DORMER PRAMET

车削

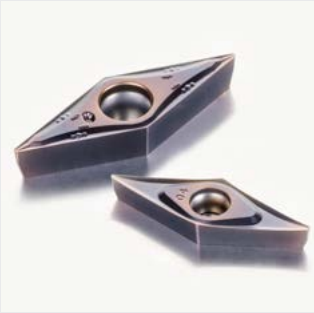
2024

PRAMET

车削加工-通常信息

ISO 车削

正前角刀片



断屑器导航	P	M	K	N	S	H	📖
							6
FF 精加工	FF2 SF3 J.	SF3 NF1	FF2	AL SF3	SF3 SF2		13
F 精加工	FM UR W	NF2 FM	UR FM	AL	NF2	.CMW	33
M 半精加工	FM2	SI	RF	AL		.CMW	49
R 粗加工	RM	RM	RM RM3	AL			61
HR 重型粗加工	OR DR4	OR					67

工具

按刀片形状	CC	DC	EC / EP	RC	SC	TC	VB	VC	WC	69
按夹紧方式	外部冷却				内部冷却		PSC			154
	S	P	DKH / KHP		S		S			

负前角刀片

断屑器导航	P	M	K	N	S	H	📖
							160
FF 精加工	NF FF	NF	FF		SF	SF	167
F 精加工	FM W	SF	FM		SF	.NMA	175
M 半精加工	SM M SI	NMR NM	M	SF	SM	.NMA	187
R 粗加工	RM R	NRM	KR R	SF	NRM		213
HR 重型粗加工	OR HR	NR2 923	HR2		NR2		229

工具

按刀片形状	CN	DN	KN	LN	RN	SN	TN	VN	WN	240
按夹紧方式	外部冷却				内部冷却		PSC			322
	P	D	M	DKH / KHP	P	D	D			

其他硬质合金和金属陶瓷刀片				327
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切槽和切断

外圆切槽和切断	GL	LCMF	355
刀板和模块化刀板	GL	LFMX LFUX	381
端面槽	GL	LFMX	401
内孔槽	GL	LCMF 13	411
O 形槽和卡环槽		X61	419

螺纹车削	螺纹刀片和工具	429
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C.-DSDNN EXT	291
C.-DSKN(RL) EXT	292
C.-DSRN(RL) EXT	293
C.-DSSN(RL) EXT	294
C.-DTFN(RL) INT	308
C.-DTJN(RL) EXT	305
C.-DVJN(RL) EXT	312
C.-DWLN(RL) EXT	318
C.-DWLN(RL) INT	321
C.-SCLC(RL) EXT	83
C.-SCLC(RL) INT	89
C.-SDJC(RL) EXT	96
C.-SDNCN EXT	97
C.-SDUC(RL) INT	102
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TCMW	60
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VCMW	60
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DNMA	211
SNMA	211
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SCMT	16
TCGT	16
TCMT	16
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WCGT	18
FM	34
CCMT	35
DCMT	36
RCMT	37
SCMT	37
TCMT	38
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VCMT	39
WCMT	39
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TNMG	179
VNMG	179
WNMG	180
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DCMT	51
ECMT	52
SCMT	52
TCMT	52
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SNMM	237
TNMM	237
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SNMM	239
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EPGX	30
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KR	226
CNMG	227
DNMG	227
SNMG	227
TNMG	227
WNMG	227
M	193
CNMG	194
DNMG	195
SNMG	196
TNMG	196
VNMG	196
WNMG	197
NF	168
CNMG	169
DNMG	169
SNMG	170
TNMG	170
VNMG	171
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CCGT	24
DCGT	24
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CCMT	40
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TNMG	208
VNMG	208
WNMG	209
NMR	202
CNMG	202
DNMG	203
SNMG	204
TNMG	204
VNMG	205
WNMG	205
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CNMM	234
DNMM	234
SNMM	235
TNMM	235
WNMM	235
NRM	223
CNMG	224
CNMM	224
DNMG	224
SNMG	225
SNMM	225
WNMG	225
OR	68
SCMT	68
OR	230
CNMM	231
DNMM	231
SNMM	232
TNMM	232
WNMM	232
R	220
CNMG	221
DNMG	221
SNMG	221
TNMG	222
WNMG	222
RF	56
CCMT	57
DCMT	57
SCMT	57
TCMT	57
WCMT	57
RM	62
CCMT	63
DCMT	63
SCMT	64
TCMT	64
VBMT	64
RM	214
CNMG	215
DNMG	216
SNMG	217
TNMG	218
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CCMT	66
RCMT	66
SCMT	66
TCMT	66
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CNGG	182
CNMG	182
DNMG	182
SNMG	183
TNMG	183
VNMG	184
WNMG	184
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ECGT	25
VCGT	25
SF3	19
CCGT	20
DCGT	20
ECGT	21
SCGT	21
TCGT	21
VCGT	22
SI	54
CCGT	54
DCGT	55
TCGT	55
SI	198
CNMG	199
DNMG	199
TNMG	200
WNMG	201
SM	188
CNMG	189
DNMG	190
SNMG	190
TNMG	191
VNMG	191
WNMG	192
UR	42
CCMT	43
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SCMT	45
TCMT	45
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CNGA CBN	348
CNGA CER	340
CNGN CER	340
DCGW CBN	348
DCMW PCD	346
DNGA CBN	349
DNGA CER	341
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	406
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GL. D – MM	370
	387
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	414
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GL. D – PR	368
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GL. S – PR	369
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RCMX	331
RNGN CER	342
RNMG	333
SNGA CER	343
SNGN CER	343
SNMM	333
SNMX	334
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产品系列	
SPUN-IT	336
T	
TCGW CBN	349
TN 55° PP EXT	444
TN 55° PP EXT – P1	434
TN 55° PP INT	444
TN 55° PP INT – P1	434
TN 60° PP EXT	440
TN 60° PP EXT – P1	432
TN 60° PP INT	441
TN 60° PP INT – P1	432
TN 60°-S PP EXT	447
TN 60°-S PP INT	448
TN ACME EXT	449
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TN API RD EXT	453
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TN UN EXT – P1	431
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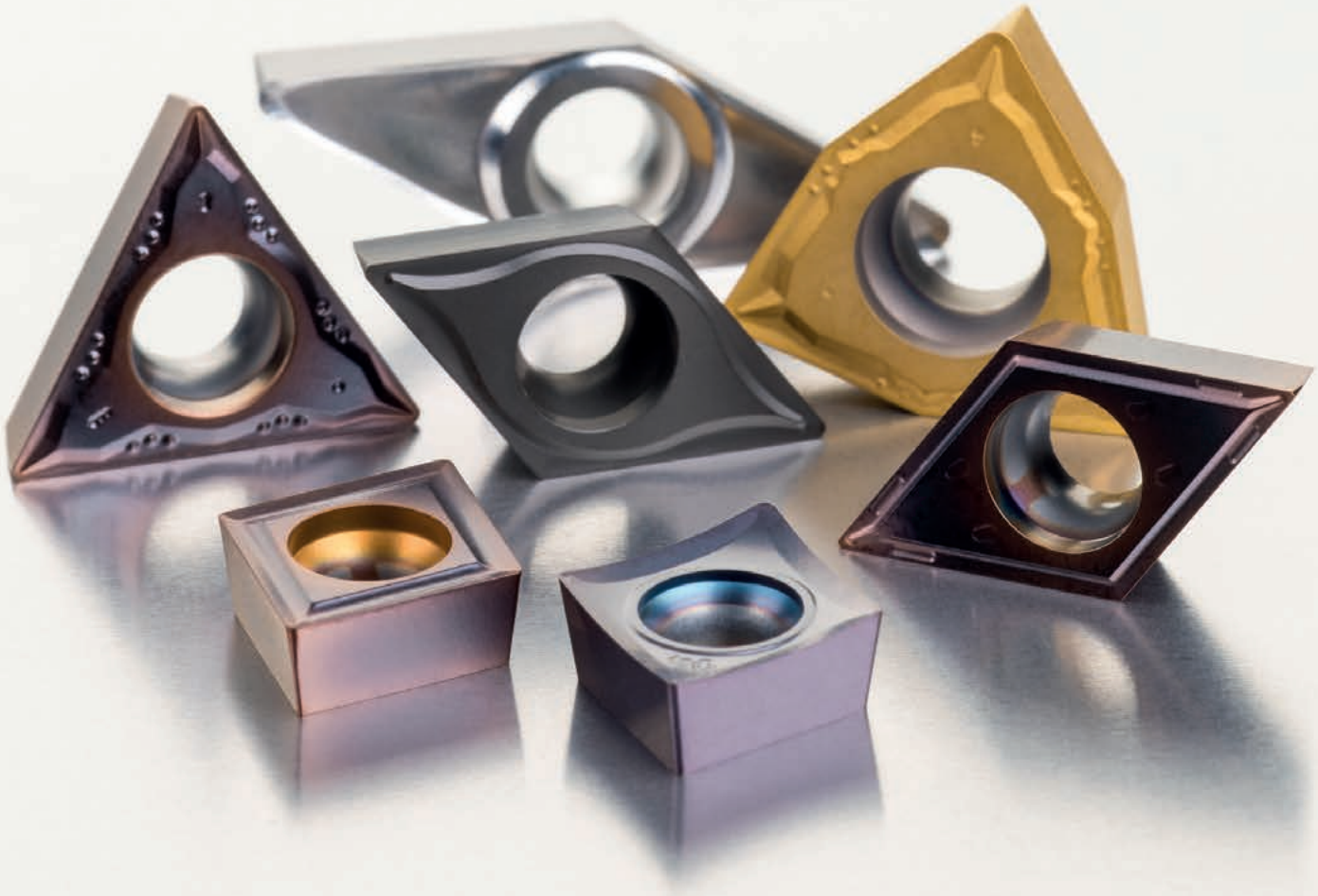
VNGA CER	346
W	
WNGA CBN	351
X	
X 61	422
X 61 R	423
X 61-1	425
X 61 R-1	426

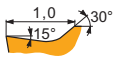
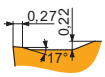


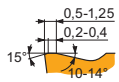
正前角刀片

正前角ISO刀片 – 断屑槽导航工具

P

	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

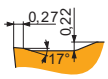
UR		设计用于超精加工至精加工，钢和铸铁及部分不锈钢，连续切削及断续切削
FM		设计用于精加工至半粗加工，钢和不锈钢，部分铸铁和有色金属材料，连续切削及适度断续切削
RM		设计用于半粗加工，钢、不锈钢和铸铁，部分高温合金和硬化材料，连续切削及断续切削

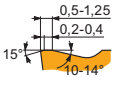
OR		设计用于粗加工和重载粗加工，钢、不锈钢和铸铁，部分高温合金，连续切削及断续切削

正前角ISO刀片 – 断屑槽导航工具

M

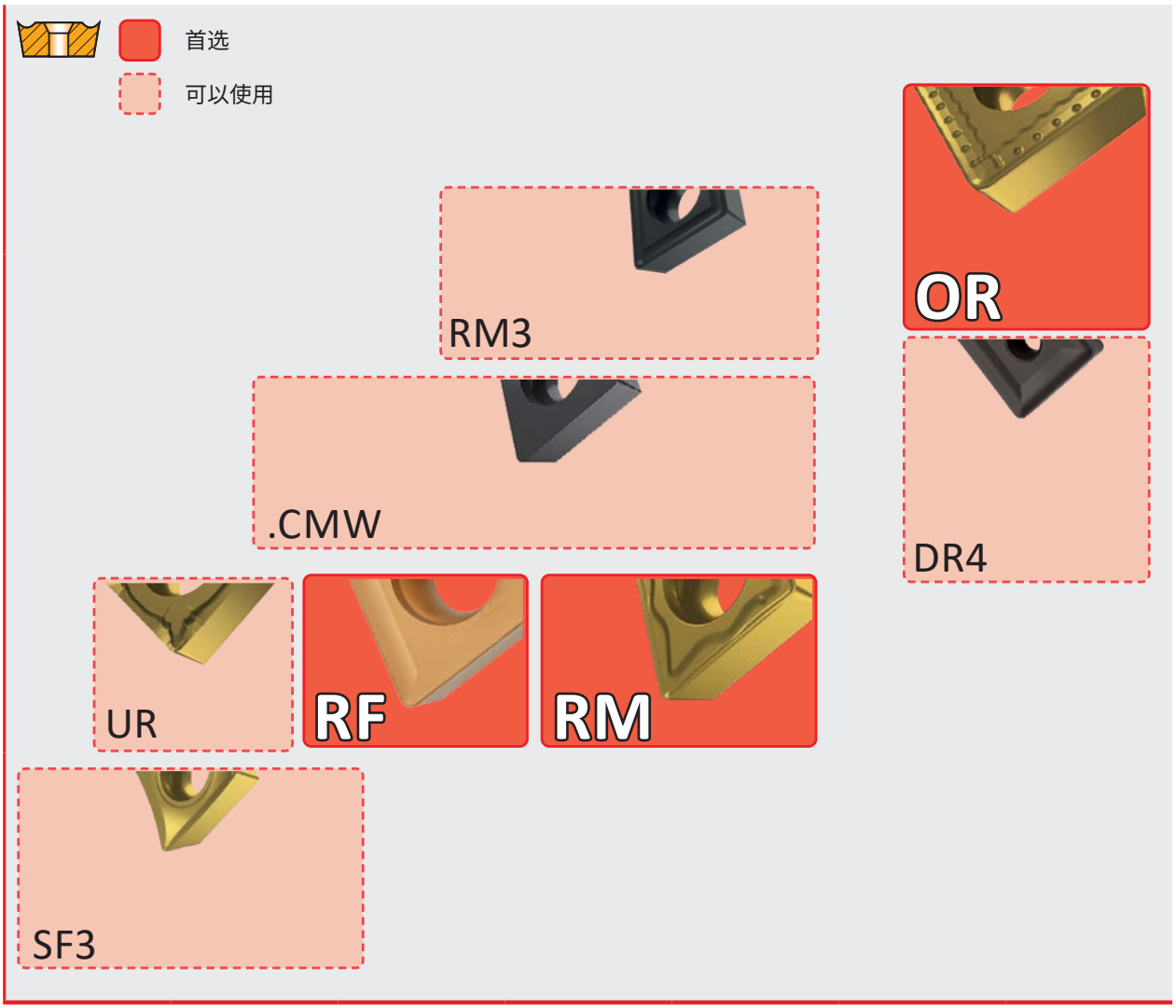
	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

NF2		正前角设计，用于超精加工-精加工至半粗加工，不锈钢和高温合金，连续切削
FM		设计用于精加工至半粗加工，钢和不锈钢，部分铸铁和有色金属材料，连续切削及适度断续切削
RM		设计用于半粗加工，钢、不锈钢和铸铁，部分高温合金和硬化材料，连续切削及断续切削

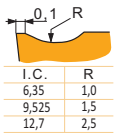
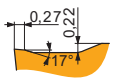
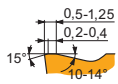
OR		设计用于粗加工和重载粗加工，钢、不锈钢和铸铁，部分高温合金，连续切削及断续切削

正前角ISO刀片 – 断屑槽导航工具

K

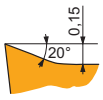


	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

RF	 I.C. / R: 6,35 / 1,0; 9,525 / 1,5; 12,7 / 2,5	设计用于粗加工，铸铁，部分钢、不锈钢及硬质材料，连续切削及断续切削
RM		设计用于半粗加工，钢、不锈钢和铸铁，部分高温合金和硬化材料，连续切削及断续切削
OR		设计用于粗加工和重载粗加工，钢、不锈钢和铸铁，部分高温合金，连续切削及断续切削

N

	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF3		大正前角设计，用于超精加工和精加工，高温合金，不锈钢和有色金属材料，部分钢、铸铁和硬质材料，连续切削
AL		大正前角设计，用于超精加工至粗加工，铝、铝合金和其它有色金属材料，部分高温合金，连续切削

正前角ISO刀片 – 断屑槽导航工具

S

首选

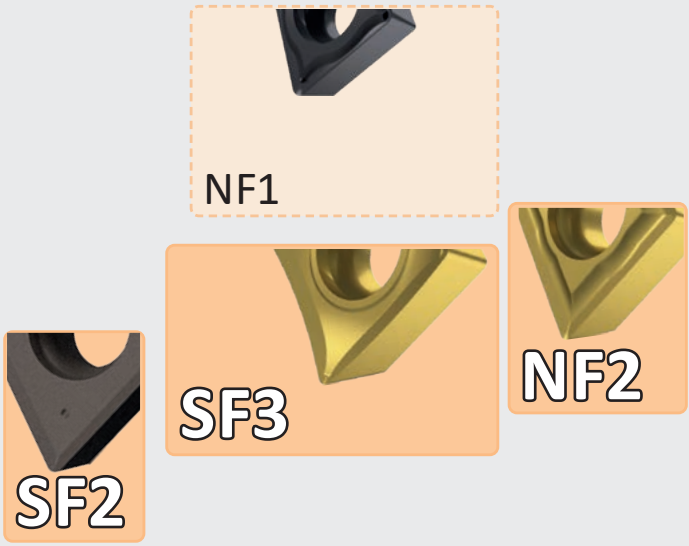
可以使用

非常不稳定工况

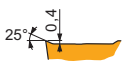
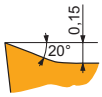
不稳定工况

稳定工况

薄壁和细长工件



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF2		大正前角设计，用于超精加工和精加工，高温合金，部分不锈钢、钢和有色金属材料，连续切削
SF3		大正前角设计，用于超精加工和精加工，高温合金，不锈钢和有色金属材料，部分钢、铸铁和硬质材料，连续切削
NF2		正前角设计，用于超精加工-精加工至半粗加工，不锈钢和高温合金，连续切削

正前角ISO刀片 – 断屑槽导航工具

H

首选

可以使用

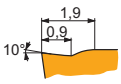
非常不稳定工况

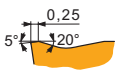
不稳定工况

稳定工况

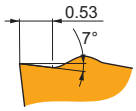
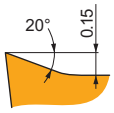
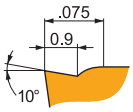
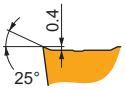
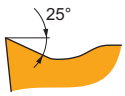
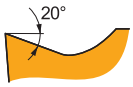
薄壁和细长工件

	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

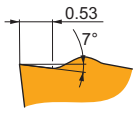
SF3		大正前角设计，用于超精加工和精加工，高温合金，不锈钢和有色金属材料，部分钢、铸铁和硬质材料，连续切削
NF1		正前角设计，用于超精加工至中等精度加工，不锈钢和高温合金，部分钢、有色金属和硬质材料，连续切削
.CMW		设计用于超精加工至半粗加工，铸铁，部分硬质材料，连续切削及轻断续切削

RM3		设计用于粗加工，铸铁，部分钢、不锈钢及硬质材料，连续切削及断续切削

精加工 – 导航工具

FF2			FF2 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。
SF3			SF3 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。具有大正前角，无T-型倒棱。也可用于有色金属（非铁）合金，以及有条件地适用于钢、铸铁和硬质材料。
NF1			NF1 型断屑槽锋利，专为钢材、不锈钢和超级合金的精加工而设计。它具有正前角，无 T倒棱。它也有条件地适用于有色金属合金和硬质材料。
SF2			SF2 型断屑槽锋利，专为不锈钢和超级合金的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于钢和有色金属合金。
AL			AL 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。
JQ JR JZ			JQ 型断屑槽非常锋利，专为钢材的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。

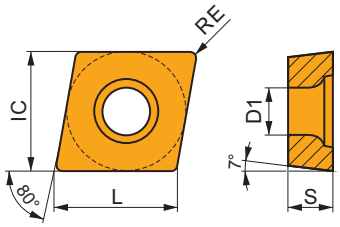
FF2



FF2 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。

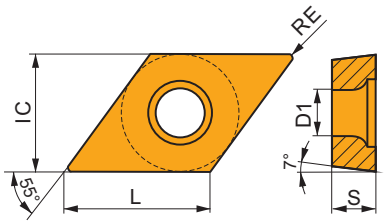
CCGT / CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97



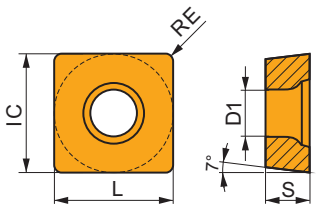
DCGT / DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



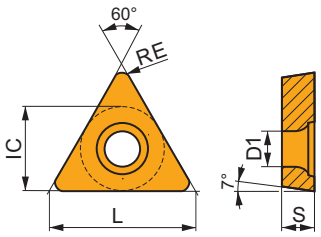
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97



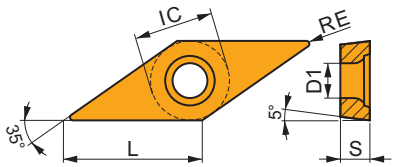
TCGT / TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



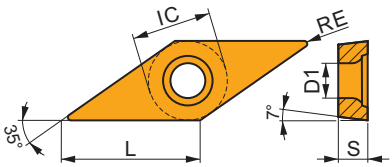
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76



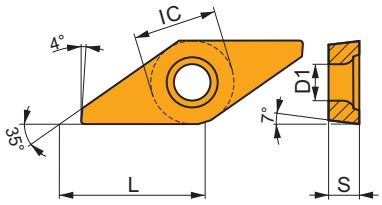
VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	3.970	2.20	6.90	2.38
1303	7.940	3.40	13.80	3.18



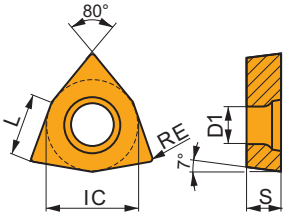
VCGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18

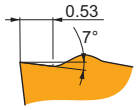
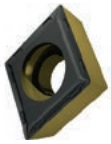
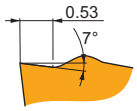
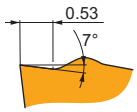
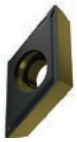
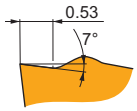


WCGT

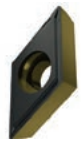
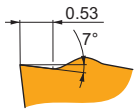
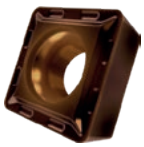
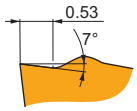
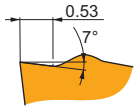
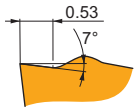
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0201	3.970	2.20	2.70	1.59



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/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)
																				
FF2 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。																				
CCGT 09T302E-FF2:T9325	●	0.2	■ 345	0.05	1.0	–	–	–	◪ 325	0.05	1.0	–	–	–	–	–	–	–	–	–
 																				
