12	3.2	–	–	–
ADMX 11T330SR-M:M8330	✱	3.0	■ 280	0.15	4.0	■ 165	0.14	4.0	■ 265	0.15	4.0	–	–	–	◪ 70	0.12	3.2	–	–	–
ADMX 11T330SR-M:M8340	✱	3.0	■ 255	0.15	4.0	■ 150	0.14	4.0	◪ 240	0.15	4.0	–	–	–	◪ 60	0.12	3.2	–	–	–
R 型，具有正前角设计，适用于不稳定的工况。																				
ADMX 11T308PR-R:8215	✱	0.8	■ 230	0.18	4.0	◪ 135	0.16	4.0	■ 215	0.18	4.0	–	–	–	◪ 55	0.16	3.2	◪ 45	0.12	0.7
ADMX 11T308PR-R:M5315	⚙	0.8	◪ 310	0.18	4.0	–	–	–	■ 290	0.18	4.0	–	–	–	–	–	–	◪ 60	0.13	0.7
ADMX 11T308PR-R:M8310	✱	0.8	■ 250	0.18	4.0	◪ 125	0.16	4.0	■ 235	0.18	4.0	–	–	–	–	–	–	◪ 50	0.12	0.7
ADMX 11T308PR-R:M8330	✱	0.8	■ 230	0.18	4.0	◪ 135	0.16	4.0	■ 215	0.18	4.0	–	–	–	◪ 55	0.16	3.2	◪ 45	0.12	0.7
ADMX 11T308PR-R:M8340	✱	0.8	■ 210	0.18	4.0	◪ 125	0.16	4.0	◪ 195	0.18	4.0	–	–	–	◪ 50	0.16	3.2	–	–	–
ADMX 11T308PR-R:M9315	⚙	0.8	■ 310	0.18	4.0	–	–	–	■ 290	0.18	4.0	–	–	–	–	–	–	◪ 60	0.13	0.7
ADMX 11T308PR-R:M9325	✱	0.8	■ 290	0.18	4.0	–	–	–	■ 275	0.18	4.0	–	–	–	–	–	–	◪ 55	0.13	0.7
ADMX 11T316PR-R:8215	✱	1.6	■ 255	0.18	4.0	◪ 150	0.16	4.0	■ 240	0.18	4.0	–	–	–	◪ 60	0.16	3.2	◪ 50	0.12	0.7
ADMX 11T316PR-R:M8330	✱	1.6	■ 255	0.18	4.0	◪ 150	0.16	4.0	■ 240	0.18	4.0	–	–	–	◪ 60	0.16	3.2	◪ 50	0.12	0.7
ADMX 11T316PR-R:M9325	✱	1.6	■ 320	0.18	4.0	–	–	–	■ 300	0.18	4.0	–	–	–	–	–	–	◪ 60	0.12	0.7
MF 型，具有大正前角设计，适用于轻载到精加工。																				
ADMX 11T304SR-MF:M6330	●	0.4	■ 215	0.08	2.5	■ 150	0.07	2.5	–	–	–	–	–	–	■ 60	0.06	2.0	–	–	–
ADMX 11T304SR-MF:M8340	●	0.4	■ 220	0.08	2.5	■ 130	0.07	2.5	–	–	–	–	–	–	■ 55	0.06	2.0	–	–	–
ADMX 11T308SR-MF:M6330	⚙	0.8	■ 255	0.08	2.5	■ 180	0.07	2.5	–	–	–	–	–	–	■ 75	0.06	2.0	–	–	–
ADMX 11T308SR-MF:M8340	⚙	0.8	■ 265	0.08	2.5	■ 155	0.07	2.5	–	–	–	–	–	–	■ 65	0.06	2.0	–	–	–
MM 型，具有大前角设计，适用于轻载到中等加工。																				
ADMX 11T304SR-MM:M6330	⚙	0.4	■ 185	0.14	2.5	■ 130	0.13	2.5	–	–	–	–	–	–	■ 55	0.11	2.0	–	–	–
ADMX 11T304SR-MM:M8340	⚙	0.4	■ 195	0.14	2.5	■ 115	0.13	2.5	–	–	–	–	–	–	■ 45	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M6330	⚙	0.8	■ 225	0.14	2.5	■ 155	0.13	2.5	–	–	–	–	–	–	■ 65	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M8340	⚙	0.8	■ 235	0.14	2.5	■ 140	0.13	2.5	–	–	–	–	–	–	■ 55	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M8345	⚙	0.8	■ 190	0.14	2.5	■ 110	0.13	2.5	–	–	–	–	–	–	■ 45	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M9340	⚙	0.8	■ 300	0.14	2.5	■ 180	0.13	2.5	–	–	–	–	–	–	■ 75	0.11	2.0	–	–	–
ADMX 11T312SR-MM:M6330	✱	1.2	■ 235	0.14	2.5	■ 165	0.13	2.5	–	–	–	–	–	–	■ 70	0.11	2.0	–	–	–
ADMX 11T312SR-MM:M8340	✱	1.2	■ 245	0.14	2.5	■ 145	0.13	2.5	–	–	–	–	–	–	■ 60	0.11	2.0	–	–	–

ADEX 11-FA

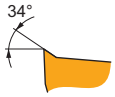
PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.450	2.90	9.70	3.91



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号	●	⇕	✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
ADEX 11T304FR-FA:HF7	●			0.4	–	–	–	–	–	–	–	–	–	210	0.30	5.0	–	–	–	–	–	–
ADEX 11T304FR-FA:M0315	●			0.4	–	–	–	–	–	–	–	–	–	480	0.30	5.0	–	–	–	–	–	–
ADEX 11T308FR-FA:HF7	●			0.8	–	–	–	–	–	–	–	–	–	240	0.30	5.0	–	–	–	–	–	–
ADEX 11T308FR-FA:M0315	●			0.8	–	–	–	–	–	–	–	–	–	570	0.30	5.0	–	–	–	–	–	–
ADEX 11T312FR-FA:HF7	●			1.2	–	–	–	–	–	–	–	–	–	255	0.30	5.0	–	–	–	–	–	–
ADEX 11T316FR-FA:HF7	●			1.6	–	–	–	–	–	–	–	–	–	270	0.18	5.0	–	–	–	–	–	–

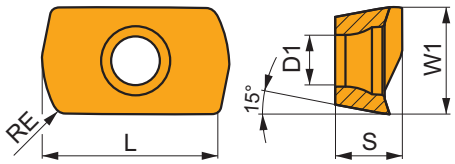


FA 型，具有大正前角设计，适用于精加工到中等加工。

ADEX 11-HF

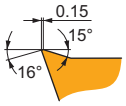
PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.450	2.90	10.67	3.82



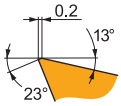
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号	●	⇕	✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
ADEX 11T308SR-HF:8215		⇕		0.8	215	0.68	0.4	125	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308SR-HF:M6330		⇕		0.8	185	0.68	0.4	130	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308SR-HF:M8310		⇕		0.8	220	0.68	0.4	110	0.52	0.4	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308SR-HF:M8330		⇕		0.8	215	0.68	0.4	125	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308SR-HF:M8340		⇕		0.8	200	0.68	0.4	120	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308SR-HF:M9340		⇕		0.8	220	0.68	0.4	130	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–



HF 型，具有大正前角设计，适用于快进给。

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

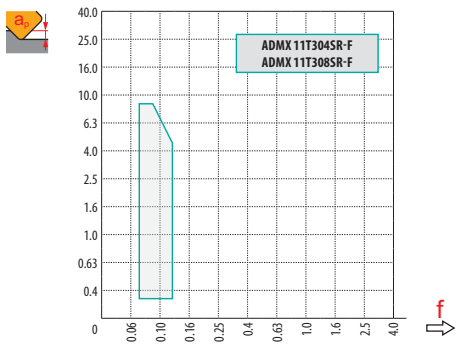
产品型号		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ADEX 11T308SR-HF2:M8310		0.8	220	0.68	0.4	110	0.61	0.4	205	0.68	0.4	–	–	–	–	–	–	40	0.48	0.3
ADEX 11T308SR-HF2:M8330		0.8	215	0.68	0.4	125	0.61	0.4	200	0.68	0.4	–	–	–	50	0.48	0.3	40	0.48	0.3
ADEX 11T308SR-HF2:M8340		0.8	200	0.68	0.4	120	0.61	0.4	190	0.68	0.4	–	–	–	50	0.48	0.3	–	–	–
ADEX 11T308SR-HF2:M9325		0.8	250	0.68	0.4	–	–	–	235	0.68	0.4	–	–	–	–	–	–	50	0.48	0.3

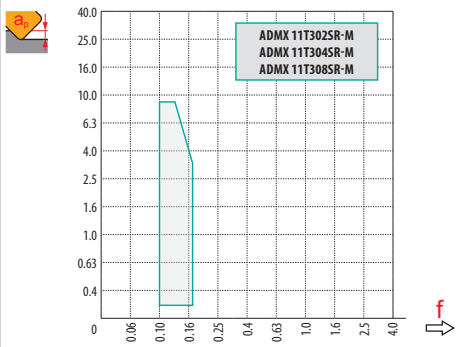
HF2 型，具有正前角设计，适用于快进给。

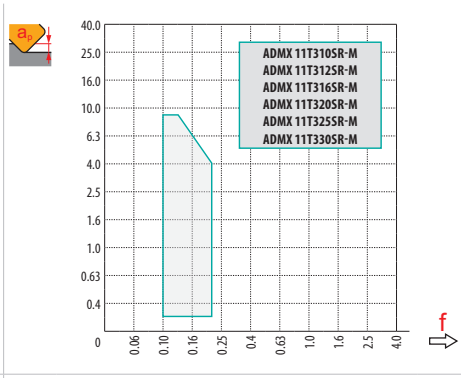
a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

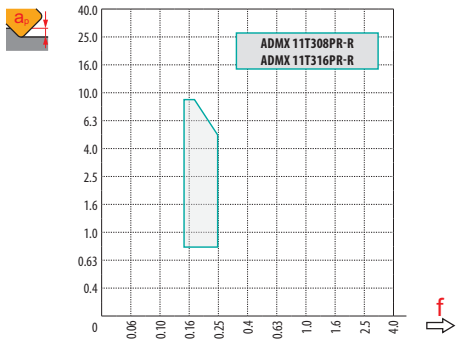
	ADMX 11-F		ADMX 11-M									ADMX 11-R		ADMX 11-MF	
RE	0.4	0.8	0.2	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0	0.8	1.6	0.4	0.8
BS	1.89	1.48	2.09	1.89	1.48	1.27	1.08	0.68	1.61	1.13	0.66	1.48	0.68	1.89	1.48

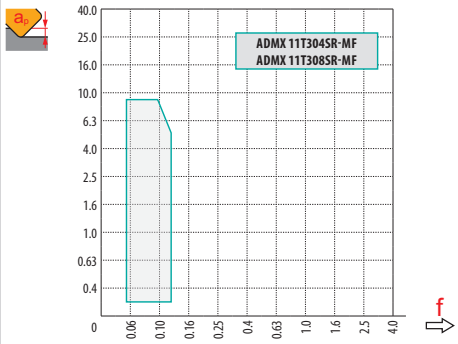
	ADMX 11-MM			ADEX 11-HF	ADEX 11-HF2	ADEX 11-FA			
RE	0.4	0.8	1.2	0.8	0.8	0.4	0.8	1.2	1.6
BS	1.89	1.48	1.08	0.17	0.17	1.77	1.39	1.0	0.62

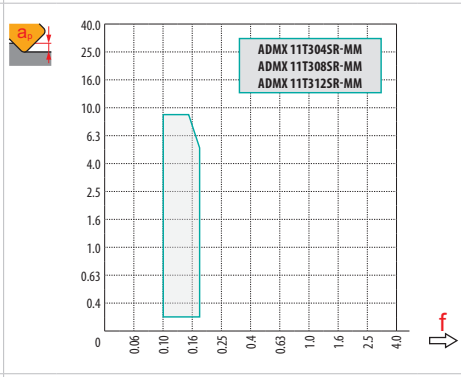


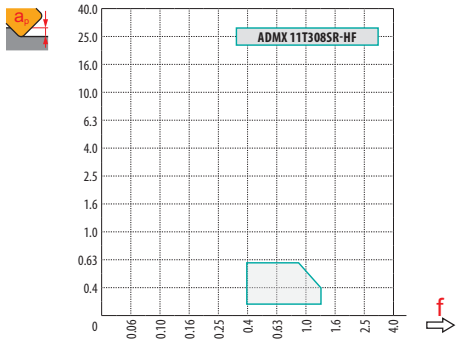


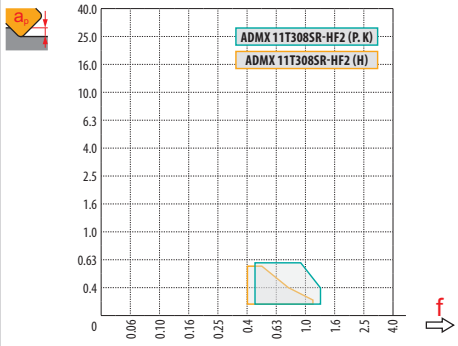


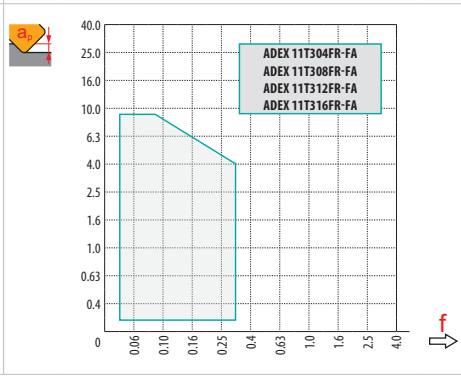












max

4.5

a_p	1.0	5.0	9.0
f	0.20	0.13	0.10

DC	RPMX	APMX/I
16	13.5°	9.0/40
18	10.0°	9.0/53
20	9.0°	9.0/59
25	6.0°	9.0/87
32	5.3°	9.0/99
40	3.8°	6.5/100
50	2.8°	4.7/100
63	1.8°	3.0/100
80	1.6°	2.6/100

HFC

DC	RPMX *	RPMX **	APMX/I
16	4.1°	5.7°	0.6/8
18	2.8°	4.5°	0.6/12
20	2.3°	4.3°	0.6/15
25	1.3°	6.7°	0.6/26
32	0.7°	4.3°	0.6/49
40	0.3°	2.9°	0.6/100
50	0.1°	2.1°	0.6/100
63	–	–	–
80	–	–	–

* 氢氟碳化物研磨
** 传统的研磨

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	27.0	32.0	8.3	9.0
18	32.0	36.0	7.5	9.0
20	35.0	40.0	7.5	9.0
25	45.0	50.0	6.5	7.5
32	59.0	64.0	4.0	4.5
40	75.0	80.0	1.5	2.0
50	–	–	–	–

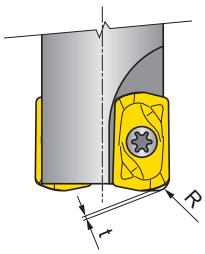
HFC				
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	21.0	32.0	0.6	0.6
18	29.0	36.0	0.6	0.6
20	29.0	40.0	0.6	0.6
25	39.0	50.0	0.6	0.6
32	53.0	64.0	0.6	0.6
40	68.5	80.0	0.6	0.6
50	88.5	100.0	0.6	0.6

a_p
1.7

DC	µm	3	5	10	15	20	30	40	50	60	80	100
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

RE	µm	3	5	10	15	20	30	40	50	60	80	100
1.0	FE	0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.894
1.2		0.170	0.219	0.310	0.379	0.438	0.537	0.620	0.693	0.759	0.876	0.980
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.5		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549

ADMX/ADEX 11	R
ADMX 11T320SR-M	1.0
ADMX 11T325SR-M	1.8
ADMX 11T330SR-M	1.8
ADEX 11T308SR-HF	1.4
ADEX 11T308SR-HF2	1.4



ADEX 11	R	t
ADEX 11T308SR-HF	1.42	0.35
ADEX 11T308SR-HF2	1.34	0.38

SAD16E

P M K N S H

PRAMET

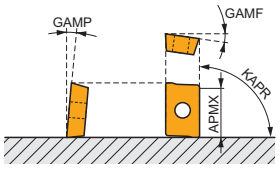
S

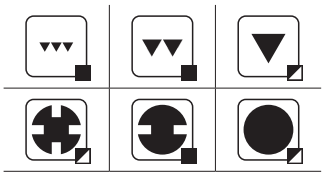
FORCE AD16带内冷的方肩铣刀

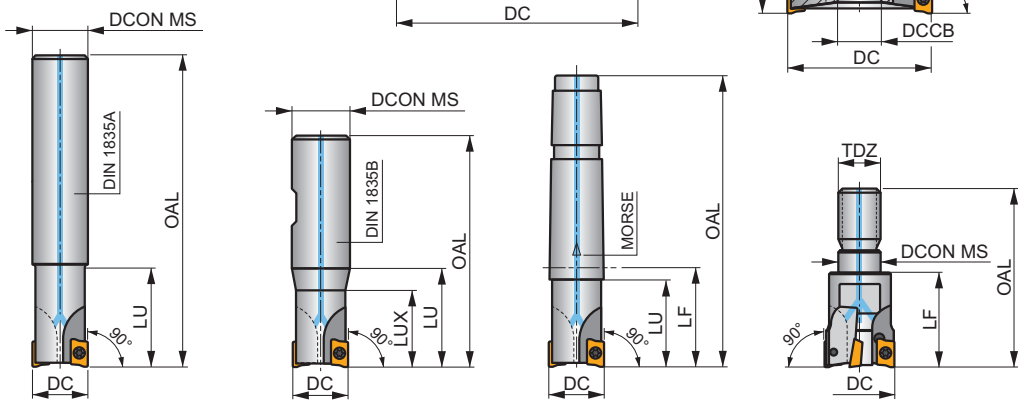
90⊠方肩铣刀和面铣刀，使用正前角AD.. 16类型刀片，具有APMX(最大切深)13mm。适用于面铣，方肩铣，铣槽，螺旋铣削，摆线加工，坡走铣和插铣。可提供圆柱柄，侧固柄，莫氏锥柄，模块夹紧系统和芯轴式(具有不等齿距)类型。刀体经过处理，使用寿命更长。

FORCE AD

KAPR	90°
APMX	13.0 mm







h_m	0.06 - 0.18
h_m	0.08 - 0.22

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	25A2R033A25-SAD16E-C	25	165	25	–	–	33	–	–	–	–	–	–	-13	5	2	–	18700	✓	0.52	GI165	SQ030	–
	25A2R038A25-SAD16E-C	25	200	25	–	–	38	–	–	–	–	–	–	-13	5	2	–	18700	✓	0.66	GI165	SQ030	–
	32A3R033A32-SAD16E-C	32	195	32	–	–	33	–	–	–	–	–	–	-12	7	3	–	16500	✓	1.03	GI165	SQ030	–
	32A3R048A32-SAD16E-C	32	250	32	–	–	48	–	–	–	–	–	–	-12	7	3	–	16500	✓	1.35	GI165	SQ030	–
DIN 1835B	25A2R042B25-SAD16E-C	25	98	25	–	–	–	42	–	–	–	–	–	-13	5	2	–	18700	✓	0.29	GI165	SQ030	–
	32A3R040B32-SAD16E-C	32	100	32	–	–	–	40	–	–	–	–	–	-12	7	3	–	16500	✓	0.51	GI165	SQ030	–
	40A3R050B32-SAD16E-C	40	110	32	–	–	–	50	–	–	–	–	–	-8.2	10.5	3	–	14800	✓	0.51	GI165	SQ030	–
	40A4R050B32-SAD16E-C	40	110	32	–	–	–	50	–	–	–	–	–	-8.2	10.5	4	–	14800	✓	0.64	GI165	SQ030	–
DIN 228A	25A2R043E03-SAD16E-C	25	98	–	–	–	38	–	43	–	3	–	–	-13	5	2	–	18600	✓	0.31	GI165	SQ030	–
	32A3R043E03-SAD16E-C	32	100	–	–	–	38	–	43	–	3	–	–	-12	7	3	–	16500	✓	0.33	GI165	SQ030	–
	40A3R054E04-SAD16E-C	40	110	–	–	–	48	–	54	–	4	–	–	-8.2	10.5	3	–	14700	✓	0.74	GI165	SQ030	–
	40A4R054E04-SAD16E-C	40	110	–	–	–	48	–	54	–	4	–	–	-8.2	10.5	4	–	14700	✓	0.70	GI165	SQ030	–
MODULAR	32A3R043M16-SAD16E-C	32	66	17	–	–	–	–	43	M16	–	–	–	-12	7	3	–	–	✓	0.20	GI165	SQ030	–
	40A4R043M16-SAD16E-C	40	66	17	–	–	–	–	43	M16	–	–	–	-8.2	10.5	4	–	–	✓	0.26	GI165	SQ030	–
ISO 8462 DIN 8030	40A04R-S90AD16E-C	40	–	16	14	–	–	–	40	–	–	8.4	5.6	-8.2	10.5	4	–	14700	✓	0.21	GI165	SQ032	–
	50A03R-S90AD16E-C	50	–	22	18	–	–	–	40	–	–	10.4	6.3	-7	11	3	–	13200	✓	0.43	GI165	SQ033	–
	50A05R-S90AD16E-C	50	–	22	18	–	–	–	40	–	–	10.4	6.3	-7	11	5	✓	13200	✓	0.40	GI165	SQ033	–
	63A04R-S90AD16E-C	63	–	22	18	–	–	–	40	–	–	10.4	6.3	-6	12	4	✓	11800	✓	0.60	GI165	SQ033	–
	63A06R-S90AD16E-C	63	–	22	18	–	–	–	40	–	–	10.4	6.3	-6	12	6	✓	11800	✓	0.59	GI165	SQ033	–
	80A05R-S90AD16E-C	80	–	27	38	–	–	–	50	–	–	12.4	7	-5	12	5	✓	10400	✓	1.09	GI165	SQ031	AC001
	80A07R-S90AD16E-C	80	–	27	38	–	–	–	50	–	–	12.4	7	-5	13	7	✓	10400	✓	0.97	GI165	SQ031	AC001
	100A06R-S90AD16E-C	100	–	32	45	–	–	–	50	–	–	14.4	8	-4	12	6	✓	9300	✓	1.85	GI165	SQ031	AC002
	100A08R-S90AD16E-C	100	–	32	45	–	–	–	50	–	–	14.4	8	-4	12	8	✓	9300	✓	1.89	GI165	SQ031	AC002
	125A09R-S90AD16E-C	125	–	40	56	–	–	–	63	–	–	16.4	9	-3.8	12	9	✓	8400	✓	3.65	GI165	SQ031	AC003
	140A08R-S90AD16E-C	140	–	40	56	–	–	–	63	–	–	16.4	9	-3.8	12	8	✓	7900	✓	4.06	GI165	SQ031	–
	160C10R-S90AD16E-C	160	–	40	–	66.7	–	–	63	–	–	16.4	9.2	-3.8	10	10	✓	7300	✓	6.04	GI165	SQ036	–
	175C10R-S90AD16E-C	175	–	40	–	66.7	–	–	63	–	–	16.4	9.2	-3.8	12	10	✓	7000	✓	6.86	GI165	SQ036	–

GI165	ADMX 1606..	ADEX 1606..

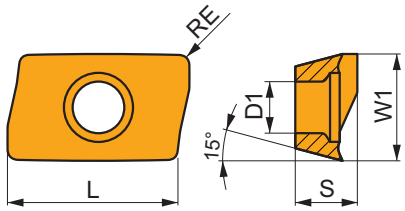
		Nm									
SQ030	US 4008-T15P	3.5	M 4	8	–	–	Flag T15P	–	–	–	–
SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	–	–	–	–
SQ032	US 4008-T15P	3.5	M 4	8	D-T08P/T15P	FG-15	–	HS 0830C	–	–	–
SQ033	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	HS 1030C	–	–	–
SQ036	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	HS 1240C	CAC 160C	HSD 0825C	HXK 5

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

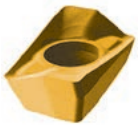
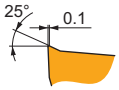
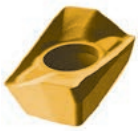
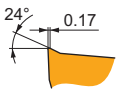
ADMX 16

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.25



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
F 型，具有大正前角设计，适用于轻载到中等加工。																				
ADMX 160608SR-F:8215		0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.07	1.6	–	–	–
ADMX 160608SR-F:M8310		0.8	320	0.10	2.0	160	0.09	2.0	300	0.10	2.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-F:M8330		0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.07	1.6	–	–	–
ADMX 160608SR-F:M8340		0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	–	–	–	65	0.07	1.6	–	–	–
ADMX 160608SR-F:M9340		0.8	340	0.10	2.0	200	0.09	2.0	–	–	–	–	–	–	85	0.07	1.6	–	–	–
 																				
M 型，具有前角设计，适用于轻载到中等加工。																				
ADMX 160604SR-M:8215	●	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	–	–	–	45	0.13	4.0	–	–	–
ADMX 160604SR-M:M8330		0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	–	–	–	45	0.13	4.0	–	–	–
ADMX 160604SR-M:M8340		0.4	170	0.18	5.0	100	0.16	5.0	160	0.18	5.0	–	–	–	40	0.13	4.0	–	–	–
ADMX 160608SR-M:8215		0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160608SR-M:M5315		0.8	305	0.18	5.0	–	–	–	285	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M8310		0.8	250	0.18	5.0	125	0.16	5.0	235	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M8330		0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160608SR-M:M8340		0.8	205	0.18	5.0	120	0.16	5.0	190	0.18	5.0	–	–	–	50	0.13	4.0	–	–	–
ADMX 160608SR-M:M9315		0.8	305	0.18	5.0	–	–	–	285	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M9325		0.8	280	0.18	5.0	–	–	–	265	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M9340		0.8	255	0.18	5.0	150	0.16	5.0	–	–	–	–	–	–	60	0.13	4.0	–	–	–

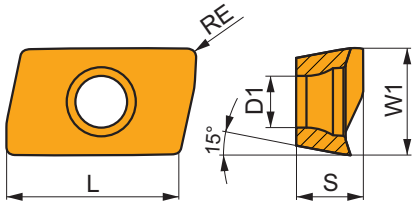
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
M 型，具有前角设计，适用于轻载到中等加工。																				
ADMX 160616SR-M:8215		1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160616SR-M:M8310		1.6	275	0.18	5.0	140	0.16	5.0	260	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160616SR-M:M8330		1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160616SR-M:M8340		1.6	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160616SR-M:M9325		1.6	310	0.18	5.0	–	–	–	290	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160620SR-M:M8330		2.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160620SR-M:M8340		2.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160630SR-M:M8330		3.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160630SR-M:M8340		3.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160632SR-M:M6330		3.2	225	0.18	5.0	155	0.16	5.0	–	–	–	–	–	–	65	0.13	4.0	–	–	–
ADMX 160632SR-M:M8330		3.2	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160632SR-M:M8340		3.2	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160632SR-M:M9325		3.2	325	0.18	5.0	–	–	–	305	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160640SR-M:M8330		4.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160640SR-M:M8340		4.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160650SR-M:M8330		5.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160650SR-M:M8340		5.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
R 型，具有正前角设计，适用于中等加工到不稳定的工况。																				
ADMX 160608PR-R:8215		0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	–	–	–	50	0.20	4.8	40	0.16	1.1
ADMX 160608PR-R:M5315		0.8	260	0.25	6.0	–	–	–	245	0.25	6.0	–	–	–	–	–	–	50	0.16	1.1
ADMX 160608PR-R:M8310		0.8	220	0.25	6.0	110	0.23	6.0	205	0.25	6.0	–	–	–	–	–	–	40	0.16	1.1
ADMX 160608PR-R:M8330		0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	–	–	–	50	0.20	4.8	40	0.16	1.1
ADMX 160608PR-R:M8340		0.8	190	0.25	6.0	110	0.23	6.0	180	0.25	6.0	–	–	–	45	0.20	4.8	–	–	–
ADMX 160608PR-R:M9315		0.8	265	0.25	6.0	–	–	–	250	0.25	6.0	–	–	–	–	–	–	50	0.16	1.1
ADMX 160608PR-R:M9325		0.8	250	0.25	6.0	–	–	–	235	0.25	6.0	–	–	–	–	–	–	50	0.16	1.1
ADMX 160616PR-R:M8330		1.6	225	0.25	6.0	135	0.23	6.0	210	0.25	6.0	–	–	–	55	0.20	4.8	45	0.16	1.1
ADMX 160616PR-R:M8340		1.6	210	0.25	6.0	125	0.23	6.0	195	0.25	6.0	–	–	–	50	0.20	4.8	–	–	–
ADMX 160616PR-R:M9315		1.6	295	0.25	6.0	–	–	–	280	0.25	6.0	–	–	–	–	–	–	55	0.16	1.1
MF 型，具有大正前角设计，适用于精加工。																				
ADMX 160608SR-MF:M6330		0.8	215	0.08	4.0	150	0.07	4.0	–	–	–	–	–	–	60	0.06	3.2	–	–	–
ADMX 160608SR-MF:M8340		0.8	225	0.08	4.0	135	0.07	4.0	–	–	–	–	–	–	55	0.06	3.2	–	–	–
ADMX 160608SR-MF:M9340		0.8	305	0.08	4.0	180	0.07	4.0	–	–	–	–	–	–	75	0.06	3.2	–	–	–
MM 型，具有大前角设计，适用于轻载到中等加工。																				
ADMX 160604SR-MM:M6330		0.4	145	0.18	4.0	105	0.16	4.0	–	–	–	–	–	–	40	0.14	3.2	–	–	–
ADMX 160604SR-MM:M8340		0.4	160	0.18	4.0	95	0.16	4.0	–	–	–	–	–	–	40	0.14	3.2	–	–	–
ADMX 160608SR-MM:M6330		0.8	175	0.18	4.0	125	0.16	4.0	–	–	–	–	–	–	50	0.14	3.2	–	–	–
ADMX 160608SR-MM:M8340		0.8	190	0.18	4.0	110	0.16	4.0	–	–	–	–	–	–	45	0.14	3.2	–	–	–
ADMX 160608SR-MM:M8345		0.8	150	0.18	4.0	90	0.16	4.0	–	–	–	–	–	–	35	0.14	3.2	–	–	–
ADMX 160608SR-MM:M9340		0.8	235	0.18	4.0	140	0.16	4.0	–	–	–	–	–	–	55	0.14	3.2	–	–	–
ADMX 160616SR-MM:M6330		1.6	195	0.18	4.0	140	0.16	4.0	–	–	–	–	–	–	55	0.14	3.2	–	–	–
ADMX 160616SR-MM:M8340		1.6	210	0.18	4.0	125	0.16	4.0	–	–	–	–	–	–	50	0.14	3.2	–	–	–
ADMX 160616SR-MM:M8345		1.6	165	0.18	4.0	95	0.16	4.0	–	–	–	–	–	–	40	0.14	3.2	–	–	–
ADMX 160616SR-MM:M9340		1.6	260	0.18	4.0	155	0.16	4.0	–	–	–	–	–	–	65	0.14	3.2	–	–	–

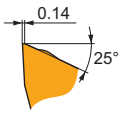
ADEX 16

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.25



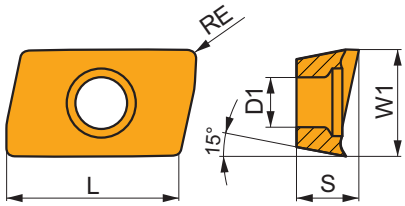
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
FM 型，具有大正前角设计，适用于中等加工。																				
ADEX 160608SR-FM:8215		0.8	260	0.16	2.0	155	0.14	2.0	245	0.16	2.0	–	–	–	65	0.11	1.6	–	–	–
ADEX 160608SR-FM:M8330		0.8	255	0.16	2.0	150	0.14	2.0	240	0.16	2.0	–	–	–	60	0.11	1.6	–	–	–
ADEX 160608SR-FM:M8340		0.8	235	0.16	2.0	140	0.14	2.0	220	0.16	2.0	–	–	–	55	0.11	1.6	–	–	–

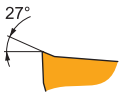
ADEX 16-FA

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.17

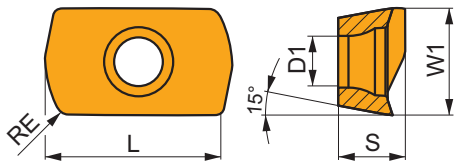


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

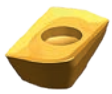
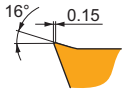
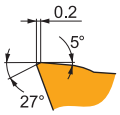
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
FA 型，具有大正前角设计，适用于精加工到中等加工。																				
ADEX 160604FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	195	0.28	6.0	–	–	–	–	–	–
ADEX 160604FR-FA:M0315	●	0.4	–	–	–	–	–	–	–	–	–	480	0.28	6.0	–	–	–	–	–	–
ADEX 160608FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	240	0.28	6.0	–	–	–	–	–	–
ADEX 160608FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	570	0.28	6.0	–	–	–	–	–	–
ADEX 160616FR-FA:HF7	●	1.6	–	–	–	–	–	–	–	–	–	255	0.28	6.0	–	–	–	–	–	–
ADEX 160616FR-FA:M0315	●	1.6	–	–	–	–	–	–	–	–	–	630	0.28	6.0	–	–	–	–	–	–
ADEX 160630FR-FA:HF7	●	3.0	–	–	–	–	–	–	–	–	–	270	0.28	6.0	–	–	–	–	–	–

ADEX 16-HF

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	5.88



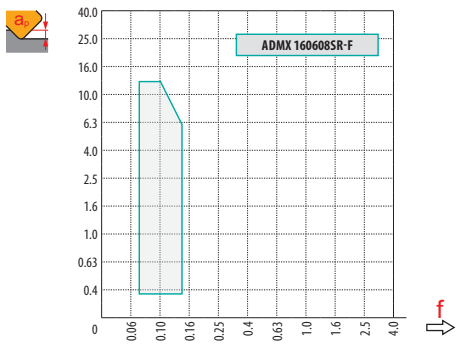
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

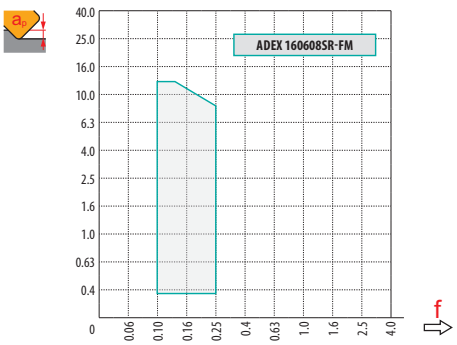
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  HFC S	**HF 型，具有大正前角设计，适用于快进给。**																			
ADEX 160612SR-HF:8215		1.2	195	1.00	0.6	115	0.90	0.6	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 160612SR-HF:M8310		1.2	205	1.00	0.6	100	0.77	0.6	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 160612SR-HF:M8330		1.2	200	1.00	0.6	120	0.90	0.6	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 160612SR-HF:M8340		1.2	185	1.00	0.6	110	0.90	0.6	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 160612SR-HF:M9340		1.2	195	1.00	0.6	115	0.90	0.6	–	–	–	–	–	–	–	–	–	–	–	–
 HFC S	**HF2 型，具有正前角设计，适用于快进给。**																			
ADEX 160612SR-HF2:M8310		1.2	205	0.90	0.6	100	0.81	0.6	190	0.90	0.6	–	–	–	–	–	–	40	0.63	0.5
ADEX 160612SR-HF2:M8330		1.2	205	0.90	0.6	120	0.81	0.6	190	0.90	0.6	–	–	–	50	0.81	0.5	40	0.63	0.5
ADEX 160612SR-HF2:M8340		1.2	190	0.90	0.6	110	0.81	0.6	180	0.90	0.6	–	–	–	45	0.81	0.5	–	–	–
ADEX 160612SR-HF2:M9325		1.2	230	0.90	0.6	–	–	–	215	0.90	0.6	–	–	–	–	–	–	45	0.63	0.5

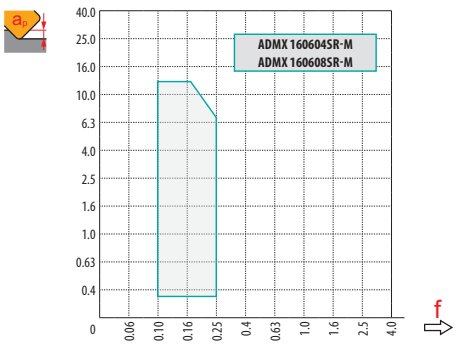
a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

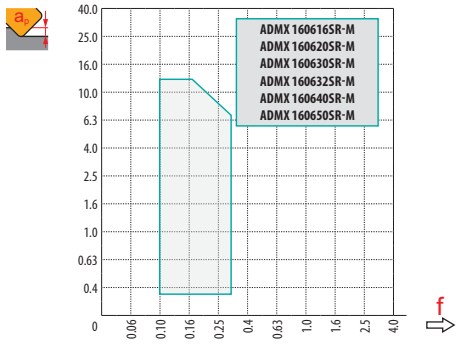
	ADMX 16-F	ADEX 16-FM	ADMX 16-M								ADMX 16-R	
RE	0.8	0.8	0.4	0.8	1.6	2.0	3.0	3.2	4.0	5.0	0.8	1.6
BS	2.99	2.18	3.39	2.99	1.62	1.23	0.28	0.09	2.69	1.52	2.99	1.62

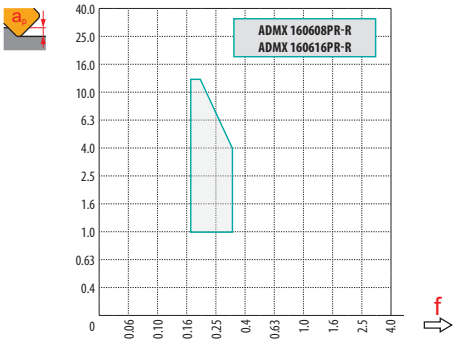
	ADMX 16-MF	ADMX 16-MM			ADEX 16-HF	ADEX 16-HF2	ADEX 16-FA			
RE	0.8	0.4	0.8	1.6	1.2	1.2	0.4	0.8	1.6	3.0
BS	2.99	3.39	2.99	1.62	0.52	0.52	2.84	2.44	1.65	0.69

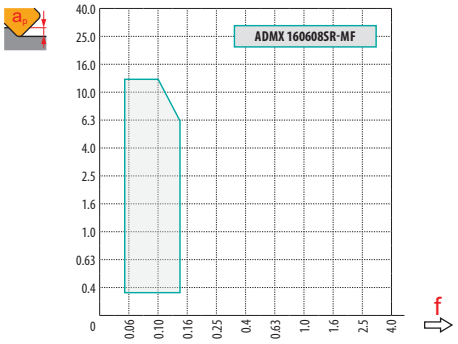


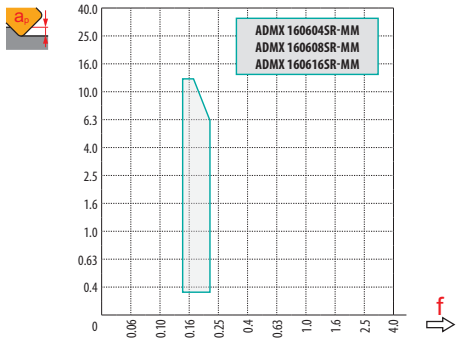


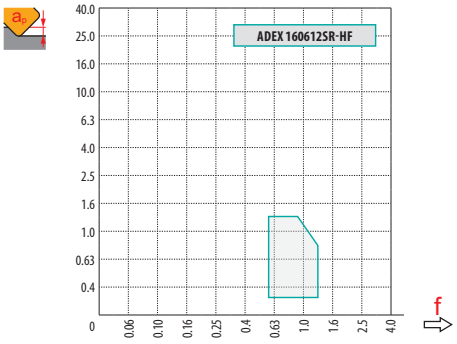


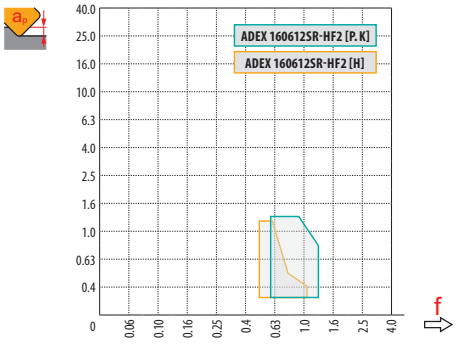


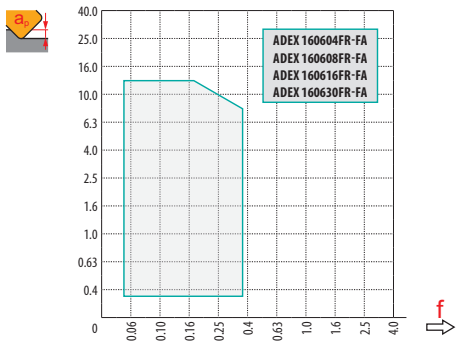












max

7.5

a_p	1.0	6.0	13.0
f	0.28	0.19	0.10

DC	RPMX	APMX/l
25	12.5°	13.0/60
32	7.5°	13.0/100
40	5.0°	8.6/100
50	3.5°	6.0/100
63	2.5°	4.2/100
80	2.0°	3.3/100

HFC

DC	RPMX *	RPMX **	APMX/l
25	4.0°	8.0°	1.3/19
32	2.0°	7.5°	1.3/38
40	1.2°	4.5°	1.3/65
50	0.8°	3.0°	1.3/100
63	0.5°	2.0°	0.8/100
80	0.4°	1.5°	0.6/100

* 氢氟碳化物研磨
** 传统的研磨

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	42.0	50.0	10.0	12.5
32	55.0	64.0	6.5	9.0
40	72.0	80.0	5.0	8.0
50	92.0	100.0	4.5	6.0
63	118.0	126.0	4.0	5.0
80	136.0	160.0	1.5	2.0

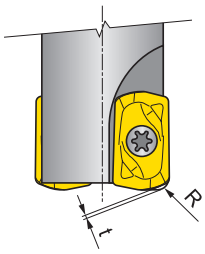
HFC				
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	42.0	50.0	1.3	1.3
32	55.0	64.0	1.3	1.3
40	72.0	80.0	1.3	1.3
50	92.0	100.0	1.3	1.3
63	118.0	126.0	1.3	1.3
80	136.0	160.0	1.3	1.3

a_p
2.5

DC	µm	3	5	10	15	20	30	40	50	60	80	100
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

RE	µm	3	5	10	15	20	30	40	50	60	80	100
1.6	FE	0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549
3.2		0.277	0.358	0.506	0.620	0.716	0.876	1.012	1.131	1.239	1.431	1.600
4.0		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
5.0		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000

ADMX/ADEX 16	R
ADMX 160630SR-M	2.5
ADMX 160632SR-M	2.5
ADMX 160640SR-M	4.0
ADMX 160650SR-M	4.5
ADEX 160612SR-HF	3.0
ADEX 160612SR-HF2	3.0



ADEX 16	R	t
ADEX 160612SR-HF	2.59	0.56
ADEX 160612SR-HF2	2.48	0.57

SAP10D

P M K N S

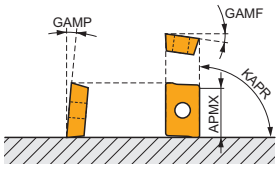
PRAMET

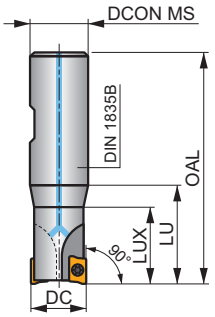
S

方肩铣刀使用APKT 10刀片，带内冷

90°方肩铣刀和面铣刀，使用正前角APKT　10类型刀片，具有APMX(最大切深)9mm。适用于面铣，方肩铣，铣槽，螺旋铣削，摆线加工，坡走铣和插铣。可提供侧固柄和芯轴式(具有不等齿距)类型。刀体经过处理，使用寿命更长。

KAPR	90°
APMX	9.0 mm





h_m	0.06 - 0.13
h_m	0.08 - 0.16

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	10A1R020B16-SAP10D-C	10	78	16	–	30	20	–	–	–	12	2	1	–	39000	✓	0.09	GI081	SQ215
	12A1R027B16-SAP10D-C	12	75	16	–	27	–	–	–	–	12	2	1	–	35600	✓	0.10	GI081	SQ210
	16A2R032B16-SAP10D-C	16	80	16	–	32	–	–	–	–	12	4	2	–	30800	✓	0.12	GI081	SQ210
	20A3R032B20-SAP10D-C	20	82	20	–	32	–	–	–	–	12	4	3	–	27600	✓	0.13	GI081	SQ210
	25A3R042B25-SAP10D-C	25	98	25	–	42	–	–	–	–	12	4	3	–	24700	✓	0.36	GI081	SQ210

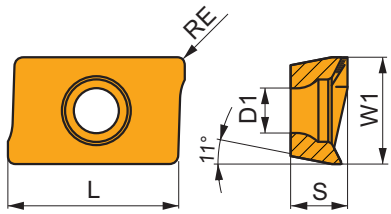
GI081	APKT 1003..

		Nm			
SQ210	US 2506-T07P	1.2	M 2.5	6.3	Flag T07P
SQ215	US 2505-T07P	1.2	M 2.5	5.2	Flag T07P

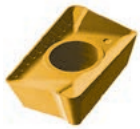
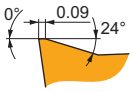
APKT 10

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1003	6.700	2.88	11.00	3.50



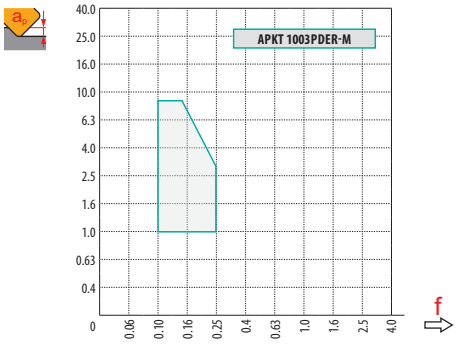
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
APKT 1003PDER-M:8215		0.5	285	0.12	4.0	170	0.11	4.0	270	0.12	4.0	–	–	–	70	0.11	3.2	–	–	–
APKT 1003PDER-M:M8330		0.5	285	0.12	4.0	170	0.11	4.0	270	0.12	4.0	–	–	–	70	0.11	3.2	–	–	–
APKT 1003PDER-M:M8340		0.5	255	0.12	4.0	150	0.11	4.0	240	0.12	4.0	–	–	–	60	0.11	3.2	–	–	–
APKT 1003PDER-M:M9325		0.5	360	0.12	4.0	–	–	–	340	0.12	4.0	–	–	–	–	–	–	–	–	–
APKT 1003PDER-M:M9340		0.5	335	0.12	4.0	200	0.11	4.0	–	–	–	–	–	–	80	0.11	3.2	–	–	–

M 型，具有大前角设计，适用于轻载到中等加工。

a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	APKT 10-M
RE	0.5
BS	0.84



max.
4.5

a_p	1.0	3.0	5.0
1 ⇨ f	0.20	0.13	0.10

DC	RPMX	APMX/I
10	7.3°	9.0/72
12	6.2°	9.0/84
16	2.4°	4.0/100
20	2.2°	3.7/100
25	2.2°	3.7/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
10	11.0	20.0	0.4	3.8
12	13.0	24.0	0.3	3.9
16	20.5	32.0	0.6	2.0
20	27.2	40.0	0.9	2.4
25	37.9	50.0	1.6	3.0

a_p
0.3

SAP16D

P M K N S

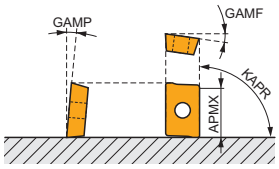
PRAMET

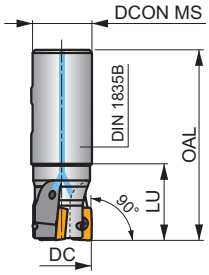
S

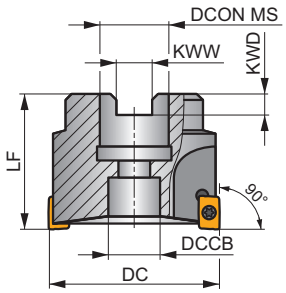
方肩铣刀使用APKT 16刀片，带内冷

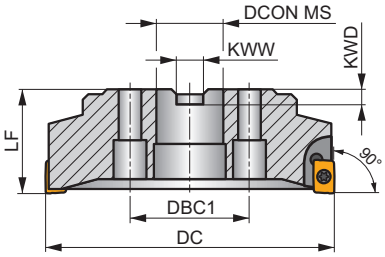
90⊠方肩铣刀和面铣刀，使用正前角APKT 16类型刀片，具有APMX(最大切深)13mm。适用于面铣，方肩铣，铣槽，螺旋铣削，摆线加工，坡走铣和插铣。可提供侧固柄和芯轴式(具有不等齿距)类型。刀体经过处理，使用寿命更长。

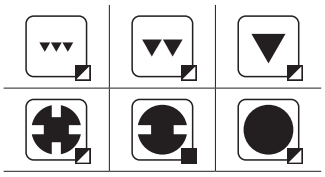
KAPR	90°
APMX	13.0 mm











h_m	0.06 - 0.18
h_m	0.10 - 0.22

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	25A2R042B25-SAP16D-C	25	98	25	–	–	42	–	–	–	0	6	2	–	16800	✓	0.31	GI080	SQ030	–
	32A3R040B32-SAP16D-C	32	100	32	–	–	50	–	–	–	0	8	3	–	14800	✓	0.51	GI080	SQ220	–
	40A4R050B32-SAP16D-C	40	110	32	–	–	50	–	–	–	0	8	4	–	13200	✓	0.67	GI080	SQ220	–
ISO 6462 DIN 8030	40A4R-S90AP16D	40	40	16	11	–	–	40	8.4	5.6	0	6	4	✓	13200	–	0.23	GI080	SQ031	–
	50A5R-S90AP16D	50	40	22	18	–	–	40	10.4	6.3	0	6	5	✓	11800	–	0.35	GI080	SQ031	–
	63A6R-S90AP16D	63	40	22	18	–	–	40	10.4	6.3	0	6	6	✓	10600	–	0.50	GI080	SQ031	–
	80B5R-S90AP16D	80	50	27	38	–	–	50	12.4	7	0	6	5	✓	9400	–	0.97	GI080	SQ031	AC001
	80B7R-S90AP16D	80	50	27	38	–	–	50	12.4	7	0	6	7	✓	9400	–	0.99	GI080	SQ031	AC001
	100B8R-S90AP16D	100	50	32	45	–	–	50	14.4	8	0	6	8	✓	8400	–	1.50	GI080	SQ031	AC002
	125B9R-S90AP16D	125	63	40	56	–	–	63	16.4	9	0	6	9	✓	7500	–	2.80	GI080	SQ031	AC003

GI080	APKT 1604..	APET 1604..

		Nm					
SQ030	US 4008-T15P	3.5	M 4	8	–	–	Flag T15P
SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–
SQ220	US 4011-T15P	3.5	M 4	10.6	–	–	Flag T15P

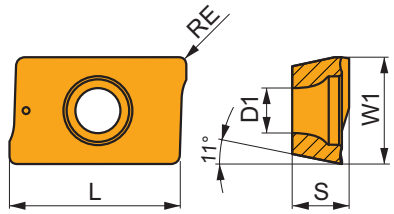
AC001	KS 1230	K.FMH27

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

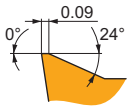
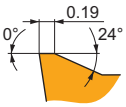
APKT 16

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.440	4.60	17.00	5.67



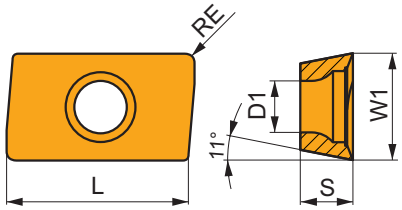
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
GM 型，具有大前角设计，适用于轻载到中等加工。																				
APKT 1604PDR-GM:M8330		0.8	235	0.20	8.0	140	0.18	8.0	220	0.20	8.0	–	–	–	55	0.16	6.4	–	–	–
APKT 1604PDR-GM:M8340		0.8	210	0.20	8.0	125	0.18	8.0	195	0.20	8.0	–	–	–	50	0.16	6.4	–	–	–
APKT 1604PDR-GM:M9315		0.8	310	0.20	8.0	–	–	–	290	0.20	8.0	–	–	–	–	–	–	–	–	–
APKT 1604PDR-GM:M9325		0.8	285	0.20	8.0	–	–	–	270	0.20	8.0	–	–	–	–	–	–	–	–	–
APKT 1604PDR-GM:M9340		0.8	260	0.20	8.0	155	0.18	8.0	–	–	–	–	–	–	65	0.16	6.4	–	–	–
																				
HM 型，具有大正前角设计，适用于中等且不稳定的工况。																				
APKT 160404-HM:M8340		0.4	160	0.30	6.0	95	0.27	6.0	150	0.30	6.0	–	–	–	40	0.24	4.8	–	–	–
APKT 160416-HM:M8340		1.6	210	0.30	6.0	125	0.27	6.0	195	0.30	6.0	–	–	–	50	0.24	4.8	–	–	–
APKT 160431-HM:M8340		3.1	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	–	–	–	55	0.24	4.8	–	–	–
APKT 1604PDR-HM:8215		0.8	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	–	–	–	55	0.24	4.8	–	–	–
APKT 1604PDR-HM:M5315		0.8	270	0.30	6.0	–	–	–	255	0.30	6.0	–	–	–	–	–	–	–	–	–
APKT 1604PDR-HM:M8330		0.8	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	–	–	–	55	0.24	4.8	–	–	–
APKT 1604PDR-HM:M8340		0.8	200	0.30	6.0	120	0.27	6.0	190	0.30	6.0	–	–	–	50	0.24	4.8	–	–	–
APKT 1604PDR-HM:M9325		0.8	260	0.30	6.0	–	–	–	245	0.30	6.0	–	–	–	–	–	–	–	–	–

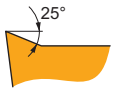
APET 16-FA

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.600	4.50	17.00	4.76



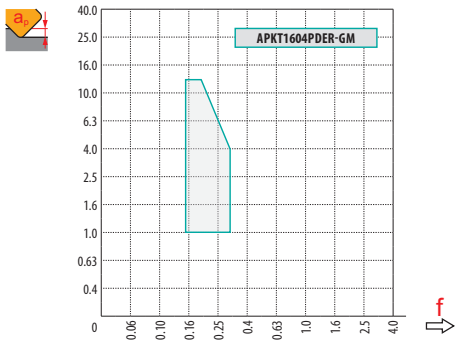
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

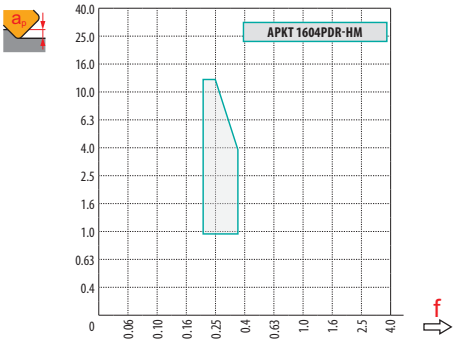
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
APET 160408FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 255	0.24	8.0	–	–	–	–	–	–

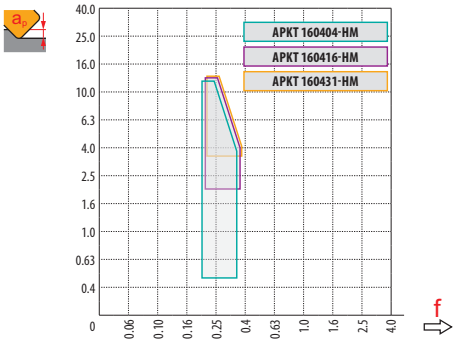
FA 型，具有大正前角设计，适用于精加工到中等加工。

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	APKT 16-GM	APKT 16-HM			
RE	0.8	0.4	0.8	1.6	3.1
BS	1.39	1.87	1.48	0.64	1.30







max
7.4

a_p	1.0	6.0	13.0
1 ⇨ f	0.28	0.19	0.13

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	34.7	50.0	1.2	3.1
32	48.5	64.0	0.9	1.7
40	63.5	80.0	1.3	2.2
50	83.5	100.0	0.9	1.4
63	110.0	126.0	1.0	1.4
80	144.0	160.0	1.1	1.3

DC	RPMX	APMX/I
25	2.3	3.9/100
32	1.0	1.6/100
40	1.0	1.6/100
50	0.5	0.7/100
63	0.4	0.5/100
80	0.3	0.4/100

a_p
0.2

平面铣

	SSO09	SSD12	FTB27X			
	90°	90°	90°			
	APMX (mm) 8.0	APMX (mm) 10.0	APMX (mm) 18.0			
	DC (mm) 20 – 80	DC (mm) 50 – 160	DC (mm) 175, 260			
圆柱刀柄						
侧固刀柄	DC = 20 – 32 (mm)					
模块式刀柄						
套式铣刀	DC = 40 – 80 (mm)					
页码	122	125	128			
ISO	P M K S	P M K N S	P M K			
刀片形状						
刀片	SOMT 09T3	SDMT 1205	TBMR 2707			
切削刃数量	4	4	3			
浅方肩铣	■	■	■			
浅槽铣	■	■	◪			
插铣	■	■				
平面铣	◪	◪	◪			

■ 推荐使用　◪ 可以使用

SSO09

P M K S

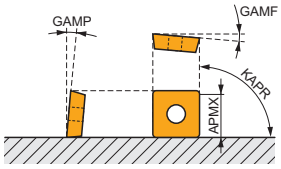
PRAMET

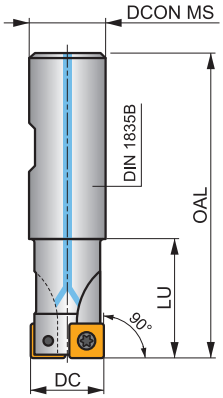
S

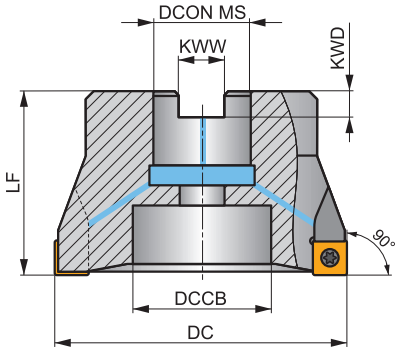
90° 方肩铣刀使用SOMT 09刀片，带内冷

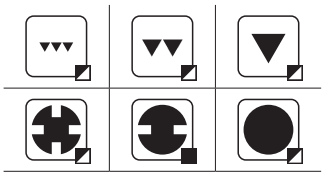
90°方肩铣刀和面铣刀，使用正前角SOMT 09刀片，具有APMX(最大切深)8mm。适用于面铣，方肩铣，铣槽和插铣。可提供侧固柄和芯轴式类型。提供不等齿距。刀体经过处理，使用寿命更长。

KAPR	90°
APMX	8.0 mm









h_m	0.07 - 0.18
h_m	0.07 - 0.22

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	20A2R032B20-SSO09-C	20	82	20	–	32	–	–	–	-12	6	2	–	23800	✓	0.21	GI146	SQ400	–
	25A3R042B25-SSO09-C	25	98	25	–	42	–	–	–	-12	6	3	–	21300	✓	0.31	GI146	SQ400	–
	32A4R042B32-SSO09-C	32	102	32	–	42	–	–	–	-10	10	4	✓	18800	✓	0.55	GI146	SQ400	–
ISO 6462 DIN 8030	40A05R-S90SO09-C	40	–	16	14	–	40	8.4	5.6	-9.1	10	5	–	16800	✓	0.29	GI146	SQ402	–
	50A06R-S90SO09-C	50	–	22	18	–	40	10.4	6.4	-8.8	10	6	–	15100	✓	0.33	GI146	SQ403	–
	63A07R-S90SO09-C	63	–	22	18	–	40	10.4	6.4	-8.6	10	7	–	13400	✓	0.62	GI146	SQ403	–
	80A09R-S90SO09-C	80	–	27	38	–	50	12.4	7	-8.1	10	9	–	11900	✓	1.03	GI146	SQ401	AC001

GI146	SOMT 09T3..

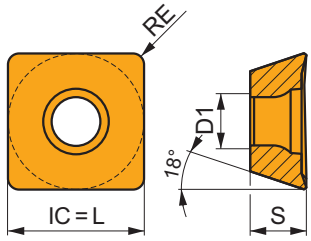
		Nm						
SQ400	US 3006-T09P	2.0	M 3	6	–	–	Flag T09P	–
SQ401	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	–
SQ402	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ403	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	HS 1030C

AC001	KS 1230	K.FMH27

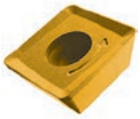
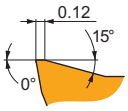
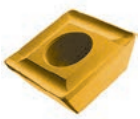
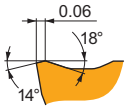
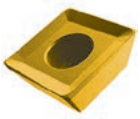
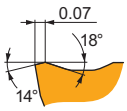
SOMT 09

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.550	3.50	9.55	3.97

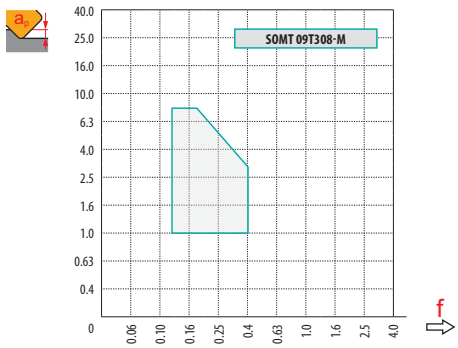


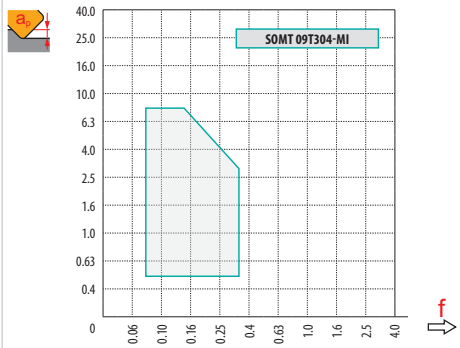
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。当设置角度为90°条件时，参考我们的Machining Calculator app，以获得进一步的计算。

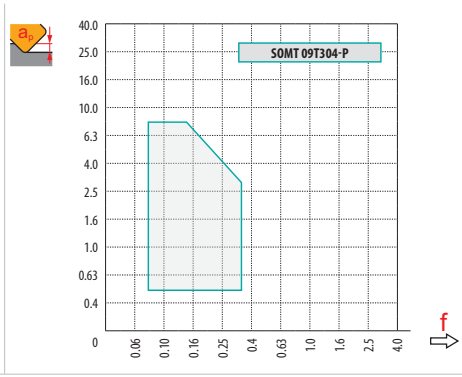
产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
M 型，具有正前角设计，适用于中等加工。																				
SOMT 09T308-M:8215	⊛	0.8	■	275	0.14	2.5	◪	165	0.13	2.5	◪	260	0.14	2.5	–	–	–	◪	65	0.13	2.0	–	–	–
SOMT 09T308-M:M5315	⊛	0.8	◪	390	0.14	2.5		–	–	–	◪	370	0.14	2.5	–	–	–		–	–	–	–	–	–
SOMT 09T308-M:M8330	⊛	0.8	■	270	0.14	2.5	■	160	0.13	2.5	◪	255	0.14	2.5	–	–	–	◪	65	0.13	2.0	–	–	–
SOMT 09T308-M:M8340	⊛	0.8	■	250	0.14	2.5	■	150	0.13	2.5	◪	235	0.14	2.5	–	–	–	◪	60	0.13	2.0	–	–	–
SOMT 09T308-M:M9315	⊛	0.8	■	380	0.14	2.5		–	–	–	◪	360	0.14	2.5	–	–	–		–	–	–	–	–	–
 																				
MI 型，具有稳定的正前角设计，适用于中等加工。																				
SOMT 09T304-MI:8215	●	0.4	■	230	0.14	2.5	◪	135	0.13	2.5	◪	215	0.14	2.5	–	–	–	◪	55	0.10	2.0	–	–	–
SOMT 09T304-MI:M8310	●	0.4	■	255	0.14	2.5	◪	130	0.13	2.5	◪	240	0.14	2.5	–	–	–		–	–	–	–	–	–
SOMT 09T304-MI:M8330	●	0.4	■	230	0.14	2.5	■	135	0.13	2.5	◪	215	0.14	2.5	–	–	–	◪	55	0.10	2.0	–	–	–
SOMT 09T304-MI:M8340	⊛	0.4	■	210	0.14	2.5	■	125	0.13	2.5	◪	195	0.14	2.5	–	–	–	◪	50	0.10	2.0	–	–	–
SOMT 09T304-MI:M9315	●	0.4	■	320	0.14	2.5		–	–	–	◪	300	0.14	2.5	–	–	–		–	–	–	–	–	–
SOMT 09T304-MI:M9340	●	0.4	■	265	0.14	2.5	■	155	0.13	2.5		–	–	–	–	–	–	◪	65	0.10	2.0	–	–	–
 																				
P 型，具有大正前角设计，适用于中等加工。																				
SOMT 09T304-P:M8330	●	0.4	■	250	0.14	2.5	◪	150	0.13	2.5	◪	235	0.14	2.5	–	–	–	◪	60	0.10	2.0	–	–	–
SOMT 09T304-P:M8340	●	0.4	■	230	0.14	2.5	◪	135	0.13	2.5	◪	215	0.14	2.5	–	–	–	◪	55	0.10	2.0	–	–	–
SOMT 09T304-P:M9325	●	0.4	■	320	0.14	2.5		–	–	–	◪	300	0.14	2.5	–	–	–		–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SOMT 09-M	SOMT 09-MI	SOMT 09-P
RE	0.8	0.4	0.4
BS	0.90	1.30	1.30







max
6.0

a_p	1.0	4.0	8.0
1 ⇨ f	0.28	0.19	0.09

SSD12

P M K N S

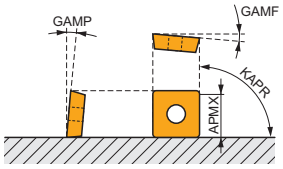
PRAMET

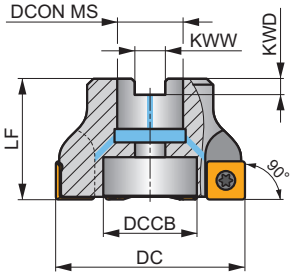
S

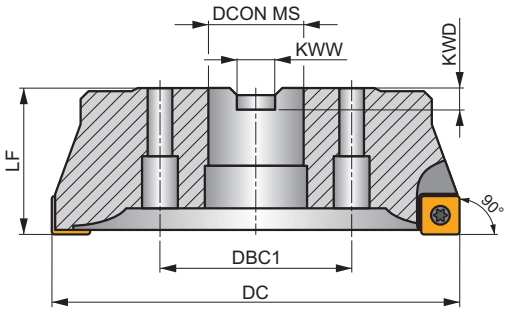
90° 方肩铣刀使用SDMT 12刀片，带内冷

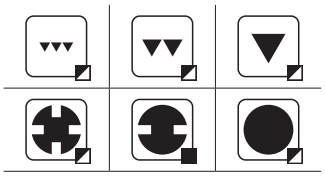
90°面铣，使用正前角SDMT 12刀片，具有APMX(最大切深)10mm。适用于面铣，方肩铣，铣槽和插铣。只提供芯轴式类型。刀体经过处理，使用寿命更长。

KAPR	90°
APMX	10.0 mm









h_m 0.09 - 0.25

	产品	DC (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	50A05R-S90SD12-C	50	40	22	18	–	10.4	6.3	-5	8	5	–	13000	✓	0.34	GI057	SQ413	–
	63A06R-S90SD12-C	63	40	22	18	–	10.4	6.3	-5	8	6	–	11600	✓	0.53	GI057	SQ413	–
	80A06R-S90SD12-C	80	50	27	38	–	12.4	7	-5	8	6	–	10300	✓	1.16	GI057	SQ411	AC001
	100A08R-S90SD12-C	100	50	32	45	–	14.4	8	-5	8	8	–	9200	✓	1.69	GI057	SQ411	AC002
	125A09R-S90SD12-C	125	63	40	56	–	16.4	9	-5	8	9	–	8300	✓	3.19	GI057	SQ411	AC003
	160C12R-S90SD12	160	63	40	–	66.7	16.4	9	-5	8	12	–	7300	–	5.70	GI057	SQ411	–

GI057	SDMT 1205..

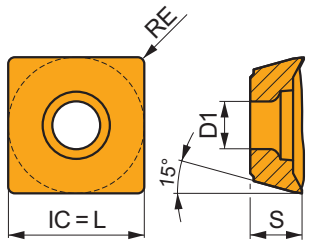
					Nm					
SQ411	SSN 100312	MS 3510	HXK 3.5	US 3511-T15	3.0	M 3.5	11	D-T07/T15	FG-15	–
SQ413	–	–	–	US 3511-T15	3.0	M 3.5	11	D-T07/T15	FG-15	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

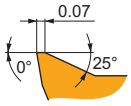
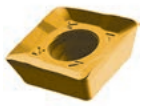
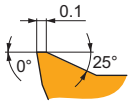
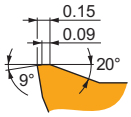
SDMT 12

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1205	12.700	4.40	12.70	5.00

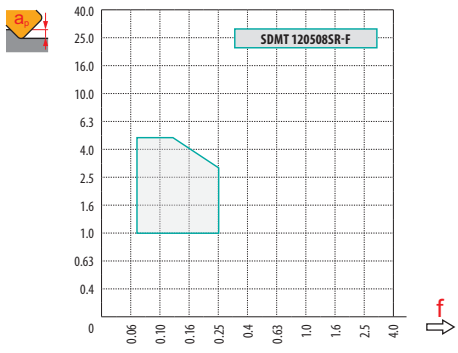


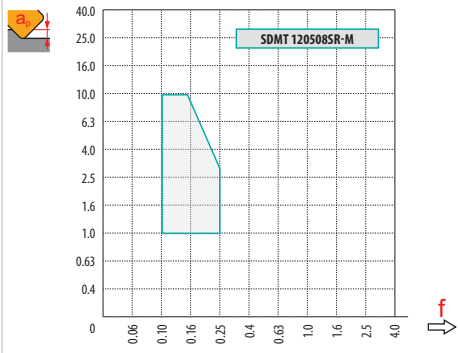
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

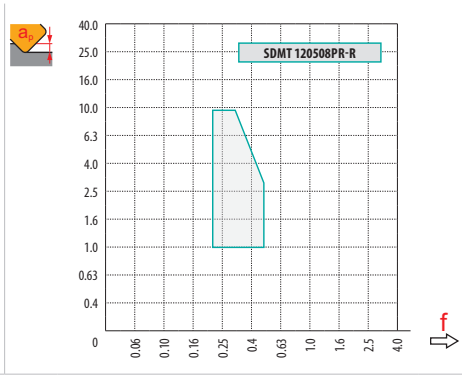
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F 型，具有正前角设计，适用于轻载到中等加工。																				
SDMT 120508SR-F:M8330		0.8	275	0.10	3.0	165	0.09	3.0	260	0.10	3.0	825	0.12	3.0	65	0.08	2.4	–	–	–
SDMT 120508SR-F:M8340		0.8	250	0.10	3.0	150	0.09	3.0	235	0.10	3.0	–	–	–	60	0.08	2.4	–	–	–
																				
M 型，具有前角设计，适用于轻载到中等加工。																				
SDMT 120508SR-M:8215		0.8	245	0.16	3.5	145	0.14	3.5	230	0.16	3.5	–	–	–	60	0.11	2.8	–	–	–
SDMT 120508SR-M:M8330		0.8	240	0.16	3.5	140	0.14	3.5	225	0.16	3.5	–	–	–	60	0.11	2.8	–	–	–
SDMT 120508SR-M:M8340		0.8	220	0.16	3.5	130	0.14	3.5	205	0.16	3.5	–	–	–	55	0.11	2.8	–	–	–
SDMT 120508SR-M:M9325		0.8	305	0.16	3.5	–	–	–	285	0.16	3.5	–	–	–	–	–	–	–	–	–
																				
R 型，具有稳定的正前角设计，适用于中等加工。																				
SDMT 120508PR-R:M8330		0.8	220	0.25	3.5	130	0.23	3.5	205	0.25	3.5	–	–	–	55	0.23	2.8	–	–	–
SDMT 120508PR-R:M8340		0.8	195	0.25	3.5	115	0.23	3.5	185	0.25	3.5	–	–	–	45	0.23	2.8	–	–	–
SDMT 120508PR-R:M9315		0.8	280	0.25	3.5	–	–	–	265	0.25	3.5	–	–	–	–	–	–	–	–	–
SDMT 120508PR-R:M9325		0.8	265	0.25	3.5	–	–	–	250	0.25	3.5	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SDMT 12-F	SDMT 12-M	SDMT 12-R
RE	0.8	0.8	0.8
BS	–	–	–







max.
8.0

a_p	1.0	5.0	10.0
1 ⇨ f	0.39	0.25	0.14

FTB27X

P M K

PRAMET

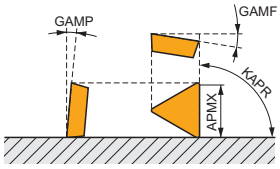
F

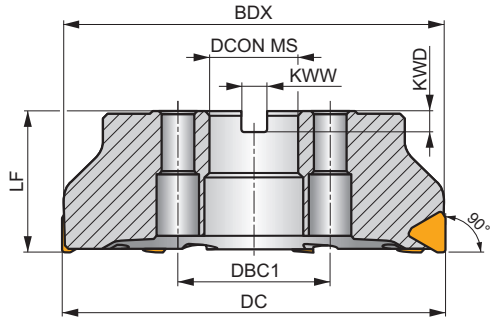
粗加工TB方肩面铣刀，使用TBMR 27刀片，适用于重载铣削

90°面铣，使用正前角TBMR 27刀片，具有APMX(最大切深)18mm。适用于重载面铣，方肩铣和铣槽。只提供芯轴式类型，具有不等齿距，刀体经过处理，使用寿命更长。

ROUGH TB

KAPR	90°
APMX	18.0 mm





h_m 0.15 - 0.38

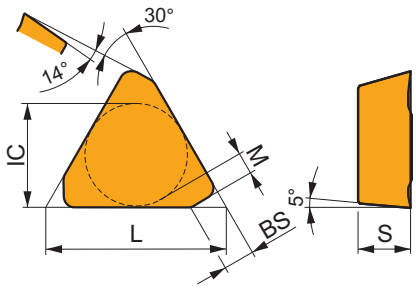
	产品	DC (mm)	BDX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	175C08R-F90TB27X	175	169.6	63	40	–	66.7	16.4	16.4	-9	9	8	✓	–	–	7.59	GI163	SQ424	–
	260C12R-F90TB27X	260	253.4	63	60	–	101.6	25.7	25.7	-9	9	12	✓	–	–	18.21	GI163	SQ425	–

GI163	TBMR 2707PZ..

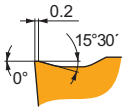
SQ424	LNK 220616	US 6013-T20P	SDR T20P-T	KU TBMR 2707	DS 01Z	KL 04	HS 1240
SQ425	LNK 220616	US 6013-T20P	SDR T20P-T	KU TBMR 2707	DS 01Z	KL 04	HS 1655

TBMR 27

	BS (mm)	IC (mm)	L (mm)	M (mm)	S (mm)
2707	4.61	15.875	27.50	3.2	7.94



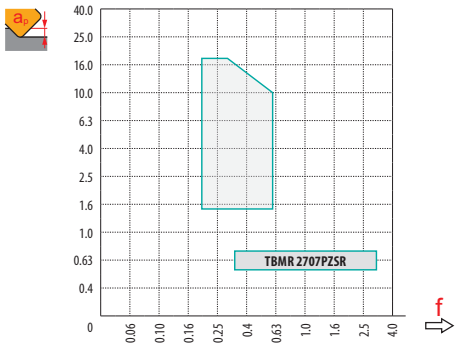
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
TBMR 2707PZSR:M8326		–	130	0.20	11.0	–	–	–	120	0.20	11.0	–	–	–	–	–	–	–	–	–
TBMR 2707PZSR:M8346		–	110	0.20	11.0	65	0.20	11.0	–	–	–	–	–	–	–	–	–	–	–	–

PZSR 强壮的设计，适用于重载加工。

a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TBMR 27
RE	–
BS	2.70



a_e	1.5	8.0	18.0
⇨ f	0.60	0.39	0.24

深方肩铣削

平面铣

	J(T)-SAD11E	J(T)-SAD16E	J(T)-SSAP	J(T)-CSD12X	J(T)-SLSN
	90°	90°	90°	90°	90°
	APMX (mm) 37.0 – 56.0	APMX (mm) 40.0 – 108.0	APMX (mm) 58.0 – 95.0	APMX (mm) 44.1 – 87.3	APMX (mm) 104.0 – 134.0
	DC (mm) 25 – 50	DC (mm) 50 – 100	DC (mm) 50 – 80	DC (mm) 40 – 80	DC (mm) 63, 80
圆柱刀柄	DC = 25 – 40 (mm)				
侧固刀柄	DC = 25 – 40 (mm)			DC = 50 (mm)	
模块式刀柄		DC = 50 – 80 (mm)		DC = 40 – 63 (mm)	
套式铣刀	DC = 50 (mm)	DC = 50 – 100 (mm)		DC = 50 – 80 (mm)	
页码	134	139	145	150	153
ISO	P M K N S H	P M K N S H	P M K N S H	P M S	P K
刀片形状					
刀片	AD 11T3	AD.. 1606	APE. 150412 SPE. 1204	SD.X 1205	LNET 1606 SN.. 1305
切削刃数量	2	2	2 / 4	4	2 / 8
深方肩铣	■	■	■	■	■
深槽铣	■	■	■	■	■
平面铣	◪	◪	◪	◪	◪
插铣	◪	◪	◪		◪

■ 推荐使用　◪ 可以使用

J(T)-SAD11E

P M K N S

PRAMET

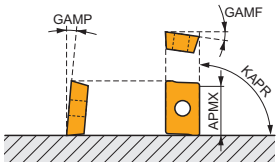
S

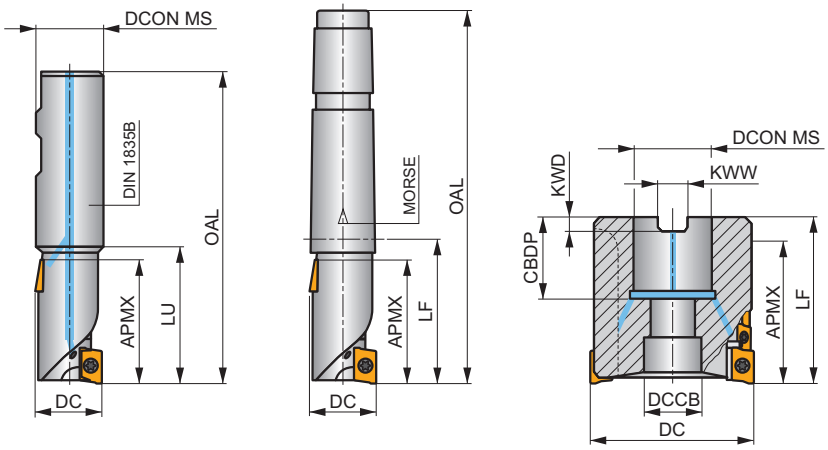
螺旋AD11长刃铣刀，带内冷

90°长刃方肩铣刀，使用正前角ADMX　11刀片，具有APMX(最大切深)36至56mm，具有内冷。适用于方肩铣，铣槽，面铣或插铣。可提供侧固柄，莫氏锥柄和芯轴式类型。刀体经过处理，使用寿命更长。

FORCE AD

KAPR	90°
APMX	37.0 - 56.0 mm





h_m	0.05 - 0.08
h_m	0.05 - 0.08

	製品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	APMX (mm)	CBDP (mm)	CZC MS	GAMF (°)	GAMP (°)	NOF			max.		kg		
DIN 1835B	25J2R50B25-SAD11E38-C	25	106	25	–	50	–	38.00	–	–	-10.5	5	2	8	–	24100	✓	0.32	GI184	SQ210
	32J2R60B32-SAD11E47-C	32	120	32	–	60	–	47.00	–	–	-9	8	2	10	–	21300	✓	0.60	GI184	SQ210
	40J2R60B40-SAD11E47-C	40	130	40	–	60	–	47.00	–	–	-8.1	11	2	10	–	19100	✓	1.07	GI184	SQ210
	40J3R70B32-SAD11E56-C	40	130	32	–	70	–	56.00	–	–	-8.1	11	3	18	–	19100	✓	0.76	GI184	SQ210
	40J3R70B40-SAD11E56-C	40	140	40	–	70	–	56.00	–	–	-8.1	11	3	18	–	19100	✓	1.07	GI184	SQ210
DIN 228A	25J2R55E03-SAD11E38-C	25	136	–	–	–	55	38.00	–	3	-10.5	5	2	8	–	24100	✓	0.32	GI184	SQ210
	32J2R65E04-SAD11E47-C	32	167.5	–	–	–	65	47.00	–	4	-9	8	2	10	–	21300	✓	0.71	GI184	SQ210
	40J3R75E04-SAD11E56-C	40	177.5	–	–	–	75	56.00	–	4	-8.1	11	3	18	–	19100	✓	0.85	GI184	SQ210
ISO 6462 DIN 8030	50T03R-S90AD11E37-C	50	–	22	18	–	58	37.00	21	–	-7.2	12	3	12	–	17000	✓	0.66	GI184	SQ903

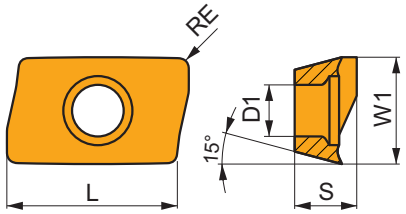
GI184	ADMX 11T3..	ADEX 11T3..-FA

		Nm						
SQ210	US 2506-T07P	1.2	M 2.5	6.3	–	–	Flag T07P	–
SQ903	US 2506-T07P	1.2	M 2.5	6.3	D-T07P/T09P	FG-15	–	HS 1030C

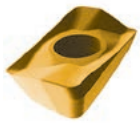
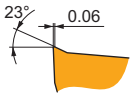
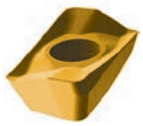
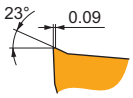
ADMX 11

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.530	2.90	11.00	3.97

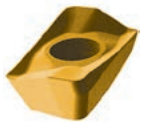


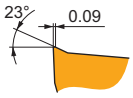
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  **F 型，具有非常锋利正前角设计，适用于轻载加工。**																				
ADMX 11T304SR-F:8215	●	0.4	245	0.10	2.0	145	0.09	2.0	230	0.10	2.0	735	0.12	2.0	60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8330	●	0.4	240	0.10	2.0	140	0.09	2.0	225	0.10	2.0	720	0.12	2.0	60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8340	●	0.4	220	0.10	2.0	130	0.09	2.0	205	0.10	2.0	–	–	–	55	0.08	1.6	–	–	–
ADMX 11T304SR-F:M9340	●	0.4	285	0.10	2.0	170	0.09	2.0	–	–	–	–	–	–	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:8215	⇕	0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8330	⇕	0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8340	⇕	0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	–	–	–	65	0.08	1.6	–	–	–
ADMX 11T308SR-F:M9340	⇕	0.8	340	0.10	2.0	200	0.09	2.0	–	–	–	–	–	–	85	0.08	1.6	–	–	–
  **M 型，具有前角设计，适用于轻载到中等加工。**																				
ADMX 11T302SR-M:M8330	●	0.2	190	0.15	4.0	110	0.14	4.0	180	0.15	4.0	–	–	–	45	0.12	3.2	–	–	–
ADMX 11T302SR-M:M8340	⇕	0.2	170	0.15	4.0	100	0.14	4.0	160	0.15	4.0	–	–	–	40	0.12	3.2	–	–	–
ADMX 11T304SR-M:8215	●	0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	–	–	–	50	0.12	3.2	–	–	–
ADMX 11T304SR-M:M8310	●	0.4	220	0.15	4.0	110	0.14	4.0	205	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T304SR-M:M8330	⇕	0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	–	–	–	50	0.12	3.2	–	–	–
ADMX 11T304SR-M:M8340	⇕	0.4	185	0.15	4.0	110	0.14	4.0	175	0.15	4.0	–	–	–	45	0.12	3.2	–	–	–
ADMX 11T304SR-M:M9325	●	0.4	255	0.15	4.0	–	–	–	240	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T304SR-M:M9340	●	0.4	235	0.15	4.0	140	0.14	4.0	–	–	–	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T308SR-M:8215	⇕	0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T308SR-M:M5315	⇕	0.8	335	0.15	4.0	–	–	–	315	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M8310	⇕	0.8	265	0.15	4.0	135	0.14	4.0	250	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M8330	⇕	0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T308SR-M:M8340	⇕	0.8	220	0.15	4.0	130	0.14	4.0	205	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T308SR-M:M9315	⇕	0.8	330	0.15	4.0	–	–	–	310	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M9325	⇕	0.8	305	0.15	4.0	–	–	–	285	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M9340	⇕	0.8	275	0.15	4.0	165	0.14	4.0	–	–	–	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T310SR-M:M8330	⇕	1.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T310SR-M:M8340	✱	1.0	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T312SR-M:8215	⇕	1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T312SR-M:M8330	✱	1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T312SR-M:M8340	✱	1.2	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T316SR-M:8215	⇕	1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M6330	✱	1.6	230	0.15	4.0	165	0.14	4.0	–	–	–	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M8310	⇕	1.6	295	0.15	4.0	150	0.14	4.0	280	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T316SR-M:M8330	✱	1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M8340	✱	1.6	240	0.15	4.0	140	0.14	4.0	225	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T320SR-M:M6330	✱	2.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T320SR-M:M8330	✱	2.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T320SR-M:M8340	✱	2.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

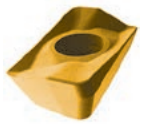
製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)

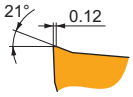




M 型，具有前角设计，适用于轻载到中等加工。

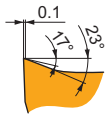
ADMX 11T325SR-M:M6330	✱	2.5	■	240	0.15	4.0	■	170	0.14	4.0		–	–	–		–	–	–	◪	70	0.12	3.2		–	–	–
ADMX 11T325SR-M:M8340	✱	2.5	■	255	0.15	4.0	■	150	0.14	4.0	◪	240	0.15	4.0		–	–	–	◪	60	0.12	3.2		–	–	–
ADMX 11T330SR-M:M6330	✱	3.0	■	240	0.15	4.0	■	170	0.14	4.0		–	–	–		–	–	–	◪	70	0.12	3.2		–	–	–
ADMX 11T330SR-M:M8330	✱	3.0	■	280	0.15	4.0	■	165	0.14	4.0	■	265	0.15	4.0		–	–	–	◪	70	0.12	3.2		–	–	–
ADMX 11T330SR-M:M8340	✱	3.0	■	255	0.15	4.0	■	150	0.14	4.0	◪	240	0.15	4.0		–	–	–	◪	60	0.12	3.2		–	–	–





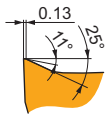
R 型，具有正前角设计，适用于不稳定的工况。

ADMX 11T308PR-R:8215	✱	0.8	■	230	0.18	4.0	◪	135	0.16	4.0	■	215	0.18	4.0		–	–	–	◪	55	0.16	3.2	◪	45	0.12	0.7
ADMX 11T308PR-R:M5315	⚙	0.8	◪	310	0.18	4.0		–	–	–	■	290	0.18	4.0		–	–	–		–	–	–	◪	60	0.13	0.7
ADMX 11T308PR-R:M8310	✱	0.8	■	250	0.18	4.0	◪	125	0.16	4.0	■	235	0.18	4.0		–	–	–		–	–	–	◪	50	0.12	0.7
ADMX 11T308PR-R:M8330	✱	0.8	■	230	0.18	4.0	◪	135	0.16	4.0	■	215	0.18	4.0		–	–	–	◪	55	0.16	3.2	◪	45	0.12	0.7
ADMX 11T308PR-R:M8340	✱	0.8	■	210	0.18	4.0	◪	125	0.16	4.0	◪	195	0.18	4.0		–	–	–	◪	50	0.16	3.2		–	–	–
ADMX 11T308PR-R:M9315	⚙	0.8	■	310	0.18	4.0		–	–	–	■	290	0.18	4.0		–	–	–		–	–	–	◪	60	0.13	0.7
ADMX 11T308PR-R:M9325	✱	0.8	■	290	0.18	4.0		–	–	–	■	275	0.18	4.0		–	–	–		–	–	–	◪	55	0.13	0.7
ADMX 11T316PR-R:8215	✱	1.6	■	255	0.18	4.0	◪	150	0.16	4.0	■	240	0.18	4.0		–	–	–	◪	60	0.16	3.2	◪	50	0.12	0.7
ADMX 11T316PR-R:M8330	✱	1.6	■	255	0.18	4.0	◪	150	0.16	4.0	■	240	0.18	4.0		–	–	–	◪	60	0.16	3.2	◪	50	0.12	0.7
ADMX 11T316PR-R:M9325	✱	1.6	■	320	0.18	4.0		–	–	–	■	300	0.18	4.0		–	–	–		–	–	–	◪	60	0.12	0.7



MF 型，具有大正前角设计，适用于轻载到精加工。

ADMX 11T304SR-MF:M6330	●	0.4	■	215	0.08	2.5	■	150	0.07	2.5		–	–	–		–	–	–	■	60	0.06	2.0		–	–	–
ADMX 11T304SR-MF:M8340	●	0.4	■	220	0.08	2.5	■	130	0.07	2.5		–	–	–		–	–	–	■	55	0.06	2.0		–	–	–
ADMX 11T308SR-MF:M6330	⚙	0.8	■	255	0.08	2.5	■	180	0.07	2.5		–	–	–		–	–	–	■	75	0.06	2.0		–	–	–
ADMX 11T308SR-MF:M8340	⚙	0.8	■	265	0.08	2.5	■	155	0.07	2.5		–	–	–		–	–	–	■	65	0.06	2.0		–	–	–



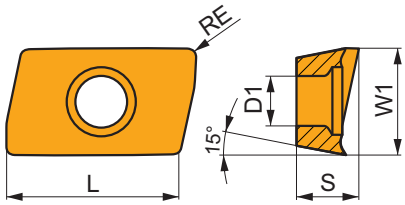
MM 型，具有大前角设计，适用于轻载到中等加工。

ADMX 11T304SR-MM:M6330	⚙	0.4	■	185	0.14	2.5	■	130	0.13	2.5		–	–	–		–	–	–	■	55	0.11	2.0		–	–	–
ADMX 11T304SR-MM:M8340	⚙	0.4	■	195	0.14	2.5	■	115	0.13	2.5		–	–	–		–	–	–	■	45	0.11	2.0		–	–	–
ADMX 11T308SR-MM:M6330	⚙	0.8	■	225	0.14	2.5	■	155	0.13	2.5		–	–	–		–	–	–	■	65	0.11	2.0		–	–	–
ADMX 11T308SR-MM:M8340	⚙	0.8	■	235	0.14	2.5	■	140	0.13	2.5		–	–	–		–	–	–	■	55	0.11	2.0		–	–	–
ADMX 11T308SR-MM:M8345	⚙	0.8	■	190	0.14	2.5	■	110	0.13	2.5		–	–	–		–	–	–	■	45	0.11	2.0		–	–	–
ADMX 11T308SR-MM:M9340	⚙	0.8	■	300	0.14	2.5	■	180	0.13	2.5		–	–	–		–	–	–	■	75	0.11	2.0		–	–	–
ADMX 11T312SR-MM:M6330	✱	1.2	■	235	0.14	2.5	■	165	0.13	2.5		–	–	–		–	–	–	■	70	0.11	2.0		–	–	–
ADMX 11T312SR-MM:M8340	✱	1.2	■	245	0.14	2.5	■	145	0.13	2.5		–	–	–		–	–	–	■	60	0.11	2.0		–	–	–

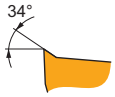
ADEX 11-FA

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.450	2.90	9.70	3.91



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			FA 型，具有大正前角设计，适用于精加工到中等加工。																	
ADEX 11T304FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 210	0.30	5.0	–	–	–	–	–	–
ADEX 11T304FR-FA:M0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 480	0.30	5.0	–	–	–	–	–	–
ADEX 11T308FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 240	0.30	5.0	–	–	–	–	–	–
ADEX 11T308FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 570	0.30	5.0	–	–	–	–	–	–
ADEX 11T312FR-FA:HF7	●	1.2	–	–	–	–	–	–	–	–	–	■ 255	0.30	5.0	–	–	–	–	–	–
ADEX 11T316FR-FA:HF7	●	1.6	–	–	–	–	–	–	–	–	–	■ 270	0.18	5.0	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	0.89	0.81	0.76	0.73	0.71	0.70	0.67	0.65	0.63	0.62	0.60	0.60	0.60	0.45

$a_{e\,max}$	1		2.5		5		7.5		10		15		20	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.25	0.40	0.16	0.26	0.12	0.19	0.10	0.15	0.09	0.14	0.07	0.12	0.07	0.11
32	0.28	0.45	0.18	0.29	0.13	0.21	0.11	0.17	0.09	0.15	0.08	0.13	0.07	0.12
40	0.32	0.51	0.20	0.32	0.14	0.23	0.12	0.19	0.10	0.17	0.09	0.14	0.08	0.13
50	0.35	0.57	0.23	0.36	0.16	0.26	0.13	0.21	0.12	0.19	0.10	0.15	0.09	0.14

$a_{e\,max}$	25		32		40		50	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.08	0.13	–	–	–	–	–	–
32	0.07	0.11	0.08	0.13	–	–	–	–
40	0.07	0.12	0.07	0.11	0.08	0.13	–	–
50	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13

	ADMX 11-F		ADMX 11-M									ADMX 11-R		ADMX 11-MF		ADMX 11-MM			ADEX 11-FA			
RE	0.4	0.8	0.2	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0	0.8	1.6	0.4	0.8	0.4	0.8	1.2	0.4	0.8	1.2	1.6
BS	1.89	1.48	2.09	1.89	1.48	1.27	1.08	0.68	1.61	1.13	0.66	1.48	0.68	1.89	1.48	1.89	1.48	1.08	1.77	1.39	1.0	0.62

ISO	DC		ADMX	a_p
25J2R50B25-SAD11E38-C	25	2	38	34.5
32J2R60B32-SAD11E47-C	32	2	47	43.5
40J2R60B40-SAD11E47-C	40	2	47	43.5
40J3R70B32-SAD11E56-C	40	3	56	52.5
40J3R70B40-SAD11E56-C	40	3	56	52.5
25J2R55E03-SAD11E38-C	25	2	38	34.5
32J2R65E04-SAD11E47-C	32	2	47	43.5
40J3R75E04-SAD11E56-C	40	3	56	52.5
50T03R-S90AD11E37-C	50	3	37	33.5

ADMX/ADEX 11	R
ADMX 11T320SR-M	1.0
ADMX 11T325SR-M	1.8
ADMX 11T330SR-M	1.8

max

4.5

J(T)-SAD16E

PRAMET

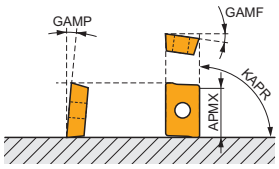
S

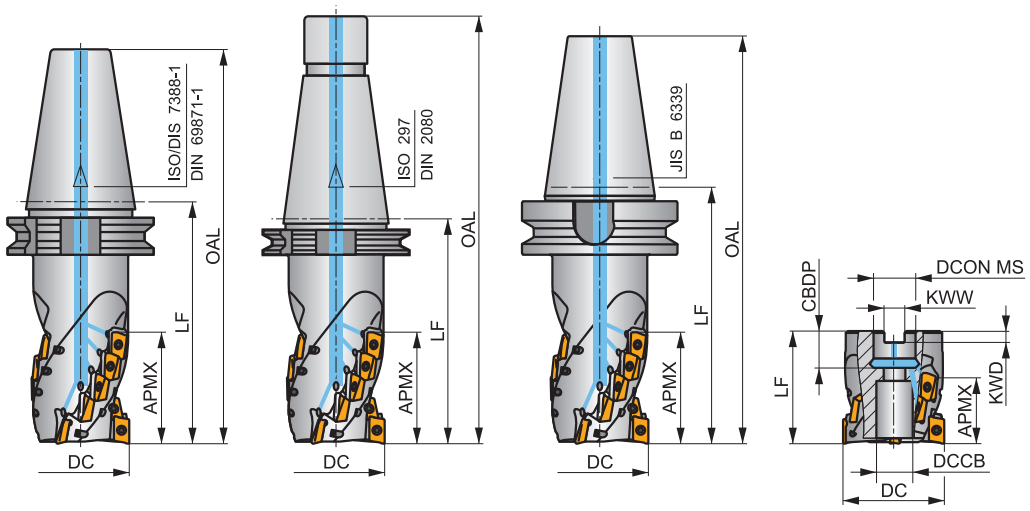
螺旋AD16长刃铣刀，带内冷

90°长刃方肩铣刀，使用正前角AD.. 16刀片，具有APMX(最大切深)40至108mm，具有内冷。适用于方肩铣，铣槽，面铣或插铣。可提供芯轴式，DIN69871，BT和DIN2080刀柄类型，有或没有不等齿距。刀体经过处理，使用寿命更长。

FORCE AD

KAPR	90°
APMX	40.0 - 108.0 mm





h_m	0.08 - 0.1
h_m	0.08 - 0.1

	製品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LF (mm)	APMX (mm)	CBDP (mm)	CZC MS	GAMF (°)	GAMP (°)	NOF			max.		kg		
ISO/DIS 7388-1	50J3R100H50-SAD16E54-C	50	202	–	–	100	54.00	–	50	-6	12	3	12	–	13200	✓	4.08	GI282	SQ031
	50J3R140H50-SAD16E80-C	50	242	–	–	140	80.00	–	50	-6	12	3	18	–	13200	✓	4.38	GI282	SQ031
	63J3R140H50-SAD16E68-C	63	242	–	–	140	68.00	–	50	-6	12	3	15	–	11700	✓	5.34	GI282	SQ031
	63J3R155H50-SAD16E95-C	63	257	–	–	155	95.00	–	50	-6	12	3	21	–	11700	✓	5.43	GI282	SQ031
	80J4R165H50-SAD16E108-C	80	257	–	–	165	108.00	–	50	-6	12	4	32	✓	10400	✓	7.37	GI282	SQ031
ISO 297	50J3R140G50-SAD16E80-C	50	267	–	–	140	80.00	–	50	-6	12	3	18	–	13200	✓	4.48	GI282	SQ031
	63J3R155G50-SAD16E95-C	63	282	–	–	155	95.00	–	50	-6	12	3	21	–	11700	✓	5.52	GI282	SQ031
	80J4R165G50-SAD16E108-C	80	292	–	–	165	108.00	–	50	-6	12	4	32	✓	10400	✓	7.51	GI282	SQ031
JIS B 6339	50J3R140X50-SAD16E68-C	50	242	–	–	140	68.00	–	50	-6	12	3	15	–	13200	✓	5.28	GI282	SQ031
	63J3R155X50-SAD16E80-C	63	257	–	–	155	80.00	–	50	-6	12	3	18	–	11700	✓	6.19	GI282	SQ031
	80J4R165X50-SAD16E95-C	80	267	–	–	165	95.00	–	50	-6	12	4	28	✓	10400	✓	7.84	GI282	SQ031
ISO 6462 DIN 8030	50T03R-S90AD16E40-C	50	–	22	18	70	40.00	21	–	-6	12	3	9	–	13200	✓	0.63	GI282	SQ913
	63T04R-S90AD16E40-C	63	–	27	22	70	40.00	22	–	-6	12	4	12	✓	11700	✓	1.14	GI282	SQ914
	63T04R-S90AD16E68-C	63	–	27	22	100	68.00	22	–	-6	12	4	20	✓	11700	✓	1.86	GI282	SQ914
	80T04R-S90AD16E55-C	80	–	32	30	85	55.00	25	–	-6	12	4	16	✓	10400	✓	2.56	GI282	SQ915
	80T04R-S90AD16E80-C	80	–	32	30	115	80.00	25	–	-6	12	4	24	✓	10400	✓	3.17	GI282	SQ915
	100T05R-S90AD16E80-C	100	–	40	36	120	80.00	30	–	-6	12	5	30	✓	9300	✓	5.31	GI282	SQ916

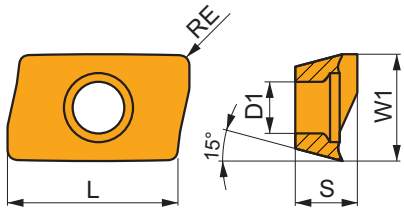
GI282	ADMX 1606..	ADEX 1606..-FA	ADEX 1606..-FM

		Nm					
SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–
SQ913	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 1030C
SQ914	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 1230C
SQ915	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 1630C
SQ916	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 2040C

ADMX 16

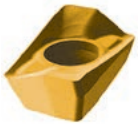
PRAMET

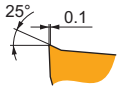
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.25



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

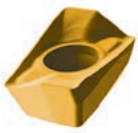
製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)

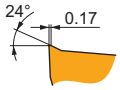




F 型，具有大正前角设计，适用于轻载到中等加工。

ADMX 160608SR-F:8215	⁘	0.8	■	290	0.10	2.0	◪	170	0.09	2.0	◪	275	0.10	2.0	◪	870	0.12	2.0	◪	70	0.07	1.6	–	–	–
ADMX 160608SR-F:M8310	⁘	0.8	■	320	0.10	2.0	◪	160	0.09	2.0	◪	300	0.10	2.0		–	–	–		–	–	–	–	–	–
ADMX 160608SR-F:M8330	⁘	0.8	■	285	0.10	2.0	◪	170	0.09	2.0	◪	270	0.10	2.0	◪	855	0.12	2.0	◪	70	0.07	1.6	–	–	–
ADMX 160608SR-F:M8340	⁘	0.8	■	260	0.10	2.0	◪	155	0.09	2.0	◪	245	0.10	2.0		–	–	–	◪	65	0.07	1.6	–	–	–
ADMX 160608SR-F:M9340	⁘	0.8	■	340	0.10	2.0	◪	200	0.09	2.0		–	–	–		–	–	–	◪	85	0.07	1.6	–	–	–

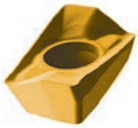


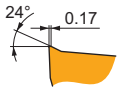


M 型，具有前角设计，适用于轻载到中等加工。

ADMX 160604SR-M:8215	●	0.4	■	190	0.18	5.0	◪	110	0.16	5.0	■	180	0.18	5.0		–	–	–	◪	45	0.13	4.0	–	–	–
ADMX 160604SR-M:M8330	⁘	0.4	■	190	0.18	5.0	■	110	0.16	5.0	■	180	0.18	5.0		–	–	–	◪	45	0.13	4.0	–	–	–
ADMX 160604SR-M:M8340	⁘	0.4	■	170	0.18	5.0	■	100	0.16	5.0	◪	160	0.18	5.0		–	–	–	◪	40	0.13	4.0	–	–	–
ADMX 160608SR-M:8215	⁘	0.8	■	225	0.18	5.0	◪	135	0.16	5.0	■	210	0.18	5.0		–	–	–	◪	55	0.13	4.0	–	–	–
ADMX 160608SR-M:M5315	⁘	0.8	◪	305	0.18	5.0		–	–	–	■	285	0.18	5.0		–	–	–		–	–	–	–	–	–
ADMX 160608SR-M:M8310	⁘	0.8	■	250	0.18	5.0	◪	125	0.16	5.0	■	235	0.18	5.0		–	–	–		–	–	–	–	–	–
ADMX 160608SR-M:M8330	⁘	0.8	■	225	0.18	5.0	■	135	0.16	5.0	■	210	0.18	5.0		–	–	–	◪	55	0.13	4.0	–	–	–
ADMX 160608SR-M:M8340	⁘	0.8	■	205	0.18	5.0	■	120	0.16	5.0	◪	190	0.18	5.0		–	–	–	◪	50	0.13	4.0	–	–	–
ADMX 160608SR-M:M9315	⁘	0.8	■	305	0.18	5.0		–	–	–	■	285	0.18	5.0		–	–	–		–	–	–	–	–	–
ADMX 160608SR-M:M9325	⁘	0.8	■	280	0.18	5.0		–	–	–	■	265	0.18	5.0		–	–	–		–	–	–	–	–	–
ADMX 160608SR-M:M9340	⁘	0.8	■	255	0.18	5.0	■	150	0.16	5.0		–	–	–		–	–	–	◪	60	0.13	4.0	–	–	–
ADMX 160616SR-M:8215	⁘	1.6	■	250	0.18	5.0	◪	150	0.16	5.0	■	235	0.18	5.0		–	–	–	◪	60	0.13	4.0	–	–	–
ADMX 160616SR-M:M8310	⁘	1.6	■	275	0.18	5.0	◪	140	0.16	5.0	■	260	0.18	5.0		–	–	–		–	–	–	–	–	–
ADMX 160616SR-M:M8330	✱	1.6	■	250	0.18	5.0	■	150	0.16	5.0	■	235	0.18	5.0		–	–	–	◪	60	0.13	4.0	–	–	–
ADMX 160616SR-M:M8340	✱	1.6	■	225	0.18	5.0	■	135	0.16	5.0	◪	210	0.18	5.0		–	–	–	◪	55	0.13	4.0	–	–	–
ADMX 160616SR-M:M9325	⁘	1.6	■	310	0.18	5.0		–	–	–	■	290	0.18	5.0		–	–	–		–	–	–	–	–	–
ADMX 160620SR-M:M8330	✱	2.0	■	265	0.18	5.0	■	155	0.16	5.0	■	250	0.18	5.0		–	–	–	◪	65	0.13	4.0	–	–	–
ADMX 160620SR-M:M8340	✱	2.0	■	240	0.18	5.0	■	140	0.16	5.0	◪	225	0.18	5.0		–	–	–	◪	60	0.13	4.0	–	–	–
ADMX 160630SR-M:M8330	✱	3.0	■	265	0.18	5.0	■	155	0.16	5.0	■	250	0.18	5.0		–	–	–	◪	65	0.13	4.0	–	–	–
ADMX 160630SR-M:M8340	✱	3.0	■	240	0.18	5.0	■	140	0.16	5.0	◪	225	0.18	5.0		–	–	–	◪	60	0.13	4.0	–	–	–
ADMX 160632SR-M:M6330	✱	3.2	■	225	0.18	5.0	■	155	0.16	5.0		–	–	–		–	–	–	◪	65	0.13	4.0	–	–	–
ADMX 160632SR-M:M8330	✱	3.2	■	265	0.18	5.0	■	155	0.16	5.0	■	250	0.18	5.0		–	–	–	◪	65	0.13	4.0	–	–	–

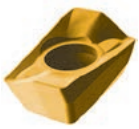
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

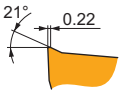




M 型，具有前角设计，适用于轻载到中等加工。

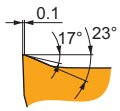
製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
ADMX 160632SR-M:M8340	✱	3.2	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160632SR-M:M9325	⚙	3.2	325	0.18	5.0	–	–	–	305	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160640SR-M:M8330	✱	4.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160640SR-M:M8340	✱	4.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160650SR-M:M8330	✱	5.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160650SR-M:M8340	✱	5.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–





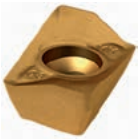
R 型，具有正前角设计，适用于中等加工到不稳定的工况。

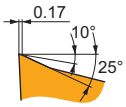
製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
ADMX 160608PR-R:8215	✱	0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	–	–	–	50	0.20	4.8	40	0.16	1.1
ADMX 160608PR-R:M5315	✱	0.8	260	0.25	6.0	–	–	–	245	0.25	6.0	–	–	–	–	–	–	50	0.16	1.1
ADMX 160608PR-R:M8310	✱	0.8	220	0.25	6.0	110	0.23	6.0	205	0.25	6.0	–	–	–	–	–	–	40	0.16	1.1
ADMX 160608PR-R:M8330	✱	0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	–	–	–	50	0.20	4.8	40	0.16	1.1
ADMX 160608PR-R:M8340	✱	0.8	190	0.25	6.0	110	0.23	6.0	180	0.25	6.0	–	–	–	45	0.20	4.8	–	–	–
ADMX 160608PR-R:M9315	✱	0.8	265	0.25	6.0	–	–	–	250	0.25	6.0	–	–	–	–	–	–	50	0.16	1.1
ADMX 160608PR-R:M9325	✱	0.8	250	0.25	6.0	–	–	–	235	0.25	6.0	–	–	–	–	–	–	50	0.16	1.1
ADMX 160616PR-R:M8330	✱	1.6	225	0.25	6.0	135	0.23	6.0	210	0.25	6.0	–	–	–	55	0.20	4.8	45	0.16	1.1
ADMX 160616PR-R:M8340	✱	1.6	210	0.25	6.0	125	0.23	6.0	195	0.25	6.0	–	–	–	50	0.20	4.8	–	–	–
ADMX 160616PR-R:M9315	✱	1.6	295	0.25	6.0	–	–	–	280	0.25	6.0	–	–	–	–	–	–	55	0.16	1.1



MF 型，具有大正前角设计，适用于精加工。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
ADMX 160608SR-MF:M6330	⚙	0.8	215	0.08	4.0	150	0.07	4.0	–	–	–	–	–	–	60	0.06	3.2	–	–	–
ADMX 160608SR-MF:M8340	⚙	0.8	225	0.08	4.0	135	0.07	4.0	–	–	–	–	–	–	55	0.06	3.2	–	–	–
ADMX 160608SR-MF:M9340	⚙	0.8	305	0.08	4.0	180	0.07	4.0	–	–	–	–	–	–	75	0.06	3.2	–	–	–





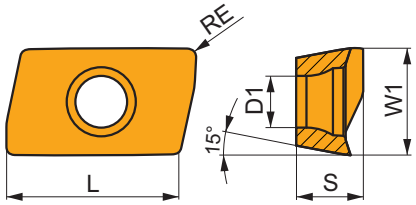
MM 型，具有大前角设计，适用于轻载到中等加工。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
ADMX 160604SR-MM:M6330	⚙	0.4	145	0.18	4.0	105	0.16	4.0	–	–	–	–	–	–	40	0.14	3.2	–	–	–
ADMX 160604SR-MM:M8340	⚙	0.4	160	0.18	4.0	95	0.16	4.0	–	–	–	–	–	–	40	0.14	3.2	–	–	–
ADMX 160608SR-MM:M6330	⚙	0.8	175	0.18	4.0	125	0.16	4.0	–	–	–	–	–	–	50	0.14	3.2	–	–	–
ADMX 160608SR-MM:M8340	⚙	0.8	190	0.18	4.0	110	0.16	4.0	–	–	–	–	–	–	45	0.14	3.2	–	–	–
ADMX 160608SR-MM:M8345	⚙	0.8	150	0.18	4.0	90	0.16	4.0	–	–	–	–	–	–	35	0.14	3.2	–	–	–
ADMX 160608SR-MM:M9340	⚙	0.8	235	0.18	4.0	140	0.16	4.0	–	–	–	–	–	–	55	0.14	3.2	–	–	–
ADMX 160616SR-MM:M6330	✱	1.6	195	0.18	4.0	140	0.16	4.0	–	–	–	–	–	–	55	0.14	3.2	–	–	–
ADMX 160616SR-MM:M8340	✱	1.6	210	0.18	4.0	125	0.16	4.0	–	–	–	–	–	–	50	0.14	3.2	–	–	–
ADMX 160616SR-MM:M8345	✱	1.6	165	0.18	4.0	95	0.16	4.0	–	–	–	–	–	–	40	0.14	3.2	–	–	–
ADMX 160616SR-MM:M9340	⚙	1.6	260	0.18	4.0	155	0.16	4.0	–	–	–	–	–	–	65	0.14	3.2	–	–	–

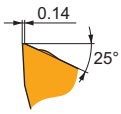
ADEX 16

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.25



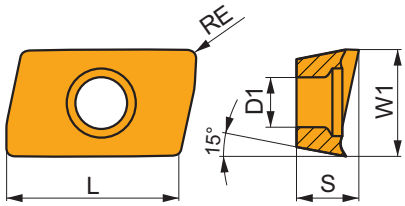
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
FM 型，具有大正前角设计，适用于中等加工。																				
ADEX 160608SR-FM:8215		0.8	260	0.16	2.0	155	0.14	2.0	245	0.16	2.0	–	–	–	65	0.11	1.6	–	–	–
ADEX 160608SR-FM:M8330		0.8	255	0.16	2.0	150	0.14	2.0	240	0.16	2.0	–	–	–	60	0.11	1.6	–	–	–
ADEX 160608SR-FM:M8340		0.8	235	0.16	2.0	140	0.14	2.0	220	0.16	2.0	–	–	–	55	0.11	1.6	–	–	–

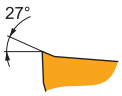
ADEX 16-FA

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.17



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
FA 型，具有大正前角设计，适用于精加工到中等加工。																				
ADEX 160604FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	195	0.28	6.0	–	–	–	–	–	–
ADEX 160604FR-FA:M0315	●	0.4	–	–	–	–	–	–	–	–	–	480	0.28	6.0	–	–	–	–	–	–
ADEX 160608FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	240	0.28	6.0	–	–	–	–	–	–
ADEX 160608FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	570	0.28	6.0	–	–	–	–	–	–
ADEX 160616FR-FA:HF7	●	1.6	–	–	–	–	–	–	–	–	–	255	0.28	6.0	–	–	–	–	–	–
ADEX 160616FR-FA:M0315	●	1.6	–	–	–	–	–	–	–	–	–	630	0.28	6.0	–	–	–	–	–	–
ADEX 160630FR-FA:HF7	●	3.0	–	–	–	–	–	–	–	–	–	270	0.28	6.0	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	0.89	0.81	0.76	0.73	0.71	0.70	0.66	0.65	0.63	0.62	0.60	0.60	0.60	0.45

$a_{e\,max}$	1		2.5		5		7.5		10		15		20	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
50	0.57	0.71	0.36	0.45	0.26	0.32	0.21	0.27	0.19	0.23	0.15	0.19	0.14	0.17
63	0.64	0.80	0.40	0.51	0.29	0.36	0.24	0.30	0.21	0.26	0.17	0.21	0.15	0.19
80	0.72	0.90	0.45	0.57	0.32	0.40	0.27	0.33	0.23	0.29	0.19	0.24	0.17	0.21
100	0.80	1.00	0.51	0.64	0.36	0.45	0.30	0.37	0.26	0.32	0.21	0.27	0.19	0.23

$a_{e\,max}$	25		32		40		50		63		80		100	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
50	0.13	0.16	0.12	0.14	0.11	0.14	0.13	0.16	–	–	–	–	–	–
63	0.14	0.17	0.12	0.16	0.12	0.15	0.11	0.14	0.13	0.16	–	–	–	–
80	0.15	0.19	0.14	0.17	0.13	0.16	0.12	0.15	0.11	0.14	0.13	0.16	–	–
100	0.17	0.21	0.15	0.19	0.14	0.17	0.13	0.16	0.12	0.15	0.11	0.14	0.13	0.16

	ADMX 16-F	ADEX 16-FM	ADMX 16-M								ADMX 16-R	
RE	0.8	0.8	0.4	0.8	1.6	2.0	3.0	3.2	4.0	5.0	0.8	1.6
BS	2.99	2.18	3.39	2.99	1.62	1.23	0.28	0.09	2.69	1.52	2.99	1.62

	ADMX 16-MF	ADMX 16-MM			ADEX 16-FA			
RE	0.8	0.4	0.8	1.6	0.4	0.8	1.6	3.0
BS	2.99	3.39	2.99	1.62	2.84	2.44	1.65	0.69

ISO	DC		APMX	a_p
50J3R100H50-SAD16E54-C	50	3	54	50.5
50J3R140H50-SAD16E80-C	50	3	80	76.5
63J3R140H50-SAD16E68-C	63	3	68	64.5
63J3R155H50-SAD16E95-C	63	3	95	91.5
80J4R165H50-SAD16E108-C	80	4	108	104.5
50J3R140G50-SAD16E80-C	50	3	80	76.5
63J3R155G50-SAD16E95-C	63	3	95	91.5
80J4R165G50-SAD16E108-C	80	4	108	104.5
50J3R140X50-SAD16E68-C	50	3	68	64.5
63J3R155X50-SAD16E80-C	63	3	80	76.5
80J4R165X50-SAD16E95-C	80	4	95	91.5
50T03R-S90AD16E40-C	50	3	40	36.5
63T04R-S90AD16E40-C	63	4	40	36.5
63T04R-S90AD16E68-C	63	4	68	64.5
80T04R-S90AD16E55-C	80	4	55	51.5
80T04R-S90AD16E80-C	80	4	80	76.5
100T05R-S90AD16E80-C	100	5	80	76.5

max
7.5

ADMX/ADEX 16	R
ADMX 160630SR-M	2.5
ADMX 160632SR-M	2.5
ADMX 160640SR-M	4.0
ADMX 160650SR-M	4.5

J(T)-SSAP

P M K S

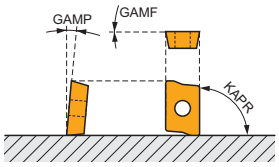
PRAMET

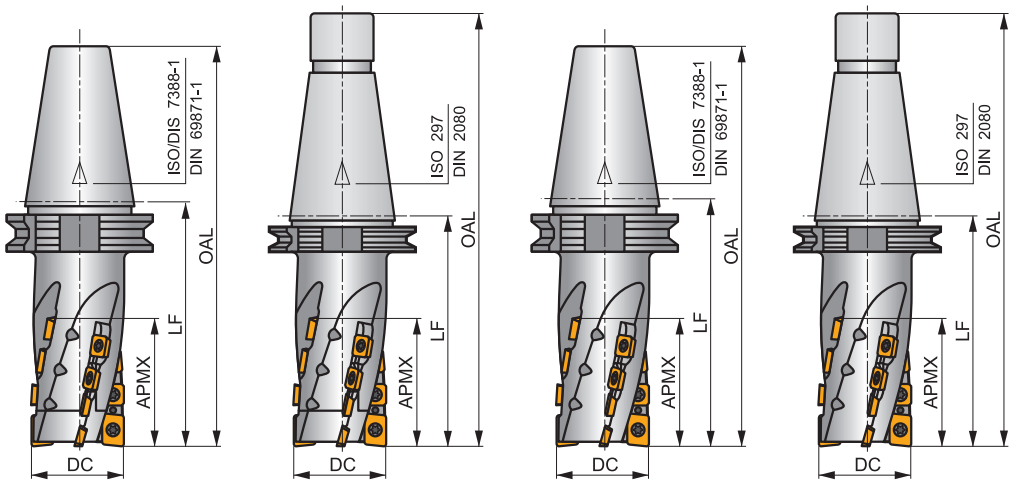
S

长刃立铣适用于中等铣削，AP.. 15和SP.. 12刀片

90°长刃方肩铣刀，使用AP.. 15和SP.. 12刀片，具有APMX(最大切深)58至95mm。刀体末端可更换。适用于方肩铣，铣槽，面铣和插铣。可提供DIN 69871和DIN 2080 50刀柄类型。刀体经过处理，使用寿命更长。

KAPR	90°
APMX	58.0 - 95.0 mm





h_m 0.07 - 0.1

	DC (mm)	OAL (mm)	APMX (mm)	LF (mm)	GAMF (°)	GAMP (°)	CZCMS	NOF	AP	SP		max.		kg		
製品																
50J4R128H50-SSAP55+21	50	230	76.00	128	0	7	50	4	2	16	–	9500	–	3.80	GI128	SQ942
63J4R150H50-SSAP74+21	63	252	95.00	150	0	7	50	4	2	20	–	8500	–	4.50	GI128	SQ943
50J4R124X50-SSAP55+21	50	251	76.00	124	0	7	50	4	2	16	–	9500	–	4.43	GI128	SQ942
63J4R146X50-SSAP74+21	63	273	95.00	146	0	7	50	4	2	20	–	8500	–	4.75	GI128	SQ943
63J4R150H50-SSAP95-A	63	252	95.00	150	0	7	50	4	2	20	–	8500	–	5.32	GI128	SQ941
80J6R155H50-SSAP95-A	80	257	95.00	155	0	7	50	6	3	30	–	7500	–	6.30	GI128	SQ941
50J4R124X50-SSAP76-A	50	251	76.00	124	0	7	50	4	2	16	–	9500	–	3.80	GI128	SQ941
63J4R146X50-SSAP95-A	63	273	95.00	146	0	7	50	4	2	20	–	8500	–	4.50	GI128	SQ941
80J6R151X50-SSAP95-A	80	275	95.00	151	0	7	50	6	3	30	–	7500	–	6.20	GI128	SQ941

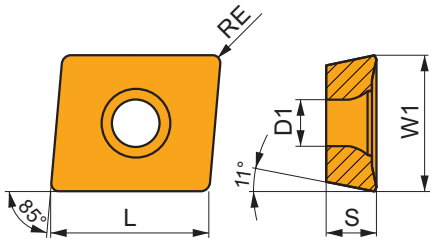
GI128	APE. 1504..	SPE. 1204..

					Nm			
SQ941	–	–	–	US 4511-T20	5.0	M 4.5	11	SDR T20-T
SQ942	P50X21	SR 25	HXK 6	US 4511-T20	5.0	M 4.5	11	SDR T20-T
SQ943	P63X21	SR 26	HXK 8	US 4511-T20	5.0	M 4.5	11	SDR T20-T

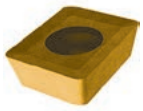
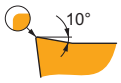
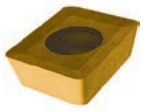
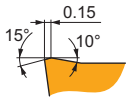
APET 15

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1504	12.700	5.50	15.90	4.76



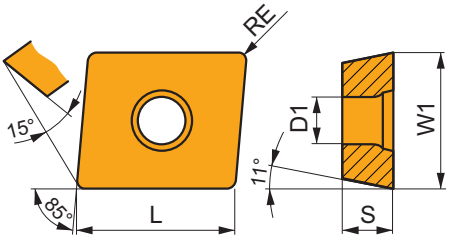
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
EN 口制备，正前角槽型，适用于轻载到中等加工。																				
APET 150412EN:M8330		1.2	225	0.20	12.0	135	0.18	12.0	210	0.20	12.0	–	–	–	55	0.14	9.6	–	–	–
 																				
SN 口制备，正前角槽型，适用于中等到重载加工。																				
APET 150412SN:M8330		1.2	215	0.25	12.0	125	0.23	12.0	200	0.25	12.0	–	–	–	50	0.25	9.6	–	–	–
APET 150412SN:M8340		1.2	190	0.25	12.0	110	0.23	12.0	180	0.25	12.0	–	–	–	45	0.25	9.6	–	–	–

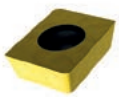
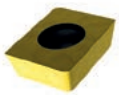
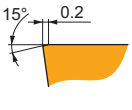
APEW 15

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	M (mm)	S (mm)
1504	12.700	5.50	15.90	3.7	4.76



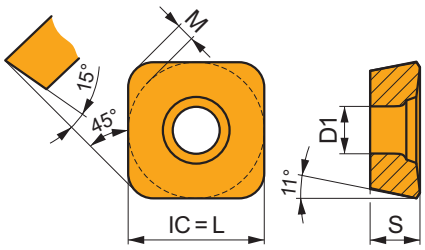
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ER 口制备，平板槽型，适用于轻载到中等加工。																				
APEW 150412ER:M8330		1.2	200	0.20	12.0	–	–	–	190	0.20	12.0	–	–	–	–	–	–	40	0.13	1.0
 																				
SR 口制备，平板槽型，适用于中等到重载加工。																				
APEW 150412SR:M8330		1.2	200	0.20	12.0	–	–	–	190	0.20	12.0	–	–	–	–	–	–	40	0.13	1.0

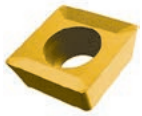
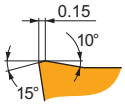
SPET 12

PRAMET

	IC (mm)	D1 (mm)	L (mm)	M (mm)	S (mm)
1204	12.700	5.50	12.70	1.9	4.76



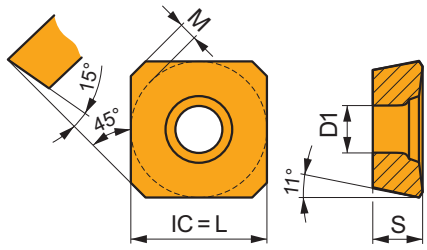
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
S 口制备，正前角通用槽型。																			
SPET 120408S:M8330	0.8	215	0.20	12.0	125	0.18	12.0	200	0.20	12.0	–	–	–	50	0.18	9.6	–	–	–
SPET 120408S:M8340	0.8	190	0.20	12.0	110	0.18	12.0	180	0.20	12.0	–	–	–	45	0.18	9.6	–	–	–

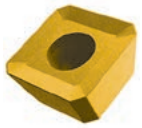
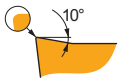
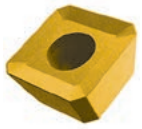
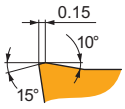
SPET 12 AD

PRAMET

	IC (mm)	D1 (mm)	L (mm)	M (mm)	S (mm)
1204	12.700	5.50	12.70	1.9	4.76



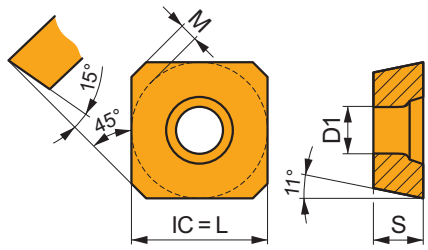
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
ADEN 口制备，正前角槽型，适用于轻载到中等加工。																			
SPET 1204ADEN:M8330	–	245	0.20	12.0	145	0.18	12.0	230	0.20	12.0	–	–	–	60	0.14	9.6	–	–	–
SPET 1204ADEN:M8340	–	220	0.20	12.0	130	0.18	12.0	205	0.20	12.0	–	–	–	55	0.14	9.6	–	–	–
 																			
ADSN 口制备，正前角槽型，适用于中等加工。																			
SPET 1204ADSN:M8330	–	245	0.20	12.0	145	0.18	12.0	230	0.20	12.0	–	–	–	60	0.14	9.6	–	–	–
SPET 1204ADSN:M8340	–	220	0.20	12.0	130	0.18	12.0	205	0.20	12.0	–	–	–	55	0.14	9.6	–	–	–

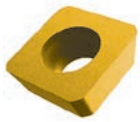
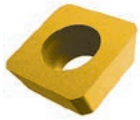
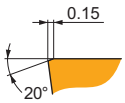
SPEW 12 AD

PRAMET

	IC (mm)	D1 (mm)	L (mm)	M (mm)	S (mm)
1204	12.700	5.50	12.70	1.9	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ADEN 口制备，平板槽型，适用于轻载到中等加工。																				
SPEW 1204ADEN:M8330		–	220	0.20	12.0	–	–	–	205	0.20	12.0	–	–	–	–	–	–	40	0.10	1.0
																				
ADSN 口制备，平板槽型，适用于中等加工。																				
SPEW 1204ADSN:M8330		–	220	0.20	12.0	–	–	–	205	0.20	12.0	–	–	–	–	–	–	40	0.13	1.0

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	0.89	0.81	0.76	0.73	0.71	0.70	0.67	0.65	0.63	0.62	0.60	0.60	0.60	0.45

$a_{e\,max}$	1		2.5		5		7.5		10		15		20	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
50	0.50	0.71	0.32	0.45	0.23	0.32	0.19	0.27	0.16	0.23	0.14	0.19	0.12	0.17
63	0.56	0.80	0.35	0.51	0.25	0.36	0.21	0.30	0.18	0.26	0.15	0.21	0.13	0.19
80	0.63	0.90	0.40	0.57	0.28	0.40	0.23	0.33	0.20	0.29	0.17	0.24	0.15	0.21

$a_{e\,max}$	25		32		40		50		63		80	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
50	0.11	0.16	0.10	0.14	0.10	0.14	0.11	0.16	–	–	–	–
63	0.12	0.17	0.11	0.16	0.10	0.15	0.10	0.14	0.11	0.16	–	–
80	0.13	0.19	0.12	0.17	0.11	0.16	0.10	0.15	0.10	0.14	0.11	0.16

	APET 15	APEW 15	SPET 12	SPET 12AD	SPEW 12AD
RE	1.2	1.2	0.8	–	–
BS	–	–	–	–	–

ISO	DC		APMX	a_p
50J4R128H50-SSAP55+21	50	2+2	76	73.6
63J4R150H50-SSAP74+21	63	2+2	95	92.6
50J4R124X50-SSAP55+21	50	2+2	76	73.6
63J4R146X50-SSAP74+21	63	2+2	95	92.6
63J4R150H50-SSAP95-A	63	2+2	95	92.6
80J6R155H50-SSAP95-A	80	3+3	95	92.6
50J4R124X50-SSAP76-A	50	2+2	76	73.6
63J4R146X50-SSAP95-A	63	2+2	95	92.6
80J6R151X50-SSAP95-A	80	3+3	95	92.6

J(T)-CSD12X

P M S

PRAMET

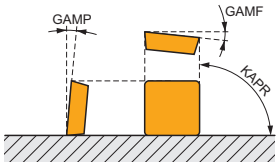
C

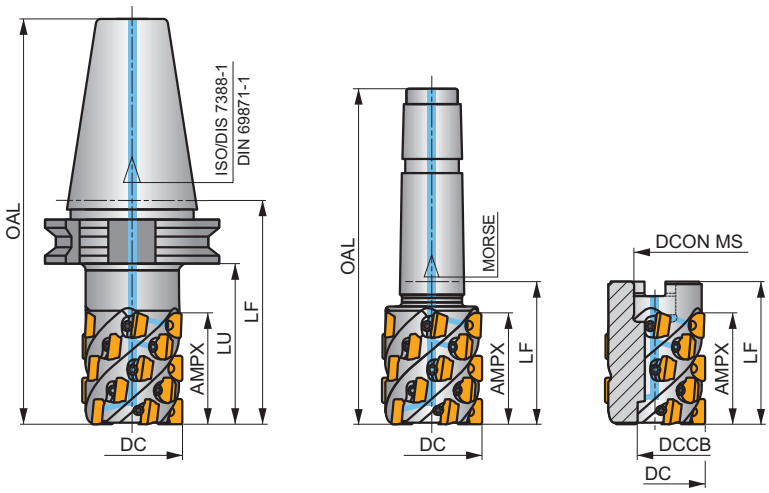
MULTISIDE SD长刃铣刀

90°长刃方肩铣刀，使用正前角SD.. 12刀片，具有APMX(最大切深)44.1至87.3mm。适用于方肩铣，铣槽或面铣。可提供芯轴式，PSC，Morse或DIN69871刀柄类型。刀体经过处理，使用寿命更长。

MULTISIDE SD

KAPR	90°
APMX	44.1 - 87.3 mm





h_m	0.025 - 0.05
h_m	0.025 - 0.05

	製品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	APMX (mm)	GAMF (°)	GAMP (°)	CZC MS	NOF			max.		kg		
ISO/DIS 7388-1	40J4R090H40-CSD12X44	40	158.4	–	–	70	90	44.10	-5	8	40	4	16	–	4000	✓	1.16	GI271	SQ091
	50J5R100H50-CSD12X55	50	201.7	–	–	80	100	54.90	-5	8	50	5	25	–	3200	✓	4.20	GI271	SQ091
	63J6R110H50-CSD12X66	63	211.7	–	–	90	110	65.70	-5	8	50	6	36	–	2500	✓	4.90	GI271	SQ091
DIN 228A	50J5R065E04-CSD12X55	50	167.5	–	–	–	65	54.90	-5	8	4	5	25	–	3200	✓	1.34	GI271	SQ091
ISO 6462 DIN 8030	50T05R-C90SD12X55	50	–	22	18	–	78	54.90	-5	8	–	5	25	–	3200	✓	1.21	GI271	SQ923
	63T06R-C90SD12X66	63	–	27	22	–	90	65.70	-5	8	–	6	36	–	2500	✓	1.72	GI271	SQ924
	80T08R-C90SD12X88	80	–	40	36	–	115	87.30	-5	8	–	8	64	–	2000	✓	3.20	GI271	SQ925

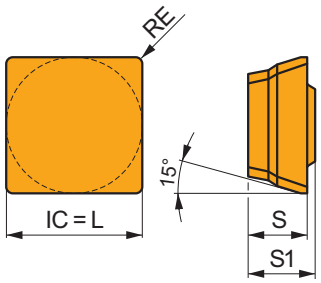
GI271	SDGX 1205..	SDMX 1205..

		Nm					
SQ091	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	–
SQ923	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	HSD 1070
SQ924	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	HS 1280
SQ925	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	HS 20100

SDGX 12

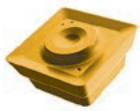
PRAMET

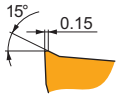
	IC (mm)	L (mm)	S (mm)	S1 (mm)
1205	12.700	12.70	5.56	6.35



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
FM 型，具有正前角设计，适用于轻载到中等重载加工。																			
SDGX 120508EN-FM:M8330	0.8	220	0.15	12.0	130	0.14	12.0	–	–	–	–	–	–	55	0.11	9.6	–	–	–
SDGX 120508EN-FM:M8345	0.8	155	0.15	12.0	90	0.14	12.0	–	–	–	–	–	–	35	0.11	9.6	–	–	–

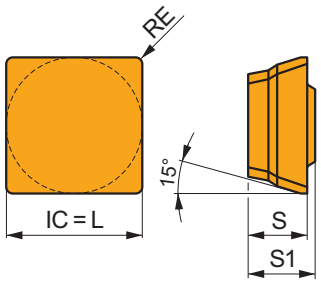




SDMX 12

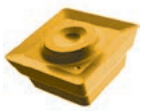
PRAMET

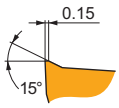
	IC (mm)	L (mm)	S (mm)	S1 (mm)
1205	12.700	12.70	5.56	6.35



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
M 型，具有正前角设计，适用于轻载到重载加工。																			
SDMX 120508EN-M:M8330	0.8	220	0.15	12.0	130	0.14	12.0	–	–	–	–	–	–	55	0.11	9.6	–	–	–
SDMX 120508EN-M:M8345	0.8	155	0.15	12.0	90	0.14	12.0	–	–	–	–	–	–	35	0.11	9.6	–	–	–



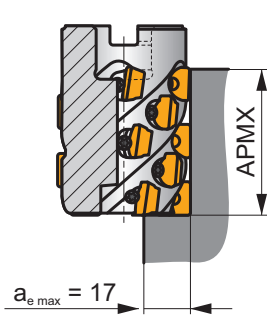


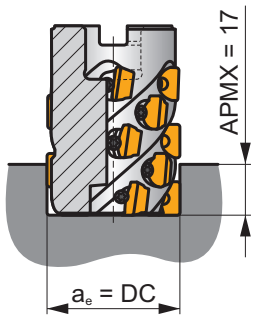
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	0.89	0.81	0.76	0.73	0.71	0.70	0.66	0.65	0.63	0.62	0.60	0.60	0.60	0.45

$a_{e\,max}$	1		2.5		5		7.5		10		15		20	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
40	0.16	0.32	0.10	0.20	0.07	0.14	0.06	0.12	0.05	0.10	0.04	0.09	0.04	0.08
50	0.18	0.35	0.11	0.23	0.08	0.16	0.07	0.13	0.06	0.12	0.05	0.10	0.04	0.09
63	0.20	0.40	0.13	0.25	0.09	0.18	0.07	0.15	0.06	0.13	0.05	0.11	0.05	0.09
80	0.22	0.45	0.14	0.28	0.10	0.20	0.08	0.17	0.07	0.14	0.06	0.12	0.05	0.10

$a_{e\,max}$	25		32		40		50		63		80	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
40	0.04	0.07	0.03	0.07	0.04	0.08	–	–	–	–	–	–
50	0.04	0.08	0.04	0.07	0.03	0.07	0.04	0.08	–	–	–	–
63	0.04	0.09	0.04	0.08	0.04	0.07	0.03	0.07	0.04	0.08	–	–
80	0.05	0.09	0.04	0.09	0.04	0.08	0.04	0.07	0.03	0.07	0.04	0.08

	SDGX 12-FM	SDMX 12-M
RE	0.8	0.8
BS	2.99	2.99





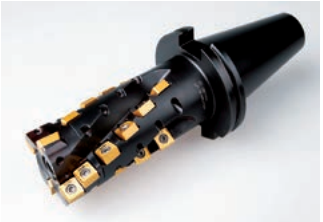
ISO	DC		APMX	a_p
40J4R090H40-CSD12X44	40	4	44.1	42.5
50J5R100H50-CSD12X55	50	5	54.9	53.3
63J6R110H50-CSD12X66	63	6	65.7	64.1
80J8R130H50-CSD12X88	80	8	87.3	85.7
40J4R080XC5-CSD12X44	40	4	44.1	42.5
50J5R080XC5-CSD12X55	50	5	54.9	53.3
63J6R095XC6-CSD12X66	63	6	65.7	64.1
50J5R065E04-CSD12X55	50	5	54.9	53.3
50T05R-C90SD12X55	50	5	54.9	53.3
63T06R-C90SD12X66	63	6	65.7	64.1
80T08R-C90SD12X88	80	8	87.3	85.7

J(T)-SLSN

P K

PRAMET

S

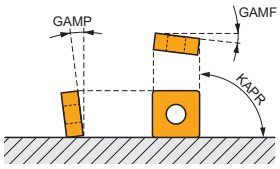


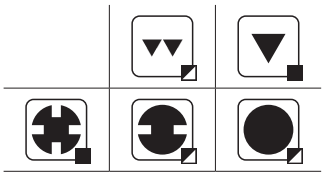
粗加工SN长刃铣刀，适用于重载铣削，带内冷

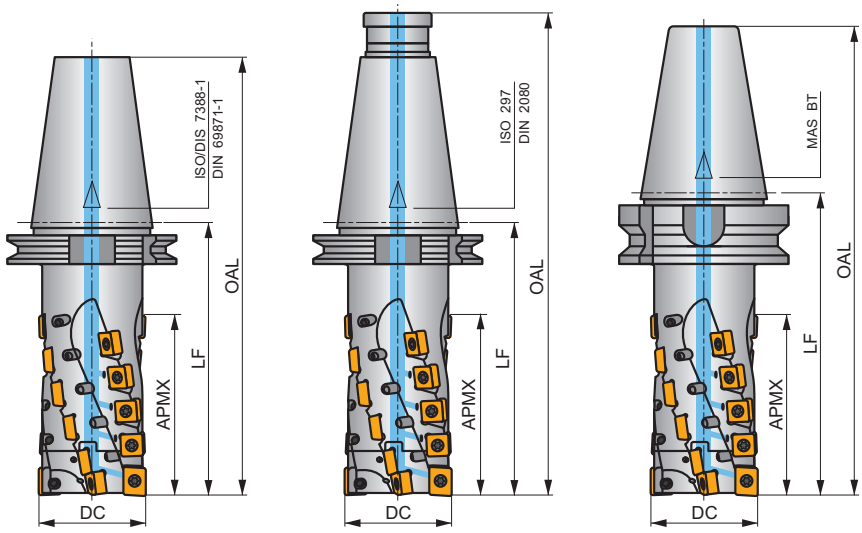
90⊠长刃方肩铣刀，使用LNET 16和SN.. 13刀片，具有APMX(最大切深)104至134mm。刀体末端可更换。适用于方肩铣，铣槽，面铣和插铣。可提供DIN 69871，BT和DIN 2080 50刀柄类型。刀体经过处理，使用寿命更长。

ROUGH SN

KAPR	90°
APMX	104.0 - 134.0 mm







h_m 0.08 - 0.22

	製品	DC (mm)	OAL (mm)	APMX (mm)	LF (mm)	GAMF (°)	GAMP (°)	CZCMS	NOF	LN	SN		max.		kg		
ISO/DIS 7388-1	63J2R155H50-SLSN104-C	63	257	104.00	155	-9	-10	50	4	2	20	–	8500	✓	5.03	GI209	SQ934
	80J2R190H50-SLSN134-C	80	292	134.00	190	-9	-10	50	4	2	26	–	7500	✓	7.45	GI209	SQ935
ISO 297	63J2R155G50-SLSN104-C	63	282	104.00	155	-9	-10	50	4	2	20	–	8500	✓	5.20	GI209	SQ934
	80J2R190G50-SLSN134-C	80	317	134.00	190	-9	-10	50	4	2	26	–	7500	✓	7.40	GI209	SQ935
JIS B 6339	63J2R175X50-SLSN104-C	63	277	104.00	175	-9	-10	50	4	2	20	–	8500	✓	6.10	GI209	SQ934
	80J2R210X50-SLSN134-C	80	312	134.00	210	-9	-10	50	4	2	26	–	7500	✓	8.50	GI209	SQ935

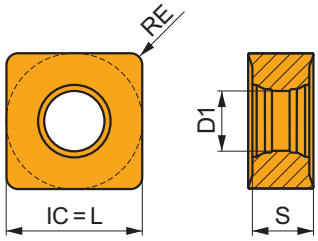
GI209	LNET 1606..	SN.. 1305..

					Nm			
SQ934	EH6326-SL-C	HS 1230	HXK 10	US 45012-T20P	5.0	M 5	12	SDR T20P-T
SQ935	EH8036-SL-C	HS 1640	HXK 14	US 45012-T20P	5.0	M 5	12	SDR T20P-T

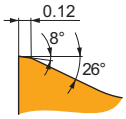
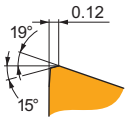
SNGX 13

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1305	13.200	5.90	5.96



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
SNGX 130512SN-M:M8330		1.2	105	0.15	12.0	–	–	–	95	0.15	12.0	–	–	–	–	–	–	–	–	–
SNGX 130512SN-M:M8340		1.2	105	0.15	12.0	–	–	–	95	0.15	12.0	–	–	–	–	–	–	–	–	–
																				
SNGX 130512PN-R:M8330		1.2	95	0.15	12.0	–	–	–	90	0.15	12.0	–	–	–	–	–	–	–	–	–
SNGX 130512PN-R:M8340		1.2	95	0.15	12.0	–	–	–	90	0.15	12.0	–	–	–	–	–	–	–	–	–

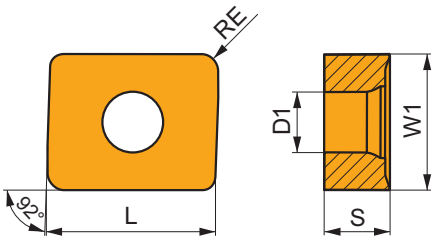
M 型，具有正前角设计，适用于轻载加工。

R 型，具有正前角设计，适用于粗加工和不稳定的工况。

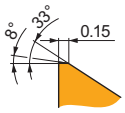
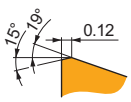
LNET 16

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	13.200	5.90	16.40	6.38



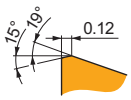
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
LNET 160616SR-M:M8340		1.6	105	0.15	15.0	–	–	–	95	0.15	15.0	–	–	–	–	–	–	–	–	–
																				
LNET 160616SR-R:M8330		1.6	100	0.15	15.0	–	–	–	95	0.15	15.0	–	–	–	–	–	–	–	–	–

M 型，具有大正前角设计，适用于中等加工。

R 型，具有大正前角设计，适用于中等加工。

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

製品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			R 型，具有大正前角设计，适用于中等加工。																	
LNET 160616SR-R:M8340		1.6	95	0.15	15.0	–	–	–	90	0.15	15.0	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

$a_{e\,max}$	1		2.5		5		7.5		10		15		20	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
63	0.64	1.75	0.40	1.11	0.29	0.79	0.24	0.65	0.21	0.57	0.17	0.47	0.15	0.41
80	0.72	1.97	0.45	1.25	0.32	0.89	0.27	0.73	0.23	0.64	0.19	0.53	0.17	0.46

$a_{e\,max}$	25		32		40		50		63		80	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
63	0.14	0.38	0.12	0.34	0.12	0.32	0.11	0.30	0.13	0.35	–	–
80	0.15	0.42	0.14	0.38	0.13	0.35	0.12	0.32	0.11	0.30	0.13	0.35

	LNET 16-M	LNET 16-R	SNGX 13-M	SNGX 13-R
RE	1.6	1.6	1.2	1.2
BS	–	–	–	–

ISO	DC		APMX	a_p
63J2R155H50-SLSN104-C	63	2+2	104	101.2
80J2R190H50-SLSN134-C	80	2+2	134	131.2
63J2R155G50-SLSN104-C	63	2+2	104	101.2
80J2R190G50-SLSN134-C	80	2+2	134	131.2
63J2R175X50-SLSN104-C	63	2+2	104	101.2
80J2R210X50-SLSN134-C	80	2+2	134	131.2

倣い加工

平面铣

	SRD05	SRD07	SRD10	SRD12	SRD16
	–	–	–	–	–
	APMX (mm) 1.5	APMX (mm) 2.0	APMX (mm) 2.5	APMX (mm) 3.0	APMX (mm) 4.0
	DCX (mm) 10 – 15	DCX (mm) 15 – 25	DCX (mm) 20 – 52	DCX (mm) 24 – 80	DCX (mm) 32 – 100
圆柱刀柄					
侧固刀柄		DCX = 15 (mm)	DCX = 20 (mm)		
模块式刀柄		DCX = 15 – 25 (mm)	DCX = 20 – 42 (mm)	DCX = 24 – 42 (mm)	DCX = 32 (mm)
套式铣刀			DCX = 42, 52 (mm)	DCX = 50 – 80 (mm)	DCX = 52 – 100 (mm)
页码	160	163	168	174	180
ISO	P K H	P M K N S H	P M K N S H	P M K N S H	P M K N S H
刀片形状					
刀片	RD 0501	RD 0702	RD 1003	RD 12T3	RD 1604
切削刃数量	–	–	–	–	–
波状表面(仿形铣)	■	■	■	■	■
平面铣	■	■	■	■	■
螺旋插补	■	■	■	■	■
连续钻铣	■	■	■	■	■
坡走铣	■	■	■	■	■

■ 推荐使用　◪ 可以使用

SRD05

P K H

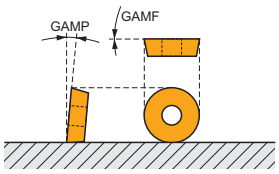
PRAMET

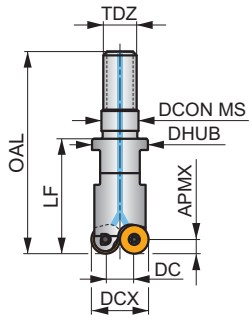
S

仿形铣削刀盘，使用圆刀片RDHX 05，带内冷

铣刀盘，用于仿形铣削，使用正前角RDHX 05刀片，具有APMX(最大切深)1.5mm。内冷。适用于面铣，螺旋插补铣，坡走铣,连续钻铣和仿形铣削。可提供模块夹紧系统和心轴式接口。刀体经过处理，使用寿命更长。

APMX	1.5 mm





h_m 0.03 - 0.1

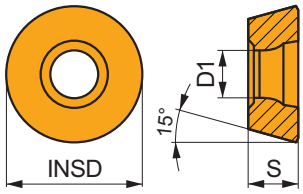
	产品	DCX (mm)	DC (mm)	DHUB (mm)	OAL (mm)	LF (mm)	DCON MS (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
MODULAR	10E2R020M06-SRD05-CF	10	5	9.8	35	20	6.5	M6	5	3	2	–	89300	✓	0.01	GI117	CO352
MODULAR	12E3R020M06-SRD05-CF	12	7	10	35	20	6.5	M6	0	3	3	–	81500	✓	0.01	GI117	CO352
MODULAR	15E4R020M08-SRD05-CF	15	10	13.5	38	20	8.5	M8	0	3	4	–	72900	✓	0.02	GI117	CO352

GI117	RD.. 0501M0..

CO352	US 62003B-T06P	0.9	M 2	3	Flag T06P

RDHX 05

	INSD (mm)	D1 (mm)	S (mm)
0501	5.000	2.20	1.51

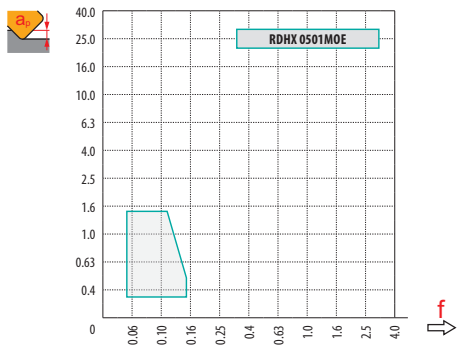


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
		HFC E	MOE 平板设计，适用于精加工。																	
RDHX 0501MOE:M8310	✖	–	400	0.10	0.5	–	–	–	380	0.10	0.5	–	–	–	–	–	–	80	0.10	0.3

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RDHX 05
RE	2.5
BS	–



DCX	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50
10	DEF	5.0	7.4	8.0	8.6	9.0	9.3	9.6	9.9	10.0
12		7.0	9.4	10.0	10.6	11.0	11.3	11.6	11.9	12.0
15		10.0	12.4	13.0	13.6	14.0	14.3	14.6	14.9	15.0
	a_p	–	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50
	1 ⇨ f	–	0.25	0.19	0.16	0.14	0.13	0.12	0.10	0.09

DCX	RPMX	APMX/I
10	15.0	1.3/11
12	11.0	1.3/14
15	7.0	1.3/22

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
10	12.0	20.0	1.2	1.2
12	16.0	24.0	1.2	1.2
15	22.0	30.0	1.2	1.2

a_p
1.0

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
10	FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
15		0.424	0.548	0.775	0.949	1.095	1.342	1.549	1.732	1.897	2.191	2.449
RE	µm	3	5	10	15	20	30	40	50	60	80	100
2.5	FE	0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414

SRD07

P M K N S H

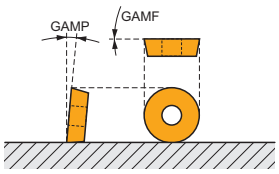
PRAMET

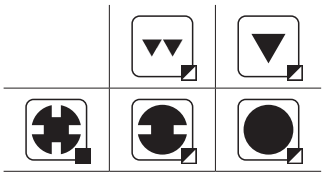
S

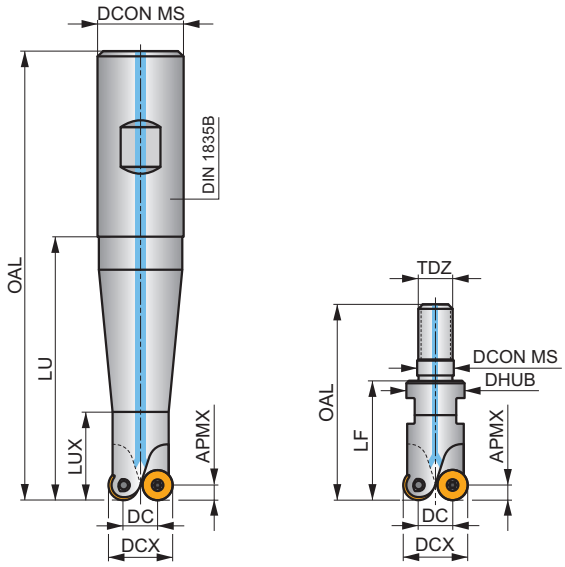
仿形铣削刀盘，使用圆刀片RD.. 07，带内冷

铣刀盘，用于仿形铣削，使用正前角RD.. 07刀片，具有APMX(最大切深)2mm。内冷。适用于面铣，螺旋插补铣，坡走铣，连续钻铣和仿形铣削。可提供侧固柄和模块夹紧系统类型。刀体经过处理，使用寿命更长。

APMX	2.0 mm







h_m 0.065 - 0.13

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	15E2R040B16-SRD07-CF	15	8	88	16	–	40	20	–	–	1	0	2	–	44200	✓	0.12	GI118	CO354
	15E2R060B16-SRD07-CF	15	8	108	16	–	60	20	–	–	1	0	2	–	44200	✓	0.15	GI118	CO354
	15E2R080B20-SRD07-CF	15	8	130	20	–	80	22	–	–	1	0	2	–	44200	✓	0.22	GI118	CO354
	15E2R100B20-SRD07-CF	15	8	150	20	–	100	22	–	–	1	0	2	–	44200	✓	0.25	GI118	CO354
	15E2R120B25-SRD07-CF	15	8	176	25	–	120	22	–	–	1	0	2	–	44200	✓	0.45	GI118	CO354
MODULAR	15E2R028M08-SRD07-CF	15	8	46	8.5	13.5	–	–	28	M8	1	0	2	–	44200	✓	0.03	GI118	CO354
	15E3R028M08-SRD07-CF	15	8	46	10.5	13.5	–	–	28	M8	2	0	3	–	44200	✓	0.05	GI118	CO354
	20E4R028M10-SRD07-CF	20	13	47	12.5	18	–	–	28	M10	-8	0	4	–	38200	✓	0.07	GI118	CO354
	25E5R028M12-SRD07-CF	25	18	50	12.5	21	–	–	28	M12	-2	0	5	–	34200	✓	0.09	GI118	CO354

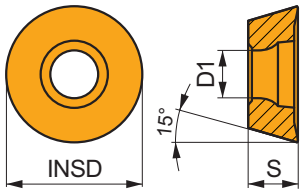
GI118	RD.. 07..MO..