FF2 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。																				
CCMT 060202E-FF2:T8430	●	0.2	■ 280	0.05	0.8	–	–	–	◪ 230	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-FF2:T9325	●	0.2	■ 350	0.05	0.8	–	–	–	◪ 330	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-FF2:T9415	●	0.2	■ 395	0.05	0.8	–	–	–	◪ 375	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-FF2:TT010	●	0.2	■ 345	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T7325	●	0.4	◪ 190	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T8430	●	0.4	■ 205	0.12	1.0	–	–	–	◪ 170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T9325	●	0.4	■ 255	0.12	1.0	–	–	–	◪ 240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T9335	●	0.4	■ 215	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T9415	●	0.4	■ 305	0.12	1.0	–	–	–	◪ 285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:TT010	●	0.4	■ 280	0.12	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080302E-FF2:T8430	●	0.2	■ 280	0.05	0.8	–	–	–	◪ 230	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 080302E-FF2:T9325	●	0.2	■ 350	0.05	0.8	–	–	–	◪ 330	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:T7325	●	0.4	◪ 190	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:T8430	●	0.4	■ 205	0.12	1.0	–	–	–	◪ 170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:T9325	●	0.4	■ 255	0.12	1.0	–	–	–	◪ 240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:TT010	●	0.4	■ 350	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080308E-FF2:T8430	⬌	0.8	■ 210	0.17	1.0	–	–	–	◪ 175	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FF2:T9325	●	0.8	■ 260	0.17	1.0	–	–	–	◪ 245	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T8430	●	0.4	■ 200	0.12	1.2	–	–	–	◪ 165	0.12	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T9325	●	0.4	■ 250	0.12	1.2	–	–	–	◪ 235	0.12	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T9335	●	0.4	■ 215	0.12	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T9415	●	0.4	■ 300	0.12	1.2	–	–	–	◪ 285	0.12	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:TT010	●	0.4	■ 350	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:T8430	⬌	0.8	■ 205	0.17	1.2	–	–	–	◪ 170	0.17	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:T9325	●	0.8	■ 255	0.17	1.2	–	–	–	◪ 240	0.17	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:T9415	●	0.8	■ 300	0.20	1.2	–	–	–	◪ 285	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:TT010	●	0.8	■ 350	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
FF2 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。																				
DCGT 11T302E-FF2:T8430	●	0.2	■ 225	0.05	0.8	–	–	–	◪ 185	0.05	0.8	–	–	–	–	–	–	–	–	–
DCGT 11T302E-FF2:T9325	●	0.2	■ 280	0.05	0.8	–	–	–	◪ 265	0.05	0.8	–	–	–	–	–	–	–	–	–
DCGT 11T302E-FF2:TT010	●	0.2	■ 275	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																				
FF2 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。																				
DCMT 070202E-FF2:T7325	●	0.2	◪ 190	0.05	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070202E-FF2:T8430	●	0.2	■ 225	0.05	0.8	–	–	–	◪ 185	0.05	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-FF2:T9325	●	0.2	■ 280	0.05	0.8	–	–	–	◪ 265	0.05	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-FF2:TT010	●	0.2	■ 275	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T7325	●	0.4	◪ 160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T8430	●	0.4	■ 170	0.12	0.8	–	–	–	◪ 135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T9325	●	0.4	■ 205	0.12	0.8	–	–	–	◪ 190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T9415	●	0.4	■ 250	0.12	0.8	–	–	–	◪ 235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T7325	●	0.8	◪ 170	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T8430	●	0.8	■ 175	0.17	0.8	–	–	–	◪ 140	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T9325	●	0.8	■ 215	0.17	0.8	–	–	–	◪ 200	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T9415	●	0.8	■ 265	0.17	0.8	–	–	–	◪ 250	0.17	0.8	–	–	–	–	–	–	–	–	–

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。

Product		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)
 																				
DCMT 11T304E-FF2:T7325	●	0.4	◪	160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2:T8430	●	0.4	■	170	0.12	0.8	–	–	–	◪	135	0.12	0.8	–	–	–	–	–	–	–
DCMT 11T304E-FF2:T9325	●	0.4	■	205	0.12	0.8	–	–	–	◪	190	0.12	0.8	–	–	–	–	–	–	–
DCMT 11T304E-FF2:T9415	●	0.4	■	250	0.12	0.8	–	–	–	◪	235	0.12	0.8	–	–	–	–	–	–	–
DCMT 11T304E-FF2:TT010	●	0.4	■	280	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T7325	●	0.8	◪	170	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T8430	●	0.8	■	175	0.17	0.8	–	–	–	◪	140	0.17	0.8	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T9325	●	0.8	■	215	0.17	0.8	–	–	–	◪	200	0.17	0.8	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T9415	●	0.8	■	265	0.17	0.8	–	–	–	◪	250	0.17	0.8	–	–	–	–	–	–	–
DCMT 11T308E-FF2:TT010	●	0.8	■	280	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																				
SCMT 09T304E-FF2:T8430	●	0.4	■	210	0.12	1.2	–	–	–	◪	175	0.12	1.2	–	–	–	–	–	–	–
SCMT 09T304E-FF2:T9325	●	0.4	■	260	0.12	1.2	–	–	–	◪	245	0.12	1.2	–	–	–	–	–	–	–
SCMT 09T308E-FF2:T8430	◓	0.8	■	220	0.17	1.2	–	–	–	◪	180	0.17	1.2	–	–	–	–	–	–	–
SCMT 09T308E-FF2:T9325	●	0.8	■	265	0.17	1.2	–	–	–	◪	250	0.17	1.2	–	–	–	–	–	–	–
																				
TCGT 06T102E-FF2:T8430	●	0.2	■	235	0.05	0.8	–	–	–	◪	190	0.05	0.8	–	–	–	–	–	–	–
TCGT 06T102E-FF2:TT010	●	0.2	■	295	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCGT 090202E-FF2:TT010	●	0.2	■	295	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
TCMT 06T102E-FF2:T8430	●	0.2	■	235	0.05	0.8	–	–	–	◪	190	0.05	0.8	–	–	–	–	–	–	–
TCMT 06T102E-FF2:T9415	●	0.2	■	335	0.05	0.8	–	–	–	◪	315	0.05	0.8	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T7325	●	0.4	◪	170	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T8430	●	0.4	■	180	0.12	0.8	–	–	–	◪	145	0.12	0.8	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T9325	●	0.4	■	220	0.12	0.8	–	–	–	◪	205	0.12	0.8	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T9415	●	0.4	■	265	0.12	0.8	–	–	–	◪	250	0.12	0.8	–	–	–	–	–	–	–
TCMT 090204E-FF2:T5315	●	0.4	◪	240	0.12	1.0	–	–	–	■	225	0.12	1.0	–	–	–	–	–	–	–
TCMT 090204E-FF2:T7325	●	0.4	◪	165	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T8430	●	0.4	■	175	0.12	1.0	–	–	–	◪	140	0.12	1.0	–	–	–	–	–	–	–
TCMT 090204E-FF2:T9325	●	0.4	■	215	0.12	1.0	–	–	–	◪	200	0.12	1.0	–	–	–	–	–	–	–
TCMT 090204E-FF2:T9415	●	0.4	■	260	0.12	1.0	–	–	–	◪	245	0.12	1.0	–	–	–	–	–	–	–
TCMT 110204E-FF2:T8430	●	0.4	■	180	0.12	0.8	–	–	–	◪	145	0.12	0.8	–	–	–	–	–	–	–
TCMT 110204E-FF2:T9325	●	0.4	■	220	0.12	0.8	–	–	–	◪	205	0.12	0.8	–	–	–	–	–	–	–
TCMT 110204E-FF2:T9335	●	0.4	■	185	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2:T9415	●	0.4	■	265	0.12	0.8	–	–	–	◪	250	0.12	0.8	–	–	–	–	–	–	–
TCMT 110208E-FF2:T8430	●	0.8	■	185	0.17	0.8	–	–	–	◪	150	0.17	0.8	–	–	–	–	–	–	–
TCMT 110208E-FF2:T9325	●	0.8	■	225	0.17	0.8	–	–	–	◪	210	0.17	0.8	–	–	–	–	–	–	–
TCMT 110208E-FF2:T9415	●	0.8	■	280	0.17	0.8	–	–	–	◪	265	0.17	0.8	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T8430	●	0.4	■	180	0.12	0.8	–	–	–	◪	145	0.12	0.8	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T9325	●	0.4	■	220	0.12	0.8	–	–	–	◪	205	0.12	0.8	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T9335	●	0.4	■	185	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T9415	●	0.4	■	265	0.12	0.8	–	–	–	◪	250	0.12	0.8	–	–	–	–	–	–	–
TCMT 16T304E-FF2:TT010	●	0.4	■	295	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–

FF2 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。

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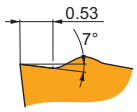
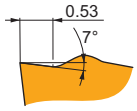
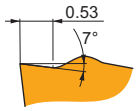
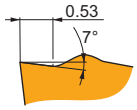
Product	●	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
TCMT 16T308E-FF2:T8430	●	0.8	185	0.17	0.8	–	–	–	150	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2:T9325	●	0.8	225	0.17	0.8	–	–	–	210	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2:T9335	●	0.8	195	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2:T9415	●	0.8	280	0.17	0.8	–	–	–	265	0.17	0.8	–	–	–	–	–	–	–	–	–
																				
VBMT 160404E-FF2:T7325	●	0.4	145	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T8430	●	0.4	150	0.12	0.8	–	–	–	125	0.12	0.8	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T9325	●	0.4	190	0.12	0.8	–	–	–	180	0.12	0.8	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T9335	●	0.4	160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T9415	●	0.4	230	0.12	0.8	–	–	–	215	0.12	0.8	–	–	–	–	–	–	–	–	–
																				
VCGT 070202E-FF2:T8315	●	0.2	150	0.05	0.8	–	–	–	140	0.05	0.8	–	–	–	–	–	–	–	–	–
VCGT 070202E-FF2:T8415	●	0.2	185	0.05	0.8	–	–	–	165	0.05	0.8	–	–	–	–	–	–	–	–	–
VCGT 070202E-FF2:T8430	●	0.2	190	0.05	0.8	–	–	–	155	0.05	0.8	–	–	–	–	–	–	–	–	–
VCGT 070204E-FF2:T8315	●	0.4	125	0.12	0.8	–	–	–	115	0.12	0.8	–	–	–	–	–	–	–	–	–
VCGT 070204E-FF2:T8415	●	0.4	155	0.12	0.8	–	–	–	140	0.12	0.8	–	–	–	–	–	–	–	–	–
VCGT 070204E-FF2:T8430	●	0.4	145	0.12	0.8	–	–	–	120	0.12	0.8	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T5315	●	0.2	250	0.05	1.0	–	–	–	235	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T8430	●	0.2	185	0.05	1.0	–	–	–	150	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T9325	●	0.2	240	0.05	1.0	–	–	–	225	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T9415	●	0.2	270	0.05	1.0	–	–	–	255	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:TT010	●	0.2	240	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T5315	●	0.4	195	0.12	1.0	–	–	–	185	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T7325	●	0.4	135	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T8430	●	0.4	140	0.12	1.0	–	–	–	115	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T9325	●	0.4	175	0.12	1.0	–	–	–	165	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T9415	●	0.4	215	0.12	1.0	–	–	–	200	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:TT010	●	0.4	245	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2:T9325	●	0.8	180	0.17	1.0	–	–	–	170	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2:T9415	●	0.8	225	0.17	1.0	–	–	–	210	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2:TT010	●	0.8	245	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
VCGX 130300FR-FF2:T6310	●	0.0	140	0.05	1.0	–	–	–	110	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FR-FF2:T8315	●	0.0	150	0.05	1.0	–	–	–	140	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FR-FF2:T8415	●	0.0	180	0.05	1.0	–	–	–	160	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FR-FF2:TT010	●	0.0	240	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:T6310	●	0.1	140	0.05	1.0	–	–	–	110	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:T8315	●	0.1	150	0.05	1.0	–	–	–	140	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:T8415	●	0.1	180	0.05	1.0	–	–	–	160	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:TT010	●	0.1	240	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

FF2 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。

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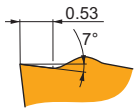
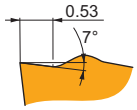
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
FF2 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。																				
VCGX 130300FL-FF2:T8315	●	0.0	◪	150	0.05	1.0	–	–	–	■	140	0.05	1.0	–	–	–	–	–	–	–	–	–	–
VCGX 130300FL-FF2:T8415	●	0.0	■	180	0.05	1.0	–	–	–	■	160	0.05	1.0	–	–	–	–	–	–	–	–	–	–
VCGX 130300FL-FF2:TT010	●	0.0	■	240	0.05	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–	–
VCGX 130301FL-FF2:T8315	●	0.1	◪	150	0.05	1.0	–	–	–	■	140	0.05	1.0	–	–	–	–	–	–	–	–	–	–
VCGX 130301FL-FF2:T8415	●	0.1	■	180	0.05	1.0	–	–	–	■	160	0.05	1.0	–	–	–	–	–	–	–	–	–	–
																				
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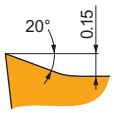
WCGT 020102E-FF2:HF7	●	0.2		–	–	–	–	–	–	■	210	0.05	0.8	–	–	–	–	–	–	–	–	–	–
WCGT 020102E-FF2:T8430	●	0.2	■	280	0.05	0.8	–	–	–	◪	230	0.05	0.8	–	–	–	–	–	–	–	–	–	–
WCGT 020102E-FF2:TT010	●	0.2	■	345	0.05	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–	–
WCGT 020104E-FF2:HF7	●	0.4		–	–	–	–	–	–	■	155	0.12	0.8	–	–	–	–	–	–	–	–	–	–
WCGT 020104E-FF2:T8430	●	0.4	■	205	0.12	0.8	–	–	–	◪	170	0.12	0.8	–	–	–	–	–	–	–	–	–	–
WCGT 020104E-FF2:TT010	●	0.4	■	350	0.06	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–	–

SF3



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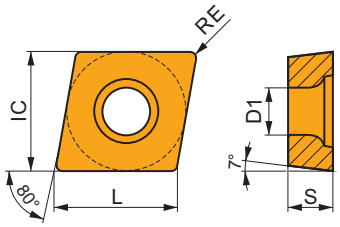
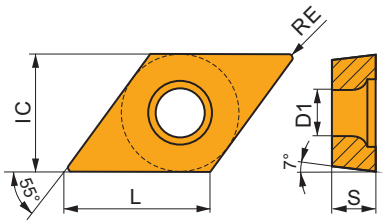
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602-SF3	6.350	2.80	6.40	2.58
0803-SF3	7.940	3.40	8.10	3.43
09T3-SF3	9.525	4.40	9.70	4.22
1204-SF3	12.700	5.50	12.90	5.01



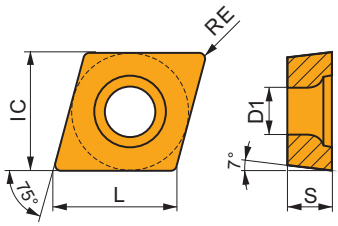
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702-SF3	6.350	2.80	7.80	2.58
11T3-SF3	9.525	4.40	11.60	4.22



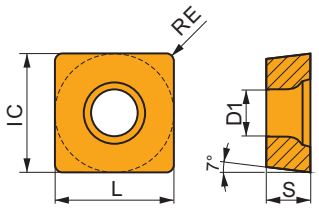
ECGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602-SF3	6.350	2.80	6.50	2.58
0803-SF3	7.940	3.40	8.20	3.43



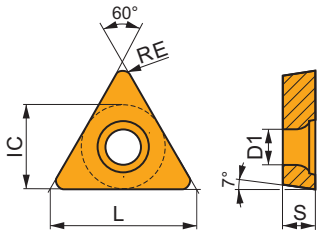
SCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3-SF3	9.525	4.40	9.53	4.22



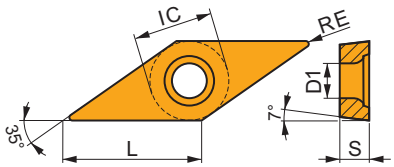
TCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102-SF3	6.350	2.80	11.00	2.58
16T3-SF3	9.525	4.40	16.50	4.22



VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	3.970	2.20	6.90	2.38
1102-SF3	6.350	2.80	11.10	2.58
1103-SF3	6.350	2.80	11.10	3.43
1303-SF3	7.940	3.40	13.80	3.43
1604-SF3	9.525	4.40	16.60	5.01



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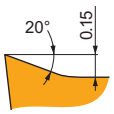

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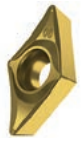
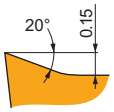
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CCGT 060201E-SF3:T6310	●	0.1	200	0.05	0.5	140	0.05	0.5	160	0.05	0.5	600	0.06	0.5	60	0.04	0.4	40	0.05	0.1
CCGT 060202E-SF3:T6310	●	0.2	205	0.05	0.8	145	0.05	0.8	165	0.05	0.8	615	0.06	0.8	60	0.04	0.6	40	0.05	0.2
CCGT 060202E-SF3:T8315	●	0.2	215	0.05	0.8	125	0.05	0.8	200	0.05	0.8	645	0.06	0.8	50	0.04	0.6	40	0.05	0.2
CCGT 060202E-SF3:T8415	●	0.2	270	0.05	0.8	140	0.04	0.8	245	0.05	0.8	675	0.06	0.8	60	0.04	0.6	45	0.05	0.2
CCGT 060204E-SF3:H07	●	0.4	–	–	–	95	0.09	0.8	150	0.10	0.8	485	0.12	0.8	45	0.07	0.6	–	–	–
CCGT 060204E-SF3:T6310	●	0.4	180	0.10	0.8	125	0.09	0.8	145	0.10	0.8	540	0.12	0.8	50	0.07	0.6	35	0.07	0.3
CCGT 060204E-SF3:T8315	●	0.4	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	570	0.12	0.8	45	0.07	0.6	35	0.07	0.3
CCGT 060204E-SF3:T8415	●	0.4	230	0.10	0.8	120	0.09	0.8	210	0.10	0.8	585	0.12	0.8	50	0.07	0.6	40	0.07	0.3
CCGT 080302E-SF3:T6310	●	0.2	205	0.05	0.8	145	0.05	0.8	165	0.05	0.8	615	0.06	0.8	60	0.04	0.6	40	0.05	0.2
CCGT 080302E-SF3:T8315	●	0.2	215	0.05	0.8	125	0.05	0.8	200	0.05	0.8	645	0.06	0.8	50	0.04	0.6	40	0.05	0.2
CCGT 080302E-SF3:T8415	●	0.2	270	0.05	0.8	140	0.04	0.8	245	0.05	0.8	675	0.06	0.8	60	0.04	0.6	45	0.05	0.2
CCGT 080304E-SF3:T6310	●	0.4	180	0.10	1.0	125	0.09	1.0	145	0.10	1.0	540	0.12	1.0	50	0.07	0.8	35	0.10	0.3
CCGT 080304E-SF3:T8315	●	0.4	190	0.10	1.0	110	0.09	1.0	180	0.10	1.0	570	0.12	1.0	45	0.07	0.8	35	0.10	0.3
CCGT 080304E-SF3:T8415	●	0.4	225	0.10	1.0	115	0.09	1.0	205	0.10	1.0	570	0.12	1.0	50	0.07	0.8	35	0.10	0.3
CCGT 09T301E-SF3:T6310	●	0.1	200	0.05	0.5	140	0.05	0.5	160	0.05	0.5	600	0.06	0.5	60	0.04	0.4	40	0.05	0.1
CCGT 09T302E-SF3:T6310	●	0.2	205	0.05	0.8	145	0.05	0.8	165	0.05	0.8	615	0.06	0.8	60	0.04	0.6	40	0.05	0.2
CCGT 09T302E-SF3:T8315	●	0.2	215	0.05	0.8	125	0.05	0.8	200	0.05	0.8	645	0.06	0.8	50	0.04	0.6	40	0.05	0.2
CCGT 09T302E-SF3:T8415	●	0.2	270	0.05	0.8	140	0.04	0.8	245	0.05	0.8	675	0.06	0.8	60	0.04	0.6	45	0.05	0.2
CCGT 09T304E-SF3:H07	●	0.4	–	–	–	95	0.09	1.0	150	0.10	1.0	485	0.12	1.0	45	0.07	0.8	–	–	–
CCGT 09T304E-SF3:T6310	●	0.4	180	0.10	1.0	125	0.09	1.0	145	0.10	1.0	540	0.12	1.0	50	0.07	0.8	35	0.05	0.3
CCGT 09T304E-SF3:T8315	●	0.4	190	0.10	1.0	110	0.09	1.0	180	0.10	1.0	570	0.12	1.0	45	0.07	0.8	35	0.05	0.3
CCGT 09T304E-SF3:T8415	●	0.4	225	0.10	1.0	115	0.09	1.0	205	0.10	1.0	570	0.12	1.0	50	0.07	0.8	35	0.05	0.3
CCGT 09T308E-SF3:H07	●	0.8	–	–	–	110	0.09	1.0	175	0.10	1.0	565	0.12	1.0	55	0.08	0.8	–	–	–
CCGT 09T308E-SF3:T6310	●	0.8	210	0.10	1.0	150	0.09	1.0	165	0.10	1.0	630	0.12	1.0	60	0.08	0.8	40	0.08	0.7
CCGT 09T308E-SF3:T8315	⚙	0.8	225	0.10	1.0	135	0.09	1.0	210	0.10	1.0	675	0.12	1.0	55	0.08	0.8	45	0.08	0.7
CCGT 09T308E-SF3:T8415	⚙	0.8	275	0.10	1.0	140	0.09	1.0	250	0.10	1.0	690	0.12	1.0	60	0.08	0.8	45	0.08	0.7
CCGT 120404E-SF3:T6310	●	0.4	180	0.10	1.0	125	0.09	1.0	145	0.10	1.0	540	0.12	1.0	50	0.07	0.8	35	0.07	0.3
CCGT 120404E-SF3:T8415	●	0.4	225	0.10	1.0	115	0.09	1.0	205	0.10	1.0	570	0.12	1.0	50	0.07	0.8	35	0.07	0.3
CCGT 120408E-SF3:H07	●	0.8	–	–	–	105	0.12	1.0	165	0.12	1.0	525	0.14	1.0	50	0.11	0.8	–	–	–
CCGT 120408E-SF3:T6310	●	0.8	200	0.12	1.0	140	0.12	1.0	160	0.12	1.0	600	0.14	1.0	60	0.11	0.8	40	0.10	0.7
CCGT 120408E-SF3:T8315	⚙	0.8	210	0.12	1.0	125	0.12	1.0	195	0.12	1.0	630	0.14	1.0	50	0.11	0.8	40	0.10	0.7
CCGT 120408E-SF3:T8415	⚙	0.8	255	0.12	1.0	135	0.12	1.0	230	0.12	1.0	645	0.14	1.0	55	0.11	0.8	45	0.10	0.7