CO354	US 42505-T07P	1.2	M 2.5	5	Flag T07P

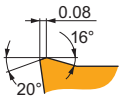
RDGT 07

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
0702	7.000	2.80	2.38



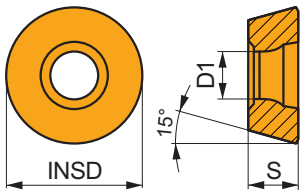
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
MOT 正前角设计，适用于精加工。																				
RDGT 0702MOT:M8325		–	305	0.15	0.5	145	0.14	0.5	–	–	–	–	–	–	–	–	–	–	–	–
RDGT 0702MOT:M8345		–	270	0.15	0.5	160	0.14	0.5	–	–	–	–	–	–	65	0.12	0.4	–	–	–

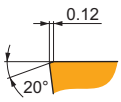
RDHX 07

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
0702	7.000	2.80	2.38
07T1	7.000	2.80	1.98



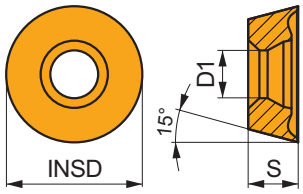
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
MOT 平板设计，适用于精加工。																				
RDHX 0702MOT:M4303		–	370	0.15	0.5	–	–	–	350	0.15	0.5	–	–	–	–	–	–	70	0.11	0.5
RDHX 0702MOT:M8310		–	360	0.15	0.5	–	–	–	340	0.15	0.5	–	–	–	–	–	–	70	0.11	0.5
RDHX 0702MOT:M8325		–	275	0.15	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 07T1MOT:M8310		–	360	0.15	0.5	–	–	–	340	0.15	0.5	–	–	–	–	–	–	70	0.11	0.5

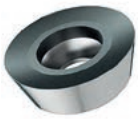
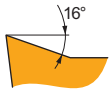
RDHT 07-FA

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
0702	7.000	2.80	2.38



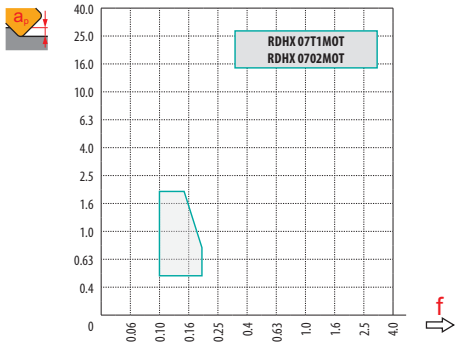
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

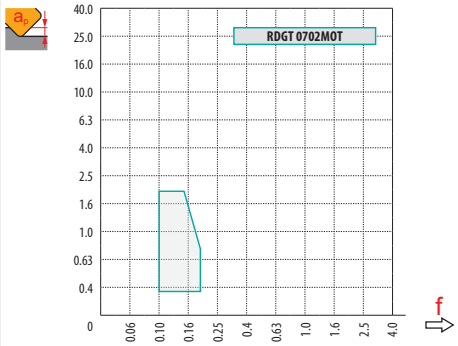
产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
RDHT 0702MO-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	■ 420	0.18	0.5	–	–	–	–	–	–

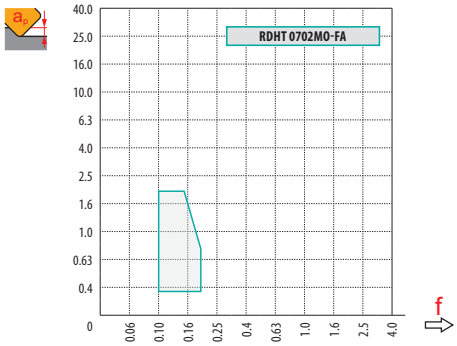
FA 型，具有大正前角设计，适用于精加工到中等加工。

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RDHX 07	RDGT 07	RDHT 07-FA
RE	3.5	3.5	3.5
BS	–	–	–







DCX	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50
15	DEF	8.0	10.8	11.6	12.3	12.9	13.4	13.7	14.3	14.7	14.9	15.0
20		13.0	15.8	16.6	17.3	17.9	18.4	18.7	19.3	19.7	19.9	20.0
25		18.0	20.8	21.6	22.3	22.9	23.4	23.7	24.3	24.7	24.9	25.0
	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50
	⇨ f	–	0.29	0.23	0.19	0.16	0.15	0.13	0.12	0.11	0.10	0.09

DCX	RPMX	APMX/I
15	11.0	1.7/20
20	7.0	1.7/30
25	6.0	1.7/35

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
15	17.0	30.0	0.4	1.7
20	28.0	40.0	1.7	1.7
25	38.0	50.0	1.7	1.7

a_p
1.2

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
15	FE	0.424	0.548	0.775	0.949	1.095	1.342	1.549	1.732	1.897	2.191	2.449
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
RE	µm	3	5	10	15	20	30	40	50	60	80	100
3.5	FE	0.290	0.374	0.529	0.648	0.748	0.917	1.058	1.183	1.296	1.497	1.673

SRD10

P M K N S H

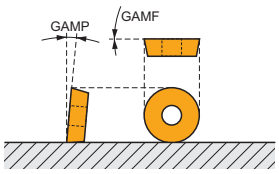
PRAMET

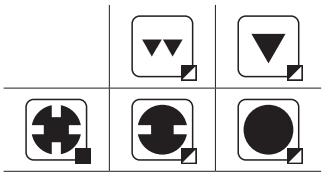
S

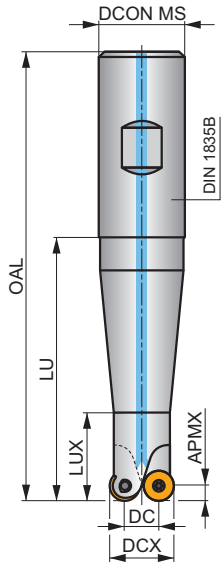
仿形铣削刀盘，使用圆刀片RD.. 10，带内冷

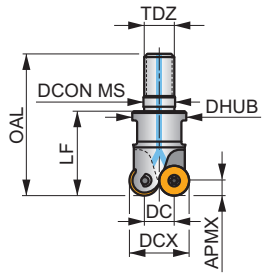
铣刀盘，用于仿形铣削，使用正前角RD.. 10刀片，具有APMX(最大切深)2.5mm。内冷。适用于面铣，螺旋插补铣，坡走铣，连续钻铣和仿形铣削。可提供侧固柄，模块夹紧系统和心轴式接口。刀体经过处理，使用寿命更长。

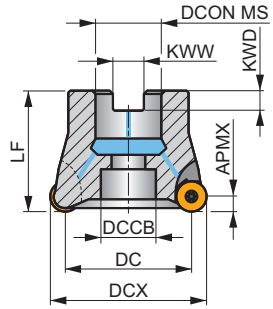
APMX	2.5 mm











h_m 0.065 - 0.19

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	20E2R040B20-SRD10-CF	20	10	90	20	–	–	40	20	–	–	–	–	-2	0	2	–	30800	✓	0.20	GI119	C0356
	20E2R060B20-SRD10-CF	20	10	110	20	–	–	60	22	–	–	–	–	-2	0	2	–	30800	✓	0.20	GI119	C0356
	20E2R080B25-SRD10-CF	20	10	136	25	–	–	80	25	–	–	–	–	-2	0	2	–	30800	✓	0.40	GI119	C0356
	20E2R100B25-SRD10-CF	20	10	156	25	–	–	100	25	–	–	–	–	-2	0	2	–	30800	✓	0.45	GI119	C0356
	20E2R120B25-SRD10-CF	20	10	176	25	–	–	120	25	–	–	–	–	-2	0	2	–	30800	✓	0.46	GI119	C0356
MODULAR	20E2R028M10-SRD10-CF	20	10	47	10.5	18	–	–	–	28	M10	–	–	-2	0	2	–	30800	✓	0.07	GI119	C0356
	25E2R032M12-SRD10-CF	25	15	54	12.5	21	–	–	–	32	M12	–	–	0.5	0.5	2	–	27500	✓	0.08	GI119	C0356
	25E3R032M12-SRD10-CF	25	15	54	12.5	21	–	–	–	32	M12	–	–	0.5	0.5	3	–	27500	✓	0.10	GI119	C0356
	30E4R042M16-SRD10-CF	30	20	65	17	29	–	–	–	42	M16	–	–	0	0	4	–	25100	✓	0.20	GI119	C0356
	32E4R042M16-SRD10-CF	32	22	65	17	29	–	–	–	42	M16	–	–	0	0	4	–	24300	✓	0.19	GI119	C0356
	35E5R042M16-SRD10-CF	35	25	65	17	29	–	–	–	42	M16	–	–	0	0	5	–	23200	✓	0.22	GI119	C0356
	42E4R042M16-SRD10-CF	42	32	65	17	29	–	–	–	42	M16	–	–	0	0	4	–	21200	✓	0.24	GI119	C0356
	42E5R042M16-SRD10-CF	42	32	65	17	29	–	–	–	42	M16	–	–	0	0	5	–	21200	✓	0.24	GI119	C0356
ISO 6462 DIN 8030	42A05R-SMORD10-CF	42	32	–	16	–	14	–	–	40	–	8.4	8.4	0	0	5	–	21200	✓	0.20	GI119	C0358
	52A07R-SMORD10-CF	52	42	–	22	–	18	–	–	40	–	10.4	10.4	0	0	7	–	19100	✓	0.41	GI119	C0360

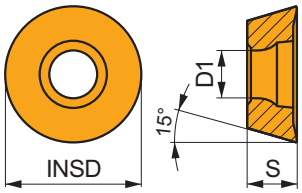
GI119	RD.. 1003MOT	RDHT 1003MO-FA

		Nm					
C0356	US 63507-T15P	3.0	M 3.5	7	Flag T15P	–	–
C0358	US 63507-T15P	3.0	M 3.5	7	D-T08P/T15P	FG-15	HS 0830C
C0360	US 63507-T15P	3.0	M 3.5	7	D-T08P/T15P	FG-15	HS 1030C

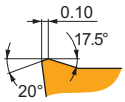
RDGT 10

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.90	3.18



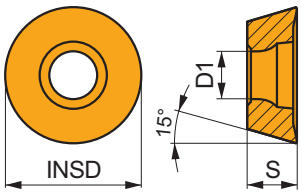
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 U HFC T																				
MOT 正前角设计，适用于精加工。																				
RDGT 1003MOT:M6330		–	290	0.15	1.0	205	0.14	1.0	–	–	–	–	–	–	85	0.12	0.8	–	–	–
RDGT 1003MOT:M8310		–	375	0.15	1.0	190	0.14	1.0	355	0.15	1.0	–	–	–	–	–	–	–	–	–
RDGT 1003MOT:M8325		–	280	0.15	1.0	130	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
RDGT 1003MOT:M8345		–	250	0.15	1.0	150	0.14	1.0	–	–	–	–	–	–	60	0.12	0.8	–	–	–
RDGT 1003MOT:M9340		–	395	0.15	1.0	235	0.14	1.0	–	–	–	–	–	–	95	0.12	0.8	–	–	–

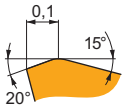
RDMT 10

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.90	3.18



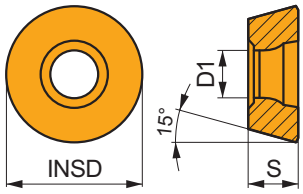
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 HFC S																				
MOT 正前角设计，适用于精加工。																				
RDMT 1003MOT:M8325		–	280	0.15	1.0	130	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
RDMT 1003MOT:M8345		–	250	0.15	1.0	150	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–

RDMX 10

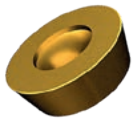
PRAMET

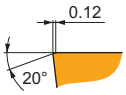
	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.90	3.18



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RDMX 1003MOT:M8310		–	335	0.15	1.0	–	–	–	315	0.15	1.0	–	–	–	–	–	–	65	0.11	0.7
RDMX 1003MOT:M8325		–	250	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDMX 1003MOT:M8345		–	225	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–





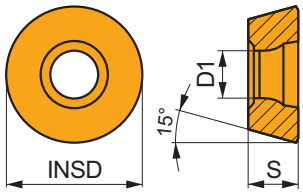
HFC T

MOT 平板设计，适用于精加工。

RDHX 10

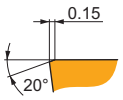
PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.90	3.18



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RDHX 1003MOT:M4303		–	340	0.15	1.0	–	–	–	320	0.15	1.0	–	–	–	–	–	–	65	0.12	0.7
RDHX 1003MOT:M8310		–	335	0.15	1.0	–	–	–	315	0.15	1.0	–	–	–	–	–	–	65	0.12	0.7
RDHX 1003MOT:M8325		–	250	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 1003MOT:M8345		–	225	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

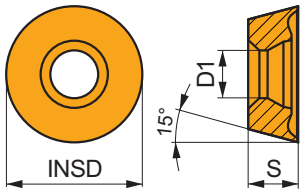


HFC T

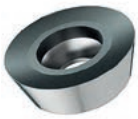
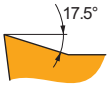
MOT 平板设计，适用于精加工。

RDHT 10-FA

	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.90	3.18

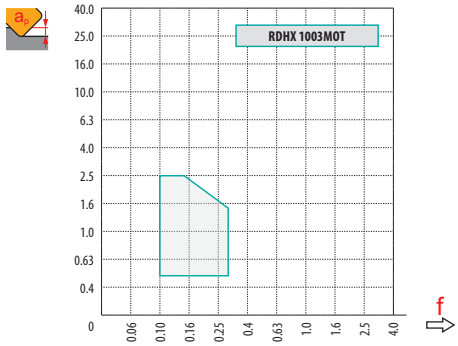


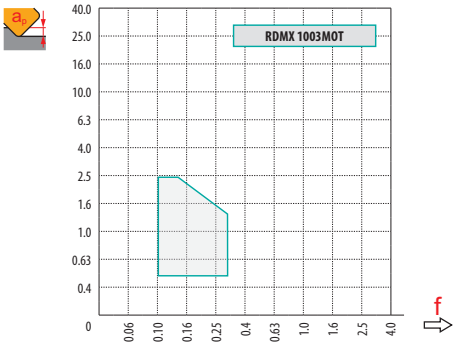
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

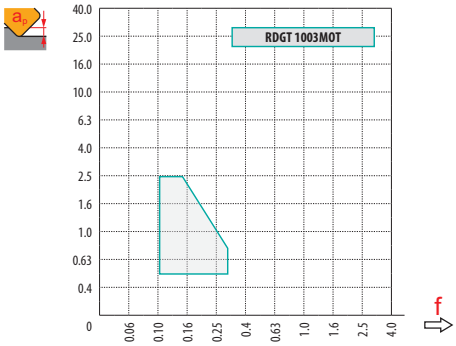
产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			FA 型，具有大正前角设计，适用于精加工到中等加工。																	
RDHT 1003M0-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	■ 390	0.18	1.0	–	–	–	–	–	–

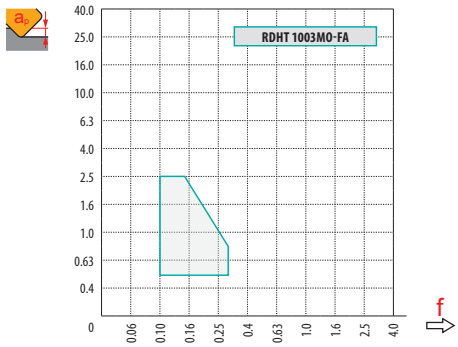
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

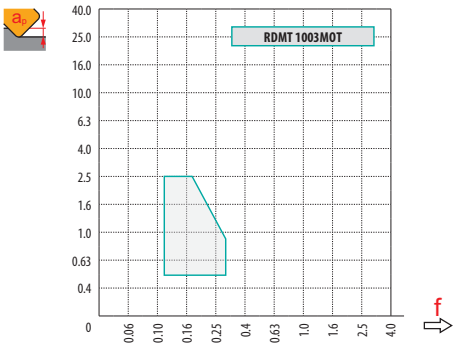
	RDHX 10	RDMX 10	RDGT 10	RDHT 10-FA	RDMT 10
RE	5.0	5.0	5.0	5.0	5.0
BS	–	–	–	–	–











DCX	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00
20	DEF	10.0	14.4	15.3	16.0	16.6	17.1	18.0	18.7	19.2	19.5	19.8	20.0
25		15.0	19.4	20.3	21.0	21.6	22.1	23.0	23.7	24.2	24.5	24.8	25.0
30		20.0	24.4	25.3	26.0	26.6	27.1	28.0	28.7	29.2	29.5	29.8	30.0
32		22.0	26.4	27.3	28.0	28.6	29.1	30.0	30.7	31.2	31.5	31.8	32.0
35		25.0	29.4	30.3	31.0	31.6	32.1	33.0	33.7	34.2	34.5	34.8	35.0
42		32.0	36.4	37.3	38.0	38.6	39.1	40.0	40.7	41.2	41.5	41.8	42.0
52		42.0	46.4	47.3	48.0	48.6	49.1	50.0	50.7	51.2	51.5	51.8	52.0
	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00
	1 ⇨ f	–	0.54	0.44	0.39	0.35	0.32	0.28	0.25	0.23	0.22	0.21	0.19

DCX	RPMX	APMX/I
20	20	2.5/15
25	12	2.5/25
30	8	2.5/37
32	7.5	2.5/20
35	7	2.5/42
42	4	2.5/37
52	3	2.5/49

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
20	22.0	40.0	2.5	2.5
25	32.0	50.0	2.5	2.5
30	42.0	60.0	2.5	2.5
32	46.0	64.0	2.5	2.5
35	52.0	70.0	2.5	2.5
42	66.0	84.0	2.5	2.5
52	86.0	104.0	2.5	2.5

a_p
2.5

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
20	FE	0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
30		0.600	0.775	1.095	1.342	1.549	1.897	2.191	2.449	2.683	3.098	3.464
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
RE	µm	3	5	10	15	20	30	40	50	60	80	100
5.0	FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000

SRD12

P M K N S H

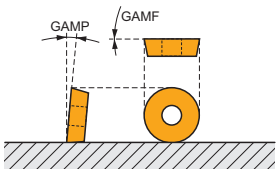
PRAMET

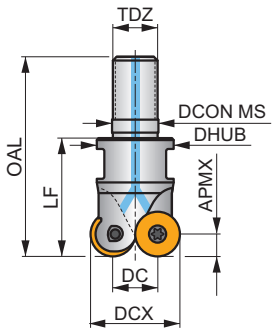
S(C)

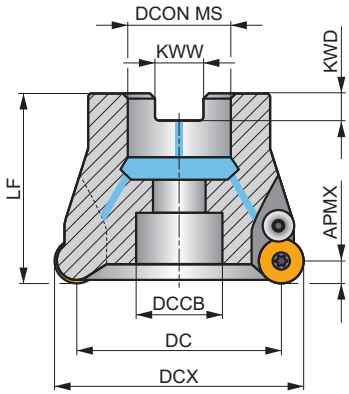
仿形铣削刀盘，使用圆刀片RD.. 12，带内冷

铣刀盘，用于仿形铣削，使用正前角RD..　12刀片，具有APMX(最大切深)3mm。内冷。适用于面铣，螺旋插补铣，坡走铣，连续钻铣和仿形铣削。可提供模块夹紧系统和芯轴式类型。刀体经过处理，使用寿命更长。

APMX	3.0 mm







h_m	0.065 - 0.25
h_m	0.065 - 0.22

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	DCCB (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
MODULAR	24E2R032M12-SRD12-CF	24	12	54	12.5	21	–	32	M12	–	–	-3	0	2	–	21900	✓	0.10	GI120	C0362
	35E3R042M16-SCRD12-CF	35	23	65	17	29	–	42	M16	–	–	0	0	3	–	18100	✓	0.22	GI120	C0364
	35E4R042M16-SRD12-CF	35	23	65	17	29	–	42	M16	–	–	0	0	4	–	18100	✓	0.20	GI120	C0362
	42E4R042M16-SCRD12-CF	42	30	65	17	29	–	42	M16	–	–	0	0	4	–	16600	✓	0.21	GI120	C0364
	42E5R042M16-SRD12-CF	42	30	65	17	29	–	42	M16	–	–	0	0	5	–	16600	✓	0.22	GI120	C0366
ISO 6462 DIN 8030	50A05R-SCMORD12-CF	50	38	–	22	–	18	50	–	10.4	10.4	2	7	5	–	15200	✓	0.29	GI120	C0366
	52A05R-SCMORD12-CF	52	40	–	22	–	18	50	–	10.4	10.4	2	7	5	–	14900	✓	0.44	GI120	C0366
	66A06R-SCMORD12-CF	66	54	–	27	–	22	50	–	12.4	12.4	2	7	6	–	13200	✓	0.54	GI120	C0370
	80A07R-SCMORD12-CF	80	68	–	27	–	38	52	–	12.4	12.4	2	7	7	–	12000	✓	0.89	GI120	C0372

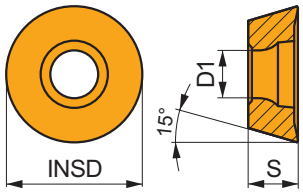
GI120	RD.. 12T3M0T	RDHT 12T3M0-FA

		Nm							
C0362	US 3508-T15P	3.5	M 3.5	8	–	–	Flag T15P	–	–
C0364	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	CS12P	–
C0366	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	–	CS12P	HS 1030C
C0370	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	–	CS12P	HS 1230C
C0372	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	–	CS12P	–

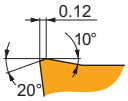
RDGT 12

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
12T3	12.000	3.90	3.97



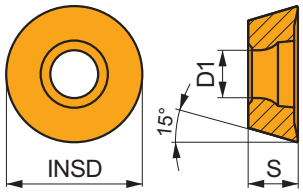
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
MOT 正前角设计，适用于精加工。																				
RDGT 12T3MOT:M6330		–	260	0.20	1.5	185	0.18	1.5	–	–	–	–	–	–	75	0.14	1.2	–	–	–
RDGT 12T3MOT:M8310		–	330	0.20	1.5	165	0.18	1.5	310	0.20	1.5	–	–	–	–	–	–	–	–	–
RDGT 12T3MOT:M8325		–	250	0.20	1.5	120	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
RDGT 12T3MOT:M8345		–	225	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	55	0.14	1.2	–	–	–
RDGT 12T3MOT:M9340		–	340	0.20	1.5	200	0.18	1.5	–	–	–	–	–	–	85	0.14	1.2	–	–	–

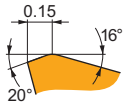
RDMT 12

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
12T3	12.000	3.90	3.97



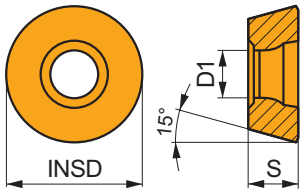
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
MOT 正前角设计，适用于精加工。																				
RDMT 12T3MOT:M8345		–	225	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

RDMX 12

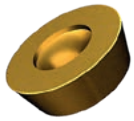
PRAMET

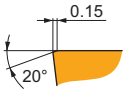
	INSD (mm)	D1 (mm)	S (mm)
12T3	12.000	3.90	3.97



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RDMX 12T3M0T:M8310	✱	–	300	0.20	1.5	–	–	–	285	0.20	1.5	–	–	–	–	–	–	60	0.10	0.8
RDMX 12T3M0T:M8325	✱	–	225	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDMX 12T3M0T:M8345	✱	–	200	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–





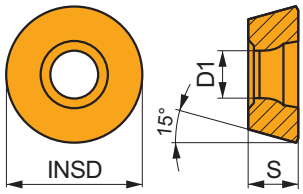
HFC T

MOT 平板设计，适用于精加工。

RDHX 12

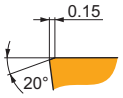
PRAMET

	INSD (mm)	D1 (mm)	S (mm)
12T3	12.000	3.90	3.97



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RDHX 12T3M0T:M4303	✱	–	300	0.20	1.5	–	–	–	285	0.20	1.5	–	–	–	–	–	–	60	0.14	0.8
RDHX 12T3M0T:M8310	✱	–	300	0.20	1.5	–	–	–	285	0.20	1.5	–	–	–	–	–	–	60	0.14	0.8
RDHX 12T3M0T:M8325	✱	–	225	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 12T3M0T:M8345	✱	–	200	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

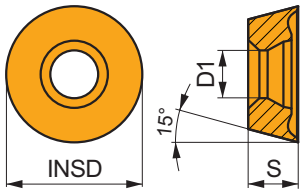


HFC T

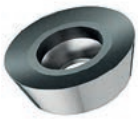
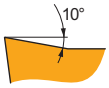
MOT 平板设计，适用于精加工。

RDHT 12-FA

	INSD (mm)	D1 (mm)	S (mm)
12T3	12.000	3.90	3.97

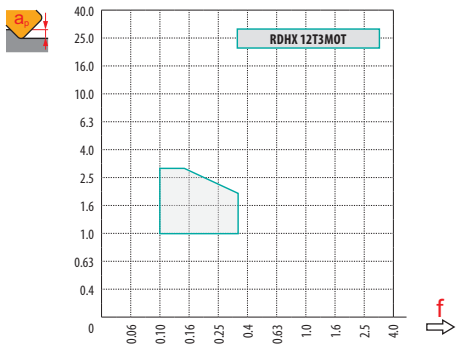


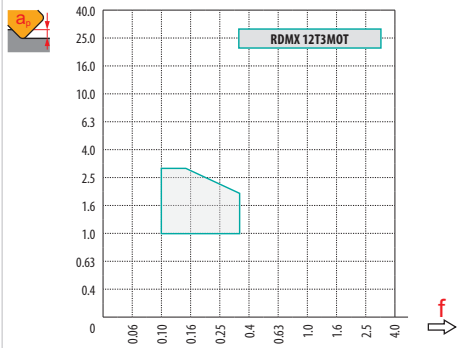
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

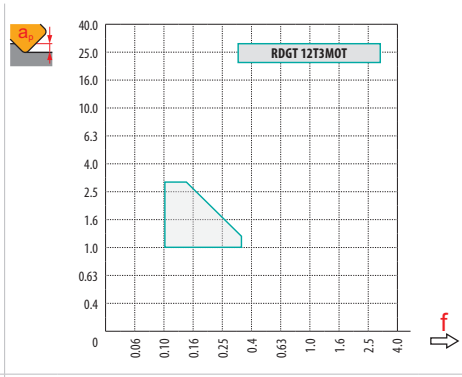
产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			FA 型，具有大正前角设计，适用于精加工到中等加工。																	
RDHT 12T3M0-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	■ 360	0.24	1.5	–	–	–	–	–	–

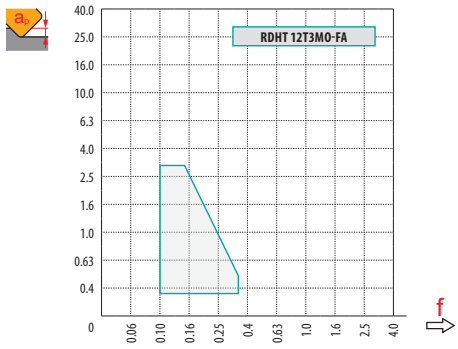
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

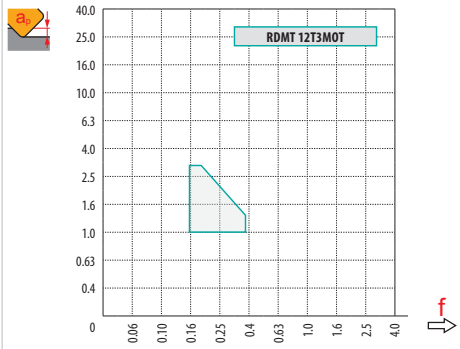
	RDHX 12	RDMX 12	RDGT 12	RDHT 12-FA	RDMT 12
RE	6.0	6.0	6.0	6.0	6.0
a_p	–	–	–	–	–











DCX	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00
24	DEF	12.0	16.8	17.8	18.6	19.3	19.9	20.9	21.7	22.4	22.9	23.3	23.8	24.0
35		23.0	27.8	28.8	29.6	30.3	30.9	31.9	32.7	33.4	33.9	34.3	34.8	35.0
42		30.0	34.8	35.8	36.6	37.3	37.9	38.9	39.7	40.4	40.9	41.3	41.8	42.0
50		38.0	42.8	43.8	44.6	45.3	45.9	46.9	47.7	48.4	48.9	49.3	49.8	50.0
52		40.0	44.8	45.8	46.6	47.3	47.9	48.9	49.7	50.4	50.9	51.3	51.8	52.0
66		54.0	58.8	59.8	60.6	61.3	61.9	62.9	63.7	64.4	64.9	65.3	65.8	66.0
80		68.0	72.8	73.8	74.6	75.3	75.9	76.9	77.7	78.4	78.9	79.3	79.8	80.0
	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00
	1 ⇨ f	–	0.49	0.40	0.35	0.32	0.29	0.25	0.23	0.21	0.20	0.18	0.17	0.16

DCX	RPMX	APMX/I
24	25.0	3.0/14
35	9.0	3.0/39
42	8.0	3.0/44
50	4.0	3.0/87
52	4.0	3.0/87
66	3.0	3.0/100
80	2.2	3.0/100

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
24	26.0	48.0	3.0	3.0
35	46.0	70.0	3.0	3.0
42	62.0	84.0	3.0	3.0
50	78.0	100.0	2.8	2.8
52	82.0	104.0	2.8	2.8
66	110.0	132.0	2.8	2.8
80	136.0	160.0	2.8	2.8

a_p
2.8

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
24	FE	0.537	0.693	0.980	1.200	1.386	1.697	1.960	2.191	2.400	2.771	3.098
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
RE	µm	3	5	10	15	20	30	40	50	60	80	100
6.0	FE	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191

SRD16

P M K N S H

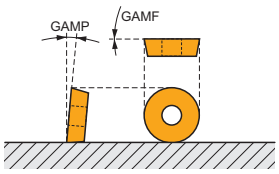
PRAMET

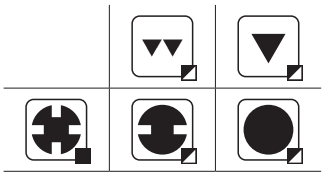
S(C)

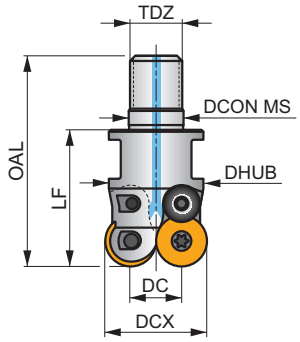
仿形铣削刀盘，使用圆刀片RD.. 16，带内冷

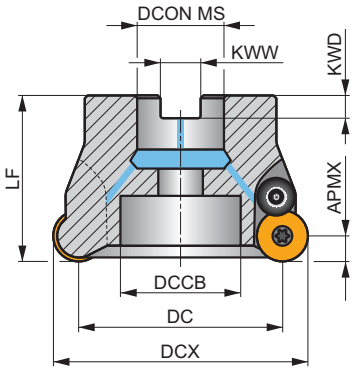
铣刀盘，用于仿形铣削，使用正前角RD.. 16刀片，具有APMX(最大切深)4mm。内冷。适用于面铣，螺旋插补铣，坡走铣，连续钻铣和仿形铣削。可提供模块夹紧系统和心轴式接口。刀体经过处理，使用寿命更长。

APMX	4.0 mm









h_m	0.11 - 0.25
h_m	0.1 - 0.2

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	DCCB (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
MODULAR	32E2R042M16-SCRD16-CF	32	16	65	17	29	–	42	M16	–	–	-2	0	2	–	12600	✓	0.18	GI121	C0374
ISO 6462 DIN 8030	52A04R-SCMORD16-CF	52	36	–	22	–	16.5	50	–	10.4	10.4	0	7	4	–	9900	✓	0.41	GI121	C0376
	66A05R-SCMORD16-CF	66	50	–	27	–	22	50	–	12.4	12.4	0	7	5	–	8800	✓	0.60	GI121	C0378
	80A06R-SCMORD16-CF	80	64	–	27	–	38	52	–	12.4	12.4	0	7	6	–	8000	✓	0.87	GI121	C0380
	100A07R-SCMORD16-CF	100	84	–	32	–	45	52	–	14.4	14.4	0	7	7	–	7100	✓	1.41	GI121	C0380

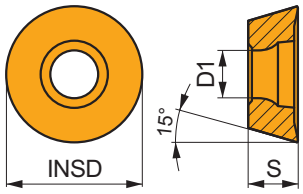
GI121	RD.. 1604MOT	RDHT 1604MO-FA

		Nm						
C0374	US 64510-T20P	4.5	M 4.5	10	–	Flag T20P	CS16P	–
C0376	US 64510-T20P	4.5	M 4.5	10	SDR T20P-T	–	CS16P	HS 1030C
C0378	US 64510-T20P	4.5	M 4.5	10	SDR T20P-T	–	CS16P	HS 1230C
C0380	US 64510-T20P	4.5	M 4.5	10	SDR T20P-T	–	CS16P	–

RDGT 16

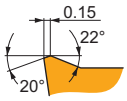
PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1604	16.000	5.20	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RDGT 1604MOT:M8310		–	285	0.30	2.0	145	0.27	2.0	270	0.30	2.0	–	–	–	–	–	–	–	–	–
RDGT 1604MOT:M8325		–	220	0.30	2.0	105	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–
RDGT 1604MOT:M8345		–	200	0.30	2.0	120	0.27	2.0	–	–	–	–	–	–	50	0.21	1.6	–	–	–

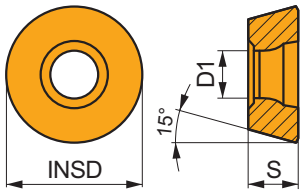


MOT 正前角设计，适用于精加工。

RDMX 16

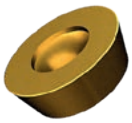
PRAMET

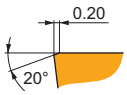
	INSD (mm)	D1 (mm)	S (mm)
1604	16.000	5.20	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RDMX 1604MOT:M8310		–	255	0.30	2.0	–	–	–	240	0.30	2.0	–	–	–	–	–	–	50	0.15	1.1



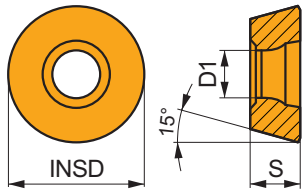


MOT 平板设计，适用于精加工。

RDHX 16

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1604	16.000	5.20	4.76



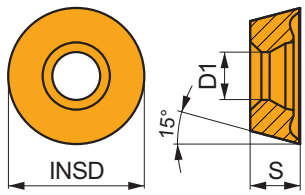
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
MOT 平板设计，适用于精加工。																				
RDHX 1604MOT:M8310	✱	–	255	0.30	2.0	–	–	–	240	0.30	2.0	–	–	–	–	–	–	50	0.15	1.1
RDHX 1604MOT:M8325	✱	–	195	0.30	2.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 1604MOT:M8345	✱	–	180	0.30	2.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 1604MOT:M9325	✱	–	290	0.30	2.0	–	–	–	275	0.30	2.0	–	–	–	–	–	–	55	0.15	1.1

RDHT 16-FA

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1604	16.000	5.20	4.76

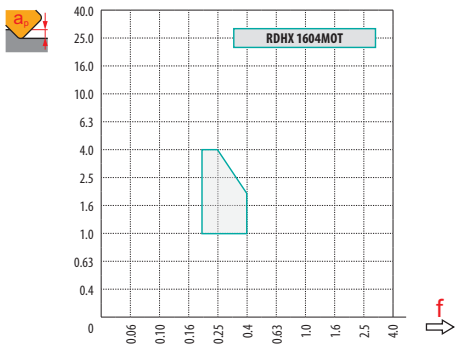


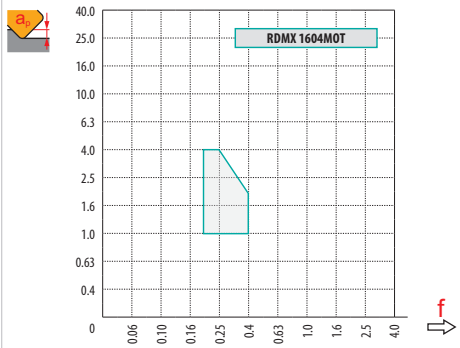
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

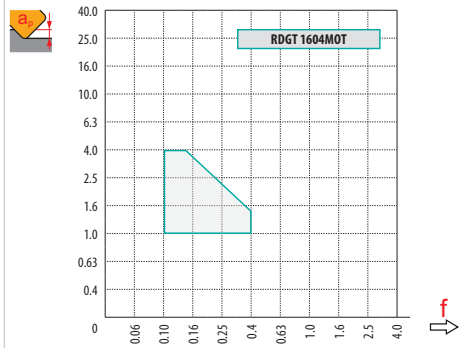
产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
FA 型，具有大正前角设计，适用于精加工到中等加工。																				
RDHT 1604MO-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	315	0.36	2.0	–	–	–	–	–	–

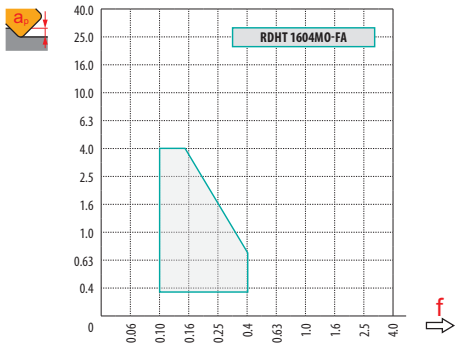
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RDHX 16	RDMX 16	RDGT 16	RDHT 16-FA
RE	8.0	8.0	8.0	8.0
BS	–	–	–	–









DCX	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00	7.00	8.00
32	DEF	16.0	21.6	22.8	23.7	24.6	25.3	26.6	27.6	28.5	29.2	29.9	30.8	31.5	31.9	32.0
52		36.0	41.6	42.8	43.7	44.6	45.3	46.6	47.6	48.5	49.2	49.9	50.8	51.5	51.9	52.0
66		50.0	55.6	56.8	57.7	58.6	59.3	60.6	61.6	62.5	63.2	63.9	64.8	65.5	65.9	66.0
80		64.0	69.6	70.8	71.7	72.6	73.3	74.6	75.6	76.5	77.2	77.9	78.8	79.5	79.9	80.0
100		84.0	89.6	90.8	91.7	92.6	93.3	94.6	95.6	96.5	97.2	97.9	98.8	99.5	99.9	100.0
	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00	7.00	8.00
	1 ⇨ f	–	0.91	0.74	0.65	0.58	0.53	0.46	0.42	0.38	0.36	0.34	0.30	0.28	0.26	0.25

DCX	RPMX	APMX/I
32	25.0	4.0/19
52	8.0	4.0/58
66	6.0	4.0/78
80	4.0	4.0/100
100	3.0	4.0/100

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	34.0	64.0	4.0	4.0
52	74.0	104.0	4.0	4.0
66	102.0	132.0	4.0	4.0
80	130.0	160.0	4.0	4.0
100	170.0	200.0	4.0	4.0

a_p
4.0

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
RE	µm	3	5	10	15	20	30	40	50	60	80	100
8.0	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530

平面铣

	SRC10	SRC12	SRC16	SRC20		
	–	–	–	–		
	APMX (mm) 5.0	APMX (mm) 6.0	APMX (mm) 8.0	APMX (mm) 10.0		
	DCX (mm) 25 – 66	DCX (mm) 40 – 100	DCX (mm) 63 – 160	DCX (mm) 80 – 160		
圆柱刀柄	DCX = 25, 32 (mm)					
侧固刀柄						
模块式刀柄	DCX = 25 – 35 (mm)					
套式铣刀	DCX = 40 – 66 (mm)					
页码	186	190	194	198		
ISO	P M K S H	P M K S H	P M K S H	P M K S H		
刀片形状						
刀片	RC 10T3	RC 1204	RC 1606	RC 2006		
切削刃数量	8	12	8	8		
波状表面(仿形铣)	■	■	■	■		
平面铣	■	■	■	■		
螺旋插补	■	■	■	■		
连续钻铣	■	■	■	■		
坡走铣	■	■	■	■		

■ 推荐使用　◪ 可以使用

SRC10

P M K S H

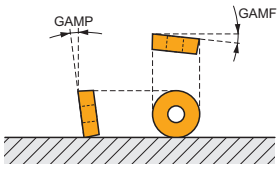
PRAMET

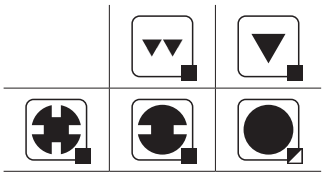
S

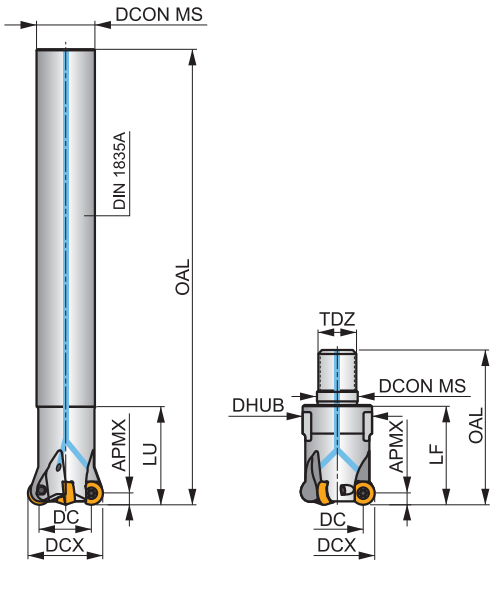
仿形铣削刀盘，使用圆刀片RCMT 10，带内冷

铣刀盘，用于仿形铣削，使用正前角RCMT 10刀片，具有APMX(最大切深)5mm。内冷。适用于面铣，螺旋插补铣，坡走铣，连续钻铣和快进给铣削。可提供圆柱柄，模块夹紧系统和心轴式接口。刀体经过处理，使用寿命更长。

APMX	5.0 mm







h_m	0.05 - 0.12
h_m	0.08 - 0.15

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	25E2R034A20-SRC10-C	25	15	170	20	–	–	34	–	–	–	–	-3	-7	2	–	20900	✓	0.40	GI328	C0010
	25E3R034A20-SRC10-C	25	15	170	20	–	–	34	–	–	–	–	-3	-7	3	–	20900	✓	0.36	GI328	C0010
	32E3R042A25-SRC10-C	32	22	200	25	–	–	42	–	–	–	–	-2.6	-7	4	–	18500	✓	0.67	GI328	C0010
	32E4R042A25-SRC10-C	32	22	200	25	–	–	42	–	–	–	–	-2.6	-7	3	–	18500	✓	0.70	GI328	C0010
MODULAR	25E2R032M12-SRC10-C	25	15	54	12.5	21	–	–	32	M12	–	–	-3	-7	2	–	20900	✓	0.11	GI328	C0010
	25E3R032M12-SRC10-C	25	15	54	12.5	21	–	–	32	M12	–	–	-3	-7	3	–	20900	✓	0.08	GI328	C0010
	32E4R042M16-SRC10-C	32	22	65	17	29	–	–	42	M16	–	–	-2.6	-7	4	–	18500	✓	0.20	GI328	C0010
	35E4R042M16-SRC10-C	35	25	65	17	29	–	–	42	M16	–	–	-2.4	-7	4	–	17700	✓	0.20	GI328	C0010
ISO 6462 DIN 8030	40A05R-SMORC10-C	40	30	–	16	–	14	–	40	–	8.4	5.6	-2.2	-7	5	–	16500	✓	0.21	GI328	C0012
	50A05R-SMORC10-C	50	40	–	22	–	18	–	40	–	10.4	6.3	-2	-7	5	–	14800	✓	0.34	GI328	C0013
	50A06R-SMORC10-C	50	40	–	22	–	18	–	40	–	10.4	6.3	-2	-7	6	–	14800	✓	0.33	GI328	C0013
	52A05R-SMORC10-C	52	42	–	22	–	18	–	40	–	10.4	6.3	-2	-7	5	–	14500	✓	0.35	GI328	C0013
	52A06R-SMORC10-C	52	42	–	22	–	18	–	40	–	10.4	6.3	-2	-7	6	–	14500	✓	0.28	GI328	C0013
	63A06R-SMORC10-C	63	53	–	22	–	18	–	40	–	10.4	6.3	-1.8	-7	6	–	13200	✓	0.52	GI328	C0013
	63A07R-SMORC10-C	63	53	–	22	–	18	–	40	–	10.4	6.3	-1.8	-7	7	–	13200	✓	0.52	GI328	C0013
	66A06R-SMORC10-C	66	56	–	27	–	22	–	50	–	12.4	7	-1.4	-7	6	–	12800	✓	0.58	GI328	C0014
	66A07R-SMORC10-C	66	56	–	27	–	22	–	50	–	12.4	7	-1.4	-7	7	–	12800	✓	0.60	GI328	C0014

GI328	RCMT 10T3MO..

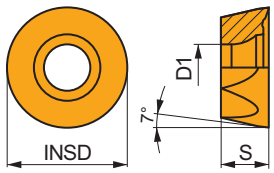
		Nm				
C0010	US 63509-T10P	3.0	M 3.5	9	Flag T10P	–
C0012	US 63509-T10P	3.0	M 3.5	9	Flag T10P	HS 0830C

		Nm				
C0013	US 63509-T10P	3.0	M 3.5	9	Flag T10P	HS 1030C
C0014	US 63509-T10P	3.0	M 3.5	9	Flag T10P	HS 1230C

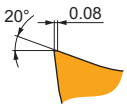
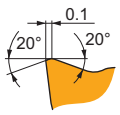
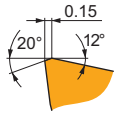
RCMT 10

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
10T3	10.000	3.90	3.97

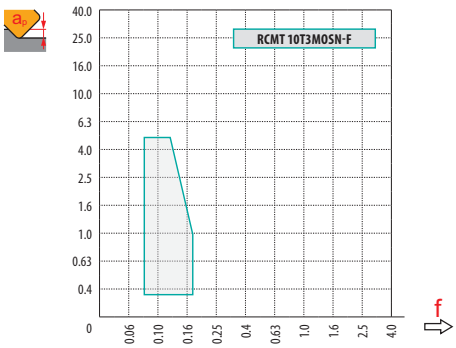


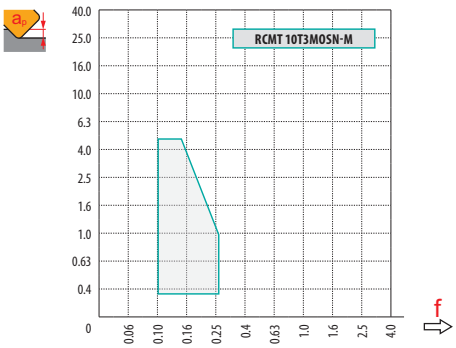
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

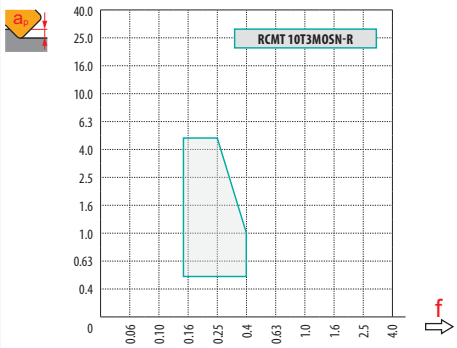
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
	**F 型，具有大正前角设计，适用于轻载加工。**																			
RCMT 10T3M0SN-F:M6330		–	340	0.10	1.0	240	0.09	1.0	–	–	–	–	–	–	100	0.08	0.8	–	–	–
RCMT 10T3M0SN-F:M8330		–	395	0.10	1.0	235	0.09	1.0	–	–	–	–	–	–	95	0.08	0.8	–	–	–
	**M 型，具有大正前角设计，适用于中等加工。**																			
RCMT 10T3M0SN-M:M6330		–	310	0.12	1.0	220	0.11	1.0	–	–	–	–	–	–	90	0.11	0.8	–	–	–
RCMT 10T3M0SN-M:M8310		–	400	0.12	1.0	200	0.11	1.0	380	0.12	1.0	–	–	–	–	–	–	–	–	–
RCMT 10T3M0SN-M:M8330		–	360	0.12	1.0	215	0.11	1.0	340	0.12	1.0	–	–	–	90	0.11	0.8	–	–	–
RCMT 10T3M0SN-M:M8340		–	330	0.12	1.0	195	0.11	1.0	310	0.12	1.0	–	–	–	80	0.11	0.8	–	–	–
	**R 型，具有正前角设计，适用于粗仿形加工。**																			
RCMT 10T3M0SN-R:M8310		–	345	0.17	1.0	–	–	–	325	0.17	1.0	–	–	–	–	–	–	65	0.12	0.7
RCMT 10T3M0SN-R:M8330		–	310	0.17	1.0	–	–	–	290	0.17	1.0	–	–	–	75	0.17	0.8	60	0.12	0.7

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RCMT 10-F	RCMT 10-M	RCMT 10-R
RE	5.0	5.0	5.0
BS	–	–	–







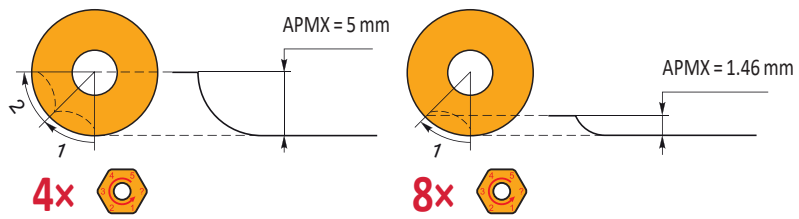
DCX	a_p	0.00	0.15	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00
25	DEF	15.00	17.43	18.41	19.36	20.27	21.00	21.61	22.14	23.00	23.66	24.17	24.80	25.00
32		22.00	24.43	25.41	26.36	27.27	28.00	28.61	29.14	30.00	30.66	31.17	31.80	32.00
35		25.00	27.43	28.41	29.36	30.27	31.00	31.61	32.14	33.00	33.66	34.17	34.80	35.00
40		30.00	32.43	33.41	34.36	35.27	36.00	36.61	37.14	38.00	38.66	39.17	39.80	40.00
50		40.00	42.43	43.41	44.36	45.27	46.00	46.61	47.14	48.00	48.66	49.17	49.80	50.00
52		42.00	44.43	45.41	46.36	47.27	48.00	48.61	49.14	50.00	50.66	51.17	51.80	52.00
63		53.00	55.43	56.41	57.36	58.27	59.00	59.61	60.14	61.00	61.66	62.17	62.80	63.00
66		56.00	58.43	59.41	60.36	61.27	62.00	62.61	63.14	64.00	64.66	65.17	65.80	66.00
	a_p	–	0.15	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00
	1 ⇨ f	–	0.90	0.64	0.50	0.41	0.35	0.32	0.29	0.25	0.23	0.21	0.19	0.17

DCX	RPMX	APMX/I
25	13.2	5/23
32	12.6	5/24
35	12.3	5/24
40	9.5	5/31
50	6.4	5/46
52	6.1	5/48
63	4.7	5/62
66	4.4	5/66

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	32.0	50.0	3.0	3.0
32	45.0	64.0	3.0	3.0
35	51.0	70.0	3.0	3.0
40	61.0	80.0	3.0	3.0
50	81.0	100.0	3.0	3.0
52	85.0	104.0	3.0	3.0
63	107.0	126.0	3.0	3.0
66	113.0	132.0	3.0	3.0

a_p
2.24

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
RE	µm	3	5	10	15	20	30	40	50	60	80	100
5.0	FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000



SRC12

P M K S H

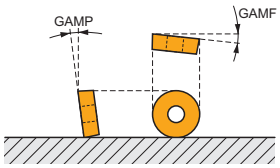
PRAMET

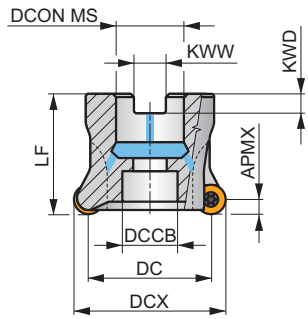
S

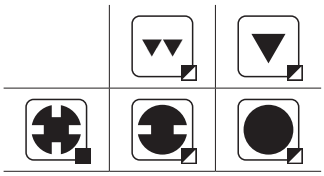
仿形铣削刀盘，使用圆刀片RCMT 12，带内冷

铣刀盘，用于中等仿形铣削，使用正前角RCMT 12刀片，具有APMX(最大切深)6mm。内冷。适用于面铣，螺旋插补铣，坡走铣，连续钻铣和快进给铣削。只提供心轴式接口。刀体经过处理，使用寿命更长。

APMX	6.0 mm







h_m 0.1 - 0.2

	产品	DCX (mm)	DC (mm)	DCON MS (mm)	DCCB (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	40A03R-SMORC12-C	40	28	16	12	40	8.4	5.6	-2.1	-7	3	–	14800	✓	0.27	GI279	C0022	–
	50A04R-SMORC12-C	50	38	22	18	40	10.4	6.3	-2	-7	4	–	13200	✓	0.36	GI279	C0023	–
	52A05R-SMORC12-C	52	40	22	18	40	10.4	6.3	-2	-7	5	–	12900	✓	0.15	GI279	C0023	–
	63A05R-SMORC12-C	63	51	22	30	40	10.4	6.3	-2	-7	5	–	11800	✓	0.45	GI279	C0023	–
	66A06R-SMORC12-C	66	54	27	22	50	12.4	7	-1.5	-7	6	–	11400	✓	0.65	GI279	C0024	–
	80A05R-SMORC12-C	80	68	27	37	50	12.4	7	-1.7	-7	5	–	10400	✓	1.08	GI279	C0024	–
	100A06R-SMORC12-C	100	88	32	45	50	14.4	8	-1.8	-7	6	–	9300	✓	1.78	GI279	C0021	AC002

GI279	RCMT 1204M0..

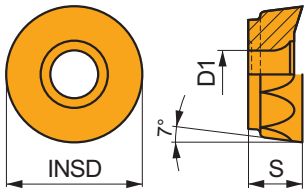
		Nm					
C0021	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	–
C0022	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	HS 90835
C0023	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	HS 1030C
C0024	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	HS 1230C

AC002	KS 1635	K.FMH32

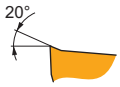
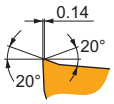
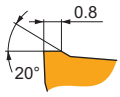
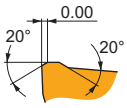
RCMT 12

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1204	12.000	4.40	4.76

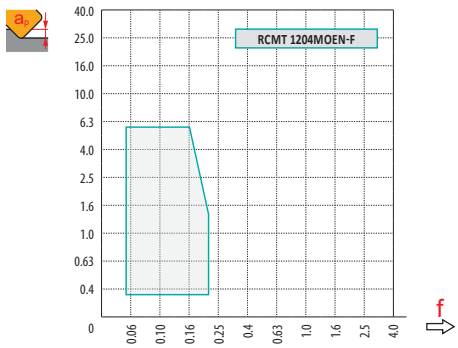


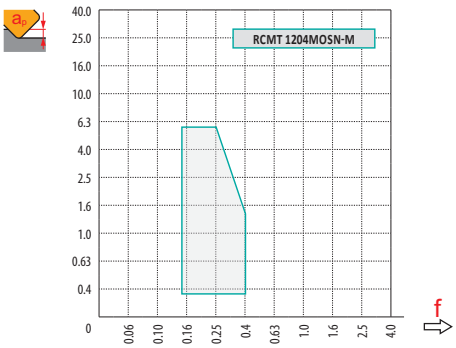
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

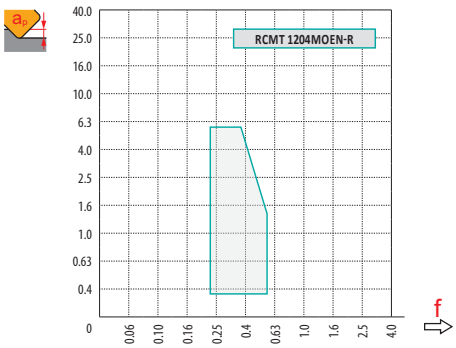
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F 型，具有大正前角设计，适用于轻载加工。																				
RCMT 1204M0EN-F:M8310		–	420	0.10	1.5	210	0.09	1.5	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1204M0EN-F:M8330		–	380	0.10	1.5	225	0.09	1.5	–	–	–	–	–	–	95	0.07	1.2	–	–	–
																				
M 型，具有大正前角设计，适用于中等加工。																				
RCMT 1204M0SN-M:M6330		–	265	0.20	1.5	185	0.18	1.5	–	–	–	–	–	–	75	0.16	1.2	–	–	–
RCMT 1204M0SN-M:M8310		–	335	0.20	1.5	170	0.18	1.5	315	0.20	1.5	–	–	–	–	–	–	–	–	–
RCMT 1204M0SN-M:M8330		–	305	0.20	1.5	180	0.18	1.5	285	0.20	1.5	–	–	–	75	0.16	1.2	–	–	–
RCMT 1204M0SN-M:M8345		–	225	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	55	0.16	1.2	–	–	–
RCMT 1204M0SN-M:M9325		–	380	0.20	1.5	–	–	–	360	0.20	1.5	–	–	–	–	–	–	–	–	–
RCMT 1204M0SN-M:M9340		–	345	0.20	1.5	205	0.18	1.5	–	–	–	–	–	–	85	0.16	1.2	–	–	–
																				
EN-R 型，具有正前角设计，适用于粗仿形加工。																				
RCMT 1204M0EN-R:M8310		–	280	0.30	1.5	140	0.27	1.5	265	0.30	1.5	–	–	–	–	–	–	55	0.15	0.8
RCMT 1204M0EN-R:M8330		–	260	0.30	1.5	155	0.27	1.5	245	0.30	1.5	–	–	–	65	0.24	1.2	50	0.15	0.8
																				
SN-R 型，具有正前角设计，适用于粗仿形加工。																				
RCMT 1204M0SN-R:M8345		–	190	0.35	1.5	–	–	–	–	–	–	–	–	–	45	0.25	1.2	–	–	–
RCMT 1204M0SN-R:M9315		–	315	0.35	1.5	–	–	–	295	0.35	1.5	–	–	–	–	–	–	60	0.18	0.8

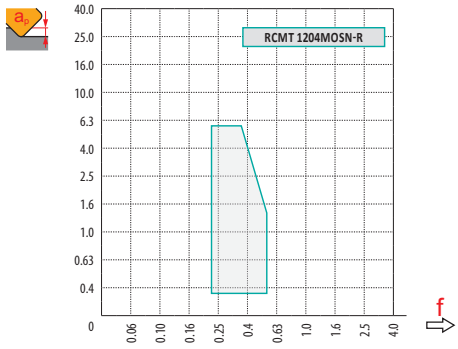
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RCMT 12-F	RCMT 12-M	RCMT 12 EN-R	RCMT 12 SN-R
RE	6.0	6.0	6.0	6.0
BS	–	–	–	–









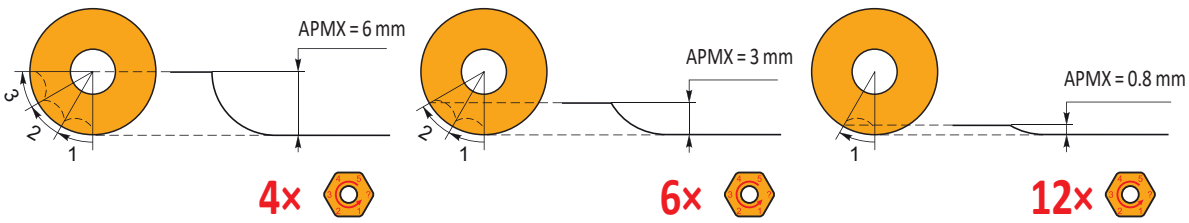
DCX	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00
40	DEF	28.0	31.7	32.8	33.8	34.6	35.3	35.9	36.9	37.7	38.4	39.3	39.8	40.0
50		38.0	41.7	42.8	43.8	44.6	45.3	45.9	46.9	47.7	48.4	49.3	49.8	50.0
52		40.0	43.7	44.8	45.8	46.6	47.3	47.9	48.9	49.7	50.4	51.3	51.8	52.0
63		51.0	54.7	55.8	56.8	57.6	58.3	58.9	59.9	60.7	61.4	62.3	62.8	63.0
66		54.0	57.7	58.8	59.8	60.6	61.3	61.9	62.9	63.7	64.4	65.3	65.8	66.0
80		68.0	71.7	72.8	73.8	74.6	75.3	75.9	76.9	77.7	78.4	79.3	79.8	80.0
100		88.0	91.7	92.8	93.8	94.6	95.3	95.9	96.9	97.7	98.4	99.3	99.8	100.0
	a_p	–	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00
	1 ⇨ f	–	0.95	0.74	0.61	0.53	0.47	0.43	0.38	0.34	0.31	0.28	0.25	0.24

DC	RPMX	APMX/l
40	9.0	6.0/39
50	7.0	6.0/50
52	6.5	6.0/53
63	5.0	6.0/70
66	4.5	6.0/76
80	3.0	5.1/100
100	2.0	3.3/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
40	56.0	80.0	6.0	6.0
50	76.0	100.0	6.0	6.0
52	80.0	104.0	6.0	6.0
63	102.0	126.0	6.0	6.0
66	108.0	132.0	6.0	6.0
80	136.0	160.0	6.0	6.0
100	176.0	200.0	6.0	6.0

a_p
3.5

DC	µm	3	5	10	15	20	30	40	50	60	80	100
40	FE	0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
RE	µm	3	5	10	15	20	30	40	50	60	80	100
6.0	FE	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191



SRC16

P M K S H

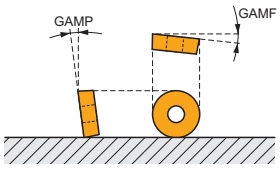
PRAMET

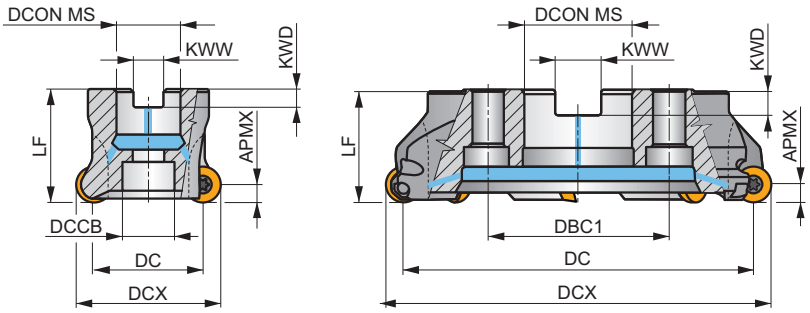
S

仿形铣削刀盘，使用圆刀片RCMT 16，带内冷

铣刀盘，从中等加工至重载仿形铣削，使用正前角RCMT 16刀片，具有APMX(最大切深)8mm。内冷。适用于面铣，螺旋插补铣，坡走铣，连续钻铣和快进给铣削。可提供心轴式接口。刀体经过处理，使用寿命更长。

APMX	8.0 mm





h_m 0.1 - 0.25

	产品	DCX (mm)	DC (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	63A04R-SMORC16-C	63	47	22	18	–	50	10.4	6.3	-2.6	-7	4	–	9700	✓	0.60	GI280	C0033	–
	66A05R-SMORC16-C	66	50	27	22	–	50	12.4	7	-2.5	-7	5	–	9200	✓	0.59	GI280	C0030	–
	80A05R-SMORC16-C	80	64	27	37	–	50	12.4	7	-1.7	-7	5	–	8600	✓	0.87	GI280	C0030	–
	100A06R-SMORC16-C	100	84	32	45	–	50	14.4	8	-1.7	-7	6	–	7700	✓	1.27	GI280	C0031	AC002
	125A07R-SMORC16-C	125	109	40	36	–	63	16.4	9	-1.2	-7	7	–	6500	✓	3.03	GI280	C0032	–
	160C08R-SMORC16-C	160	144	40	–	66.7	63	16.4	9	-0.9	-7	8	–	5400	✓	5.63	GI280	C0034	–

GI280	RCMT 1606M0..

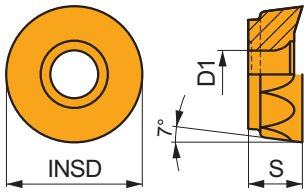
		Nm							
C0030	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HS 1230C	–	–	–
C0031	US 65014-T20P	5.0	M 5	14	SDR T20P-T	–	–	–	–
C0032	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HSD 2040	–	–	–
C0033	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HS 1030C	–	–	–
C0034	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5

AC002	KS 1635	K.FMH32

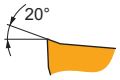
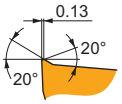
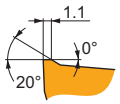
RCMT 16

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1606	16.000	5.50	6.35

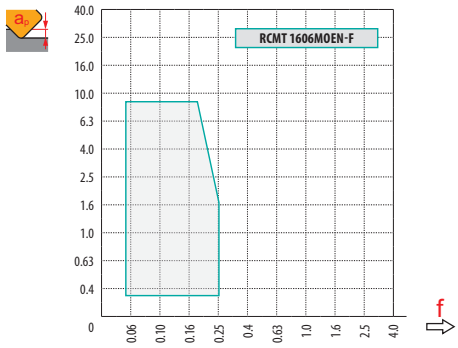


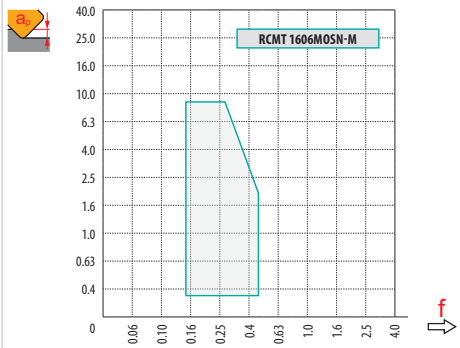
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

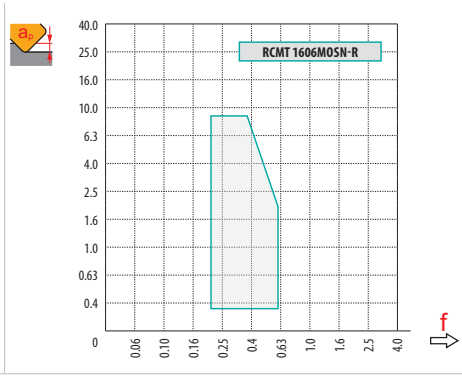
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F 型，具有大正前角设计，适用于轻载加工。																				
RCMT 1606M0EN-F:M8310		–	■	410	0.10	2.0	◪	205	0.09	2.0		–	–	–		–	–	–		–	–	–		–	–	–
RCMT 1606M0EN-F:M8330		–	■	370	0.10	2.0	■	220	0.09	2.0		–	–	–		–	–	–	◪	90	0.07	1.6		–	–	–
																				
M 型，具有大正前角设计，适用于中等加工。																				
RCMT 1606M0SN-M:M6330		–	■	255	0.20	2.0	◪	180	0.18	2.0		–	–	–		–	–	–	■	75	0.16	1.6		–	–	–
RCMT 1606M0SN-M:M8330		–	■	300	0.20	2.0	◪	180	0.18	2.0	■	285	0.20	2.0		–	–	–	◪	75	0.16	1.6		–	–	–
RCMT 1606M0SN-M:M8345		–	■	215	0.20	2.0	◪	125	0.18	2.0		–	–	–		–	–	–	■	50	0.16	1.6		–	–	–
RCMT 1606M0SN-M:M9325		–	■	370	0.20	2.0		–	–	–	■	350	0.20	2.0		–	–	–		–	–	–		–	–	–
RCMT 1606M0SN-M:M9340		–	■	335	0.20	2.0	◪	200	0.18	2.0		–	–	–		–	–	–	■	80	0.16	1.6		–	–	–
																				
R 型，具有正前角设计，适用于粗仿形加工。																				
RCMT 1606M0SN-R:M8310		–	■	250	0.40	2.0		–	–	–	■	235	0.40	2.0		–	–	–		–	–	–	■	50	0.20	1.1
RCMT 1606M0SN-R:M8330		–	■	240	0.40	2.0		–	–	–	■	225	0.40	2.0		–	–	–	◪	60	0.28	1.6	◪	45	0.20	1.1
RCMT 1606M0SN-R:M8345		–	■	175	0.40	2.0		–	–	–		–	–	–		–	–	–	◪	40	0.28	1.6		–	–	–

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RCMT 16-F	RCMT 16-M	RCMT 16-R
RE	8.0	8.0	8.0
BS	–	–	–







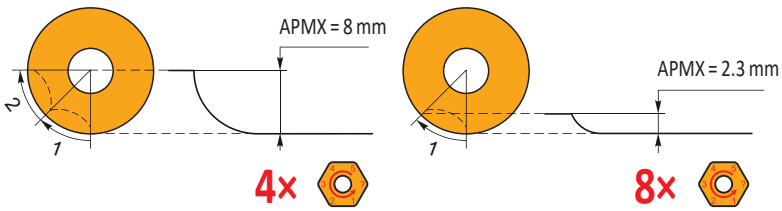
DCX	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00
63	DEF	47.0	51.3	52.6	53.8	54.7	55.6	56.3	57.6	58.6	59.5	60.9	61.8	62.5	62.9	63.0
66		50.0	54.3	55.6	56.8	57.8	58.6	59.3	60.6	61.6	62.5	63.9	64.8	65.5	65.9	66.0
80		64.0	68.3	69.6	70.8	71.7	72.6	73.3	74.6	75.6	76.5	77.9	78.8	79.5	79.9	80.0
100		84.0	88.3	89.6	90.8	91.7	92.6	93.3	94.6	95.6	96.5	97.9	98.8	99.5	99.9	100.0
125		109.0	113.3	114.6	115.8	116.7	117.6	118.3	119.6	120.6	121.5	122.9	123.8	124.5	124.9	125.0
160		144.0	148.3	149.6	150.8	151.7	152.6	153.3	154.6	155.6	156.5	157.9	158.8	159.5	159.9	160.0
	a_p	–	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00
	⇨ f	–	1.10	0.85	0.70	0.61	0.54	0.50	0.43	0.39	0.36	0.31	0.28	0.26	0.25	0.24

DC	RPMX	APMX/I
63	7.0	8.0/67
66	6.5	8.0/71
80	5.0	8.0/93
100	4.0	6.8/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
63	94.0	126.0	8.0	8.0
66	100.0	132.0	8.0	8.0
80	128.0	160.0	8.0	8.0
100	168.0	200.0	8.0	8.0

a_p
5.0

DC	µm	3	5	10	15	20	30	40	50	60	80	100
63	FE	0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071
160		1.386	1.789	2.530	3.098	3.578	4.382	5.060	5.657	6.197	7.155	8.000
RE	µm	3	5	10	15	20	30	40	50	60	80	100
8.0	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530



SRC20

P M K S H

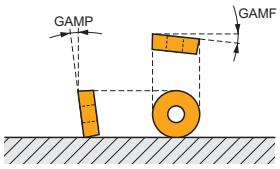
PRAMET

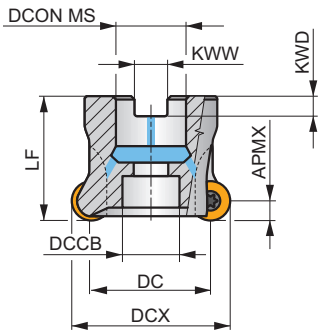
S

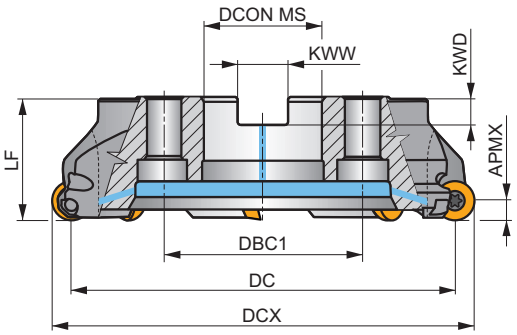
仿形铣削刀盘，使用圆刀片RCMT 20，带内冷

铣刀盘，用于重载仿形铣削，使用正前角RCMT　20刀片，具有APMX(最大切深)10mm。内冷。适用于面铣，螺旋插补铣，坡走铣，连续钻铣和快进给铣削。可提供心轴式接口。刀体经过处理，使用寿命更长。

APMX	10.0 mm







h_m 0.11 - 0.32

	产品	DCX (mm)	DC (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**80A04R-SMORC20-C**	80	60	27	28	–	50	12.4	7	-2.7	-7	4	–	8500	✓	0.91	GI281	C0040	–
	100A05R-SMORC20-C	100	80	32	45	–	50	14.4	8	-1.7	-7	5	–	7600	✓	1.20	GI281	C0041	AC002
	125A06R-SMORC20-C	125	105	40	36	–	63	16.4	9	-1	-7	6	–	6500	✓	2.92	GI281	C0042	–
	160C07R-SMORC20-C	160	140	40	–	66.7	63	16.4	9	-0.9	-7	7	–	5400	✓	5.37	GI281	C0046	–

GI281	RCMT 2006M0..

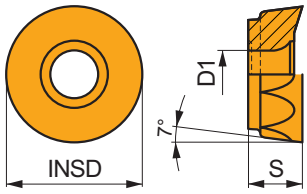
		Nm							
C0040	US 66015-T25P	7.5	M 6	15	SDR T25P-T	HS 1230C	–	–	–
C0041	US 66015-T25P	7.5	M 6	15	SDR T25P-T	–	–	–	–
C0042	US 66015-T25P	7.5	M 6	15	SDR T25P-T	HSD 2040	–	–	–
C0046	US 66015-T25P	7.5	M 6	15	SDR T25P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5

AC002	KS 1635	K.FMH32

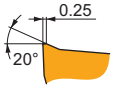
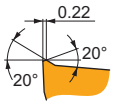
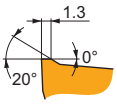
RCMT 20

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
2006	20.000	6.50	6.35

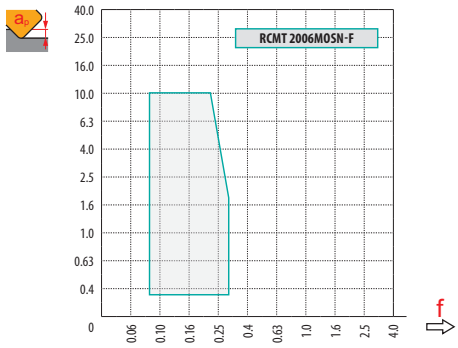


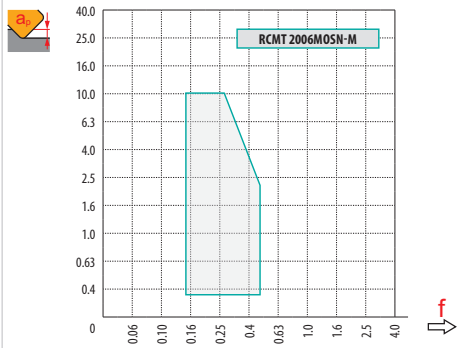
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

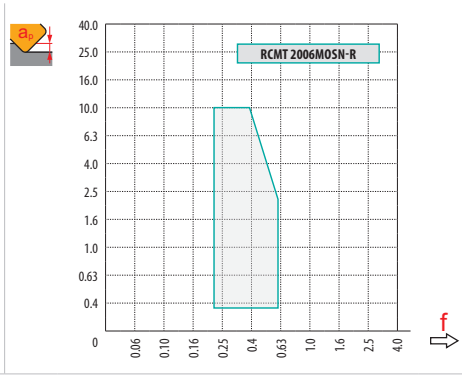
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F 型，具有大正前角设计，适用于轻载加工。																				
RCMT 2006MOSN-F:M8330		–	320	0.15	3.0	190	0.14	3.0	–	–	–	–	–	–	80	0.11	2.4	–	–	–
																				
M 型，具有大正前角设计，适用于中等加工。																				
RCMT 2006MOSN-M:M6330		–	225	0.30	3.0	155	0.27	3.0	–	–	–	–	–	–	65	0.21	2.4	–	–	–
RCMT 2006MOSN-M:M8330		–	255	0.30	3.0	150	0.27	3.0	240	0.30	3.0	–	–	–	60	0.21	2.4	–	–	–
RCMT 2006MOSN-M:M8345		–	190	0.30	3.0	110	0.27	3.0	–	–	–	–	–	–	45	0.21	2.4	–	–	–
RCMT 2006MOSN-M:M9315		–	330	0.30	3.0	–	–	–	310	0.30	3.0	–	–	–	–	–	–	–	–	–
RCMT 2006MOSN-M:M9325		–	315	0.30	3.0	–	–	–	295	0.30	3.0	–	–	–	–	–	–	–	–	–
RCMT 2006MOSN-M:M9340		–	275	0.30	3.0	165	0.27	3.0	–	–	–	–	–	–	65	0.21	2.4	–	–	–
																				
R 型，具有正前角设计，适用于粗仿形加工。																				
RCMT 2006MOSN-R:M8330		–	225	0.45	3.0	–	–	–	210	0.45	3.0	–	–	–	55	0.32	2.4	45	0.23	1.3
RCMT 2006MOSN-R:M8345		–	165	0.45	3.0	–	–	–	–	–	–	–	–	–	40	0.32	2.4	–	–	–
RCMT 2006MOSN-R:M9325		–	260	0.45	3.0	–	–	–	245	0.45	3.0	–	–	–	–	–	–	50	0.23	1.3

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RCMT 20-F	RCMT 20-M	RCMT 20-R
RE	10.0	10.0	10.0
BS	–	–	–







DCX	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00	9.00	10.00
80	DEF	60.0	64.9	66.2	67.6	68.7	69.7	70.5	72.0	73.2	74.3	76.0	77.3	78.3	79.1	79.6	79.9	80.0
100		80.0	84.9	86.2	87.6	88.7	89.7	90.5	92.0	93.2	94.3	96.0	97.3	98.3	99.1	99.6	99.9	100.0
125		105.0	109.9	111.2	112.6	113.7	114.7	115.5	117.0	118.2	119.3	121.0	122.3	123.3	124.1	124.6	124.9	125.0
160		140.0	144.9	146.2	147.6	148.7	149.7	150.5	152.0	153.2	154.3	156.0	157.3	158.3	159.1	159.6	159.9	160.0
	a_p	–	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00	9.00	10.00
	1 ⇨ f	–	1.23	0.95	0.78	0.68	0.61	0.55	0.48	0.43	0.40	0.35	0.31	0.29	0.27	0.26	0.25	0.24

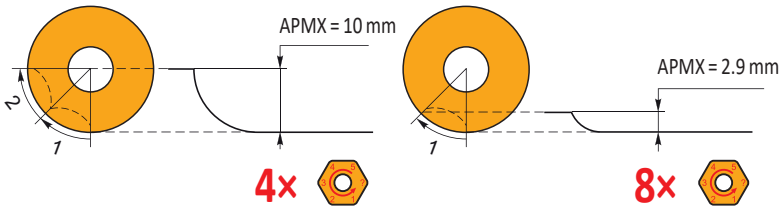
DCX	RPMX	APMX/I
80	7.0	10.0/83
100	5.0	8.6/100

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
80	120.0	160.0	10.0	10.0
100	160.0	200.0	10.0	10.0

a_p
6.0

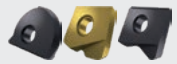
DCX	µm	3	5	10	15	20	30	40	50	60	80	100
80	FE	0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071
160		1.386	1.789	2.530	3.098	3.578	4.382	5.060	5.657	6.197	7.155	8.000

RE	µm	3	5	10	15	20	30	40	50	60	80	100
10.0	FE	0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828



轮廓铣削

平面铣

	L2-SZP	K2-SRC	K2-SLC	K2-PPH	K3-CXP
	–	–	90°	–	–
	APMX (mm) 8.9 – 44.7	APMX (mm) 0.6 – 3.2	APMX (mm) 1.0 – 3.0	APMX (mm) 0.3 – 4.0	APMX (mm) 8.0 – 16.0
	DCX (mm) 10 – 50	DCX (mm) 8 – 32	DCX (mm) 12 – 20	DCX (mm) 8 – 32	DCX (mm) 16 – 32
圆柱刀柄	DCX = 10 – 32 (mm)	DCX = 8 – 32 (mm)		DCX = 8 – 32 (mm)	DCX = 16 – 32 (mm)
侧固刀柄	DCX = 12 – 50 (mm)				DCX = 16 – 25 (mm)
模块式刀柄	DCX = 10 – 32 (mm)	DCX = 8 – 20 (mm)		DCX = 16, 20 (mm)	DCX = 16 – 25 (mm)
Morse	DCX = 12 – 32 (mm)				
页码	206	211	218	222	234
ISO	P M K S H	P M K H	P M K H	P M K S H	P M K S H
刀片形状					
刀片	ZP	RC LC	LC	PPH PPHF PPHT	XP
切削刃数量	2	2	2	2	1
波状表面(仿形铣)	■	■	■	■	■
螺旋插补			◪	◪	
连续钻铣			◪	◪	
坡走铣			◪	◪	
倒角铣			◪	◪	

■ 推荐使用　◪ 可以使用

L2-SZP

P M K S H

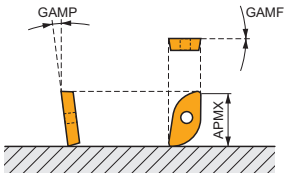
PRAMET

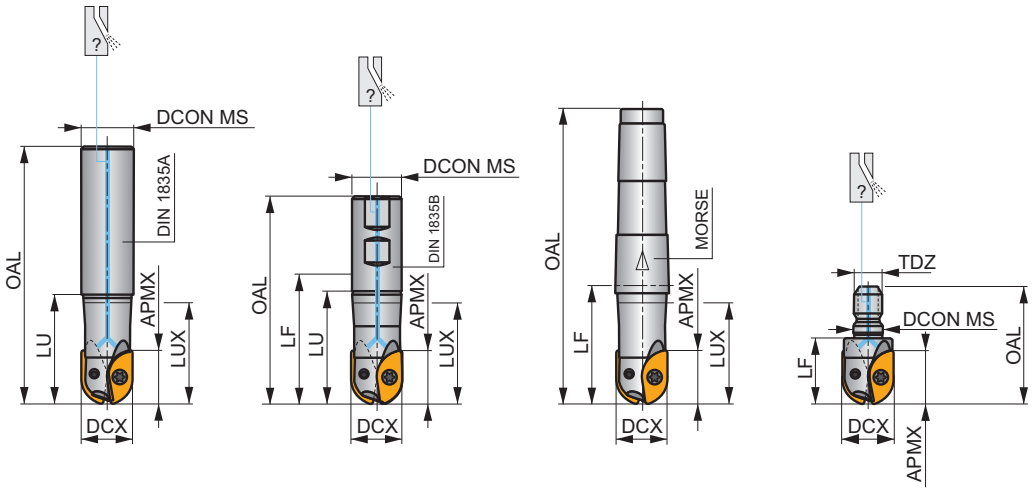
S

球头仿形铣削刀盘，使用ZP..刀片

仿形柳叶铣刀盘，使用ZP..类型刀片，具有APMX(最大切深)从8.9至44.7mm。适用于轮廓铣削。可提供圆柱柄，侧固柄，莫氏锥柄和模块夹紧系统类型。刀体经过处理，使用寿命更长。

APMX	8.9 - 44.7 mm





h_m	0.05 - 0.19

	产品	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	APMX (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	10L2R030A10-SZP10	10	130	10	30	30	–	–	–	8.90	0	-10	2	–	35800	–	0.11	GI255	C0510
	10L2R050A16-SZP10	10	160	16	50	22.3	–	–	–	8.90	0	-10	2	–	35800	–	0.24	GI255	C0510
	12L2R035A12-SZP12	12	140	12	35	35	–	–	–	10.70	0	-10	2	–	21000	–	0.15	GI253	C0510
	12L2R045A20-SZP12	12	200	20	–	22	–	–	–	10.70	0	-10	2	–	21000	–	0.48	GI253	C0511
	16L2R040A16-SZP16-C	16	160	16	40	40	–	–	–	14.40	0	-10	2	–	20000	✓	0.24	GI256	C0510
	16L2R045A20-SZP16-C	16	200	20	–	29.4	–	–	–	14.40	0	-10	2	–	20000	✓	0.43	GI256	C0512
	20L2R050A20-SZP20-C	20	250	20	50	–	–	–	–	17.90	0	-10	2	–	24000	✓	0.54	GI254	C0513
	20L2R055A25-SZP20-C	20	200	25	–	36.1	–	–	–	17.90	0	-10	2	–	24000	✓	0.68	GI254	C0513
	25L2R060A25-SZP25-C	25	250	25	60	–	–	–	–	22.30	0	-10	2	–	24000	✓	0.85	GI257	C0514
	25L2R065A32-SZP25-C	25	250	32	–	43	–	–	–	22.30	0	-10	2	–	24000	✓	1.34	GI257	C0514
	32L2R070A32-SZP32-C	32	250	32	–	–	–	–	–	28.60	0	-10	2	–	18500	✓	1.43	GI258	C0515
DIN 1835B	12L2R040B20-SZP12	12	91	20	40	21.5	66.5	–	–	10.70	0	-10	2	–	21000	–	0.19	GI253	C0511
	12L2R060B20-SZP12	12	111	20	60	23.8	86.5	–	–	10.70	0	-10	2	–	21000	–	0.22	GI253	C0511
	16L2R040B20-SZP16-C	16	91	20	40	28.3	66.5	–	–	14.40	0	-10	2	–	20000	✓	0.15	GI256	C0512
	16L2R060B20-SZP16-C	16	111	20	60	32.9	86.5	–	–	14.40	0	-10	2	–	20000	✓	0.21	GI256	C0512
	20L2R050B25-SZP20-C	20	107	25	50	35.1	75.5	–	–	17.90	0	-10	2	–	24000	✓	0.30	GI254	C0513
	20L2R070B25-SZP20-C	20	127	25	70	39.5	95.5	–	–	17.90	0	-10	2	–	24000	✓	0.36	GI254	C0513
	25L2R060B25-SZP25-C	25	117	25	60	–	85.5	–	–	22.30	0	-10	2	–	24000	✓	0.36	GI257	C0514
	25L2R080B25-SZP25-C	25	137	25	80	–	105	–	–	22.30	0	-10	2	–	24000	✓	0.42	GI257	C0514
	32L2R070B32-SZP32-C	32	131	32	70	–	95.5	–	–	28.60	0	-10	2	–	18500	✓	0.72	GI258	C0515
	32L2R100B32-SZP32-C	32	161	32	100	–	125.5	–	–	28.60	0	-10	2	–	18500	✓	0.81	GI258	C0515
	40L2R070B32-SZP40-C	40	131	32	70	–	95.5	–	–	35.70	0	-10	2	–	8000	✓	0.81	GI259	C0516
	40L2R100B40-SZP40-C	40	171	40	100	–	131	–	–	35.70	0	-10	2	–	8000	✓	1.40	GI259	C0516
	50L2R100B50-SZP50-C	50	181	50	100	–	136.5	–	–	44.70	0	-10	2	–	7000	✓	2.25	GI260	C0517
DIN 228A	12L2R060E02-SZP12	12	124	–	–	25.8	60	–	2	10.70	0	-10	2	–	21000	–	0.17	GI253	C0511
	12L2R090E02-SZP12	12	154	–	–	25.8	90	–	2	10.70	0	-10	2	–	21000	–	0.23	GI253	C0511
	16L2R060E02-SZP16	16	124	–	–	42.2	60	–	2	14.40	0	-10	2	–	20000	–	0.19	GI256	C0512

	产品	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	APMX (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 228A	**16L2R090E02-SZP16**	16	154	–	–	75.9	90	–	2	14.40	0	-10	2	–	20000	–	0.23	GI256	C0512
	20L2R070E03-SZP20	20	151	–	–	–	70	–	3	17.90	0	-10	2	–	24000	–	0.37	GI254	C0513
	20L2R100E03-SZP20	20	181	–	–	77.4	100	–	3	17.90	0	-10	2	–	24000	–	0.42	GI254	C0513
	25L2R080E03-SZP25	25	161	–	–	–	80	–	3	22.30	0	-10	2	–	24000	–	0.44	GI257	C0514
	25L2R110E04-SZP25	25	213	–	–	92.7	110	–	4	22.30	0	-10	2	–	24000	–	0.83	GI257	C0514
	32L2R100E04-SZP32	32	203	–	–	–	100	–	4	28.60	0	-10	2	–	18500	–	0.90	GI258	C0515
	32L2R150E04-SZP32	32	253	–	–	–	150	–	4	28.60	0	-10	2	–	18500	–	1.10	GI258	C0515
MODULAR	**10L2R025M08-SZP10**	10	–	8.5	–	–	25	M8	–	8.90	0	-10	2	–	–	–	0.03	GI255	C0510
	12L2R025M06-SZP12	12	–	6.5	–	–	25	M6	–	10.70	0	-10	2	–	–	–	0.05	GI253	C0510
	12L2R025M08-SZP12	12	–	8.5	–	–	25	M8	–	10.70	0	-10	2	–	–	–	0.04	GI253	C0511
	16L2R025M08-SZP16	16	–	8.5	–	–	25	M8	–	14.40	0	-10	2	–	–	–	0.05	GI256	C0512
	20L2R030M10-SZP20-C	20	–	10.5	–	–	30	M10	–	17.90	0	-10	2	–	–	✓	0.07	GI254	C0513
	25L2R035M12-SZP25-C	25	–	12.5	–	–	35	M12	–	22.30	0	-10	2	–	–	✓	0.09	GI257	C0514
	32L2R045M16-SZP32-C	32	–	17	–	–	45	M16	–	27.90	0	-10	2	–	–	✓	0.15	GI258	C0515

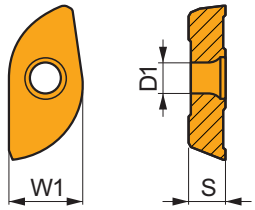
GI253	ZP 12..
GI254	ZP 20..
GI255	ZP 10..
GI256	ZP 16..
GI257	ZP 25..
GI258	ZP 32..
GI259	ZP 40..
GI260	ZP 50..

					Nm			
C0510	–	–	Flag T06P	US 62004-T06P	0.6	M 2	4	–
C0511	–	–	Flag T08P	US 62506-T08P	1.2	M 2.5	6	–
C0512	–	–	Flag T08P	US 62508-T08P	1.2	M 2.5	7	–
C0513	–	–	Flag T10P	US 63510-T10P	2.0	M 3.5	9	–
C0514	–	–	Flag T15P	US 4011A-T15P	3.5	M 4	11	–
C0515	–	–	–	US 65013-T20	5.0	M 5	13	SDR T20
C0516	–	–	–	US 66015-T25P	7.5	M 6	15	SDR T25P
C0517	SZN 400322	US 3508-T15P	Flag T15P	US 68020-T30P	15.0	M 8	20	SDR T30P

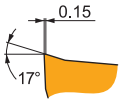
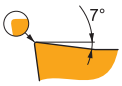
ZP

PRAMET

	W1 (mm)	D1 (mm)	S (mm)
10	10.000	2.20	1.70
12	12.000	2.90	2.38
16	16.000	2.90	3.18
20	20.000	4.00	3.97
25	25.000	4.70	4.76
32	32.000	5.90	6.35
40	40.000	7.00	7.94
50	50.000	9.60	7.94



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

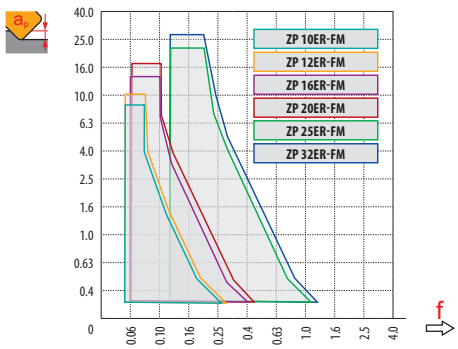
产品	●	⚙	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
FM 型，具有锋利中等宽度设计适用于轻载到中等加工。																					
ZP 10ER-FM:M8310	●	–	■	305	0.36	0.5	–	–	–	■	285	0.36	0.5	–	–	–	–	–	–	■ 60	0.25	0.5
ZP 10ER-FM:M8345	⚙	–	■	210	0.36	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
ZP 12ER-FM:M8310	●	–	■	300	0.36	0.6	–	–	–	■	285	0.36	0.6	–	–	–	–	–	–	■ 60	0.25	0.6
ZP 12ER-FM:M8345	⚙	–	■	205	0.36	0.6	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
ZP 16ER-FM:M8310	●	–	■	290	0.36	0.8	–	–	–	■	275	0.36	0.8	–	–	–	–	–	–	■ 55	0.25	0.8
ZP 20ER-FM:M8310	●	–	■	285	0.36	1.0	–	–	–	■	270	0.36	1.0	–	–	–	–	–	–	■ 55	0.25	1.0
ZP 25ER-FM:M8310	●	–	■	275	0.36	1.3	–	–	–	■	260	0.36	1.3	–	–	–	–	–	–	■ 55	0.25	1.3
ZP 32ER-FM:M8310	●	–	■	270	0.36	1.6	–	–	–	■	255	0.36	1.6	–	–	–	–	–	–	■ 50	0.25	1.6
																					
M 型，具有大正前角设计，适用于中等加工。																					
ZP 12ER-M:M8330	⚙	–	■	280	0.36	0.6	■	165	0.32	0.6	◪	265	0.36	0.6	–	–	–	◪	70	0.25	0.5	–	–	–
ZP 12ER-M:M8345	⚙	–	■	205	0.36	0.6	■	120	0.32	0.6		–	–	–	–	–	–	◪	50	0.25	0.5	–	–	–
ZP 16ER-M:M8330	⚙	–	■	270	0.36	0.8	■	160	0.32	0.8	◪	255	0.36	0.8	–	–	–	◪	65	0.25	0.6	–	–	–
ZP 16ER-M:M8340	⚙	–	■	250	0.36	0.8	■	150	0.32	0.8	◪	235	0.36	0.8	–	–	–	◪	60	0.25	0.6	–	–	–
ZP 16ER-M:M8345	⚙	–	■	200	0.36	0.8	■	120	0.32	0.8		–	–	–	–	–	–	◪	50	0.25	0.6	–	–	–
ZP 20ER-M:M8330	⚙	–	■	265	0.36	1.0	■	155	0.32	1.0	◪	250	0.36	1.0	–	–	–	◪	65	0.25	0.8	–	–	–
ZP 20ER-M:M8345	⚙	–	■	195	0.36	1.0	■	115	0.32	1.0		–	–	–	–	–	–	◪	45	0.25	0.8	–	–	–
ZP 25ER-M:M8330	⚙	–	■	260	0.36	1.3	■	155	0.32	1.3	◪	245	0.36	1.3	–	–	–	◪	65	0.25	1.0	–	–	–
ZP 25ER-M:M8345	⚙	–	■	190	0.36	1.3	■	110	0.32	1.3		–	–	–	–	–	–	◪	45	0.25	1.0	–	–	–
ZP 32ER-M:M8330	⚙	–	■	255	0.36	1.6	■	150	0.32	1.6	◪	240	0.36	1.6	–	–	–	◪	60	0.25	1.3	–	–	–
																					
R 型，具有锋利很小的正前角设计，适用于轻载到中等加工。																					
ZP 16ER-R:M8345	⚙	–	■	190	0.45	0.8	■	110	0.41	0.8		–	–	–	–	–	–	◪	45	0.32	0.8	–	–	–
ZP 20ER-R:M8345	⚙	–	■	185	0.45	1.0	■	110	0.41	1.0		–	–	–	–	–	–	◪	45	0.32	1.0	–	–	–
ZP 25ER-R:M8345	⚙	–	■	180	0.45	1.3	■	105	0.41	1.3		–	–	–	–	–	–	◪	45	0.32	1.3	–	–	–
ZP 32ER-R:M8330	⚙	–	■	240	0.45	1.6	■	140	0.41	1.6	◪	225	0.45	1.6	–	–	–	◪	60	0.32	1.6	◪ 45	0.32	1.6
ZP 32ER-R:M8345	⚙	–	■	175	0.45	1.6	■	105	0.41	1.6		–	–	–	–	–	–	◪	40	0.32	1.6	–	–	–
ZP 40ER-R:M8345	⚙	–	■	170	0.45	2.0	■	100	0.41	2.0		–	–	–	–	–	–	◪	40	0.32	2.0	–	–	–
ZP 50ER-R:M8345	⚙	–	■	165	0.45	2.5	■	95	0.41	2.5		–	–	–	–	–	–	◪	40	0.32	2.5	–	–	–

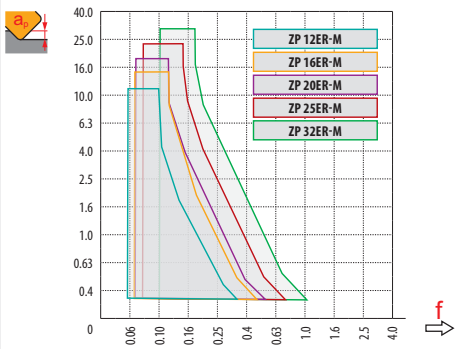
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

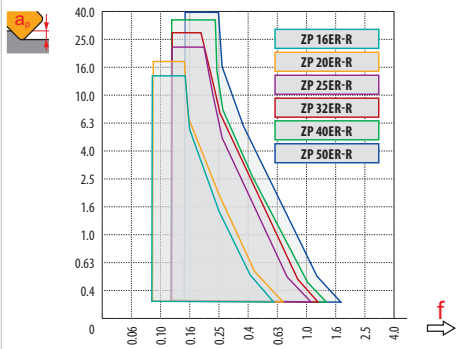
	ZP 10-FM	ZP 12-FM	ZP 16-FM	ZP 20-FM	ZP 25-FM	ZP 32-FM
RE	5.0	6.0	8.0	10.0	12.5	16.0
BS	–	–	–	–	–	–

	ZP 12-M	ZP 16-M	ZP 20-M	ZP 25-M	ZP 32-M
RE	6.0	8.0	10.0	12.5	16.0
BS	–	–	–	–	–

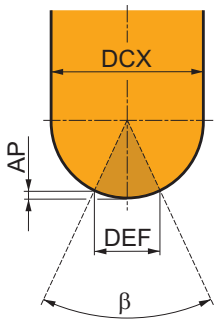
	ZP 16-R	ZP 20-R	ZP 25-R	ZP 32-R	ZP 40-R	ZP 50-R
RE	8.0	10.0	12.5	16.0	20.0	25.0
BS	–	–	–	–	–	–







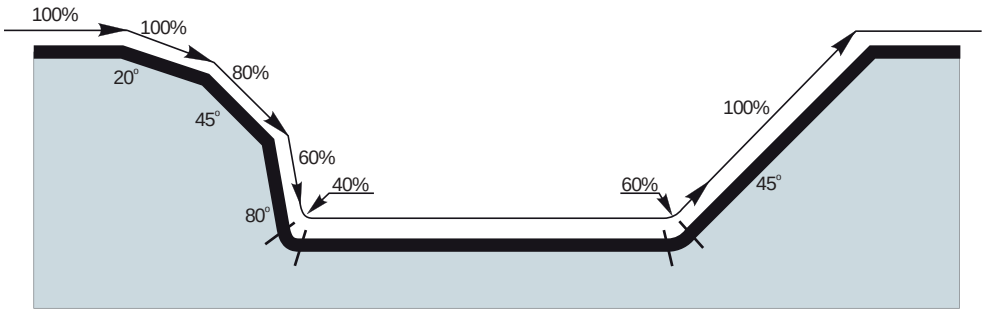
DCX	a_p	0.30	0.40	0.50	0.70	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	8.00	10.00	12.00	15.00	16.00	20.00	22.50	25.00
10	DEF	3.4	3.9	4.4	5.1	6.0	6.6	7.1	8.0	8.7	9.2	9.8	10.0	–	–	–	–	–	–	–	–	–
12		3.7	4.3	4.8	5.6	6.6	7.3	7.9	8.9	9.7	10.4	11.3	11.8	12.0	–	–	–	–	–	–	–	–
16		4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	–	–	–	–	–	–	–
20		4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	–	–	–	–	–	–
25		5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	–	–	–	–	–
32		6.2	7.1	7.9	9.4	11.1	12.4	13.5	15.5	17.2	18.7	21.2	23.2	25.0	27.7	29.7	31.2	31.9	32.0	–	–	–
40		6.9	8.0	8.9	10.5	12.5	13.9	15.2	17.4	19.4	21.1	24.0	26.5	28.6	32.0	34.6	37.1	38.7	39.2	40.0	–	–
50		7.7	8.9	9.9	11.7	14.0	15.6	17.1	19.6	21.8	23.7	27.1	30.0	32.5	36.7	40.0	43.3	45.8	46.6	49.0	49.7	50.0



DCX		β	DEF	AP
10	FM	41°	3.496	0.322
12	FM	41°	4.194	0.381
16	FM	42°	5.660	0.520
20	FM	42°	7.100	0.650
25	FM	41°	8.756	0.794
35	FM	41°	11.113	0.998
40	R	41°	14.108	1.298
50	R	45°	19.176	1.915

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472

DEF	a_e	1 %	2.5 %	5 %	7.5 %	10 %	15 %	20 %	25 %	30 %	35 %	40 %	45 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	a_p										⇨ x.f									
19.9 %	1.0 %	2.86	1.84	1.33	1.12	1.00	0.89	–	–	–	–	–	–	–	–	–	–	–	–	–
31.2 %	2.5 %	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	–	–	–	–	–	–	–	–	–	–
43.6 %	5.0 %	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	–	–	–	–	–	–	–	–
52.7 %	7.5 %	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	–	–	–	–	–	–
60.0 %	10.0 %	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	–	–	–	–	–
71.4 %	15.0 %	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	–	–	–	–
80.0 %	20.0 %	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	–	–
86.6 %	25.0 %	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	–	–
91.7 %	30.0 %	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	–
95.4 %	35.0 %	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	–
98.0 %	40.0 %	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	–
99.5%	45.0 %	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	–
100.0 %	50.0 %	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00



悬伸(长径比)	< 3.0	3.0 – 3.5	3.6 – 4.0	4.1 – 4.5	> 4.6
速度校正因子	1.0	0.9	0.8	0.7	0.5

K2-SRC

P M K H

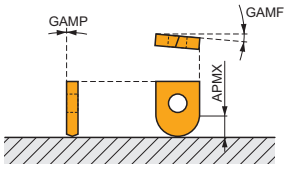
PRAMET

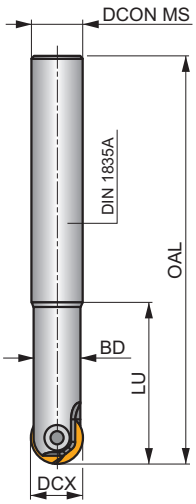
S

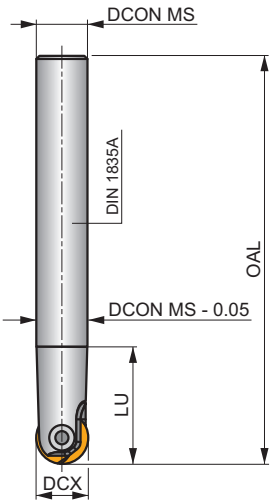
仿形和轮廓立铣刀

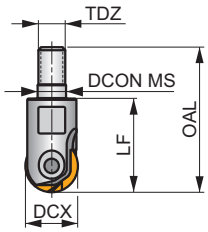
灵活的立铣刀适用于各种模具。一种刀具可提供球形、环形刀片。可提供圆柱直柄和模块夹紧系统类型。刀体经过处理，使用寿命更长。

APMX	0.6 - 3.2 mm









h_m	0.07 - 0.14

	产品	DCX (mm)	OAL (mm)	DCON MS (mm)	BD (mm)	LU (mm)	LF (mm)	TDZ			max.		kg		
DIN 1835A	08K2R025A10-SRC08-A	8	110	10	7.5	25	–	–	2	–	56000	–	0.08	GI030	CO530
	08K2R050A12-SRC08-A	8	140	12	–	13.5	–	–	2	–	56000	–	0.14	GI030	CO530
	10K2R030A12-SRC10-A	10	130	12	9	30	–	–	2	–	42000	–	0.16	GI031	CO531
	10K2R060A16-SRC10-A	10	150	16	–	19.5	–	–	2	–	42000	–	0.18	GI031	CO531
	12K2R030A12-SRC12-A	12	130	12	10.5	30	–	–	2	–	35000	–	0.11	GI032	CO532
	12K2R060A16-SRC12-A	12	160	16	–	24.5	–	–	2	–	35000	–	0.14	GI032	CO532
	16K2R035A16-SRC16-A	16	140	16	14	35	–	–	2	–	22000	–	0.23	GI033	CO533
	16K2R065A20-SRC16-A	16	175	20	–	31.5	–	–	2	–	22000	–	0.30	GI033	CO533
	20K2R045A20-SRC20-A	20	160	20	18	45	–	–	2	–	16000	–	0.40	GI034	CO534
	20K2R080A25-SRC20-A	20	190	25	–	33.5	–	–	2	–	16000	–	0.66	GI034	CO534
	25K2R045A25-SRC25-A	25	160	25	22.4	45	–	–	2	–	10000	–	0.59	GI035	CO535
	32K2R060A32-SRC32-A	32	180	32	28.6	60	–	–	2	–	6000	–	1.10	GI036	CO536
MODULAR	08K2R30M06-SRC08-A	8	45	6.5	–	–	30	M6	2	–	–	–	0.02	GI123	CO530
	10K2R30M06-SRC10-A	10	45	6.5	–	–	30	M6	2	–	–	–	0.03	GI124	CO531
	12K2R30M06-SRC12-A	12	45	6.5	–	–	30	M6	2	–	–	–	0.15	GI125	CO530
	12K2R30M08-SRC12-A	12	48	8.5	–	–	30	M8	2	–	–	–	0.04	GI125	CO532
	16K2R35M08-SRC16-A	16	53	8.5	–	–	35	M8	2	–	–	–	0.16	GI033	CO533
	20K2R35M10-SRC20-A	20	54	10.5	–	–	35	M10	2	–	–	–	0.08	GI034	CO534

GI030	RC 08	–	LC 08-KP	LC 08-KPF
GI031	RC 10	RC 10-F	LC 10-KP	LC 10-KPF
GI032	RC 12	RC 12-F	–	–
GI033	RC 16	RC 16-F	–	–
GI034	RC 20	–	–	–
GI035	RC 25	–	–	–

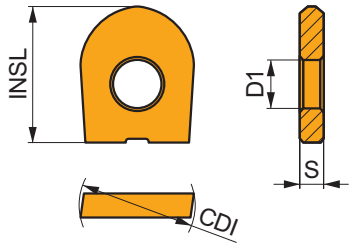
GI036	RC 32	–	–	–
GI123	RC 08	–	–	–
GI124	RC 10	RC 10-F	–	–
GI125	RC 12	RC 12-F	–	–

		Nm						
C0530	CS 3007-T08P	1.2	M 3	7	–	–	–	Flag T08P
C0531	CS 4008-T15P	3.0	M 4	8	–	D-T08P/T15P	FG-15	–
C0532	CS 5009-T20P	5.0	M 5	9	SDR T20P	–	–	–
C0533	CS 5013-T20P	5.0	M 5	13	SDR T20P	–	–	–
C0534	CS 5015-T20P	5.0	M 5	15	SDR T20P	–	–	–
C0535	CS 6020-T20P	7.5	M 6	20	SDR T20P	–	–	–
C0536	CS 8025-T30P	15.0	M 8	25	SDR T30P	–	–	–

RC

PRAMET

	CDI (mm)	D1 (mm)	INSL (mm)	S (mm)
08	8.0	3.00	9.5	2.00
10	10.0	4.00	11.5	2.50
12	12.0	5.00	12.0	2.50
16	16.0	5.00	14.0	3.00
20	20.0	5.00	16.0	3.00
25	25.0	6.00	21.5	4.00
32	32.0	8.00	25.8	5.00



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

N 中等宽度的表面具有一个正前角切削刃设计。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RC 08:M4310		–	◪ 255	0.36	0.4	–	–	–	■ 240	0.36	0.4	–	–	–	–	–	–	■ 50	0.18	0.8
RC 08:M8310		–	◪ 295	0.36	0.4	–	–	–	■ 280	0.36	0.4	–	–	–	–	–	–	■ 55	0.18	0.8
RC 10:M4310		–	◪ 250	0.36	0.5	–	–	–	■ 235	0.36	0.5	–	–	–	–	–	–	■ 50	0.18	1.0
RC 10:M8310		–	◪ 290	0.36	0.5	–	–	–	■ 275	0.36	0.5	–	–	–	–	–	–	■ 55	0.18	1.0
RC 10:M8330		–	◪ 270	0.36	0.5	–	–	–	■ 255	0.36	0.5	–	–	–	–	–	–	◪ 50	0.18	1.0
RC 12:M4310		–	◪ 245	0.36	0.6	–	–	–	■ 230	0.36	0.6	–	–	–	–	–	–	■ 45	0.18	1.2
RC 12:M8310		–	■ 285	0.36	0.6	–	–	–	■ 270	0.36	0.6	–	–	–	–	–	–	■ 55	0.18	1.2
RC 12:M8330		–	■ 265	0.36	0.6	–	–	–	■ 250	0.36	0.6	–	–	–	–	–	–	◪ 50	0.18	1.2
RC 16:M4310		–	◪ 235	0.36	0.8	–	–	–	■ 220	0.36	0.8	–	–	–	–	–	–	■ 45	0.18	1.1
RC 16:M8310		–	■ 275	0.36	0.8	–	–	–	■ 260	0.36	0.8	–	–	–	–	–	–	■ 55	0.18	1.1
RC 16:M8330		–	■ 255	0.36	0.8	–	–	–	■ 240	0.36	0.8	–	–	–	–	–	–	◪ 50	0.18	1.1
RC 20:M4310		–	◪ 235	0.36	1.0	–	–	–	■ 220	0.36	1.0	–	–	–	–	–	–	■ 45	0.18	1.3
RC 20:M8310		–	■ 270	0.36	1.0	–	–	–	■ 255	0.36	1.0	–	–	–	–	–	–	■ 50	0.18	1.3
RC 20:M8330		–	■ 250	0.36	1.0	–	–	–	■ 235	0.36	1.0	–	–	–	–	–	–	◪ 50	0.18	1.3
RC 25:M8310		–	■ 260	0.36	1.3	–	–	–	■ 245	0.36	1.3	–	–	–	–	–	–	■ 50	0.18	1.7
RC 25:M8330		–	■ 245	0.36	1.3	–	–	–	■ 230	0.36	1.3	–	–	–	–	–	–	◪ 45	0.18	1.7
RC 32:M4310		–	◪ 220	0.36	1.6	–	–	–	■ 205	0.36	1.6	–	–	–	–	–	–	■ 40	0.18	2.1
RC 32:M8330		–	■ 240	0.36	1.6	–	–	–	■ 225	0.36	1.6	–	–	–	–	–	–	◪ 45	0.18	2.1

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

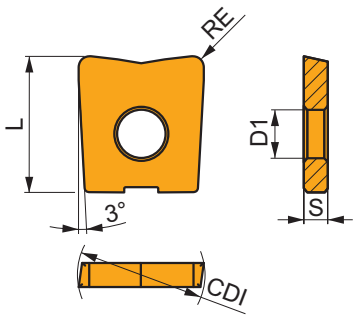
F 型锋利，适用于精加工。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RC 10-F:M4310		–	250	0.36	0.5	125	0.32	0.5	235	0.36	0.5	–	–	–	–	–	–	50	0.18	1.0
RC 12-F:M4310		–	245	0.36	0.6	120	0.32	0.6	230	0.36	0.6	–	–	–	–	–	–	45	0.18	1.2
RC 16-F:M4310		–	235	0.36	0.8	115	0.32	0.8	220	0.36	0.8	–	–	–	–	–	–	45	0.18	1.1
RC 16-F:M8330		–	255	0.36	0.8	150	0.32	0.8	240	0.36	0.8	–	–	–	–	–	–	50	0.18	1.1

LC

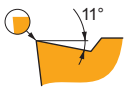
PRAMET

	CDI (mm)	D1 (mm)	L (mm)	S (mm)
08	8.0	3.00	9.50	2.00
10	10.0	4.00	11.50	2.50



KP 型，具有平板设计适用于轻载到中等加工。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
LC 0806-KP:M4310		0.6	280	0.16	0.3	–	–	–	265	0.16	0.3	–	–	–	–	–	–	55	0.11	0.6
LC 0806-KP:M8310		0.6	325	0.16	0.3	–	–	–	305	0.16	0.3	–	–	–	–	–	–	65	0.11	0.6
LC 0810-KP:M4310		1.0	280	0.16	0.5	–	–	–	265	0.16	0.5	–	–	–	–	–	–	55	0.11	1.0
LC 1008-KP:M4310		0.8	270	0.16	0.4	–	–	–	255	0.16	0.4	–	–	–	–	–	–	50	0.08	0.8
LC 1008-KP:M8310		0.8	315	0.16	0.4	–	–	–	295	0.16	0.4	–	–	–	–	–	–	60	0.08	0.8
LC 1010-KP:M4310		1.0	280	0.16	0.5	–	–	–	265	0.16	0.5	–	–	–	–	–	–	55	0.08	1.0
LC 1010-KP:M8310		1.0	325	0.16	0.5	–	–	–	305	0.16	0.5	–	–	–	–	–	–	65	0.08	1.0



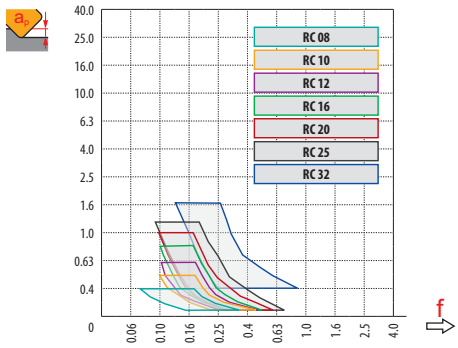
KPF 型，具有前角设计，适用于轻载到中等加工。

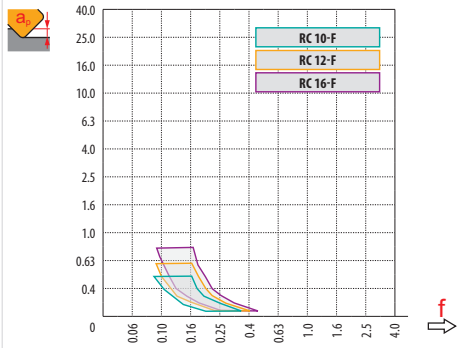
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
LC 0806-KPF:M4310		0.6	280	0.16	0.3	140	0.14	0.3	265	0.16	0.3	–	–	–	–	–	–	55	0.08	0.6
LC 1008-KPF:M4310		0.8	270	0.16	0.4	135	0.14	0.4	255	0.16	0.4	–	–	–	–	–	–	50	0.08	0.8

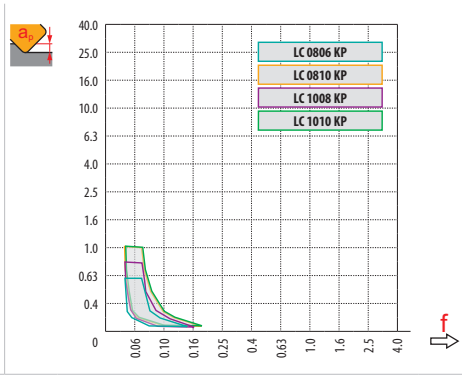
	RC 08	RC 10	RC 12	RC 16	RC 20	RC 25	RC 32
RE	4.0	5.0	6.0	8.0	10.0	12.5	16.0
BS	–	–	–	–	–	–	–

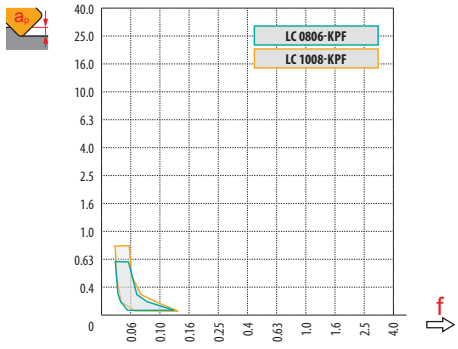
	RC 10-F	RC 12-F	RC 16-F
RE	5.0	6.0	8.0
BS	–	–	–

	LC 08-KP	LC 08-KP	LC 10-KP	LC 10-KP	LC 08-KPF	LC 10-KPF
RE	0.6	1.0	0.8	1.0	0.6	0.8
BS	–	–	–	–	–	–





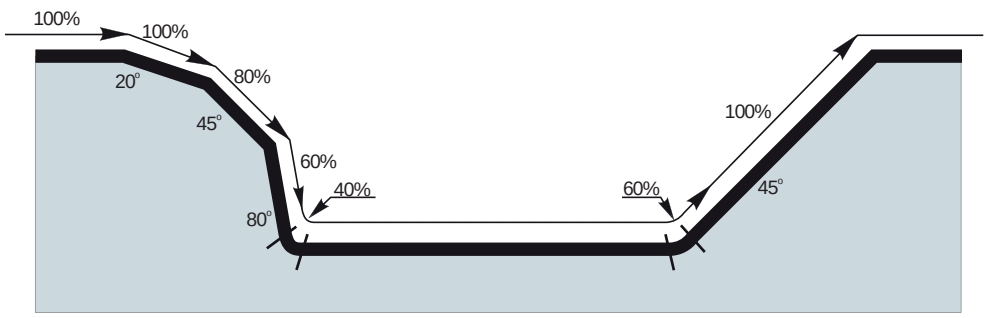




	DCX	a_p 0.3	0.4	0.5	0.7	1.0	1.25	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0	16.0
RC 08	8	3.0	3.5	3.9	4.5	5.3	5.8	6.2	6.9	7.4	7.7	8.0	–	–	–	–	–	–	–
RC 10 / RC 10-F	10	3.4	3.9	4.4	5.1	6.0	6.6	7.1	8.0	8.7	9.2	9.8	10.0	–	–	–	–	–	–
RC 12 / RC 12-F	12	3.7	4.3	4.8	5.6	6.6	7.3	7.9	8.9	9.7	10.4	11.3	11.8	12.0	–	–	–	–	–
RC 16 / RC 16-F	16	4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	–	–	–	–
RC 20	20	4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	–	–	–
RC 25	25	5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	–	–
RC 32	32	6.17	7.11	7.94	9.36	11.14	12.40	13.53	15.49	17.18	18.65	21.17	23.24	24.98	27.71	29.66	30.98	31.94	32.00

	DCX	µm 3	5	10	15	20	30	40	50	60	80	100
RC 08	8	0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
RC 10 / RC 10-F	10	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
RC 12 / RC 12-F	12	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
RC 16 / RC 16-F	16	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
RC 20	20	0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
RC 25	25	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
RC 32	32	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578

DEF	a_e	1.0 %	2.5 %	5.0 %	7.5 %	10 %	15 %	20 %	25 %	30 %	35 %	40 %	45 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	a_p										⇨ x.f									
19.9%	1.0%	2.86	1.84	1.33	1.12	1.00	0.89	–	–	–	–	–	–	–	–	–	–	–	–	–
31.2%	2.5%	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	–	–	–	–	–	–	–	–	–	–
43.6%	5.0%	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	–	–	–	–	–	–	–	–
52.7%	7.5%	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	–	–	–	–	–	–
60.0%	10.0%	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	–	–	–	–	–
71.4%	15.0%	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	–	–	–	–
80.0%	20.0%	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	–	–
86.6%	25.0%	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	–	–
91.7%	30.0%	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	–
95.4%	35.0%	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	–
98.0%	40.0%	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	–
99.5%	45.0%	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	–
100.0%	50.0%	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00



	DCX	RE	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.25	1.50	2.00	2.50	3.00	4.00
LC 0806-KP	8	0.6	6.8	7.8	7.9	8.0	8.0	–	–	–	–	–	–	–	–	–	–
LC 0806-KPF		0.6	6.8	7.8	7.9	8.0	8.0	–	–	–	–	–	–	–	–	–	–
LC 0810-KP		1.0	6.0	7.4	7.6	7.7	7.8	7.9	8.0	8.0	8.0	–	–	–	–	–	–
LC 1008-KP	10	0.8	8.4	9.6	9.8	9.9	9.9	10.0	10.0	–	–	–	–	–	–	–	–
LC 1008-KPF		0.8	8.4	9.6	9.8	9.9	9.9	10.0	10.0	–	–	–	–	–	–	–	–
LC 1010-KP		1.0	8.0	9.4	9.6	9.7	9.8	9.9	10.0	10.0	10.0	–	–	–	–	–	–

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
8	FE	0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
RE	µm	3	5	10	15	20	30	40	50	60	80	100
0.6	FE	0.120	0.155	0.219	0.268	0.310	0.379	0.438	0.490	0.537	0.620	0.693
0.8		0.139	0.179	0.253	0.310	0.358	0.438	0.506	0.566	0.620	0.716	0.800
1.0		0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.89

	DCX	RE	max
LC 0806-KP	8	0.6	3.0
LC 0806-KPF		0.6	2.8
LC 0810-KP		1.0	3.0
LC 1008-KP	10	0.8	3.8
LC 1008-KPF		0.8	3.6
LC 1010-KP		1.0	3.8

	DCX	RE	RPMX	APMX/l
LC 0806-KP	8	0.6	2.5	1.5/35
LC 0806-KPF		0.6	2.2	1.5/39
LC 0810-KP		1.0	2.4	1.5/36
LC 1008-KP	10	0.8	2.6	1.5/33
LC 1008-KPF		0.8	2.3	1.5/38
LC 1010-KP		1.0	2.6	1.5/33

	DCX	RE	DMIN	DMAX	SMAX DMIN	SMAX DMAX
LC 0806-KP	8	0.6	9.8	15.9	0.8	1.0
LC 0806-KPF		0.6	10.2	15.9	0.1	0.1
LC 0810-KP		1.0	9.9	15.9	0.1	0.1
LC 1008-KP	10	0.8	12.2	19.9	0.9	1.1
LC 1008-KPF		0.8	12.6	19.9	0.2	0.2
LC 1010-KP		1.0	12.2	19.9	0.2	0.2

	DCX	RE	a_p
LC 0806-KP	8	0.6	0.15
LC 0806-KPF		0.6	0.13
LC 0810-KP		1.0	0.13
LC 1008-KP	10	0.8	0.2
LC 1008-KPF		0.8	0.18
LC 1010-KP		1.0	0.19

悬伸(长径比)	< 3.0	3.0 – 3.5	3.6 – 4.0	4.1 – 4.5	> 4.6
速度校正因子	1.0	0.9	0.8	0.7	0.5

K2-SLC

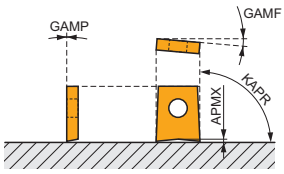
PRAMET

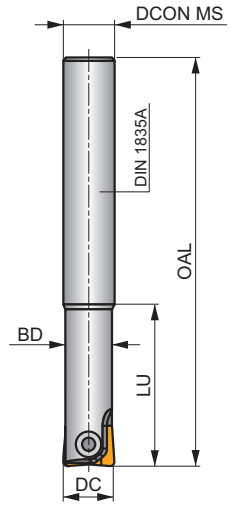
S

仿形和轮廓立铣刀适用于精加工

方肩铣刀可利用LC刀片在各种应用中进行精加工。高精度磨削刀片可提供出色的精度。用于轮廓加工，倒角加工，螺旋铣削，渐进式插铣和坡走铣。只提供圆柱柄类型。主体经过处理，使用寿命更长。

APMX	1.0 - 3.0 mm





h_m 0.03 - 0.10

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	BD (mm)			max.		kg		
DIN 1835A	12K2R030A12-SLC12-A	12	130	12	30	10.5	2	–	35000	–	0.11	GI037	CO532
	16K2R035A16-SLC16-A	16	140	16	35	14	2	–	22000	–	0.20	GI038	CO533
	20K2R045A20-SLC20-A	20	160	20	45	18	2	–	16000	–	0.38	GI039	CO534

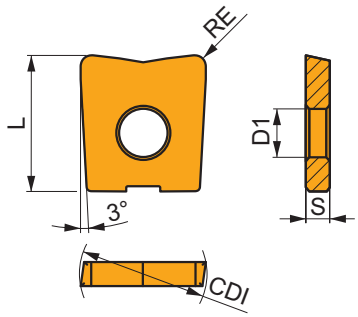
GI037	LC 12-KP	LC 12-KPF
GI038	LC 16-KP	–
GI039	LC 20-KP	–

		Nm			
CO532	CS 5009-T20P	5.0	M 5	9	SDR T20P
CO533	CS 5013-T20P	5.0	M 5	13	SDR T20P
CO534	CS 5015-T20P	5.0	M 5	15	SDR T20P

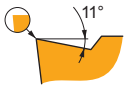
LC

PRAMET

	CDI (mm)	D1 (mm)	L (mm)	S (mm)
12	12.0	5.00	14.00	2.50
16	16.0	5.00	16.00	3.00
20	20.0	5.00	18.00	3.00

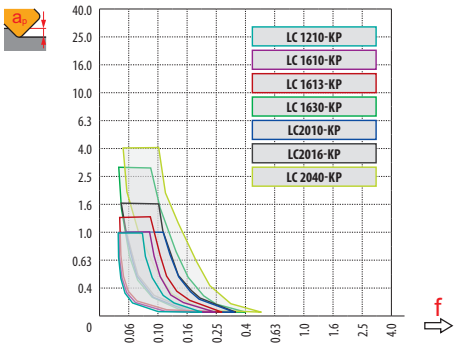


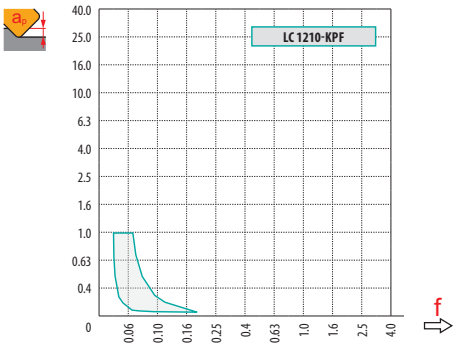
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			U E																	
KP 型，具有平板设计适用于轻载到中等加工。																				
LC 1210-KP:M4310		1.0	◪ 280	0.16	0.5	–	–	–	■ 265	0.16	0.5	–	–	–	–	–	–	■ 55	0.08	1.0
LC 1210-KP:M8310		1.0	■ 325	0.16	0.5	–	–	–	■ 305	0.16	0.5	–	–	–	–	–	–	■ 65	0.08	1.0
LC 1210-KP:M8330		1.0	■ 295	0.16	0.5	–	–	–	■ 280	0.16	0.5	–	–	–	–	–	–	◪ 55	0.08	1.0
LC 1610-KP:M4310		1.0	◪ 280	0.16	0.5	–	–	–	■ 265	0.16	0.5	–	–	–	–	–	–	■ 55	0.08	1.0
LC 1610-KP:M8310		1.0	■ 325	0.16	0.5	–	–	–	■ 305	0.16	0.5	–	–	–	–	–	–	■ 65	0.08	1.0
LC 1610-KP:M8330		1.0	■ 295	0.16	0.5	–	–	–	■ 280	0.16	0.5	–	–	–	–	–	–	◪ 55	0.08	1.0
LC 1613-KP:M4310		1.3	◪ 270	0.16	0.7	–	–	–	■ 255	0.16	0.7	–	–	–	–	–	–	■ 50	0.08	1.3
LC 1613-KP:M8310		1.3	■ 315	0.16	0.7	–	–	–	■ 295	0.16	0.7	–	–	–	–	–	–	■ 60	0.08	1.3
LC 2010-KP:M4310		1.0	◪ 280	0.16	0.5	–	–	–	■ 265	0.16	0.5	–	–	–	–	–	–	■ 55	0.08	1.0
LC 2010-KP:M8310		1.0	■ 325	0.16	0.5	–	–	–	■ 305	0.16	0.5	–	–	–	–	–	–	■ 65	0.08	1.0
LC 2016-KP:M4310		1.6	◪ 280	0.16	0.8	–	–	–	■ 265	0.16	0.8	–	–	–	–	–	–	■ 55	0.08	1.1
LC 2016-KP:M8310		1.6	■ 325	0.16	0.8	–	–	–	■ 305	0.16	0.8	–	–	–	–	–	–	■ 65	0.08	1.1
LC 2040-KP:M8330		4.0	■ 285	0.16	2.0	–	–	–	■ 270	0.16	2.0	–	–	–	–	–	–	◪ 55	0.08	2.7
			F																	
KPF 型，具有前角设计，适用于轻载到中等加工。																				
LC 1210-KPF:M4310		1.0	◪ 280	0.16	0.5	◪ 140	0.14	0.5	■ 265	0.16	0.5	–	–	–	–	–	–	■ 55	0.08	1.0
LC 1210-KPF:M8330		1.0	■ 295	0.16	0.5	◪ 175	0.14	0.5	■ 280	0.16	0.5	–	–	–	–	–	–	◪ 55	0.08	1.0

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	LC 1210-KP	LC 1610-KP	LC 1613-KP	LC 2010-KP	LC 2016-KP	LC 2040-KP	LC 1210-KPF
RE	1.0	1.3	3.0	1.0	1.6	4.0	1.0
BS	–	–	–	–	–	–	–





	DC	RE	a_p 0.0	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.25	1.5	2.0	2.5	3.0	4.0
LC 1210-KP	12	1.0	10.0	11.4	11.6	11.7	11.8	11.9	12.0	12.0	12.0	–	–	–	–	–	–
LC 1210-KPF		1.0	10.0	11.4	11.6	11.7	11.8	11.9	12.0	12.0	12.0	–	–	–	–	–	–
LC 1610-KP	16	1.0	14.0	15.4	15.6	15.7	15.8	15.9	16.0	16.0	16.0	–	–	–	–	–	–
LC 1613-KP		1.3	13.4	15.1	15.3	15.4	15.6	15.7	15.8	15.9	15.9	16.0	–	–	–	–	–
LC 2010-KP	20	1.0	18.0	19.4	19.6	19.7	19.8	19.9	20.0	20.0	20.0	–	–	–	–	–	–
LC 2016-KP		1.6	16.8	18.7	18.9	19.1	19.3	19.4	19.6	19.7	19.8	19.9	20.0	–	–	–	–
LC 2040-KP		4.0	12.0	15.0	15.5	15.9	16.2	16.5	16.8	17.1	17.3	17.8	18.2	18.9	19.4	–	–

DC	µm	3	5	10	15	20	30	40	50	60	80	100
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
RE	µm	3	5	10	15	20	30	40	50	60	80	100
1.3		0.177	0.228	0.322	0.395	0.456	0.559	0.645	0.721	0.790	0.912	1.020
1.6	FE	0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
4.0		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789

	DC	RE	max.
LC 1210-KP	12	1.0	4.8
LC 1210-KPF		1.0	4.4
LC 1610-KP	16	1.0	6.6
LC 1613-KP		1.3	6.6
LC 2010-KP	20	1.0	8.5
LC 2016-KP		1.6	8.5
LC 2040-KP		4.0	8.5

	DC	RE	RPMX	APMX/l
LC 1210-KP	12	1.0	4.7	1.5/19
LC 1210-KPF		1.0	3.8	1.5/23
LC 1610-KP	16	1.0	4.8	1.5/18
LC 1613-KP		1.3	4.8	1.5/18
LC 2010-KP	20	1.0	5.0	1.5/18
LC 2016-KP		1.6	4.9	1.6/19
LC 2040-KP		4.0	4.5	4.0/51

	DC	RE	DMIN	DMAX	SMAX DMIN	SMAX DMAX
LC 1210-KP	12	1.0	14.1	23.9	1.0	1.2
LC 1210-KPF		1.0	15.0	23.9	0.4	0.4
LC 1610-KP	16	1.0	18.6	31.9	1.1	1.4
LC 1613-KP		1.3	18.6	31.9	0.6	0.6
LC 2010-KP	20	1.0	22.8	39.9	1.3	1.5
LC 2016-KP		1.6	22.8	39.9	0.8	0.8
LC 2040-KP		4.0	22.8	39.9	0.5	0.5

	DC	RE	a_p
LC 1210-KP	12	1.0	0.44
LC 1210-KPF		1.0	0.9
LC 1610-KP	16	1.0	0.65
LC 1613-KP		1.3	0.62
LC 2010-KP	20	1.0	0.85
LC 2016-KP		1.6	0.79
LC 2040-KP		4.0	0.54

悬伸(长径比)	< 3.0	3 – 3.5	3.6 – 4.0	4.1 – 4.5	> 4.6
速度校正因子	1.0	0.9	0.8	0.7	0.5

K2-PPH

P M K S H

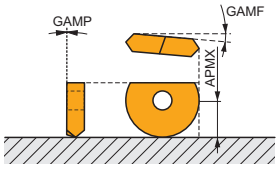
PRAMET

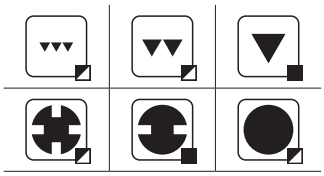
S

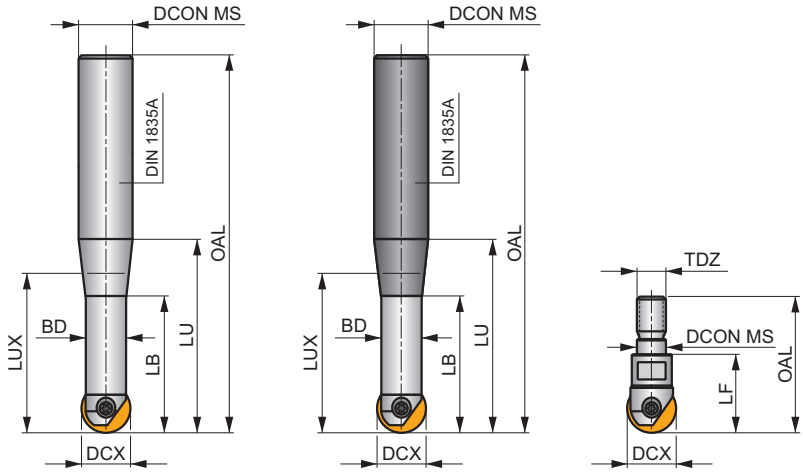
仿形和轮廓立铣刀

灵活的立铣刀适用于各种模具。一种刀具可提供球形、环形和快进给刀片的解决方案。提供圆柱直柄和模块夹紧系统类型。刀体经过处理，使用寿命更长。

APMX	0.3 - 4.0 mm







h_m 0.07 - 0.14

	产品	DCX (mm)	OAL (mm)	DCON MS (mm)	BD (mm)	LB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	Carbide	max.		kg		
	PPH-08/02-QC12-092	8	92	12	6.5	19	35	23.1	–	–	–	40000	–	0.14	GI284	C0540
	PPH-08/02-QC12-110	8	110	12	6.5	33.5	53	41.5	–	–	–	33600	–	0.14	GI284	C0540
	PPH-08/02-QC12-132	8	132	12	6.5	19	75	41.8	–	–	–	16800	–	0.15	GI284	C0540
	PPH-10/02-QC12-092	10	92	12	8	22.4	38	30	–	–	–	40000	–	0.12	GI285	C0541
	PPH-10/02-QC12-110	10	110	12	8	38.7	53	51.9	–	–	–	40000	–	0.15	GI285	C0541
	PPH-10/02-QC12-132	10	132	12	8	21.8	75	73.6	–	–	–	20300	–	0.16	GI285	C0541
	PPH-12/02-QC16-145	12	145	16	10	22.5	85	63.3	–	–	–	19800	–	0.23	GI286	C0542
	PPH-16/02-QC20-166	16	166	20	14	29.5	100	75.5	–	–	–	20000	–	0.37	GI287	C0543
	PPH-20/02-QC25-191	20	191	25	17	35	115	82.2	–	–	–	18400	–	0.64	GI288	C0544
	PPH-25/02-QC32-215	25	215	32	21	42.5	135	97	–	–	–	16500	–	1.07	GI289	C0545
	PPH-12/02-QC12-083	12	83	12	10	–	26	–	–	–	–	40000	–	0.15	GI286	C0542
	PPH-12/02-QC12-110	12	110	12	10	–	53	–	–	–	–	40000	–	0.15	GI286	C0542
	PPH-16/02-QC16-092	16	92	16	14	–	92	–	–	–	–	36000	–	0.20	GI287	C0543
DIN 1835A	PPH-16/02-QC16-123	16	123	16	14	–	63	–	–	–	–	36000	–	0.24	GI287	C0543
	PPH-20/02-QC20-104	20	104	20	17	–	38	–	–	–	–	40000	–	0.34	GI288	C0544
	PPH-20/02-QC20-141	20	141	20	17	–	75	–	–	–	–	40000	–	0.41	GI288	C0544
	PPH-25/02-QC25-121	25	121	25	21	–	45	–	–	–	–	40000	–	0.53	GI289	C0545
	PPH-25/02-QC25-166	25	166	25	21	–	90	–	–	–	–	37100	–	0.57	GI289	C0545
	PPH-32/02-QC32-186	32	186	32	26	–	107	–	–	–	–	32500	–	1.09	GI290	C0546
	PPH-32/02-QC32-240	32	240	32	26	–	160	–	–	–	–	14500	–	1.37	GI290	C0546
	PPH-08/02-QC12-110HSCW	8	110	12	6.5	19	53	30.1	–	–	✓	40000	–	0.21	GI284	C0540
	PPH-08/02-QC12-132HSCW	8	132	12	6.5	19	75	37.1	–	–	✓	23400	–	0.22	GI284	C0540
	PPH-10/02-QC12-092HSCW	10	92	12	8	21.9	38.1	90.9	–	–	✓	40000	–	0.20	GI285	C0541
	PPH-10/02-QC12-132HSCW	10	132	12	8	21.8	75.1	51.1	–	–	✓	23400	–	0.24	GI285	C0541
	PPH-12/02-QC16-145HSCW	12	145	16	10	21.5	85	65.6	–	–	✓	21000	–	0.28	GI286	C0542
	PPH-16/02-QC20-166HSCW	16	166	20	14	28.5	100	87.2	–	–	✓	25500	–	0.66	GI287	C0543
	PPH-20/02-QC25-191HSCW	20	191	25	17	35	115	75.6	–	–	✓	18500	–	1.07	GI288	C0544
	PPH-08/02-QC08-130HSCW	8	130	8	6.5	–	20	–	–	–	✓	40000	–	0.17	GI284	C0540

	产品	DCX (mm)	OAL (mm)	DCON MS (mm)	BD (mm)	LB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	Carbide	max.		kg		
DIN 1835A	**PPH-10/02-QC10-140HSCW**	10	140	10	8	–	25	–	–	–	✓	40000	–	0.22	GI285	C0541
	PPH-12/02-QC12-083HSCW	12	83	12	10	–	26	–	–	–	✓	40000	–	0.19	GI286	C0542
	PPH-12/02-QC12-110HSCW	12	110	12	10	–	53	–	–	–	✓	40000	–	0.22	GI286	C0542
	PPH-16/02-QC16-092HSCW	16	92	16	14	–	32	–	–	–	✓	43000	–	0.29	GI287	C0543
	PPH-16/02-QC16-123HSCW	16	123	16	14	–	63	–	–	–	✓	43000	–	0.36	GI287	C0543
	PPH-20/02-QC20-104HSCW	20	104	20	17	–	38	–	–	–	✓	40000	–	0.50	GI288	C0544
	PPH-20/02-QC20-141HSCW	20	141	20	17	–	75	–	–	–	✓	40000	–	0.62	GI288	C0544
MODULAR	**PPH-16/02-025-P08**	16	–	8.5	–	–	–	–	25	M8	–	–	–	0.10	GI287	C0543
	PPH-20/02-030-P10	20	–	10.5	–	–	–	–	30	M10	–	–	–	0.16	GI288	C0544

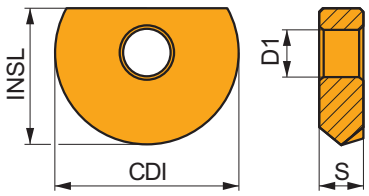
GI284	PPH 08..	–	PPHT 08..	PPHF 08..
GI285	PPH 10..	PPHE 10..	PPHT 10..	PPHF 10..
GI286	PPH 12..	PPHE 12..	PPHT 12..	PPHF 12..
GI287	PPH 16..	PPHE 16..	PPHT 16..	PPHF 16..
GI288	PPH 20..	PPHE 20..	PPHT 20..	PPHF 20..
GI289	PPH 25..	–	PPHT 25..	–
GI290	PPH 32..	–	–	–

		Nm						
C0540	CS 42506-T07P	1.0	M 2.5	6	D-T07P/T09P	FG-15	–	–
C0541	CS 43008-T08P	1.2	M 3	8	D-T08P/T15P	FG-15	–	–
C0542	CS 43509-T10P	2.0	M 3.5	9	–	–	SDR T10P	–
C0543	CS 44013-T15P	3.0	M 4	13	D-T08P/T15P	FG-15	–	–
C0544	CS 45016-T20P	5.0	M 5	16	–	–	SDR T20P	–
C0545	CS 46020-T25P	7.5	M 6	20	–	–	–	SDR T25P-T
C0546	CS 48025-T40P	15.0	M 8	25	–	–	–	SDR T40P-T

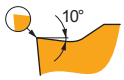
PPH

PRAMET

	CDI (mm)	D1 (mm)	INSL (mm)	S (mm)
0800	8.0	2.50	7.0	2.40
1000	10.0	3.00	8.5	2.60
1200	12.0	3.50	10.0	3.00
1600	16.0	4.00	12.0	4.00
2000	20.0	5.00	15.0	5.00
2500	25.0	6.00	18.5	6.00
3000	30.0	8.00	22.5	7.00
3200	32.0	8.00	23.5	7.00



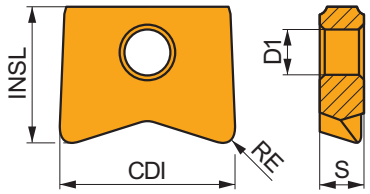
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
CL1 型，具有锋利的设计。																				
PPH 0800-CL1:2003		–	◪ 285	0.36	0.4	◪ 145	0.32	0.4	■ 270	0.36	0.4	–	–	–	–	–	–	◪ 55	0.18	0.8
PPH 1000-CL1:2003		–	◪ 280	0.36	0.5	◪ 140	0.32	0.5	■ 265	0.36	0.5	–	–	–	–	–	–	◪ 55	0.18	1.0
PPH 1200-CL1:2003		–	◪ 275	0.36	0.6	◪ 140	0.32	0.6	■ 260	0.36	0.6	–	–	–	–	–	–	◪ 55	0.18	1.2
PPH 1600-CL1:2003		–	◪ 265	0.36	0.8	◪ 135	0.32	0.8	■ 250	0.36	0.8	–	–	–	–	–	–	◪ 50	0.18	1.1
PPH 2000-CL1:2003		–	◪ 260	0.36	1.0	◪ 130	0.32	1.0	■ 245	0.36	1.0	–	–	–	–	–	–	◪ 50	0.18	1.3
PPH 2500-CL1:2003		–	◪ 250	0.36	1.3	◪ 125	0.32	1.3	■ 235	0.36	1.3	–	–	–	–	–	–	◪ 50	0.18	1.7
PPH 3000-CL1:2003		–	◪ 245	0.36	1.5	◪ 120	0.32	1.5	■ 230	0.36	1.5	–	–	–	–	–	–	◪ 45	0.18	2.0
PPH 3200-CL1:2003		–	◪ 245	0.36	1.6	◪ 120	0.32	1.6	■ 230	0.36	1.6	–	–	–	–	–	–	◪ 45	0.18	2.1
CL4 型，具有锋利的设计，适用于断续切削。																				
PPH 0800-CL4:8215		–	■ 270	0.36	0.4	–	–	–	■ 255	0.36	0.4	–	–	–	–	–	–	■ 50	0.18	0.8
PPH 1000-CL4:8215		–	■ 265	0.36	0.5	–	–	–	■ 250	0.36	0.5	–	–	–	–	–	–	■ 50	0.18	1.0
PPH 1200-CL4:8215		–	■ 255	0.36	0.6	–	–	–	■ 240	0.36	0.6	–	–	–	–	–	–	■ 50	0.18	1.2
PPH 1600-CL4:8215		–	■ 250	0.36	0.8	–	–	–	■ 235	0.36	0.8	–	–	–	–	–	–	■ 50	0.18	1.1
PPH 2000-CL4:8215		–	■ 245	0.36	1.0	–	–	–	■ 230	0.36	1.0	–	–	–	–	–	–	■ 45	0.18	1.3
																				
SM1 型，具有锋利的设计。																				
PPHE 1000-SM1:8215		–	■ 275	0.31	0.5	◪ 165	0.28	0.5	■ 260	0.31	0.5	–	–	–	–	–	–	■ 55	0.16	1.0
PPHE 1200-SM1:8215		–	■ 255	0.36	0.6	◪ 150	0.32	0.6	■ 240	0.36	0.6	–	–	–	–	–	–	■ 50	0.18	1.2
PPHE 1600-SM1:8215		–	■ 260	0.31	0.8	◪ 155	0.28	0.8	■ 245	0.31	0.8	–	–	–	–	–	–	■ 50	0.16	1.1
PPHE 2000-SM1:8215		–	■ 250	0.31	1.0	◪ 150	0.28	1.0	■ 235	0.31	1.0	–	–	–	–	–	–	■ 50	0.16	1.3

PPHT

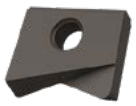
PRAMET

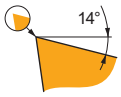
	CDI (mm)	D1 (mm)	INSL (mm)	S (mm)
0800	8.0	2.50	7.0	2.40
1000	10.0	3.00	8.5	2.60
1200	12.0	3.50	10.0	3.00
1600	16.0	4.00	12.0	4.00
2000	20.0	5.00	15.0	5.00
2500	25.0	6.00	18.5	6.00



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
PPHT 080003-A2:2003	●	0.3	275	0.10	0.3	140	0.09	0.3	260	0.10	0.3	–	–	–	–	–	–	55	0.07	0.3
PPHT 080005-A2:2003	●	0.5	270	0.13	0.3	135	0.12	0.3	255	0.13	0.3	–	–	–	–	–	–	50	0.09	0.5
PPHT 080010-A2:2003	⬌	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	–	–	–	–	–	–	60	0.10	1.0
PPHT 100005-A2:2003	●	0.5	270	0.13	0.3	135	0.12	0.3	255	0.13	0.3	–	–	–	–	–	–	50	0.09	0.5
PPHT 100008-A2:2003	⬌	0.8	305	0.14	0.4	155	0.13	0.4	285	0.14	0.4	–	–	–	–	–	–	60	0.10	0.8
PPHT 100010-A2:2003	⬌	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	–	–	–	–	–	–	60	0.10	1.0
PPHT 120005-A2:2003	●	0.5	270	0.13	0.3	135	0.12	0.3	255	0.13	0.3	–	–	–	–	–	–	50	0.09	0.5
PPHT 120010-A2:2003	⬌	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	–	–	–	–	–	–	60	0.10	1.0
PPHT 120020-A2:2003	⬌	2.0	320	0.14	1.0	160	0.13	1.0	300	0.14	1.0	–	–	–	–	–	–	60	0.10	1.3
PPHT 160010-A2:2003	⬌	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	–	–	–	–	–	–	60	0.10	1.0
PPHT 160013-A2:2003	⬌	1.3	300	0.15	0.6	150	0.13	0.6	285	0.15	0.6	–	–	–	–	–	–	60	0.10	1.3
PPHT 160020-A2:2003	⬌	2.0	320	0.14	1.0	160	0.13	1.0	300	0.14	1.0	–	–	–	–	–	–	60	0.10	1.3
PPHT 200010-A2:2003	⬌	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	–	–	–	–	–	–	60	0.10	1.0
PPHT 200016-A2:2003	⬌	1.6	310	0.14	0.8	155	0.13	0.8	290	0.14	0.8	–	–	–	–	–	–	60	0.10	1.1
PPHT 200030-A2:2003	⬌	3.0	305	0.14	1.5	155	0.13	1.5	285	0.14	1.5	–	–	–	–	–	–	60	0.10	2.0
PPHT 200040-A2:2003	⬌	4.0	295	0.14	2.0	150	0.13	2.0	280	0.14	2.0	–	–	–	–	–	–	55	0.10	2.7
PPHT 250020-A2:2003	⬌	2.0	320	0.14	1.0	160	0.13	1.0	300	0.14	1.0	–	–	–	–	–	–	60	0.10	1.3



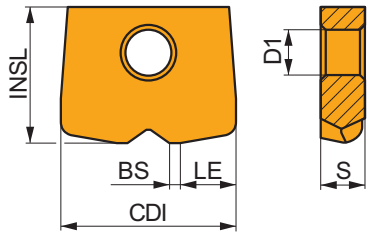


A2 型，具有正前角设计，适用于轻载到中等加工。

PPHF

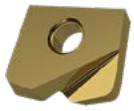
PRAMET

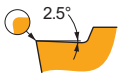
	BS (mm)	LE (mm)	CDI (mm)	D1 (mm)	INSL (mm)	S (mm)
0800	0.40	2.60	8.0	2.50	7.0	2.40
1000	0.50	3.20	10.0	3.00	8.5	2.60
1200	0.60	3.90	12.0	3.50	10.0	3.00
1600	0.80	5.20	16.0	4.00	12.0	4.00
2000	1.00	6.40	20.0	5.00	15.0	5.00



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
PPHF 080004-CE1:M8330	●	–	200	0.30	0.3	120	0.27	0.3	190	0.30	0.3	–	–	–	50	0.27	0.2	40	0.21	0.2
PPHF 100005-CE1:M8330	⬌	–	190	0.35	0.3	110	0.32	0.3	180	0.35	0.3	–	–	–	45	0.32	0.2	35	0.25	0.2
PPHF 120006-CE1:M8330	⬌	–	205	0.45	0.4	120	0.41	0.4	190	0.45	0.4	–	–	–	50	0.41	0.3	40	0.32	0.3
PPHF 160008-CE1:M8330	⬌	–	190	0.60	0.5	110	0.54	0.5	180	0.60	0.5	–	–	–	45	0.54	0.4	35	0.42	0.4
PPHF 200010-CE1:M8330	⬌	–	185	0.75	0.6	110	0.68	0.6	175	0.75	0.6	–	–	–	45	0.68	0.5	35	0.53	0.4





HFC E

CE1 型，具有强壮的设计，适用于快进给。

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	PPH 08-CL1	PPH 10-CL1	PPH 12-CL1	PPH 16-CL1	PPH 20-CL1	PPH 25-CL1	PPH 30-CL1	PPH 32-CL1
RE	4.0	5.0	6.0	8.0	10.0	12.5	15.0	16.0
BS	–	–	–	–	–	–	–	–

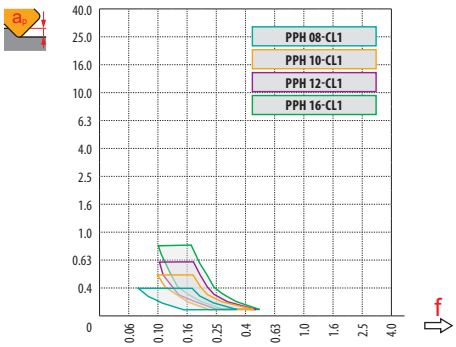
	PPH 08-CL4	PPH 10-CL4	PPH 12-CL4	PPH 16-CL4	PPH 20-CL4
RE	4.0	5.0	6.0	8.0	10.0
BS	–	–	–	–	–

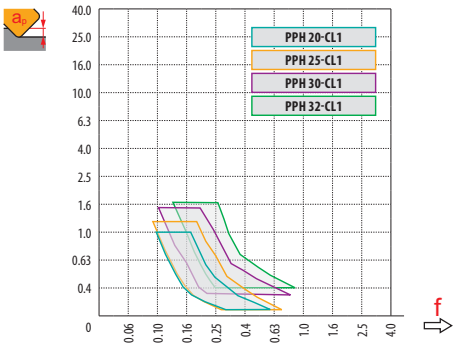
	PPHE 10-SM1	PPHE 12-SM1	PPHE 16-SM1	PPHE 20-SM1
RE	5.0	6.0	8.0	10.0
BS	–	–	–	–

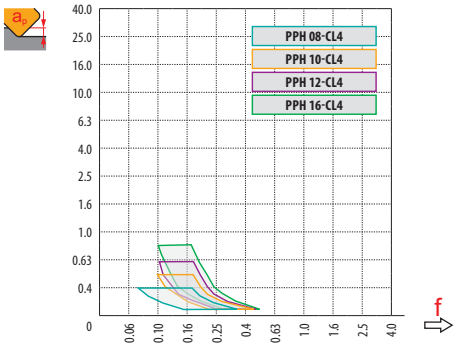
	PPHF 08-CE1	PPHF 10-CE1	PPHF 12-CE1	PPHF 16-CE1	PPHF 20-CE1
RE	0.6	0.8	1.0	1.3	1.6
BS	0.40	0.50	0.60	0.80	1.00

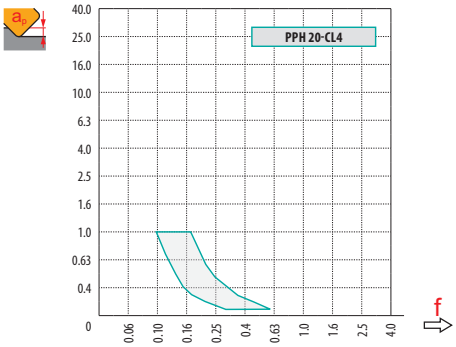
	PPHT 08-A2	PPHT 08-A2	PPHT 08-A2	PPHT 10-A2	PPHT 10-A2	PPHT 10-A2	PPHT 12-A2	PPHT 12-A2	PPHT 12-A2
RE	0.3	0.5	1.0	0.5	0.8	1.0	0.5	1.0	2.0
BS	–	–	–	–	–	–	–	–	–

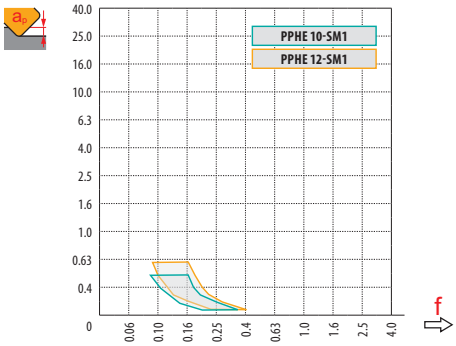
	PPHT 16-A2	PPHT 16-A2	PPHT 16-A2	PPHT 20-A2	PPHT 20-A2	PPHT 20-A2	PPHT 20-A2	PPHT 25-A2
RE	1.0	1.3	2.0	1.0	1.6	3.0	4.0	2.0
BS	–	–	–	–	–	–	–	–

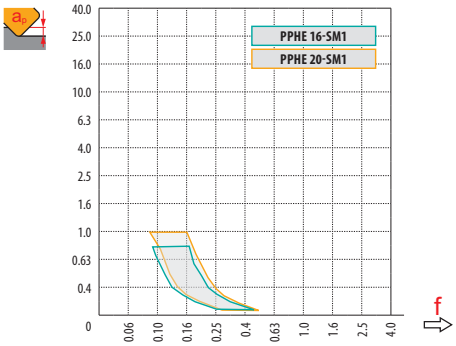

PPH 08-CL1
PPH 10-CL1
PPH 12-CL1
PPH 16-CL1

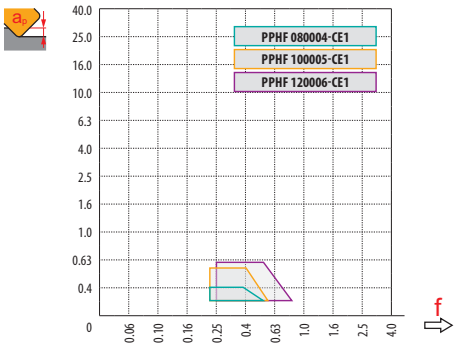

PPH 20-CL1
PPH 25-CL1
PPH 30-CL1
PPH 32-CL1


PPH 08-CL4
PPH 10-CL4
PPH 12-CL4
PPH 16-CL4


PPH 20-CL4


PPHE 10-SM1
PPHE 12-SM1


PPHE 16-SM1
PPHE 20-SM1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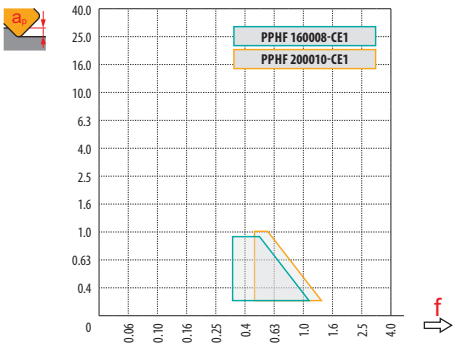
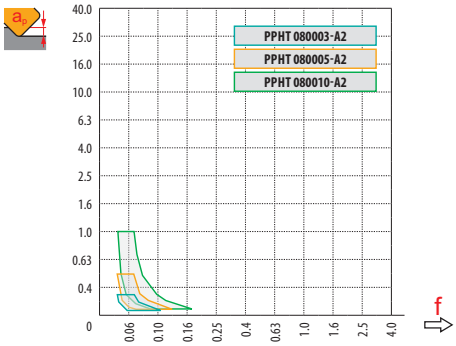
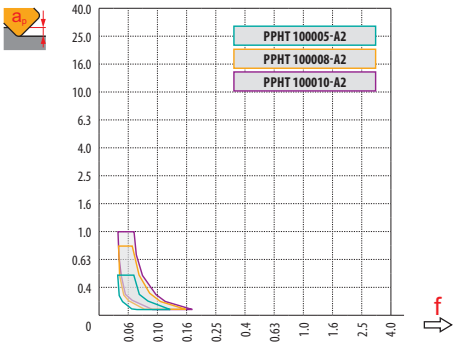
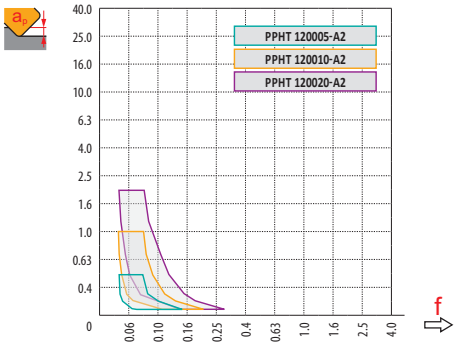
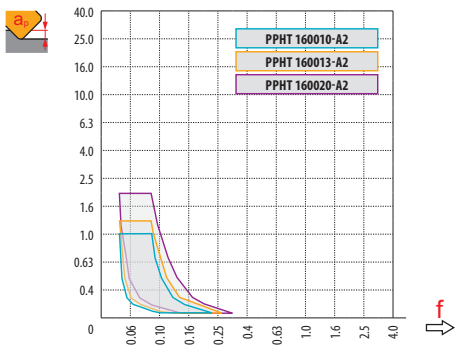
PPHF 100005-CE1
PPHF 120006-CE1

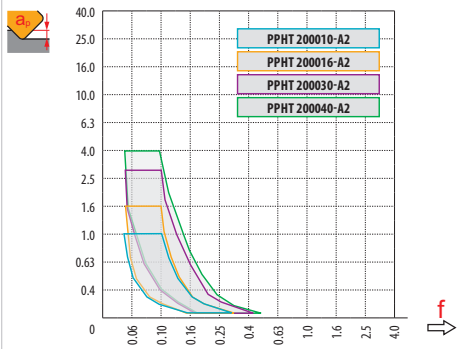

PPHF 160008-CE1
PPHF 200010-CE1

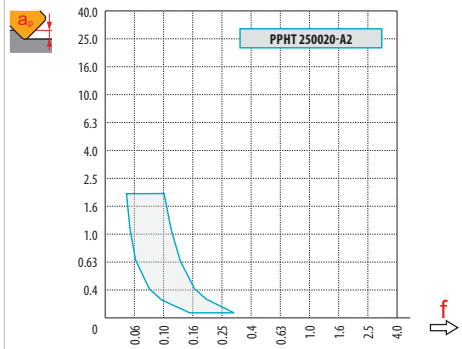

PPHT 080003-A2
PPHT 080005-A2
PPHT 080010-A2


PPHT 100005-A2
PPHT 100008-A2
PPHT 100010-A2


PPHT 120005-A2
PPHT 120010-A2
PPHT 120020-A2







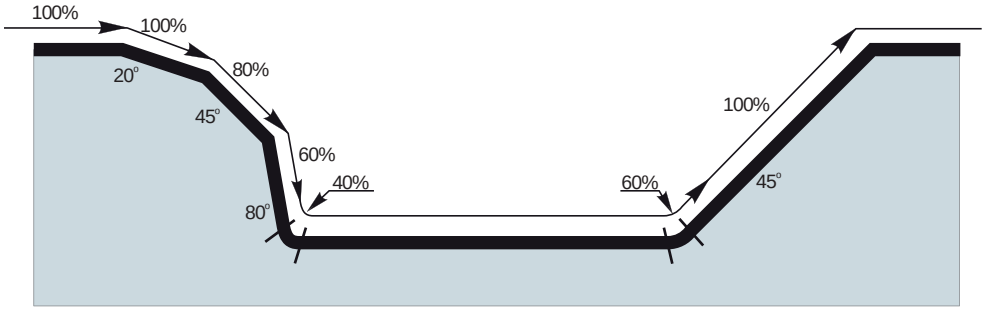
	DCX	a_p	0.3	0.4	0.5	0.7	1.0	1.25	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0	16.0
PPH 08	**8**	DEF	3.0	3.5	3.9	4.5	5.3	5.8	6.2	6.9	7.4	7.7	8.0	–	–	–	–	–	–	–
PPH 10	**10**		3.4	3.9	4.4	5.1	6.0	6.6	7.1	8.0	8.7	9.2	9.8	10.0	–	–	–	–	–	–
PPH 12	**12**		3.7	4.3	4.8	5.6	6.6	7.3	7.9	8.9	9.7	10.4	11.3	11.8	12.0	–	–	–	–	–
PPH 16	**16**		4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	–	–	–	–
PPH 20	**20**		4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	–	–	–
PPH 25	**25**		5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	–	–
PPH 32	**32**		6.17	7.11	7.94	9.36	11.14	12.40	13.53	15.49	17.18	18.65	21.17	23.24	24.98	27.71	29.66	30.98	31.94	32.00

	DCX	µm	3	5	10	15	20	30	40	50	60	80	100
PPH 08	**8**		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
PPH 10	**10**	FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
PPH 12	**12**		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
PPH 16	**16**	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
PPH 20	**20**		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
PPH 25	**25**		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
PPH 32	**32**		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578

DEF	a_e	1 %	2.5 %	5 %	7.5 %	10 %	15 %	20 %	25 %	30 %	35 %	40 %	45 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	a_p										⇨ x.f									
19.9 %	1.0 %	2.86	1.84	1.33	1.12	1.00	0.89	–	–	–	–	–	–	–	–	–	–	–	–	–
31.2 %	2.5 %	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	–	–	–	–	–	–	–	–	–	–
43.6 %	5.0 %	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	–	–	–	–	–	–	–	–
52.7 %	7.5 %	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	–	–	–	–	–	–
60.0 %	10.0 %	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	–	–	–	–	–
71.4 %	15.0 %	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	–	–	–	–
80.0 %	20.0 %	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	–	–
86.6 %	25.0 %	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	–	–
91.7 %	30.0 %	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	–
95.4 %	35.0 %	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	–
98.0 %	40.0 %	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	–
99.5 %	45.0 %	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	–
100.0 %	50.0 %	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00