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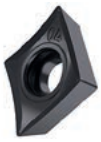
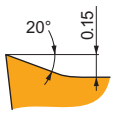
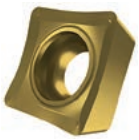
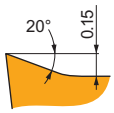
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
DCGT 070201E-SF3:T6310	●	0.1	160	0.05	0.5	115	0.05	0.5	125	0.05	0.5	480	0.06	0.5	45	0.04	0.4	30	0.05	0.1
DCGT 070202E-SF3:T6310	●	0.2	165	0.05	0.8	115	0.05	0.8	130	0.05	0.8	495	0.06	0.8	45	0.04	0.6	30	0.05	0.2
DCGT 070202E-SF3:T8315	●	0.2	175	0.05	0.8	105	0.05	0.8	165	0.05	0.8	525	0.06	0.8	40	0.04	0.6	35	0.05	0.2
DCGT 070202E-SF3:T8415	●	0.2	215	0.05	0.8	110	0.04	0.8	195	0.05	0.8	540	0.06	0.8	45	0.04	0.6	35	0.05	0.2
DCGT 070204E-SF3:H07	●	0.4	–	–	–	75	0.09	0.8	120	0.10	0.8	390	0.12	0.8	35	0.07	0.6	–	–	–
DCGT 070204E-SF3:T6310	●	0.4	145	0.10	0.8	100	0.09	0.8	115	0.10	0.8	435	0.12	0.8	40	0.07	0.6	25	0.07	0.3
DCGT 070204E-SF3:T8315	●	0.4	155	0.10	0.8	90	0.09	0.8	145	0.10	0.8	465	0.12	0.8	35	0.07	0.6	30	0.07	0.3
DCGT 070204E-SF3:T8415	●	0.4	185	0.10	0.8	95	0.09	0.8	165	0.10	0.8	465	0.12	0.8	40	0.07	0.6	30	0.07	0.3
DCGT 11T301E-SF3:T6310	●	0.1	160	0.05	0.5	115	0.05	0.5	125	0.05	0.5	480	0.06	0.5	45	0.04	0.4	30	0.05	0.1
DCGT 11T302E-SF3:H07	●	0.2	–	–	–	95	0.05	0.8	150	0.05	0.8	485	0.06	0.8	45	0.04	0.6	–	–	–
DCGT 11T302E-SF3:T6310	●	0.2	165	0.05	0.8	115	0.05	0.8	130	0.05	0.8	495	0.06	0.8	45	0.04	0.6	30	0.05	0.2
DCGT 11T302E-SF3:T8415	●	0.2	215	0.05	0.8	110	0.04	0.8	195	0.05	0.8	540	0.06	0.8	45	0.04	0.6	35	0.05	0.2
DCGT 11T304E-SF3:H07	●	0.4	–	–	–	75	0.09	0.8	120	0.10	0.8	390	0.12	0.8	35	0.07	0.6	–	–	–
DCGT 11T304E-SF3:T6310	●	0.4	145	0.10	0.8	100	0.09	0.8	115	0.10	0.8	435	0.12	0.8	40	0.07	0.6	25	0.07	0.3
DCGT 11T304E-SF3:T8315	●	0.4	155	0.10	0.8	90	0.09	0.8	145	0.10	0.8	465	0.12	0.8	35	0.07	0.6	30	0.07	0.3
DCGT 11T304E-SF3:T8415	●	0.4	185	0.10	0.8	95	0.09	0.8	165	0.10	0.8	465	0.12	0.8	40	0.07	0.6	30	0.07	0.3
DCGT 11T308E-SF3:H07	●	0.8	–	–	–	90	0.09	0.8	145	0.10	0.8	455	0.12	0.8	45	0.08	0.6	–	–	–
DCGT 11T308E-SF3:T6310	●	0.8	170	0.10	0.8	120	0.09	0.8	135	0.10	0.8	510	0.12	0.8	50	0.08	0.6	30	0.08	0.7
DCGT 11T308E-SF3:T8315	●	0.8	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	540	0.12	0.8	45	0.08	0.6	35	0.08	0.7
DCGT 11T308E-SF3:T8415	●	0.8	220	0.10	0.8	115	0.09	0.8	200	0.10	0.8	555	0.12	0.8	50	0.08	0.6	35	0.08	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。

Product		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)
																				
																				
SF3 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。具有大正前角，无T-型倒棱。也可用于有色金属（非铁）合金，以及有条件地适用于钢、铸铁和硬质材料。																				
ECGT 060202E-SF3:H07	●	0.2		–	–	–	◪	105	0.05	0.8	◪	170	0.05	0.8	■	540	0.06	0.8	■	55	0.04	0.6		–	–	–
ECGT 060202E-SF3:T6310	●	0.2	◪	185	0.05	0.8	■	130	0.05	0.8	◪	145	0.05	0.8	■	555	0.06	0.8	■	55	0.04	0.6	◪	35	0.05	0.2
ECGT 060202E-SF3:T8415	●	0.2	◪	240	0.05	0.8	■	125	0.04	0.8	◪	215	0.05	0.8	◪	600	0.06	0.8	■	55	0.04	0.6	◪	40	0.05	0.2
ECGT 080304E-SF3:H07	●	0.4		–	–	–	◪	85	0.09	1.0	◪	135	0.10	1.0	■	430	0.12	1.0	■	40	0.07	0.8		–	–	–
ECGT 080304E-SF3:T6310	●	0.4	◪	160	0.10	1.0	■	115	0.09	1.0	◪	125	0.10	1.0	■	480	0.12	1.0	■	45	0.07	0.8	◪	30	0.05	0.3
ECGT 080304E-SF3:T8415	●	0.4	◪	200	0.10	1.0	■	105	0.09	1.0	◪	185	0.10	1.0	◪	510	0.12	1.0	■	45	0.07	0.8	◪	35	0.05	0.3
																				
																				
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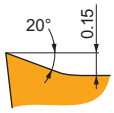
SCGT 09T304E-SF3:H07	●	0.4		–	–	–	◪	95	0.09	1.0	◪	155	0.10	1.0	■	495	0.12	1.0	■	50	0.07	0.8		–	–	–
SCGT 09T304E-SF3:T6310	●	0.4	◪	185	0.10	1.0	■	130	0.09	1.0	◪	145	0.10	1.0	■	555	0.12	1.0	■	55	0.07	0.8	◪	35	0.05	0.3
SCGT 09T304E-SF3:T8315	●	0.4	◪	200	0.10	1.0	■	120	0.09	1.0	◪	190	0.10	1.0	■	600	0.12	1.0	◪	50	0.07	0.8	◪	40	0.05	0.3
SCGT 09T304E-SF3:T8415	●	0.4	◪	240	0.10	1.0	■	125	0.09	1.0	◪	215	0.10	1.0	◪	600	0.12	1.0	■	55	0.07	0.8	◪	40	0.05	0.3
SCGT 09T308E-SF3:T6310	⬌	0.8	◪	210	0.12	1.0	■	150	0.12	1.0	◪	165	0.12	1.0	■	630	0.14	1.0	■	60	0.11	0.8	◪	40	0.10	0.7
SCGT 09T308E-SF3:T8315	⬌	0.8	◪	220	0.12	1.0	■	130	0.12	1.0	◪	205	0.12	1.0	■	660	0.14	1.0	◪	55	0.11	0.8	◪	40	0.10	0.7
SCGT 09T308E-SF3:T8415	⬌	0.8	◪	270	0.12	1.0	■	140	0.12	1.0	◪	245	0.12	1.0	◪	675	0.14	1.0	■	60	0.11	0.8	◪	45	0.10	0.7
																				
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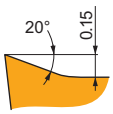
TCGT 110202E-SF3:T6310	●	0.2	◪	175	0.05	0.8	■	125	0.05	0.8	◪	140	0.05	0.8	■	525	0.06	0.8	■	50	0.04	0.6	◪	35	0.05	0.2
TCGT 110202E-SF3:T8315	●	0.2	◪	185	0.05	0.8	■	110	0.05	0.8	◪	175	0.05	0.8	■	555	0.06	0.8	◪	45	0.04	0.6	◪	35	0.05	0.2
TCGT 110202E-SF3:T8415	●	0.2	◪	225	0.05	0.8	■	115	0.04	0.8	◪	205	0.05	0.8	◪	570	0.06	0.8	■	50	0.04	0.6	◪	35	0.05	0.2
TCGT 110204E-SF3:H07	●	0.4		–	–	–	◪	80	0.09	0.8	◪	130	0.10	0.8	■	415	0.12	0.8	■	40	0.07	0.6		–	–	–
TCGT 110204E-SF3:T6310	●	0.4	◪	155	0.10	0.8	■	110	0.09	0.8	◪	125	0.10	0.8	■	465	0.12	0.8	■	45	0.07	0.6	◪	30	0.07	0.3
TCGT 110204E-SF3:T8315	●	0.4	◪	165	0.10	0.8	■	95	0.09	0.8	◪	155	0.10	0.8	■	495	0.12	0.8	◪	40	0.07	0.6	◪	30	0.07	0.3
TCGT 110204E-SF3:T8415	●	0.4	◪	195	0.10	0.8	■	100	0.09	0.8	◪	180	0.10	0.8	◪	495	0.12	0.8	■	45	0.07	0.6	◪	30	0.07	0.3
TCGT 16T304E-SF3:H07	●	0.4		–	–	–	◪	80	0.09	1.0	◪	125	0.10	1.0	■	405	0.12	1.0	■	40	0.07	0.8		–	–	–
TCGT 16T304E-SF3:T6310	●	0.4	◪	150	0.10	1.0	■	105	0.09	1.0	◪	120	0.10	1.0	■	450	0.12	1.0	■	45	0.07	0.8	◪	30	0.07	0.3
TCGT 16T304E-SF3:T8315	●	0.4	◪	160	0.10	1.0	■	95	0.09	1.0	◪	150	0.10	1.0	■	480	0.12	1.0	◪	40	0.07	0.8	◪	30	0.07	0.3
TCGT 16T304E-SF3:T8415	●	0.4	◪	195	0.10	1.0	■	100	0.09	1.0	◪	180	0.10	1.0	◪	495	0.12	1.0	■	45	0.07	0.8	◪	30	0.07	0.3
TCGT 16T308E-SF3:H07	●	0.8		–	–	–	◪	90	0.09	1.2	◪	145	0.10	1.2	■	470	0.12	1.2	■	45	0.08	1.0		–	–	–
TCGT 16T308E-SF3:T6310	●	0.8	◪	175	0.10	1.2	■	125	0.09	1.2	◪	140	0.10	1.2	■	525	0.12	1.2	■	50	0.08	1.0	◪	35	0.08	0.7
TCGT 16T308E-SF3:T8315	●	0.8	◪	185	0.10	1.2	■	110	0.09	1.2	◪	175	0.10	1.2	■	555	0.12	1.2	◪	45	0.08	1.0	◪	35	0.08	0.7
TCGT 16T308E-SF3:T8415	●	0.8	◪	225	0.10	1.2	■	115	0.09	1.2	◪	205	0.10	1.2	◪	570	0.12	1.2	■	50	0.08	1.0	◪	35	0.08	0.7
TCGT 16T312E-SF3:T6310	●	1.2	◪	150	0.20	1.2	■	105	0.18	1.2	◪	120	0.20	1.2	■	450	0.24	1.2	■	45	0.14	1.0	◪	30	0.10	0.9
TCGT 16T312E-SF3:T8415	●	1.2	◪	190	0.20	1.2	■	100	0.18	1.2	◪	170	0.20	1.2	◪	480	0.24	1.2	■	40	0.14	1.0	◪	30	0.10	0.9

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。



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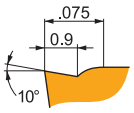
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
VCGT 070202E-SF3:H07	●	0.2	–	–	–	80	0.05	0.8	130	0.05	0.8	415	0.06	0.8	40	0.04	0.6	–	–	–
VCGT 070202E-SF3:T6310	●	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 070202E-SF3:T8415	●	0.2	185	0.05	0.8	95	0.04	0.8	165	0.05	0.8	465	0.06	0.8	40	0.04	0.6	30	0.05	0.2
VCGT 070204E-SF3:T6310	●	0.4	125	0.10	0.8	90	0.09	0.8	100	0.10	0.8	375	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 070204E-SF3:T8415	●	0.4	160	0.10	0.8	85	0.09	0.8	145	0.10	0.8	405	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 110202E-SF3:T6310	●	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 110202E-SF3:T8315	●	0.2	150	0.05	0.8	90	0.05	0.8	140	0.05	0.8	450	0.06	0.8	35	0.04	0.6	30	0.05	0.2
VCGT 110202E-SF3:T8415	●	0.2	185	0.05	0.8	95	0.04	0.8	165	0.05	0.8	465	0.06	0.8	40	0.04	0.6	30	0.05	0.2
VCGT 110204E-SF3:H07	●	0.4	–	–	–	65	0.09	0.8	105	0.10	0.8	335	0.12	0.8	30	0.07	0.6	–	–	–
VCGT 110204E-SF3:T6310	●	0.4	125	0.10	0.8	90	0.09	0.8	100	0.10	0.8	375	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 110204E-SF3:T8315	●	0.4	135	0.10	0.8	80	0.09	0.8	125	0.10	0.8	405	0.12	0.8	30	0.07	0.6	25	0.07	0.3
VCGT 110204E-SF3:T8415	●	0.4	160	0.10	0.8	85	0.09	0.8	145	0.10	0.8	405	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 110301E-SF3:T6310	●	0.1	140	0.05	0.5	100	0.05	0.5	110	0.05	0.5	420	0.06	0.5	40	0.04	0.4	25	0.05	0.1
VCGT 110302E-SF3:T6310	●	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 110304E-SF3:T6310	●	0.4	125	0.10	0.8	90	0.09	0.8	100	0.10	0.8	375	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 110304E-SF3:T8415	●	0.4	160	0.10	0.8	85	0.09	0.8	145	0.10	0.8	405	0.12	0.8	35	0.07	0.6	25	0.07	0.3
VCGT 130302E-SF3:H07	●	0.2	–	–	–	80	0.05	0.8	130	0.05	0.8	415	0.06	0.8	40	0.04	0.6	–	–	–
VCGT 130302E-SF3:T6310	●	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 130302E-SF3:T8315	●	0.2	150	0.05	0.8	90	0.05	0.8	140	0.05	0.8	450	0.06	0.8	35	0.04	0.6	30	0.05	0.2
VCGT 130302E-SF3:T8415	●	0.2	185	0.05	0.8	95	0.04	0.8	165	0.05	0.8	465	0.06	0.8	40	0.04	0.6	30	0.05	0.2
VCGT 130304E-SF3:H07	●	0.4	–	–	–	65	0.09	1.0	105	0.10	1.0	335	0.12	1.0	30	0.07	0.8	–	–	–
VCGT 130304E-SF3:T6310	●	0.4	125	0.10	1.0	90	0.09	1.0	100	0.10	1.0	375	0.12	1.0	35	0.07	0.8	25	0.07	0.3
VCGT 130304E-SF3:T8315	●	0.4	130	0.10	1.0	75	0.09	1.0	120	0.10	1.0	390	0.12	1.0	30	0.07	0.8	25	0.07	0.3
VCGT 130304E-SF3:T8415	●	0.4	160	0.10	1.0	85	0.09	1.0	145	0.10	1.0	405	0.12	1.0	35	0.07	0.8	25	0.07	0.3
VCGT 130308E-SF3:H07	●	0.8	–	–	–	75	0.09	1.0	120	0.10	1.0	390	0.12	1.0	35	0.08	0.8	–	–	–
VCGT 130308E-SF3:T6310	●	0.8	145	0.10	1.0	100	0.09	1.0	115	0.10	1.0	435	0.12	1.0	40	0.08	0.8	25	0.08	0.7
VCGT 130308E-SF3:T8315	●	0.8	155	0.10	1.0	90	0.09	1.0	145	0.10	1.0	465	0.12	1.0	35	0.08	0.8	30	0.08	0.7
VCGT 130308E-SF3:T8415	●	0.8	190	0.10	1.0	100	0.09	1.0	170	0.10	1.0	480	0.12	1.0	40	0.08	0.8	30	0.08	0.7
VCGT 160402E-SF3:T6310	●	0.2	145	0.05	0.8	100	0.05	0.8	115	0.05	0.8	435	0.06	0.8	40	0.04	0.6	25	0.05	0.2
VCGT 160402E-SF3:T8415	●	0.2	185	0.05	0.8	95	0.04	0.8	165	0.05	0.8	465	0.06	0.8	40	0.04	0.6	30	0.05	0.2
VCGT 160404E-SF3:H07	●	0.4	–	–	–	65	0.09	1.0	105	0.10	1.0	335	0.12	1.0	30	0.07	0.8	–	–	–
VCGT 160404E-SF3:T6310	●	0.4	125	0.10	1.0	90	0.09	1.0	100	0.10	1.0	375	0.12	1.0	35	0.07	0.8	25	0.07	0.3
VCGT 160404E-SF3:T8315	●	0.4	130	0.10	1.0	75	0.09	1.0	120	0.10	1.0	390	0.12	1.0	30	0.07	0.8	25	0.07	0.3
VCGT 160404E-SF3:T8415	●	0.4	160	0.10	1.0	85	0.09	1.0	145	0.10	1.0	405	0.12	1.0	35	0.07	0.8	25	0.07	0.3
VCGT 160408E-SF3:H07	●	0.8	–	–	–	75	0.09	1.2	120	0.10	1.2	390	0.12	1.2	35	0.08	1.0	–	–	–
VCGT 160408E-SF3:T6310	●	0.8	145	0.10	1.2	100	0.09	1.2	115	0.10	1.2	435	0.12	1.2	40	0.08	1.0	25	0.08	0.7
VCGT 160408E-SF3:T8315	●	0.8	155	0.10	1.2	90	0.09	1.2	145	0.10	1.2	465	0.12	1.2	35	0.08	1.0	30	0.08	0.7
VCGT 160408E-SF3:T8415	●	0.8	185	0.10	1.2	95	0.09	1.2	165	0.10	1.2	465	0.12	1.2	40	0.08	1.0	30	0.08	0.7
VCGT 160412E-SF3:H07	●	1.2	–	–	–	60	0.18	1.2	95	0.20	1.2	310	0.24	1.2	30	0.14	1.0	–	–	–
VCGT 160412E-SF3:T6310	●	1.2	125	0.20	1.2	90	0.18	1.2	100	0.20	1.2	375	0.24	1.2	35	0.14	1.0	25	0.10	0.9
VCGT 160412E-SF3:T8415	●	1.2	160	0.20	1.2	85	0.18	1.2	145	0.20	1.2	405	0.24	1.2	35	0.14	1.0	25	0.10	0.9

NF1

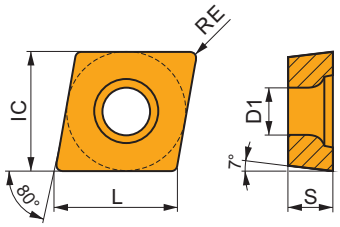


NF1 型断屑槽锋利，专为钢材、不锈钢和超级合金的精加工而设计。它具有正前角，无 T倒棱。它也有条件地适用于有色金属合金和硬质材料。

PRAMET

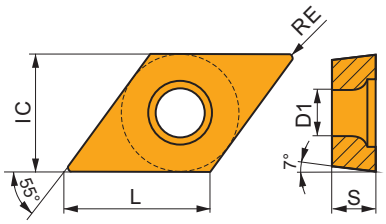
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97



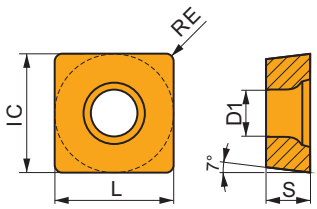
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97



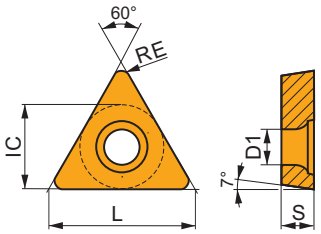
SCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76

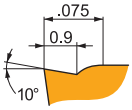
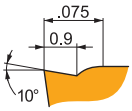
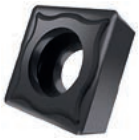
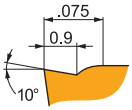
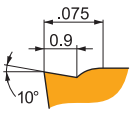


TCGT

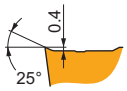
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38



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。

Product		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)
																				
NF1 型断屑槽锋利，专为钢材、不锈钢和超级合金的精加工而设计。它具有正前角，无 T倒棱。它也有条件地适用于有色金属合金和硬质材料。																				
CCGT 060204E-NF1:T6310	●	0.4	180	0.10	0.8	125	0.09	0.8	–	–	–	540	0.12	0.8	50	0.07	0.6	35	0.08	0.3
CCGT 060204E-NF1:T7325	●	0.4	210	0.10	0.8	160	0.09	0.8	–	–	–	–	–	–	65	0.07	0.6	–	–	–
CCGT 060208E-NF1:T6310	⬌	0.8	205	0.12	0.8	145	0.11	0.8	–	–	–	615	0.14	0.8	60	0.11	0.6	40	0.09	0.7
CCGT 09T304E-NF1:T6310	●	0.4	175	0.10	1.2	125	0.09	1.2	–	–	–	525	0.12	1.2	50	0.07	1.0	35	0.08	0.3
CCGT 09T304E-NF1:T7325	●	0.4	200	0.10	1.2	155	0.09	1.2	–	–	–	–	–	–	65	0.07	1.0	–	–	–
CCGT 09T308E-NF1:T6310	⬌	0.8	190	0.14	1.2	135	0.13	1.2	–	–	–	570	0.17	1.2	55	0.13	1.0	35	0.11	0.7
CCGT 09T308E-NF1:T7325	⬌	0.8	215	0.14	1.2	165	0.13	1.2	–	–	–	–	–	–	65	0.13	1.0	–	–	–
																				
NF1 型断屑槽锋利，专为钢材、不锈钢和超级合金的精加工而设计。它具有正前角，无 T倒棱。它也有条件地适用于有色金属合金和硬质材料。																				
DCGT 11T304E-NF1:T6310	●	0.4	145	0.10	0.8	100	0.09	0.8	–	–	–	435	0.12	0.8	40	0.07	0.6	25	0.07	0.3
DCGT 11T304E-NF1:T7325	●	0.4	165	0.10	0.8	125	0.09	0.8	–	–	–	–	–	–	50	0.07	0.6	–	–	–
DCGT 11T308E-NF1:T6310	●	0.8	155	0.14	0.8	110	0.13	0.8	–	–	–	465	0.17	0.8	45	0.13	0.6	30	0.10	0.7
DCGT 11T308E-NF1:T7325	●	0.8	180	0.14	0.8	140	0.13	0.8	–	–	–	–	–	–	55	0.13	0.6	–	–	–
 																				
NF1 型断屑槽锋利，专为钢材、不锈钢和超级合金的精加工而设计。它具有正前角，无 T倒棱。它也有条件地适用于有色金属合金和硬质材料。																				
SCGT 09T308E-NF1:T6310	⬌	0.8	200	0.14	1.2	140	0.13	1.2	–	–	–	600	0.17	1.2	60	0.13	1.0	40	0.10	0.7
SCGT 120408E-NF1:T6310	⬌	0.8	180	0.18	1.4	125	0.16	1.4	–	–	–	540	0.22	1.4	50	0.16	1.1	35	0.13	0.7
SCGT 120408E-NF1:T7325	⬌	0.8	205	0.18	1.4	155	0.16	1.4	–	–	–	–	–	–	65	0.16	1.1	–	–	–
																				
NF1 型断屑槽锋利，专为钢材、不锈钢和超级合金的精加工而设计。它具有正前角，无 T倒棱。它也有条件地适用于有色金属合金和硬质材料。																				
TCGT 110204E-NF1:T6310	●	0.4	155	0.10	0.8	110	0.09	0.8	–	–	–	465	0.12	0.8	45	0.08	0.6	30	0.08	0.3

SF2



SF2 型断屑槽锋利，专为不锈钢和超级合金的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于钢和有色金属合金。

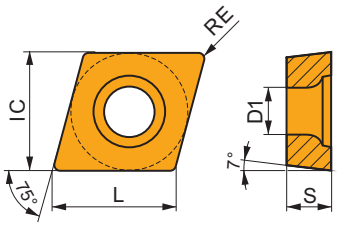
PRAMET

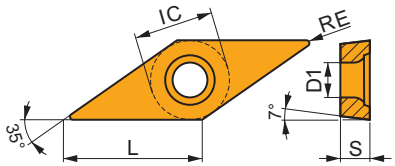
ECGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18

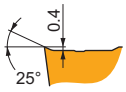
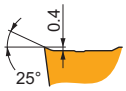
VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18

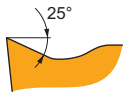




线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	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)
																				