	DCX										a_p							
		RE	0.0	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.25	1.5	2.0	2.5	3.0	4.0
PPHT 08-A2	**8**	0.3	7.4	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–
PPHT 08-A2		0.5	7.0	7.9	8.0	8.0	–	–	–	–	–	–	–	–	–	–	–
PPHT 08-A2		0.8	6.4	7.6	7.8	7.9	7.9	8.0	8.0	–	–	–	–	–	–	–	–
PPHT 08-A2		1.0	6.0	7.4	7.6	7.7	7.8	7.9	8.0	8.0	8.0	–	–	–	–	–	–
PPHT 10-A2	**10**	0.5	9.0	9.9	10.0	10.0	–	–	–	–	–	–	–	–	–	–	–
PPHT 10-A2		0.8	8.4	9.6	9.8	9.9	9.9	10.0	10.0	–	–	–	–	–	–	–	–
PPHT 10-A2		1.0	8.0	9.4	9.6	9.7	9.8	9.9	10.0	10.0	10.0	–	–	–	–	–	–
PPHT 12-A2	**12**	0.5	11.0	11.9	12.0	12.0	–	–	–	–	–	–	–	–	–	–	–
PPHT 12-A2		1.0	10.0	11.4	11.6	11.7	11.8	11.9	12.0	12.0	12.0	–	–	–	–	–	–
PPHT 12-A2		2.0	8.0	10.1	10.4	10.6	10.9	11.0	11.2	11.3	11.5	11.7	11.9	12.0	–	–	–
PPHT 16-A2	**16**	1.0	14.0	15.4	15.6	15.7	15.8	15.9	16.0	16.0	16.0	–	–	–	–	–	–
PPHT 16-A2		1.3	13.4	15.1	15.3	15.4	15.6	15.7	15.8	15.9	15.9	16.0	–	–	–	–	–
PPHT 16-A2		2.0	12.0	14.1	14.4	14.6	14.9	15.0	15.2	15.3	15.5	15.7	15.9	16.0	–	–	–
PPHT 16-A2		3.0	10.0	12.6	13.0	13.3	13.6	13.9	14.1	14.3	14.5	14.9	15.2	15.7	15.9	16.0	–
PPHT 20-A2	**20**	1.0	18.0	19.4	19.6	19.7	19.8	19.9	20.0	20.0	20.0	–	–	–	–	–	–
PPHT 20-A2		1.6	16.8	18.7	18.9	19.1	19.3	19.4	19.6	19.7	19.8	19.9	20.0	–	–	–	–
PPHT 20-A2		3.0	14.0	16.6	17.0	17.3	17.6	17.9	18.1	18.3	18.5	18.9	19.2	19.7	19.9	20.0	–
PPHT 20-A2		4.0	12.0	15.0	15.5	15.9	16.2	16.5	16.8	17.1	17.3	17.8	18.2	18.9	19.4	19.7	20.0
PPHT 25-A2	**25**	2.0	21.0	23.1	23.4	23.6	23.9	24.0	24.2	24.3	24.5	24.7	24.9	25.0	–	–	–
PPHF 08-CE1	**8**	0.6	2.8	6.0	7.1	–	–	–	–	–	–	–	–	–	–	–	–
PPHF 10-CE1	**10**	0.8	3.6	6.8	7.9	9.0	–	–	–	–	–	–	–	–	–	–	–
PPHF 12-CE1	**12**	1.0	4.2	7.4	8.5	9.6	10.7	11.8	–	–	–	–	–	–	–	–	–
PPHF 16-CE1	**16**	1.3	5.6	8.8	9.9	11.0	12.1	13.2	14.2	15.3	–	–	–	–	–	–	–
PPHF 20-CE1	**20**	1.6	7.2	10.4	11.5	12.6	13.7	14.8	15.8	16.9	18.0	–	–	–	–	–	–
PPHF 25-CE1	**25**	1.9	9.2	12.4	13.5	14.6	15.7	16.8	17.8	18.9	20.0	22.7	–	–	–	–	–

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
8	FE	0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
RE	µm	3	5	10	15	20	30	40	50	60	80	100
1.3	FE	0.177	0.228	0.322	0.395	0.456	0.559	0.645	0.721	0.790	0.912	1.020
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
1.9		0.214	0.276	0.390	0.477	0.551	0.675	0.780	0.872	0.955	1.103	1.233
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549
4.0		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789



	DCX	RE	max
PPHT 08-A2	8	0.3	2.4
PPHT 08-A2		0.5	2.4
PPHT 08-A2		0.8	2.5
PPHT 08-A2		1.0	2.7
PPHT 10-A2	10	0.5	3.2
PPHT 10-A2		0.8	3.3
PPHT 10-A2		1.0	3.4
PPHT 12-A2	12	0.5	4.0
PPHT 12-A2		1.0	4.2
PPHT 12-A2		2.0	4.6
PPHT 16-A2	16	1.0	5.7
PPHT 16-A2		1.3	5.8
PPHT 16-A2		2.0	6.0
PPHT 16-A2		3.0	6.4
PPHT 20-A2	20	1.0	7.2
PPHT 20-A2		1.6	7.4
PPHT 20-A2		3.0	7.8
PPHT 20-A2		4.0	8.2
PPHT 25-A2	25	2.0	9.3

	DCX	RE	max
PPHF 08-CE1	8	0.6	2.0
PPHF 10-CE1	10	0.8	2.5
PPHF 12-CE1	12	1.0	3.0
PPHF 16-CE1	16	1.3	4.0
PPHF 20-CE1	20	1.6	5.0
PPHF 25-CE1	25	1.9	6.0

	DCX	RE	RPMX	APMX/l
PPHT 08-A2	8	0.3	6.3	1.2/11
PPHT 08-A2		0.5	6.1	1.2/12
PPHT 08-A2		0.8	5.7	1.2/12
PPHT 08-A2		1.0	6.8	1.2/11
PPHT 10-A2	10	0.5	6.9	1.5/13
PPHT 10-A2		0.8	6.6	1.5/13
PPHT 10-A2		1.0	7.5	1.5/12
PPHT 12-A2	12	0.5	7.9	1.8/13
PPHT 12-A2		1.0	7.5	1.8/14
PPHT 12-A2		2.0	9.0	1.8/12
PPHT 16-A2	16	1.0	8.9	2.4/16
PPHT 16-A2		1.3	8.9	2.4/16
PPHT 16-A2		2.0	8.5	2.4/17
PPHT 16-A2		3.0	12.3	2.4/11
PPHT 20-A2	20	1.0	9.3	3/19
PPHT 20-A2		1.6	9.1	3/19
PPHT 20-A2		3.0	8.8	3/20
PPHT 20-A2		4.0	11.4	3/15
PPHT 25-A2	25	2.0	8.3	3.7/26

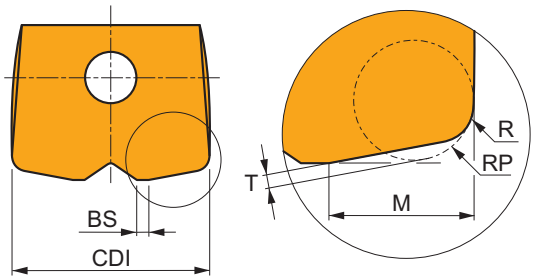
	DCX	RE	RPMX	APMX/l
PPHF 08-CE1	8	0.6	8.0	0.4/3
PPHF 10-CE1	10	0.8	8.0	0.5/4
PPHF 12-CE1	12	1.0	8.0	0.6/5
PPHF 16-CE1	16	1.3	8.0	0.8/6
PPHF 20-CE1	20	1.6	8.0	1.0/8
PPHF 25-CE1	25	1.9	8.0	1.2/9

	DCX	RE	DMIN	DMAX	SMAX DMIN	SMAX DMAX
PPHT 08-A2	8	0.3	11.0	15.9	0.5	0.5
PPHT 08-A2		0.5	10.9	15.9	0.5	0.5
PPHT 08-A2		0.8	10.7	15.9	0.4	0.4
PPHT 08-A2		1.0	10.3	15.9	0.4	0.4
PPHT 10-A2	10	0.5	13.4	19.9	0.7	0.7
PPHT 10-A2		0.8	13.2	19.9	0.6	0.6
PPHT 10-A2		1.0	12.9	19.9	0.6	0.6
PPHT 12-A2	12	0.5	15.8	23.9	1.0	1.0
PPHT 12-A2		1.0	15.4	23.9	0.8	0.8
PPHT 12-A2		2.0	14.6	23.9	0.7	0.7
PPHT 16-A2	16	1.0	20.4	31.9	1.3	1.3
PPHT 16-A2		1.3	20.2	31.9	1.3	1.3
PPHT 16-A2		2.0	19.7	31.9	1.0	1.0
PPHT 16-A2		3.0	18.9	31.9	1.2	1.2
PPHT 20-A2	20	1.0	25.4	39.9	1.8	1.8
PPHT 20-A2		1.6	24.9	39.9	1.6	1.6
PPHT 20-A2		3.0	24.1	39.9	1.2	1.2
PPHT 20-A2		4.0	23.3	39.9	1.3	1.3
PPHT 25-A2	25	2.0	31.1	49.9	1.8	1.8

	DCX	RE	DMIN	DMAX	SMAX DMIN	SMAX DMAX
PPHF 08-CE1	8	0.6	10.0	14.7	0.40	0.40
PPHF 10-CE1	10	0.8	13.0	18.4	0.50	0.50
PPHF 12-CE1	12	1.0	15.7	22.0	0.60	0.60
PPHF 16-CE1	16	1.3	20.9	29.4	0.80	0.80
PPHF 20-CE1	20	1.6	26.2	36.7	1.00	1.00
PPHF 25-CE1	25	1.9	33.0	46.1	1.20	1.20

	DCX	RE	a_p
PPHT 08-A2	**8**	0.3	0.52
PPHT 08-A2		0.5	0.47
PPHT 08-A2		0.8	0.39
PPHT 08-A2		1.0	0.40
PPHT 10-A2	**10**	0.5	0.69
PPHT 10-A2		0.8	0.61
PPHT 10-A2		1.0	0.62
PPHT 12-A2	**12**	0.5	0.97
PPHT 12-A2		1.0	0.79
PPHT 12-A2		2.0	0.68
PPHT 16-A2	**16**	1.0	1.33
PPHT 16-A2		1.3	1.26
PPHT 16-A2		2.0	1.03
PPHT 16-A2		3.0	1.15
PPHT 20-A2	**20**	1.0	1.80
PPHT 20-A2		1.6	1.59
PPHT 20-A2		3.0	1.21
PPHT 20-A2		4.0	1.27
PPHT 25-A2	**25**	2.0	1.83

	DCX	RE	a_p
PPHF 08-CE1	**8**	0.6	0.40
PPHF 10-CE1	**10**	0.8	0.50
PPHF 12-CE1	**12**	1.0	0.60
PPHF 16-CE1	**16**	1.3	0.80
PPHF 20-CE1	**20**	1.6	1.00
PPHF 25-CE1	25	1.9	1.20



DCX	R	RP	M	T
08	0.6	1.0	2.6	0.3
10	0.8	1.2	3.2	0.4
12	1.0	1.5	3.9	0.4
16	1.3	2.0	5.2	0.6
20	1.6	2.5	6.4	0.7
25	1.9	3.0	7.9	0.9

悬伸(长径比)	**< 3.0**	**3.0 – 3.5**	**3.6 – 4.0**	**4.1 – 4.5**	**> 4.6**
速度校正因子	1.0	0.9	0.8	0.7	0.5

K3-CXP

P M K S H

PRAMET

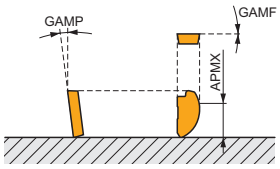
C

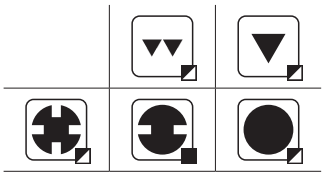
MULTISIDE XP仿形铣削刀盘

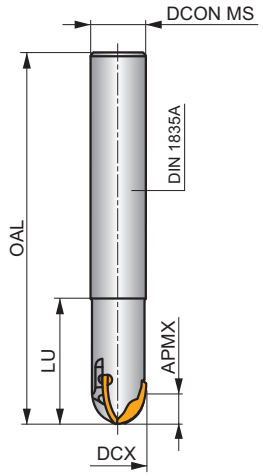
仿形柳叶铣刀盘，使用XP..类型刀片，具有APMX(最大切深)从8至16mm。独特的夹紧方式可使用三种刀片。可提供圆柱柄和模块夹紧系统类型。刀体经过处理，使用寿命更长。

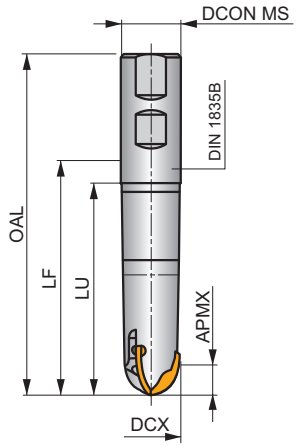
MULTISIDE XP

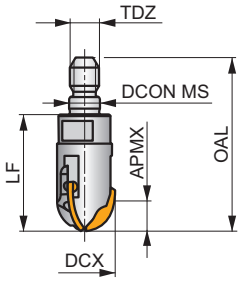
APMX	8.0 - 16.0 mm











h_m 0.05 - 0.19

	Product	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	APMX (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	16K3R050A16-CXP16	16	200	16	50	–	–	–	8.00	0	-5	3	–	22600	–	0.35	GI267	C0520
	16K3R050A20-CXP16	16	200	20	50	–	–	–	8.00	0	-5	3	–	22600	–	0.50	GI267	C0520
	20K3R050A20-CXP20	20	200	20	50	–	–	–	10.00	0	-5	3	–	20000	–	0.52	GI268	C0521
	20K3R060A25-CXP20	20	250	25	60	–	–	–	10.00	0	-5	3	–	20000	–	0.92	GI268	C0521
	25K3R060A25-CXP25	25	250	25	60	–	–	–	12.50	0	-5	3	–	20000	–	0.96	GI269	C0522
	32K3R080A32-CXP32	32	250	32	80	–	–	–	16.00	0	-5	3	–	15000	–	1.50	GI270	C0523
DIN 1835B	16K3R060B20-CXP16	16	111	20	60	–	86.5	–	8.00	0	-5	3	–	22600	–	0.23	GI267	C0520
	20K3R070B25-CXP20	20	127	25	70	–	95.5	–	10.00	0	-5	3	–	20000	–	0.41	GI268	C0521
	25K3R080B25-CXP25	25	137	25	80	–	105	–	12.50	0	-5	3	–	20000	–	0.49	GI269	C0522
MODULAR	16K3R035M10-CXP16	16	–	10.5	–	–	35	M10	8.00	0	-5	3	–	–	–	0.07	GI267	C0520
	20K3R040M10-CXP20	20	–	10.5	–	–	40	M10	10.00	0	-5	3	–	–	–	0.07	GI268	C0521
	25K3R045M12-CXP25	25	–	12.5	–	–	45	M12	12.50	0	-5	3	–	–	–	0.16	GI269	C0522

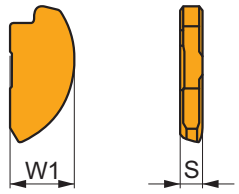
GI267	XP 16..
GI268	XP 20..
GI269	XP 25..
GI270	XP 32..

		Nm			
C0520	US 63009-T09P	1.2	M 3	9	Flag T09P
C0521	US 63513-T15P	3.0	M 3.5	13	Flag T15P
C0522	US 64014-T15P	3.5	M 4	14	Flag T15P
C0523	US 65017-T20P	5.0	M 5	17	Flag T20P

XP

PRAMET

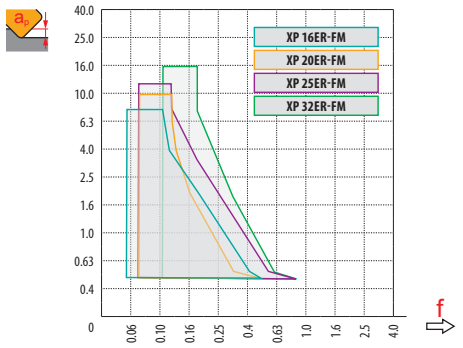
	W1 (mm)	S (mm)
16	16.000	2.00
20	20.000	2.50
25	25.000	3.17
32	32.000	4.00



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

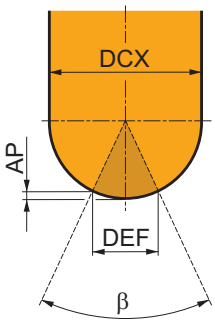
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			U E			FM 型，具有中等宽度设计，适用于轻载加工。														
XP 16ER-FM:M8310		–	■ 285	0.27	0.8	◪ 145	0.24	0.8	■ 270	0.27	0.8	–	–	–	–	–	–	■ 55	0.19	0.8
XP 20ER-FM:M8330		–	■ 260	0.27	1.0	◪ 155	0.24	1.0	■ 245	0.27	1.0	–	–	–	◪ 65	0.19	1.0	◪ 50	0.19	1.0
XP 20ER-FM:M8345		–	■ 190	0.27	1.0	◪ 110	0.24	1.0	–	–	–	–	–	–	◪ 45	0.19	1.0	–	–	–
XP 25ER-FM:M8310		–	■ 270	0.27	1.3	◪ 135	0.24	1.3	■ 255	0.27	1.3	–	–	–	–	–	–	■ 50	0.19	1.3
XP 32ER-FM:M8345		–	■ 180	0.27	1.6	◪ 105	0.24	1.6	–	–	–	–	–	–	◪ 45	0.19	1.6	–	–	–

	XP 16-FM	XP 20-FM	XP 25-FM	XP 32-FM
RE	8.0	10.0	12.5	16.0
BS	–	–	–	–



DCX	a_p	0.3	0.4	0.5	0.7	1.0	1.25	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0
16	DEF	4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	–	–	–
20		4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	–	–
25		5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	–
32		6.2	7.1	7.9	9.4	11.1	12.4	13.5	15.5	17.2	18.7	21.2	23.2	25.0	27.7	29.7	31.2	31.9

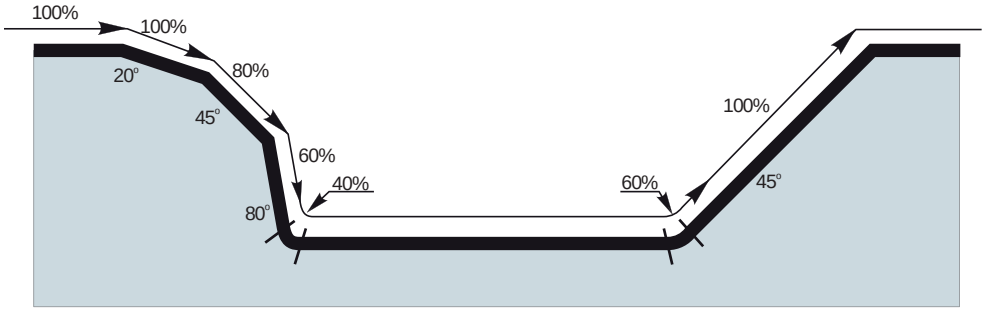
切削刃有效范围.



DCX	β	DEF	AP
16	41°	5.568	0.51
20	37°	6.314	0.52
25	37°	7.901	0.65
32	37°	10.122	0.83

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578

DEF	a_e	1.0 %	2.5 %	5.0 %	7.5 %	10 %	15 %	20 %	25 %	30 %	35 %	40 %	45 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	a_p										⇨ x.f									
19.9 %	1.0 %	2.86	1.84	1.33	1.12	1.00	0.89	–	–	–	–	–	–	–	–	–	–	–	–	–
31.2 %	2.5 %	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	–	–	–	–	–	–	–	–	–	–
43.6 %	5.0 %	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	–	–	–	–	–	–	–	–
52.7 %	7.5 %	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	–	–	–	–	–	–
60.0 %	10.0 %	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	–	–	–	–	–
71.4 %	15.0 %	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	–	–	–	–
80.0 %	20.0 %	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	–	–
86.6 %	25.0 %	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	–	–
91.7 %	30.0 %	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	–
95.4 %	35.0 %	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	–
98.0 %	40.0 %	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	–
99.5 %	45.0 %	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	–
100.0 %	50.0 %	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00



悬伸(长径比)	< 3.0	3.1 – 4.0	4.1 – 6.0	> 6.1
速度校正因子	1.0	0.9	0.7	0.5

平面铣

	SVC22C	SCN05C	SWN04C			
	90°	90° (93°)	90° (93°)			
	APMX (mm) 3.0 (16.0)	APMX (mm) 0.5 (1.0)	APMX (mm) 0.5 (2.0)			
	DC (mm) 32 – 80	DC (mm) 12 – 20	DC (mm) 16 – 35			
圆柱刀柄	DC = 32, 40 (mm)	DC = 12 – 20 (mm)	DC = 16 – 32 (mm)			
侧固刀柄						
模块式刀柄	DC = 32, 40 (mm)	DC = 12 – 20 (mm)	DC = 16 – 35 (mm)			
套式铣刀	DC = 50 – 80 (mm)					
页码	240	243	246			
ISO	N	P K H	P K H			
刀片形状						
刀片	VCGT 220530	CN.. 0502	WN.. 0403			
切削刃数量	2	4	6			
波状表面(仿形铣)		■	■			
平面铣		■	■			
螺旋插补	■					
连续钻铣	■					
坡走铣	◪	■	■			
浅槽铣	◪					
深方肩铣	◪	■	■			
插铣		■	■			

■ 推荐使用 ◪ 可以使用

SVC22C

N

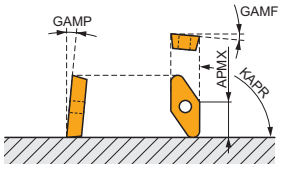
PRAMET

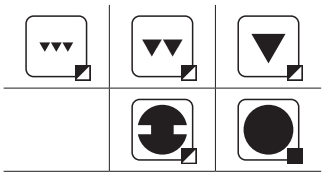
S

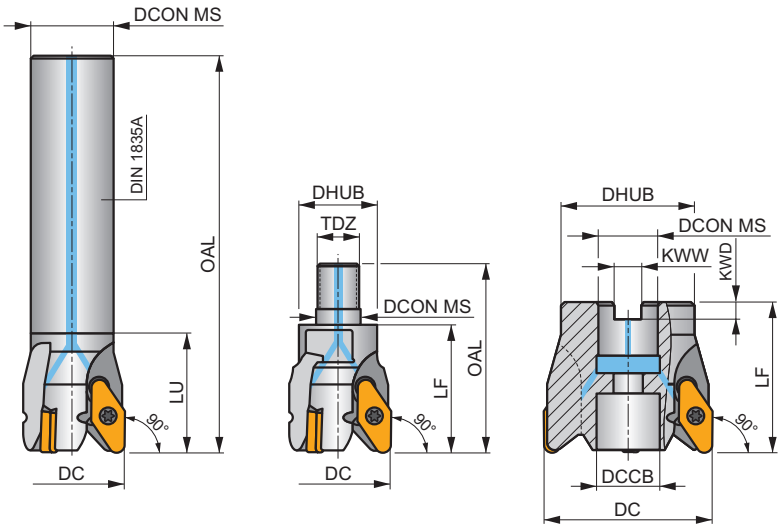
有色金属材质铣刀盘，带内冷

高效富有成效的VCGT　22刀片，铝和有色金属材料的高效刀具，具有APMX(最大切深)16mm。内冷。适用于面铣，连续钻铣，方肩铣，坡走铣和铣槽。可提供圆柱直柄，模块夹紧系统和心轴式接口。刀体经过处理，使用寿命更长。

KAPR	90°
APMX	3.0 (16.0) mm







h_m	0.03 - 0.5
h_m	0.03 - 0.55

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	DHUB (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	32A2R045A25-SVC22C	32	120	25	–	45	–	–	–	–	–	4	3	2	–	10400	✓	0.46	GI141	C0560
	40A3R045A32-SVC22C	40	150	32	–	45	–	–	–	–	–	8	3	3	–	9300	✓	0.91	GI141	C0560
MODULAR	32A2R048M16-SVC22C	32	71	17	–	–	48	29	M16	–	–	11	3	2	–	–	✓	0.17	GI141	C0560
	40A3R048M16-SVC22C	40	71	17	–	–	48	29	M16	–	–	13	3	3	–	–	✓	0.24	GI141	C0560
ISO 6462 DIN 8030	50A03R-S90VC22C	50	–	22	18	–	56	40	–	10	6.3	4	3	3	–	8400	✓	0.42	GI141	C0563
	63A04R-S90VC22C	63	–	22	18	–	56	50	–	10	6.3	6	3	4	–	7400	✓	0.68	GI141	C0563
	80A05R-S90VC22C	80	–	27	20	–	56	63	–	12	7	8	3	5	–	6600	✓	1.12	GI141	C0562

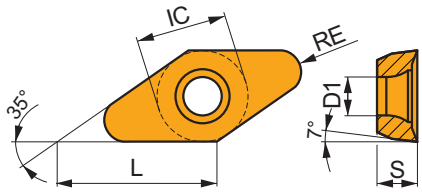
GI141	VCGT 220530F-FA

		Nm					
C0560	US 4511-T20	5.0	M 4.5	11	–	–	Flag T20
C0562	US 4511-T20	5.0	M 4.5	11	SDR T20-T	–	–
C0563	US 4511-T20	5.0	M 4.5	11	SDR T20-T	HS 1030C	–

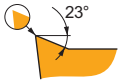
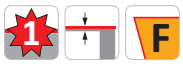
VCGT 22-FA

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2205	12.700	5.20	22.00	5.50

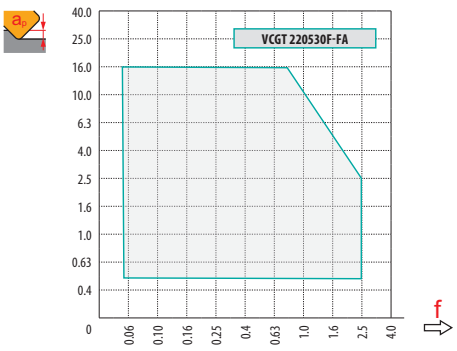


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	●	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
FA 型，具有大正前角设计，适用于中等加工到粗加工。																				
VCGT 220515F-FA:HF7	●	1.5	–	–	–	–	–	–	–	–	–	■ 255	0.24	0.4	–	–	–	–	–	–
VCGT 220520F-FA:HF7	●	2.0	–	–	–	–	–	–	–	–	–	■ 255	0.30	0.5	–	–	–	–	–	–
VCGT 220530F-FA:HF7	●	3.0	–	–	–	–	–	–	–	–	–	■ 210	0.48	1.0	–	–	–	–	–	–

a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	VCGT 22-FA		
RE	1.5	2.0	3.0
BS	–	–	–



a_p	0.5	3.0	12.0
f	0.86	0.31	0.05

DC	RPMX	APMX/I
32	8.0	12.0/87
40	8.0	12.0/87
50	6.0	10.4/100
63	4.2	7.2/100
80	3.1	5.3/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	42.0	64.0	4.2	12.0
40	58.0	80.0	7.7	12.0
50	78.0	100.0	9.0	12.0
63	104.0	126.0	9.3	12.0
80	138.0	160.0	9.7	12.0

a_p
9

DC	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
RE	µm	3	5	10	15	20	30	40	50	60	80	100
3.0	FE	0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549

SCN05C

P K H

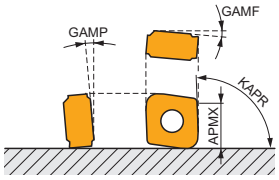
PRAMET

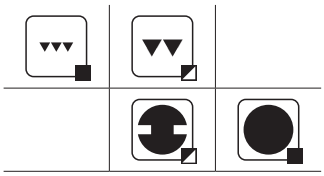
S

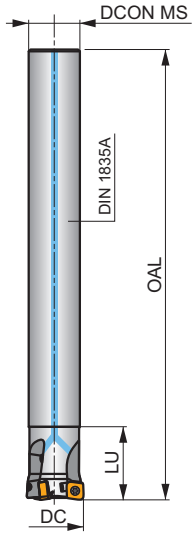
立铣刀用于模具应用，带内冷

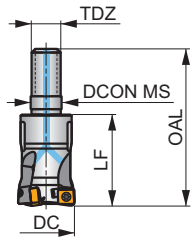
方肩铣刀，广泛应用APMX(最大切深)为0.5mm的模具精加工区域。具有4个切削刃的高精度磨削双面CNHX05刀片，提供了高精度和经济性。可提供圆柱柄和模块夹紧系统类型。刀体经过处理，使用寿命更长。

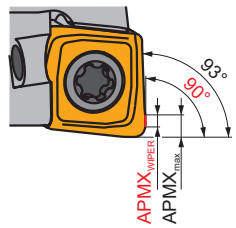
KAPR	90° (93°)
APMX	0.5 (1.0 mm)











h_m 0.02 - 0.07

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	12A2R020A10-SCN05C-C	12	100	10	20	–	–	-15	-8	2	–	48700	✓	0.08	GI330	C0601
	16A3R020A14-SCN05C-C	16	130	14	20	–	–	-13.5	-7.8	3	–	42200	✓	0.16	GI330	C0601
	20A5R020A18-SCN05C-C	20	160	18	20	–	–	-12.7	-7.5	5	✓	37700	✓	0.31	GI330	C0601
MODULAR	12A2R020M06-SCN05C-C	12	35	6.5	–	20	M6	-15	-8	2	–	–	✓	0.04	GI330	C0601
	16A3R025M08-SCN05C-C	16	43	8.5	–	25	M8	-13.5	-7.8	3	–	–	✓	0.05	GI330	C0601
	20A5R030M10-SCN05C-C	20	49	10.5	–	30	M10	-12.7	-7.5	5	✓	–	✓	0.08	GI330	C0601

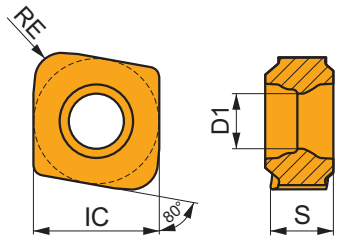
GI330	CNHX0502..

C0601	US 62005-T06P	0.9	M 2	4.9	Flag T06P

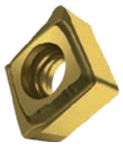
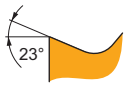
CNHX 05

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0502	4.800	2.10	2.40



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

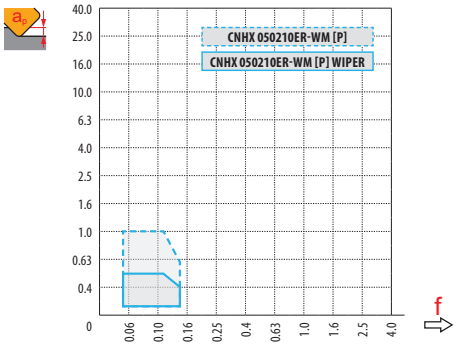
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
CNHX 050205ER-WM:M4310	●	0.5	◪	350	0.10	0.5	–	–	–	■	335	0.10	0.5	–	–	–	–	–	–	■	70	0.10	0.5
CNHX 050205ER-WM:M8330	⬌	0.5	■	310	0.10	0.5	–	–	–	■	290	0.10	0.5	–	–	–	–	–	–	◪	60	0.10	0.5
CNHX 050210ER-WM:M4310	⬌	1.0	◪	440	0.10	0.5	–	–	–	■	420	0.10	0.5	–	–	–	–	–	–	■	85	0.10	0.5
CNHX 050210ER-WM:M8330	⬌	1.0	■	390	0.10	0.5	–	–	–	■	370	0.10	0.5	–	–	–	–	–	–	◪	75	0.10	0.5

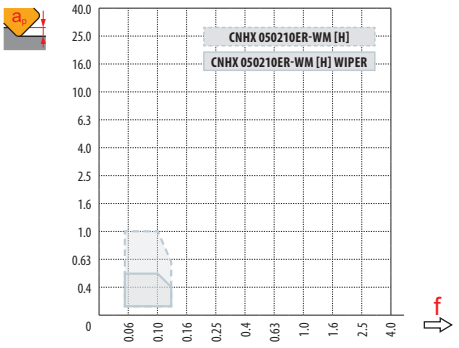
WM 型，具有修光刃设计，适用于半精加工到精加工。

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

a_e / DC	0.5 %	1.0 %	2.0 %	3.0 %	4.0 %	5.0 %
X.V	2.04	1.85	1.68	1.59	1.53	1.48

	CNHX 05-WM	
RE	0.5	1.0
BS	0.50	0.50





DC	max
12	0.4
16	0.4
20	0.5

DC	RPMX	APMX/I
12	2.4	1/25
16	1.5	1/40
20	1.1	1/54

SWN04C

P K H

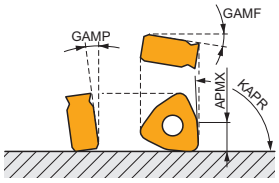
PRAMET

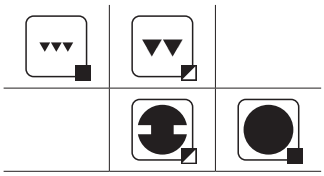
S

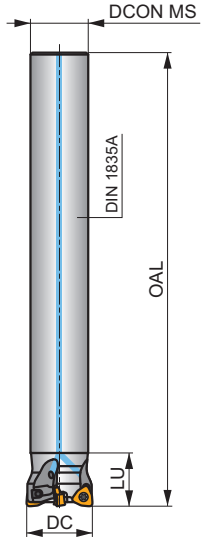
立铣刀用于模具应用，带内冷

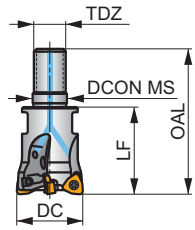
方肩铣刀，广泛应用APMX(最大切深)为0.5mm的模具精加工区域。具有6个切削刃的高精度磨削WNHX04刀片，提供了高精度和经济性。可提供圆柱柄和模块夹紧系统类型。刀体经过处理，使用寿命更长。

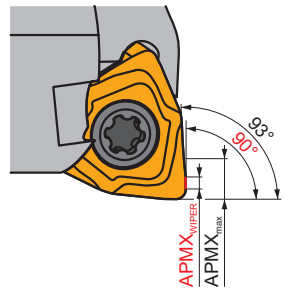
KAPR	90° (93°)
APMX	0.5 (2.0 mm)











h_m 0.02 - 0.07

	产品	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	16A2R020A14-SWN04C-C	16	140	14	20	–	–	-13.5	-8	2	–	33200	✓	0.14	GI331	C0602
	20A3R020A18-SWN04C-C	20	160	18	20	–	–	-12	-8	3	–	19700	✓	0.27	GI331	C0602
	25A4R020A22-SWN04C-C	25	180	22	20	–	–	-11.5	-8	4	✓	26600	✓	0.45	GI331	C0602
	32A6R020A25-SWN04C-C	32	200	25	20	–	–	-11.2	-8	6	✓	23500	✓	0.69	GI331	C0602
MODULAR	16A2R025M08-SWN04C-C	16	43	8.5	–	25	M08	-13.5	-8	2	–	33200	✓	0.05	GI331	C0602
	20A3R030M10-SWN04C-C	20	49	10.5	–	30	M10	-12	-8	3	–	–	✓	0.07	GI331	C0602
	25A4R033M12-SWN04C-C	25	55	12.5	–	33	M12	-11.5	-8	4	✓	–	✓	0.10	GI331	C0602
	32A6R040M16-SWN04C-C	32	63	17	–	40	M16	-11.2	-8	6	✓	–	✓	0.21	GI331	C0602
	35A6R043M16-SWN04C-C	35	66	17	–	43	M16	-11.1	-8	6	✓	–	✓	0.22	GI331	C0602

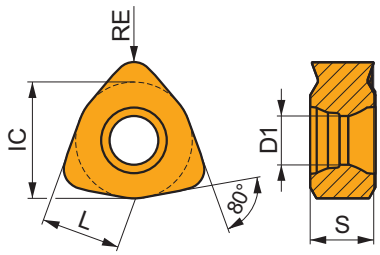
GI331	WNHX0403..

		Nm			
C0602	US 42507-T07P	1.2	M 2.5	7	Flag T07P

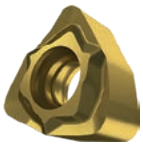
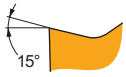
WNHX 04

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0403	6.200	2.60	3.38



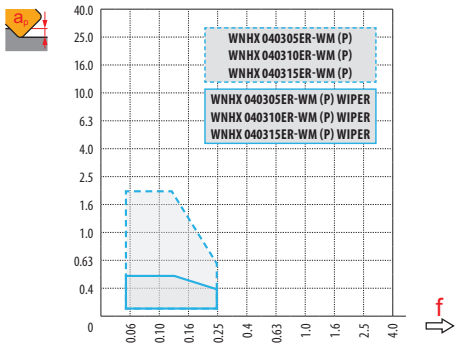
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

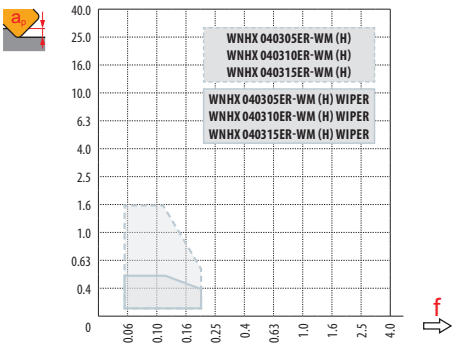
产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
						WM 型，具有修光刃设计，适用于半精加工到精加工。														
WNHX 040305ER-WM:M4310	●	0.5	◪ 290	0.15	1.0	–	–	–	■ 275	0.15	1.0	–	–	–	–	–	–	■ 55	0.10	0.7
WNHX 040305ER-WM:M8330	⇕	0.5	■ 260	0.15	1.0	–	–	–	■ 245	0.15	1.0	–	–	–	–	–	–	◪ 50	0.10	0.7
WNHX 040310ER-WM:M4310	⇕	1.0	◪ 370	0.15	1.0	–	–	–	■ 350	0.15	1.0	–	–	–	–	–	–	■ 70	0.10	0.7
WNHX 040310ER-WM:M8330	⇕	1.0	■ 330	0.15	1.0	–	–	–	■ 310	0.15	1.0	–	–	–	–	–	–	◪ 65	0.10	0.7
WNHX 040315ER-WM:M4310	⇕	1.5	◪ 390	0.15	1.0	–	–	–	■ 370	0.15	1.0	–	–	–	–	–	–	■ 75	0.10	0.7
WNHX 040315ER-WM:M8330	⇕	1.5	■ 345	0.15	1.0	–	–	–	■ 325	0.15	1.0	–	–	–	–	–	–	◪ 65	0.10	0.7

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

a_e / DC	0.5 %	1.0 %	2.0 %	3.0 %	4.0 %	5.0 %
X.V	2.04	1.85	1.68	1.59	1.53	1.48

	WNHX 04-WM		
RE	0.5	1.0	1.5
BS	0.50	0.50	0.50





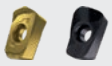
DC	max
16	
20	0.4
25	0.5
32	0.5
35	0.5

DC	RPMX	APMX/I
16		
20	0.7	1.1/100
25	0.5	0.75/100
32	0.3	0.4/100
35	0.3	0.4/100

快进给铣削

可转位铣刀 – 导航工具

平面铣

	SBN10	SSN11				
	20°	18°				
	APMX (mm) 1.0	APMX (mm) 1.7				
	DCX (mm) 16 – 66	DCX (mm) 32 – 125				
圆柱刀柄	DCX = 16 – 35 (mm)	DCX = 32, 35 (mm)				
侧固刀柄						
模块式刀柄	DCX = 16 – 40 (mm)	DCX = 32 – 40 (mm)				
套式铣刀	DCX = 40 – 66 (mm)	DCX = 40 – 125 (mm)				
页码	252	258				
ISO	P M K S H	P M K S H				
刀片形状						
刀片	BNGX 10T3 ANHX 10T3	SNGX 1104				
切削刃数量	4 / 2	8				
平面铣	■	■				
螺旋插补	■	◪				
浅方肩铣	■	■				
插铣	■	■				
连续钻铣	■	◪				
坡走铣	■	◪				
形面铣(仿形铣)	■	■				
浅槽铣	◪	◪				

■ 推荐使用　◪ 可以使用

SBN10

P M K S H

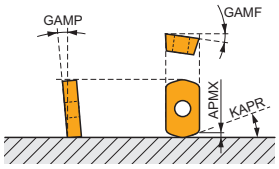
PRAMET

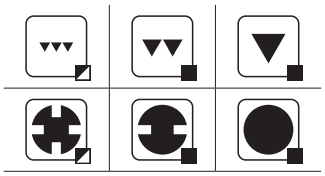
S

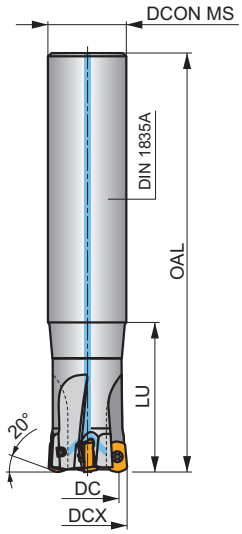
快进给铣刀盘，使用BN.. 10刀片，带内冷，新一代

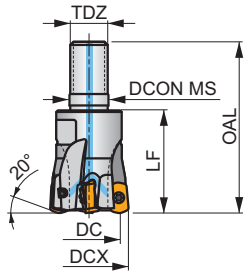
快进给铣刀盘，小尺寸双面BNGX 10刀片，具有4个切削刃和APMX(最大切深)1mm。内冷。应用范围广泛。可提供圆柱直柄，模块夹紧系统和心轴式接口。刀体经过处理，使用寿命更长。

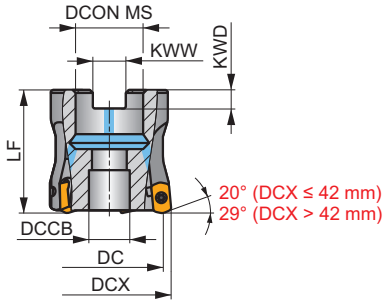
KAPR	20° (29°)
APMX	1.0 mm











h_m	0.17 - 0.41
h_m	0.17 - 0.41

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	KAPR (°)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	16E2R030A16-SBN10-C	16	9.4	100	16	–	30	–	–	–	–	20	-12	-10	2	✓	31100	✓	0.13	GI329	C0310
	16E2R050A16-SBN10-C	16	9.4	150	16	–	50	–	–	–	–	20	-12	-10	2	–	31100	✓	0.18	GI329	C0310
	16E2R030A14-SBN10-C	16	9.4	150	14	–	30	–	–	–	–	20	-12	-10	2	–	31100	✓	0.18	GI329	C0310
	18E2R030A16-SBN10-C	18	11.4	150	16	–	30	–	–	–	–	20	-11	-10	2	–	29200	✓	0.23	GI329	C0310
	20E3R040A20-SBN10-C	20	13.4	130	20	–	40	–	–	–	–	20	-10	-10	3	–	27700	✓	0.25	GI329	C0310
	20E3R080A20-SBN10-C	20	13.4	160	20	–	80	–	–	–	–	20	-10	-10	3	–	27700	✓	0.29	GI329	C0310
	20E3R040A18-SBN10-C	20	13.4	180	18	–	40	–	–	–	–	20	-10	-10	3	–	27700	✓	0.29	GI329	C0310
	20E4R040A20-SBN10-C	20	13.4	130	20	–	40	–	–	–	–	20	-10	-10	4	–	27700	✓	0.28	GI329	C0310
	25E4R050A25-SBN10-C	25	18.4	140	25	–	50	–	–	–	–	20	-9	-10	4	✓	24800	✓	0.42	GI329	C0310
	25E4R100A25-SBN10-C	25	18.4	180	25	–	100	–	–	–	–	20	-9	-10	4	✓	24800	✓	0.51	GI329	C0310
	25E4R050A22-SBN10-C	25	18.4	220	22	–	50	–	–	–	–	20	-9	-10	4	✓	24800	✓	0.58	GI329	C0310
	25E5R050A25-SBN10-C	25	18.4	140	25	–	50	–	–	–	–	20	-9	-10	5	–	24800	✓	0.42	GI329	C0310
	32E5R070A32-SBN10-C	32	25.4	150	32	–	70	–	–	–	–	20	-8	-10	5	✓	21900	✓	0.73	GI329	C0310
	32E6R070A32-SBN10-C	32	25.4	150	32	–	70	–	–	–	–	20	-8	-10	6	✓	21900	✓	0.76	GI329	C0310
	32E5R120A32-SBN10-C	32	25.4	200	32	–	120	–	–	–	–	20	-8	-10	5	✓	21900	✓	0.96	GI329	C0310
	35E5R050A32-SBN10-C	35	28.4	200	32	–	50	–	–	–	–	20	-7.5	-10	5	✓	21000	✓	1.08	GI329	C0310
	35E6R050A32-SBN10-C	35	28.4	200	32	–	50	–	–	–	–	20	-7.5	-10	6	✓	21000	✓	1.08	GI329	C0310
MODULAR	16E2R025M08-SBN10-C	16	9.4	43	8.5	–	–	25	M8	–	–	20	-12	-10	2	–	31100	✓	0.05	GI329	C0310
	18E2R025M08-SBN10-C	18	11.4	43	8.5	–	–	25	M8	–	–	20	-11	-10	2	–	29200	✓	0.05	GI329	C0310
	20E3R030M10-SBN10-C	20	13.4	49	10.5	–	–	30	M10	–	–	20	-10	-10	3	–	27700	✓	0.07	GI329	C0310
	20E4R030M10-SBN10-C	20	13.4	49	10.5	–	–	30	M10	–	–	20	-10	-10	4	–	27700	✓	0.06	GI329	C0310
	25E4R033M12-SBN10-C	25	18.4	55	12.5	–	–	33	M12	–	–	20	-9	-10	4	✓	24800	✓	0.08	GI329	C0310
	25E5R033M12-SBN10-C	25	18.4	55	12.5	–	–	33	M12	–	–	20	-9	-10	5	–	24800	✓	0.10	GI329	C0310
	28E5R035M12-SBN10-C	28	21.4	57	12.5	–	–	35	M12	–	–	20	-8.5	-10	5	✓	23400	✓	0.12	GI329	C0310
	32E5R040M16-SBN10-C	32	25.4	63	17	–	–	40	M16	–	–	20	-8	-10	5	✓	21900	✓	0.21	GI329	C0310
	32E6R040M16-SBN10-C	32	25.4	63	17	–	–	40	M16	–	–	20	-8	-10	6	✓	21900	✓	0.21	GI329	C0310
	35E6R043M16-SBN10-C	35	28.4	66	17	–	–	43	M16	–	–	20	-7.5	-10	6	✓	21000	✓	0.23	GI329	C0310

产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	KAPR (°)	GAMF (°)	GAMP (°)			max.		kg		
MODULAR																				
40E6R043M16-SBN10-C	40	33.4	66	17	–	–	43	M16	–	–	20	-7	-10	6	✓	19600	✓	0.27	GI329	C0310
40E7R043M16-SBN10-C	40	33.4	66	17	–	–	43	M16	–	–	20	-7	-10	7	✓	19600	✓	0.26	GI329	C0310
ISO 6462 DIN 8030																				
40A05R-SMOBN10-C	40	33.4	–	16	14.1	–	40	–	8.4	5.6	20	-7	-10	5	✓	19600	✓	0.23	GI329	C0312
40A07R-SMOBN10-C	40	33.4	–	16	14.1	–	40	–	8.4	5.6	20	-7	-10	7	✓	19600	✓	0.27	GI329	C0312
42A05R-SMOBN10-C	42	35.4	–	16	14.1	–	40	–	8.4	5.6	20	-7	-10	5	✓	19100	✓	0.23	GI329	C0312
42A07R-SMOBN10-C	42	35.4	–	16	14.1	–	40	–	8.4	5.6	20	-7	-10	7	✓	19100	✓	0.36	GI329	C0312
50A07R-SMOBN10-C	50	45	–	22	18.1	–	40	–	10.4	6.3	29	-6	-7	7	✓	17500	✓	0.46	GI343	C0311
50A08R-SMOBN10-C	50	45	–	22	18.1	–	40	–	10.4	6.3	29	-6	-7	8	✓	17500	✓	0.34	GI343	C0311
52A07R-SMOBN10-C	52	47	–	22	18.1	–	40	–	10.4	6.3	29	-6	-7	7	✓	17200	✓	0.49	GI343	C0311
52A08R-SMOBN10-C	52	47	–	22	18.1	–	40	–	10.4	6.3	29	-6	-7	8	✓	17200	✓	0.37	GI343	C0311
66A08R-SMOBN10-C	66	61	–	27	22.1	–	50	–	12.4	7	29	-6	-7	8	✓	15200	✓	0.89	GI343	C0313

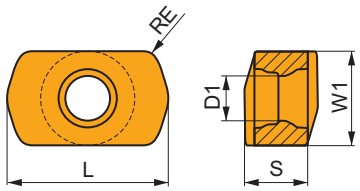
GI329	BNGX 10T3…	ANHX 10T3..
GI343	BNGX 10T3…	–

		Nm						
C0310	US 42507-T07P	1.2	M 2.5	7	Flag T07P	–	–	–
C0313	US 42507-T07P	1.2	M 2.5	7	–	D-T07P/T09P	FG-15	HS 1230C
C0312	US 42507-T07P	1.2	M 2.5	7	–	D-T07P/T09P	FG-15	HS 0830C
C0311	US 42507-T07P	1.2	M 2.5	7	–	D-T07P/T09P	FG-15	HS 1030C

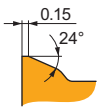
BNGX 10

PRAMET

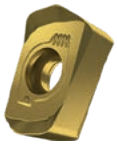
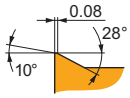
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
10T3	5.800	2.76	9.92	3.90



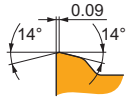
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
					M 型，具有正前角设计，适用于快进给。														
BNGX 10T308SR-M:8215	0.8	240	0.65	0.7	–	–	–	225	0.65	0.7	–	–	–	–	–	–	45	0.36	0.5
BNGX 10T308SR-M:M6330	0.8	210	0.65	0.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
BNGX 10T308SR-M:M8310	0.8	250	0.65	0.7	–	–	–	235	0.65	0.7	–	–	–	–	–	–	50	0.36	0.5
BNGX 10T308SR-M:M8330	0.8	240	0.65	0.7	–	–	–	225	0.65	0.7	–	–	–	–	–	–	45	0.36	0.5
BNGX 10T308SR-M:M8340	0.8	225	0.65	0.7	–	–	–	210	0.65	0.7	–	–	–	–	–	–	–	–	–
BNGX 10T308SR-M:M8345	0.8	180	0.65	0.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
BNGX 10T308SR-M:M9325	0.8	275	0.65	0.7	–	–	–	260	0.65	0.7	–	–	–	–	–	–	55	0.36	0.5

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
BNGX 10T308SR-MM:M6330		0.8	215	0.65	0.6	150	0.59	0.6	–	–	–	–	–	–	60	0.46	0.5	–	–	–
BNGX 10T308SR-MM:M8310		0.8	255	0.65	0.6	130	0.59	0.6	–	–	–	–	–	–	–	–	–	–	–	–
BNGX 10T308SR-MM:M8330		0.8	245	0.65	0.6	145	0.59	0.6	–	–	–	–	–	–	60	0.46	0.5	–	–	–
BNGX 10T308SR-MM:M8340		0.8	230	0.65	0.6	135	0.59	0.6	–	–	–	–	–	–	55	0.46	0.5	–	–	–
BNGX 10T308SR-MM:M8345		0.8	180	0.65	0.6	105	0.59	0.6	–	–	–	–	–	–	45	0.46	0.5	–	–	–
BNGX 10T308SR-MM:M9325		0.8	280	0.65	0.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
BNGX 10T308SR-MM:M9340		0.8	250	0.65	0.6	150	0.59	0.6	–	–	–	–	–	–	60	0.46	0.5	–	–	–

MM 型，具有大正前角设计，适用于快进给。



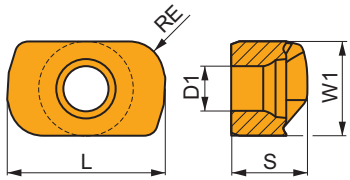
BNGX 10T308SR-HM:8215		0.8	–	–	–	–	–	–	240	0.65	0.4	–	–	–	–	–	–	50	0.65	0.4
BNGX 10T308SR-HM:M8310		0.8	–	–	–	–	–	–	250	0.65	0.4	–	–	–	–	–	–	50	0.65	0.4
BNGX 10T308SR-HM:M8330		0.8	–	–	–	–	–	–	240	0.65	0.4	–	–	–	–	–	–	50	0.65	0.4

HM 型，具有强壮的设计，适用于快进给。

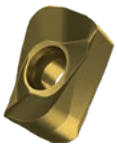
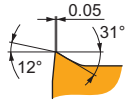
ANHX 10

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
10T3	5.800	2.76	9.72	4.70



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

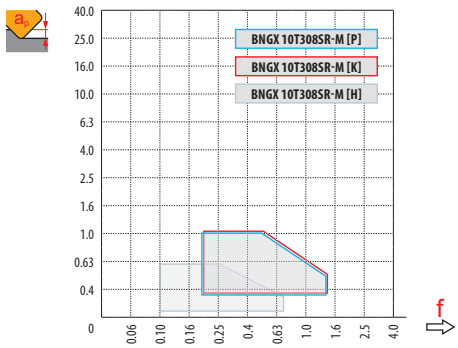
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
ANHX 10T320SR-F:M8310		2.0	380	0.10	2.5	190	0.09	2.5	–	–	–	–	–	–	–	–	–	–	–	–
ANHX 10T320SR-F:M8330		2.0	340	0.10	2.5	200	0.09	2.5	–	–	–	–	–	–	–	–	–	–	–	–

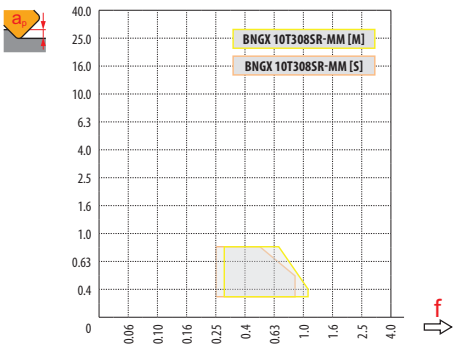
F 型，具有正前角设计，适用于精加工和半精加工。

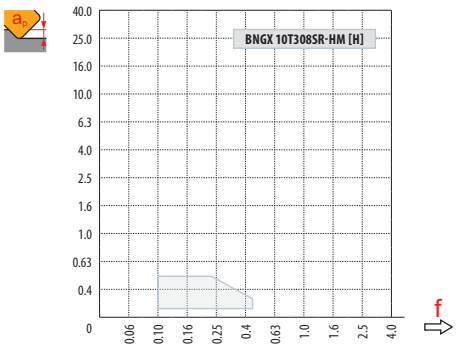
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

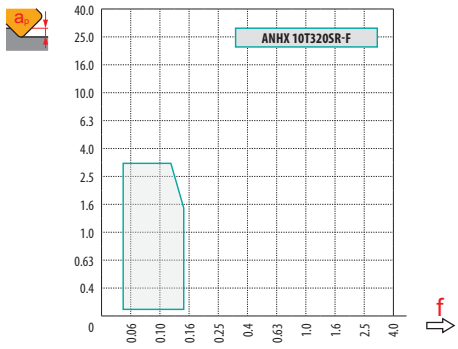
	BNGX 10-M	BNGX 10-MM	BNGX 10-HM
RE	0.8	0.8	0.8
BS	–	–	–

	ANHX 10 - F
RE	2.0
BS	0.92









BNGX 10 (HFC)										
DCX	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
16	DEF	9.40	12.85	13.36	13.80	14.20	14.56	14.88	15.19	15.47
18		11.40	14.85	15.36	15.80	16.20	16.56	16.88	17.19	17.47
20		13.40	16.85	17.36	17.80	18.20	18.56	18.88	19.19	19.47
25		18.40	21.85	22.36	22.80	23.20	23.56	23.88	24.19	24.47
32		25.40	28.85	29.36	29.80	30.20	30.56	30.88	31.19	31.47
35		28.40	31.85	32.36	32.80	33.20	33.56	33.88	34.19	34.47
40		33.40	36.85	37.36	37.80	38.20	38.56	38.88	39.19	39.47
42		35.40	38.85	39.36	39.80	40.20	40.56	40.88	41.19	41.47
50		43.98	46.09	46.45	46.82	47.18	47.54	47.90	48.26	48.56
52		45.98	48.09	48.45	48.82	49.18	49.54	49.90	50.26	50.56
66		59.98	62.09	62.45	62.82	63.18	63.54	63.90	64.26	64.56
	a_p	**0.00**	**0.30**	**0.40**	**0.50**	**0.60**	**0.70**	**0.80**	**0.90**	**1.00**
	1 f	–	1.30	1.10	0.90	0.80	0.72	0.68	0.65	0.50

BNGX 10		
DCX	$a_{e\,max}$	f_{max}
16	3.5	0.12
18	3.5	0.12
20	4.0	0.15
25	4.0	0.15
32	4.0	0.17
35	4.0	0.17
40	4.0	0.17
42	4.0	0.17
50	4.5	0.30
52	4.5	0.30
66	4.5	0.30

BNGX 10 (HFC)			
a_p	0.3	0.6	1.0
1 f	1.10	0.60	0.30

DCX	BNGX 10 (HFC)		ANHX 10	
	RPMX	APMX/I	RPMX	APMX/I
16	3.8	1/17	1.6°	2.65/100
18	3.8	1/17	1.3°	2.15/100
20	3.8	1/17	1.1°	1.80/100
25	2.6	1/24	0.8°	1.25/100
32	1.8	1/33	0.5°	0.75/100
35	1.6	1/37	0.5°	0.75/100
40	1.3	1/46	0.4°	0.55/100
42	1.3	1/46	0.4°	0.55/100
50	0.4	0.55/100	–	–
52	0.4	0.55/100	–	–
66	0.3	0.4/100	–	–

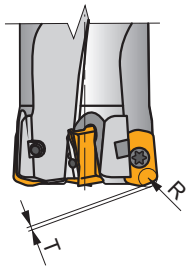
BNGX 10 (HFC)		
DCX	a_p	f_{max}
16	0.4	0.15
18	0.7	0.15
20	0.7	0.15
25	0.7	0.15
32	0.7	0.2
35	0.7	0.2
40	0.7	0.2
42	0.7	0.2
50	0.3	0.2
52	0.3	0.2
66	0.3	0.2

BNGX 10 (HFC)				
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	22.4	31.8	0.5	0.5
18	25.4	35.8	0.5	0.5
20	29.4	39.8	0.5	0.5
25	39.4	49.8	0.5	0.5
32	53.4	63.8	0.5	0.5
35	59.4	69.8	0.5	0.5
40	69.4	79.8	0.5	0.5
42	73.4	83.8	0.5	0.5
50	89.6	99.6	0.5	0.5
52	93.6	103.6	0.5	0.5
66	121.6	131.6	0.5	0.5

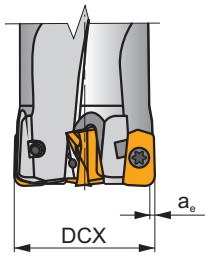
DCX	µm	3	5	10	15	20	30	40	50	60	80	100
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099

ANHX 10

RE	µm	3	5	10	15	20	30	40	50	60	80	100
2.0	FE	0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265



	R	T
BNGX 10T308	1.60	0.44



	max a_e/DCX
ANHX 10T320	0.05

SSN11

P M K S H

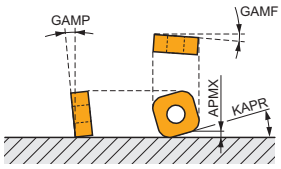
PRAMET

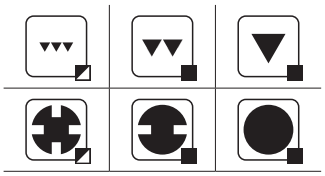
S

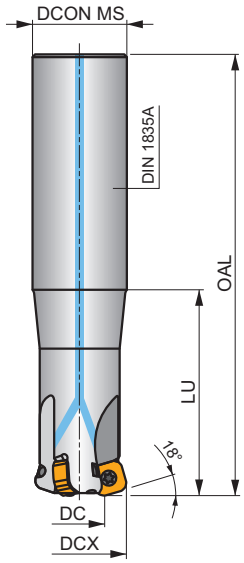
快进给铣刀，使用SN.. 11刀片，带内冷设计，新型刀片

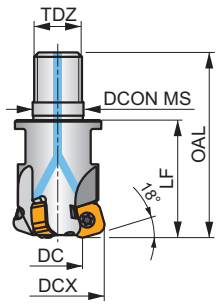
适合加工更大直径的快进给铣刀，使用双面SNGX 11刀片，具有8个切削刃和1.7毫米APMX。带有内冷设计。应用范围广泛。可以选择圆柄直柄、模块化和心轴式接口，直径从32毫米到125毫米。刀杆经过处理，延长了使用寿命。

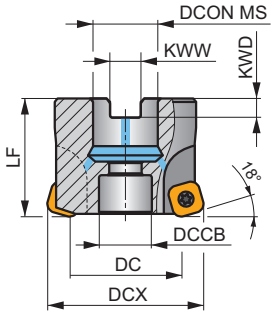
KAPR	18°
APMX	1.7 mm











h_m	0.20 - 0.46
h_m	0.20 - 0.46

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	32E3R070A32-SSN11-C	32	18.3	150	32	–	70	–	–	–	–	-11.5	-10	3	–	17500	✓	0.69	GI339	C0314	–
	32E3R120A32-SSN11-C	32	18.3	200	32	–	120	–	–	–	–	-11.5	-10	3	–	17500	✓	0.89	GI339	C0314	–
	35E3R050A32-SSN11-C	35	21.2	200	32	–	50	–	–	–	–	-11	-10	3	–	16800	✓	1.08	GI339	C0314	–
MODULAR	32E3R040M16-SSN11-C	32	18.3	63	17	–	–	40	M16	–	–	-11.5	-10	3	–	17500	✓	0.19	GI339	C0314	–
	35E3R040M16-SSN11-C	35	21.2	63	17	–	–	40	M16	–	–	-11	-10	3	–	16800	✓	0.19	GI339	C0314	–
	40E4R043M16-SSN11-C	40	26.2	66	17	–	–	43	M16	–	–	-10.5	-10	4	✓	15700	✓	0.26	GI339	C0314	–
ISO 6462 DIN 8030	40A04R-SMOSN11-C	40	26.2	–	16	12.4	–	40	–	8.4	5.6	-10.5	-10	4	✓	15700	✓	0.19	GI339	C0316	–
	42A04R-SMOSN11-C	42	28.2	–	16	14.1	–	40	–	8.4	5.6	-10.5	-10	4	✓	15300	✓	0.21	GI339	C0318	–
	50A05R-SMOSN11-C	50	36.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	5	✓	14000	✓	0.31	GI339	C0320	–
	50A06R-SMOSN11-C	50	36.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	6	✓	14000	✓	0.43	GI339	C0320	–
	52A05R-SMOSN11-C	52	38.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	5	✓	13800	✓	0.47	GI339	C0320	–
	52A06R-SMOSN11-C	52	38.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	6	✓	13800	✓	0.46	GI339	C0320	–
	63A06R-SMOSN11-C	63	49.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	6	✓	12500	✓	0.46	GI339	C0320	–
	63A08R-SMOSN11-C	63	49.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	8	✓	12500	✓	0.60	GI339	C0320	–
	66A06R-SMOSN11-C	66	52.1	–	27	18.1	–	50	–	12.4	7	-10	-10	6	✓	12200	✓	0.88	GI339	C0322	–
	66A08R-SMOSN11-C	66	52.1	–	27	18.1	–	50	–	12.4	7	-10	-10	8	✓	12200	✓	0.88	GI339	C0322	–
	80A07R-SMOSN11-C	80	66.1	–	27	38.1	–	50	–	12.4	7	-10	-10	7	✓	11100	✓	0.95	GI339	C0324	AC001
	80A09R-SMOSN11-C	80	66.1	–	27	38.1	–	50	–	12.4	7	-10	-10	9	✓	11100	✓	1.03	GI339	C0324	AC001
	100A08R-SMOSN11-C	100	86.1	–	32	45.1	–	50	–	14.4	8	-10	-10	8	✓	9900	✓	1.83	GI339	C0324	AC002
	115A08R-SMOSN11-C	115	101.1	–	32	45.1	–	50	–	14.4	8	-10	-10	8	✓	9200	✓	2.30	GI339	C0324	AC002
	125A08R-SMOSN11-C	125	111.1	–	40	56.1	–	63	–	16.4	9	-10	-10	8	✓	8900	✓	3.34	GI339	C0324	AC003

GI339	SNGX 1104..

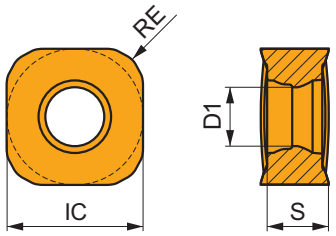
		Nm						
C0314	US 44012-T15P	3.5	M 4	12	–	–	Flag T15P	–
C0316	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HCS 0840C
C0318	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 90835
C0320	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 1030C
C0322	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 1230C
C0324	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

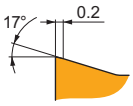
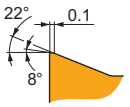
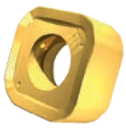
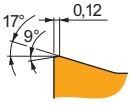
SNGX 11

PRAMET

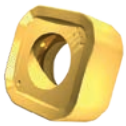
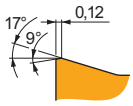
	IC (mm)	D1 (mm)	S (mm)
1104	10.600	4.56	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

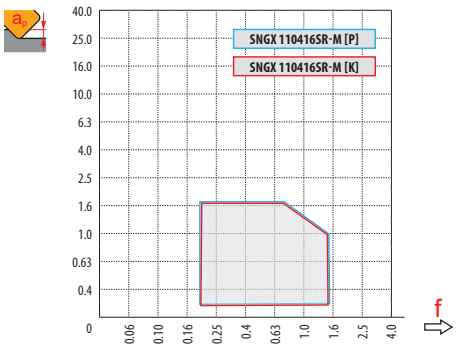
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
M 型，具有正前角设计，适用于快进给。																				
SNGX 110416SR-M:8215		1.6	260	0.60	1.0	–	–	–	245	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M8310		1.6	275	0.60	1.0	–	–	–	260	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M8330		1.6	260	0.60	1.0	–	–	–	245	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M8340		1.6	245	0.60	1.0	–	–	–	230	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M9325		1.6	305	0.60	1.0	–	–	–	285	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M9340		1.6	270	0.60	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
MM 型，具有大正前角设计，适用于快进给。																				
SNGX 110416SR-MM:M6330		1.6	175	0.60	1.0	125	0.54	1.0	–	–	–	–	–	–	50	0.42	0.8	–	–	–
SNGX 110416SR-MM:M8340		1.6	190	0.60	1.0	110	0.54	1.0	–	–	–	–	–	–	45	0.42	0.8	–	–	–
SNGX 110416SR-MM:M8345		1.6	150	0.60	1.0	90	0.54	1.0	–	–	–	–	–	–	35	0.42	0.8	–	–	–
SNGX 110416SR-MM:M9340		1.6	210	0.60	1.0	125	0.54	1.0	–	–	–	–	–	–	50	0.42	0.8	–	–	–
																				
HM 型，具有强壮的设计，适用于快进给。																				
SNGX 110416SR-HM:8215		1.6	230	1.00	1.0	–	–	–	215	1.00	1.0	–	–	–	–	–	–	45	0.70	0.7
SNGX 110416SR-HM:M8310		1.6	240	1.00	1.0	–	–	–	225	1.00	1.0	–	–	–	–	–	–	45	0.70	0.7

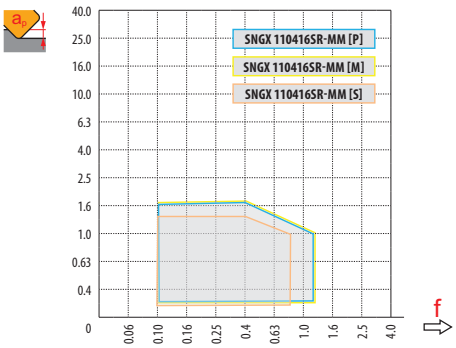
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

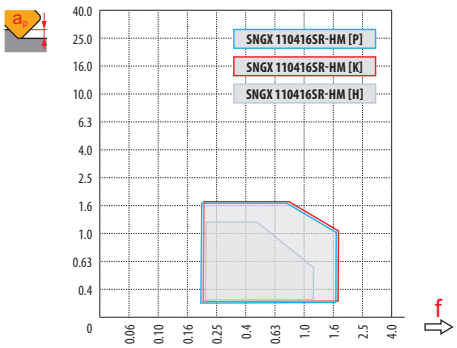
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  HFC S **HM 型，具有强壮的设计，适用于快进给。**																				
SNGX 110416SR-HM:M8330		1.6	235	1.00	1.0	–	–	–	220	1.00	1.0	–	–	–	–	–	–	45	0.70	0.7
SNGX 110416SR-HM:M9325		1.6	260	1.00	1.0	–	–	–	245	1.00	1.0	–	–	–	–	–	–	50	0.70	0.7

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SNGX 11 - M	SNGX 11 - MM	SNGX 11 - HM
RE	1.6	1.6	1.6
BS	–	–	–







HFC

DCX	a_p	0.00	0.20	0.40	0.60	0.80	1.00	1.10	1.20	1.30	1.40	1.50	1.60	1.70
32	DEF	18.30	19.53	20.76	21.99	23.22	24.46	25.07	25.69	26.30	26.92	27.53	28.15	28.76
35		21.20	22.43	23.66	24.89	26.12	27.36	27.97	28.59	29.20	29.82	30.43	31.05	31.66
40		26.20	27.43	28.66	29.89	31.12	32.36	32.97	33.59	34.20	34.82	35.43	36.05	36.66
42		28.20	29.43	30.66	31.89	33.12	34.36	34.97	35.59	36.20	36.82	37.43	38.05	38.66
50		36.10	37.33	38.56	39.79	41.02	42.26	42.87	43.49	44.10	44.72	45.33	45.95	46.56
52		38.10	39.33	40.56	41.79	43.02	44.26	44.87	45.49	46.10	46.72	47.33	47.95	48.56
63		49.10	50.33	51.56	52.79	54.02	55.26	55.87	56.49	57.10	57.72	58.33	58.95	59.56
66		52.10	53.33	54.56	55.79	57.02	58.26	58.87	59.49	60.10	60.72	61.33	61.95	62.56
80		66.10	67.33	68.56	69.79	71.02	72.26	72.87	73.49	74.10	74.72	75.33	75.95	76.56
100		86.10	87.33	88.56	89.79	91.02	92.26	92.87	93.49	94.10	94.72	95.33	95.95	96.56
115		101.10	102.33	103.56	104.79	106.02	107.26	107.87	108.49	109.10	109.72	110.33	110.95	111.56
125		111.10	112.33	113.56	114.79	116.02	117.26	117.87	118.49	119.10	119.72	120.33	120.95	121.56
	a_p	–	0.20	0.40	0.60	0.80	1.00	1.10	1.20	1.30	1.40	1.50	1.60	1.70
	⇨ f	–	1.37	0.98	0.81	0.71	0.64	0.62	0.59	0.58	0.56	0.54	0.53	0.52

SNGX		
DCX	$a_{e\,max}$	f_{max}
32	5.0	0.25
35	5.0	0.25
40	5.2	0.30
42	5.2	0.30
50	5.3	0.30
52	5.3	0.30
63	5.4	0.30
66	5.4	0.30
80	5.5	0.35
100	5.5	0.35
115	5.5	0.35
125	5.5	0.35

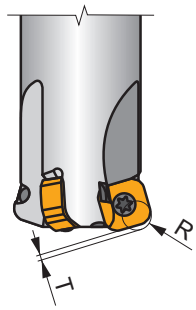
SNGX (HFC)		
DCX	RPMX	APMX/l
32	0.8	1.4/100
35	0.8	1.4/100
40	0.7	1.2/100
42	0.7	1.2/100
50	0.5	0.9/100
52	0.5	0.9/100
63	0.4	0.7/100
66	0.4	0.7/100
80	0.3	0.5/100
100	0.2	0.3/100
115	0.2	0.3/100
125	0.2	0.3/100

SNGX (HFC)		
DCX	a_p	f_{max}
32	0.2	0.3
35	0.2	0.3
40	0.2	0.3
42	0.2	0.3
50	0.3	0.4
52	0.3	0.4
63	0.3	0.4
66	0.3	0.4
80	0.3	0.4
100	0.3	0.4
115	0.3	0.4
125	0.3	0.4

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
115		1.175	1.517	2.145	2.627	3.033	3.715	4.290	4.796	5.254	6.066	6.782
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071

	SNGX			
a_p	0.2	0.5	1.0	1.7
1 f	1.20	1.00	0.50	0.25

SNGX (HFC)				
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	48.0	63.8	0.7	1.4
35	54.0	69.8	0.8	1.5
40	64.0	79.8	0.9	1.5
42	68.0	83.8	1.0	1.6
50	84.0	99.8	0.9	1.4
52	88.0	103.8	1.0	1.4
63	109.0	125.8	1.0	1.4
66	115.0	131.8	1.1	1.4
80	143.0	159.8	1.0	1.3
100	183.0	199.8	0.9	1.1
115	213.0	229.8	1.1	1.3
125	233.0	249.8	1.2	1.4



SNGX	R	T
SNGX 110416	4.6	0.92

可转位铣刀 – 导航工具

平面铣

	SSO12	SPD09	SZD07	SZD09	SZD12
	12°	19°	–	–	–
	APMX (mm) 1.9	APMX (mm) 2.0	APMX (mm) 1.0	APMX (mm) 1.0	APMX (mm) 1.6
	DCX (mm) 35 – 125	DCX (mm) 32 – 140	DCX (mm) 16 – 25	DCX (mm) 25 – 63	DCX (mm) 32 – 80
圆柱刀柄	DC = 35, 40 (mm)	DCX = 32, 40 (mm)	DCX = 16 – 25 (mm)		
侧固刀柄	DC = 35, 40 (mm)			DCX = 25, 32 (mm)	
模块式刀柄				DCX = 25, 32 (mm)	DCX = 32, 40 (mm)
套式铣刀	DC = 42 – 125 (mm)	DCX = 42 – 140 (mm)		DCX = 40 – 63 (mm)	DCX = 50 – 80 (mm)
页码	266	270	276	280	284
ISO	P M K N S H	P M K S H	P K H	P K H	P K H
刀片形状					
刀片	SOHT 1205	PD.. 0905	ZDCW 0703	ZDCW 09T3	ZDEW 1204
切削刃数量	4	5	4	4	4
平面铣	■	■	■	■	■
螺旋插补	■	■	◪	◪	◪
浅方肩铣	■	■	◪	◪	◪
插铣	■	■	◪	◪	◪
连续钻铣	■	■	◪	◪	◪
坡走铣	■	■			
形面铣（仿形铣）		◪	◪	◪	◪
浅槽铣	■	◪	◪	◪	◪

■ 推荐使用　◪ 可以使用

SSO12

P M K S H

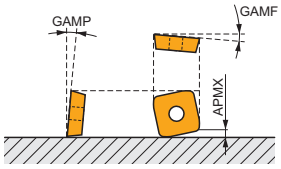
PRAMET

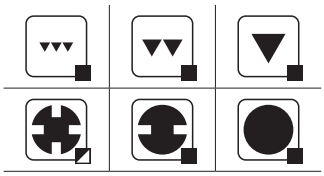
S

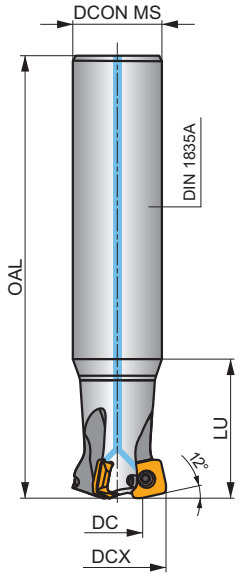
VER SO12 12° 快进给铣削带内冷

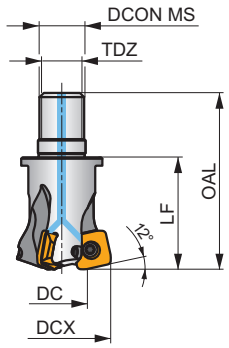
多功能 12° 快进给铣刀，采用单面 SO... 12 型刀片，APMX 为 1.9 mm。适用于大多数工件材料。可提供圆柱柄、模块化和心轴式，不等齿距。有内冷，刀体经过处理，可延长刀具寿命。

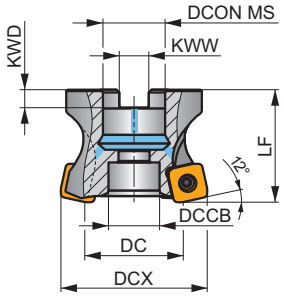
KAPR	12°
APMX	1.9 mm











h_m	0.09-0.93
h_m	0.09-0.93

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	35E3R050A32-SSO12-C	35	17.3	200	32	–	50	–	–	–	–	-5	5	3	–	15700	✓	1.07	GI350	SQ501	–
	35E3R120A32-SSO12-C	35	17.3	200	32	–	120	–	–	–	–	-5	5	3	–	15700	✓	0.95	GI350	SQ501	–
	40E4R120A32-SSO12-C	40	22.3	200	32	–	120	–	–	–	–	-5	5	4	–	14700	✓	1.00	GI350	SQ501	–
MODULAR	35E3R040M16-SSO12-C	35	17.3	63	17	–	–	40	M16	–	–	-5	5	3	–	15700	✓	0.15	GI350	SQ501	–
	40E4R043M16-SSO12-C	40	22.3	66	17	–	–	43	M16	–	–	-5	5	4	–	14700	✓	0.18	GI350	SQ501	–
ISO 6462 DIN 8030	42A04R-SMOSO12-C	42	24.3	–	16	12.4	–	40	–	8.4	5.6	-5	5	4	–	14300	✓	0.16	GI350	SQ502	–
	50A05R-SMOSO12-C	50	32.3	–	22	18.1	–	40	–	10.4	6.3	-5	5	5	✓	13100	✓	0.23	GI350	SQ503	–
	52A05R-SMOSO12-C	52	34.3	–	22	18.1	–	40	–	10.4	6.3	-5	5	5	✓	12800	✓	0.35	GI350	SQ503	–
	63A06R-SMOSO12-C	63	45.3	–	27	22.1	–	50	–	12.4	7	-5	5	6	✓	11700	✓	0.48	GI350	SQ504	–
	66A06R-SMOSO12-C	66	48.3	–	27	22.1	–	50	–	12.4	7	-5	5	6	✓	11400	✓	0.51	GI350	SQ504	–
	80A07R-SMOSO12-C	80	62.3	–	27	22.1	–	50	–	12.4	7	-5	5	7	✓	10400	✓	0.76	GI350	SQ504	–
	100A08R-SMOSO12-C	100	82.3	–	32	45.1	–	50	–	14.4	8	-5	5	8	✓	9300	✓	1.32	GI350	SQ505	AC002
	125A10R-SMOSO12-C	125	107.3	–	40	56.1	–	63	–	16.4	9	-5	5	10	✓	8300	✓	2.46	GI350	SQ505	AC003

GI350	SOHT 1205..