SF2 型断屑槽锋利，专为不锈钢和超级合金的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于钢和有色金属合金。																				
ECGT 060202E-SF2:H07	●	0.2		–	–	–	◪	105	0.05	1.0		–	–	–	◪	525	0.06	1.0	■	50	0.04	0.8		–	–	–
ECGT 060202E-SF2:T6310	●	0.2	◪	185	0.05	1.0	■	130	0.05	1.0		–	–	–	◪	555	0.06	1.0	■	55	0.04	0.8		–	–	–
ECGT 060204E-SF2:H07	●	0.4		–	–	–	◪	85	0.09	1.0		–	–	–	◪	430	0.12	1.0	■	40	0.07	0.8		–	–	–
ECGT 060204E-SF2:T6310	●	0.4	◪	160	0.10	1.0	■	115	0.09	1.0		–	–	–	◪	480	0.12	1.0	■	45	0.07	0.8		–	–	–
ECGT 080302E-SF2:H07	●	0.2		–	–	–	◪	105	0.05	1.0		–	–	–	◪	525	0.06	1.0	■	50	0.04	0.8		–	–	–
ECGT 080302E-SF2:T6310	●	0.2	◪	185	0.05	1.0	■	130	0.05	1.0		–	–	–	◪	555	0.06	1.0	■	55	0.04	0.8		–	–	–
ECGT 080304E-SF2:H07	●	0.4		–	–	–	◪	85	0.09	1.0		–	–	–	◪	430	0.12	1.0	■	40	0.07	0.8		–	–	–
ECGT 080304E-SF2:T6310	●	0.4	◪	160	0.10	1.0	■	115	0.09	1.0		–	–	–	◪	480	0.12	1.0	■	45	0.07	0.8		–	–	–
																				
SF2 型断屑槽锋利，专为不锈钢和超级合金的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于钢和有色金属合金。																				
VCGT 130301E-SF2:H07	●	0.1		–	–	–	◪	80	0.05	1.0		–	–	–	◪	405	0.06	1.0	■	40	0.04	0.8		–	–	–
VCGT 130301E-SF2:T6310	●	0.1	◪	140	0.05	1.0	■	100	0.05	1.0		–	–	–	◪	420	0.06	1.0	■	40	0.04	0.8		–	–	–
VCGT 130302E-SF2:H07	●	0.2		–	–	–	◪	80	0.05	1.0		–	–	–	◪	405	0.06	1.0	■	40	0.04	0.8		–	–	–
VCGT 130302E-SF2:HF7	●	0.2		–	–	–	◪	90	0.05	1.0		–	–	–	◪	450	0.06	1.0		–	–	–		–	–	–
VCGT 130302E-SF2:T6310	●	0.2	◪	140	0.05	1.0	■	100	0.05	1.0		–	–	–	◪	420	0.06	1.0	■	40	0.04	0.8		–	–	–
VCGT 130304E-SF2:H07	●	0.4		–	–	–	◪	65	0.09	1.0		–	–	–	◪	335	0.12	1.0	■	30	0.07	0.8		–	–	–
VCGT 130304E-SF2:HF7	●	0.4		–	–	–	◪	75	0.09	1.0		–	–	–	◪	375	0.12	1.0		–	–	–		–	–	–
VCGT 130304E-SF2:T6310	●	0.4	◪	125	0.10	1.0	■	90	0.09	1.0		–	–	–	◪	375	0.12	1.0	■	35	0.07	0.8		–	–	–
VCGT 130308E-SF2:HF7	●	0.8		–	–	–	◪	85	0.09	1.0		–	–	–	◪	435	0.12	1.0		–	–	–		–	–	–
VCGT 130308E-SF2:T6310	●	0.8	◪	145	0.10	1.0	■	100	0.09	1.0		–	–	–	◪	435	0.12	1.0	■	40	0.08	0.8		–	–	–

AL

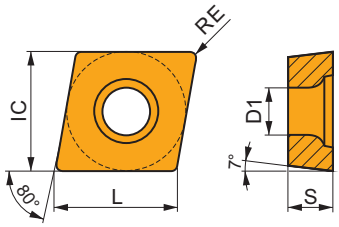


AL 型断屑槽非常锋利，是有色金属合金全方位加工的首选。它具有大正前角，无 T 倒棱。它也有条件地适用于超级合金。

PRAMET

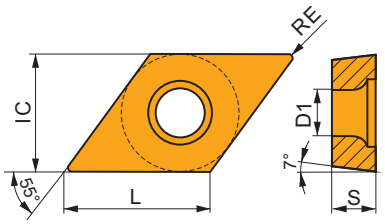
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803-AL	7.940	3.40	8.10	3.43
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



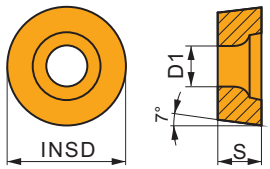
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



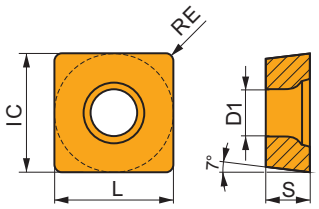
RCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0803	8.000	3.40	3.18	3.97
1003	10.000	4.40	3.18	



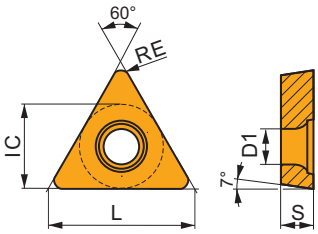
SCGT

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



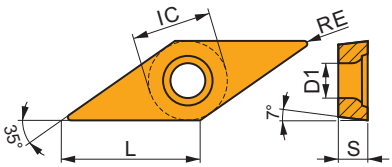
TCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



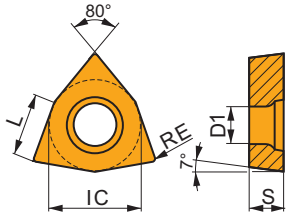
VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	3.970	2.20	6.90	2.38
1103	6.350	2.80	11.10	3.18
1303-AL	7.940	3.40	13.80	3.43
1604	9.525	4.40	16.60	4.76

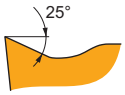


WCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	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/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)
																				
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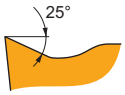
CCGT 060202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	450	0.12	1.0	–	–	–	–	–	–
CCGT 060202F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	645	0.12	1.0	–	–	–	–	–	–
CCGT 060204F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	360	0.24	1.0	–	–	–	–	–	–
CCGT 060204F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	525	0.24	1.0	–	–	–	–	–	–
CCGT 080302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	645	0.12	1.0	–	–	–	–	–	–
CCGT 080304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	360	0.24	1.0	–	–	–	–	–	–
CCGT 080304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	525	0.24	1.0	–	–	–	–	–	–
CCGT 09T302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	450	0.12	1.0	–	–	–	–	–	–
CCGT 09T302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	645	0.12	1.0	–	–	–	–	–	–
CCGT 09T304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	345	0.24	1.5	–	–	–	–	–	–
CCGT 09T304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	495	0.24	1.5	–	–	–	–	–	–
CCGT 09T308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	315	0.48	1.5	–	–	–	–	–	–
CCGT 09T308F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	450	0.48	1.5	–	–	–	–	–	–
CCGT 120404F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	330	0.24	2.4	–	–	–	–	–	–
CCGT 120404F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	480	0.24	2.4	–	–	–	–	–	–
CCGT 120408F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	300	0.48	2.4	–	–	–	–	–	–
CCGT 120408F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	435	0.48	2.4	–	–	–	–	–	–
																				
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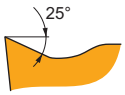
DCGT 070202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	360	0.12	1.0	–	–	–	–	–	–
DCGT 070202F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	510	0.12	1.0	–	–	–	–	–	–
DCGT 070204F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	285	0.24	1.0	–	–	–	–	–	–
DCGT 070204F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	420	0.24	1.0	–	–	–	–	–	–
DCGT 11T302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	345	0.12	1.5	–	–	–	–	–	–
DCGT 11T302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	495	0.12	1.5	–	–	–	–	–	–
DCGT 11T304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	270	0.24	1.5	–	–	–	–	–	–
DCGT 11T304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	390	0.24	1.5	–	–	–	–	–	–
DCGT 11T308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	255	0.48	1.5	–	–	–	–	–	–
DCGT 11T308F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	360	0.48	1.5	–	–	–	–	–	–
																				
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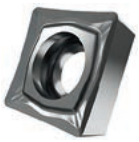
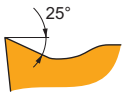
RCGT 0803MOF-AL:HF7	●	–	–	–	–	–	–	–	–	–	–	285	1.20	1.0	–	–	–	–	–	–
RCGT 0803MOF-AL:T0315	●	–	–	–	–	–	–	–	–	–	–	420	1.20	1.0	–	–	–	–	–	–
RCGT 1003MOF-AL:HF7	●	–	–	–	–	–	–	–	–	–	–	255	1.50	1.0	–	–	–	–	–	–
RCGT 1003MOF-AL:T0315	●	–	–	–	–	–	–	–	–	–	–	390	1.50	1.0	–	–	–	–	–	–
																				
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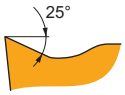
SCGT 120408F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	315	0.48	2.0	–	–	–	–	–	–
SCGT 120408F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	465	0.48	2.0	–	–	–	–	–	–

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。

Product	●	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)
																				
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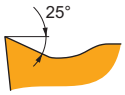
TCGT 090202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	375	0.12	1.0	–	–	–	–	–	–
TCGT 090202F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	555	0.12	1.0	–	–	–	–	–	–
TCGT 090204F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	300	0.24	1.0	–	–	–	–	–	–
TCGT 090204F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	450	0.24	1.0	–	–	–	–	–	–
TCGT 110202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	360	0.12	1.5	–	–	–	–	–	–
TCGT 110202F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	525	0.12	1.5	–	–	–	–	–	–
TCGT 110204F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	285	0.24	1.5	–	–	–	–	–	–
TCGT 110204F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	420	0.24	1.5	–	–	–	–	–	–
TCGT 110208F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	270	0.48	1.5	–	–	–	–	–	–
TCGT 16T304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	285	0.24	2.4	–	–	–	–	–	–
TCGT 16T304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	405	0.24	2.4	–	–	–	–	–	–
TCGT 16T308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	255	0.48	2.4	–	–	–	–	–	–
TCGT 16T308F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	360	0.48	2.4	–	–	–	–	–	–
																				
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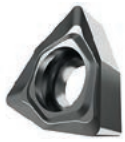
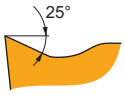
VCGT 070202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	315	0.12	1.0	–	–	–	–	–	–
VCGT 110302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	300	0.12	1.5	–	–	–	–	–	–
VCGT 110302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	465	0.12	0.8	–	–	–	–	–	–
VCGT 110304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	240	0.24	1.5	–	–	–	–	–	–
VCGT 110304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	375	0.24	0.8	–	–	–	–	–	–
VCGT 130302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	285	0.12	1.7	–	–	–	–	–	–
VCGT 130302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	420	0.12	1.7	–	–	–	–	–	–
VCGT 130304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	240	0.24	1.7	–	–	–	–	–	–
VCGT 130304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	345	0.24	1.7	–	–	–	–	–	–
VCGT 130308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	210	0.48	1.7	–	–	–	–	–	–
VCGT 130308F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	315	0.48	1.7	–	–	–	–	–	–
VCGT 160402F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	285	0.12	2.4	–	–	–	–	–	–
VCGT 160402F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	420	0.12	2.4	–	–	–	–	–	–
VCGT 160404F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	225	0.24	2.4	–	–	–	–	–	–
VCGT 160404F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	330	0.24	2.4	–	–	–	–	–	–
VCGT 160408F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	210	0.48	2.4	–	–	–	–	–	–
VCGT 160408F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	300	0.48	2.4	–	–	–	–	–	–
VCGT 160412F-AL:HF7	●	1.2	–	–	–	–	–	–	–	–	–	180	0.72	2.4	–	–	–	–	–	–
VCGT 160412F-AL:T0315	●	1.2	–	–	–	–	–	–	–	–	–	270	0.72	2.4	–	–	–	–	–	–
 																				
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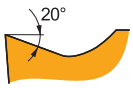
WCGT 06T302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	450	0.12	1.0	–	–	–	–	–	–
WCGT 06T304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	360	0.24	1.0	–	–	–	–	–	–
WCGT 06T304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	525	0.24	1.0	–	–	–	–	–	–
WCGT 06T308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	315	0.48	1.5	–	–	–	–	–	–
WCGT 080412F-AL:HF7	●	1.2	–	–	–	–	–	–	–	–	–	255	0.72	2.4	–	–	–	–	–	–

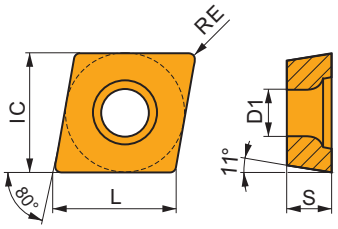
JQ JR JZ



JQ, JR, JZ 型断屑槽非常锋利，专为钢材的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。

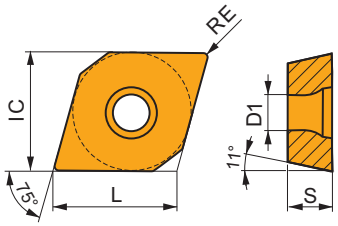
CPGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97



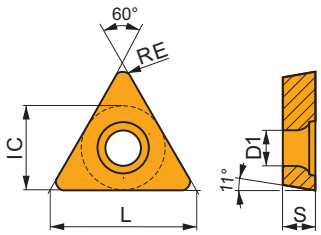
EPGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.560	2.50	5.70	2.38



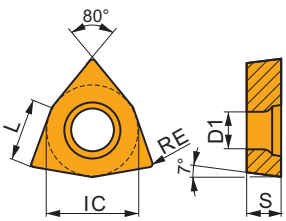
TPGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97

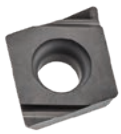
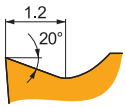
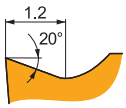
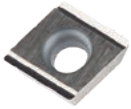
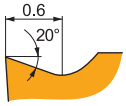
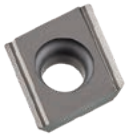
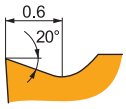
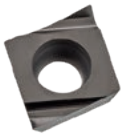
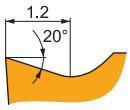
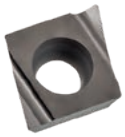
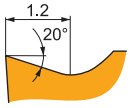
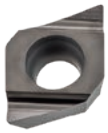
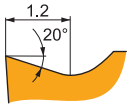
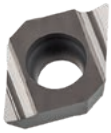
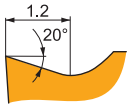
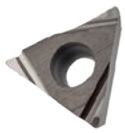
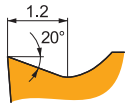


WCGX

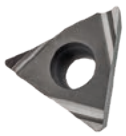
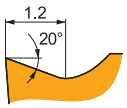
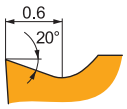
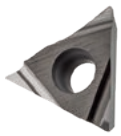
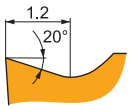
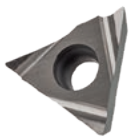
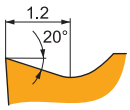
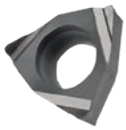
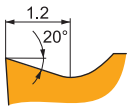
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0201	3.970	2.20	2.70	1.59



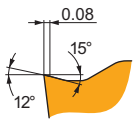
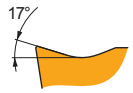
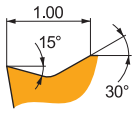
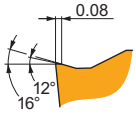
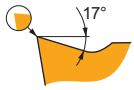
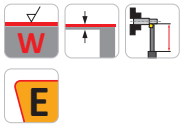
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)	
																					JQ 型断屑槽非常锋利，专为钢材的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。
CPGX 080304FR-JQ:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
																					JQ 型断屑槽非常锋利，专为钢材的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。
CPGX 080304FL-JQ:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
CPGX 09T304FL-JQ:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
																					JR 型断屑槽非常锋利，专为钢材的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。
CPGX 060204FR-JR:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
CPGX 080304FR-JR:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
																					JR 型断屑槽非常锋利，专为钢材的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。
CPGX 060204FL-JR:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
CPGX 080304FL-JR:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
																					JZ 型断屑槽非常锋利，专为钢材的精加工而设计。它的特点是具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。
CPGX 060202FR-JZ:TT010	●	0.2	330	0.06	0.5	195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
																					JZ 型断屑槽非常锋利，专为钢材的精加工而设计。它的特点是具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。
CPGX 060202FL-JZ:TT010	●	0.2	330	0.06	0.5	195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
																					JZ 型断屑槽非常锋利，专为钢材的精加工而设计。它的特点是具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。
EPGX 050202FR-JZ:TT010	●	0.2	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
																					JZ 型断屑槽非常锋利，专为钢材的精加工而设计。它的特点是具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。
EPGX 050202FL-JZ:TT010	●	0.2	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	
																					JQ 型断屑槽非常锋利，专为钢材的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。
TPGX 110204FR-JQ:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	

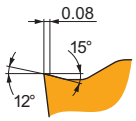
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
																				
JQ 型断屑槽非常锋利，专为钢材的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。																				
TPGX 090204FL-JQ:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
TPGX 110204FL-JQ:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JR 型断屑槽非常锋利，专为钢材的精加工而设计。它具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。																				
TPGX 16T304FL-JR:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ 型断屑槽非常锋利，专为钢材的精加工而设计。它的特点是具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。																				
TPGX 090202FR-JZ:TT010	●	0.2	280	0.06	0.5	165	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ 型断屑槽非常锋利，专为钢材的精加工而设计。它的特点是具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。																				
TPGX 090202FL-JZ:TT010	●	0.2	280	0.06	0.5	165	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ 型断屑槽非常锋利，专为钢材的精加工而设计。它的特点是具有大正前角，无 T 倒棱。它也有条件地适用于不锈钢。																				
WCGX 020102FL-JZ:TT010	●	0.2	330	0.06	0.5	195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

精加工 – 导航工具

FM			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。
NF2			NF2 断屑槽非常锋利，是不锈钢精加工的首选。具有正前角，无T-型倒棱。还适用于耐热合金，有条件地适用于钢、铸铁和有色合金。
UR			UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。
W -FM			W-FM 型断屑槽具有修光刃，专为钢材、不锈钢和铸铁的精加工而设计。它具有正前角和正窄 T 倒棱。
W -UR			W-UR 型断屑槽具有修光刃，专为钢和铸铁的精加工而设计。它具有正前角，无 T 倒棱。它也有条件地适用于不锈钢。

FM

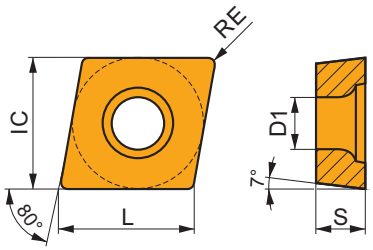


FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。

PRAMET

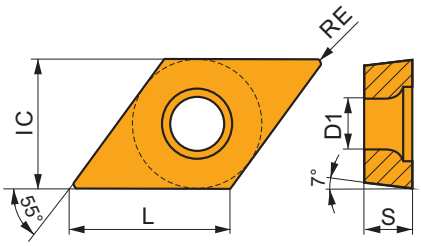
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



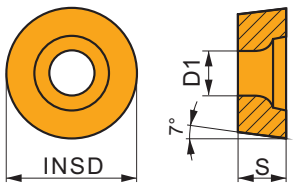
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



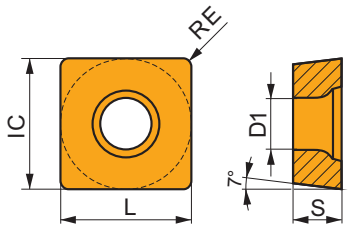
RCMT

	IC (mm)	D1 (mm)	S (mm)
0602	6.000	2.80	2.38
0803	8.000	3.40	3.18
10T3	10.000	4.40	3.97
1204	12.000	4.40	4.76



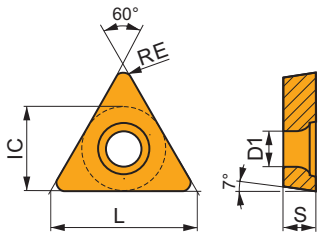
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



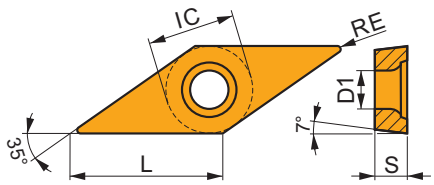
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



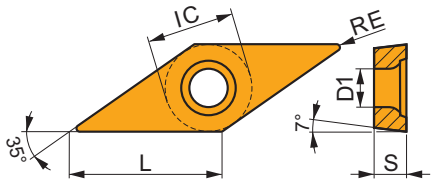
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



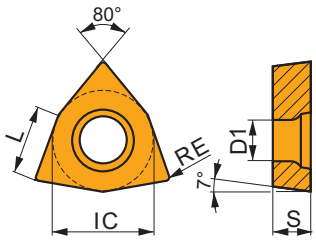
VCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76

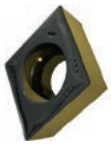


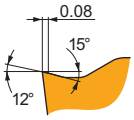
WCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	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。