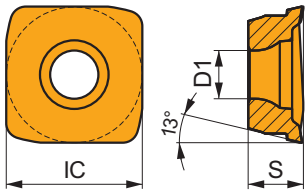
		Nm					
SQ501	US 4011-T15P	3.5	M 4	10.6	FLAG T15P	–	–
SQ502	US 4011-T15P	3.5	M 4	10.6	–	SDR T15P-T	HCS 0840C
SQ503	US 4011-T15P	3.5	M 4	10.6	–	SDR T15P-T	HS 1030C
SQ504	US 4011-T15P	3.5	M 4	10.6	–	SDR T15P-T	HS 1230C
SQ505	US 4011-T15P	3.5	M 4	10.6	–	SDR T15P-T	–

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

SOHT 12

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	4.50	5.15

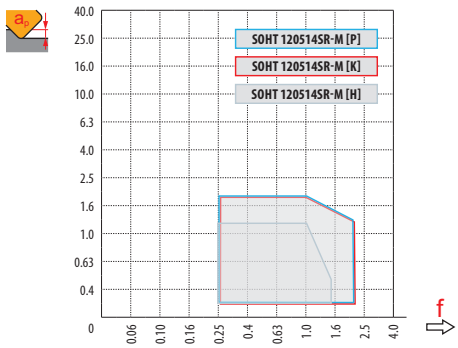


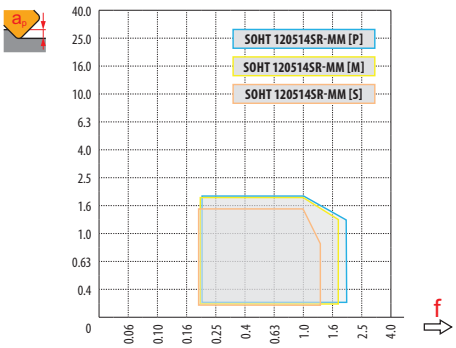
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
M 型槽型用途广泛，适用于多种工况。正前角设计，中等 T-型倒棱和研磨切削刃，可实现平滑的 HFC 铣削。钢、铸铁和淬火钢的首选。																				
SOHT 120514SR-M:8215		1.4	215	1.00	1.0	125	0.90	1.0	200	1.00	1.0	–	–	–	50	0.70	0.8	40	0.68	0.8
SOHT 120514SR-M:M8310		1.4	225	1.00	1.0	110	0.90	1.0	210	1.00	1.0	–	–	–	–	–	–	45	0.68	0.8
SOHT 120514SR-M:M8330		1.4	220	1.00	1.0	130	0.90	1.0	205	1.00	1.0	–	–	–	55	0.70	0.8	40	0.68	0.8
SOHT 120514SR-M:M8340		1.4	205	1.00	1.0	120	0.90	1.0	190	1.00	1.0	–	–	–	50	0.70	0.8	–	–	–
SOHT 120514SR-M:M9325		1.4	245	1.00	1.0	–	–	–	230	1.00	1.0	–	–	–	–	–	–	45	0.68	0.8
SOHT 120514SR-M:M9340		1.4	215	1.00	1.0	125	0.90	1.0	–	–	–	–	–	–	50	0.70	0.8	–	–	–
MM 槽型锋利，适用于大悬伸或薄壁和细长工件。正前角设计，窄 T- 型倒棱和研磨切削刃，可实现平滑的 HFC 铣削。不锈钢和耐热合金的首选。																				
SOHT 120514SR-MM:M6330		1.4	190	1.00	1.0	135	0.90	1.0	–	–	–	–	–	–	55	0.70	0.8	–	–	–
SOHT 120514SR-MM:M8340		1.4	205	1.00	1.0	120	0.90	1.0	–	–	–	–	–	–	50	0.70	0.8	–	–	–
SOHT 120514SR-MM:M8345		1.4	165	1.00	1.0	95	0.90	1.0	–	–	–	–	–	–	40	0.70	0.8	–	–	–
SOHT 120514SR-MM:M9325		1.4	245	1.00	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SOHT 120514SR-MM:M9340		1.4	215	1.00	1.0	125	0.90	1.0	–	–	–	–	–	–	50	0.70	0.8	–	–	–

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SOHT 12-M	SOHT 12-MM
RE	1.4	1.4
BS	2.00	2.00





HFC

DCX	a_p	0.00	0.20	0.40	0.60	0.80	1.00	1.20	1.40	1.50	1.60	1.70	1.80	1.90
35	DEF	17.3	19.2	21.1	22.9	24.8	26.7	28.6	30.5	31.4	32.4	33.1	33.5	33.9
40		22.3	24.2	26.1	27.9	29.8	31.7	33.6	35.5	36.4	37.4	38.1	38.5	38.9
42		24.3	26.2	28.1	29.9	31.8	33.7	35.6	37.5	38.4	39.4	40.1	40.5	40.9
50		32.3	34.2	36.1	37.9	39.8	41.7	43.6	45.5	46.4	47.4	48.1	48.5	48.9
52		34.3	36.2	38.1	39.9	41.8	43.7	45.6	47.5	48.4	49.4	50.1	50.5	50.9
63		45.3	47.2	49.1	50.9	52.8	54.7	56.6	58.5	59.4	60.4	61.1	61.5	61.9
66		48.3	50.2	52.1	53.9	55.8	57.7	59.6	61.5	62.4	63.4	64.1	64.5	64.9
80		62.3	64.2	66.1	67.9	69.8	71.7	73.6	75.5	76.4	77.4	78.1	78.5	78.9
100		82.3	84.2	86.1	87.9	89.8	91.7	93.6	95.5	96.4	97.4	98.1	98.5	98.9
125		107.3	109.2	111.1	112.9	114.8	116.7	118.6	120.5	121.4	122.4	123.1	123.5	123.9
	a_p	0.00	0.20	0.40	0.60	0.80	1.00	1.20	1.40	1.50	1.60	1.70	1.80	1.90
	1 ⇨ f	-	2.20	2.00	1.80	1.60	1.40	1.20	1.10	1.00	0.90	0.80	0.70	0.60

DCX	a_{emax}	f_{max}
35	10.0	0.10
40	10.0	0.10
42	10.0	0.12
50	10.0	0.12
52	10.0	0.12
63	10.0	0.15
66	10.0	0.15
80	10.0	0.20
100	10.0	0.20
125	10.0	0.20

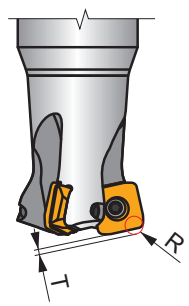
DCX	RPMX	APMX/I
35	9.6	1.9/11
40	6.9	1.9/16
42	6.1	1.9/18
50	4.3	1.9/25
52	4.0	1.9/27
63	2.6	1.9/41
66	2.5	1.9/44
80	1.9	1.9/59
100	1.4	1.9/79
125	1.0	1.9/105

DCX	a_p	f_{max}
35	1.6	0.17
40	1.6	0.17
42	1.6	0.15
50	1.6	0.10
52	1.6	0.10
63	1.6	0.05
66	1.6	0.05
80	1.6	0.05
100	1.6	0.05
125	1.6	0.05

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
35	FE	0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071

a_p	0.2	0.6	1.0	1.5	1.9
1 f	2.0	1.6	1.2	0.8	0.5

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
35	46.0	69.8	1.9	1.9
40	56.0	79.8	1.9	1.9
42	60.0	83.8	1.9	1.9
50	76.0	99.8	1.9	1.9
52	80.0	103.8	1.9	1.9
63	102.0	125.8	1.9	1.9
66	108.0	131.8	1.9	1.9
80	136.0	159.8	1.9	1.9
100	176.0	199.8	1.9	1.9
125	226.0	249.8	1.9	1.9



SOHT	R	T
SOHT 120514	3.37	1.21

SPD09

P M K S H

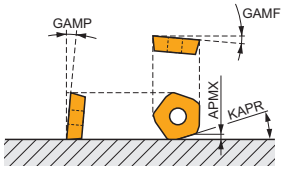
PRAMET

S

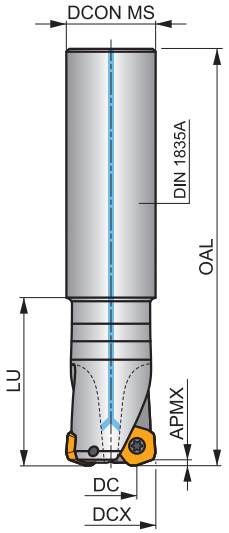
PENTA HF快进给刀盘，带内冷

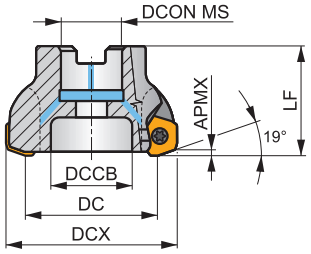
富有成效的快进给铣刀盘，使用单面正前角PD.. 09刀片，具有5个切削刃和APMX(最大切深)2mm。内冷。应用范围广泛。可提供圆柱直柄和心轴式类型。刀体经过处理，使用寿命更长。

KAPR	19°
APMX	2.0 mm



PENTA HF





h_m	0.065 - 0.975
h_m	0.065 - 0.975

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	32E2R060A32-SPD09-C	32	18.4	250	32	–	60	–	-24	10	2	–	13100	✓	1.34	GI245	CO340	–
	40E3R060A32-SPD09-C	40	25.5	250	32	–	60	–	-11	10	3	–	11700	✓	1.43	GI245	CO340	–
	42A03R-S19PD09-C	42	27.5	–	16	12	–	40	-8	10	3	–	11500	✓	0.18	GI245	CO342	–
	50A04R-S19PD09-C	50	35.3	–	22	18	–	40	-3	10	4	–	10500	✓	0.23	GI245	CO343	–
	50A05R-S19PD09-C	50	35.3	–	22	18	–	40	-3	10	5	–	10500	✓	0.33	GI245	CO343	–
	52A04R-S19PD09-C	52	37.3	–	22	18	–	40	-3	10	4	–	10300	✓	0.25	GI245	CO343	–
	63A05R-S19PD09-C	63	48.2	–	22	18	–	40	-1	10	5	–	9400	✓	0.44	GI245	CO343	–
	63A06R-S19PD09-C	63	48.2	–	22	18	–	40	-1	10	6	–	9300	✓	0.45	GI245	CO343	–
	66A06R-S19PD09-C	66	51.2	–	22	18	–	40	-1	10	6	–	9200	✓	0.35	GI245	CO343	–
ISO 6462 DIN 8030	66A06R-S19PD09-CF	66	51.2	–	27	22	–	50	-1	10	6	–	9100	✓	0.67	GI245	CO344	–
	80A05R-S19PD09-C	80	65.3	–	27	37	–	50	-1	10	5	–	8300	✓	0.84	GI245	CO341	AC001
	80A06R-S19PD09-C	80	65.3	–	27	37	–	50	-1	10	6	–	8300	✓	0.86	GI245	CO341	AC001
	100A06R-S19PD09-C	100	58.3	–	32	45	–	50	-1	10	6	–	7400	✓	1.46	GI245	CO341	AC002
	100A08R-S19PD09-C	100	85.3	–	32	45	–	50	-1	10	8	–	7400	✓	1.40	GI245	CO341	AC002
	125A08R-S19PD09-C	125	110.3	–	40	36	–	63	-1	10	8	–	6600	✓	3.10	GI245	CO349	–
	125A10R-S19PD09-C	125	110.3	–	40	36	–	63	-1	10	10	–	6600	✓	3.11	GI245	CO349	–
	140A08R-S19PD09-C	140	125.3	–	40	36	–	63	-1	10	8	–	6200	✓	3.57	GI245	CO349	–

GI245	PD.X 0905ZE..	PDKT 0905..	PDMW 0905..

		Nm					
CO340	US 45011-T20P	5.0	M 5	11	–	–	Flag T20P
CO341	US 45011-T20P	5.0	M 5	11	SDR T20P-T	–	–

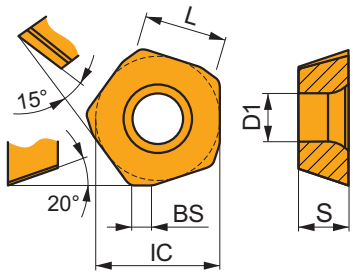
		Nm					
C0342	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HS 90835	–
C0343	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HS 1030C	–
C0344	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HS 1230C	–
C0349	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HSD 2040	–

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32

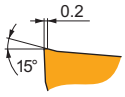
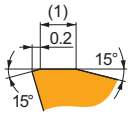
PDMX 09

PRAMET

	BS (mm)	IC (mm)	D1 (mm)	L (mm)	S (mm)
0905	2.00	13.500	5.50	9.00	5.47



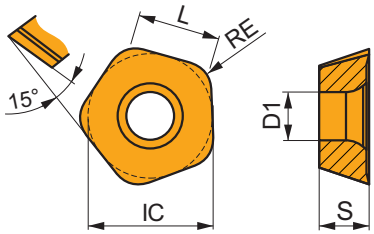
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
M 型，具有正前角设计，适用于中等快进给。																				
PDMX 0905ZEER-M:8215		–	215	1.00	1.2	125	0.90	1.2	200	1.00	1.2	–	–	–	–	–	–	–	–	–
PDMX 0905ZEER-M:M8330		–	220	1.00	1.2	130	0.90	1.2	205	1.00	1.2	–	–	–	–	–	–	–	–	–
PDMX 0905ZEER-M:M8345		–	165	1.00	1.2	95	0.90	1.2	–	–	–	–	–	–	–	–	–	–	–	–
PDMX 0905ZEER-M:M9340		–	215	1.00	1.2	125	0.90	1.2	–	–	–	–	–	–	–	–	–	–	–	–
																				
R 型，具有强壮的设计，适用于快进给。																				
PDMX 0905ZESR-R:8215		–	215	1.00	1.3	–	–	–	200	1.00	1.3	–	–	–	–	–	–	40	0.70	0.9
PDMX 0905ZESR-R:M8330		–	215	1.00	1.3	–	–	–	200	1.00	1.3	–	–	–	–	–	–	40	0.70	0.9
PDMX 0905ZESR-R:M8345		–	165	1.00	1.3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
PDMX 0905ZESR-R:M9325		–	245	1.00	1.3	–	–	–	230	1.00	1.3	–	–	–	–	–	–	45	0.70	0.9

PDKT 09

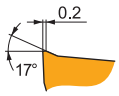
PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0905	13.500	5.50	9.00	5.47



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
PDKT 090530ER-FM:8215		3.0	240	1.00	1.2	140	0.90	1.2	225	1.00	1.2	–	–	–	60	0.70	1.0	–	–	–
PDKT 090530ER-FM:M6330		3.0	210	1.00	1.2	150	0.90	1.2	–	–	–	–	–	–	60	0.70	1.0	–	–	–
PDKT 090530ER-FM:M8310		3.0	250	1.00	1.2	125	0.90	1.2	235	1.00	1.2	–	–	–	–	–	–	–	–	–
PDKT 090530ER-FM:M8330		3.0	245	1.00	1.2	145	0.90	1.2	230	1.00	1.2	–	–	–	60	0.70	1.0	–	–	–
PDKT 090530ER-FM:M8345		3.0	180	1.00	1.2	105	0.90	1.2	–	–	–	–	–	–	45	0.70	1.0	–	–	–
PDKT 090530ER-FM:M9325		3.0	275	1.00	1.2	–	–	–	260	1.00	1.2	–	–	–	–	–	–	–	–	–

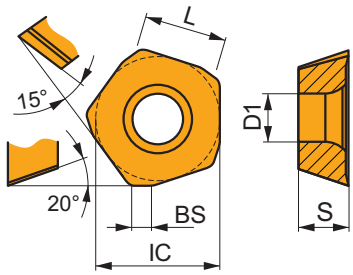


FM 型，具有大正前角设计，适用于轻载到中等快进给。

PDKX 09

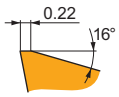
PRAMET

	BS (mm)	IC (mm)	D1 (mm)	L (mm)	S (mm)
0905	2.00	13.500	5.50	9.00	5.47



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
PDKX 0905ZEER-FM:M6330		–	195	1.00	1.2	135	0.90	1.2	–	–	–	–	–	–	55	0.70	1.0	–	–	–
PDKX 0905ZEER-FM:M8345		–	165	1.00	1.2	95	0.90	1.2	–	–	–	–	–	–	40	0.70	1.0	–	–	–
PDKX 0905ZEER-FM:M9340		–	215	1.00	1.2	125	0.90	1.2	–	–	–	–	–	–	50	0.70	1.0	–	–	–

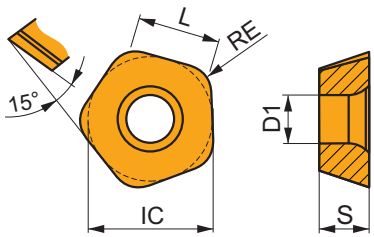


FM 型，具有大正前角设计，适用于中等快进给。

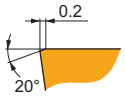
PDMW 09

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0905	13.500	5.50	9.00	5.47

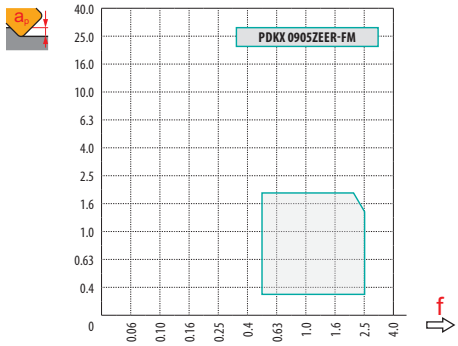


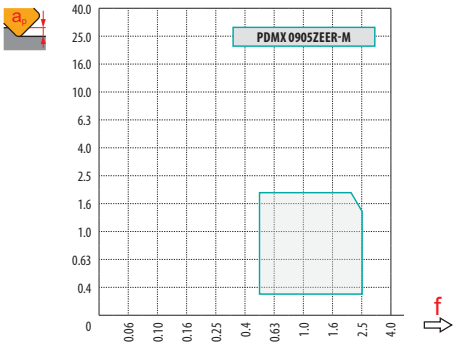
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

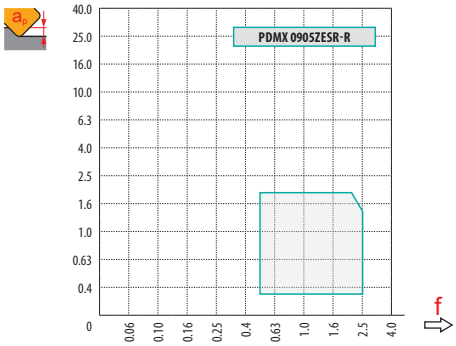
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
SR 平板设计，适用于快进给。																				
PDMW 090530SR:M8310	✱	3.0	245	1.00	1.4	–	–	–	230	1.00	1.4	–	–	–	–	–	–	45	0.70	1.0
PDMW 090530SR:M8345	✱	3.0	180	1.00	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
PDMW 090530SR:M9325	✱	3.0	270	1.00	1.4	–	–	–	255	1.00	1.4	–	–	–	–	–	–	50	0.70	1.0

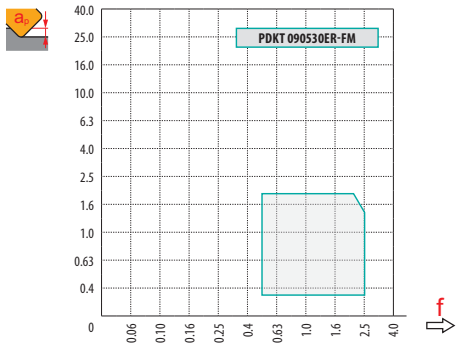
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

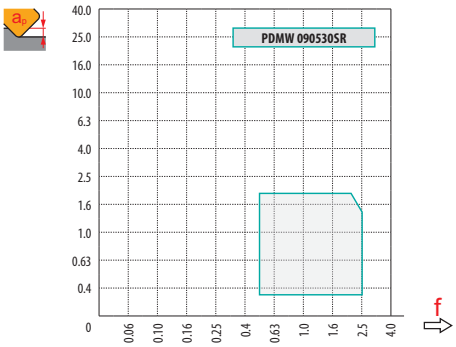
	PDKX 09-FM	PDMX 09-M	PDMX 09-R	PDKT 09-FM	PDMW 09
RE	–	–	–	3.0	3.0
BS	2.00	2.00	2.00	–	–











DCX	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.25	1.50	2.00
32	DEF	18.4	20.1	20.7	21.3	21.9	22.5	23.0	23.6	24.2	25.7	27.1	30.0
40		25.5	27.2	27.8	28.4	29.0	29.6	30.1	30.7	31.3	32.8	34.2	37.1
42		27.5	29.2	29.8	30.4	31.0	31.6	32.1	32.7	33.3	34.8	36.2	39.1
50		35.3	37.0	37.6	38.2	38.8	39.4	39.9	40.5	41.1	42.6	44.0	46.9
52		37.3	39.0	39.6	40.2	40.8	41.4	41.9	42.5	43.1	44.6	46.0	48.9
63		48.2	49.9	50.5	51.1	51.7	52.3	52.8	53.4	54.0	55.5	56.9	59.8
66		51.2	52.9	53.5	54.1	54.7	55.3	55.8	56.4	57.0	58.5	59.9	62.8
80		65.3	67.0	67.6	68.2	68.8	69.4	69.9	70.5	71.1	72.6	74.0	76.9
100		85.3	87.0	87.6	88.2	88.8	89.4	89.9	90.5	91.1	92.6	94.0	96.9
125		110.3	112.3	112.9	113.5	114.1	114.6	115.2	115.8	116.4	117.9	119.3	122.2
140		125.3	127.3	127.9	128.5	129.1	129.7	130.2	130.8	131.4	132.9	134.3	137.2
	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.25	1.50	2.00
	1 ⇨ f	–	3.00	3.00	2.90	2.80	2.70	2.60	2.50	2.40	2.25	1.50	1.50

说明用于面铣，如果铣削接近立壁，降低每齿进给(f_z)至50%，以防止刃口振动和损坏.

DCX	max	f_{max}
32	5.0	0.20
40	5.0	0.20
42	5.0	0.20
50	6.0	0.20
52	6.0	0.20
63	7.0	0.25
66	7.0	0.25
80	8.0	0.30
100	8.0	0.30

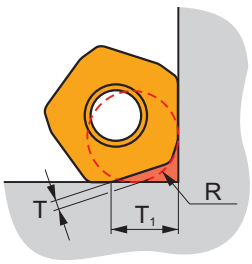
DCX	RPMX	APMX/l
40	8.0	1.80/16
42	8.0	2.00/16
50	8.0	2.00/16
52	8.0	2.00/16
63	7.0	2.00/18
66	6.0	2.00/21
80	5.0	2.00/24
100	3.0	2.00/40

	HFC		
a_p	0.5	1.0	2.0
1 f	3.0	2.3	1.5

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
40	63.7	80.0	2.00	2.00
42	67.5	84.0	2.00	2.00
50	83.3	100.0	2.00	2.00
52	87.3	104.0	2.00	2.00
63	109.2	126.0	2.00	2.00
66	115.2	132.0	2.00	2.00
80	143.3	160.0	2.00	2.00
100	183.3	200.0	2.00	2.00

DCX	a_p	f_{max}
32	1.8	0.20
40	1.8	0.20
42	2.0	0.20
50	2.0	0.20
52	2.0	0.20
63	2.0	0.25
66	2.0	0.25
80	2.0	0.30
100	2.0	0.30

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657



DCX	R	T	T_1
32	4.5	1.1	6.8
40 – 140	4.5	1.1	7.3

SZD07

P K H

PRAMET

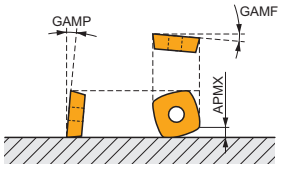
S

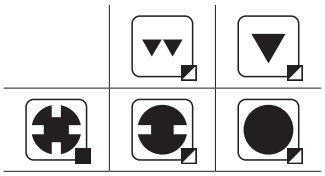
FEED ZD07快进给刀盘，带内冷

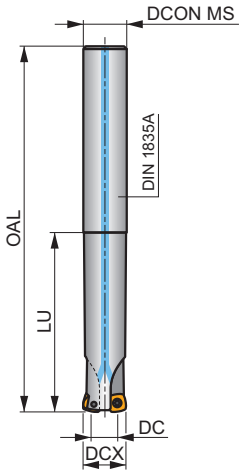
富有成效的快进给铣刀盘，使用单面ZD.. 07刀片，具有4个切削刃和aPMX(最大切深)1mm。内冷。应用范围广泛。可提供圆柱直柄和模块夹紧系统类型。刀体经过处理，使用寿命更长。

FEED ZD

APMX	1.0 mm







h_m 0.175 - 0.44

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	16E2R030A16-SZD07	16	6	100	16	30	–	-5	8	2	–	47400	✓	0.13	GI201	CO350
	16E2R065A16-SZD07	16	6	145	16	65	–	-5	8	2	–	47400	✓	0.22	GI201	CO350
	20E3R040A20-SZD07	20	10	120	20	40	–	-5	8	3	–	42400	✓	0.25	GI201	CO350
	20E3R080A20-SZD07	20	10	165	20	80	–	-5	8	3	–	42400	✓	0.33	GI201	CO350
	25E3R050A25-SZD07	25	15	140	25	50	–	-5	8	3	–	37900	✓	0.47	GI201	CO350
	25E3R100A25-SZD07	25	15	190	25	100	–	-5	8	3	–	37900	✓	0.60	GI201	CO350

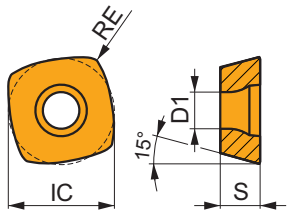
GI201	ZDCW 0703..

CO350	US 2205-T07P	0.9 Nm	M 2.2	5	Flag T07P

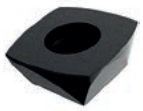
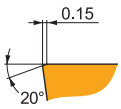
ZDCW 07

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0703	6.800	2.60	3.18



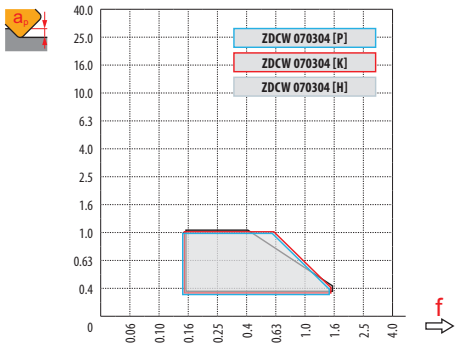
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ZDCW 070304:M8310		0.4	420	0.60	0.4	–	–	–	395	0.60	0.4	–	–	–	–	–	–	80	0.42	0.3
ZDCW 070304:M8325		0.4	325	0.60	0.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZDCW 070304:M8345		0.4	305	0.60	0.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

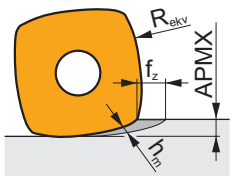
ZDCW 非标槽型，适用于快进给。

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ZDCW 07
RE	0.4
BS	–



DCX	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
16	DEF	6.0	12.0	12.9	13.7	14.4	15.1	15.7	16.2	16.8
20		10.0	16.0	16.9	17.7	18.4	19.1	19.7	20.2	20.8
25		15.0	21.0	21.9	22.7	23.4	24.1	24.7	25.2	25.8
	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
	1 ⇨ f	–	1.50	1.50	1.13	1.00	0.88	0.75	0.61	0.60



$$f_z = h_m \times \sqrt{\frac{2R_{ekv.}}{APMX}}$$ (每齿进给)

说明用于面铣，如果铣削接近立壁，降低每齿进给(f_z)至50%，以防止刃口振动和损坏.

DCX	max	f_{max}
16	5.6	0.12
20	5.6	0.15
25	5.6	0.17

HFC			
a_p	0.3	0.6	1.0
1 ⇨ f	1.50	0.80	0.40

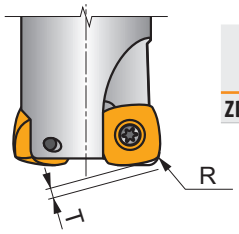
DCX	RPMX	APMX/l
16	7.8	1.0/9
20	9.7	1.0/7
25	4.9	1.0/13

HFC		
DCX	RPMX	APMX/l
16	0.5	0.75/100
20	0.3	0.40/100
25	0.2	0.20/100

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	21.0	32.0	0.10	0.40
20	29.0	40.0	0.10	0.30
25	39.0	50.0	0.15	0.25

DCX	a_p	f_{max}
16	0.05	0.12
20	0.05	0.15
25	0.05	0.17

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162



	R	T
ZDCW 070304	1.70	0.60

SZD09

P K H

PRAMET

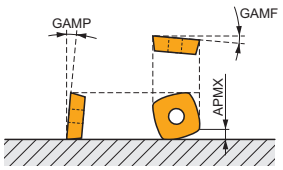
S

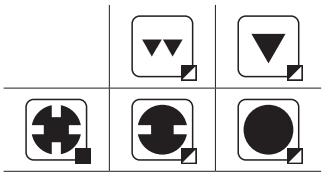
FEED ZD09快进给刀盘，带内冷

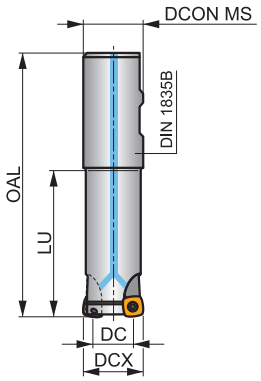
富有成效的快进给铣刀盘，使用单面ZD.. 09刀片，具有4个切削刃和APMX(最大切深)1mm。内冷。适用于广泛的应用。可提供圆柱柄，模块夹紧系统和心轴式接口。刀体经过处理，使用寿命更长。

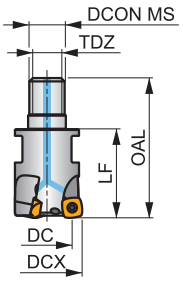
FEED ZD

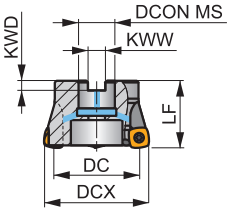
APMX	1.0 mm











h_m	0.31 - 0.618
h_m	0.31 - 0.618

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	25E2R080B25-SZD09-C	25	11.6	140	25	80	–	–	–	–	-6	10	2	–	22800	✓	0.46	GI191	SQ400
	25E2R140B25-SZD09-C	25	11.6	200	25	140	–	–	–	–	-6	10	2	–	22800	✓	0.63	GI191	SQ400
	32E2R080B32-SZD09-C	32	18.7	140	32	80	–	–	–	–	-6	10	2	–	20100	✓	0.76	GI191	SQ400
MODULAR	25E3R032M12-SZD09-C	25	11.6	54	12.5	–	32	M12	–	–	-6	10	3	–	–	✓	0.11	GI191	SQ400
	32E3R040M16-SZD09-C	32	18.7	63	17	–	40	M16	–	–	-6	10	3	–	–	✓	0.21	GI191	SQ400
ISO 6462 DIN 8030	40A04R-SMOZD09-C	40	26.7	–	16	–	40	–	8.4	5.6	-6	10	4	✓	18000	✓	0.34	GI191	SQ402
	50A05R-SMOZD09-C	50	36.7	–	22	–	40	–	10.4	6.4	-6	10	5	✓	16000	✓	0.41	GI191	SQ403
	63A06R-SMOZD09-C	63	49.7	–	22	–	40	–	10.4	6.4	-6	10	6	✓	14300	✓	0.60	GI191	SQ403

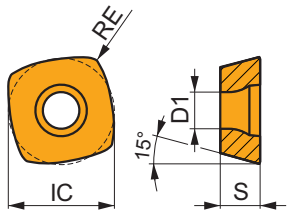
GI191	ZDCW 09T3..

		Nm						
SQ400	US 3006-T09P	2.0	M 3	6	–	–	Flag T09P	–
SQ402	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ403	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	HS 1030C

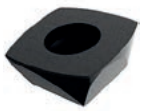
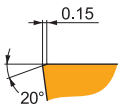
ZDCW 09

PRAMET

	IC (mm)	D1 (mm)	S (mm)
09T3	9.525	3.40	3.97



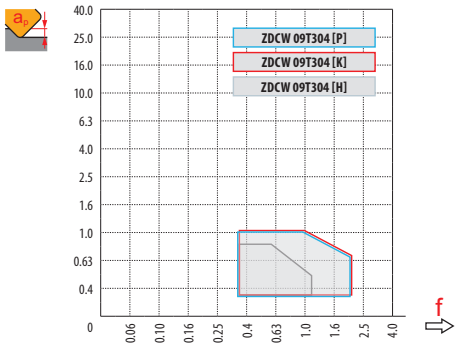
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ZDCW 09T304:M8310		0.4	320	1.00	0.6	–	–	–	300	1.00	0.6	–	–	–	–	–	–	60	0.70	0.4
ZDCW 09T304:M8325		0.4	250	1.00	0.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZDCW 09T304:M8345		0.4	235	1.00	0.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

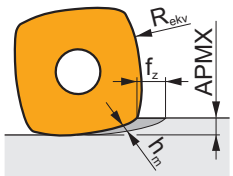
ZDCW 非标槽型，适用于快进给。

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ZDCW 09
RE	0.4
BS	–



DCX	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
25	DEF	11.6	17.4	18.2	19.0	19.7	20.3	20.9	21.5	22.0
32		18.7	24.5	25.3	26.1	26.8	27.4	28.0	28.6	29.1
40		27.7	33.5	34.3	35.1	35.8	36.4	37.0	37.6	38.1
50		36.7	42.3	43.1	43.8	44.5	45.1	45.7	46.2	46.7
63		49.7	55.3	56.1	56.8	57.5	58.1	58.7	59.2	59.7
	a_p	**0.00**	**0.30**	**0.40**	**0.50**	**0.60**	**0.70**	**0.80**	**0.90**	**1.00**
	⇨ f	–	2.00	2.00	2.00	1.75	1.50	1.25	1.13	1.00



$$f_z = h_m \times \sqrt{\frac{2R_{ekv.}}{APMX}}$$ (每齿进给)

说明用于面铣，如果铣削接近立壁，降低每齿进给(f_z)至50%，以防止刃口振动和损坏.

DCX	max	f_{max}
25	7.7	0.15
32	7.7	0.17
40	7.7	0.20

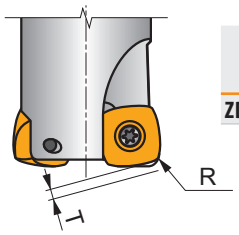
	HFC		
a_p	0.3	0.6	1.0
⇨ f	2.00	1.50	1.00

DCX	RPMX	APMX/l	HFC RPMX	HFC APMX/l
25	12.0	1.0/6	0.9	1.00/65
32	7.5	1.0/11	0.5	0.75/100
40	3.6	1.0/17	0.4	0.55/100

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	35.0	50.0	0.45	1.00
32	49.0	64.0	0.45	0.85
40	65.0	80.0	0.50	0.85

DCX	a_p	f_{max}
25	0.15	0.15
32	0.15	0.17
40	0.15	0.20

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50												
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020



	R	T
ZDCW 09T304	2.27	0.52

SZD12

P K H

PRAMET

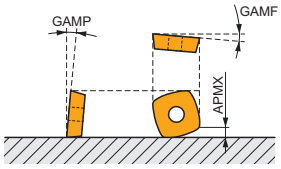
S

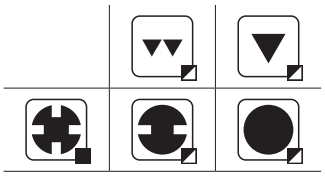
FEED ZD12快进给刀盘，带内冷

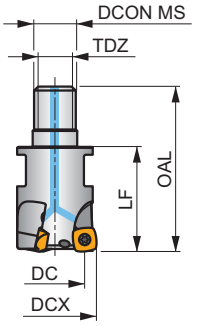
高效富有成效的快进给铣刀盘，使用单面ZD..　12刀片，具有4个切削刃和APMX(最大切深)1.6mm。内冷。应用范围广泛。可提供圆柱柄，模块夹紧系统和心轴接口。刀体经过处理，使用寿命更长。

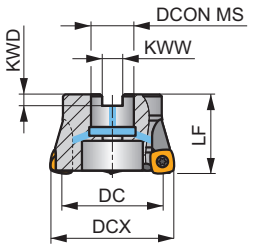
FEED ZD

APMX	1.6 mm









h_m	0.46 - 0.925
h_m	0.46 - 0.925

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
MODULAR	32E3R040M16-SZD12-C	32	14.5	63	17	–	40	M16	–	–	-6	10	3	–	–	✓	0.19	GI192	SQ220	–
MODULAR	40E4R040M16-SZD12-C	40	22.5	63	17	–	40	M16	–	–	-6	10	4	–	–	✓	0.22	GI192	SQ220	–
ISO 6462 DIN 8030	50A04R-SMOZD12-C	50	32.5	–	22	–	40	–	10.4	6.4	-6	10	4	✓	14000	✓	0.38	GI192	SQ033	–
ISO 6462 DIN 8030	63A05R-SMOZD12-C	63	45.5	–	22	–	40	–	10.4	6.4	-6	10	5	✓	12500	✓	0.57	GI192	SQ033	–
ISO 6462 DIN 8030	80A05R-SMOZD12-C	80	62.5	–	27	–	50	–	12	7	-6	10	5	✓	11100	✓	1.07	GI192	CO371	AC001

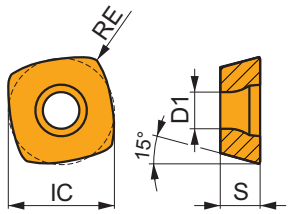
GI192	ZDEW 1204..

		Nm						
CO371	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	–
SQ033	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	HS 1030C
SQ220	US 4011-T15P	3.5	M 4	10.6	–	–	Flag T15P	–

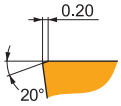
AC001	KS 1230	K.FMH27

ZDEW 12

	IC (mm)	D1 (mm)	S (mm)
1204	12.700	4.40	4.76



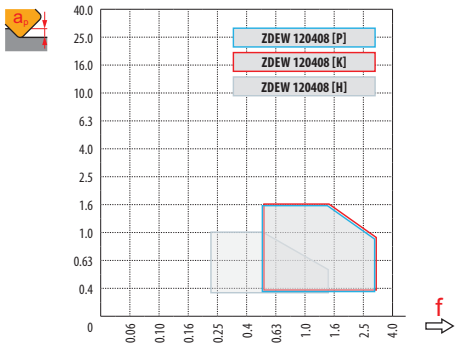
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ZDEW 120408:M8310		0.8	270	1.00	1.0	–	–	–	255	1.00	1.0	–	–	–	–	–	–	50	0.70	0.7
ZDEW 120408:M8325		0.8	205	1.00	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZDEW 120408:M8345		0.8	195	1.00	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

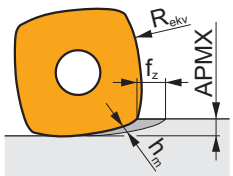
ZDEW 非标槽型，适用于快进给。

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ZDEW 12
RE	0.8
BS	–



DCX	a_p	0.00	0.50	0.60	0.70	0.80	0.90	1.00	1.10	1.20	1.30	1.40	1.50	1.60
32	DEF	14.5	22.7	23.5	24.2	24.8	25.4	26.0	26.5	27.0	27.5	28.0	28.5	28.9
40		22.5	30.7	31.5	32.2	32.8	33.4	34.0	34.5	35.0	35.5	36.0	36.5	36.9
50		32.5	40.7	41.5	42.2	42.8	43.4	44.0	44.5	45.0	45.5	46.0	46.5	46.9
63		45.5	53.7	54.5	55.2	55.8	56.4	57.0	57.5	58.0	58.5	59.0	59.5	59.9
80		62.5	70.7	71.5	72.2	72.8	73.4	74.0	74.5	75.0	75.5	76.0	76.5	76.9
	a_p	0.00	0.50	0.60	0.70	0.80	0.90	1.00	1.10	1.20	1.30	1.40	1.50	1.60
	⇨ f	–	3.00	3.00	3.00	3.00	3.00	3.00	2.50	2.25	2.00	1.80	1.65	1.50



$$f_z = h_m \times \sqrt{\frac{2R_{ekv.}}{APMX}}$$ (每齿进给)

说明用于面铣，如果铣削接近立壁，降低每齿进给(f_z)至50%，以防止刃口振动和损坏.

DCX	max	f_{max}
32	10.0	0.15
40	10.0	0.17
50	10.0	0.20
63	10.0	0.20
80	10.0	0.25

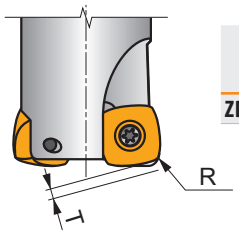
	HFC		
a_p	0.5	1.0	1.6
⇨ f	3.00	2.00	1.50

			HFC	
DCX	RPMX	APMX/l	RPMX	APMX/l
32	10	1.6/11	1.2	1.60/78
40	5.5	1.6/18	0.7	1.10/100
50	3.3	1.6/29	0.5	0.75/100
63	2.2	1.6/43	0.3	0.40/100
80	1.5	1.6/63	0.2	0.20/100

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	44.0	64.0	0.75	1.60
40	60.0	80.0	0.75	1.50
50	80.0	100.0	0.80	1.35
63	106.0	126.0	0.70	1.00
80	140.0	160.0	0.65	0.85

DCX	a_p	f_{max}
32	0.25	0.15
40	0.25	0.17
50	0.25	0.20
63	0.25	0.20
80	0.25	0.25

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657



	R	T
ZDEW 120408	3.52	0.64

倒角

可转位铣刀 – 导航工具

平面铣

	SSD09	N-SSO09	STC	2516	2636	J(T)-SXP16
	45°	45°	45°	45°	10°– 80°	15°– 75°
	APMX (mm) 4.5	APMX (mm) 4.5	APMX (mm) 8.0	APMX (mm) 8.5	APMX (mm) 8.5	APMX (mm) 7.0– 28.0
	DC (mm) 10 – 25	DC (mm) 8 – 25	DC (mm) 20	DC (mm) 11 – 19	DC (mm) 5 – 23	DC (mm) 35 – 45
圆柱刀柄	DC = 16, 25 (mm)					
侧固刀柄	DC = 10 – 25 (mm)					
模块式刀柄	DC = 16, 25 (mm)					
套式铣刀						
页码	292	295	298	301	304	307
ISO	P M K S H	P M K S	P M K N	P M K N	P M K N	P M K N
刀片形状						
刀片	SDE. 0903	SOMT 09T3	TCTX 16 STC	TCMT 16T3	TCMT 16T3	XPHT 1604
切削刃数量	4	4	3	3	3	2
倒角铣	■	■	■	■	■	■

■推荐使用 ◪可以使用

SSD09

P M K S H

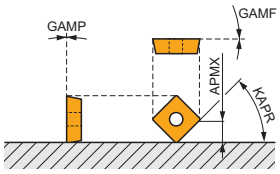
PRAMET

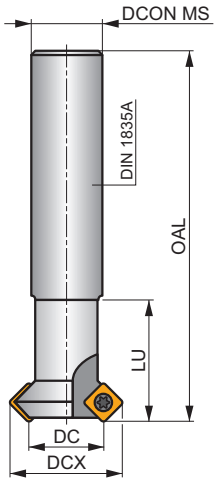
S

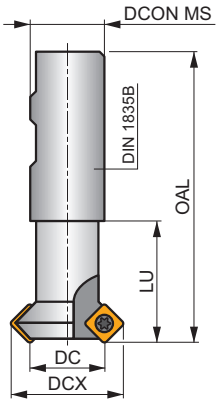
45°倒角铣刀盘，使用正方形刀片SD.. 09

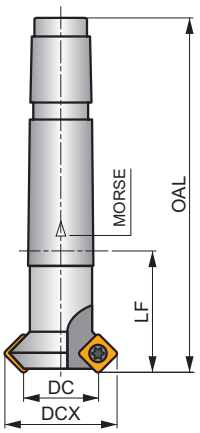
A45°倒角铣刀盘，使用单面SD.. 09刀片，具有APMX(最大切深)4.5mm。适用于顶部和顶部侧边倒角加工。可提供圆柱柄，侧固柄和莫氏锥柄类型。刀体经过处理，使用寿命更长。

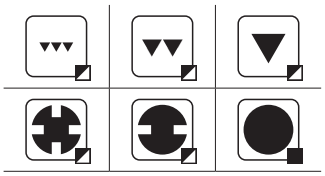
KAPR	45°
APMX	4.5 mm











h_m 0.095 - 0.15

	产品	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	CZC MS	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	16N2R027A16-SSD09	16	28	200	16	27	–	–	0	0	2	–	32200	–	0.34	GI129	C0070
	25N3R042A25-SSD09	25	37	200	25	42	–	–	0	0	3	–	25800	–	0.77	GI129	CH011
DIN 1835B	10N1R027B16-SSD09-A	10	22	75	16	27	–	–	0	0	1	–	40700	–	0.13	GI129	C0070
	16N2R027B16-SSD09-A	16	28	75	16	27	–	–	0	0	2	–	32200	–	0.14	GI129	C0070
	25N3R042B25-SSD09-A	25	37	98	25	42	–	–	0	0	3	–	25800	–	0.37	GI129	CH011
DIN 228A	16N2R030E02-SSD09-A	16	28	94	–	–	30	2	0	0	2	–	32200	–	0.14	GI129	C0070
	25N3R043E03-SSD09-A	25	37	124	–	–	43	3	0	0	3	–	25800	–	0.38	GI129	CH011

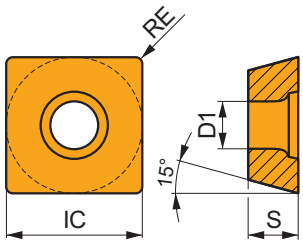
GI129	SDEW 0903..	SDEX 0903..

		Nm			
C0070	US 3507-T15	3.0	M 3.5	7	Flag T15
CH011	US 3509-T15	3.0	M 3.5	9	Flag T15

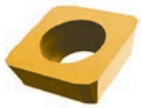
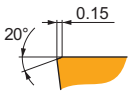
SDEW 09

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0903	9.525	4.40	3.18



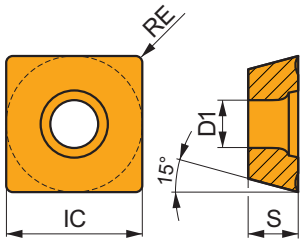
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
EN 型，具有平板设计，适用于45°倒角铣削。																				
SDEW 090308EN:M8330		0.8	235	0.10	4.5	–	–	–	220	0.10	4.5	–	–	–	–	–	–	45	0.09	0.7
SDEW 090308EN:M8340		0.8	210	0.10	4.5	–	–	–	195	0.10	4.5	–	–	–	–	–	–	–	–	–
 																				
SN 型，具有平板设计，适用于45°倒角铣削。																				
SDEW 090308SN:M8330		0.8	215	0.15	4.5	–	–	–	200	0.15	4.5	–	–	–	–	–	–	40	0.11	0.7
SDEW 090308SN:M8340		0.8	195	0.15	4.5	–	–	–	185	0.15	4.5	–	–	–	–	–	–	–	–	–

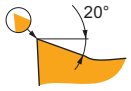
SDEX 09

PRAMET

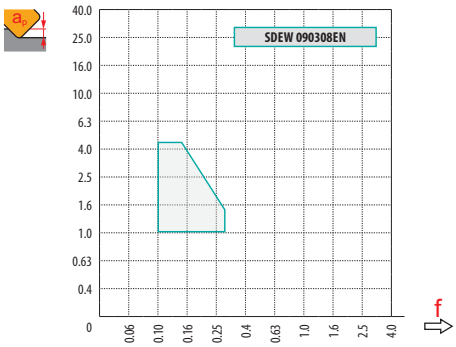
	IC (mm)	D1 (mm)	S (mm)
0903	9.525	4.40	3.18

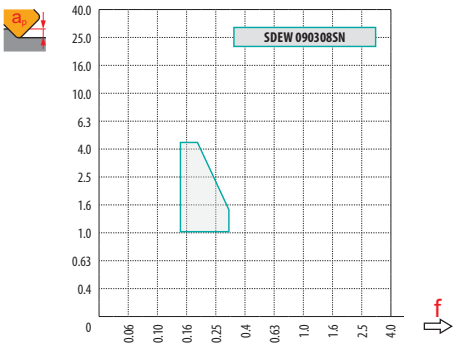


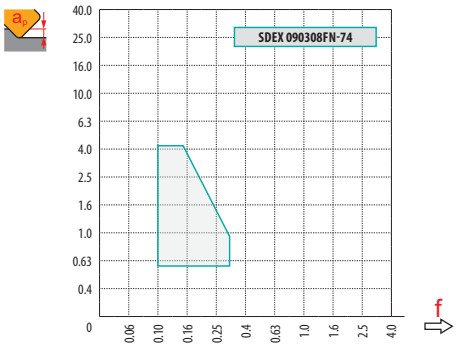
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
74 型，具有正前角设计，适用于45°倒角铣削。																				
SDEX 090308FN-74:M8330		0.8	305	0.12	4.5	180	0.11	4.5	285	0.12	4.5	–	–	–	75	0.11	3.6	–	–	–

	SDEW 09 EN	SDEW 09 SN	SDEX 09-74
RE	0.8	0.8	0.8
BS	–	–	–







DC	DCX	X.V	f_{min}	f_{max}
10	22	1.09	0.20	0.30
16	28	1.17	0.25	0.34
25	37	1.24	0.32	0.39

a_e / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
45°	0.42	0.54	0.67	0.35	0.44	0.55	0.30	0.38	0.47	0.27	0.34	0.42	0.25	0.31	0.39	0.23	0.29	0.36	0.21	0.27	0.34	0.19	0.24	0.30
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

N-SSO09

P M K S

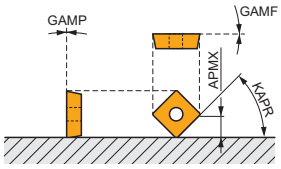
PRAMET

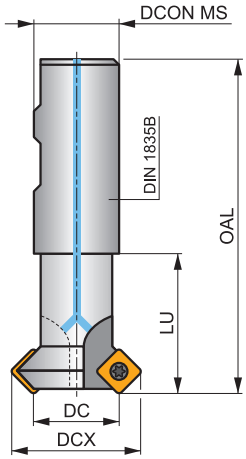
S

45°倒角铣刀盘，使用正方形刀片SOMT 09，带内冷

A45°倒角铣刀盘，使用单面SOMT 09刀片，具有APMX(最大切深)4.5mm。内冷。适用于顶部和顶部侧边倒角加工。可提供侧固柄类型。刀体经过处理，使用寿命更长。

KAPR	45°
APMX	4.5 mm





h_m 0.095 - 0.18

	产品	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	16N2R027B16-SSO09-C	16	28.8	110	16	27	0	0	2	–	26600	✓	0.23	GI146	SQ500
	25N3R042B25-SSO09-C	25	37.8	125	25	42	0	0	3	–	21300	✓	0.49	GI146	SQ500
	8N1R027B16-SSO09-C	8	20.5	90	16	27	0	0	1	–	37700	✓	0.16	GI146	SQ500

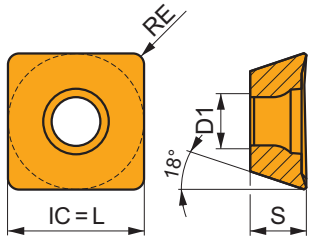
GI146	SOMT 09T3..

SQ500	US 3006-T09P	2.0	M 3	6	Flag T09P

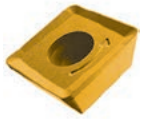
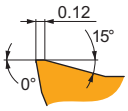
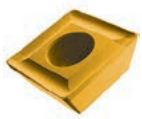
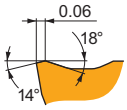
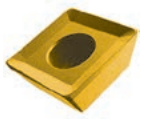
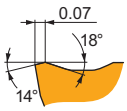
SOMT 09

PRAMET

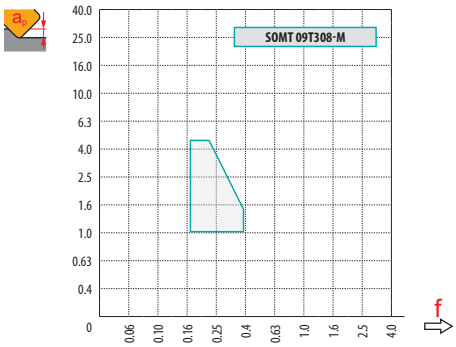
	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.550	3.50	9.55	3.97

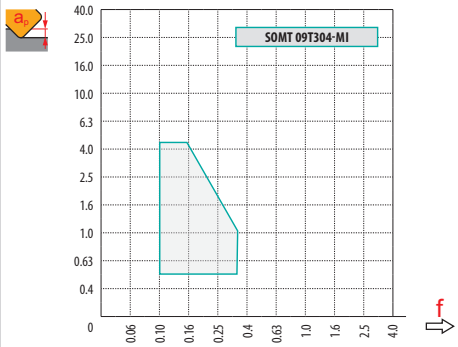


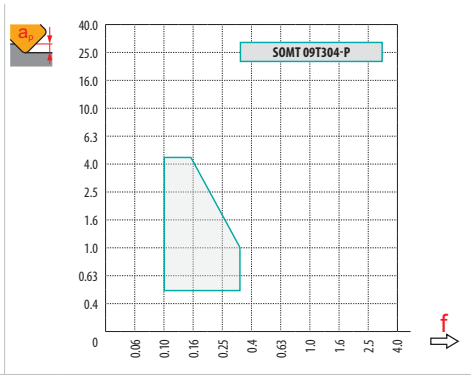
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。当设置角度为90°条件时，参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
M 型，具有正前角设计，适用于中等加工。																				
SOMT 09T308-M:8215		0.8	275	0.14	2.5	165	0.13	2.5	260	0.14	2.5	–	–	–	65	0.13	2.0	–	–	–
SOMT 09T308-M:M5315		0.8	390	0.14	2.5	–	–	–	370	0.14	2.5	–	–	–	–	–	–	–	–	–
SOMT 09T308-M:M8330		0.8	270	0.14	2.5	160	0.13	2.5	255	0.14	2.5	–	–	–	65	0.13	2.0	–	–	–
SOMT 09T308-M:M8340		0.8	250	0.14	2.5	150	0.13	2.5	235	0.14	2.5	–	–	–	60	0.13	2.0	–	–	–
SOMT 09T308-M:M9315		0.8	380	0.14	2.5	–	–	–	360	0.14	2.5	–	–	–	–	–	–	–	–	–
 																				
MI 型，具有稳定的正前角设计，适用于中等加工。																				
SOMT 09T304-MI:8215	●	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	–	–	–	55	0.10	2.0	–	–	–
SOMT 09T304-MI:M8310	●	0.4	255	0.14	2.5	130	0.13	2.5	240	0.14	2.5	–	–	–	–	–	–	–	–	–
SOMT 09T304-MI:M8330	●	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	–	–	–	55	0.10	2.0	–	–	–
SOMT 09T304-MI:M8340		0.4	210	0.14	2.5	125	0.13	2.5	195	0.14	2.5	–	–	–	50	0.10	2.0	–	–	–
SOMT 09T304-MI:M9315	●	0.4	320	0.14	2.5	–	–	–	300	0.14	2.5	–	–	–	–	–	–	–	–	–
SOMT 09T304-MI:M9340	●	0.4	265	0.14	2.5	155	0.13	2.5	–	–	–	–	–	–	65	0.10	2.0	–	–	–
 																				
P 型，具有大正前角设计，适用于中等加工。																				
SOMT 09T304-P:M8330	●	0.4	250	0.14	2.5	150	0.13	2.5	235	0.14	2.5	–	–	–	60	0.10	2.0	–	–	–
SOMT 09T304-P:M8340	●	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	–	–	–	55	0.10	2.0	–	–	–
SOMT 09T304-P:M9325	●	0.4	320	0.14	2.5	–	–	–	300	0.14	2.5	–	–	–	–	–	–	–	–	–

	SOMT 09-M	SOMT 09-MI	SOMT 09-P
RE	0.8	0.4	0.4
BS	–	–	–







DC	DCX	X.V	f_{min}	f_{max}
8	20.5	1.06	0.18	0.29
16	28.8	1.17	0.25	0.34
25	37.8	1.24	0.32	0.39

a_e / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
45°	0.42	0.63	0.80	0.35	0.51	0.66	0.30	0.44	0.57	0.27	0.40	0.51	0.25	0.36	0.46	0.23	0.33	0.43	0.21	0.31	0.40	0.19	0.28	0.36
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

STC

P M K N

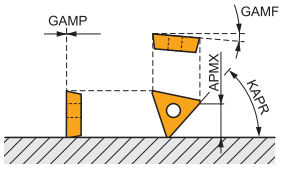
PRAMET

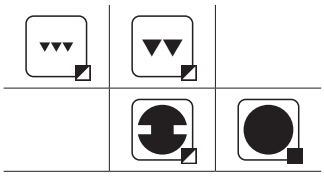
S

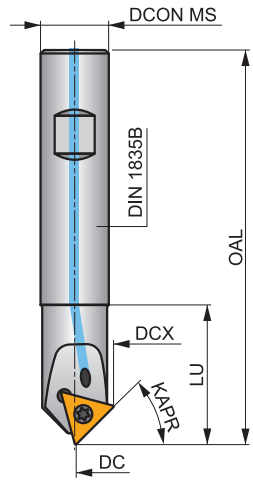
45°倒角和雕刻铣刀，使用TC.T 16刀片，带内冷

45°倒角和雕刻铣刀，使用单面TC.T 16刀片，具有APMX(最大切深)8.5mm。内冷。适用于正面倒角。只提供侧固柄类型。刀体经过处理，使用寿命更长。

KAPR	45°







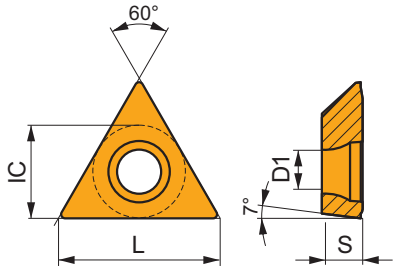
	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)			kg		
DIN 1835B	20N1R040B20-STC-000887	22.8	1.1	114	20	40	1	✓	0.26	GI223	SQ222

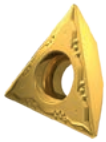
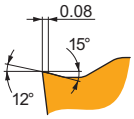
GI223	TC.T 16 STC

SQ222	US 2002-T15P	3.0 Nm	4	8.5	Flag T15P

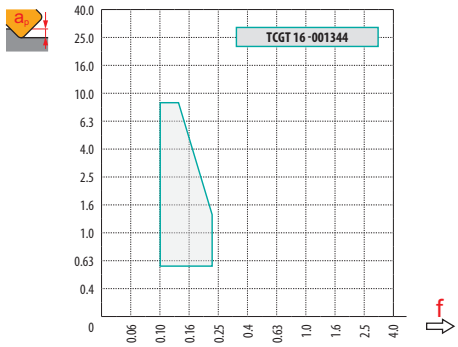
TCXT 16 STC

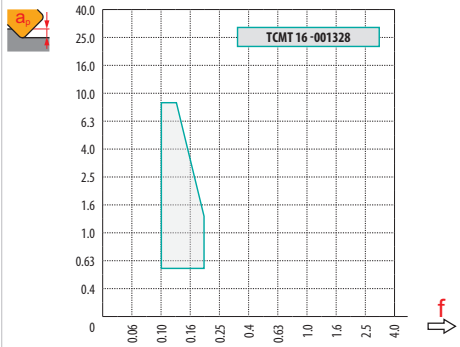
	IC (mm)	D1 (mm)	L (mm)	S (mm)
16	9.525	4.60	16.50	3.97



产品	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  **328** 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。																				
TCMT 16-001328:M8330	–	0.4	■ 150	0.13	8.5	◪ 90	0.12	8.5	◪ 140	0.13	8.5	–	–	–	–	–	–	–	–	–
344 型断屑槽非常锋利，是有色金属合金全方位加工的首选。它具有大正前角，无 T 倒棱。它也有条件地适用于超级合金。																				
TCGT 16-001344:HF7	–	0.4	–	–	–	–	–	–	–	–	–	■ 225	0.10	8.5	–	–	–	–	–	–

	TCGT 16 -001344	TCMT 16 -001328
RE	0.4	0.4
BS	–	–





DC	DCX	X.V	f_{min}	f_{max}
1.1	22.8	1.1	0.1	.018

2516

P M K N

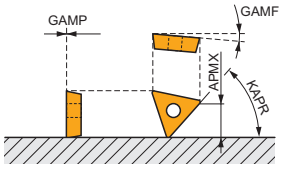
PRAMET

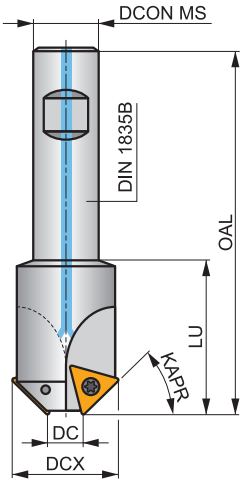
S

45°倒角铣刀盘，使用TCMT 16刀片，带内冷

A45°倒角铣刀盘，使用单面TCMT 16刀片，具有APMX(最大切深)8.5mm。内冷。适用于正面倒角。只提供侧固柄类型。刀体经过处理，使用寿命更长。

KAPR	45°
APMX	8.5 mm





h_m 0.065 - 0.095

	产品	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)			max.		kg		
DIN 1835B	**2516-45-11**	31	11	100	16	30	2	–	18100	✓	0.20	GI155	SQ220
	2516-45-19	39	19	100	20	30	2	–	16200	✓	0.31	GI155	SQ220

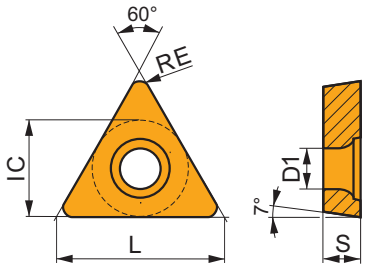
GI155	TCMT 16T308E-FM:T8..

		Nm			
SQ220	US 4011-T15P	3.5	M 4	10.6	Flag T15P

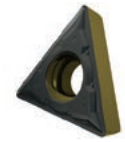
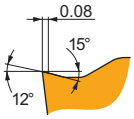
TCMT

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

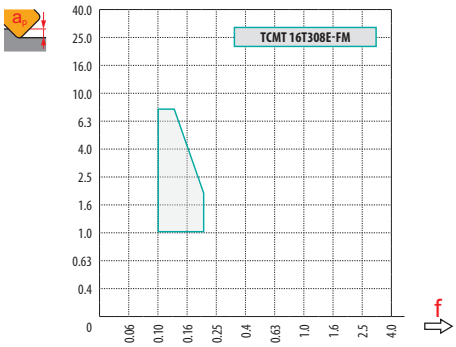


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
TCMT 16T308E-FM:T8315	●	0.8	◪ 170	0.17	1.7	■ 100	0.15	1.7	◪ 160	0.17	1.7	◪ 510	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8415	●	0.8	■ 210	0.17	1.7	■ 110	0.15	1.7	◪ 190	0.17	1.7	◪ 525	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8430	●	0.8	■ 185	0.17	1.7	■ 100	0.15	1.7	◪ 150	0.17	1.7	◪ 510	0.20	1.7	–	–	–	–	–	–

FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。

	TCMT 16-FM
RE	0.8
BS	–



DC	DCX	X.V	f_{min}	f_{max}
11.0	31.0	1.02	0.10	0.18
19.0	39.0	1.10	0.14	0.20

2636

P M K N

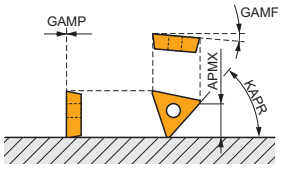
PRAMET

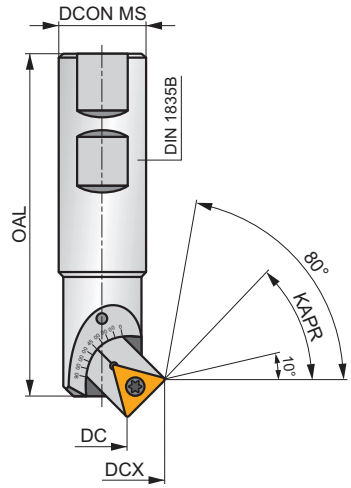
S

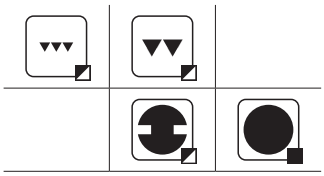
可调节铣刀，使用TCMT 16刀片

可调节倒角铣刀盘，使用TCMT 16刀片，具有APMX(最大切深)8.5mm。可调节角度范围从 10°至80°。只提供侧固柄类型。刀体经过处理，使用寿命更长。

KAPR	10° – 80°
APMX	8.5 mm







h_m 0.03 – 0.08

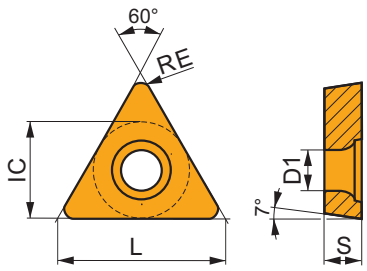
	产品	DCN (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	KAPR (°)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	2636-05-25	5.0	31.0	100	25	10	-8	0	1	–	18100	–	0.35	GI294	CH040
		5.5	31.0			15									
		7.0	29.5			30									
		11.0	29.5			45									
		16.0	28.5			60									
		21.0	26.5			75									
		23.0	26.0			80									

GI294	TCMT 16T304E-FM:T8...	TCMT 16T308E-FM:T8...

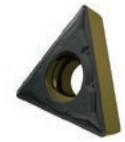
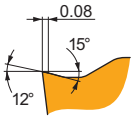
CH040	USI 0614	CA 2669	US 4011-T15P	3.5 Nm	M 4	10.6	Flag T15

TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

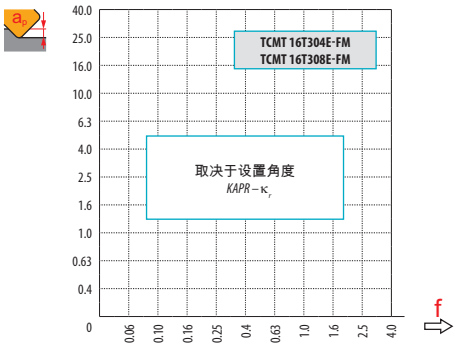


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	●	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
TCMT 16T304E-FM:T8315	●	0.4	◪ 155	0.12	1.7	■ 90	0.11	1.7	◪ 145	0.12	1.7	◪ 465	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T8415	●	0.4	■ 190	0.12	1.7	■ 100	0.11	1.7	◪ 170	0.12	1.7	◪ 480	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T8430	●	0.4	■ 180	0.12	1.7	■ 95	0.11	1.7	◪ 145	0.12	1.7	◪ 495	0.14	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8315	●	0.8	◪ 170	0.17	1.7	■ 100	0.15	1.7	◪ 160	0.17	1.7	◪ 510	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8415	●	0.8	■ 210	0.17	1.7	■ 110	0.15	1.7	◪ 190	0.17	1.7	◪ 525	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8430	●	0.8	■ 185	0.17	1.7	■ 100	0.15	1.7	◪ 150	0.17	1.7	◪ 510	0.20	1.7	–	–	–	–	–	–

FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。

	TCMT 16-FM	
RE	0.8	0.4
BS	–	–



	ap	DC	DCX	X.V	fmin	fmax
10°	2.6	5.0	31.0	1.38	0.24	0.59
15°	3.9	5.5	31.0	1.30	0.17	0.40
30°	7.6	7.0	29.5	1.18	0.10	0.20
45°	10.7	11.0	29.5	1.13	0.09	0.14
60°	13.2	16.0	28.5	1.09	0.09	0.11
75°	14.7	21.0	26.5	1.06	0.09	0.10
80°	15.0	23.0	26.0	1.06	0.09	0.10

ae / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
10°	0.55	0.91	1.46	0.45	0.74	1.19	0.39	0.64	1.03	0.35	0.58	0.92	0.32	0.53	0.84	0.29	0.49	0.78	0.27	0.46	0.73	0.24	0.41	0.65
15°	0.37	0.61	0.98	0.30	0.50	0.80	0.26	0.43	0.69	0.23	0.39	0.62	0.21	0.35	0.56	0.20	0.33	0.52	0.18	0.31	0.49	0.16	0.27	0.44
30°	0.19	0.32	0.51	0.15	0.26	0.41	0.13	0.22	0.36	0.12	0.20	0.32	0.11	0.18	0.29	0.10	0.17	0.27	0.09	0.16	0.25	0.08	0.14	0.23
45°	0.13	0.22	0.36	0.11	0.18	0.29	0.09	0.16	0.25	0.08	0.14	0.23	0.08	0.13	0.21	0.07	0.12	0.19	0.07	0.11	0.18	0.06	0.10	0.16
60°	0.11	0.18	0.29	0.09	0.15	0.24	0.08	0.13	0.21	0.07	0.12	0.18	0.06	0.11	0.17	0.06	0.10	0.16	0.05	0.09	0.15	0.05	0.08	0.13
75°	0.10	0.16	0.26	0.08	0.13	0.21	0.07	0.12	0.19	0.06	0.10	0.17	0.06	0.09	0.15	0.05	0.09	0.14	0.05	0.08	0.13	0.04	0.07	0.12
80°	0.10	0.16	0.26	0.08	0.13	0.21	0.07	0.11	0.18	0.06	0.10	0.16	0.06	0.09	0.15	0.05	0.09	0.14	0.05	0.08	0.13	0.04	0.07	0.11
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

J(T)-SXP16

P M K N

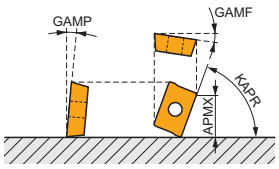
PRAMET

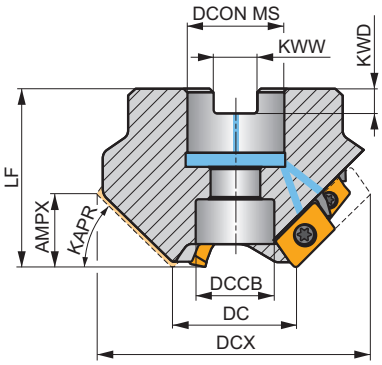
S

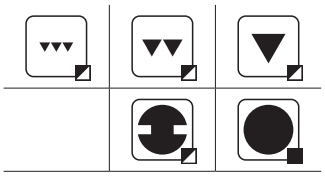
长刃倒角铣刀盘，使用XPHT 16刀片，带内冷

倒角铣刀盘，使用单面XPHT 16刀片，具有APMX(最大切深)从7至28mm。内冷。适用于顶部倒角。只提供芯轴式类型。尺寸范围从15°，25°，30°，35°，40°，45°，50°，55°，60°和75°倒角角度。刀体经过处理，使用寿命更长。

KAPR	15° - 75°
APMX	7.0 - 28.0 mm







h_m 0.05 - 0.11

	产品	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	KAPR (°)	KWW (mm)	KWD (mm)	APMX (mm)	GAMF (°)	GAMP (°)	NOF			max.		kg		
	35T03R-S15XP1607-C	35	90.6	50	27	22	15	12.4	7	7.00	-6	-1	3	6	–	15200	✓	1.32	GI208	CH050
	35T03R-S25XP1612-C	35	87.3	50	27	22	25	12.4	7	12.00	-6	0	3	6	–	15200	✓	1.15	GI208	CH050
	35T03R-S30XP1614-C	35	85.1	50	27	22	30	12.4	7	14.00	-6	0	3	6	–	15200	✓	1.11	GI208	CH050
	35T03R-S35XP1616-C	35	82.4	50	27	22	35	12.4	7	16.00	-6	0	3	6	–	15200	✓	1.04	GI208	CH050
	35T03R-S40XP1618-C	35	79.4	50	27	22	40	12.4	7	18.00	-6	1	3	6	–	15200	✓	0.96	GI208	CH050
	35T03R-S45XP1620-C	35	76.1	50	27	22	45	12.4	7	20.00	-6	2	3	6	–	15200	✓	0.90	GI208	CH050
	35T03R-S50XP1622-C	35	72.4	50	27	22	50	12.4	7	22.00	-6	2	3	6	–	15200	✓	0.83	GI208	CH050
	35T03R-S55XP1623-C	35	68.4	50	27	22	55	12.4	7	23.00	-6	2	3	6	–	15200	✓	0.72	GI208	CH050
ISO 6462 DIN 8030	35T03R-S60XP1625-C	35	64.2	50	27	22	60	12.4	7	25.00	-5	4	3	6	–	15200	✓	0.63	GI208	CH050
	45T03R-S75XP1628-C	45	60.1	50	27	22	75	12.4	7	28.00	-5	5	3	6	–	13400	✓	0.64	GI208	CH050
	45T04R-S25XP1612-C	45	97.3	50	27	22	25	12.4	7	12.00	-6	0	4	8	✓	13400	✓	1.24	GI208	CH050
	45T04R-S30XP1614-C	45	95.1	50	27	22	30	12.4	7	14.00	-6	0	4	8	✓	13400	✓	1.21	GI208	CH050
	45T04R-S35XP1616-C	45	92.4	50	27	22	35	12.4	7	16.00	-6	2	4	8	✓	13400	✓	1.30	GI208	CH050
	45T04R-S40XP1618-C	45	89.5	50	27	22	40	12.4	7	18.00	-6	2	4	8	✓	13400	✓	1.08	GI208	CH050
	45T04R-S45XP1620-C	45	86.1	50	27	22	45	12.4	7	20.00	-6	2	4	8	✓	13400	✓	1.03	GI208	CH050
	45T04R-S50XP1622-C	45	82.4	50	27	22	50	12.4	7	22.00	-6	2	4	8	✓	13400	✓	0.96	GI208	CH050
	45T04R-S55XP1623-C	45	78.4	50	27	22	55	12.4	7	23.00	-6	2	4	8	✓	13400	✓	0.88	GI208	CH050
	45T04R-S60XP1625-C	45	74.2	50	27	22	60	12.4	7	25.00	-5	4	4	8	✓	13400	✓	0.78	GI208	CH050

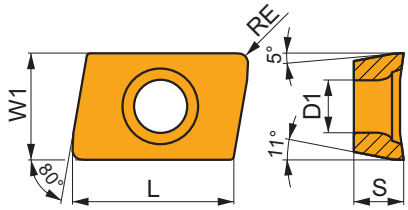
GI208	XPHT 1604..