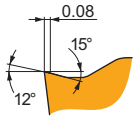




FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。

Product		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)
CCMT 060202E-FM:T7325	●	0.2	210	0.10	1.0	160	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060202E-FM:T7335	●	0.2	210	0.10	1.0	160	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060202E-FM:T8315	●	0.2	195	0.10	1.0	115	0.09	1.0	185	0.10	1.0	585	0.12	1.0	–	–	–	–	–	–
CCMT 060202E-FM:T8415	●	0.2	240	0.10	1.0	125	0.09	1.0	215	0.10	1.0	600	0.12	1.0	–	–	–	–	–	–
CCMT 060202E-FM:T8430	●	0.2	230	0.10	1.0	125	0.09	1.0	185	0.10	1.0	630	0.12	1.0	–	–	–	–	–	–
CCMT 060202E-FM:T9325	●	0.2	285	0.10	1.0	170	0.09	1.0	270	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 060202E-FM:T9415	●	0.2	335	0.10	1.0	–	–	–	315	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T7325	●	0.4	200	0.15	1.0	155	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T7335	●	0.4	195	0.15	1.0	150	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T8315	●	0.4	185	0.15	1.0	110	0.14	1.0	175	0.15	1.0	555	0.18	1.0	–	–	–	–	–	–
CCMT 060204E-FM:T8415	●	0.4	225	0.15	1.0	115	0.14	1.0	205	0.15	1.0	570	0.18	1.0	–	–	–	–	–	–
CCMT 060204E-FM:T8430	●	0.4	205	0.15	1.0	110	0.14	1.0	170	0.15	1.0	570	0.18	1.0	–	–	–	–	–	–
CCMT 060204E-FM:T9315	●	0.4	285	0.15	1.0	–	–	–	270	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T9325	●	0.4	250	0.15	1.0	150	0.15	1.0	235	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T9415	●	0.4	310	0.15	1.0	–	–	–	290	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-FM:T7325	●	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060208E-FM:T8430	⬌	0.8	220	0.20	1.0	120	0.18	1.0	180	0.20	1.0	600	0.24	1.0	–	–	–	–	–	–
CCMT 060208E-FM:T9325	●	0.8	265	0.20	1.0	155	0.18	1.0	250	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-FM:T9415	●	0.8	335	0.20	1.0	–	–	–	315	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-FM:T7325	●	0.2	205	0.10	1.2	155	0.09	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T302E-FM:T7335	●	0.2	205	0.10	1.2	155	0.09	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T302E-FM:T8315	●	0.2	190	0.10	1.2	110	0.09	1.2	180	0.10	1.2	570	0.12	1.2	–	–	–	–	–	–
CCMT 09T302E-FM:T8415	●	0.2	230	0.10	1.2	120	0.09	1.2	210	0.10	1.2	585	0.12	1.2	–	–	–	–	–	–
CCMT 09T302E-FM:T8430	●	0.2	225	0.10	1.2	120	0.09	1.2	185	0.10	1.2	615	0.12	1.2	–	–	–	–	–	–
CCMT 09T302E-FM:T9325	●	0.2	275	0.10	1.2	165	0.09	1.2	260	0.10	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T302E-FM:T9415	●	0.2	330	0.10	1.2	–	–	–	310	0.10	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T7325	●	0.4	195	0.15	1.2	150	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T7335	●	0.4	190	0.15	1.2	145	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T8315	●	0.4	180	0.15	1.2	105	0.14	1.2	170	0.15	1.2	540	0.18	1.2	–	–	–	–	–	–
CCMT 09T304E-FM:T8415	●	0.4	220	0.15	1.2	115	0.14	1.2	200	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–
CCMT 09T304E-FM:T8430	●	0.4	200	0.15	1.2	110	0.14	1.2	165	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–
CCMT 09T304E-FM:T9315	●	0.4	275	0.15	1.2	–	–	–	260	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T9325	●	0.4	245	0.15	1.2	145	0.15	1.2	230	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T9415	●	0.4	305	0.15	1.2	–	–	–	285	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM:T7325	●	0.8	215	0.20	1.2	165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM:T7335	●	0.8	205	0.20	1.2	155	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM:T8315	●	0.8	195	0.20	1.2	115	0.18	1.2	185	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–
CCMT 09T308E-FM:T8415	●	0.8	240	0.20	1.2	125	0.18	1.2	215	0.20	1.2	600	0.24	1.2	–	–	–	–	–	–
CCMT 09T308E-FM:T8430	⬌	0.8	210	0.20	1.2	115	0.18	1.2	175	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–
CCMT 09T308E-FM:T9325	●	0.8	260	0.20	1.2	155	0.18	1.2	245	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM:T9415	●	0.8	330	0.20	1.2	–	–	–	310	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 120404E-FM:T7325	●	0.4	190	0.15	1.7	145	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120404E-FM:T7335	●	0.4	185	0.15	1.7	140	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120404E-FM:T8315	●	0.4	170	0.15	1.7	100	0.14	1.7	160	0.15	1.7	510	0.18	1.7	–	–	–	–	–	–
CCMT 120404E-FM:T8415	●	0.4	210	0.15	1.7	110	0.14	1.7	190	0.15	1.7	525	0.18	1.7	–	–	–	–	–	–
CCMT 120404E-FM:T8430	●	0.4	195	0.15	1.7	105	0.14	1.7	160	0.15	1.7	540	0.18	1.7	–	–	–	–	–	–
CCMT 120404E-FM:T9325	●	0.4	240	0.15	1.7	140	0.15	1.7	225	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-FM:T9415	●	0.4	295	0.15	1.7	–	–	–	280	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM:T7325	●	0.8	205	0.20	1.7	155	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM:T7335	●	0.8	200	0.20	1.7	155	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM:T8315	●	0.8	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–
CCMT 120408E-FM:T8415	●	0.8	230	0.20	1.7	120	0.18	1.7	210	0.20	1.7	585	0.24	1.7	–	–	–	–	–	–
CCMT 120408E-FM:T8430	⬌	0.8	205	0.20	1.7	110	0.18	1.7	170	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–
CCMT 120408E-FM:T9325	●	0.8	250	0.20	1.7	150	0.18	1.7	235	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM:T9415	●	0.8	315	0.20	1.7	–	–	–	295	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-FM:T8430	⬌	1.2	190	0.27	1.7	105	0.24	1.7	155	0.27	1.7	525	0.32	1.7	–	–	–	–	–	–
CCMT 120412E-FM:T9325	⬌	1.2	235	0.27	1.7	140	0.24	1.7	220	0.27	1.7	–	–	–	–	–	–	–	–	–

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。



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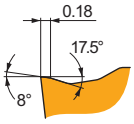
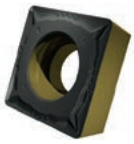
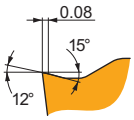
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
DCMT 070202E-FM:T7325	●	0.2	175	0.10	0.8	135	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070202E-FM:T8315	●	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	480	0.12	0.8	–	–	–	–	–	–
DCMT 070202E-FM:T8415	●	0.2	190	0.10	0.8	100	0.09	0.8	170	0.10	0.8	480	0.12	0.8	–	–	–	–	–	–
DCMT 070202E-FM:T8430	●	0.2	185	0.10	0.8	100	0.09	0.8	150	0.10	0.8	510	0.12	0.8	–	–	–	–	–	–
DCMT 070202E-FM:T9325	●	0.2	230	0.10	0.8	135	0.09	0.8	215	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-FM:T9415	●	0.2	275	0.10	0.8	–	–	–	260	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T7325	●	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T7335	●	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T8315	●	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
DCMT 070204E-FM:T8415	●	0.4	190	0.12	0.8	100	0.11	0.8	170	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
DCMT 070204E-FM:T8430	●	0.4	185	0.12	0.8	100	0.11	0.8	150	0.12	0.8	510	0.14	0.8	–	–	–	–	–	–
DCMT 070204E-FM:T9325	●	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T9415	●	0.4	275	0.12	0.8	–	–	–	260	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM:T7325	●	0.2	175	0.10	0.8	135	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM:T8315	●	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	480	0.12	0.8	–	–	–	–	–	–
DCMT 11T302E-FM:T8415	●	0.2	190	0.10	0.8	100	0.09	0.8	170	0.10	0.8	480	0.12	0.8	–	–	–	–	–	–
DCMT 11T302E-FM:T8430	●	0.2	185	0.10	0.8	100	0.09	0.8	150	0.10	0.8	510	0.12	0.8	–	–	–	–	–	–
DCMT 11T302E-FM:T9325	●	0.2	230	0.10	0.8	135	0.09	0.8	215	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM:T9415	●	0.2	275	0.10	0.8	–	–	–	260	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T7325	●	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T7335	●	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T8315	●	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
DCMT 11T304E-FM:T8415	●	0.4	190	0.12	0.8	100	0.11	0.8	170	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
DCMT 11T304E-FM:T8430	●	0.4	155	0.17	0.8	85	0.15	0.8	130	0.17	0.8	435	0.20	0.8	–	–	–	–	–	–
DCMT 11T304E-FM:T9310	●	0.4	285	0.12	0.8	–	–	–	270	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T9315	●	0.4	255	0.12	0.8	–	–	–	240	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T9325	●	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T9415	●	0.4	275	0.12	0.8	–	–	–	260	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T7325	●	0.8	185	0.17	0.8	140	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T7335	●	0.8	180	0.17	0.8	140	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T8315	●	0.8	170	0.17	0.8	100	0.15	0.8	160	0.17	0.8	510	0.20	0.8	–	–	–	–	–	–
DCMT 11T308E-FM:T8415	●	0.8	210	0.17	0.8	110	0.15	0.8	190	0.17	0.8	525	0.20	0.8	–	–	–	–	–	–
DCMT 11T308E-FM:T8430	●	0.8	190	0.17	0.8	105	0.15	0.8	155	0.17	0.8	525	0.20	0.8	–	–	–	–	–	–
DCMT 11T308E-FM:T9310	●	0.8	285	0.17	0.8	–	–	–	270	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T9315	●	0.8	260	0.17	0.8	–	–	–	245	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T9325	●	0.8	235	0.17	0.8	140	0.15	0.8	220	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T9415	●	0.8	290	0.17	0.8	–	–	–	275	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM:T8430	●	1.2	175	0.22	1.2	95	0.22	1.2	140	0.22	1.2	480	0.26	1.2	–	–	–	–	–	–
DCMT 11T312E-FM:T9325	●	1.2	210	0.22	1.2	125	0.22	1.2	195	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM:T9415	●	1.2	265	0.22	1.2	–	–	–	250	0.22	1.2	–	–	–	–	–	–	–	–	–

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。

Product		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)
																				
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。																				
RCMT 0602M0E-FM:T7325		–	215	0.45	1.2	165	0.41	1.2	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 0602M0E-FM:T8430		–	200	0.45	1.2	110	0.41	1.2	165	0.45	1.2	555	0.54	1.2	–	–	–	–	–	–
RCMT 0602M0E-FM:T9325		–	235	0.45	1.2	140	0.41	1.2	220	0.45	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602M0E-FM:T9415		–	320	0.45	1.2	–	–	–	300	0.45	1.2	–	–	–	–	–	–	–	–	–
RCMT 0803M0E-FM:T7325		–	190	0.60	1.6	145	0.54	1.6	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 0803M0E-FM:T8430		–	175	0.60	1.6	95	0.54	1.6	140	0.60	1.6	480	0.72	1.6	–	–	–	–	–	–
RCMT 0803M0E-FM:T9325		–	200	0.60	1.6	120	0.54	1.6	190	0.60	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803M0E-FM:T9415		–	280	0.60	1.6	–	–	–	265	0.60	1.6	–	–	–	–	–	–	–	–	–
RCMT 10T3M0E-FM:T7325		–	185	0.65	1.7	140	0.59	1.7	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 10T3M0E-FM:T8430		–	170	0.65	1.7	90	0.59	1.7	135	0.65	1.7	465	0.78	1.7	–	–	–	–	–	–
RCMT 10T3M0E-FM:T9325		–	195	0.65	1.7	115	0.59	1.7	185	0.65	1.7	–	–	–	–	–	–	–	–	–
RCMT 10T3M0E-FM:T9415		–	275	0.65	1.7	–	–	–	260	0.65	1.7	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-FM:T7325		–	175	0.70	1.8	135	0.63	1.8	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-FM:T8430		–	155	0.70	1.8	85	0.63	1.8	130	0.70	1.8	435	0.84	1.8	–	–	–	–	–	–
RCMT 1204M0E-FM:T9325		–	190	0.70	1.8	110	0.63	1.8	180	0.70	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-FM:T9415		–	260	0.70	1.8	–	–	–	245	0.70	1.8	–	–	–	–	–	–	–	–	–
 																				
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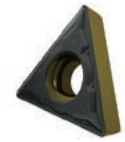
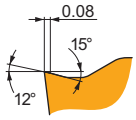
SCMT 09T304E-FM:T7325	●	0.4	205	0.15	1.2	155	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM:T7335	●	0.4	200	0.15	1.2	155	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM:T8315	●	0.4	190	0.15	1.2	110	0.14	1.2	180	0.15	1.2	570	0.18	1.2	–	–	–	–	–	–
SCMT 09T304E-FM:T8415	●	0.4	230	0.15	1.2	120	0.14	1.2	210	0.15	1.2	585	0.18	1.2	–	–	–	–	–	–
SCMT 09T304E-FM:T8430	●	0.4	210	0.15	1.2	115	0.14	1.2	175	0.15	1.2	585	0.18	1.2	–	–	–	–	–	–
SCMT 09T304E-FM:T9325	●	0.4	260	0.15	1.2	155	0.15	1.2	245	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM:T9415	●	0.4	320	0.15	1.2	–	–	–	300	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T7325	●	0.8	225	0.20	1.2	175	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T7335	●	0.8	215	0.20	1.2	165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T8315	●	0.8	205	0.20	1.2	120	0.18	1.2	190	0.20	1.2	615	0.24	1.2	–	–	–	–	–	–
SCMT 09T308E-FM:T8415	●	0.8	250	0.20	1.2	130	0.18	1.2	225	0.20	1.2	630	0.24	1.2	–	–	–	–	–	–
SCMT 09T308E-FM:T8430	●	0.8	225	0.20	1.2	120	0.18	1.2	185	0.20	1.2	615	0.24	1.2	–	–	–	–	–	–
SCMT 09T308E-FM:T9325	●	0.8	275	0.20	1.2	165	0.18	1.2	260	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T9415	●	0.8	350	0.20	1.2	–	–	–	330	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM:T7325	●	0.4	195	0.15	1.6	150	0.15	1.6	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM:T8315	●	0.4	185	0.15	1.6	110	0.14	1.6	175	0.15	1.6	555	0.18	1.6	–	–	–	–	–	–
SCMT 120404E-FM:T8415	●	0.4	225	0.15	1.6	115	0.14	1.6	205	0.15	1.6	570	0.18	1.6	–	–	–	–	–	–
SCMT 120404E-FM:T8430	●	0.4	205	0.15	1.6	110	0.14	1.6	170	0.15	1.6	570	0.18	1.6	–	–	–	–	–	–
SCMT 120404E-FM:T9325	●	0.4	250	0.15	1.6	150	0.15	1.6	235	0.15	1.6	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM:T9415	●	0.4	315	0.15	1.6	–	–	–	295	0.15	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T7325	●	0.8	215	0.20	1.6	165	0.18	1.6	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T7335	●	0.8	210	0.20	1.6	160	0.18	1.6	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T8315		0.8	200	0.20	1.6	120	0.18	1.6	190	0.20	1.6	600	0.24	1.6	–	–	–	–	–	–
SCMT 120408E-FM:T8415		0.8	245	0.20	1.6	125	0.18	1.6	220	0.20	1.6	615	0.24	1.6	–	–	–	–	–	–
SCMT 120408E-FM:T8430		0.8	220	0.20	1.6	120	0.18	1.6	180	0.20	1.6	600	0.24	1.6	–	–	–	–	–	–
SCMT 120408E-FM:T9325	●	0.8	265	0.20	1.6	155	0.18	1.6	250	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T9415	●	0.8	340	0.20	1.6	–	–	–	320	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-FM:T8430		1.2	200	0.27	1.6	110	0.24	1.6	165	0.27	1.6	555	0.32	1.6	–	–	–	–	–	–
SCMT 120412E-FM:T9325		1.2	245	0.27	1.6	145	0.24	1.6	230	0.27	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-FM:T9415		1.2	320	0.27	1.6	–	–	–	300	0.27	1.6	–	–	–	–	–	–	–	–	–

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。





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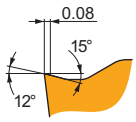
Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
TCMT 110202E-FM:T7325	●	0.2	185	0.10	0.8	140	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110202E-FM:T7335	●	0.2	185	0.10	0.8	140	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110202E-FM:T8315	●	0.2	170	0.10	0.8	100	0.09	0.8	160	0.10	0.8	510	0.12	0.8	–	–	–	–	–	–
TCMT 110202E-FM:T8415	●	0.2	200	0.10	0.8	105	0.09	0.8	185	0.10	0.8	510	0.12	0.8	–	–	–	–	–	–
TCMT 110202E-FM:T8430	●	0.2	195	0.10	0.8	105	0.09	0.8	160	0.10	0.8	540	0.12	0.8	–	–	–	–	–	–
TCMT 110202E-FM:T9325	●	0.2	245	0.10	0.8	145	0.09	0.8	230	0.10	0.8	–	–	–	–	–	–	–	–	–
TCMT 110202E-FM:T9415	●	0.2	290	0.10	0.8	–	–	–	275	0.10	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T7325	●	0.4	160	0.19	0.8	120	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T7335	●	0.4	155	0.19	0.8	120	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T8315	●	0.4	170	0.12	0.8	100	0.11	0.8	160	0.12	0.8	510	0.14	0.8	–	–	–	–	–	–
TCMT 110204E-FM:T8415	●	0.4	210	0.12	0.8	110	0.11	0.8	190	0.12	0.8	525	0.14	0.8	–	–	–	–	–	–
TCMT 110204E-FM:T8430	●	0.4	195	0.12	0.8	105	0.11	0.8	160	0.12	0.8	540	0.14	0.8	–	–	–	–	–	–
TCMT 110204E-FM:T9315	●	0.4	270	0.12	0.8	–	–	–	255	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T9325	●	0.4	205	0.18	0.8	120	0.16	0.8	190	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T9415	●	0.4	295	0.12	0.8	–	–	–	280	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM:T7325	●	0.8	195	0.17	0.8	150	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM:T8430	●	0.8	200	0.17	0.8	110	0.15	0.8	165	0.17	0.8	555	0.20	0.8	–	–	–	–	–	–
TCMT 110208E-FM:T9325	●	0.8	250	0.17	0.8	150	0.15	0.8	235	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM:T9415	●	0.8	310	0.17	0.8	–	–	–	290	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T7325	●	0.4	150	0.19	1.7	115	0.17	1.7	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T7335	●	0.4	145	0.19	1.7	110	0.17	1.7	–	–	–	–	–	–	–	–	–	–	–	–
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 16T304E-FM:T9325	●	0.4	190	0.18	1.7	110	0.16	1.7	180	0.18	1.7	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T9415	●	0.4	270	0.12	1.7	–	–	–	255	0.12	1.7	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T7325	●	0.8	180	0.17	1.7	140	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T7335	●	0.8	175	0.17	1.7	135	0.15	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	–	–	–	–	–	–
TCMT 16T308E-FM:T9325	●	0.8	230	0.17	1.7	135	0.15	1.7	215	0.17	1.7	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T9415	●	0.8	285	0.17	1.7	–	–	–	270	0.17	1.7	–	–	–	–	–	–	–	–	–



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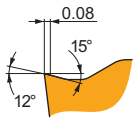
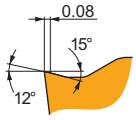
VBMT 110302E-FM:T7325	●	0.2	160	0.10	0.8	120	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 110302E-FM:T8315	●	0.2	145	0.10	0.8	85	0.09	0.8	135	0.10	0.8	435	0.12	0.8	–	–	–	–	–	–
VBMT 110302E-FM:T8415	●	0.2	180	0.10	0.8	90	0.09	0.8	160	0.10	0.8	450	0.12	0.8	–	–	–	–	–	–
VBMT 110302E-FM:T8430	●	0.2	170	0.10	0.8	90	0.09	0.8	135	0.10	0.8	465	0.12	0.8	–	–	–	–	–	–
VBMT 110302E-FM:T9325	●	0.2	210	0.10	0.8	125	0.09	0.8	195	0.10	0.8	–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T7325	●	0.4	140	0.19	0.8	105	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T7335	●	0.4	135	0.19	0.8	105	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T8315	●	0.4	145	0.12	0.8	85	0.11	0.8	135	0.12	0.8	435	0.14	0.8	–	–	–	–	–	–
VBMT 110304E-FM:T8415	●	0.4	180	0.12	0.8	90	0.11	0.8	160	0.12	0.8	450	0.14	0.8	–	–	–	–	–	–
VBMT 110304E-FM:T8430	●	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	465	0.14	0.8	–	–	–	–	–	–
VBMT 110304E-FM:T9325	●	0.4	175	0.19	0.8	105	0.17	0.8	165	0.19	0.8	–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T9415	●	0.4	255	0.12	0.8	–	–	–	240	0.12	0.8	–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T7325	●	0.8	170	0.17	0.8	130	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T8430	●	0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	480	0.20	0.8	–	–	–	–	–	–
VBMT 110308E-FM:T9315	●	0.8	240	0.17	0.8	–	–	–	225	0.17	0.8	–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T9325	●	0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T9415	●	0.8	270	0.17	0.8	–	–	–	255	0.17	0.8	–	–	–	–	–	–	–	–	–
VBMT 160402E-FM:T7325	●	0.2	150	0.10	1.2	115	0.09	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160402E-FM:T8430	●	0.2	165	0.10	1.2	90	0.09	1.2	135	0.10	1.2	450	0.12	1.2	–	–	–	–	–	–
VBMT 160402E-FM:T9325	●	0.2	205	0.10	1.2	120	0.09	1.2	190	0.10	1.2	–	–	–	–	–	–	–	–	–
VBMT 160402E-FM:T9415	●	0.2	245	0.10	1.2	–	–	–	230	0.10	1.2	–	–	–	–	–	–	–	–	–

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。

Product		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)
																				
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。																				
VBMT 160404E-FM:T5315	●	0.4	225	0.12	1.2	–	–	–	210	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T7325	●	0.4	130	0.19	1.2	100	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T7335	●	0.4	130	0.19	1.2	100	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T8315	●	0.4	140	0.12	1.2	80	0.11	1.2	130	0.12	1.2	420	0.14	1.2	–	–	–	–	–	–
VBMT 160404E-FM:T8415	●	0.4	170	0.12	1.2	90	0.11	1.2	155	0.12	1.2	435	0.14	1.2	–	–	–	–	–	–
VBMT 160404E-FM:T8430	●	0.4	165	0.12	1.2	90	0.11	1.2	135	0.12	1.2	450	0.14	1.2	–	–	–	–	–	–
VBMT 160404E-FM:T9315	●	0.4	225	0.12	1.2	–	–	–	210	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T9325	●	0.4	165	0.19	1.2	95	0.17	1.2	155	0.19	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T9415	●	0.4	245	0.12	1.2	–	–	–	230	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T5315	●	0.8	235	0.17	1.2	–	–	–	220	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T7325	●	0.8	165	0.17	1.2	125	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T7335	●	0.8	160	0.17	1.2	120	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T8315	●	0.8	150	0.17	1.2	90	0.15	1.2	140	0.17	1.2	450	0.20	1.2	–	–	–	–	–	–
VBMT 160408E-FM:T8415	●	0.8	185	0.17	1.2	95	0.15	1.2	165	0.17	1.2	465	0.20	1.2	–	–	–	–	–	–
VBMT 160408E-FM:T8430	●	0.8	170	0.17	1.2	90	0.15	1.2	135	0.17	1.2	465	0.20	1.2	–	–	–	–	–	–
VBMT 160408E-FM:T9315	●	0.8	230	0.17	1.2	–	–	–	215	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T9325	●	0.8	205	0.17	1.2	120	0.15	1.2	190	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T9415	●	0.8	260	0.17	1.2	–	–	–	245	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T7325	●	1.2	160	0.22	1.2	120	0.22	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T8430	●	1.2	155	0.22	1.2	85	0.22	1.2	130	0.22	1.2	435	0.26	1.2	–	–	–	–	–	–
VBMT 160412E-FM:T9315	●	1.2	215	0.22	1.2	–	–	–	200	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T9325	●	1.2	195	0.22	1.2	115	0.22	1.2	185	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T9415	●	1.2	245	0.22	1.2	–	–	–	230	0.22	1.2	–	–	–	–	–	–	–	–	–
																				
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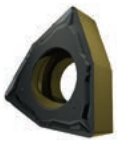
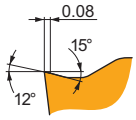
VCMT 160404E-FM:T7325	●	0.4	125	0.19	1.2	95	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 160404E-FM:T8430	●	0.4	150	0.12	1.2	80	0.11	1.2	125	0.12	1.2	420	0.14	1.2	–	–	–	–	–	–
VCMT 160404E-FM:T9325	●	0.4	155	0.19	1.2	90	0.17	1.2	145	0.19	1.2	–	–	–	–	–	–	–	–	–
VCMT 160404E-FM:T9415	●	0.4	230	0.12	1.2	–	–	–	215	0.12	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM:T7325	●	0.8	155	0.17	1.2	120	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM:T8430	●	0.8	155	0.17	1.2	85	0.15	1.2	130	0.17	1.2	435	0.20	1.2	–	–	–	–	–	–
VCMT 160408E-FM:T9325	●	0.8	195	0.17	1.2	115	0.15	1.2	185	0.17	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM:T9415	●	0.8	245	0.17	1.2	–	–	–	230	0.17	1.2	–	–	–	–	–	–	–	–	–
 																				
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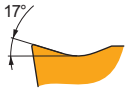
WCMT 06T304E-FM:T8315	●	0.4	180	0.15	1.2	105	0.14	1.2	170	0.15	1.2	540	0.18	1.2	–	–	–	–	–	–
WCMT 06T304E-FM:T8415	●	0.4	220	0.15	1.2	115	0.14	1.2	200	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–
WCMT 06T304E-FM:T8430	●	0.4	200	0.15	1.2	110	0.14	1.2	165	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–
WCMT 06T304E-FM:T9325	●	0.4	245	0.15	1.2	145	0.15	1.2	230	0.15	1.2	–	–	–	–	–	–	–	–	–
WCMT 06T304E-FM:T9415	●	0.4	305	0.15	1.2	–	–	–	285	0.15	1.2	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T7325	●	0.8	215	0.20	1.2	165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T7335	●	0.8	205	0.20	1.2	155	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T8315	●	0.8	195	0.20	1.2	115	0.18	1.2	185	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–
WCMT 06T308E-FM:T8415	●	0.8	240	0.20	1.2	125	0.18	1.2	215	0.20	1.2	600	0.24	1.2	–	–	–	–	–	–
WCMT 06T308E-FM:T8430	⬌	0.8	210	0.20	1.2	115	0.18	1.2	175	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–
WCMT 06T308E-FM:T9325	●	0.8	260	0.20	1.2	155	0.18	1.2	245	0.20	1.2	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T9415	●	0.8	330	0.20	1.2	–	–	–	310	0.20	1.2	–	–	–	–	–	–	–	–	–
WCMT 080404E-FM:T8430	●	0.4	195	0.15	1.7	105	0.14	1.7	160	0.15	1.7	540	0.18	1.7	–	–	–	–	–	–
WCMT 080404E-FM:T9325	●	0.4	240	0.15	1.7	140	0.15	1.7	225	0.15	1.7	–	–	–	–	–	–	–	–	–
WCMT 080408E-FM:T8430	⬌	0.8	205	0.20	1.7	110	0.18	1.7	170	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–
WCMT 080408E-FM:T9325	●	0.8	250	0.20	1.7	150	0.18	1.7	235	0.20	1.7	–	–	–	–	–	–	–	–	–
WCMT 080408E-FM:T9415	●	0.8	315	0.20	1.7	–	–	–	295	0.20	1.7	–	–	–	–	–	–	–	–	–
WCMT 080412E-FM:T8430	⬌	1.2	190	0.27	1.7	105	0.24	1.7	155	0.27	1.7	525	0.32	1.7	–	–	–	–	–	–
WCMT 080412E-FM:T9325	⬌	1.2	235	0.27	1.7	140	0.24	1.7	220	0.27	1.7	–	–	–	–	–	–	–	–	–

NF2



NF2 断屑槽非常锋利，是不锈钢精加工的首选。具有正前角，无T-型倒棱。还适用于耐热合金，有条件地适用于钢、铸铁和有色合金。

PRAMET

CCMT

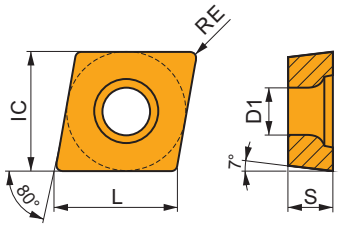
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97

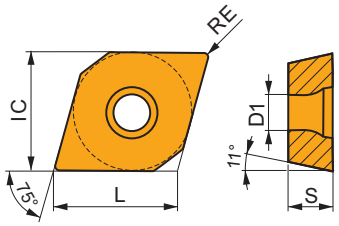
EPMT

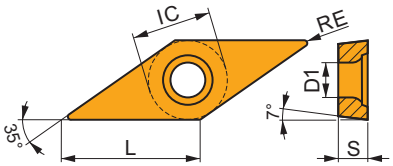
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.560	2.50	5.70	2.38

VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18



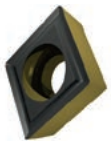
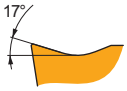




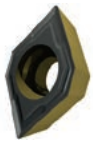
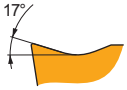
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	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)
CCMT 060202E-NF2:T6310	●	0.2	170	0.10	0.8	120	0.09	0.8	135	0.10	0.8	510	0.12	0.8	50	0.08	0.6	–	–	–
CCMT 060202E-NF2:T7325	●	0.2	195	0.10	0.8	150	0.09	0.8	–	–	–	–	–	–	60	0.08	0.6	–	–	–
CCMT 060202E-NF2:T8415	●	0.2	220	0.10	0.8	115	0.09	0.8	200	0.10	0.8	555	0.12	0.8	50	0.08	0.6	–	–	–
CCMT 060202E-NF2:T8430	●	0.2	210	0.10	0.8	115	0.09	0.8	175	0.10	0.8	585	0.12	0.8	45	0.08	0.6	–	–	–
CCMT 060202E-NF2:T9325	●	0.2	260	0.10	0.8	155	0.09	0.8	245	0.10	0.8	–	–	–	55	0.08	0.6	–	–	–
CCMT 060204E-NF2:T6310	●	0.4	170	0.12	0.8	120	0.11	0.8	135	0.12	0.8	510	0.14	0.8	50	0.11	0.6	–	–	–
CCMT 060204E-NF2:T7325	●	0.4	200	0.12	0.8	155	0.11	0.8	–	–	–	–	–	–	65	0.11	0.6	–	–	–
CCMT 060204E-NF2:T8415	●	0.4	220	0.12	0.8	115	0.11	0.8	200	0.12	0.8	555	0.14	0.8	50	0.11	0.6	–	–	–
CCMT 060204E-NF2:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	570	0.14	0.8	45	0.11	0.6	–	–	–
CCMT 060204E-NF2:T9325	●	0.4	255	0.12	0.8	150	0.11	0.8	240	0.12	0.8	–	–	–	55	0.11	0.6	–	–	–
CCMT 060204E-NF2:T9335	●	0.4	220	0.12	0.8	130	0.11	0.8	–	–	–	–	–	–	45	0.11	0.6	–	–	–
CCMT 060204E-NF2:T9415	●	0.4	315	0.12	0.8	–	–	–	295	0.12	0.8	–	–	–	–	–	–	–	–	–
CCMT 080304E-NF2:T5315	●	0.4	280	0.12	1.0	–	–	–	265	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-NF2:T7325	●	0.4	190	0.12	1.0	145	0.11	1.0	–	–	–	–	–	–	60	0.11	0.8	–	–	–
CCMT 080304E-NF2:T7335	●	0.4	190	0.12	1.0	145	0.11	1.0	–	–	–	–	–	–	60	0.11	0.8	–	–	–
CCMT 080304E-NF2:T9325	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	55	0.11	0.8	–	–	–
CCMT 080304E-NF2:T9335	●	0.4	215	0.12	1.2	125	0.11	1.2	–	–	–	–	–	–	45	0.11	1.0	–	–	–
CCMT 080304E-NF2:T9415	●	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-NF2:H07	●	0.8	–	–	–	95	0.13	1.2	150	0.14	1.2	485	0.17	1.2	45	0.13	1.0	–	–	–
CCMT 080308E-NF2:T5315	●	0.8	295	0.17	1.0	–	–	–	280	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-NF2:T7325	⬢	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.14	0.8	–	–	–
CCMT 080308E-NF2:T7335	⬢	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.14	0.8	–	–	–
CCMT 080308E-NF2:T9325	⬢	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	55	0.14	0.8	–	–	–
CCMT 09T304E-NF2:H07	●	0.4	–	–	–	85	0.11	1.2	135	0.12	1.2	430	0.14	1.2	40	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T6310	●	0.4	165	0.12	1.2	115	0.11	1.2	130	0.12	1.2	495	0.14	1.2	45	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T7325	●	0.4	190	0.12	1.2	145	0.11	1.2	–	–	–	–	–	–	60	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T8415	●	0.4	215	0.12	1.2	110	0.11	1.2	195	0.12	1.2	540	0.14	1.2	45	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T8430	●	0.4	200	0.12	1.2	110	0.11	1.2	165	0.12	1.2	555	0.14	1.2	40	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T9325	●	0.4	250	0.12	1.2	150	0.11	1.2	235	0.12	1.2	–	–	–	55	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T9415	●	0.4	300	0.12	1.2	–	–	–	285	0.12	1.2	–	–	–	–	–	–	–	–	–

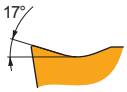
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
 																				
CCMT 09T308E-NF2:H07	⬌	0.8	–	–	–	◪ 95	0.13	1.2	◪ 150	0.14	1.2	◪ 485	0.17	1.2	■ 45	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T6310	⬌	0.8	◪ 190	0.14	1.2	■ 135	0.13	1.2	◪ 150	0.14	1.2	◪ 570	0.17	1.2	■ 55	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T7325	⬌	0.8	◪ 215	0.14	1.2	■ 165	0.13	1.2	–	–	–	–	–	–	■ 65	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T8415	⬌	0.8	◪ 245	0.14	1.2	■ 125	0.13	1.2	◪ 220	0.14	1.2	◪ 615	0.17	1.2	■ 55	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T8430	⬌	0.8	◪ 225	0.14	1.2	■ 120	0.13	1.2	◪ 185	0.14	1.2	◪ 615	0.17	1.2	◪ 45	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T9325	⬌	0.8	◪ 275	0.14	1.2	■ 165	0.13	1.2	◪ 260	0.14	1.2	–	–	–	◪ 60	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T9335	⬌	0.8	◪ 235	0.14	1.2	■ 140	0.13	1.2	–	–	–	–	–	–	◪ 50	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T9415	●	0.8	◪ 340	0.14	1.2	–	–	–	◪ 320	0.14	1.2	–	–	–	–	–	–	–	–	–

NF2 断屑槽非常锋利，是不锈钢精加工的首选。具有正前角，无T-型倒棱。还适用于耐热合金，有条件地适用于钢、铸铁和有色合金。

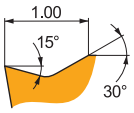
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
EPMT 050202E-NF2:H07	●	0.2	–	–	–	◪ 80	0.09	0.8	◪ 125	0.10	0.8	◪ 405	0.12	0.8	■ 40	0.07	0.6	–	–	–
EPMT 050202E-NF2:T7325	●	0.2	◪ 215	0.07	0.8	■ 165	0.06	0.8	–	–	–	–	–	–	■ 65	0.06	0.6	–	–	–
EPMT 050202E-NF2:T7335	●	0.2	◪ 220	0.07	0.8	■ 170	0.06	0.8	–	–	–	–	–	–	■ 70	0.06	0.6	–	–	–
EPMT 050202E-NF2:T9325	●	0.2	◪ 305	0.07	0.8	■ 180	0.06	0.8	◪ 285	0.07	0.8	–	–	–	◪ 65	0.06	0.6	–	–	–
EPMT 050202E-NF2:T9335	●	0.2	◪ 200	0.10	0.8	■ 120	0.09	0.8	–	–	–	–	–	–	◪ 45	0.07	0.6	–	–	–
EPMT 050202E-NF2:T9415	●	0.2	◪ 355	0.05	0.8	–	–	–	◪ 335	0.05	0.8	–	–	–	–	–	–	–	–	–
EPMT 050202E-NF2:TT010	●	0.2	◪ 345	0.05	0.5	◪ 205	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

NF2 断屑槽非常锋利，是不锈钢精加工的首选。具有正前角，无T-型倒棱。还适用于耐热合金，有条件地适用于钢、铸铁和有色合金。

Product		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)
																				
VCGT 130302E-NF2:H07	●	0.2	–	–	–	◪ 60	0.09	1.0	◪ 95	0.10	1.0	◪ 310	0.12	1.0	■ 30	0.07	0.8	–	–	–
VCGT 130302E-NF2:T6310	●	0.2	◪ 125	0.07	1.0	■ 90	0.06	1.0	◪ 100	0.07	1.0	◪ 375	0.08	1.0	■ 35	0.06	0.8	–	–	–
VCGT 130302E-NF2:T7325	●	0.2	◪ 150	0.07	1.0	■ 115	0.06	1.0	–	–	–	–	–	–	■ 45	0.06	0.8	–	–	–
VCGT 130302E-NF2:T7335	●	0.2	◪ 150	0.07	1.0	■ 115	0.06	1.0	–	–	–	–	–	–	■ 45	0.06	0.8	–	–	–
VCGT 130302E-NF2:T8415	●	0.2	◪ 160	0.07	1.0	■ 85	0.06	1.0	◪ 145	0.07	1.0	◪ 405	0.08	1.0	■ 35	0.06	0.8	–	–	–
VCGT 130302E-NF2:T9325	●	0.2	◪ 210	0.07	1.0	■ 125	0.06	1.0	◪ 195	0.07	1.0	–	–	–	◪ 45	0.06	0.8	–	–	–
VCGT 130302E-NF2:T9335	●	0.2	◪ 155	0.10	1.0	■ 90	0.09	1.0	–	–	–	–	–	–	◪ 30	0.07	0.8	–	–	–
VCGT 130302E-NF2:TT010	●	0.2	◪ 240	0.05	0.5	◪ 140	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130304E-NF2:H07	●	0.4	–	–	–	◪ 60	0.11	1.0	◪ 95	0.12	1.0	◪ 310	0.14	1.0	■ 30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T5315	●	0.4	◪ 195	0.12	1.0	–	–	–	◪ 185	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-NF2:T6310	●	0.4	◪ 115	0.12	1.0	■ 80	0.11	1.0	◪ 90	0.12	1.0	◪ 345	0.14	1.0	■ 30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T7325	●	0.4	◪ 135	0.12	1.0	■ 105	0.11	1.0	–	–	–	–	–	–	■ 40	0.08	0.8	–	–	–
VCGT 130304E-NF2:T7335	●	0.4	◪ 135	0.12	1.0	■ 105	0.11	1.0	–	–	–	–	–	–	■ 40	0.08	0.8	–	–	–
VCGT 130304E-NF2:T8415	●	0.4	◪ 150	0.12	1.0	■ 75	0.11	1.0	◪ 135	0.12	1.0	◪ 375	0.14	1.0	■ 30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T9325	●	0.4	◪ 175	0.12	1.0	■ 105	0.11	1.0	◪ 165	0.12	1.0	–	–	–	◪ 35	0.08	0.8	–	–	–
VCGT 130304E-NF2:T9335	●	0.4	◪ 150	0.12	1.0	■ 90	0.11	1.0	–	–	–	–	–	–	◪ 30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T9415	●	0.4	◪ 225	0.10	1.0	–	–	–	◪ 210	0.10	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-NF2:TT010	●	0.4	◪ 245	0.06	0.5	◪ 145	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130308E-NF2:T5315	●	0.8	◪ 205	0.17	1.0	–	–	–	◪ 190	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-NF2:T6310	●	0.8	◪ 125	0.17	1.0	■ 90	0.15	1.0	◪ 100	0.17	1.0	◪ 375	0.20	1.0	■ 35	0.12	0.8	–	–	–
VCGT 130308E-NF2:T7325	●	0.8	◪ 145	0.17	1.0	■ 110	0.15	1.0	–	–	–	–	–	–	■ 45	0.12	0.8	–	–	–
VCGT 130308E-NF2:T7335	●	0.8	◪ 140	0.17	1.0	■ 105	0.15	1.0	–	–	–	–	–	–	■ 45	0.12	0.8	–	–	–
VCGT 130308E-NF2:T8415	●	0.8	◪ 160	0.17	1.0	■ 85	0.15	1.0	◪ 145	0.17	1.0	◪ 405	0.20	1.0	■ 35	0.12	0.8	–	–	–
VCGT 130308E-NF2:T9325	●	0.8	◪ 180	0.17	1.0	■ 105	0.15	1.0	◪ 170	0.17	1.0	–	–	–	◪ 40	0.12	0.8	–	–	–
VCGT 130308E-NF2:T9335	●	0.8	◪ 155	0.18	1.0	■ 90	0.16	1.0	–	–	–	–	–	–	◪ 30	0.16	0.8	–	–	–
VCGT 130308E-NF2:T9415	●	0.8	◪ 225	0.17	1.0	–	–	–	◪ 210	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-NF2:TT010	●	0.8	◪ 245	0.10	0.8	◪ 145	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–

NF2 断屑槽非常锋利，是不锈钢精加工的首选。具有正前角，无T-型倒棱。还适用于耐热合金，有条件地适用于钢、铸铁和有色合金。

UR

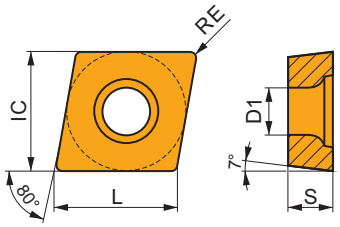


UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。

PRAMET

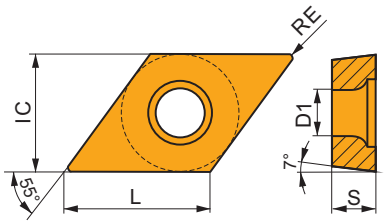
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



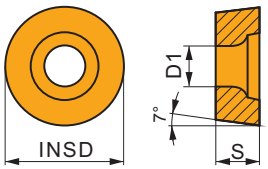
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



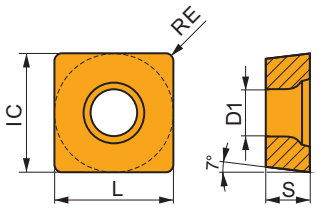
RCMT

	INSD (mm)	D1 (mm)	S (mm)
0602	6.000	2.80	2.38
0803	8.000	3.40	3.18
10T3	10.000	4.40	3.97
1204	12.000	4.40	4.76



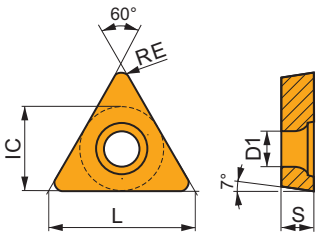
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



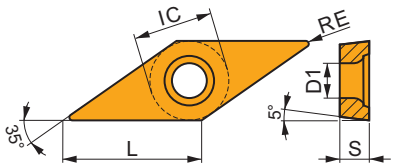
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



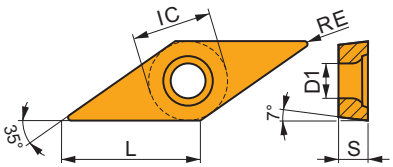
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.10	2.38
1604	9.525	4.40	16.60	4.76



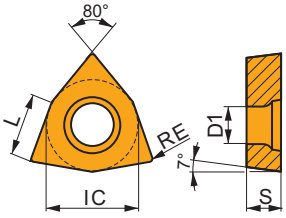
VCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76

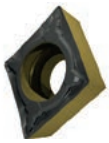


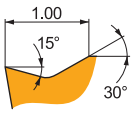
WCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	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。

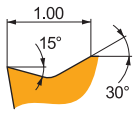
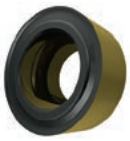
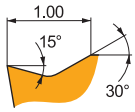




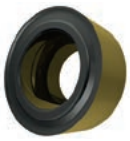
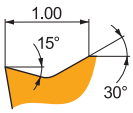
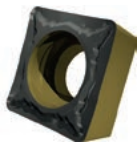
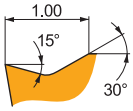
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。

Product		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)
CCMT 060202E-UR:T8315	●	0.2	170	0.10	0.8	100	0.09	0.8	160	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T8415	●	0.2	210	0.10	0.8	110	0.09	0.8	190	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T8430	●	0.2	200	0.10	0.8	110	0.09	0.8	165	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T9325	●	0.2	250	0.10	0.8	150	0.09	0.8	235	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T9415	●	0.2	295	0.10	0.8	–	–	–	280	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:TT310	●	0.2	275	0.10	0.5	165	0.09	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T5315	●	0.4	245	0.15	1.0	–	–	–	230	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T7325	●	0.4	170	0.15	1.0	130	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T7335	●	0.4	170	0.15	1.0	130	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T8315	●	0.4	160	0.15	1.0	95	0.14	1.0	150	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T8415	●	0.4	190	0.15	1.0	100	0.14	1.0	170	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T8430	●	0.4	175	0.15	1.0	95	0.14	1.0	140	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T9325	●	0.4	215	0.15	1.0	125	0.15	1.0	200	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T9415	●	0.4	270	0.15	1.0	–	–	–	255	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:TT310	●	0.4	255	0.15	0.5	150	0.14	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T5315	●	0.8	270	0.20	1.0	–	–	–	255	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T8430	⬌	0.8	185	0.20	1.0	100	0.18	1.0	150	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T9325	●	0.8	230	0.20	1.0	135	0.18	1.0	215	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T9415	●	0.8	290	0.20	1.0	–	–	–	275	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:T6310	●	0.2	160	0.10	1.0	115	0.09	1.0	125	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:T8415	●	0.2	200	0.10	1.0	105	0.09	1.0	185	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:T8430	●	0.2	195	0.10	1.0	105	0.09	1.0	160	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:TT310	●	0.2	255	0.10	1.0	150	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T5315	●	0.4	245	0.15	1.2	–	–	–	230	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T7325	●	0.4	170	0.15	1.2	130	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T7335	●	0.4	165	0.15	1.2	125	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T8315	●	0.4	155	0.15	1.2	90	0.14	1.2	145	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T8415	●	0.4	190	0.15	1.2	100	0.14	1.2	170	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T8430	●	0.4	175	0.15	1.2	95	0.14	1.2	140	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T9315	●	0.4	235	0.15	1.2	–	–	–	220	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T9325	●	0.4	215	0.15	1.2	125	0.15	1.2	200	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T9415	●	0.4	265	0.15	1.2	–	–	–	250	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:TT310	●	0.4	235	0.15	1.2	140	0.14	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T5315	●	0.8	265	0.20	1.2	–	–	–	250	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T7325	●	0.8	185	0.20	1.2	140	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T7335	●	0.8	175	0.20	1.2	135	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T8315	●	0.8	170	0.20	1.2	100	0.18	1.2	160	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T8415	●	0.8	200	0.20	1.2	105	0.18	1.2	185	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T8430	⬌	0.8	185	0.20	1.2	100	0.18	1.2	150	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T9325	●	0.8	225	0.20	1.2	135	0.18	1.2	210	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T9415	●	0.8	285	0.20	1.2	–	–	–	270	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:TT310	●	0.8	255	0.20	1.2	150	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T5315	●	0.4	235	0.15	1.7	–	–	–	220	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T7325	●	0.4	160	0.15	1.7	120	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T8430	●	0.4	170	0.15	1.7	90	0.14	1.7	135	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T9325	●	0.4	205	0.15	1.7	120	0.15	1.7	190	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T9415	●	0.4	255	0.15	1.7	–	–	–	240	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T5315	●	0.8	255	0.20	1.7	–	–	–	240	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T7325	●	0.8	175	0.20	1.7	135	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T8430	⬌	0.8	180	0.20	1.7	95	0.18	1.7	145	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T9325	●	0.8	215	0.20	1.7	125	0.18	1.7	200	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T9415	●	0.8	275	0.20	1.7	–	–	–	260	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T5315	●	1.2	240	0.27	1.7	–	–	–	225	0.27	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T8430	⬌	1.2	165	0.27	1.7	90	0.24	1.7	135	0.27	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T9325	⬌	1.2	205	0.27	1.7	120	0.24	1.7	190	0.27	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T9415	●	1.2	265	0.27	1.7	–	–	–	250	0.27	1.7	–	–	–	–	–	–	–	–	–

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/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)
																				