CH050	US 3509-T15	3.0 Nm	M 3.5	9	D-T07/T15	FG-15	HS 1230C

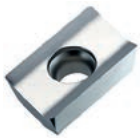
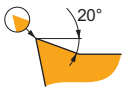
XPHT 16-FA

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	15.88	4.76



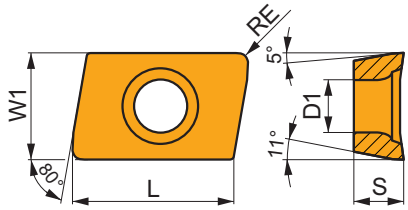
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	●	⇕	✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  F																						
FA 型，具有大正前，适用于倒角铣削。																						
XPHT 160408F-FA:HF7	●			0.8	–	–	–	–	–	–	–	–	–	■ 255	0.12	15.0	–	–	–	–	–	–

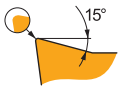
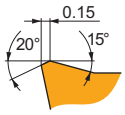
XPHT 16

PRAMET

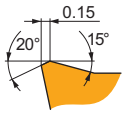
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	15.88	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

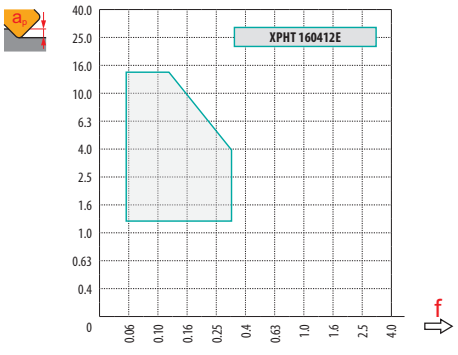
产品	●	⇕	✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 U E																						
E 型，具有大正前角设计，适用于倒角铣削。																						
XPHT 160412E:8215		⇕		1.2	■ 225	0.10	15.0	◪ 135	0.09	15.0	◪ 210	0.10	15.0	–	–	–	–	–	–	–	–	–
XPHT 160412E:M6330		⇕		1.2	■ 190	0.10	15.0	■ 135	0.09	15.0	–	–	–	–	–	–	–	–	–	–	–	–
XPHT 160412E:M8330		⇕		1.2	■ 220	0.10	15.0	■ 130	0.09	15.0	◪ 205	0.10	15.0	–	–	–	–	–	–	–	–	–
XPHT 160412E:M8340		⇕		1.2	■ 195	0.10	15.0	■ 115	0.09	15.0	◪ 185	0.10	15.0	–	–	–	–	–	–	–	–	–
 1 U S																						
S 型，具有大正前角设计，适用于倒角铣削。																						
XPHT 160412S:8215		⇕		1.2	■ 210	0.12	15.0	◪ 125	0.11	15.0	◪ 195	0.12	15.0	–	–	–	–	–	–	–	–	–
XPHT 160412S:M8330		⇕		1.2	■ 210	0.12	15.0	■ 125	0.11	15.0	◪ 195	0.12	15.0	–	–	–	–	–	–	–	–	–
XPHT 160412S:M8340		✱		1.2	■ 190	0.12	15.0	■ 110	0.11	15.0	◪ 180	0.12	15.0	–	–	–	–	–	–	–	–	–

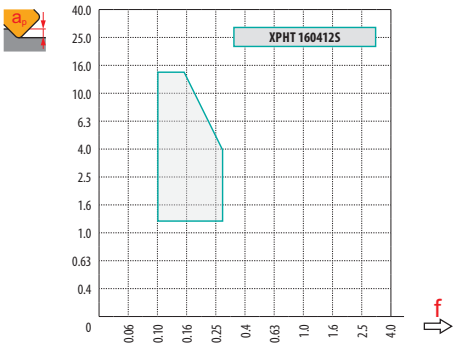
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

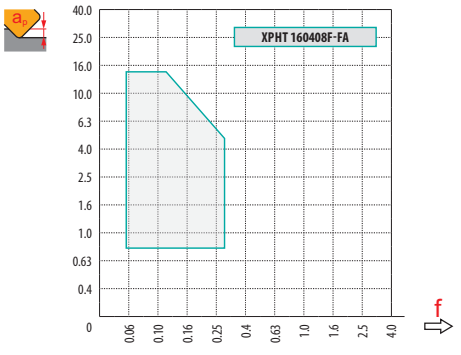
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
XPHT 160412S:M9325		1.2	270	0.12	15.0	–	–	–	255	0.12	15.0	–	–	–	–	–	–	–	–	–
XPHT 160412S:M9340		1.2	245	0.12	15.0	145	0.11	15.0	–	–	–	–	–	–	–	–	–	–	–	–

S 型，具有大正前角设计，适用于倒角铣削。

	XPHT 16 E	XPHT 16 S	XPHT 16-FA
RE	1.2	1.2	0.8
BS	–	–	–







ae / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
15°	0.61	0.98	1.34	0.50	0.80	1.10	0.43	0.69	0.95	0.39	0.62	0.85	0.35	0.56	0.78	0.33	0.52	0.72	0.31	0.49	0.67	0.27	0.44	0.60
25°	0.37	0.60	0.82	0.31	0.49	0.67	0.26	0.42	0.58	0.24	0.38	0.52	0.22	0.35	0.48	0.20	0.32	0.44	0.19	0.30	0.41	0.17	0.27	0.37
30°	0.32	0.51	0.70	0.26	0.41	0.57	0.22	0.36	0.49	0.20	0.32	0.44	0.18	0.29	0.40	0.17	0.27	0.37	0.16	0.25	0.35	0.14	0.23	0.31
35°	0.28	0.44	0.61	0.23	0.36	0.50	0.19	0.31	0.43	0.17	0.28	0.38	0.16	0.25	0.35	0.15	0.24	0.32	0.14	0.22	0.30	0.12	0.20	0.27
40°	0.25	0.39	0.54	0.20	0.32	0.44	0.17	0.28	0.38	0.16	0.25	0.34	0.14	0.23	0.31	0.13	0.21	0.29	0.12	0.20	0.27	0.11	0.18	0.24
45°	0.22	0.36	0.49	0.18	0.29	0.40	0.16	0.25	0.35	0.14	0.23	0.31	0.13	0.21	0.28	0.12	0.19	0.26	0.11	0.18	0.25	0.10	0.16	0.22
50°	0.21	0.33	0.45	0.17	0.27	0.37	0.15	0.23	0.32	0.13	0.21	0.29	0.12	0.19	0.26	0.11	0.18	0.24	0.10	0.17	0.23	0.09	0.15	0.20
55°	0.19	0.31	0.42	0.16	0.25	0.35	0.14	0.22	0.30	0.12	0.20	0.27	0.11	0.18	0.25	0.10	0.17	0.23	0.10	0.15	0.21	0.09	0.14	0.19
60°	0.18	0.29	0.40	0.15	0.24	0.33	0.13	0.21	0.28	0.12	0.18	0.25	0.11	0.17	0.23	0.10	0.16	0.21	0.09	0.15	0.20	0.08	0.13	0.18
75°	0.16	0.26	0.36	0.13	0.21	0.29	0.12	0.19	0.25	0.10	0.17	0.23	0.09	0.15	0.21	0.09	0.14	0.19	0.08	0.13	0.18	0.07	0.12	0.16
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

	ap	DC	DCX	X.V	fmin	fmax
15°	7	35.0	90.6	1.16	0.43	0.70
25°	12	35.0	87.3	1.16	0.20	0.32
30°	14	35.0	85.1	1.17	0.16	0.25
35°	16	35.0	82.4	1.17	0.13	0.20
40°	18	35.0	79.4	1.17	0.11	0.16
45°	20	35.0	76.0	1.18	0.09	0.14
50°	22	35.0	72.4	1.18	0.08	0.12
55°	23	35.0	68.4	1.20	0.08	0.11
60°	25	35.0	64.1	1.20	0.07	0.09
25°	12	45.0	97.3	1.18	0.23	0.34
30°	14	45.0	95.0	1.18	0.18	0.26
35°	16	45.0	92.4	1.19	0.15	0.21
40°	18	45.0	89.5	1.19	0.12	0.17
45°	20	45.0	86.0	1.20	0.11	0.15
50°	22	45.0	82.4	1.21	0.09	0.13
55°	23	45.0	78.4	1.22	0.09	0.11
60°	25	45.0	74.1	1.23	0.08	0.10
75°	28	45.0	60.1	1.31	0.07	0.08

设定角度为15°的铣刀可作为HFC使用。使用倒角台的进给。

槽铣

平面铣

	S90SN	S90CN(XN)	F-SCC			
	90°	90°	90°			
	APMX (mm) 4.0 – 14.0	APMX (mm) 14.0 – 30.5	APMX (mm) 11.0 – 18.0			
	DC (mm) 63 – 200	DC (mm) 125 – 315	DC (mm) 25 – 40			
圆柱刀柄	DC = 80 – 200 (mm)	DC = 125 – 315 (mm)				
侧固刀柄	DC = 63 – 160 (mm)	DC = 125 – 200 (mm)				
模块式刀柄						
套式铣刀						
页码	314	320	325			
ISO	P M K	P M K	P M K			
刀片形状						
刀片	SNHQ 11 SNHQ 12	CNHQ 1005 XNHQ 1205 XNHQ 1606	CCMX			
切削刃数量	4	2	2			
深槽铣	■	■				
深方肩铣	◪	◪				
平面铣	◪	◪				
背面铣削	◪	◪	■			
T形槽铣			■			
浅方肩铣			◪			
浅槽铣			◪			

■ 推荐使用　◪ 可以使用

S90SN

P M K

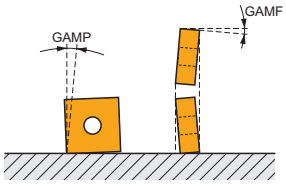
PRAMET

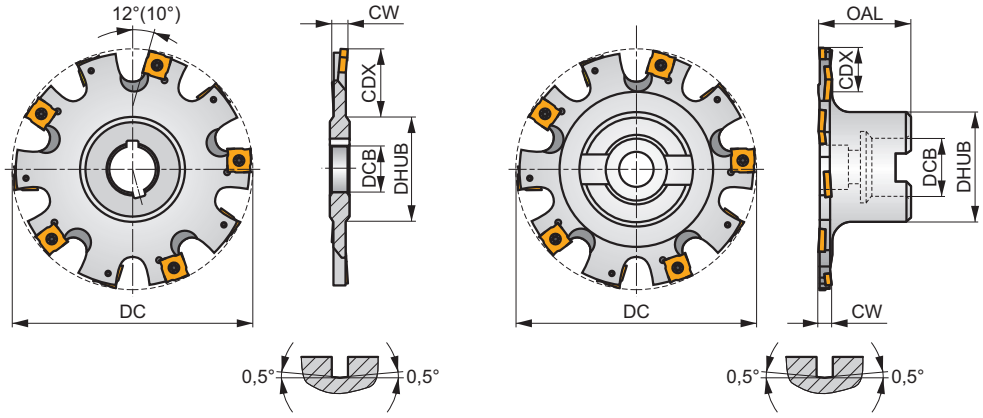
S

三面刃铣刀盘

90° disc mill utilising SNHQ inserts. Suitable for slot, shoulder, rear side and face milling. Available in arbor or stub arbor style. Body treated for longer tool life.

KAPR	90°
CW	4.0 – 14.0 mm





h_m	0.07 – 0.09
h_m	0.07 – 0.09

	产品	DC (mm)	OAL (mm)	DCB (mm)	DHUB (mm)	CDX (mm)	CW (mm)	x/1	GAMF (°)	GAMP (°)			max.		kg			
	80F8N-S90SN11N4	80	–	27	42	16	4.00	–	2.5	-0.5	8	–	12300	–	0.21	GI151	DI011	–
	80F8N-S90SN11N5	80	–	27	42	16	5.00	–	2.5	-0.5	8	–	12300	–	0.22	GI152	DI019	–
	80F8N-S90SN12N6	80	–	27	42	16	6.00	–	2.5	-0.5	8	–	8400	–	0.25	GI153	DI012	–
	80F8N-S90SN12N8	80	–	27	42	16	8.00	–	2.5	-0.5	8	–	8400	–	0.25	GI157	DI013	–
	100G10N-S90SN12N6	100	–	32	48	24	6.00	–	2.5	-0.5	10	–	7500	–	0.43	GI153	DI012	–
	100G10N-S90SN12N8	100	–	32	48	24	8.00	–	2.5	-0.5	10	–	7500	–	0.42	GI157	DI013	–
	100G10N-S90SN12N10	100	–	32	48	24	10.00	–	2.5	-0.5	10	–	7500	–	0.46	GI154	DI014	–
	100G10N-S90SN12N12	100	–	32	48	24	12.00	–	2.5	-0.5	10	–	7500	–	0.66	GI158	DI015	–
	125H12N-S90SN12N6	125	–	40	58	31	6.00	–	2.5	-0.5	12	–	6700	–	0.62	GI153	DI012	–
	125H12N-S90SN12N8	125	–	40	58	31	8.00	–	2.5	-0.5	12	–	6700	–	0.73	GI157	DI013	–
ISO 6462 DIN 8030	125H12N-S90SN12N10	125	–	40	58	31	10.00	–	2.5	-0.5	12	–	6700	–	0.66	GI154	DI014	–
	125H12N-S90SN12N12	125	–	40	58	31	12.00	–	2.5	-0.5	12	–	6700	–	0.76	GI158	DI015	–
	160H16N-S90SN12N6	160	–	40	58	43	6.00	–	2.5	-0.5	16	–	5900	–	0.86	GI153	DI012	–
	160H16N-S90SN12N8	160	–	40	58	43	8.00	–	2.5	-0.5	16	–	5900	–	1.10	GI157	DI013	–
	160H16N-S90SN12N10	160	–	40	58	43	10.00	–	2.5	-0.5	16	–	5900	–	1.14	GI154	DI014	–
	160H16N-S90SN12N12	160	–	40	58	43	12.00	–	2.5	-0.5	16	–	5900	–	1.30	GI158	DI015	–
	160H15N-S90SN12N14	160	–	40	58	43	14.00	–	2.5	-0.5	15	–	5900	–	1.40	GI158	DI015	–
	200J18N-S90SN12N6	200	–	50	72	62	6.00	–	2.5	-0.5	18	–	5300	–	1.40	GI153	DI012	–
	200J18N-S90SN12N8	200	–	50	72	62	8.00	–	2.5	-0.5	18	–	5300	–	1.78	GI157	DI013	–
	200J18N-S90SN12N10	200	–	50	72	62	10.00	–	2.5	-0.5	18	–	5300	–	1.89	GI154	DI014	–
	200J18N-S90SN12N12	200	–	50	72	62	12.00	–	2.5	-0.5	18	–	5300	–	2.23	GI158	DI015	–
	200J18N-S90SN12N14	200	–	50	72	62	14.00	–	2.5	-0.5	18	–	5300	–	2.67	GI158	DI015	–
	63A03R-S90SN11N4	63	40	16	34	10.5	4.00	3	2.5	-0.5	6	–	13900	–	0.37	GI151	DI021	–
	63A03R-S90SN11N5	63	40	16	34	10.5	5.00	3	2.5	-0.5	6	–	13900	–	0.36	GI152	DI021	–
ISO 6462 DIN 8030	63A03R-S90SN12N6	63	40	16	34	10.5	6.00	3	2.5	-0.5	6	–	9500	–	0.37	GI153	DI022	–
	80A04R-S90SN11N5	80	40	22	40	17.5	5.00	4	2.5	-0.5	8	–	12300	–	0.48	GI152	DI023	–
	80A04R-S90SN12N6	80	40	22	40	17.5	6.00	4	2.5	-0.5	8	–	8400	–	0.50	GI153	DI024	–

	产品	DC (mm)	OAL (mm)	DCB (mm)	DHUB (mm)	CDX (mm)	CW (mm)		GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**100A05R-S90SN12N6**	100	50	27	48	23.5	6.00	5	2.5	-0.5	10	–	7500	–	0.86	GI153	DI025	–
	125B06R-S90SN12N6	125	50	40	56	24	6.00	6	2.5	-0.5	12	–	6700	–	1.20	GI153	DI012	AC003
	160B08R-S90SN12N10	160	50	40	70	41	10.00	8	2.5	-0.5	16	–	5900	–	1.83	GI154	DI014	–

GI151	SNHQ 1102..
GI152	SNHQ 1103..
GI153	SNHQ 1203..
GI154	SNHQ 1205..
GI157	SNHQ 1204..
GI158	SNHQ 1207

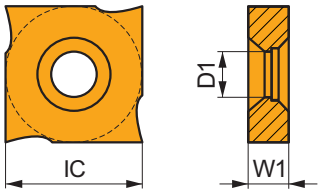
		Nm					
DI011	US 3504-T09P	3.0	M 3.5	4	D-T07P/T09P	FG-15	–
DI012	US 70	5.0	M 4	5	D-T07/T15	FG-15	–
DI013	US 71	5.0	M 4	7	D-T07/T15	FG-15	–
DI014	US 72	5.0	M 4	9	D-T07/T15	FG-15	–
DI015	US 73	5.0	M 4	11	D-T07/T15	FG-15	–
DI019	US 3505-T09P	3.0	M 3.5	5	D-T07P/T09P	FG-15	HS 0830
DI021	US 3504-T09P	3.0	M 3.5	4	D-T07P/T09P	FG-15	HS 0830
DI022	US 70	5.0	M 4	5	D-T07/T15	FG-15	HS 0830
DI023	US 3505-T09P	3.0	M 3.5	5	D-T07P/T09P	FG-15	HS 1030
DI024	US 70	5.0	M 4	5	D-T07/T15	FG-15	HS 1030
DI025	US 70	5.0	M 4	5	D-T07/T15	FG-15	HS 1230

AC003	KS 2040	K.FMH40

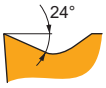
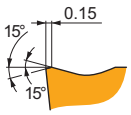
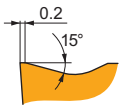
SNHQ AZ

PRAMET

	IC (mm)	D1 (mm)	W1 (mm)
1102	11.000	4.30	2.300
1103	11.000	4.30	2.700
1203	12.700	5.00	3.200
1204	12.700	5.00	4.500
1205	12.700	5.00	5.400
1207	12.700	5.00	7.000
12T3	12.700	5.00	3.400



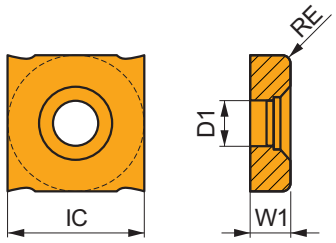
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
EN 型，具有特殊的设计，适用于铣槽。																				
SNHQ 1203AZEN:8215		–	415	0.10	–	245	0.10	–	390	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1203AZEN:M8340		–	370	0.10	–	220	0.10	–	350	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1204AZEN:8215		–	405	0.10	–	240	0.10	–	380	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1204AZEN:M8340		–	355	0.10	–	210	0.10	–	335	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1205AZEN:8215		–	390	0.10	–	230	0.10	–	370	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1205AZEN:M8340		–	345	0.10	–	205	0.10	–	325	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1207AZEN:8215		–	380	0.10	–	225	0.10	–	360	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1207AZEN:M8340		–	335	0.10	–	200	0.10	–	315	0.10	–	–	–	–	–	–	–	–	–	–
																				
TN 型，具有特殊的设计，适用于铣槽。																				
SNHQ 1102AZTN:M8330		–	365	0.20	–	215	0.18	–	345	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1102AZTN:M8340		–	335	0.20	–	200	0.18	–	315	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1103AZTN:M8330		–	345	0.20	–	205	0.18	–	325	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1103AZTN:M8340		–	315	0.20	–	185	0.18	–	295	0.20	–	–	–	–	–	–	–	–	–	–
																				
TN 型，具有特殊的设计，适用于铣槽。																				
SNHQ 1203AZTN:M8330		–	345	0.20	–	205	0.18	–	325	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1203AZTN:M8340		–	315	0.20	–	185	0.18	–	295	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1204AZTN:M8330		–	335	0.20	–	200	0.20	–	315	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1204AZTN:M8340		–	300	0.20	–	180	0.20	–	285	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1205AZTN:M8330		–	330	0.20	–	195	0.20	–	310	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1205AZTN:M8340		–	295	0.20	–	175	0.20	–	280	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1207AZTN:M8330		–	320	0.20	–	190	0.20	–	300	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1207AZTN:M8340		–	290	0.20	–	170	0.20	–	275	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 12T3AZTN:M8340		–	300	0.20	–	180	0.18	–	285	0.20	–	–	–	–	–	–	–	–	–	–

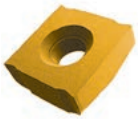
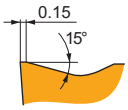
SNHQ TRL

PRAMET

	IC (mm)	D1 (mm)	L (mm)	W1 (mm)
1203	12.700	5.00	12.70	3.200
1204	12.700	5.00	12.70	4.500
1205	12.700	5.00	12.70	5.400
1207	12.700	5.00	12.70	7.000



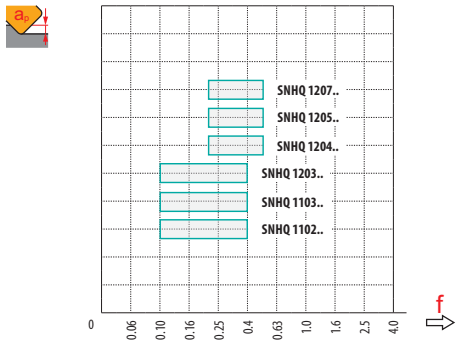
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

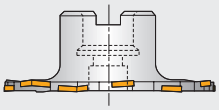
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
SNHQ 120305TRL:M8340		0.5	230	0.20	–	135	0.18	–	215	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 120310TRL:M8340		1.0	285	0.20	–	170	0.18	–	270	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 120315TRL:M8340		1.5	300	0.20	–	180	0.18	–	285	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 120405TRL:M8340		0.5	220	0.20	–	130	0.20	–	205	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 120415TRL:M8340		1.5	290	0.20	–	170	0.20	–	275	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 120505TRL:M8340		0.5	215	0.20	–	125	0.20	–	200	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 120515TRL:M8340		1.5	280	0.20	–	165	0.20	–	265	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 120705TRL:M8340		0.5	210	0.20	–	125	0.20	–	195	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 120710TRL:M8340		1.0	265	0.20	–	155	0.20	–	250	0.20	–	–	–	–	–	–	–	–	–	–

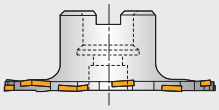
TRL 型，具有特殊的设计，适用于铣槽。

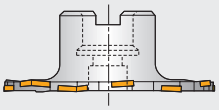
a_e / DC	0.05	0.10	0.15	0.20	0.25	0.30	0.40	0.50	0.60	0.70	0.75	0.80	0.90	1.00
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

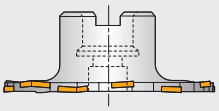
	SNHQ AZEN	SNHQ AZTN	SNHQ 12TRL
RE	–	–	0.5 – 1.5
BS	–	–	–



	DC		CDX	$a_{e\,max}$
	80	4	16	16
	100	5	24	24
	125	6	31	31
	160	5	43	43
	200	9	62	62
	63	3	10.5	63
	80	4	17.5	80
	100	5	23.5	100
	125	6	24	125
	160	8	41	160

	a_e	5		10		15		20		25	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	80	0.28	0.36	0.20	0.26	0.17	0.21	–	–	–	–
	100	0.32	0.41	0.23	0.29	0.19	0.24	0.16	0.21	–	–
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23
	200	0.44	0.57	0.32	0.41	0.26	0.33	0.23	0.29	0.20	0.26
	63	0.25	0.32	0.18	0.23	0.15	0.19	0.13	0.17	0.12	0.15
	80	0.28	0.36	0.20	0.26	0.17	0.21	0.15	0.19	0.13	0.17
	100	0.32	0.41	0.23	0.29	0.19	0.24	0.16	0.21	0.15	0.19
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23

	a_e	32		40		50		63		80	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	80	–	–	–	–	–	–	–	–	–	–
	100	–	–	–	–	–	–	–	–	–	–
	125	–	–	–	–	–	–	–	–	–	–
	160	0.16	0.21	0.15	0.19	–	–	–	–	–	–
	200	0.18	0.23	0.16	0.21	0.15	0.19	–	–	–	–
	63	0.11	0.14	0.10	0.13	0.10	0.12	0.10	0.11	–	–
	80	0.12	0.15	0.11	0.14	0.10	0.13	0.10	0.12	0.10	0.11
	100	0.13	0.17	0.12	0.15	0.11	0.14	0.10	0.13	0.10	0.12
	125	0.15	0.19	0.13	0.17	0.12	0.15	0.11	0.14	0.10	0.13
	160	0.16	0.21	0.15	0.19	0.13	0.17	0.12	0.16	0.11	0.14

	a_e	100		125		160	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	80	–	–	–	–	–	–
	100	–	–	–	–	–	–
	125	–	–	–	–	–	–
	160	–	–	–	–	–	–
	200	–	–	–	–	–	–
	63	–	–	–	–	–	–
	80	–	–	–	–	–	–
	100	0.10	0.11	–	–	–	–
	125	0.10	0.12	0.10	0.11	–	–
	160	0.10	0.13	0.10	0.12	0.10	0.11

S90CN(XN)

P M K

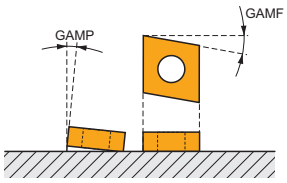
PRAMET

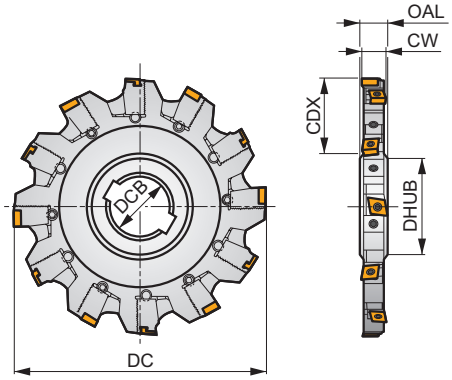
S

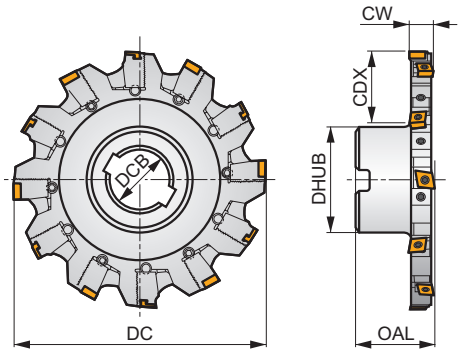
三面刃铣刀盘，宽度可调节

90° disc mill utilising CNHQ and XNHQ inserts. Suitable for slot, shoulder, rear side and face milling. Available in arbor or stub arbor style. Body treated for longer tool life.

KAPR	90°
CW	14.0 – 30.5 mm







h_m	0.07 – 0.09
h_m	0.07 – 0.09

	产品	DC (mm)	OAL (mm)	DCB (mm)	DHUB (mm)	CDX (mm)	CW (mm)	GAMF (°)	GAMP (°)				max.		kg			
	125H04N-S90CN10N18	125	18	40	56	34	14.0 – 18.5	-10	4	4	8	–	7800	–	1.19	GI195	DI051	–
	160H06N-S90CN10N18	160	18	40	56	50	14.0 – 18.5	-8	4	6	12	–	6900	–	1.80	GI195	DI052	–
	160H05N-S90XN12N24	160	24	40	56	50	19.0 – 24.3	-8	5	5	10	–	5200	–	2.50	GI196	DI056	–
	200J07N-S90CN10N18	200	18	50	71	60	14.0 – 18.5	-8	4	7	14	–	6100	–	2.85	GI195	DI053	–
	200J06N-S90XN12N24	200	24	50	71	60	19.0 – 24.3	-8	5	6	12	–	4700	–	3.60	GI196	DI057	–
ISO 6462 DIN 8030	200J06N-S90XN16N30	200	30	50	71	60	24.5 – 30.5	-9	5	6	12	–	4000	–	6.00	GI197	DI060	–
	250J09N-S90CN10N18	250	18	50	71	85	14.0 – 18.5	-8	4	9	18	–	5500	–	5.30	GI195	DI054	–
	250J08N-S90XN12N24	250	24	50	71	85	19.0 – 24.3	-8	5	8	16	–	4200	–	7.50	GI196	DI058	–
	250J08N-S90XN16N30	250	30	50	71	85	24.5 – 30.5	-8	5	8	16	–	3600	–	8.00	GI197	DI061	–
	315J12N-S90CN10N18	315	18	50	71	110	14.0 – 18.5	-8	4	12	24	–	4900	–	7.80	GI195	DI055	–
	315J10N-S90XN12N24	315	24	50	71	110	19.0 – 24.3	-8	5	10	20	–	3700	–	10.70	GI196	DI059	–
	315K10N-S90XN16N30	315	30	60	85	110	24.5 – 30.5	-8	5	10	20	–	3200	–	13.00	GI197	DI062	–
	125B04R-S90CN10N18	125	50	40	70	25	14.0 – 18.5	-10	4	4	8	–	7800	–	1.65	GI195	DI071	AC003
ISO 6462 DIN 8030	160B06R-S90CN10N18	160	50	40	70	44	14.0 – 18.5	-8	5	6	12	–	6900	–	2.55	GI195	DI072	–
	160B05R-S90XN12N24	160	50	40	70	44	19.0 – 24.3	-8	5	5	10	–	5200	–	2.50	GI196	DI074	–
	200C06R-S90XN12N24	200	50	40	90	52	19.0 – 24.3	-8	5	6	12	–	6100	–	4.70	GI196	DI075	–
ISO 6462 DIN 8030	200C07R-S90CN10N18	200	50	40	90	52	14.0 – 18.5	-8	4	7	14	–	6100	–	4.05	GI195	DI073	–

GI195	CNHQ 1005..
GI196	XNHQ 1205..
GI197	XNHQ 1606..

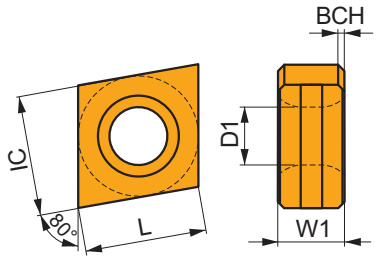
DI051	125H04N-S-14-08	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI052	160H06N-S-14-12	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI053	200J07N-S-14-14	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI054	250J09N-S-14-18	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI055	315J12N-S-14-24	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI056	160H05N-S-19-10	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI057	200J06N-S-19-12	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI058	250J08N-S-19-16	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI059	315J10N-S-19-20	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI060	200J06N-S-25-12	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI061	250J08N-S-25-16	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI062	315K10N-S-25-20	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI071	125B04R-S-14-08	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI072	160B06R-S-14-12	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI073	200C07R-S-14-14	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI074	160B05R-S-19-10	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI075	200C06R-S-19-12	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4

AC003	KS 2040	K.FMH40

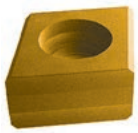
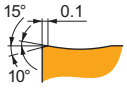
CNHQ

PRAMET

	BCH (mm)	IC (mm)	D1 (mm)	L (mm)	W1 (mm)
1005	0.50	10.000	4.70	10.00	5.400



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

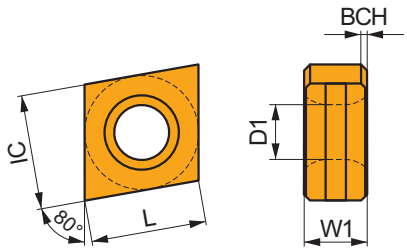
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
CNHQ 1005AZTN:M8330		–	310	0.15	–	185	0.14	–	290	0.15	–	–	–	–	–	–	–	–	–	–
CNHQ 1005AZTN:M8340		–	280	0.15	–	165	0.14	–	265	0.15	–	–	–	–	–	–	–	–	–	–

TN 非标设计，适用于铣槽具有轻载到重载切削工况。

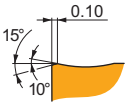
XNHQ

PRAMET

	BCH (mm)	IC (mm)	D1 (mm)	L (mm)	W1 (mm)
1205	0.50	10.000	4.70	12.70	5.400
1606	0.50	12.000	5.90	16.00	6.400



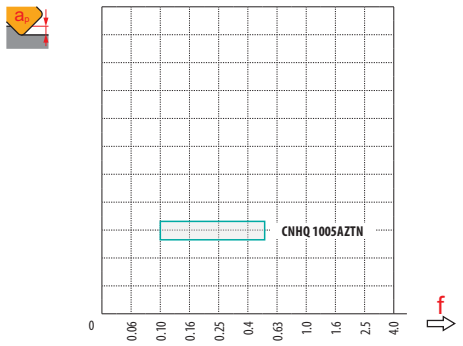
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
XNHQ 1205AZTN:M8330		–	310	0.15	–	185	0.14	–	290	0.15	–	–	–	–	–	–	–	–	–	–
XNHQ 1205AZTN:M8340		–	275	0.15	–	165	0.14	–	260	0.15	–	–	–	–	–	–	–	–	–	–
XNHQ 1606AZTN:M8330		–	300	0.15	–	180	0.14	–	285	0.15	–	–	–	–	–	–	–	–	–	–
XNHQ 1606AZTN:M8340		–	270	0.15	–	160	0.14	–	255	0.15	–	–	–	–	–	–	–	–	–	–

TN 非标设计，适用于铣槽。

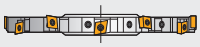
a_e / DC	0.05	0.10	0.15	0.20	0.25	0.30	0.40	0.50	0.60	0.70	0.75	0.80	0.90	1.00
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

	XNHQ 10
RE	–
BS	–



	DC		CDX	$a_{e\,max}$
	125	4	34	34
	160	6	50	50
	200	7	60	60
	250	9	85	85
	315	12	110	110
	125	4	25	125
	160	6	44	160
	200	7	52	200

	a_e	5		10		15		20		25	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23
	200	0.44	0.57	0.32	0.41	0.26	0.33	0.23	0.29	0.20	0.26
	250	0.50	0.64	0.35	0.45	0.29	0.37	0.25	0.32	0.23	0.29
	315	0.56	0.72	0.39	0.51	0.32	0.42	0.28	0.36	0.25	0.32
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23
	200	0.44	0.57	0.32	0.41	0.26	0.33	0.23	0.29	0.20	0.26

	a_e	32		40		50		63		80	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	125	0.15	0.19	–	–	–	–	–	–	–	–
	160	0.16	0.21	0.15	0.19	–	–	–	–	–	–
	200	0.18	0.23	0.16	0.21	0.15	0.19	–	–	–	–
	250	0.20	0.26	0.18	0.23	0.16	0.21	0.15	0.19	0.13	0.17
	315	0.22	0.29	0.20	0.26	0.18	0.23	0.16	0.21	0.15	0.19
	125	0.15	0.19	0.13	0.17	0.12	0.15	0.11	0.14	0.10	0.13
	160	0.16	0.21	0.15	0.19	0.13	0.17	0.12	0.16	0.11	0.14
	200	0.18	0.23	0.16	0.21	0.15	0.19	0.13	0.17	0.12	0.15

	a_e	100		125		160		200	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	125	–	–	–	–	–	–	–	–
	160	–	–	–	–	–	–	–	–
	200	–	–	–	–	–	–	–	–
	250	–	–	–	–	–	–	–	–
	315	0.13	0.17	–	–	–	–	–	–
	125	0.10	0.12	0.10	0.11	–	–	–	–
	160	0.10	0.13	0.10	0.12	0.10	0.11	–	–
	200	0.11	0.14	0.10	0.13	0.10	0.12	0.10	0.11

F-SCC

P M K

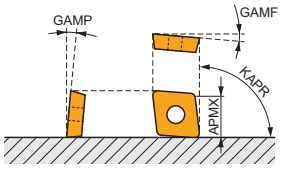
PRAMET

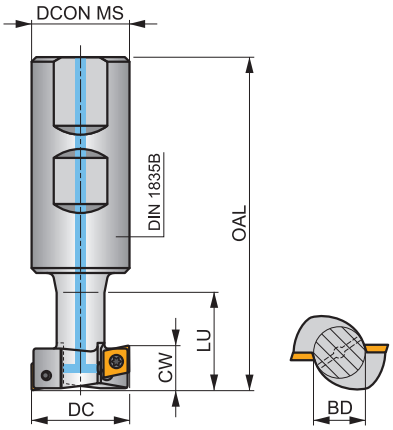
S

T-型槽铣刀盘，使用CCMX刀片，带内冷

T-型槽铣刀盘，使用单面CCMX刀片，有内冷。适用于T-型槽，背铣，浅方肩铣和浅槽铣。提供侧固柄类型。刀体经过处理，使用寿命更长。

KAPR	90°
APMX	11.0 – 18.0 mm





h_m 0.05 – 0.08

	产品	DC (mm)	BD (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	CW (mm)				max.		kg		
DIN 1835B	25F1R030B25-SCC06-C	25	12	86	25	25	11.00	1	2	–	28100	✓	0.26	GI148	SQ213
	32F1R038B32-SCC08-C	32	16	98	32	33	14.00	1	2	–	19100	✓	0.50	GI149	SQ212
	40F2R046B32-SCC09-C	40	20	105	32	41	18.00	2	4	–	14900	✓	0.56	GI150	SQ212

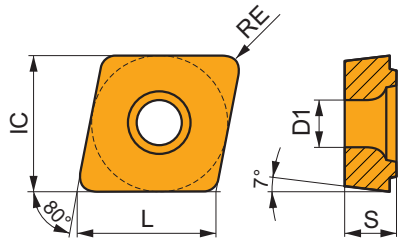
GI148	CCMX 060304
GI149	CCMX 08T308
GI150	CCMX 09T308

		Nm			
SQ212	US 3007-T09P	2.0	M 3	7.3	Flag T09P
SQ213	US 2506-T07P	1.2	M 2.5	6.3	Flag T07P

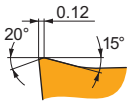
CCMX

PRAMET

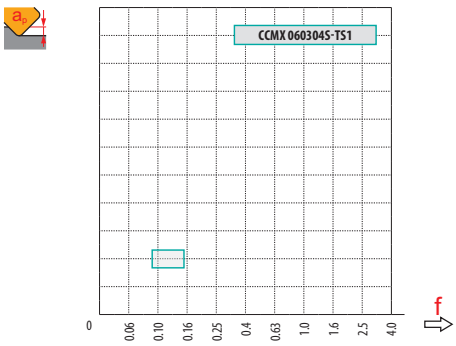
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0603	6.350	2.80	6.40	3.50
08T3	8.030	3.50	8.10	4.40
09T3	9.525	3.50	9.70	3.97

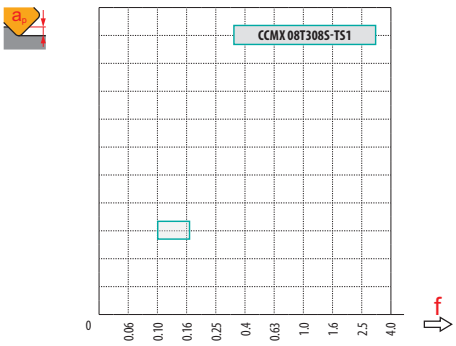


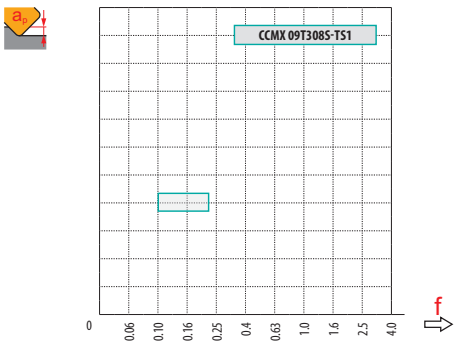
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
TS1 非标设计，适用于T-型铣槽fo+l250r轻载到中等切削工况。																				
CCMX 060304S-TS1:M8330	●	0.4	240	0.10	–	140	0.09	–	225	0.10	–	–	–	–	–	–	–	–	–	–
CCMX 060304S-TS1:M8340	⬌	0.4	215	0.10	–	125	0.09	–	200	0.10	–	–	–	–	–	–	–	–	–	–
CCMX 08T308S-TS1:M8330	⬌	0.8	275	0.10	–	165	0.10	–	260	0.10	–	–	–	–	–	–	–	–	–	–
CCMX 09T308S-TS1:M8330	⬌	0.8	270	0.10	–	160	0.10	–	255	0.10	–	–	–	–	–	–	–	–	–	–
CCMX 09T308S-TS1:M8340	⬌	0.8	240	0.10	–	140	0.10	–	225	0.10	–	–	–	–	–	–	–	–	–	–

	CCMX 06-TS1	CCMX 08-TS1	CCMX 09-TS1
RE	0.4	0.8	0.8
BS	–	–	–







a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

DC	a_e = 1		a_e = 2		a_e = 3		a_e = 4		a_e = 5		a_e = 8		a_e = 10	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.25	0.40	0.18	0.29	0.15	0.24	0.13	0.21	0.12	0.19	0.09	0.15	0.09	0.14
32	0.28	0.45	0.20	0.32	0.17	0.27	0.14	0.23	0.13	0.21	0.10	0.17	0.09	0.15
40	0.32	0.51	0.23	0.36	0.18	0.30	0.16	0.26	0.14	0.23	0.12	0.19	0.10	0.17

DC	a_e = 12		a_e = 16		a_e = 20		a_e = 25		a_e = 32		a_e = 40	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13	–	–	–	–
32	0.09	0.14	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13	–	–
40	0.10	0.15	0.09	0.14	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13

用于T型槽铣

用于方肩和逆铣加工

用于方肩铣

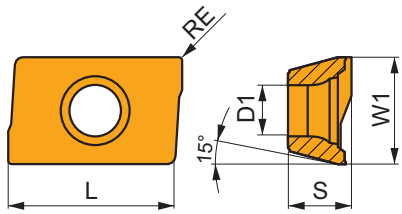
DC		A_{PMX}	$a_{e\,max}$
25	1	11	6.4
32	1	14	8.0
40	2	18	9.7

其他铣削刀片

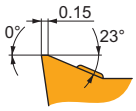
ADKT 15

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1505	9.525	4.40	15.55	5.60



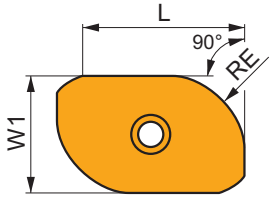
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			M 型，具有大正前角设计，适用于中等加工。																	
ADKT 1505PDER-M:M8330		0.8	235	0.20	5.0	140	0.18	5.0	220	0.20	5.0	–	–	–	55	0.16	4.0	–	–	–
ADKT 1505PDER-M:M8340		0.8	210	0.20	5.0	125	0.18	5.0	195	0.20	5.0	–	–	–	50	0.16	4.0	–	–	–
ADKT 1505PDER-M:M9325		0.8	290	0.20	5.0	–	–	–	275	0.20	5.0	–	–	–	–	–	–	–	–	–

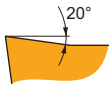
ADKX 15

PRAMET

	W1 (mm)	L (mm)	S (mm)
15T3	9.525	12.20	3.97



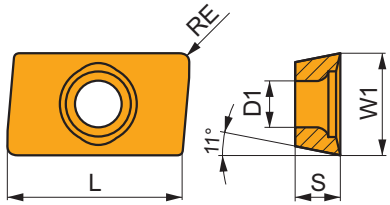
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			F 型，具有非常锋利正前角设计，适用于轻载到中等加工。																	
ADKX 15T308ER-F:M8345		0.8	170	0.10	10.0	100	0.09	10.0	–	–	–	–	–	–	40	0.07	8.0	–	–	–

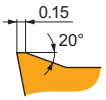
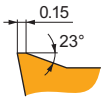
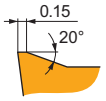
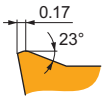
APMT 16

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.600	4.50	17.00	4.76



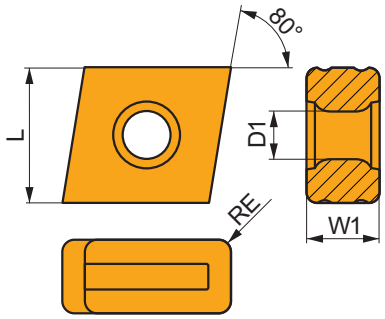
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F 型，具有正前角设计，适用于轻载加工。																				
APMT 1604PDER-F:M8330		–	320	0.10	2.0	190	0.09	2.0	300	0.10	2.0	–	–	–	80	0.07	1.6	–	–	–
																				
FM 型，具有前角设计，适用于轻载到中等加工。																				
APMT 1604PDER-FM:M8330		–	285	0.16	2.0	170	0.14	2.0	270	0.16	2.0	–	–	–	70	0.13	1.6	–	–	–
APMT 1604PDER-FM:M8345		–	205	0.16	2.0	120	0.14	2.0	–	–	–	–	–	–	50	0.13	1.6	–	–	–
																				
ER-R 型，具有正前角设计，适用于粗加工。																				
APMT 1604PDER-R:M8330		–	255	0.16	5.0	–	–	–	240	0.16	5.0	–	–	–	–	–	–	–	–	–
																				
SR-R 型，具有正前角设计，适用于粗加工。																				
APMT 1604PDSR-R:M8330		–	255	0.18	5.0	–	–	–	240	0.18	5.0	–	–	–	–	–	–	–	–	–

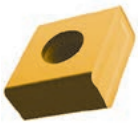
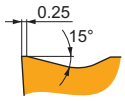
CNM

PRAMET

	D1 (mm)	L (mm)	S (mm)
63	5.50	15.00	8.00



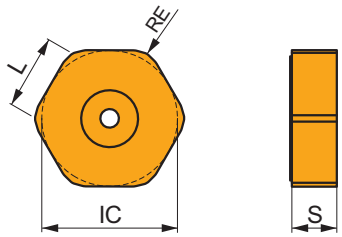
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  U T	563 通用槽型。																			
CNM 563:M8330	●	1.2	185	0.30	10.0	–	–	–	175	0.30	10.0	–	–	–	–	–	–	–	–	–
CNM 563:M8340	⇕	1.2	220	0.30	10.0	–	–	–	205	0.30	10.0	–	–	–	–	–	–	–	–	–

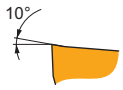
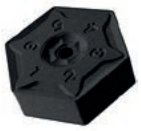
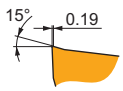
HNEF 09

PRAMET

	IC (mm)	L (mm)	S (mm)
0905	16.200	9.40	5.64



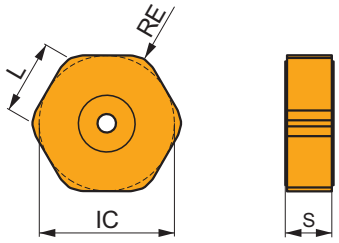
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 S	R 型，具有负前角设计，适用于轻载和重载加工。																			
HNMF 090516SN-R:8215	●	1.6	–	–	–	–	–	–	380	0.15	1.5	–	–	–	–	–	–	–	–	–
HNMF 090516SN-R:M5315	⇕	1.6	–	–	–	–	–	–	265	0.30	3.0	–	–	–	–	–	–	–	–	–
  1 E	M 型，具有前角设计，适用于轻载到中等加工。																			
HNEF 090508EN-M:M5315	⇕	0.8	–	–	–	–	–	–	290	0.18	3.0	–	–	–	–	–	–	–	–	–

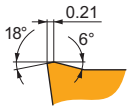
HNMF 09

PRAMET

	IC (mm)	L (mm)	S (mm)
0905	16.200	9.40	5.64



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

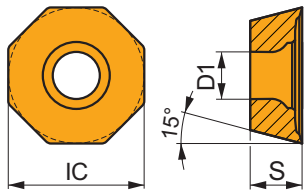
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
HNMF 090516SN-R:8215		1.6	–	–	–	–	–	–	210	0.30	3.0	–	–	–	–	–	–	–	–	–
HNMF 090516SN-R:M5315		1.6	–	–	–	–	–	–	265	0.30	3.0	–	–	–	–	–	–	–	–	–

R 型，具有负前角设计，适用于轻载和重载加工。

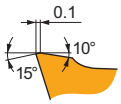
ODMT 05

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0504	12.700	4.40	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

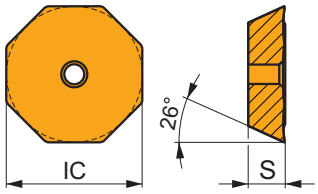
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
ODMT 0504ZZN:M8340		–	195	0.25	1.5	–	–	–	185	0.25	1.5	–	–	–	–	–	–	–	–	–

ZZN 很小的正前角设计，适用于中等加工。

OFKR 07

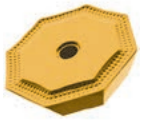
PRAMET

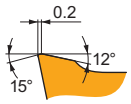
	IC (mm)	D1 (mm)	S (mm)
0704	17.845	2.65	4.56



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
OFKR 0704SN-M:M8330		–	235	0.25	1.5	140	0.23	1.5	220	0.25	1.5	–	–	–	–	–	–	–	–	–
OFKR 0704SN-M:M8340		–	215	0.25	1.5	125	0.23	1.5	200	0.25	1.5	–	–	–	–	–	–	–	–	–



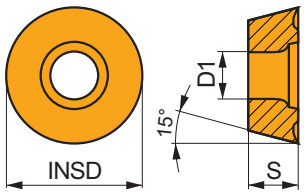


M 型，具有前角设计，适用于轻载到中等加工。

RDET

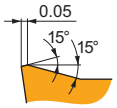
PRAMET

	INSD (mm)	D1 (mm)	S (mm)
0802	8.000	3.40	2.38
1003	10.000	4.40	3.18
12T3	12.000	4.40	3.97



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RDET 0802MOSN:M8340		–	335	0.15	0.5	200	0.14	0.5	315	0.15	0.5	–	–	–	80	0.12	0.4	–	–	–
RDET 1003MOSN:M8340		–	310	0.15	1.0	185	0.14	1.0	290	0.15	1.0	–	–	–	75	0.12	0.8	–	–	–
RDET 12T3MOSN:M8340		–	280	0.20	1.5	165	0.18	1.5	265	0.20	1.5	–	–	–	70	0.14	1.2	–	–	–

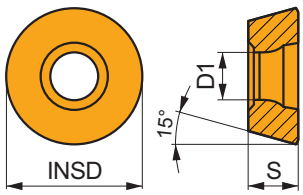


SN 正前角设计，适用于精加工。

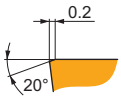
RDHX 20

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
2006	20.000	5.20	6.35



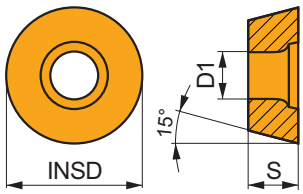
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			MOT 平板设计，适用于精加工。																	
RDHX 2006MOT:M8310		–	240	0.35	3.0	–	–	–	225	0.35	3.0	–	–	–	–	–	–	45	0.18	1.3
RDHX 2006MOT:M8325		–	180	0.35	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

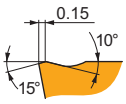
RPET 12

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1204	12.000	4.40	4.76



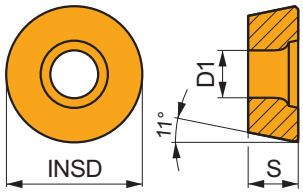
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			MOSN 正前角设计，适用于精加工。																	
RPET 1204MOSN:8215		–	325	0.20	1.5	195	0.18	1.5	305	0.20	1.5	–	–	–	80	0.14	1.2	–	–	–
RPET 1204MOSN:M8330		–	320	0.20	1.5	190	0.18	1.5	300	0.20	1.5	–	–	–	80	0.14	1.2	–	–	–
RPET 1204MOSN:M8340		–	295	0.20	1.5	175	0.18	1.5	280	0.20	1.5	–	–	–	70	0.14	1.2	–	–	–

RPEW 12

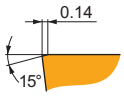
PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1204	12.000	4.40	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RPEW 1204MOSN:M8330	✱	–	285	0.20	1.5	–	–	–	270	0.20	1.5	–	–	–	–	–	–	55	0.10	0.8
RPEW 1204MOSN:M8340	✱	–	265	0.20	1.5	–	–	–	250	0.20	1.5	–	–	–	–	–	–	–	–	–



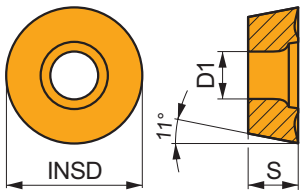
HFC S

MOSN 平板设计，适用于精加工。

RPEX

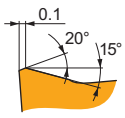
PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1204	12.000	4.40	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
RPEX 1204MOSN-12:M8340	✱	–	215	0.30	1.5	125	0.27	1.5	200	0.30	1.5	–	–	–	50	0.21	1.2	–	–	–



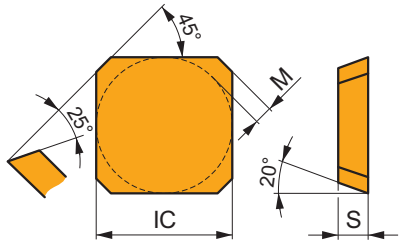
HFC S

12 正前角设计，适用于精加工。

SEEN

PRAMET

	IC (mm)	M (mm)	S (mm)
1203	12.700	1.6	3.18
1504	15.875	2.0	4.76



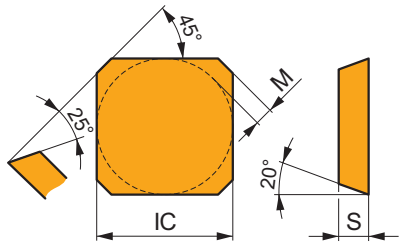
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
AFFN 口制备，平板槽型，适用于轻载到中等加工。																				
SEEN 1203AFFN:M8330		–	270	0.15	2.0	160	0.14	2.0	255	0.15	2.0	–	–	–	–	–	–	–	–	–
SEEN 1203AFFN:M8340		–	245	0.15	2.0	145	0.14	2.0	230	0.15	2.0	–	–	–	–	–	–	–	–	–
AFSN 口制备，平板槽型，适用于中等到重载加工。																				
SEEN 1203AFSN:8215		–	255	0.20	2.0	–	–	–	240	0.20	2.0	–	–	–	–	–	–	50	0.13	1.0
SEEN 1203AFSN:M8330		–	255	0.20	2.0	–	–	–	240	0.20	2.0	–	–	–	–	–	–	50	0.13	1.0
SEEN 1203AFSN:M8340		–	230	0.20	2.0	–	–	–	215	0.20	2.0	–	–	–	–	–	–	–	–	–
SEEN 1203AFSN:M9315		–	340	0.20	2.0	–	–	–	320	0.20	2.0	–	–	–	–	–	–	65	0.13	1.0
SEEN 1203AFSN:M9325		–	315	0.20	2.0	–	–	–	295	0.20	2.0	–	–	–	–	–	–	60	0.13	1.0
AFSN 口制备，平板槽型，适用于中等到重载加工。																				
SEEN 1504AFSN:M8330		–	240	0.20	3.0	–	–	–	225	0.20	3.0	–	–	–	–	–	–	45	0.13	1.3
SEEN 1504AFSN:M8340		–	225	0.20	3.0	–	–	–	210	0.20	3.0	–	–	–	–	–	–	–	–	–

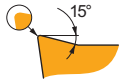
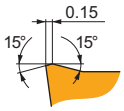
SEER

PRAMET

	IC (mm)	M (mm)	S (mm)
1203	12.700	1.6	3.18
1204	12.700	1.6	4.76
1504	15.875	2.0	4.76



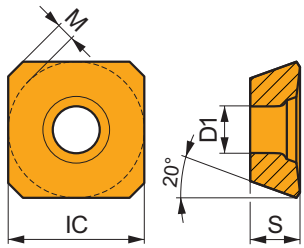
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			AFEN 口制备，断屑槽型，适用于中等到重载加工。																	
SEER 1203AFEN:M8330		–	265	0.24	2.5	155	0.22	2.5	250	0.24	2.5	–	–	–	65	0.22	2.0	–	–	–
SEER 1203AFEN:M8340		–	245	0.24	2.5	145	0.22	2.5	230	0.24	2.5	–	–	–	60	0.22	2.0	–	–	–
			AFSN 口制备，断屑槽型，适用于中等到重载加工。																	
SEER 1203AFSN:M8330		–	265	0.25	2.5	155	0.23	2.5	250	0.25	2.5	–	–	–	65	0.20	2.0	–	–	–
SEER 1203AFSN:M8340		–	240	0.25	2.5	140	0.23	2.5	225	0.25	2.5	–	–	–	60	0.20	2.0	–	–	–
SEER 1204AFSN:M8330		–	265	0.25	2.5	155	0.23	2.5	250	0.25	2.5	–	–	–	65	0.20	2.0	–	–	–
SEER 1504AFSN:M8330		–	255	0.25	3.5	150	0.23	3.5	240	0.25	3.5	–	–	–	60	0.20	2.8	–	–	–
SEER 1504AFSN:M8340		–	230	0.25	3.5	135	0.23	3.5	215	0.25	3.5	–	–	–	55	0.20	2.8	–	–	–

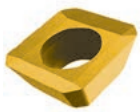
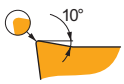
SEET 12

PRAMET

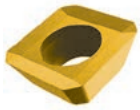
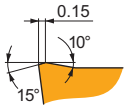
	IC (mm)	D1 (mm)	M (mm)	S (mm)
1204	12.700	5.50	1.6	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			AFEN 口制备，正前角通用槽型。																	
SEET 1204AFEN:M8330		–	265	0.24	2.5	155	0.22	2.5	250	0.24	2.5	–	–	–	65	0.22	2.0	–	–	–

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

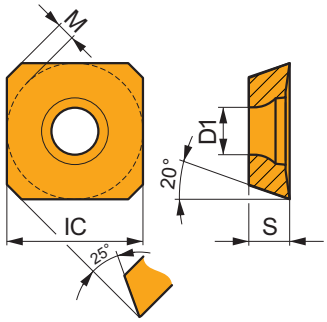
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
SEET 1204AFSN:8215		–	265	0.23	2.5	155	0.21	2.5	250	0.23	2.5	–	–	–	65	0.21	2.0	–	–	–
SEET 1204AFSN:M8330		–	265	0.24	2.5	155	0.22	2.5	250	0.24	2.5	–	–	–	65	0.22	2.0	–	–	–
SEET 1204AFSN:M8340		–	240	0.25	2.5	140	0.23	2.5	225	0.25	2.5	–	–	–	60	0.23	2.0	–	–	–
SEET 1204AFSN:M9325		–	340	0.20	2.5	–	–	–	320	0.20	2.5	–	–	–	–	–	–	–	–	–

AFSN 口制备，正前角通用槽型。

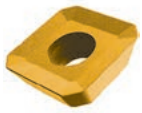
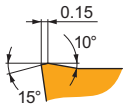
SEET 12-PM

PRAMET

	IC (mm)	D1 (mm)	M (mm)	S (mm)
12T3	13.400	4.20	1.5	3.97



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

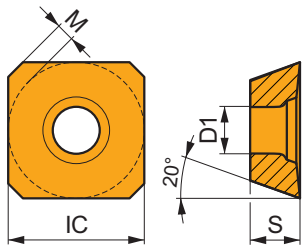
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
SEET 12T3M-PM:M8330		–	265	0.25	2.0	155	0.23	2.0	250	0.25	2.0	–	–	–	65	0.20	1.6	–	–	–
SEET 12T3M-PM:M8340		–	245	0.25	2.0	145	0.23	2.0	230	0.25	2.0	–	–	–	60	0.20	1.6	–	–	–
SEET 12T3M-PM:M9325		–	325	0.25	2.0	–	–	–	305	0.25	2.0	–	–	–	–	–	–	–	–	–
SEET 12T3M-PM:M9340		–	290	0.25	2.0	170	0.23	2.0	–	–	–	–	–	–	70	0.20	1.6	–	–	–

PM 型，具有正前角通用设计。

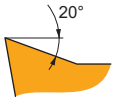
SEET 12-FA

PRAMET

	IC (mm)	D1 (mm)	M (mm)	S (mm)
1204	12.700	5.50	1.6	4.76



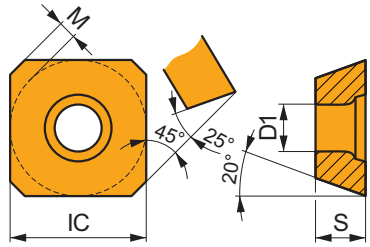
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 FA 型，具有大正前角设计，适用于精加工到中等加工。																				
SEET 1204AFFN-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	■ 330	0.18	3.0	–	–	–	–	–	–

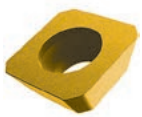
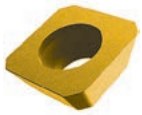
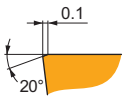
SEEW 12

PRAMET

	IC (mm)	D1 (mm)	M (mm)	S (mm)
1204	12.700	5.50	1.6	4.76



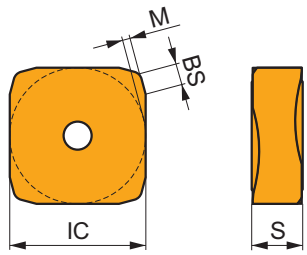
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 AFEN 口制备具有平板槽型，适用于轻载到中等加工。																				
SEEW 1204AFEN:M8330	⚙	–	◪ 265	0.15	2.5	–	–	–	◪ 250	0.15	2.5	–	–	–	–	–	–	–	–	–
SEEW 1204AFEN:M8340	⚙	–	◪ 240	0.15	2.5	–	–	–	◪ 225	0.15	2.5	–	–	–	–	–	–	–	–	–
  AFSN 口制备，具有平板槽型，适用于轻载到中等加工。																				
SEEW 1204AFSN:8215	⚙	–	◪ 250	0.20	2.5	–	–	–	■ 235	0.20	2.5	–	–	–	–	–	–	◪ 50	0.13	1.0
SEEW 1204AFSN:M8330	⚙	–	◪ 245	0.20	2.5	–	–	–	■ 230	0.20	2.5	–	–	–	–	–	–	◪ 45	0.13	1.0
SEEW 1204AFSN:M8340	✱	–	◪ 225	0.20	2.5	–	–	–	◪ 210	0.20	2.5	–	–	–	–	–	–	–	–	–
SEEW 1204AFSN:M9325	⚙	–	◪ 305	0.20	2.5	–	–	–	■ 285	0.20	2.5	–	–	–	–	–	–	◪ 60	0.13	1.0

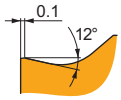
SNHF

PRAMET

	BS (mm)	IC (mm)	M (mm)	S (mm)
1204	2.00	12.700	0.5	4.76
1504	1.40	15.875	1.1	4.76



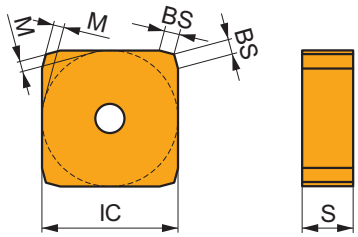
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			M 型，具有前角设计，适用于轻载到中等加工。																	
SNHF 1204ENSR-M:M8330	✱	–	■	235	0.15	4.0	–	–	–	◪	220	0.15	4.0	–	–	–	–	–	–	–	–	–
SNHF 1504ENSR-M:M8340	✱	–	■	220	0.15	6.0	–	–	–	◪	205	0.15	6.0	–	–	–	–	–	–	–	–	–

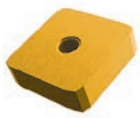
SNHN

PRAMET

	BS (mm)	IC (mm)	M (mm)	S (mm)
1204	1.40	12.700	0.9	4.76
1504	1.40	15.875	1.3	4.76



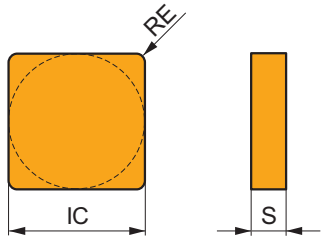
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			ENEN 标准负前角铣削槽型，适用于75°面铣削。																	
SNHN 1204ENEN:8215	⇕	–	◪	275	0.15	6.0	–	–	–	■	260	0.15	6.0	–	–	–	–	–	–	◪	55	0.11	1.0
SNHN 1204ENEN:M8330	⇕	–	◪	270	0.15	6.0	–	–	–	■	255	0.15	6.0	–	–	–	–	–	–	◪	50	0.11	1.0
SNHN 1204ENEN:M8340	⇕	–	◪	245	0.15	6.0	–	–	–	◪	230	0.15	6.0	–	–	–	–	–	–		–	–	–
SNHN 1204ENEN:S26	⇕	–	◪	110	0.15	6.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
SNHN 1504ENEN:8215	⇕	–	◪	260	0.15	9.0	–	–	–	■	245	0.15	9.0	–	–	–	–	–	–	◪	50	0.11	1.3
SNHN 1504ENEN:M8330	⇕	–	◪	260	0.15	9.0	–	–	–	■	245	0.15	9.0	–	–	–	–	–	–	◪	50	0.11	1.3
SNHN 1504ENEN:M8340	⇕	–	◪	235	0.15	9.0	–	–	–	◪	220	0.15	9.0	–	–	–	–	–	–		–	–	–
SNHN 1504ENEN:S26	⇕	–	◪	105	0.15	9.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–

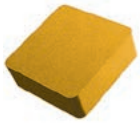
SNUN

PRAMET

	IC (mm)	S (mm)
1204	12.700	4.76
1504	15.875	4.76



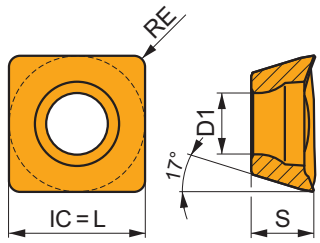
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 E																				
N 负前角槽型铣削刀片，也可以用于车削。																				
SNUN 120408:M8330	⇕	0.8	260	0.13	4.5	–	–	–	245	0.13	4.5	–	–	–	–	–	–	50	0.10	1.0
SNUN 120412:M8330	✱	1.2	275	0.13	4.5	–	–	–	260	0.13	4.5	–	–	–	–	–	–	55	0.10	1.0
SNUN 150412:M8330	✱	1.2	255	0.15	6.0	–	–	–	240	0.15	6.0	–	–	–	–	–	–	50	0.12	1.3

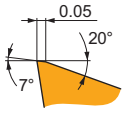
SOMT 05

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.570	2.50	5.57	2.63



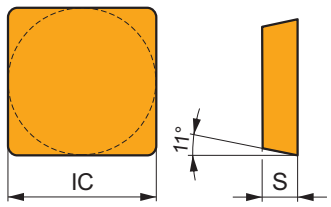
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 U S																				
M 型，具有前角设计，适用于轻载到中等加工。																				
SOMT 050204SR-M:M6330	●	0.4	255	0.05	2.5	180	0.05	2.5	–	–	–	–	–	–	75	0.04	2.0	–	–	–
SOMT 050204SR-M:M8330	●	0.4	290	0.05	2.5	170	0.05	2.5	275	0.05	2.5	–	–	–	70	0.04	2.0	–	–	–
SOMT 050208SR-M:M8330	⇕	0.8	350	0.05	2.5	210	0.05	2.5	330	0.05	2.5	–	–	–	85	0.04	2.0	–	–	–

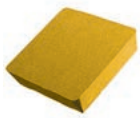
SPGN

PRAMET

	IC (mm)	S (mm)
0903	9.525	3.18
1203	12.700	3.18
1504	15.875	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

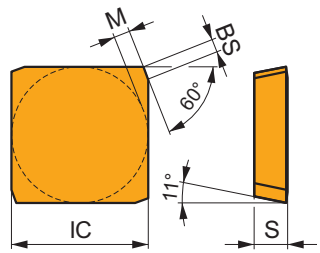
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			E																	
SPGN 090308:M8340		0.8	225	0.15	2.0	–	–	–	210	0.15	2.0	–	–	–	–	–	–	–	–	–
SPGN 120308:M8330		0.8	230	0.15	4.0	–	–	–	215	0.15	4.0	–	–	–	–	–	–	–	–	–
SPGN 150412:M8330		1.2	225	0.20	5.0	–	–	–	210	0.20	5.0	–	–	–	–	–	–	–	–	–

N 平板设计的铣削刀片，也可以用于车削。

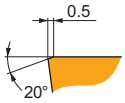
SPGN 25 DZ

PRAMET

	IC (mm)	M (mm)	S (mm)	BS (mm)
2506	25.000	3.5	6.35	2.40



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

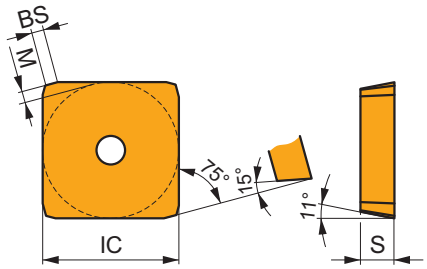
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			1		S															
SPGN 2506DZSR:M8326		–	110	0.50	12.0	–	–	–	100	0.50	12.0	–	–	–	–	–	–	–	–	–
SPGN 2506DZSR:M8346		–	90	0.50	12.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

DZ 型，具有平板设计，适用于重载加工。

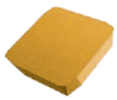
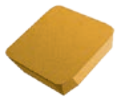
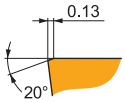
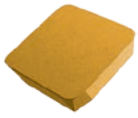
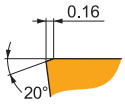
SPKN

PRAMET

	IC (mm)	M (mm)	S (mm)	BS (mm)
1203	12.700	0.9	3.18	1.60
1504	15.875	1.3	4.76	1.70



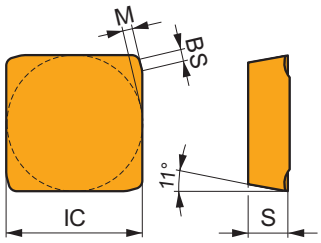
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
EDER 口制备具有平板槽型，适用于轻载到中等加工。																				
SPKN 1203EDER:M8330		–	255	0.15	4.0	–	–	–	240	0.15	4.0	–	–	–	–	–	–	–	–	–
SPKN 1203EDER:M8340		–	230	0.15	4.0	–	–	–	215	0.15	4.0	–	–	–	–	–	–	–	–	–
SPKN 1504EDER:M8330		–	235	0.20	5.0	–	–	–	220	0.20	5.0	–	–	–	–	–	–	–	–	–
SPKN 1504EDER:M8340		–	210	0.20	5.0	–	–	–	195	0.20	5.0	–	–	–	–	–	–	–	–	–
																				
EDSR 口制备，平板槽型，适用于中等加工。																				
SPKN 1203EDSL:M8330		–	240	0.20	4.0	–	–	–	225	0.20	4.0	–	–	–	–	–	–	45	0.13	1.0
SPKN 1203EDSR:M8330		–	240	0.20	4.0	–	–	–	225	0.20	4.0	–	–	–	–	–	–	45	0.13	1.0
SPKN 1203EDSR:M8340		–	215	0.20	4.0	–	–	–	200	0.20	4.0	–	–	–	–	–	–	–	–	–
SPKN 1203EDSR:M9325		–	290	0.20	4.0	–	–	–	275	0.20	4.0	–	–	–	–	–	–	55	0.13	1.0
SPKN 1203EDSR:S26		–	95	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
EDS. EDSR(右手)/EDSL(左手)刃口制备，具有平板槽型，适用于中等加工。																				
SPKN 1504EDSR:8215		–	220	0.25	5.0	–	–	–	205	0.25	5.0	–	–	–	–	–	–	40	0.13	1.3
SPKN 1504EDSR:M8330		–	220	0.25	5.0	–	–	–	205	0.25	5.0	–	–	–	–	–	–	40	0.13	1.3
SPKN 1504EDSR:M8340		–	205	0.25	5.0	–	–	–	190	0.25	5.0	–	–	–	–	–	–	–	–	–
SPKN 1504EDSR:M9315		–	285	0.25	5.0	–	–	–	270	0.25	5.0	–	–	–	–	–	–	55	0.13	1.3
SPKN 1504EDSR:M9325		–	270	0.25	5.0	–	–	–	255	0.25	5.0	–	–	–	–	–	–	50	0.13	1.3
SPKN 1504EDSR:S26		–	90	0.25	5.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

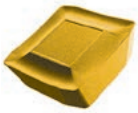
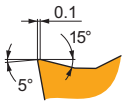
SPKR

PRAMET

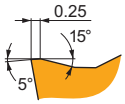
	IC (mm)	L (mm)	M (mm)	S (mm)
1203	12.700	12.70	0.9	3.18
1504	15.875	15.88	1.2	4.76



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
SPKR 1203EDSR:M8330		–	265	0.20	4.0	155	0.18	4.0	250	0.20	4.0	–	–	–	–	–	–	–	–	–
SPKR 1203EDSR:M8340		–	240	0.20	4.0	140	0.18	4.0	225	0.20	4.0	–	–	–	–	–	–	–	–	–

EDSR 口制备，断屑槽型，适用于中等到重载加工。

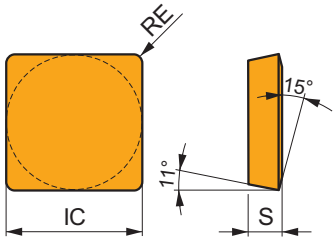
																				
SPKR 1504EDSR:M8330		–	245	0.25	5.0	145	0.25	5.0	230	0.25	5.0	–	–	–	–	–	–	–	–	–
SPKR 1504EDSR:M8340		–	225	0.25	5.0	135	0.25	5.0	210	0.25	5.0	–	–	–	–	–	–	–	–	–

EDSR 口制备，断屑槽型，适用于中等到重载加工。

SPUN

PRAMET

	IC (mm)	S (mm)
1203	12.700	3.18
1504	15.875	4.76
1904	19.050	4.76
2506	25.400	6.35

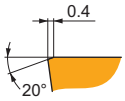


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
SPUN 120304:M8330		0.4	195	0.15	4.0	–	–	–	185	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 120308:M8330		0.8	230	0.15	4.0	–	–	–	215	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 120308:S26		0.8	95	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SPUN 120312:M8330		1.2	245	0.15	4.0	–	–	–	230	0.15	4.0	–	–	–	–	–	–	–	–	–

N 平板槽型铣削刀片，也可以用于车削。

线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
SPUN 150412:M8330		1.2	225	0.20	5.0	–	–	–	210	0.20	5.0	–	–	–	–	–	–	–	–	–
SPUN 190408:M8330		0.8	210	0.20	6.0	–	–	–	195	0.20	6.0	–	–	–	–	–	–	–	–	–
SPUN 190412:M8330		1.2	220	0.20	6.0	–	–	–	205	0.20	6.0	–	–	–	–	–	–	–	–	–
																				
SPUN 250616S:M8326		1.6	115	0.40	12.0	–	–	–	105	0.40	12.0	–	–	–	–	–	–	–	–	–
SPUN 250620S:M5326		2.0	145	0.40	12.0	–	–	–	135	0.40	12.0	–	–	–	–	–	–	–	–	–
SPUN 250620S:M8326		2.0	120	0.40	12.0	–	–	–	110	0.40	12.0	–	–	–	–	–	–	–	–	–
SPUN 250620S:M8346		2.0	100	0.40	12.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SPUN 250620S:S26		2.0	45	0.40	12.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

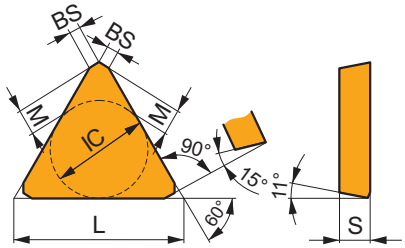
N 平板槽型铣削刀片，也可以用于车削。

N 平板槽型铣削刀片，也可以用于车削。

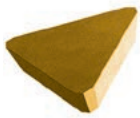
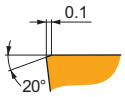
TPCN 16

PRAMET

	BS (mm)	IC (mm)	L (mm)	M (mm)	S (mm)
1603	1.20	9.530	16.10	2.5	3.18



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

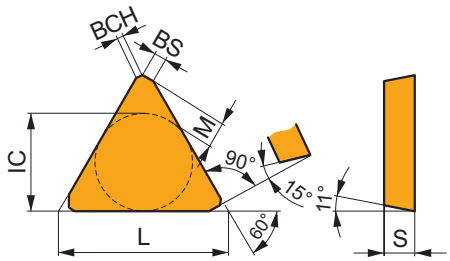
产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
TPCN 1603PDSN:M8330		–	195	0.20	–	–	–	–	185	0.20	–	–	–	–	–	–	–	–	–	–

XNCB 非标设计，适用于盘铣刀。

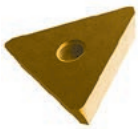
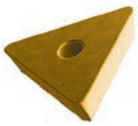
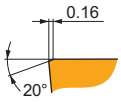
TPKN

PRAMET

	IC (mm)	L (mm)	M (mm)	S (mm)	BCH (mm)	BS (mm)
1603	9.530	16.50	2.5	3.18	1.20	1.30
2204	12.700	22.00	3.5	4.76	1.20	1.50



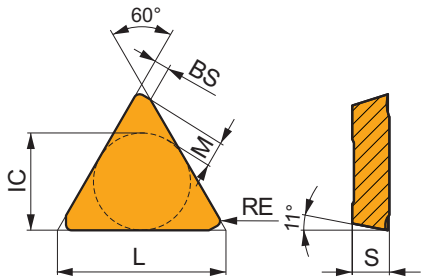
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	●	⬌	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
				E																	
PDER 口制备，平板槽型，适用于轻载到中等加工。																					
TPKN 1603PDER:M8330	●	–	◪	195	0.15	4.0	–	–	–	◪	185	0.15	4.0	–	–	–	–	–	–	–	–	–	–
TPKN 1603PDER:M8340	●	–	◪	175	0.15	4.0	–	–	–	◪	165	0.15	4.0	–	–	–	–	–	–	–	–	–	–
TPKN 2204PDER:8215	●	–	◪	190	0.15	5.5	–	–	–	◪	180	0.15	5.5	–	–	–	–	–	–	–	–	–	–
TPKN 2204PDER:M8330	●	–	◪	190	0.15	5.5	–	–	–	◪	180	0.15	5.5	–	–	–	–	–	–	–	–	–	–
TPKN 2204PDER:M8340	●	–	◪	170	0.15	5.5	–	–	–	◪	160	0.15	5.5	–	–	–	–	–	–	–	–	–	–
				U	S																
PDSR 口制备，平板槽型，适用于中等加工。																					
TPKN 1603PDSR:M8330	●	–	◪	185	0.20	4.0	–	–	–	◪	175	0.20	4.0	–	–	–	–	–	–	◪	35	0.13	0.8
TPKN 1603PDSR:M8340	⬌	–	◪	165	0.20	4.0	–	–	–	◪	155	0.20	4.0	–	–	–	–	–	–		–	–	–
TPKN 1603PDSR:S26	●	–	◪	75	0.20	4.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
TPKN 2204PDSR:M8310	●	–	◪	195	0.20	5.5	–	–	–	◪	185	0.20	5.5	–	–	–	–	–	–	◪	35	0.13	1.0
TPKN 2204PDSR:M8330	⬌	–	◪	175	0.20	5.5	–	–	–	◪	165	0.20	5.5	–	–	–	–	–	–	◪	35	0.13	1.0
TPKN 2204PDSR:M8340	⬌	–	◪	160	0.20	5.5	–	–	–	◪	150	0.20	5.5	–	–	–	–	–	–		–	–	–
TPKN 2204PDSR:M9325	●	–	◪	220	0.20	5.5	–	–	–	◪	205	0.20	5.5	–	–	–	–	–	–	◪	40	0.13	1.0
TPKN 2204PDSR:S26	●	–	◪	75	0.20	5.5	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–

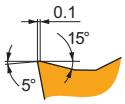
TPKR

PRAMET

	IC (mm)	L (mm)	M (mm)	S (mm)	BS (mm)
1603	9.530	16.50	2.5	3.18	1.40
2204	12.700	22.00	3.5	4.76	1.40



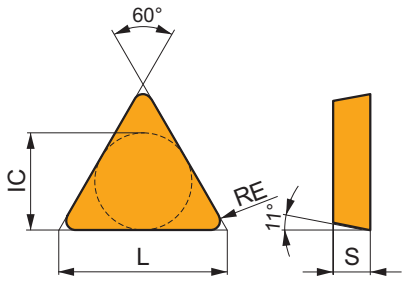
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 1 S																				
PDSR 口制备，断屑槽型，适用于中等到重载加工。																				
TPKR 1603PDSR:M8330	⇕	–	185	0.20	4.0	110	0.18	4.0	175	0.20	4.0	–	–	–	–	–	–	–	–	–
TPKR 1603PDSR:M8340	⇕	–	165	0.20	4.0	95	0.18	4.0	155	0.20	4.0	–	–	–	–	–	–	–	–	–
TPKR 2204PDSR:M8330	⇕	–	175	0.20	5.5	105	0.18	5.5	165	0.20	5.5	–	–	–	–	–	–	–	–	–
TPKR 2204PDSR:M8340	⇕	–	160	0.20	5.5	95	0.18	5.5	150	0.20	5.5	–	–	–	–	–	–	–	–	–
TPKR 2204PDSR:M9325	●	–	220	0.20	5.5	–	–	–	205	0.20	5.5	–	–	–	–	–	–	–	–	–

TPUN

PRAMET

	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18
2204	12.700	22.00	4.76



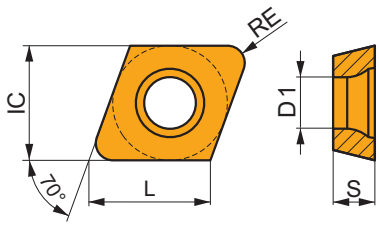
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
E																				
N 平板槽型铣削刀片，也可以用于车削。																				
TPUN 110304:M8330	●	0.4	–	–	–	–	–	–	150	0.10	1.2	–	–	–	–	–	–	30	0.10	0.4
TPUN 160304:8215	●	0.4	155	0.15	4.0	–	–	–	145	0.15	4.0	–	–	–	–	–	–	–	–	–
TPUN 160304:H10	●	0.4	–	–	–	–	–	–	65	0.15	4.0	–	–	–	–	–	–	–	–	–
TPUN 160304:M8330	●	0.4	155	0.15	4.0	–	–	–	145	0.15	4.0	–	–	–	–	–	–	–	–	–
TPUN 160304:S26	●	0.4	65	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TPUN 160308:8215	●	0.8	185	0.15	4.0	–	–	–	175	0.15	4.0	–	–	–	–	–	–	–	–	–
TPUN 160308:M8330	⇕	0.8	–	–	–	–	–	–	155	0.18	1.5	–	–	–	–	–	–	30	0.11	0.6
TPUN 160312:M8330	⇕	1.2	–	–	–	–	–	–	155	0.20	1.5	–	–	–	–	–	–	30	0.11	0.8
TPUN 220408:M8330	●	0.8	170	0.20	5.0	–	–	–	160	0.20	5.0	–	–	–	–	–	–	–	–	–
TPUN 220412:M8330	⇕	1.2	–	–	–	–	–	–	155	0.20	2.0	–	–	–	–	–	–	30	0.11	1.0

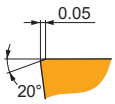
XDHW

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.500	2.95	6.90	2.38
10T3	10.000	3.95	10.60	3.97



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
XDHW 070210EN:M8310		1.0	310	0.10	1.0	–	–	–	290	0.10	1.0	–	–	–	–	–	–	60	0.05	1.0
																				
XDHW 070210SN:M8310		1.0	310	0.10	1.0	–	–	–	290	0.10	1.0	–	–	–	–	–	–	60	0.05	1.0
XDHW 070210SN:M8325		1.0	230	0.10	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
XDHW 10T310SN:M8310		1.0	275	0.15	1.0	–	–	–	260	0.15	1.0	–	–	–	–	–	–	55	0.08	1.0
XDHW 10T310SN:M8325		1.0	210	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

EN 型，具有平板设计，适用于铣槽。

SN 型，具有平板设计，适用于铣槽。

说明

1 **SAD11E**

P M K N S H 2

PRAMET 3 S

4

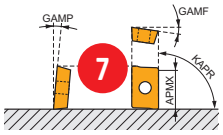
FORCE AD11带内冷的方肩铣刀

90°方肩铣刀和面铣刀，使用正前角AD..　11类型刀片，具有APMX(最大切深)9mm。适用于面铣，方肩铣，铣槽，螺旋铣削，摆线加工，坡走铣和插铣。可提供圆柱柄，侧固柄，莫氏锥柄，模块夹紧系统和芯轴式(具有不等齿距)类型。刀体经过处理，使用寿命更长。 5

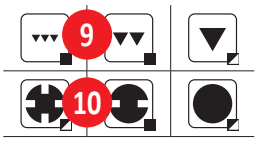
FORCE AD

KAPR	90°
APMX	9.0 mm

6

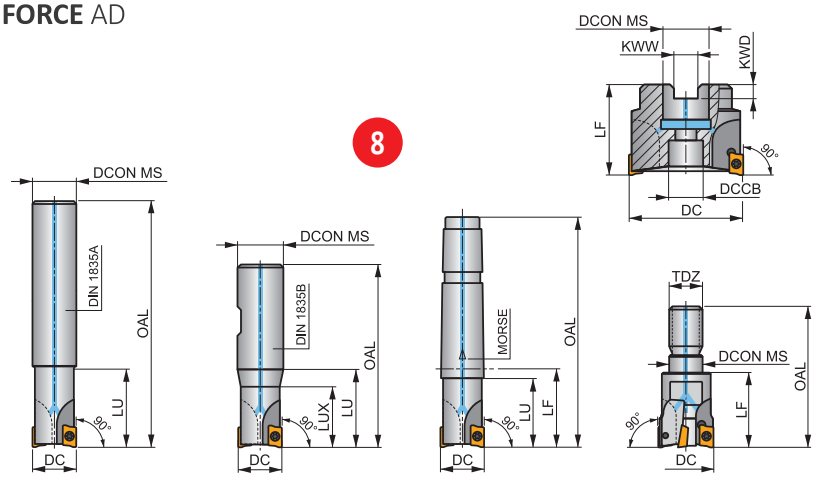


7



9 10

8



11

12

	产品型号	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	16	17	18 max.	19	20 kg	21	22	23
	16A2R024A14-SAD11E-C	16	160	14	–	24	–	–	–	–	–	–	-12.8	4	2		30100	✓	0.19	GI169	SQ025	
	16A2R024A16-SAD11E-C	16	135	16	–	24	–	–	–	–	–	–	-12.8	4	2		30100	✓	0.19	GI169	SQ025	
	16A2R050A16-SAD11E-C	16	135	16	–	50	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.20	GI169	SQ025	–
	18A2R029A20-SAD11E-C	18	150	20	–	29	–	–	–	–	–	–	-12	4.5	2	–	28400	✓	0.35	GI169	SQ025	–
	20A2R029A20-SAD11E-C	20	150	20	–	29	–	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.33	GI169	SQ020	–
	20A2R07[illegible]-SAD11E-C	20	150	20	–	70	–	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.32	GI169	SQ020	–
	20A3R0[illegible]SAD11E-C	20	200	18	–	29	–	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.36	GI169	SQ025	–
	20A3R029A20-SAD11E-C	20	150	20	–	29	–	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.31	GI169	SQ025	–
DIN 1835A	22A3R029A20-SAD11E-C	22	200	20	–	29	–	–	–	–	–	–	-11.5	5	3	–	25600	✓	0.45	GI169	SQ025	–
	25A3R034A25-SAD11E-C	25	170	25	–	34	–	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.42	GI169	SQ020	–
	25A3R080A25-SAD11E-C	25	170	25	–	80	–	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.52	GI169	SQ020	–
	25A4R034A25-SAD11E-C	25	170	25	–	34	–	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.56	GI169	SQ025	–
	25A4R040A25-SAD11E-C	25	250	25	–	40	–	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.85	GI169	SQ025	–
	30A3R080A32-SAD11E-C	30	200	32	–	80	–	–	–	–	–	–	-9.3	7	3	–	22000	✓	0.98	GI169	SQ020	–
	32A3R080A32-SAD11E-C	32	195	32	–	80	–	–	–	–	–	–	-9	5	3	–	21300	✓	0.80	GI169	SQ020	–

13 14 15

GI169	ADMX 11T3..	ADEX 11T3..