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。																				
DCMT 070202E-UR:T7325	●	0.2	◪ 150	0.10	0.8	◪ 115	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T8315	●	0.2	◪ 135	0.10	0.8	◪ 80	0.09	0.8	■ 125	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T8415	●	0.2	■ 165	0.10	0.8	◪ 85	0.09	0.8	■ 150	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T8430	●	0.2	■ 155	0.10	0.8	◪ 85	0.09	0.8	◪ 130	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T9325	●	0.2	■ 200	0.10	0.8	◪ 120	0.09	0.8	◪ 190	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T9415	●	0.2	■ 235	0.10	0.8	–	–	–	◪ 220	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T7325	●	0.4	◪ 135	0.17	0.8	◪ 105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T8315	●	0.4	◪ 135	0.12	0.8	◪ 80	0.11	0.8	■ 125	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T8415	●	0.4	■ 165	0.12	0.8	◪ 85	0.11	0.8	■ 150	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T8430	●	0.4	■ 155	0.12	0.8	◪ 85	0.11	0.8	◪ 130	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T9325	●	0.4	■ 165	0.18	0.8	◪ 95	0.16	0.8	◪ 155	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T9415	●	0.4	■ 240	0.12	0.8	–	–	–	◪ 225	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T7325	●	0.2	◪ 150	0.10	0.8	◪ 115	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T8430	●	0.2	■ 155	0.10	0.8	◪ 85	0.09	0.8	◪ 130	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T9325	●	0.2	■ 200	0.10	0.8	◪ 120	0.09	0.8	◪ 190	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T9415	●	0.2	■ 235	0.10	0.8	–	–	–	◪ 220	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:TT310	●	0.2	■ 210	0.10	0.8	◪ 125	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T5315	●	0.4	◪ 220	0.12	0.8	–	–	–	■ 205	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T7325	●	0.4	◪ 135	0.17	0.8	◪ 105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T7335	●	0.4	◪ 130	0.17	0.8	◪ 100	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T8315	●	0.4	◪ 135	0.12	0.8	◪ 80	0.11	0.8	■ 125	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T8415	●	0.4	■ 165	0.12	0.8	◪ 85	0.11	0.8	■ 150	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T8430	●	0.4	■ 155	0.12	0.8	◪ 85	0.11	0.8	◪ 130	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T9325	●	0.4	■ 165	0.18	0.8	◪ 95	0.16	0.8	◪ 155	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T9415	●	0.4	■ 240	0.12	0.8	–	–	–	◪ 225	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:TT310	●	0.4	■ 210	0.12	0.8	◪ 125	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T5315	●	0.8	◪ 230	0.17	0.8	–	–	–	■ 215	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T7325	●	0.8	◪ 160	0.17	0.8	◪ 120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T7335	●	0.8	◪ 155	0.17	0.8	◪ 120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T8315	●	0.8	◪ 145	0.17	0.8	◪ 85	0.15	0.8	■ 135	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T8415	●	0.8	■ 180	0.17	0.8	◪ 90	0.15	0.8	■ 160	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T8430	●	0.8	■ 165	0.17	0.8	◪ 90	0.15	0.8	◪ 135	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T9325	●	0.8	■ 200	0.17	0.8	◪ 120	0.15	0.8	◪ 190	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T9415	●	0.8	■ 250	0.17	0.8	–	–	–	◪ 235	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:TT310	●	0.8	■ 225	0.17	0.8	◪ 135	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T312E-UR:T9325	●	1.2	■ 180	0.22	1.2	◪ 105	0.20	1.2	◪ 170	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 11T312E-UR:T9415	●	1.2	■ 230	0.22	1.2	–	–	–	◪ 215	0.22	1.2	–	–	–	–	–	–	–	–	–
 																				
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。																				
RCMT 0602MOE-UR:T6310	⬌	–	■ 170	0.40	1.2	◪ 120	0.36	1.2	■ 135	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T8415	⬌	–	■ 220	0.40	1.2	◪ 115	0.36	1.2	■ 200	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T8430	⬌	–	■ 180	0.40	1.2	◪ 95	0.36	1.2	◪ 145	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T9325	⬌	–	■ 215	0.40	1.2	◪ 125	0.36	1.2	◪ 200	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T9415	⬌	–	■ 285	0.40	1.2	–	–	–	◪ 270	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T6310	⬌	–	■ 160	0.45	1.6	◪ 115	0.41	1.6	■ 125	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T7325	⬌	–	◪ 180	0.45	1.6	◪ 140	0.41	1.6	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T8415	⬌	–	■ 200	0.45	1.6	◪ 105	0.41	1.6	■ 185	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T8430	⬌	–	■ 170	0.45	1.6	◪ 90	0.41	1.6	◪ 135	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T9325	⬌	–	■ 200	0.45	1.6	◪ 120	0.41	1.6	◪ 190	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T9415	⬌	–	■ 265	0.45	1.6	–	–	–	◪ 250	0.45	1.6	–	–	–	–	–	–	–	–	–

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/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)
 																				
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。																				
RCMT 10T3M0E-UR:T6310		–	■	160	0.50	1.4	◪	115	0.45	1.4	■	125	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3M0E-UR:T7325		–	◪	175	0.50	1.4	◪	135	0.45	1.4		–	–	–	–	–	–	–	–	–	–	–	–
RCMT 10T3M0E-UR:T8415		–	■	200	0.50	1.4	◪	105	0.45	1.4	■	185	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3M0E-UR:T8430		–	■	165	0.50	1.4	◪	90	0.45	1.4	◪	135	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3M0E-UR:T9325		–	■	190	0.50	1.4	◪	110	0.45	1.4	◪	180	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3M0E-UR:T9415		–	■	260	0.50	1.4		–	–	–	◪	245	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-UR:T6310		–	■	150	0.55	1.8	◪	105	0.50	1.8	■	120	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-UR:T8415		–	■	190	0.55	1.8	◪	100	0.49	1.8	■	170	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-UR:T8430		–	■	145	0.55	1.8	◪	80	0.50	1.8	◪	120	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-UR:T9315		–	■	200	0.55	1.8		–	–	–	◪	190	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-UR:T9325		–	■	180	0.55	1.8	◪	105	0.50	1.8	◪	170	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-UR:T9415		–	■	245	0.55	1.8		–	–	–	◪	230	0.55	1.8	–	–	–	–	–	–	–	–	–
 																				
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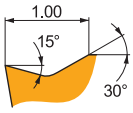
SCMT 09T304E-UR:T8430	●	0.4	■	180	0.15	1.2	◪	95	0.14	1.2	◪	145	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-UR:T9325	●	0.4	■	225	0.15	1.2	◪	135	0.15	1.2	◪	210	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-UR:T9415	●	0.4	■	280	0.15	1.2		–	–	–	◪	265	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T5315	●	0.8	◪	280	0.20	1.2		–	–	–	■	265	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T8430		0.8	■	190	0.20	1.2	◪	105	0.18	1.2	◪	155	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T9325	●	0.8	■	235	0.20	1.2	◪	140	0.18	1.2	◪	220	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T9415	●	0.8	■	300	0.20	1.2		–	–	–	◪	285	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:TT310	●	0.8	■	270	0.20	1.2	◪	160	0.18	1.2		–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T5315	●	0.8	◪	270	0.20	1.6		–	–	–	■	255	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T8430		0.8	■	185	0.20	1.6	◪	100	0.18	1.6	◪	150	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T9325	●	0.8	■	230	0.20	1.6	◪	135	0.18	1.6	◪	215	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-UR:T8430		1.2	■	175	0.27	1.6	◪	95	0.24	1.6	◪	140	0.27	1.6	–	–	–	–	–	–	–	–	–
																				
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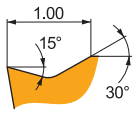
TCMT 110204E-UR:T7325	●	0.4	◪	135	0.19	0.8	◪	105	0.17	0.8		–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110204E-UR:T8430	●	0.4	■	170	0.12	0.8	◪	90	0.11	0.8	◪	135	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-UR:T9325	●	0.4	■	175	0.18	0.8	◪	105	0.16	0.8	◪	165	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-UR:T9415	●	0.4	■	255	0.12	0.8		–	–	–	◪	240	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:T8430	●	0.4	■	170	0.12	0.8	◪	90	0.11	0.8	◪	135	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:T9325	●	0.4	■	175	0.18	0.8	◪	105	0.16	0.8	◪	165	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:T9415	●	0.4	■	255	0.12	0.8		–	–	–	◪	240	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:TT310	●	0.4	■	225	0.12	0.8	◪	135	0.11	0.8		–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T5315	●	0.8	◪	245	0.17	0.8		–	–	–	■	230	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T7325	●	0.8	◪	170	0.17	0.8	◪	130	0.15	0.8		–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T8430	●	0.8	■	175	0.17	0.8	◪	95	0.15	0.8	◪	140	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T9325	●	0.8	■	215	0.17	0.8	◪	125	0.15	0.8	◪	200	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T9415	●	0.8	■	265	0.17	0.8		–	–	–	◪	250	0.17	0.8	–	–	–	–	–	–	–	–	–

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。

Product		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)
																				
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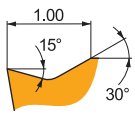
VBMT 110202E-UR:TT310	●	0.2	■	195	0.10	0.8	◪	115	0.09	0.8		–	–	–		–	–	–		–	–	–	–	–	–
VBMT 110204E-UR:T8430	●	0.4	■	145	0.12	0.8	◪	80	0.11	0.8	◪	120	0.12	0.8		–	–	–		–	–	–	–	–	–
VBMT 110204E-UR:T9325	●	0.4	■	150	0.19	0.8	◪	90	0.17	0.8	◪	140	0.19	0.8		–	–	–		–	–	–	–	–	–
VBMT 160402E-UR:T8430	●	0.2	■	140	0.10	1.2	◪	75	0.09	1.2	◪	115	0.10	1.2		–	–	–		–	–	–	–	–	–
VBMT 160404E-UR:T5315	●	0.4	◪	195	0.12	1.2		–	–	–	■	185	0.12	1.2		–	–	–		–	–	–	–	–	–
VBMT 160404E-UR:T7325	●	0.4	◪	115	0.19	1.2	◪	85	0.17	1.2		–	–	–		–	–	–		–	–	–	–	–	–
VBMT 160404E-UR:T8430	●	0.4	■	140	0.12	1.2	◪	75	0.11	1.2	◪	115	0.12	1.2		–	–	–		–	–	–	–	–	–
VBMT 160404E-UR:T9325	●	0.4	■	145	0.18	1.2	◪	85	0.16	1.2	◪	135	0.18	1.2		–	–	–		–	–	–	–	–	–
VBMT 160404E-UR:T9415	●	0.4	■	210	0.12	1.2		–	–	–	◪	195	0.12	1.2		–	–	–		–	–	–	–	–	–
VBMT 160404E-UR:TT310	●	0.4	■	185	0.12	1.2	◪	110	0.11	1.2		–	–	–		–	–	–		–	–	–	–	–	–
VBMT 160408E-UR:T5315	●	0.8	◪	205	0.17	1.2		–	–	–	■	190	0.17	1.2		–	–	–		–	–	–	–	–	–
VBMT 160408E-UR:T7325	●	0.8	◪	140	0.17	1.2	◪	105	0.15	1.2		–	–	–		–	–	–		–	–	–	–	–	–
VBMT 160408E-UR:T8430	●	0.8	■	145	0.17	1.2	◪	80	0.15	1.2	◪	120	0.17	1.2		–	–	–		–	–	–	–	–	–
VBMT 160408E-UR:T9310	●	0.8	■	220	0.17	1.2		–	–	–	◪	205	0.17	1.2		–	–	–		–	–	–	–	–	–
VBMT 160408E-UR:T9325	●	0.8	■	180	0.17	1.2	◪	105	0.15	1.2	◪	170	0.17	1.2		–	–	–		–	–	–	–	–	–
VBMT 160408E-UR:T9415	●	0.8	■	225	0.17	1.2		–	–	–	◪	210	0.17	1.2		–	–	–		–	–	–	–	–	–
VBMT 160408E-UR:TT310	●	0.8	■	200	0.17	1.2	◪	120	0.15	1.2		–	–	–		–	–	–		–	–	–	–	–	–
VBMT 160412E-UR:T8430	●	1.2	■	135	0.22	1.2	◪	75	0.20	1.2	◪	110	0.22	1.2		–	–	–		–	–	–	–	–	–
VBMT 160412E-UR:T9325	●	1.2	■	170	0.22	1.2	◪	100	0.20	1.2	◪	160	0.22	1.2		–	–	–		–	–	–	–	–	–
VBMT 160412E-UR:T9415	●	1.2	■	210	0.22	1.2		–	–	–	◪	195	0.22	1.2		–	–	–		–	–	–	–	–	–
																				
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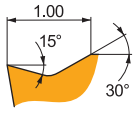
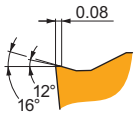
VCMT 110304E-UR:T7325	●	0.4	◪	110	0.19	0.8	◪	85	0.17	0.8		–	–	–		–	–	–		–	–	–	–	–	–
VCMT 110304E-UR:T8430	●	0.4	■	135	0.12	0.8	◪	75	0.11	0.8	◪	110	0.12	0.8		–	–	–		–	–	–	–	–	–
VCMT 110304E-UR:T9325	●	0.4	■	140	0.19	0.8	◪	80	0.17	0.8	◪	130	0.19	0.8		–	–	–		–	–	–	–	–	–
VCMT 110304E-UR:T9415	●	0.4	■	210	0.12	0.8		–	–	–	◪	195	0.12	0.8		–	–	–		–	–	–	–	–	–
VCMT 110308E-UR:T7325	●	0.8	◪	140	0.17	0.8	◪	105	0.15	0.8		–	–	–		–	–	–		–	–	–	–	–	–
VCMT 110308E-UR:T8430	●	0.8	■	140	0.17	0.8	◪	75	0.15	0.8	◪	115	0.17	0.8		–	–	–		–	–	–	–	–	–
VCMT 110308E-UR:T9325	●	0.8	■	175	0.17	0.8	◪	105	0.15	0.8	◪	165	0.17	0.8		–	–	–		–	–	–	–	–	–
VCMT 110308E-UR:T9415	●	0.8	■	220	0.17	0.8		–	–	–	◪	205	0.17	0.8		–	–	–		–	–	–	–	–	–
VCMT 160404E-UR:T7325	●	0.4	◪	110	0.19	1.2	◪	85	0.17	1.2		–	–	–		–	–	–		–	–	–	–	–	–
VCMT 160404E-UR:T8430	●	0.4	■	130	0.12	1.2	◪	70	0.11	1.2	◪	105	0.12	1.2		–	–	–		–	–	–	–	–	–
VCMT 160404E-UR:T9325	●	0.4	■	135	0.19	1.2	◪	80	0.17	1.2	◪	125	0.19	1.2		–	–	–		–	–	–	–	–	–
VCMT 160404E-UR:T9415	●	0.4	■	200	0.12	1.2		–	–	–	◪	190	0.12	1.2		–	–	–		–	–	–	–	–	–
VCMT 160408E-UR:T7325	●	0.8	◪	135	0.17	1.2	◪	105	0.15	1.2		–	–	–		–	–	–		–	–	–	–	–	–
VCMT 160408E-UR:T8430	●	0.8	■	135	0.17	1.2	◪	75	0.15	1.2	◪	110	0.17	1.2		–	–	–		–	–	–	–	–	–
VCMT 160408E-UR:T9325	●	0.8	■	170	0.17	1.2	◪	100	0.15	1.2	◪	160	0.17	1.2		–	–	–		–	–	–	–	–	–
VCMT 160408E-UR:T9415	●	0.8	■	210	0.17	1.2		–	–	–	◪	195	0.17	1.2		–	–	–		–	–	–	–	–	–
																				
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。																				
WCMT 06T308E-UR:T7325	●	0.8	◪	185	0.20	1.2	◪	140	0.18	1.2		–	–	–		–	–	–		–	–	–	–	–	–
WCMT 06T308E-UR:T9325	●	0.8	■	225	0.20	1.2	◪	135	0.18	1.2	◪	210	0.20	1.2		–	–	–		–	–	–	–	–	–

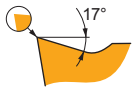
W -FM



W-FM 型断屑槽具有修光刃，专为钢材、不锈钢和铸铁的精加工而设计。它具有正前角和正窄 T 倒棱。

PRAMET

W -UR



W-UR 型断屑槽具有修光刃，专为钢和铸铁的精加工而设计。它具有正前角，无 T 倒棱。它也有条件地适用于不锈钢。

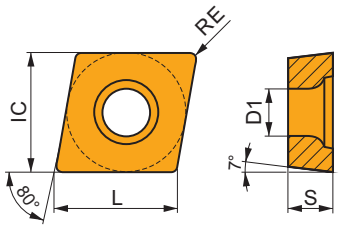
PRAMET

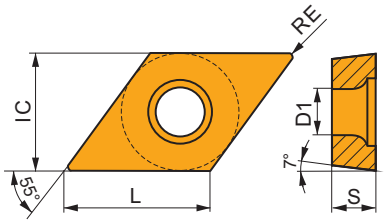
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97

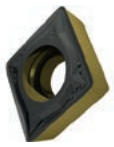
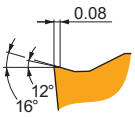
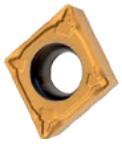
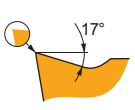
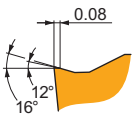
DCMX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97

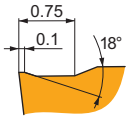
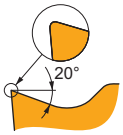
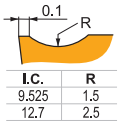




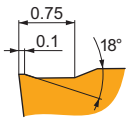
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
 																				
CCMT 060204W-FM:T8430	●	0.4	165	0.30	0.8	90	0.27	0.8	135	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 060204W-FM:T9325	●	0.4	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 060204W-FM:T9415	●	0.4	250	0.30	0.8	–	–	–	235	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM:T8430	●	0.4	165	0.30	0.8	90	0.27	0.8	135	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM:T9325	●	0.4	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM:T9415	●	0.4	305	0.15	1.2	–	–	–	285	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308W-FM:T8430	⬌	0.8	170	0.40	1.0	90	0.36	1.0	135	0.40	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308W-FM:T9325	●	0.8	200	0.40	1.0	120	0.36	1.0	190	0.40	1.0	–	–	–	–	–	–	–	–	–
 																				
CCMT 060204W-UR:TT310	●	0.4	255	0.15	0.5	150	0.14	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
DCMX 11T304W-FM:T7325	●	0.4	130	0.30	0.8	100	0.27	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMX 11T304W-FM:T8430	●	0.4	130	0.30	0.8	70	0.27	0.8	105	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T304W-FM:T9325	●	0.4	155	0.30	0.8	90	0.27	0.8	145	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T304W-FM:T9415	●	0.4	200	0.30	0.8	–	–	–	190	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T308W-FM:T8430	●	0.8	130	0.40	1.0	70	0.36	1.0	105	0.40	1.0	–	–	–	–	–	–	–	–	–
DCMX 11T308W-FM:T9325	●	0.8	160	0.40	1.0	95	0.36	1.0	150	0.40	1.0	–	–	–	–	–	–	–	–	–

半精加工 – 导航工具

FM2			FM2 断屑槽坚固耐用，是钢材中型加工的首选。它具有正前角和稳定、适中的 T 倒棱。它还适用于铸铁和有条件的不锈钢。
SI			SI 型断屑槽型非常锋利，是不锈钢中等加工的首选。具有大正前角，无T-型倒棱。还适用于钢和耐热合金，有条件的用于铸铁。
RF	 I.C. R 9.525 1.5 12.7 2.5		RF 断屑槽坚固耐用，是铸铁中型加工的首选。它的特点是略带正前角和稳定、适中的 T 倒棱。它也适用于钢材，有条件时也适用于不锈钢和硬质材料。
.CMW			.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。

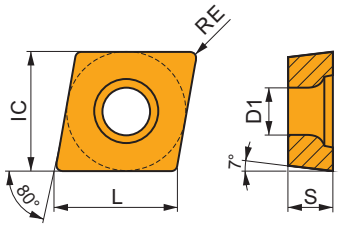
FM2



FM2 断屑槽坚固耐用，是钢材中型加工的首选。它具有正前角和稳定、适中的 T 倒棱。它还适用于铸铁和有条件的不锈钢。

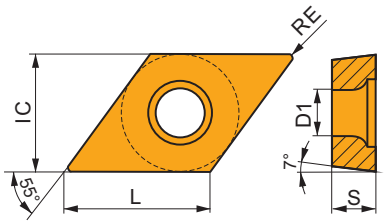
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



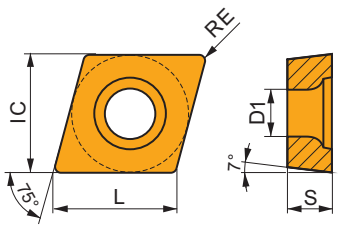
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



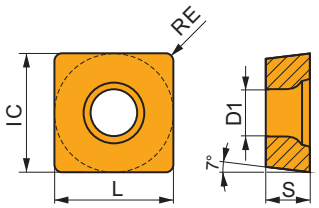
ECMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18



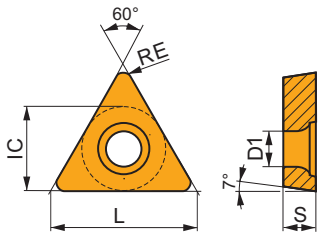
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97



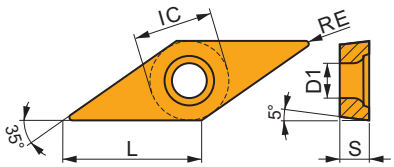
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



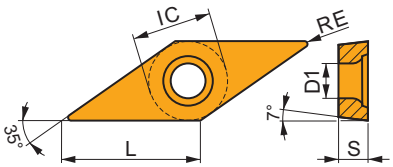
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76

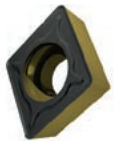


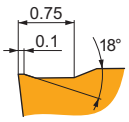
VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18



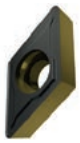
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

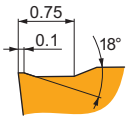




FM2 断屑槽坚固耐用，是钢材中型加工的首选。它具有正前角和稳定、适中的 T 倒棱。它还适用于铸铁和有条件的不锈钢。

Product		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)
CCMT 080304E-FM2:T8430	●	0.4	205	0.12	1.0	110	0.11	1.0	170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FM2:T9325	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FM2:T9335	●	0.4	215	0.12	1.0	125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080304E-FM2:T9415	●	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2:T8430	⬌	0.8	210	0.17	1.0	115	0.15	1.0	175	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2:T9325	⬌	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2:T9335	⬌	0.8	225	0.17	1.0	135	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T6310	●	0.4	165	0.12	1.0	115	0.11	1.0	130	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T8430	●	0.4	205	0.12	1.0	110	0.11	1.0	170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T9325	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T9415	●	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T6310	⬌	0.8	180	0.17	1.0	125	0.15	1.0	145	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T7325	⬌	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T8430	⬌	0.8	210	0.17	1.0	115	0.15	1.0	175	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T9325	⬌	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T9335	⬌	0.8	225	0.17	1.0	135	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T9415	●	0.8	320	0.17	1.0	–	–	–	300	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T7325	⬌	0.8	190	0.20	1.5	145	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T8430	⬌	0.8	190	0.20	1.5	105	0.18	1.5	155	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T9325	⬌	0.8	235	0.20	1.5	140	0.18	1.5	220	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T9335	⬌	0.8	200	0.20	1.5	120	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

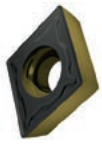
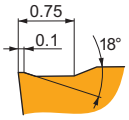