24

		Nm						
SQ020	US 62506-T07P	1.2	M 2.5	6	–	–	Flag T07P	–
SQ021	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	–
SQ022	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ023	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	HS 1030C
SQ025	US 62505-T07P	1.2	M 2.5	5	–	–	Flag T07P	–

25

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

26

所示为可转位铣刀的典型页面 – 具体页面详情可能不同。

可转位铣刀 – 页面概览

图号	说明
1	铣刀名称
2	推荐的材料组
3	刀片夹紧机构
4	实物图
5	刀具简介
6	主偏角和最大理论切削深度(mm)
7	刀具槽型
8	刀具示意图
9	可实现的表面质量
10	切削特点/工况
11	立铣刀和/或套式铣刀的最大平均切屑厚度范围[mm]
12	产品应用
13	刀柄类型

图号	说明
14	铣刀的ISO代码
15	尺寸(mm)、角度[1][°]和连接尺寸代码
16	齿数
17	不等齿距
18	铣刀最大转数
19	内冷供应
20	重量 (kg)
21	兼容刀片组[2]
22	备件组[2]
23	专用附件组[2]
24	兼容刀片
25	备件
26	专用附件

[1] γ_f = 刀片座的径向前角（GAMF）– 参见可转位铣刀技术信息
γ_p = 刀片座轴向前角（GAMP）– 参见可转位铣刀技术信息

[2] 备件和专用附件图标设计为易于理解的示意图。它们不包含在图标列表中。在某些情况下，螺钉信息包括扭矩值（Nm）、螺钉长度和螺纹尺寸。

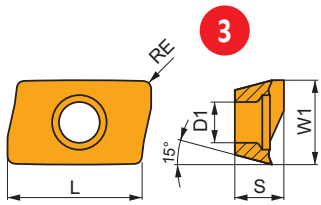
铣削刀片 – 页面概览

1 **ADMX 11**

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.530	2.90	11.00	3.97

2



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
4			23° 0.06 5			6 S			F 型，具有非常锋利正前角设计，适用于轻载加工。									10		
ADMX 11T304SR-F:8215	●	0.4	245	0.10	2.0	145	0.09	2.0	230	0.10	2.0	735	0.12	2.0	60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8330	●	0.4	240	0.10	2.0	140	0.09	2.0	225	0.10	2.0	720	0.12	2.0	60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8340	●	0.4	220	0.10	2.0	130	0.09	2.0	205	0.10	2.0	–	–	–	55	0.08	1.6	–	–	–
ADMX 11T[illegible]F:M9340	●	0.4	285	0.10	2.0	170	0.09	2.0	–	–	–	–	–	–	70	0.08	1.6	–	–	–
ADMX 11T[illegible]F:8215	●	0.4	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8330	✱	0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8340	✱	0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	–	–	–	65	0.08	1.6	–	–	–
ADMX 11T308SR-F:M9340	✱	0.8	340	0.10	2.0	200	0.09	2.0	–	–	–	–	–	–	85	0.08	1.6	–	–	–

7 8 9 11

图号	说明
1	刀片名称
2	刀片尺寸表 (mm)
3	刀片示意图
4	相应刀片的图片
5	主切削刃廓形
6	图标 – 特征和切削刃类型

图号	说明
7	ISO刀片代码: 涂层
8	Working conditions
9	刀尖半径 [mm]
10	槽形
11	刀片的应用领域 [1]

[1] “技术”部分的铣削章节结尾给出了有关线速度校正的建议。

铣刀页面后的技术信息包括铣刀兼容的刀片以及起始线速度信息。这些信息能够帮助你正确使用刀具。如果不确定如何使用或解读这些信息，请参考铣削章节末尾的“技术”部分，或者联系Dormer Pramet经销商。

所示为铣削刀片的典型页面 – 具体页面详情可能不同。大部分刀片可在此产品目录中相关铣刀后面或者单独的刀片章节中找到。

图标概览

通用图标

■	主要使用
◪	可以使用

▼▼▼	精加工
▼▼	中等精度加工
▼	粗加工

●	适用于稳定工况
	适用于不稳定工况
	适用于非常不稳定的工况

铣削操作

	平面铣
	浅方肩铣
	深方肩铣
	浅槽铣
	深槽铣

	插铣
	连续钻铣
	坡走铣
	螺旋插补
	对预钻孔进行螺旋插补

	倒角铣
	T形槽铣
	背面铣削
	波状表面(仿形铣)

特点

1	首选
U	应用广泛的多用途选项
W	具有修光刃槽型的刀片

	薄壁和细长工件
	长悬伸
HFC	快进给切削

	重载作业条件

切削刃状态码(CECC)

F	锐利刃口
E	刃口圆弧倒棱

T	刃口T型倒棱
S	刃口S型倒棱

P	刃口两次S型倒棱

夹紧类型代码(MTP)

S	系统 S
C	C-型顶部夹紧

F	系统 F
S(C)	系统 SC

Nm	螺钉的夹紧力矩 (Nm)

图标概览

柄部

DIN 1835A	DIN1835A圆柱刀柄	ISO/DIS 7388-1	刀柄DIN69871-1	ISO 6462 DIN 8030	套式铣刀DIN8030-螺旋式铣刀
DIN 1835B	DIN1835B侧固刀柄	ISO 297	刀柄DIN2080-1	ISO 6462 DIN 8030	套式铣刀DIN8030-盘式铣刀
DIN 228A	莫氏刀柄DIN228-1	JIS B 6339	刀柄MASBT(JIS-B-6339)		
MODULAR	螺纹接头	ISO 6462 DIN 8030	套式铣刀DIN8030		

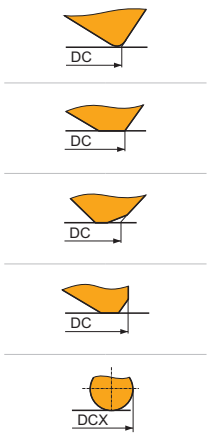
技术参数

a_e/DC	径向切削宽度与切削直径之比(%)	a_p	切削深度 (mm)		齿数
a_e/DCX	径向切削宽度与最大切削直径之比(%)	DC	刀具直径 (mm)	APMX	刀具有效加工长度(mm)
X.V	线速度的倍增因数	DCX	刀具最大直径(mm)		齿数（螺旋刀具）
⇨x.f	进给的倍增因数（沿中心线加工）	DEF	刀具的有效直径 (mm)	CDX	刀具有效范围(mm)
⇨x.f	进给的倍增因数（偏离中心线加工）	$a_{e\,max}$	加工区域的最大宽度(mm)		有效齿数
	断屑槽	max	钻铣的切削深度 (mm)		切削锥的角度(°)
RE	刀片刃角半径(mm)	RPMX	坡走铣的最大角度 (°)		使用的切刃数
BS	修光刃长度(mm)	APMX/I	整个切削长度上的最大切削深度 (mm)		孔直径(mm)
f ⇨	进给 (mm/齿)	SMAX DMAX	最大孔径处的每转最大切削深度 (mm)	µm	加工表面的粗糙度Ra (mm)
1 ⇨f	初始进给 (mm/齿)	SMAX DMIN	最小孔径处的每转最大切削深度 (mm)		螺距
f_{min} ⇨	最小进给(mm/齿)	FE	逆铣的轮廓铣梯度(mm)	1 2 3 /1"	牙数
f_{max} ⇨	最大进给(mm/齿)	FE	上/下横向铣削的轮廓铣梯度(mm)		时间(min)

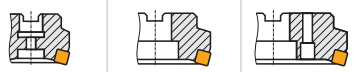
ISO规格 – 玉米铣刀体

	1	2	3	4		5	6	7	8	9	10	11	12
ISO	63	A	06	R	–		S	90	A	D	16	E	
ANSI	300	F	04	N	–	I	S	90	S	N	12	N	4

1 切削直径

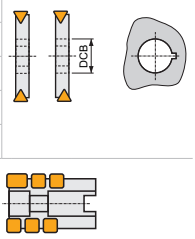


2 刀体类型, 规格及装夹尺寸



A ISO 6462/A DIN 8030/A	B ISO 6462/B DIN 8030/B	C ISO 6462/C DIN 8030/C

F	DC = 27 mm	DC = 1.000
G	DC = 32 mm	DC = 1.250
H	DC = 40 mm	–
J	DC = 50 mm	–
K	DC = 60 mm	–
M	DC = 80 mm	–
T		



3 齿数

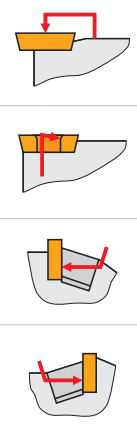
4 切削方向

R	
L	
N	

5 标准

I	(")

6 夹紧类型

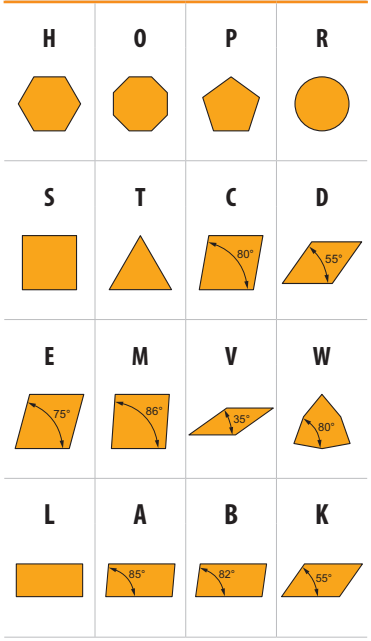


C	
S	
W	
F	

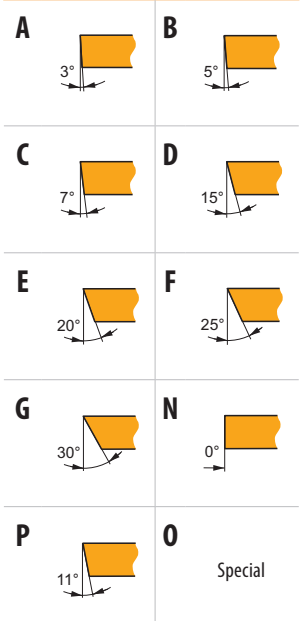
7 主偏角 (KAPR)

90°	
75°	
60°	
45°	
M0	

8 刀片形状



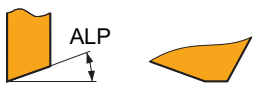
9 后角



10 切削刃长度

IC (mm)	(")	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32"							1.2"						
4.76					04	08	04	05	04	04	08	L3		
	3/16"							1.5"						
5.56					05	09	05	06	05	05	09	03		
	7/32"							1.8"						
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"							2"						
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"							2.5"						
9.525		05	04	07	09	16	09	11	09	09	16	06	09	19
	3/8"							3"						
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"							4"						
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"							5"						
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"							6"						
25.4		14	10	18	25	44	25	31	26	25	44	17	25	
	5/1"							8"						
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"							10"						

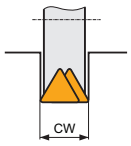
11 修光刃后角



N ALP = 0°	C ALP = 7°	P ALP = 11°
D ALP = 15°	E ALP = 20°	F ALP = 25°

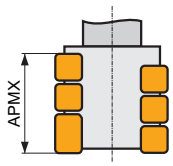
12 切削刃长度(或宽度)

CW (mm) / (")



CW	1/16"
0.156	2.5
0.187	3
0.250	4
0.313	5
0.375	6

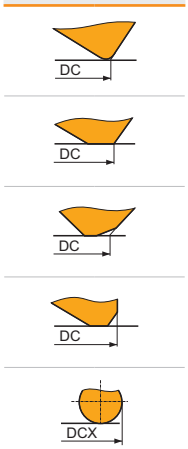
APMX



ISO代码 – 方肩立铣刀

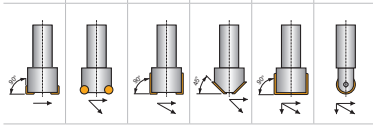
	1	2	3	4	5	6	7		8	9	10	11	12	13
ISO	32	A	4	R	042	B	32	–		S	A	D	11	E
ANSI	125	A	4	R	150	W	125	–	I	S	A	D	11	E

1 切削直径



2 刀杆类型和主偏角

A	E	J	N	H	K



5 悬伸

(mm)
(")

3 齿数

4 切削方向

R	L	N

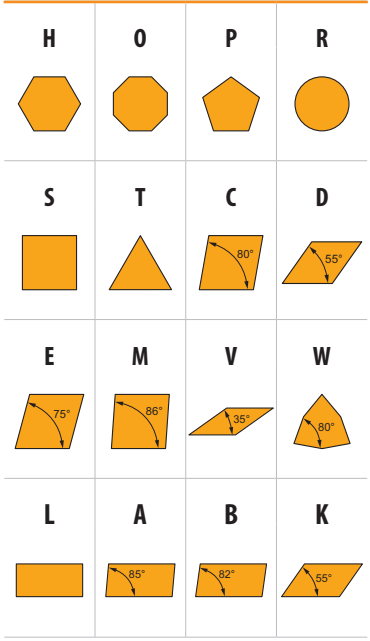
6 刀杆类型

A	C	DIN 1835A	
B	W	ISO 3338-2, DIN 1835B	
E	-	ISO 296, DIN 228-1	
G	-	ISO 297, DIN 208-1	
H	-	ISO/DIS 7388-1, DIN 69871-1	
N	-	ISO 12 164-1, DIN 69893	
-	R8	R8	
X	-	MAS BT	
XC	-	CAPTO	
-	CA	ANSI B5.50	

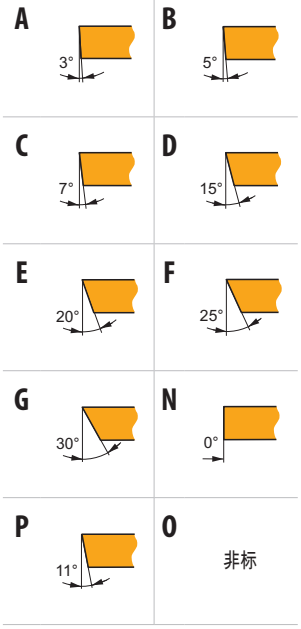
7 刀杆尺寸

6 – 40 mm	.250" – 1.250"
6 – 50 mm	.375" – 2.000"
1 – 6	–
40 – 50 mm	–
30 – 50 mm	–
25 – 100 mm	–
–	1.250"
30 – 50	–
3 – 10	–
–	40 / 50

10 刀片形状



11 后角



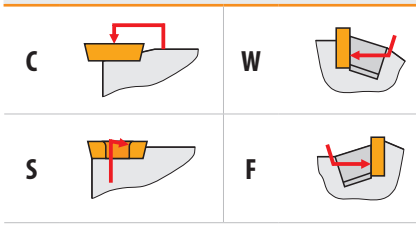
12 切削刃长度

IC (mm)	(")	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32"							1.2"						
4.76					04	08	04	05	04	04	08	L3		
	3/16"							1.5"						
5.56					05	09	05	06	05	05	09	03		
	7/32"							1.8"						
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"							2"						
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"							2.5"						
9.525		05	04	07	09	16	09	11	09	09	16	06	09	19
	3/8"							3"						
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"							4"						
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"							5"						
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"							6"						
25.4		14	10	18	25	44	25	31	26	25	44	17	25	
	5/1"							8"						
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"							10"						

8 标准

I	(")

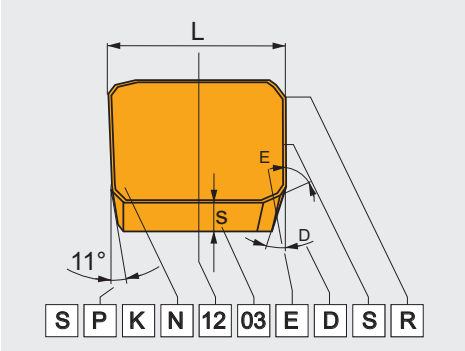
9 夹紧类型



13 修光刃后角

N ALP = 0°	**C** ALP = 7°	**P** ALP = 11°
D ALP = 15°	**E** ALP = 20°	**F** ALP = 25°

ISO代码 – 铣刀刀片



	1	2	3	4
ISO	S	P	G	N
	S	P	K	N
ANSI	S	P	G	
	S	P	K	N

1 刀片形状

H	O	P	R
S	T	C (80°)	D (55°)
E (75°)	M (86°)	V (35°)	W (80°)
L	A (85°)	B (82°)	K (55°)

2 后角

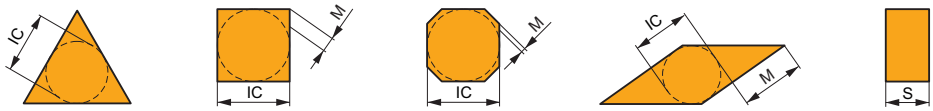
A	3°	B	5°
C	7°	D	15°
E	20°	F	25°
G	30°	N	0°
P	11°	O	非标

4 刀片类型

N		
R		
F		
A		
M		
G		
W	40 – 60°	
T		
Q		
U		
B	70 – 90°	
H		
C		
J		
X	非标	

3 公差

	(mm)			(″)		
	M (±)	S (±)	IC (±)	M (±)	S (±)	IC (±)
A	0.005	0.025	0.025	0.0002″	0.001″	0.0010″
F	0.005	0.025	0.013	0.0002″	0.001″	0.0005″
C	0.013	0.025	0.025	0.0005″	0.001″	0.0010″
H	0.013	0.025	0.013	0.0005″	0.001″	0.0005″
E	0.025	0.025	0.025	0.0010″	0.001″	0.0010″
G	0.025	0.130	0.025	0.0010″	0.005″	0.0010″
J	0.005	0.025	0.05 – 0.13	0.0002″	0.001″	0.002″ – 0.005″
K	0.013	0.025	0.05 – 0.13	0.0005″	0.001″	0.002″ – 0.005″
L	0.025	0.025	0.05 – 0.13	0.0010″	0.001″	0.002″ – 0.005″
M	0.08 – 0.18	0.130	0.05 – 0.13	0.003″ – 0.007″	0.005″	0.002″ – 0.005″
N	0.08 – 0.18	0.025	0.05 – 0.13	0.003″ – 0.007″	0.001″	0.002″ – 0.005″
U	0.05 – 0.38	0.130	0.05 – 0.13	0.005″ – 0.015″	0.005″	0.003″ – 0.010″



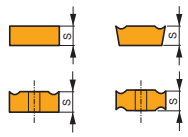
ISO代码 – 铣刀刀片

5	6	7		8	9		10
12	03	08					
12	03	ED		S	R	-	
5a	6a	7a		8	9		
4	2	2					
4	2	ED		S	R	-	

5 / 5 切削刃长度

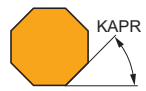
I.C. (mm)	(″)	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32″	1.2″												
4.76					04	08	04	05	04	04	08	L3		
	3/16″	1.5″												
5.56					05	09	05	06	05	05	09	03		
	7/32″	1.8″												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4″	2″												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16″	2.5″												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	19
	3/8″	3″												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2″	4″												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8″	5″												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4″	6″												
25.4		14	10	18	25	44	25	31	26	25	44	17	25	
	5/1″	8″												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4″	10″												

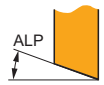
6 厚度



符号	S (mm)	S (″)
01	1.59	1/16″
T1	1.98	5/64″
02	2.38	3/32″
03	3.18	1/8″
T3	3.97	5.32″
04	4.76	3/16″
05	5.56	7/32″
06	6.35	1/4″
07	7.94	5/16″
09	9.52	3/8″

7 切削刃角度 / 后角



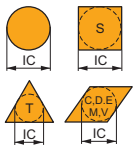


	KAPR		ALP
A	45°	A	3°
D	60°	B	5°
E	75°	C	7°
F	85°	D	15°
P	90°	E	20°
Z	非标	F	25°
		G	30°
		N	0°
		P	11°
		Z	非标

ZZ – 非标

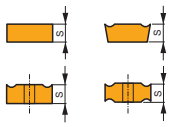
ANSI

5a 内切圆



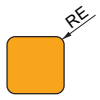
符号	I.C. (mm)	I.C. (″)
1	3.175	1/8″
1.2	3.969	5/32″
1.5	4.763	3/16″
1.8	5.556	7/32″
2	6.350	1/4″
2.5	7.938	5/16″
3	9.525	3/8″
4	12.700	1/2″
5	15.875	5/8″
6	19.050	3/4″
7	22.225	7/8″
8	25.400	1″
10	31.750	5/4″
12	38.100	6/4″

6a 厚度



符号	S (mm)	S (″)
1	1.588	1/16″
1.2	1.984	5/64″
1.5	2.381	3/32″
2	3.175	1/8″
2.5	3.969	5/32″
3	4.763	3/16″
3.5	5.556	7/32″
4	6.350	1/4″
5	7.938	5/16″
6	9.525	3/8″
7	11.113	7/16″
8	12.700	1/2″
9	14.288	9/16″
10	15.875	5/8″

7a 刀尖圆角

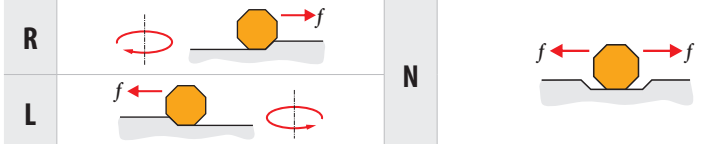


符号	RE (mm)	RE (″)
0	0	0″
0.2	0.099	1/256″
0.5	0.198	1/128″
1	0.397	1/64″
2	0.794	1/32″
3	1.191	3/64″
4	1.588	1/16″
5	1.984	5/64″
6	2.381	3/32″
7	2.778	7/64″
8	3.175	1/8″
10	3.969	5/32″
12	4.763	3/16″
14	5.556	7/32″
16	6.350	1/4″

8 / 8 刃口处理

F	锋利刃口	E	刃口圆弧倒棱
T	刃口T型倒棱	S	刃口S型倒棱
K	刃口两次倒棱	P	刃口两次S型倒棱

9 / 9 进给方向



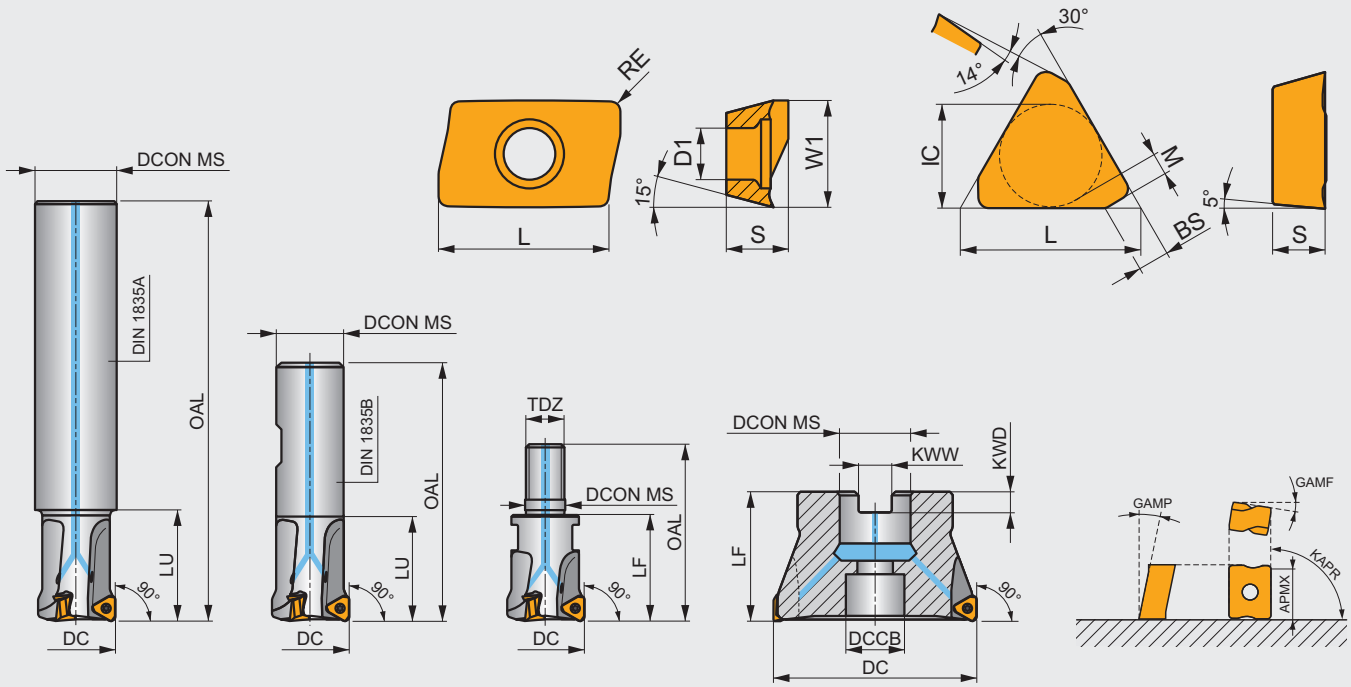
10 / 10 断屑槽类型

ISO 13399标准切削刀具参数

所有切削工具由一系列参数依据标准ISO 13399定义。此列表包含本目录中使用的所有参数及其定义。

ISO 13399是一项国际切削刀具信息标准。它以独立于任何特定系统或公司术语的中立格式提供尺寸和参数。当切削刀具按照全球标准进行明确定义时，所有类型的软件都可以更快地处理电子数据、提高通信质量并帮助信息交换顺利进行。在我们的切削刀具描述中支持一种通用语言，这将有助于系统间的通信。这将为您节省大量时间，通过我们的40,000个整体式可转位刀具更容易地收集高质量数据。通过使用符合ISO 13399标准的系统，不再需要手动解读数据并将其输入到系统中。

仅为示例！



ISO 13399 代码	说明
APMX	最大切削深度
BD	刀体直径
BDX	刀体最大直径
BCH	刀尖倒角长度
BS	修光刃长度
CBDP	连接孔深度
CDI	刀片切削直径
CDX	最大切削深度
CW	切削宽度
CZC MS	机床侧接头尺寸代码
D1	固定孔直径
DAH4	检修孔直径
DAH5	检修孔直径
DAH6	检修孔直径
DBC1	螺栓圆周直径1
DBC2	螺栓圆周直径2
DBC4	螺栓圆周直径
DBC5	螺栓圆周直径
DBC6	螺栓圆周直径

ISO 13399 代码	说明
DC	切削直径
DCB	连接孔直径
DCCB	连接沉孔直径
DCN	最小切削直径
DCON MS	刀柄直径
DCX	最大切削直径
DHUB	毂直径
DN	缩颈直径
GAMF	径向前角
GAMP	轴向前角
CHW	刀尖倒角宽度
IC	内切圆直径
INSD	刀片直径
INSL	刀片长度
KAPR	刀具主偏角
KWD	键槽深度
KWW	键槽宽度
L	切削刃长度
LB	刀体长度
LE	切削刃有效长度

ISO 13399 代码	说明
LF	有效长度
LH	刀头长度
LU	可用长度
LUX	最大可用长度
M	M-尺寸
NOF	刃数
OAL	总长度
P	刀片的螺距
PRFA	轮廓角度
PRFRAD(2)	轮廓半径
RE	刀尖半径
S	刀片厚度
S1	刀片总厚度
TDZ	螺纹直径尺寸
TP	螺纹螺距
TPI	每英寸螺纹牙数
W1	刀片宽度
ZNP	齿数

铣削涂层 – 概览

集团	使用MTCVD的硬质合金	带PVD的硬质合金	无涂层
P01		M8310	
P05	M9315		
P10		8215	
P15	M9325		
P20		M8330	
P25			
P30		M8340	
P35		M8345	
P40			
P45			
P50			

集团	使用MTCVD的硬质合金	带PVD的硬质合金	无涂层
M01			
M05			
M10			
M15			
M20		M6330	
M25		M8340	
M30	M9340	M8345	
M35			
M40			
M45			
M50			

集团	使用MTCVD的硬质合金	带PVD的硬质合金	无涂层
K01		M4303	
K05	M5315	M8310	
K10		M4310	
K15			
K20		8215	
K25			
K30		M8330	
K35			
K40			
K45			
K50			

集团	使用MTCVD的硬质合金	带PVD的硬质合金	无涂层
N01			
N05		M0315	
N10		8215	HF7
N15			
N20			
N25			
N30			
N35			
N40			
N45			
N50			

集团	使用MTCVD的硬质合金	带PVD的硬质合金	无涂层
S01			
S05			
S10			
S15	M9340		
S20		M6330	
S25		M8340	
S30		M8345	
S35			
S40			
S45			
S50			

集团	使用MTCVD的硬质合金	带PVD的硬质合金	无涂层
H01		M4303	
H05	M5315	2003	
H10		M4310	
H15		M8310	
H20		8215	
H25			
H30			
H35			
H40			
H45			
H50			

铣削涂层 – 概览

材质	ISO应用范围	适用工况	进给范围	线速度范围	不稳定工况适用性	涂层	颜色	基体	冷却液影响	切割材料的描述
M8345	P30 – P50 M30 – M40	■ ■			+	PVD		H	-	这种材料具有特殊的操作可靠性，是为在恶劣条件下对困难和坚韧的材料进行重负荷切割而设计的。
M6330	P20 – P35 M20 – M35 S20 – S30	■ ■ ■				PVD		H	+ / -	铣削材料，具有卓越的操作可靠性。特别适用于加工难以加工的材料。在恶劣条件和难于切割的应用中，具有强大的功能。
M4303	P01 – P10 K01 – K10 N01 – N10 H01 – H10	◪ ■ ◪ ■				PVD		ultra submicron H	-	在模具加工中具有最高耐磨性的材料。在稳定的切削条件下，在高切削速度和低进给的情况下，提供卓越的性能。适用于困难工件材料的精加工操作。
M4310	P05 – P15 M05 – M15 K05 – K15 S05 – S10 H05 – H15	◪ ◪ ■ ■ ■				PVD		ultra submicron H	-	一种用于模具加工的多功能材料。适用于精加工和半粗加工的操作。这种涂层的产品结合了高耐磨性和卓越的操作可靠性。
2003	P01 – P10 M01 – M10 K01 – K10 S05 – S10 H05 – H15	◪ ◪ ■ ■ ◪				PVD		ultra submicron H	-	具有优良的耐磨性的铣削材料。最适合在稳定的切削条件和中/高切削速度下加工硬质和高强度材料。适用于切割除有色金属以外的其他工件组材料
M0315	N05 – N25	■				PVD		submicron H	-	用于铣削有色金属及其合金的亚微米级材料，具有平衡的耐磨性和韧性比例。它有一个独特的涂层，具有出色的摩擦性能。
M8326	P20 – P40 M15 – M30	■ ◪				PVD		H	-	专用于重型加工的涂层。此涂层主要用于加工“柔性状态”下的所有类型的钢（包括不锈钢）。它还可用于加工较软的铸铁。适合在普通切削工况下进行中速M15 – M30加工。
M8346	P30 – P50 M30 – M40	■ ■			+	PVD		H	-	专用于重型加工的涂层。此涂层具有出色的加工可靠性，用于在不利工况下对难加工的坚韧材料进行重型切削。
S26	P15 – P30	■				–		S	+ +	无涂层的铣削材料，具有良好的抗切削表面侵蚀能力。专门为低速加工碳钢和合金钢而设计。
S45	P30 – P45	■			+	–		S	+ +	无涂层的坚韧材料，适用于低切削速度和不利切削条件下的加工。
HF7	M10 – M20 K10 – K25 N10 – N25	◪ ■ ■				–		submicron H	+ +	一种无涂层的材料，主要用于加工非铁金属。它也可用于加工其他材料（钢除外）。这种材料可用于车削、铣削，甚至是镗削。

铣削涂层 – 概览

材质	ISO应用范围	适用工况	进给范围	线速度范围	不稳定工况适用性	涂层	颜色	基体	冷却液影响	切割材料的描述
M9315	P05 – P25 K10 – K30 H10 – H20	■ ■ ◪				MT-CVD		H	- - -	一种即使在高热负荷下也具有高耐磨性的铣削材料，主要的应用范围是较高的切削速度和中等或小的切削深度。
M9325	P10 – P30 K10 – K30 H15 – H20	■ ■ ◪				MT-CVD		H	- - -	这种铣削材料在耐磨性和韧性之间有一个理想的平衡，它主要设计用于粗加工。其优点是即使在相对较高的切削速度下也有很好的耐磨性，具有很好的可靠性，这种材料更适合于使用较高速度和较低进给率的应用。
M9340	P35 – P50 M30 – M40 S15 – S20	■ ■ ■				MT-CVD		H	- - -	非常坚韧，其主要优点是切削刃强度高，能抵抗不利的切削条件。虽然这种材料有MT-CVD M30 – M40涂层，但在其应用中可以使用乳化液冷却，特别是在最佳切割条件下。
M5315	P05 – P20 K05 – K25 H05 – H20	◪ ■ ■				MT-CVD		H	- - -	最耐磨损的铣削材料之一，应在稳定的条件下使用。它的主要优点是具有极高的抗热应力和抗磨蚀性K05-K25.主要用于加工硬质和超硬质材料，特别是铸铁。
M8310	P01 – P10 M01 – M10 K01 – K10 H05 – H15	■ ◪ ■ ◪				PVD		ultra submicron H	-	专门为仿形铣削开发的材料，其特点是高耐磨性。它适用于在稳定的切削条件下以较高的切削速度进行加工，并适用于几乎所有的材料组（特别是较硬和更硬的材料）的加工。
8215	P10 – P20 M10 – M20 K10 – K25 N10 – N25 S10 – S15 H10 – H15	■ ◪ ■ ■ ◪ ■				PVD		submicron H	+ / -	最通用的铣削材料之一，无论是从工件的范围还是从可能的应用范围来看。它的特点是高耐磨性和运行可靠性。它的其他优点包括出色的抗温度冲击开裂性。由于其独特的性能，这种材料无疑是铣刀系列的支柱之一。
M8325	P20 – P40 M15 – M30	■ ◪				PVD		S	-	这种基体的主要应用领域是加工所有类型的钢（包括不锈钢）的“软状态”。它也可用于加工较软的铸铁。适用于在平均切削条件下以中等速度加工M15 – M30。
M8330	P20 – P40 M20 – M35 K20 – K40 N15 – N30 S15 – S25 H15 – H25	■ ■ ■ ◪ ◪ ◪				PVD		submicron H	+ / -	这种材料用途广泛，可用于加工各种材料。然而，它的优先应用领域是钢和球墨铸铁。建议在不稳定的切削条件下以中速进行铣削。
M8340	P25 – P50 M20 – M40 K20 – K40 S20 – S30	■ ■ ◪ ■				PVD		submicron H	+ / -	最坚硬的材质之一，专用于较低线速度和不利工况下的加工。该材质适用于所有操作，但要求有坚韧的切削刃。

铣削涂层 – 概览

涂层标识

M	9	3	2	5
加工类型	涂层/基体	产品代别	ISO范围	

加工类型

D	钻孔
M	铣削
T	车削
G	切槽和分断

涂层/基体

0 PVD 1 CVD	专用
2 PVD 3 CVD	无限制
4 PVD 5 CVD	K、H分组
6 PVD 7 CVD	M、S分组
8 PVD 9 CVD	通用
B	CBN
D	PCD

产品代别

1 – 9

ISO范围

	01 – 05
	05 – 10
	10 – 20
	20 – 30
	30 – 40
	40 – 50

基材

H	WC-Co基体
submicron H	WC-Co基体, 细颗粒度(<1µm)
ultra submicron H	WC-Co基体,极细颗粒度(<0.5µm)
S	立方碳化钨基材

涂层

MT-CVD	中温CVD涂层
PVD	物理涂层
–	无涂层材质

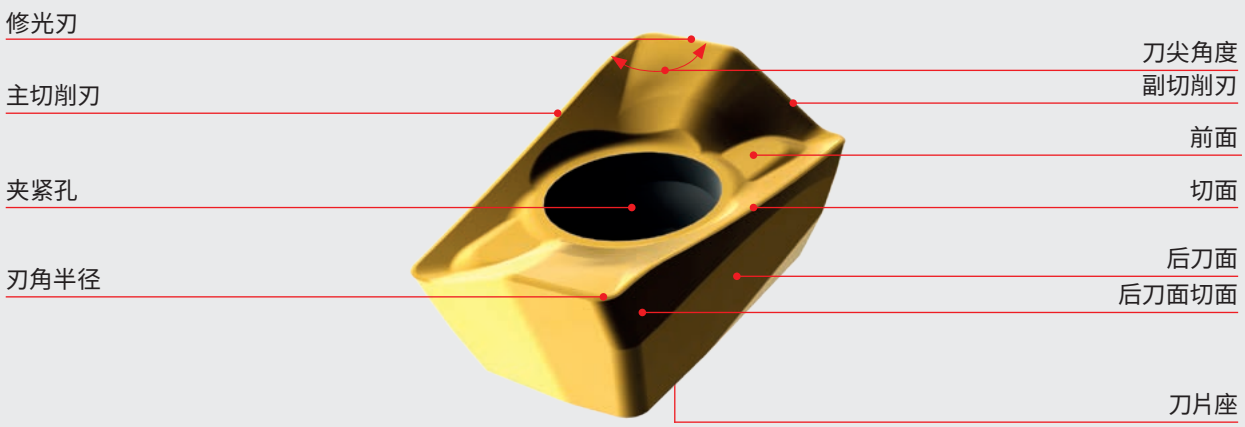
冷却的影响

- - -	对刀具寿命有非常不利的影响 – 不建议冷却
-	对刀具寿命有轻微的不利影响
+ / -	冷却的效果既可以是积极的，也可以是消极的--具体的工作条件是决定因素
+ +	对刀具寿命有积极影响 – 建议进行冷却

影响程度

	级别 1 – 5

可转位刀片的各个部分



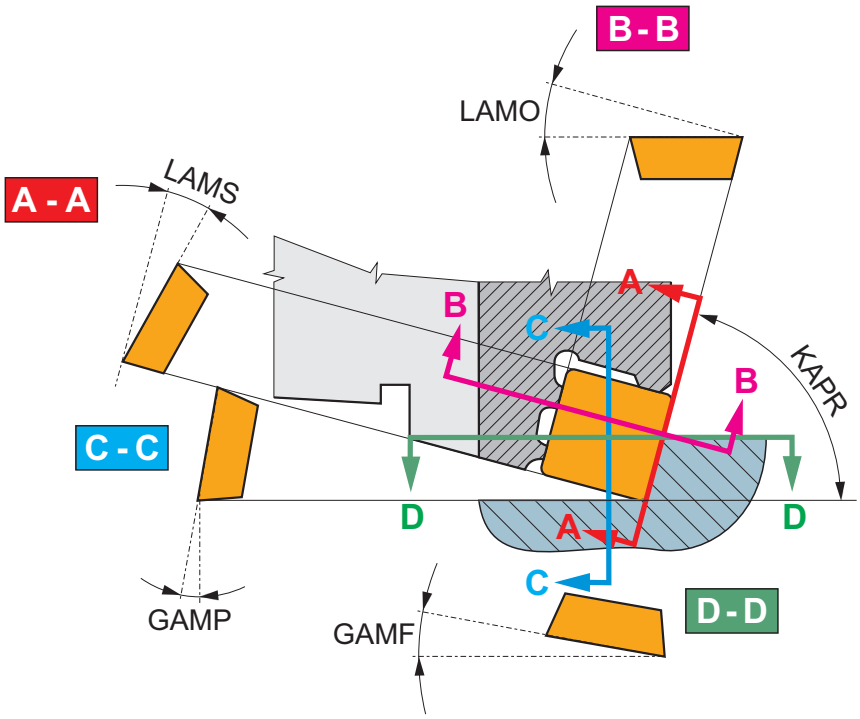
铣削刀具的槽形

结构角决定着用于夹固刀片的刀片座基本方位，因此对于铣刀刀体的设计很重要。具体的结构角如下：轴向前面角GAMP – g_p（后前角）和径向前面角GAMF – g_f（侧前角）– 见下图。
工作角度包括主偏角KAPR – k_r、正交前面角GAMO g_o和切削刃前角 LAMS – l_s。

- 正交前面角GAMO – g_o不仅影响切屑的塑性变形程度，还影响切削力和温度。前角GAMO – g_o越大，切削力越低，主轴电机的功率需求越小（反之亦然）。
- 主偏角KAPR – k_r决定着特定每齿进给量f_z和轴向切削深度a_p下的切屑厚度，因此影响着切削力、单位负荷、磨损和刀具寿命。在进给f_z不变的情况下，主偏角KAPR – k_r越小，切屑厚度h也越小。
- 切削刃前角LAMS – l_s以及主偏角KAPR – k_r和前面角GAMO – g_o决定着切刃与工件的第一个接触点，因此能够在断续切削中帮助切削刃抵抗崩口风险。同时，它影响着排屑的方向。

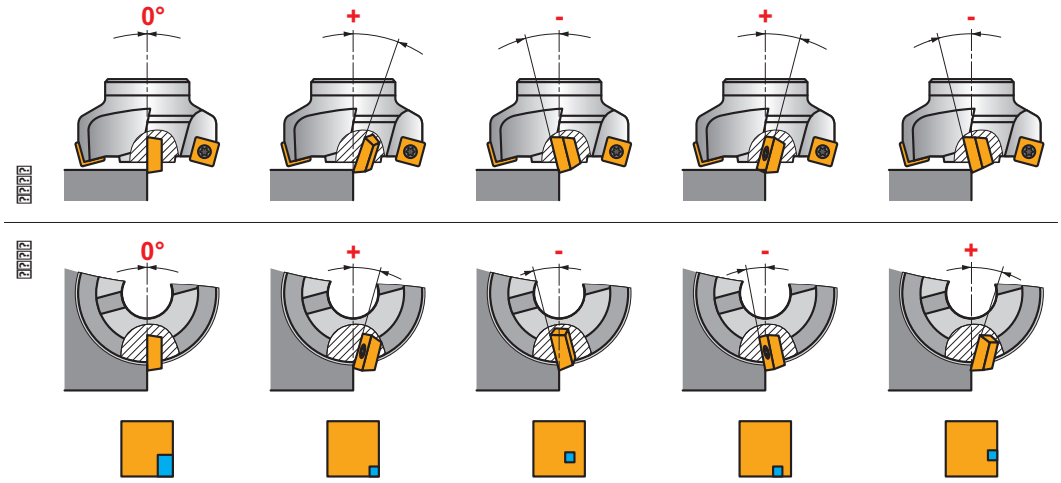
刀具的工作角度 可以用以下公式或图表来确定底座。

铣刀的工作角度和结构角度



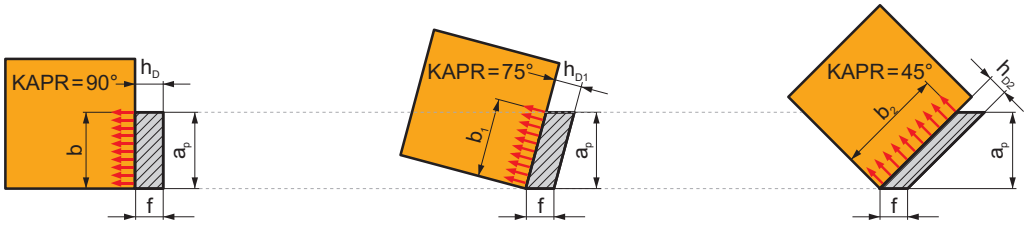
刀具的选择

铣刀槽形



选择刀具时需要考虑许多标准。其中一项标准是切削刃和工件之间，远离刀尖和切削刃的第一个接触点。该接触点取决于切削刃的基本槽形，即角度GAMO－g_o、LAMS－l_s、KAPR－k_r，以及铣刀与工件入刀边缘的相对位置。下图显示了在某些最不利接触条件下（即铣刀轴与工件边缘对齐时）的各个铣刀槽形（确切地说，是径向角和轴向角的组合）。图片底部是可转位刀片示意图，标明了刀片与工件第一次接触的区域。从图中可以看出，在这种不利的接触条件下，刀具为负-负槽形最佳，而正-正槽形出现问题的可能性最大。另一项需要考虑的标准是排屑。负-负槽形刀具将切屑推送到工作表面（推向工件），而正-正槽形刀具与此相反，将切屑推离工作表面，即离开工件。因此，负-正角度组合是最佳的折衷方案。

切入角



$h_D = f$ $k_c = 1{,}00\ k_{c1}$ $k_c/b = 1{,}00$	$h_{D1} = 0{,}97f$ $k_c = 1{,}01\ k_{c1}$ $k_c/b_1 = 0{,}98$	$h_{D2} = 0{,}71f$ $k_c = 1{,}09\ k_{c1}$ $k_c/b_2 = 0{,}77$

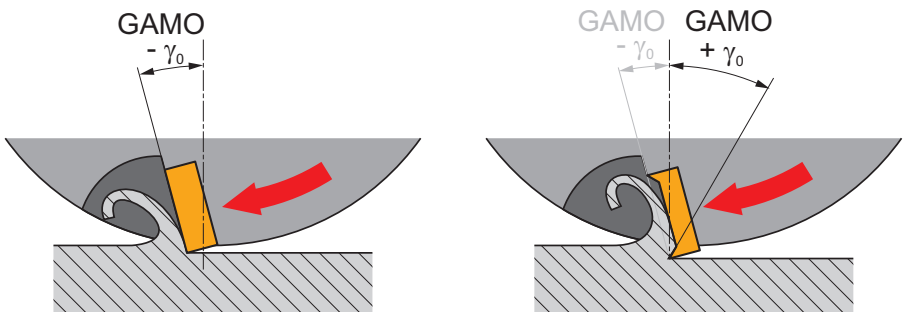
选择平面铣的切入角时，还需要考虑机床的功率和刚度（刀架的尺寸和类型）、机床动态能力以及最大切除深度。例如，使用带ISO 50刀架的高性能（50－100 kW）机床进行大深度切削时，应首选切入角介于90°－58°之间的铣刀。而如果使用带ISO 40（HSK 63）刀架的低功率（最高功率10 kW）机床以2－3 mm深度进行切削，则应选择切入角介于45°－10°（即HFC）之间的刀具或圆刃刀片。因此，最理想的折中方案是选择切入角为45°、能够采用更大切削深度的刀具，并且，与切入角为90°的刀具相比，在相同切削深度下，这种刀具的进给增加了多达30%，且负荷基本相同。最后，还要强调非常重要的一点，切入角越小，切屑越薄，并且切削刃的接触部分越长，这对于散热以及刀片边缘的受力分配都至关重要。同样需要指出的是，切削合力方向几乎与切刃垂直。（减小切入角会增加导入主轴的切削力被动部分，减少切削力的主动径向部分）。

刀具的选择

下图所示为Pramet铣刀产品组合的切入角和铣刀刀体基本槽形（即前面的轴向角度和径向角度）。但是必须指出，刀片槽形可能改变刀具的最终槽形，如下图所示。

	负 – 负	← 负 – 正 →	正 – 正
93°	SWN04C, SCN05C		
90°	STN10, STN16, SLN12, SLN16, SLN12X, J(T)-SLSN	SAD07D, SAD11E, SAD16E, SAP10D, SAP16D, SS009, SSD12, FTB27X, F-SCC, S90SN, S90CN(XN), J(T)-SAD11E, J(T)-SAD16E, J(T)-SSAP, J(T)-CSD12X	SAP10D, SVC22C
57° – 60°	SPN13	FSB22X	
45°	SHN06C, SHN09C, SSD09, N-SS009, 2516	SSF13F, SOD05, SOD06D, SSE09, SSN12Z	
43°	SON06C		SOE06Z
12° – 20°	SBN10, SSN11	SPD09, SS012	
–	SRC10, SRC12, SRC16, SRC20, SRD10, SRD12, L2-SZP, K3-CXP, K2-PPH, K2-SLC, K2-SRC	SRD05, SRD07, SRD10, SRD12, SRD16, SZD07, SZD09, SZD12, 2636, J(T)-SXP16	

最终槽形（铣刀 + 可转位刀片）



下表列出了根据加工材料类型所使用的三种基本铣刀槽形和大致的使用优先级。有关各个刀具产品系列及相应刀片槽形的更多详细信息，请参见产品目录部分。

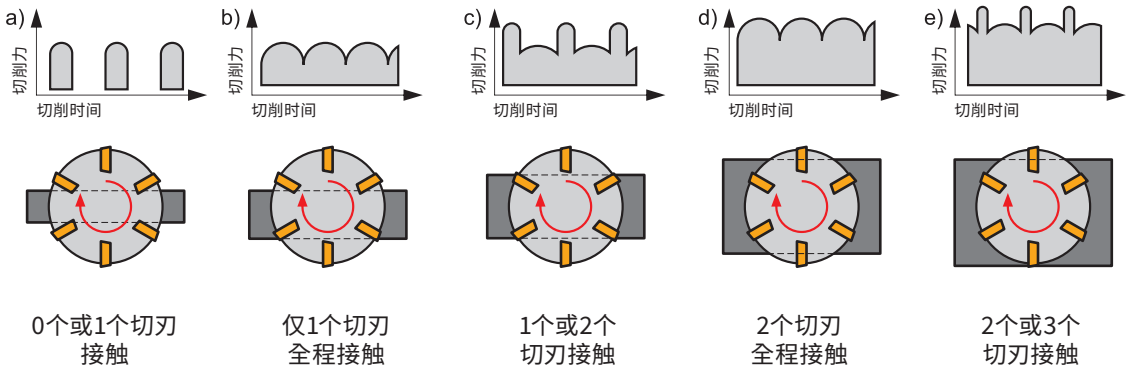
工况		根据应用选择铣刀槽形		
		负 – 负	负 – 正	正 – 正
刀体的结构参数	*GAMP* (A.R.)	-	+	+
	GAMF (R.R.)	-	-	+
	GAMO	-	+	+
加工材料	碳钢、合金钢（< 300 HB）	◪	■	■
	不锈钢（< 300 HB）		■	◪
	不锈钢（> 300 HB）		■	◪
	铸铁、延性铸铁	■	◪	◪
	Al合金		◪	■
	铜和铜合金		◪	■
	钛和钛合金		◪	◪
	淬硬钢（40 – 55 HRC）	◪	◪	

铣刀齿数

铣刀齿数对于铣削表面的宽度也很重要，决定着切削力（和声学）特性，如下图所示。

每分钟进给量	+	++	+++
韧性材料	+++	++	+
所需功率	+	++	+++
加工表面粗糙度	+++	++	+

齿距

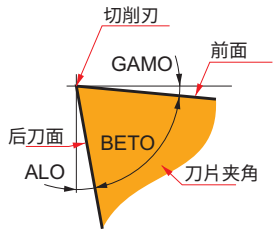
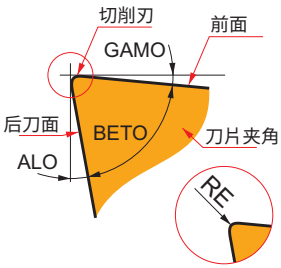
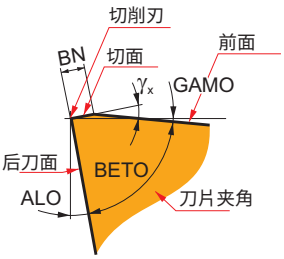
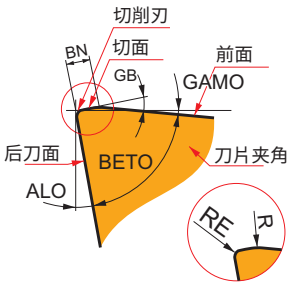
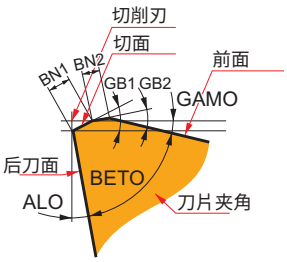
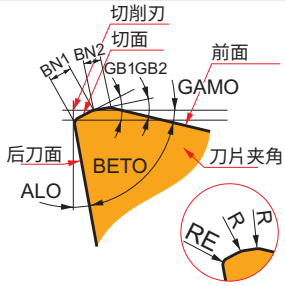


此外，部分刀具产品系列可以选择均匀齿距和不均匀齿距。使用齿距不均匀的刀具产品系列干扰谐振，有助于改善稳定性并降低振动风险。如果预计加工过程中会产生振动，即，主要在较长悬伸下工作或以较大径向切削深度加工时，以及在不完全稳定的工况下加工时，应选择不均匀的齿距。

刀片的选择

选择可转位刀片时，还要注意目录中直接用图标表示的刀片刃口槽型。下面简要介绍了刀片上常见的切削刃类型。

切削刃处理类型概览

F		尖刃 – 建议用于与AI合金铣刀搭配的刀片。尖切削刃产生的切削层变形最小，能够减少积屑瘤，并且所需的切削力更低。但是，切削刃的强度也比其它类型的刀具要低。
E		圆刃 – 刀刃经过轻微倒圆处理，旨在消除其表面上的微小缺陷。以非常小的半径（RE）对切刃进行修正，能够改善切削刃的抗机械损伤性能，防止脆性断裂或微小破碎。目前，所有无切面的可转位刀片均经过这种改进（以前是F修正），可用于铣削几乎所有类型的材料。
T		带切面的切削刃 – 宽度为x、角度为g_x的切面加大了靠近切削刃的刃口槽型角度g_n，并且提高了切削刃强度，即抵抗机械载荷、脆性损伤或断裂的性能。由于其已被S修正取代，目前仅在极少数情况下使用。
S		带切面的圆刃 – 与T修正相比，这种切削刃经过倒圆处理，并利用一个切面增加了刀刃厚度。这种修正能够让刀片更好地抵抗机械损伤。
K		双切面刀刃 – 宽度为x_1 x_2，角度为g_{x1} g_{x2}的双切面进一步提高了刀刃强度，即抵抗机械应力、脆性损伤或断裂的性能。极少用于铣削刀片，仅用于难度特别高的切削加工。
P		带双切面的圆刃 – 与K修正相比，这种切削刃经过倒圆处理，并利用双切面增加了刀刃厚度。这种修正能够令刀刃获得最大的抗机械损伤能力。

修正系数

用于特定类型铣刀及加工方式的修正系数C_{VcO}

X.V	●		
KAPR 45° – 60°面铣刀和负前角刀片 (SON06C, SHN06C, SHN09C)	1.15	1.00	0.85
KAPR 45°面铣刀和正前角刀片 (SSD13F, SSE09, SSN12Z, FSB22X, SOD05, SOD06D, SOE06Z)	1.15	1.00	0.85
KAPR 90°方肩铣刀(SAD07/10/16, STN10/16, SLN12/16, SAP10/16, SSO09, SSD12)	1.10	1.00	0.90
仿形面铣刀 (SRC10 – SRC20, SRD05 – SRD16, ...)	1.10	1.00	0.90
仿形立铣刀 (K2-PPH, K2-SLC, K2-SRC, K3-CXP...)	1.10	1.00	0.90
盘式铣刀 (S90CN (XN), S90SN...)	1.10	1.00	0.90
带扩展槽的方肩铣刀 J (T)-CSD12X, J (T)-SAD11E, J (T)-SAD16E...)	1.25	1.00	0.80
重型加工面铣刀 (FSB22X, SPN13..)	1.30	1.00	0.85
重型加工方肩铣刀 (FTB27X..)	1.25	1.00	0.85

满足耐久性C_{VcT}要求所需的修正系数

分钟	15	20	30	45	60	90	120
通用加工 (超精加工至粗加工)	1.23	1.13	1.00	0.89	0.81	0.72	–
重型加工 (重型粗加工)	–	–	1.23	1.13	1.00	0.89	0.81

附加修正系数C_{VcA}

加工环境	C_{VcA}
加工材料的状况 (因锻造或铸造形成硬皮)	0.70
不稳定的加工工况	0.85
常用加工工况	1.00
稳定加工工况	1.20

径向切深C_{VcRCT}低于100%的前面铣削及方肩铣削的线速度修正系数

a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

径向切深Cf_{zRCT}低于100%的前面铣削及方肩铣削的薄切屑补偿修正系数

a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
⇨x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

修正后的线速度vcc

$v_{cc} = v_c \times kvG \times C_{VcO} \times CvcT \times C_{VcA} \times C_{VcRCT} \times Cf_{zRCT}$

k_{vG} – 所用材料的系数

v_c – 目录页中的初始速度

公式

数值	单位	公式
转数	(rev/min)	$n = \frac{v_c \times 1000}{DC \times \pi}$
切削速度	(m/min)	$v_c = \frac{\pi \times DC \times n}{1000}$
每转进给	(mm/rev)	$f_{rev} = \frac{f_{min}}{n} = f_z \times z$
每分钟进给	(mm/min)	$f_{min} = v_f = f_{rev} \times n = f_z \times z \times n$
每齿进给	(mm/tooth)	$f_z = \frac{f_{rev}}{z} = \frac{f_{min}}{n \times z}$
切削断面	(mm^2)	$A = f_z \times a_p$
切屑厚度(用于直刃刀片)	(mm)	$h = f_z \times \sin KAPR$
切屑厚度(用于圆刀片)	(mm)	$h = f_z \times \sqrt{\frac{a_p}{INSD}}$
金属去除率	(cm^3/min)	$Q = \frac{a_p \times a_e \times f_{min}}{1000}$
所需功率	(kW)	$P_c = \frac{a_p \times a_e \times f_{min}}{60 \times 10^6 \times \eta} \times k_c \times k_\gamma$
大概功率	(kW)	$P_c = \frac{a_p \times a_e \times f_{min}}{x}$

注意:

	种类	单位
n	转数	(rev/
DC	直径(刀具或者工件)	(mm)
v_c	切削速度	(m/min)
f_{rev}	每转进给	(mm/
A	切削断面	(mm^2)
a_p	切削深度	(mm)
a_e	切削宽度	(mm)
$KAPR$	主偏角	(°)
f_{min}	每分钟进给	(mm/
f_z	每齿进给	(mm/to-
z	齿数	(-)
$INSD$	直径切削刀片	(mm)

	种类	单位
h	切屑厚度	(mm)
Q	每分钟金属去除率	(cm^3/
P_c	所需功率	(kW)
k_c	单位切削力mm^2	(MPa)
k_γ	影响g_0角度的系数	(°)
η	加工的有效系数 h = 0.75	(-)
x	影响工件材料的系数	(-)

材料	钢	铸铁	铝合金
系数 x	24 000	30 000	120 000

推荐的夹紧螺钉扭矩

螺钉型号	扭矩	螺距	长度
	(Nm)	–	(mm)
US 20	0.9	M 2	3
US 2205-T07P	0.9	M 2.2	5
US 25	1.2	M 2.5	5
US 2505-T08P	1.2	M 2.5	5
US 2506-T07P	1.2	M 2.5	6
US 3006-T09P	2	M 3	6
US 3007-T09P	2	M 3	7
US 3504-T09P	3	M 3.5	4
US 3507-T15	3	M 3.5	7
US 3509-T15	3	M 3.5	9
US 3511-T15	3	M 3.5	11
US 3512-T15P	3	M 3.5	12
US 4008-T15P	3.5	M 4	8
US 4011-T15P	3.5	M 4	11
US 4511-T20	5	M 4.5	11
US 5012-T15P	5	M 5	12
US 70	5	M 4	5
US 71	5	M 4	7
US 72	5	M 4	9
US 73	5	M 4	11
CS 3007-T08P	1.2	M 3	7
CS 4008-T15P	3	M 4	8
CS 42506-T07P	1	M 2.5	6
CS 43008-T08P	1.2	M 3	8
CS 43509-T10P	2	M 3.5	9
CS 44013-T15P	3	M 4	13
CS 45016-T20P	5	M 5	16
CS 46020-T25P	7.5	M 6	20
CS 48025-T40P	15	M 8	25
CS 5009-T20P	5	M 5	9
CS 5013-T20P	5	M 5	13
CS 5015-T20P	5	M 5	15
CS 6020-T20P	7.5	M 6	20
CS 8025-T30P	15	M 8	25
US 2505-T07P	1.2	M 2.5	5
US 2506-T07P	1.2	M 2.5	6
US 3007-T09P	2	M 3	7
US 3505-T09P	3	M 3.5	5
US 4011A-T15P	3.5	M 4	11
US 4011-T15P	3.5	M 4	11
US 44010-T15P	3.5	M 4	10
US 44012-T15P	3.5	M 4	12
US 45011-T20P	5	M 5	11
US 45012-T20P	5	M 5	12
US 5011-T20P	5	M 5	11
US 5018-T20P	5	M 5	18
US 52506-T07P	0.8	M 2.5	6
US 54511-T15P	5	M 4.5	11
US 62003A-T06P	0.6	M 2	3
US 62004A-T06P	0.6	M 2	4
US 62004-T06P	0.6	M 2	4
US 62505-T07P	1.2	M 2.5	5
US 62506-T07P	1.2	M 2.5	6
US 62506-T08P	1.2	M 2.5	6
US 62508-T08P	1.2	M 2.5	7
US 63009-T09P	1.2	M 3	9
US 63509-T15P	3	M 3.5	10
US 63510-T10P	2	M 3.5	9
US 63511D-T15P	3	M 3.5	11

螺钉型号	扭矩	螺距	长度
	(Nm)	–	(mm)
US 63513-T15P	3	M 3.5	12
US 64014-T15P	3.5	M 4	14
US 65013-T20	5	M 5	13
US 65014-T20P	5	M 5	14
US 65017-T20P	5	M 5	17
US 66015-T25P	7.5	M 6	15
US 68020-T30P	15	M 8	20
US 68026-T30P	15	M 8	26
US 74016-T15P	3.5	M 4	16

扭矩扳手

刀柄	扭矩 (Nm)	螺钉螺距
MR-0.8-2.0 Vario	0.5 – 2.0	M 2 – M 3
MR-1.0-5.0 Vario	0.8 – 5.0	M 2.5 – M 5
MR-0.9 fix	0.9	M 2
MR-2.0 fix	2.0	M 3
MR-3.0 fix	3.0	M 3.5
MR-3.5 fix	3.5	M 4
MR-5.0 fix	5.0	M 5

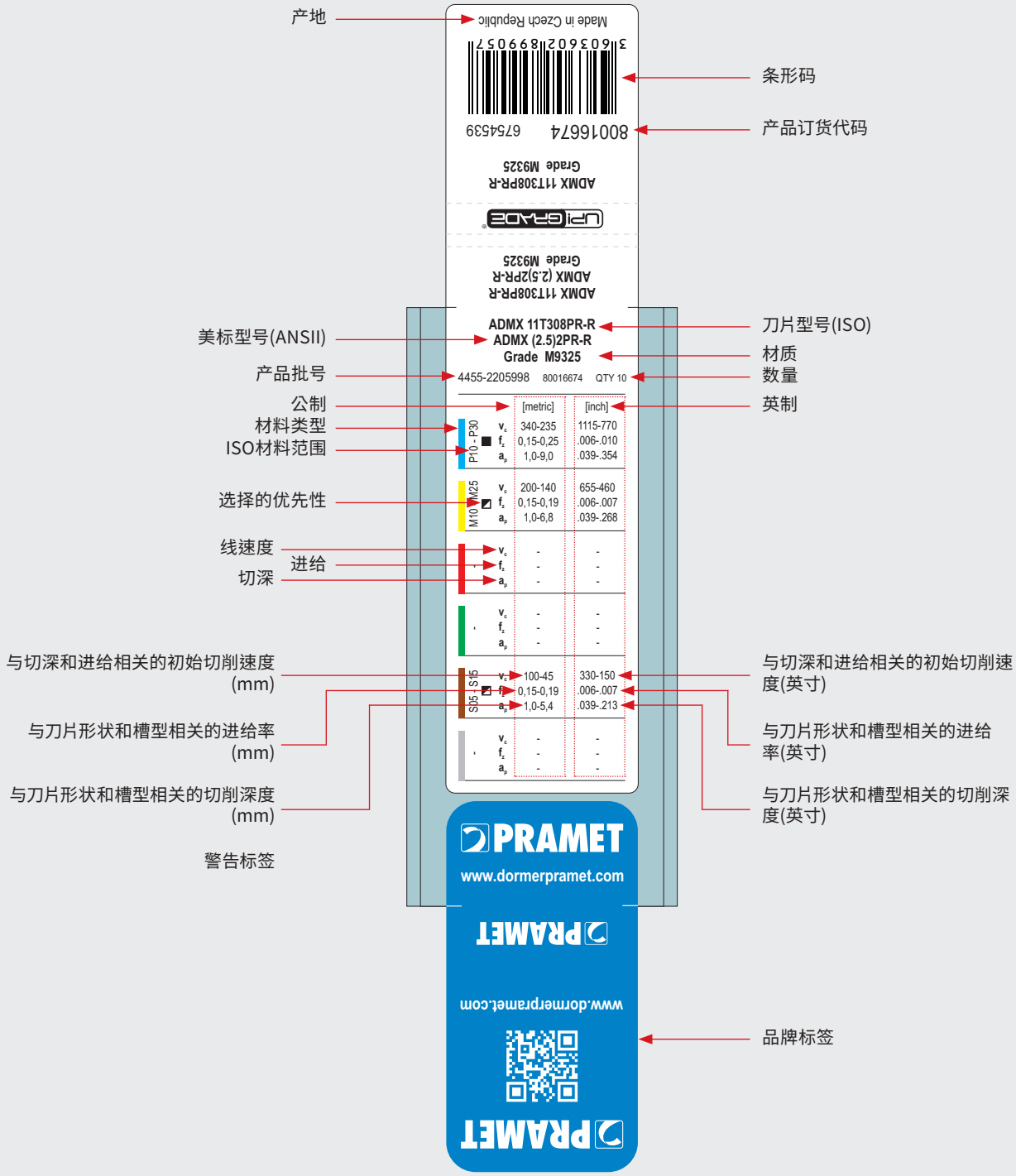
可拆卸扳手

可拆卸扳手
D-T6
D-T6P
D-T7
D-T7P
D-T8
D-T8P
D-T9
D-T9P
D-T15
D-T15P
D-T20
D-T20P

螺钉润滑

刀片夹紧螺钉承受高热应力,推荐所有的螺钉都适用润滑剂 MOLYCOTE 1000.

刀片盒子的技术信息


产地
Made in Czech Republic
条形码
产品订货代码
80016674
6754539
ADMX 11T308PR-R
Grade M9325
美标型号(ANSII)
ADMX 11T308PR-R
ADMX (2.5)2PR-R
Grade M9325
刀片型号(ISO)
材质
产品批号
4455-2205998
80016674
QTY 10
数量
公制
[metric]
[inch]
英制
材料类型
ISO材料范围
P10 - P30
340-235
0,15-0,25
1,0-9,0
1115-770
.006-.010
.039-.354
选择的优先性
M10 - M25
200-140
0,15-0,19
1,0-6,8
655-460
.006-.007
.039-.268
线速度
进给
切深
与切深和进给相关的初始切削速度(mm)
S35 - S45
100-45
0,15-0,19
1,0-5,4
330-150
.006-.007
.039-.213
与切深和进给相关的初始切削速度(英寸)
与刀片形状和槽型相关的进给率(mm)
与刀片形状和槽型相关的进给率(英寸)
与刀片形状和槽型相关的切削深度(mm)
与刀片形状和槽型相关的切削深度(英寸)
警告标签
PRAMET
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品牌标签

WMG（加工材料组）

ISO组		WMG（加工材料组）				硬度 (HB或HRC)	极限抗拉强度 (MPa)	修正系数 kvG
P	P1	P1.1	易切削钢（可加工性较高的碳钢）	硫化		< 240 HB	≤ 830	1.33
		P1.2		硫化和磷化		< 180 HB	≤ 620	1.49
		P1.3		硫化/磷化和含铅		< 180 HB	≤ 620	1.53
	P2	P2.1	普通碳钢（主要由铁和碳组成的钢）	含<0.25%C		< 180 HB	≤ 620	1.14
		P2.2		含<0.55%C		< 240 HB	≤ 830	1.00
		P2.3		含>0.55%C		< 300 HB	≤ 1030	0.89
	P3	P3.1	合金钢（碳钢，合金含量≤10%）	退火		< 180 HB	≤ 620	0.92
		P3.2		硬化与回火		180 – 260 HB	> 620 ≤ 900	0.74
		P3.3				260 – 360 HB	> 900 ≤ 1240	0.63
	P4	P4.1	工具钢（特种合金钢，用于刀具、模具）	退火		< 26 HRC	≤ 900	0.55
		P4.2		硬化与回火		26 – 39 HRC	> 900 ≤ 1240	0.47
		P4.3				39 – 45 HRC	> 1240 ≤ 1450	0.38
M	M1	M1.1	铁素体不锈钢（直铬非硬化合金）			< 160 HB	≤ 520	1.22
		M1.2				160 – 220 HB	> 520 ≤ 700	1.03
	M2	M2.1	马氏体不锈钢（直铬可硬化合金）	退火		< 200 HB	≤ 670	1.08
		M2.2		淬火加回火		200 – 280 HB	> 670 ≤ 950	0.89
		M2.3		沉淀硬化		280 – 380 HB	> 950 ≤ 1300	0.75
	M3	M3.1	奥氏体不锈钢（铬镍和铬镍锰合金）			< 200 HB	≤ 750	1.00
		M3.2				200 – 260 HB	> 750 ≤ 870	0.86
		M3.3				260 – 300 HB	> 870 ≤ 1040	0.77
	M4	M4.1	奥氏体-铁素体（双相）或 高级奥氏体不锈钢			< 300 HB	≤ 990	0.75
		M4.2	沉淀硬化奥氏体不锈钢			300 – 380 HB	≤ 1320	0.64
K	K1	K1.1	灰口铸铁（ASTM A48）或汽车用灰铸铁（ASTM A159）（具有片状石墨微结构的铁碳铸件）	铁素体或铁素体-珠光体		< 180 HB	≤ 190	1.35
		K1.2		铁素体-珠光体或珠光体		180 – 240 HB	> 190 ≤ 310	1.00
		K1.3		珠光体		240 – 280 HB	> 310 ≤ 390	0.75
	K2	K2.1	可锻铸铁（ASTM A602）（无石墨结构的铁碳铸件）	铁素体		< 160 HB	≤ 400	1.39
		K2.2		铁素体或珠光体		160 – 200 HB	> 400 ≤ 550	1.13
		K2.3		珠光体		200 – 240 HB	> 550 ≤ 660	0.90
	K3	K3.1	延性铸铁（ASTM A536）（有石墨结构的铁碳铸件）	铁素体		< 180 HB	≤ 560	1.23
		K3.2		铁素体或珠光体		180 – 220 HB	> 560 ≤ 680	0.94
		K3.3		珠光体		220 – 260 HB	> 680 ≤ 800	0.76
	K4	K4.1	奥氏体灰口铸铁（ASTM A436）（具有奥氏体片状石墨组织的铁碳合金铸件）			< 180 HB	≤ 190	1.14
		K4.2	奥氏体延性铸铁（ASTM A439或ASTM A571）（具有奥氏体球墨结构铁碳合金铸件）			< 240 HB	≤ 740	0.86
		K4.3	等温淬火球墨铸铁（ASTM A897）（具有奥氏体组织的铁碳合金铸件）			< 280 HB	> 840 ≤ 980	0.63
		K4.4				280 – 320 HB	> 980 ≤ 1130	0.54
		K4.5				320 – 360 HB	> 1130 ≤ 1280	0.45
	K5	K5.1	蠕墨铸铁CGI（ASTM A842）（具有蠕虫状石墨结构的铁碳铸件）	铁素体		< 180 HB	≤ 400	1.29
		K5.2		铁素体-珠光体		180 – 220 HB	> 400 ≤ 450	0.97
		K5.3		珠光体		220 – 260 HB	> 450 ≤ 500	0.75
N	N1	N1.1	工业纯锻铝			< 60 HB	≤ 240	1.33
		N1.2	锻铝合金	中硬质回火		60 – 100 HB	> 240 ≤ 400	1.00
		N1.3		全硬质回火		100 – 150 HB	> 400 ≤ 590	0.67
	N2	N2.1	铸铝合金			< 75 HB	≤ 240	0.67
		N2.2				75 – 90 HB	> 240 ≤ 270	0.60
		N2.3				90 – 140 HB	> 270 ≤ 440	0.43
	N3	N3.1	易切削铜合金材料，具有出色机械加工性能			–	–	0.70
		N3.2	短切屑铜合金，具有良好至中等的机械加工性能			–	–	0.41
		N3.3	电解铜和长切屑铜合金，具有中等至较差的机械加工性能			–	–	0.21
	N4	N4.1	热塑性聚合物			–	–	0.70
		N4.2	热固性聚合物			–	–	0.27
		N4.3	增强型聚合物或复合材料			–	–	0.29
	N5	N5.1	石墨			–	–	1.00
S	S1	S1.1	钛或钛合金			< 200 HB	≤ 660	1.94
		S1.2				200 – 280 HB	> 660 ≤ 950	1.72
		S1.3				280 – 360 HB	> 950 ≤ 1200	1.44
	S2	S2.1	铁基高温合金			< 200 HB	≤ 690	1.33
		S2.2				200 – 280 HB	> 690 ≤ 970	1.17
	S3	S3.1	镍基高温合金			< 280 HB	≤ 940	1.00
		S3.2				280 – 360 HB	> 940 ≤ 1200	0.83
	S4	S4.1	钴基高温合金			< 240 HB	≤ 800	0.78
		S4.2				240 – 320 HB	> 800 ≤ 1070	0.67
H	H1	H1.1	冷硬铸铁			< 440 HB	–	1.52
	H2	H2.1	硬化铸铁			< 55 HRC	–	0.90
		H2.2				> 55 HRC	–	0.77
	H3	H3.1	硬化钢 < 55 HRC			< 51 HRC	–	1.00
		H3.2				51 – 55 HRC	–	0.82
	H4	H4.1	硬化钢 > 55 HRC			55 – 59 HRC	–	0.64
		H4.2				> 59 HRC	–	0.54

硬度转换表

强度 (MPa)	硬度			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
285	86	**90**	1190	–
320	95	**100**	56.2	–
350	105	**110**	62.3	–
385	114	**120**	66.7	–
415	124	**130**	71.2	–
450	133	**140**	75.0	–
480	143	**150**	78.7	–
510	152	**160**	81.7	–
545	162	**170**	85.8	–
575	171	**180**	87.1	–
610	181	**190**	89.5	–
640	190	**200**	91.5	–
675	199	**210**	93.5	–
705	209	**220**	95	–
740	219	**230**	96.7	–
770	228	**240**	98.1	–
800	238	**250**	99.5	–
820	242	**255**	–	23.1
850	252	**265**	–	24.8
880	261	**275**	–	26.4
900	266	**280**	–	27.1
930	276	**290**	–	28.5
950	280	**295**	–	29.2
995	295	**310**	–	31.0
1030	304	**320**	–	32.2
1060	314	**330**	–	33.3
1095	323	**340**	–	34.4
1125	333	**350**	–	35.5
1155	342	**360**	–	36.6

强度 (MPa)	硬度			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
1190	352	**370**	–	37.7
1220	361	**380**	–	38.8
1255	371	**390**	–	39.8
1290	380	**400**	–	40.8
1320	390	**410**	–	41.8
1350	399	**420**	–	42.7
1385	409	**430**	–	43.6
1420	418	**440**	–	44.5
1455	428	**450**	–	45.3
1485	437	**460**	–	46.1
1520	447	**470**	–	46.9
1555	456	**480**	–	47.7
1595	466	**490**	–	48.4
1630	475	**500**	–	49.1
1665	485	**510**	–	49.8
1700	494	**520**	–	50.5
1740	504	**530**	–	51.1
1775	513	**540**	–	51.7
1810	523	**550**	–	52.3
1845	532	**560**	–	53.0
1880	542	**570**	–	53.6
1920	551	**580**	–	54.1
1955	561	**590**	–	54.7
1995	570	**600**	–	55.2
2030	580	**610**	–	55.7
2070	589	**620**	–	56.3
2105	599	**630**	–	56.8
2145	608	**640**	–	57.3
2180	618	**650**	–	57.8

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