FM2 断屑槽坚固耐用，是钢材中型加工的首选。它具有正前角和稳定、适中的 T 倒棱。它还适用于铸铁和有条件的不锈钢。

Product		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)
DCMT 070204E-FM2:T6310	●	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T7325	●	0.4	160	0.12	0.8	120	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T8430	●	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T9325	●	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T9415	●	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T6310	●	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T7325	●	0.4	160	0.12	0.8	120	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T8430	●	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T9325	●	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T9335	●	0.4	175	0.12	0.8	105	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T9415	●	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T6310	●	0.8	150	0.17	0.8	105	0.15	0.8	120	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T7325	●	0.8	170	0.17	0.8	130	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T8430	●	0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T9325	●	0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T9335	●	0.8	180	0.17	0.8	105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T9415	●	0.8	265	0.17	0.8	–	–	–	250	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM2:T8430	⬌	1.2	155	0.22	1.2	85	0.20	1.2	130	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM2:T9325	●	1.2	190	0.22	1.2	110	0.20	1.2	180	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 150408E-FM2:T9325	●	0.8	185	0.20	1.5	110	0.18	1.5	175	0.20	1.5	–	–	–	–	–	–	–	–	–
DCMT 150408E-FM2:T9335	●	0.8	160	0.20	1.5	95	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

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。

Product	●	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)
 																				
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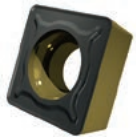
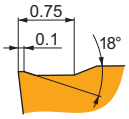
ECMT 060204E-FM2:T7325	●	0.4	◪	180	0.12	0.8	◪	140	0.11	0.8		–	–	–		–	–	–		–	–	–		–	–	–
ECMT 060204E-FM2:T8430	●	0.4	■	205	0.12	0.8	◪	110	0.11	0.8	◪	170	0.12	0.8		–	–	–		–	–	–		–	–	–
ECMT 060204E-FM2:T9325	●	0.4	■	255	0.12	0.8	◪	150	0.11	0.8	◪	240	0.12	0.8		–	–	–		–	–	–		–	–	–
ECMT 060204E-FM2:T9335	●	0.4	■	220	0.12	0.8	◪	130	0.11	0.8		–	–	–		–	–	–		–	–	–		–	–	–
ECMT 060204E-FM2:T9415	●	0.4	■	285	0.12	0.8		–	–	–	◪	270	0.12	0.8		–	–	–		–	–	–		–	–	–
ECMT 080304E-FM2:T5315	●	0.4	◪	280	0.12	1.0		–	–	–	■	265	0.12	1.0		–	–	–		–	–	–		–	–	–
ECMT 080304E-FM2:T7325	●	0.4	◪	170	0.12	1.0	◪	130	0.11	1.0		–	–	–		–	–	–		–	–	–		–	–	–
ECMT 080304E-FM2:T8430	●	0.4	■	205	0.12	1.0	◪	110	0.11	1.0	◪	170	0.12	1.0		–	–	–		–	–	–		–	–	–
ECMT 080304E-FM2:T9325	●	0.4	■	255	0.12	1.0	◪	150	0.11	1.0	◪	240	0.12	1.0		–	–	–		–	–	–		–	–	–
ECMT 080304E-FM2:T9335	●	0.4	■	215	0.12	1.0	◪	125	0.11	1.0		–	–	–		–	–	–		–	–	–		–	–	–
ECMT 080304E-FM2:T9415	●	0.4	■	275	0.12	1.0		–	–	–	◪	260	0.12	1.0		–	–	–		–	–	–		–	–	–
ECMT 080308E-FM2:T7325	⬌	0.8	◪	185	0.17	1.0	◪	140	0.15	1.0		–	–	–		–	–	–		–	–	–		–	–	–
ECMT 080308E-FM2:T8430	⬌	0.8	■	210	0.17	1.0	◪	115	0.15	1.0	◪	175	0.17	1.0		–	–	–		–	–	–		–	–	–
ECMT 080308E-FM2:T9325	⬌	0.8	■	260	0.17	1.0	◪	155	0.15	1.0	◪	245	0.17	1.0		–	–	–		–	–	–		–	–	–
ECMT 080308E-FM2:T9335	⬌	0.8	■	225	0.17	1.0	◪	135	0.15	1.0		–	–	–		–	–	–		–	–	–		–	–	–
ECMT 080308E-FM2:T9415	●	0.8	■	290	0.17	1.0		–	–	–	◪	275	0.17	1.0		–	–	–		–	–	–		–	–	–
 																				
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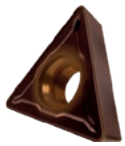
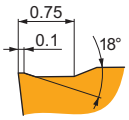
SCMT 09T304E-FM2:T8430	●	0.4	■	220	0.12	1.0	◪	120	0.11	1.0	◪	180	0.12	1.0		–	–	–		–	–	–		–	–	–
SCMT 09T304E-FM2:T9325	●	0.4	■	265	0.12	1.0	◪	155	0.11	1.0	◪	250	0.12	1.0		–	–	–		–	–	–		–	–	–
SCMT 09T308E-FM2:T8430	⬌	0.8	■	225	0.17	1.0	◪	120	0.15	1.0	◪	185	0.17	1.0		–	–	–		–	–	–		–	–	–
SCMT 09T308E-FM2:T9325	⬌	0.8	■	270	0.17	1.0	◪	160	0.15	1.0	◪	255	0.17	1.0		–	–	–		–	–	–		–	–	–
SCMT 09T308E-FM2:T9415	●	0.8	■	340	0.17	1.0		–	–	–	◪	320	0.17	1.0		–	–	–		–	–	–		–	–	–
 																				
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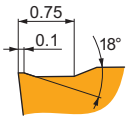
TCMT 110204E-FM2:T8430	●	0.4	■	180	0.12	0.8	◪	95	0.11	0.8	◪	145	0.12	0.8		–	–	–		–	–	–		–	–	–
TCMT 110204E-FM2:T9325	●	0.4	■	220	0.12	0.8	◪	130	0.11	0.8	◪	205	0.12	0.8		–	–	–		–	–	–		–	–	–
TCMT 110208E-FM2:T8430	●	0.8	■	185	0.17	0.8	◪	100	0.15	0.8	◪	150	0.17	0.8		–	–	–		–	–	–		–	–	–
TCMT 110208E-FM2:T9325	●	0.8	■	225	0.17	0.8	◪	135	0.15	0.8	◪	210	0.17	0.8		–	–	–		–	–	–		–	–	–
TCMT 16T308E-FM2:T7325	●	0.8	◪	170	0.20	1.0	◪	130	0.18	1.0		–	–	–		–	–	–		–	–	–		–	–	–
TCMT 16T308E-FM2:T8430	⬌	0.8	■	170	0.20	1.0	◪	90	0.18	1.0	◪	135	0.20	1.0		–	–	–		–	–	–		–	–	–
TCMT 16T308E-FM2:T9325	●	0.8	■	205	0.20	1.0	◪	120	0.18	1.0	◪	190	0.20	1.0		–	–	–		–	–	–		–	–	–
TCMT 16T308E-FM2:T9335	●	0.8	■	175	0.20	1.0	◪	105	0.18	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/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)
																				
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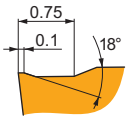
VBMT 160404E-FM2:T6310	●	0.4	■	120	0.12	1.2	◪	85	0.11	1.2	■	95	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T7325	●	0.4	◪	140	0.12	1.2	◪	105	0.11	1.2		–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T8430	●	0.4	■	145	0.12	1.2	◪	80	0.11	1.2	◪	120	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T9325	●	0.4	■	185	0.12	1.2	◪	110	0.11	1.2	◪	175	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T9335	●	0.4	■	155	0.12	1.2	◪	90	0.11	1.2		–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T9415	●	0.4	■	220	0.12	1.2		–	–	–	◪	205	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T6310	●	0.8	■	125	0.20	1.2	◪	90	0.18	1.2	■	100	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T7325	●	0.8	◪	145	0.20	1.2	◪	110	0.18	1.2		–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T8430	●	0.8	■	140	0.20	1.2	◪	75	0.18	1.2	◪	115	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T9325	●	0.8	■	175	0.20	1.2	◪	105	0.18	1.2	◪	165	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T9335	●	0.8	■	150	0.20	1.2	◪	90	0.18	1.2		–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T9415	●	0.8	■	220	0.20	1.2		–	–	–	◪	205	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T8430	●	1.2	■	145	0.22	1.2	◪	80	0.20	1.2	◪	120	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T9315	●	1.2	■	195	0.22	1.2		–	–	–	◪	185	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T9325	●	1.2	■	175	0.22	1.2	◪	105	0.20	1.2	◪	165	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T9415	●	1.2	■	225	0.22	1.2		–	–	–	◪	210	0.22	1.2	–	–	–	–	–	–	–	–	–
																				
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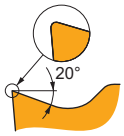
VCGT 130308E-FM2:T8430	●	0.8	■	145	0.17	1.0	◪	80	0.15	1.0	◪	120	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FM2:T9325	●	0.8	■	180	0.17	1.0	◪	105	0.15	1.0	◪	170	0.17	1.0	–	–	–	–	–	–	–	–	–

SI



SI 型断屑槽型非常锋利，是不锈钢中等加工的首选。具有大正前角，无T-型倒棱。还适用于钢和耐热合金，有条件的用于铸铁。

PRAMET

CCGT

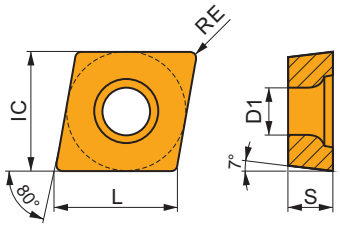
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76

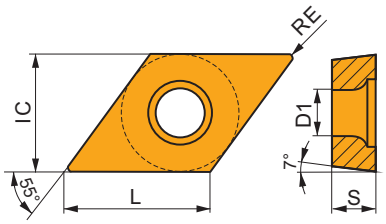
DCGT

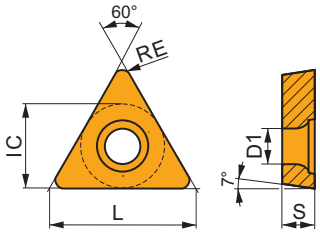
	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97

TCGT

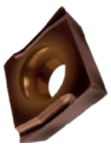
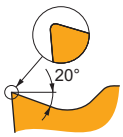
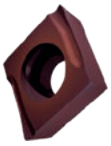
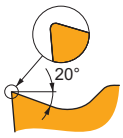
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38



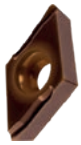
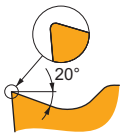
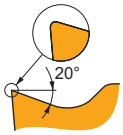




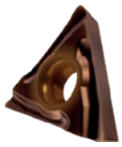
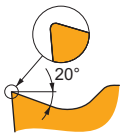
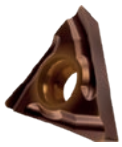
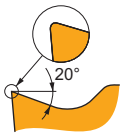
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
 	SI 型断屑槽型非常锋利，是不锈钢中等加工的首选。具有大正前角，无T-型倒棱。还适用于钢和耐热合金，有条件的用于铸铁。																			
CCGT 060202ER-SI:T8430	●	0.2	260	0.10	0.8	140	0.09	0.8	215	0.10	0.8	–	–	–	55	0.08	0.6	–	–	–
CCGT 060204ER-SI:T8315	●	0.4	225	0.12	0.8	135	0.11	0.8	210	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 060204ER-SI:T8430	●	0.4	260	0.12	0.8	140	0.11	0.8	215	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 09T304ER-SI:T8315	●	0.4	205	0.17	0.8	120	0.15	0.8	190	0.17	0.8	–	–	–	50	0.15	0.6	–	–	–
CCGT 09T304ER-SI:T8430	●	0.4	230	0.17	0.8	125	0.15	0.8	185	0.17	0.8	–	–	–	45	0.15	0.6	–	–	–
CCGT 120408ER-SI:T8430	⬌	0.8	230	0.24	1.0	125	0.22	1.0	185	0.24	1.0	–	–	–	45	0.22	0.8	–	–	–
 	SI 型断屑槽型非常锋利，是不锈钢中等加工的首选。具有大正前角，无T-型倒棱。还适用于钢和耐热合金，有条件的用于铸铁。																			
CCGT 060202EL-SI:T8430	●	0.2	260	0.10	0.8	140	0.09	0.8	215	0.10	0.8	–	–	–	55	0.08	0.6	–	–	–
CCGT 060204EL-SI:T8315	●	0.4	225	0.12	0.8	135	0.11	0.8	210	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 060204EL-SI:T8415	●	0.4	275	0.12	0.8	140	0.11	0.8	250	0.12	0.8	–	–	–	60	0.10	0.6	–	–	–
CCGT 060204EL-SI:T8430	●	0.4	260	0.12	0.8	140	0.11	0.8	215	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 09T304EL-SI:T8315	●	0.4	205	0.17	0.8	120	0.15	0.8	190	0.17	0.8	–	–	–	50	0.15	0.6	–	–	–
CCGT 09T304EL-SI:T8415	●	0.4	250	0.17	0.8	130	0.15	0.8	225	0.17	0.8	–	–	–	55	0.15	0.6	–	–	–
CCGT 09T304EL-SI:T8430	●	0.4	230	0.17	0.8	125	0.15	0.8	185	0.17	0.8	–	–	–	45	0.15	0.6	–	–	–
CCGT 120408EL-SI:T8430	⬌	0.8	230	0.24	1.0	125	0.22	1.0	185	0.24	1.0	–	–	–	45	0.22	0.8	–	–	–

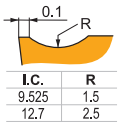
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
																				
SI 型断屑槽型非常锋利，是不锈钢中等加工的首选。具有大正前角，无T-型倒棱。还适用于钢和耐热合金，有条件的用于铸铁。																				
DCGT 11T304ER-SI:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
DCGT 11T308ER-SI:T8430	●	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	–	–	–	40	0.18	0.8	–	–	–
																				
SI 型断屑槽型非常锋利，是不锈钢中等加工的首选。具有大正前角，无T-型倒棱。还适用于钢和耐热合金，有条件的用于铸铁。																				
DCGT 11T304EL-SI:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
DCGT 11T308EL-SI:T8430	●	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	–	–	–	40	0.18	0.8	–	–	–

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。

Product	Interrupted/ Continuous cut	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)
																				
SI 型断屑槽型非常锋利，是不锈钢中等加工的首选。具有大正前角，无T-型倒棱。还适用于钢和耐热合金，有条件的用于铸铁。																				
TCGT 110202ER-SI:T8315	●	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110202ER-SI:T8430	●	0.2	225	0.10	0.8	120	0.09	0.8	185	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110204ER-SI:T8430	●	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
																				
SI 型断屑槽型非常锋利，是不锈钢中等加工的首选。具有大正前角，无T-型倒棱。还适用于钢和耐热合金，有条件的用于铸铁。																				
TCGT 110202EL-SI:T8315	●	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110202EL-SI:T8415	●	0.2	230	0.10	0.8	120	0.09	0.8	210	0.10	0.8	–	–	–	50	0.08	0.6	–	–	–
TCGT 110202EL-SI:T8430	●	0.2	225	0.10	0.8	120	0.09	0.8	185	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110204EL-SI:T8315	●	0.4	195	0.12	0.8	115	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
TCGT 110204EL-SI:T8415	●	0.4	230	0.12	0.8	120	0.11	0.8	210	0.12	0.8	–	–	–	50	0.10	0.6	–	–	–
TCGT 110204EL-SI:T8430	●	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–

RF

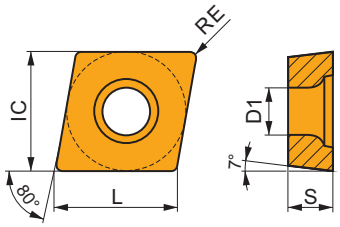


RF 断屑槽坚固耐用，是铸铁中型加工的首选。它的特点是略带正前角和稳定、适中的 T 倒棱。它也适用于钢材，有条件时也适用于不锈钢和硬质材料。

PRAMET

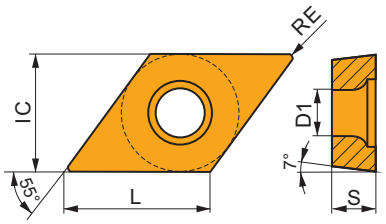
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



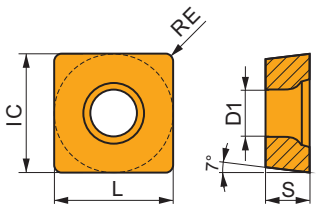
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97



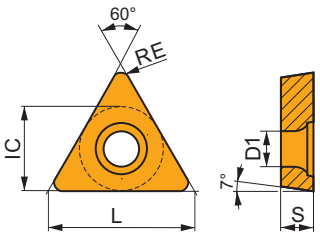
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



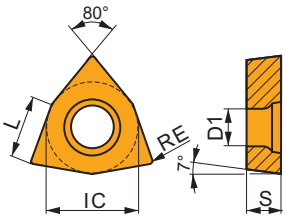
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

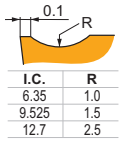
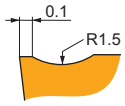
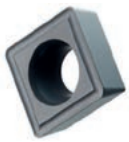
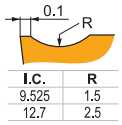
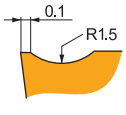
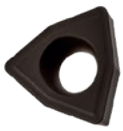
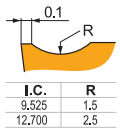


WCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	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。

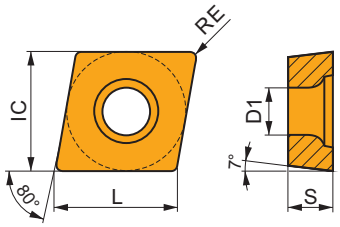
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
	RF 断屑槽坚固耐用，是铸铁中型加工的首选。它的特点是略带正前角和稳定、适中的 T 倒棱。它也适用于钢材，有条件时也适用于不锈钢和硬质材料。																			
CCMT 060202E-RF:T7335	●	0.2	◪	150	0.15	1.0	◪	115	0.14	1.0		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 060204E-RF:T5315	●	0.4	◪	235	0.15	1.0		–	–	–	■	220	0.15	1.0		–	–	–		–	–	–	◪	45	0.11	0.3
CCMT 060204E-RF:T7335	●	0.4	◪	160	0.15	1.0	◪	120	0.15	1.0		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 060204E-RF:T9325	●	0.4	■	205	0.15	1.0	◪	120	0.15	1.0	◪	190	0.15	1.0		–	–	–		–	–	–		–	–	–
CCMT 09T304E-RF:T7335	●	0.4	◪	135	0.20	1.5	◪	105	0.18	1.5		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 09T304E-RF:T9325	●	0.4	■	175	0.20	1.5	◪	105	0.18	1.5	◪	165	0.20	1.5		–	–	–		–	–	–		–	–	–
CCMT 09T308E-RF:T5315	●	0.8	◪	245	0.20	1.5		–	–	–	■	230	0.20	1.5		–	–	–		–	–	–	◪	45	0.14	0.7
CCMT 09T308E-RF:T7335	●	0.8	◪	165	0.20	1.5	◪	125	0.18	1.5		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 09T308E-RF:T9325	●	0.8	■	210	0.20	1.5	◪	125	0.18	1.5	◪	195	0.20	1.5		–	–	–		–	–	–		–	–	–
CCMT 120408E-RF:T5315	●	0.8	◪	230	0.22	2.2		–	–	–	■	215	0.22	2.2		–	–	–		–	–	–	◪	45	0.13	0.7
CCMT 120408E-RF:T7335	●	0.8	◪	150	0.22	2.2	◪	115	0.22	2.2		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 120408E-RF:T9325	●	0.8	■	195	0.22	2.2	◪	115	0.22	2.2	◪	185	0.22	2.2		–	–	–		–	–	–		–	–	–
	RF 断屑槽坚固耐用，是铸铁中型加工的首选。它的特点是略带正前角和稳定、适中的 T 倒棱。它也适用于钢材，有条件时也适用于不锈钢和硬质材料。																			
DCMT 11T304E-RF:T5315	●	0.4	◪	175	0.20	0.8		–	–	–	■	165	0.20	0.8		–	–	–		–	–	–	◪	35	0.14	0.3
DCMT 11T304E-RF:T7335	●	0.4	◪	115	0.20	0.8	◪	85	0.18	0.8		–	–	–		–	–	–		–	–	–		–	–	–
DCMT 11T304E-RF:T9325	●	0.4	■	150	0.20	0.8	◪	90	0.18	0.8	◪	140	0.20	0.8		–	–	–		–	–	–		–	–	–
DCMT 11T308E-RF:T5315	●	0.8	◪	205	0.20	0.8		–	–	–	■	190	0.20	0.8		–	–	–		–	–	–	◪	40	0.10	0.7
DCMT 11T308E-RF:T7335	●	0.8	◪	140	0.20	0.8	◪	105	0.18	0.8		–	–	–		–	–	–		–	–	–		–	–	–
DCMT 11T308E-RF:T9325	●	0.8	■	175	0.20	0.8	◪	105	0.18	0.8	◪	165	0.20	0.8		–	–	–		–	–	–		–	–	–
 	RF 断屑槽坚固耐用，是铸铁中型加工的首选。它的特点是略带正前角和稳定、适中的 T 倒棱。它也适用于钢材，有条件时也适用于不锈钢和硬质材料。																			
SCMT 09T308E-RF:T5315	●	0.8	◪	255	0.20	1.5		–	–	–	■	240	0.20	1.5		–	–	–		–	–	–	◪	50	0.10	0.7
SCMT 09T308E-RF:T9325	●	0.8	■	220	0.20	1.5	◪	130	0.18	1.5	◪	205	0.20	1.5		–	–	–		–	–	–		–	–	–
SCMT 120408E-RF:T5315	●	0.8	◪	240	0.22	2.2		–	–	–	■	225	0.22	2.2		–	–	–		–	–	–	◪	45	0.13	0.7
SCMT 120408E-RF:T7335	●	0.8	◪	160	0.22	2.2	◪	120	0.22	2.2		–	–	–		–	–	–		–	–	–		–	–	–
SCMT 120408E-RF:T9325	●	0.8	■	205	0.22	2.2	◪	120	0.22	2.2	◪	190	0.22	2.2		–	–	–		–	–	–		–	–	–
	RF 断屑槽坚固耐用，是铸铁中型加工的首选。它的特点是略带正前角和稳定、适中的 T 倒棱。它也适用于钢材，有条件时也适用于不锈钢和硬质材料。																			
TCMT 16T308E-RF:T9325	●	0.8	■	175	0.20	1.5	◪	105	0.18	1.5	◪	165	0.20	1.5		–	–	–		–	–	–		–	–	–
 	RF 断屑槽坚固耐用，是铸铁中型加工的首选。它的特点是略带正前角和稳定、适中的 T 倒棱。它也适用于钢材，有条件时也适用于不锈钢和硬质材料。																			
WCMT 06T308E-RF:T7335	●	0.8	◪	165	0.20	1.5	◪	125	0.18	1.5		–	–	–		–	–	–		–	–	–		–	–	–
WCMT 080412E-RF:T7335	⬌	1.2	◪	160	0.22	2.2	◪	120	0.22	2.2		–	–	–		–	–	–		–	–	–		–	–	–

.CMW

.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。

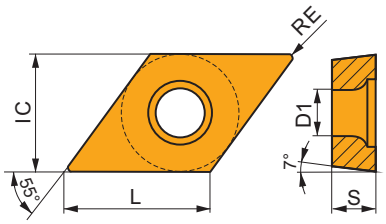
CCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



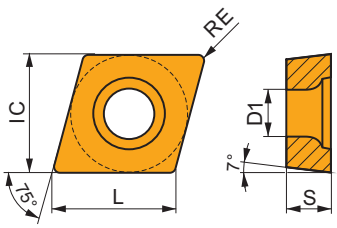
DCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



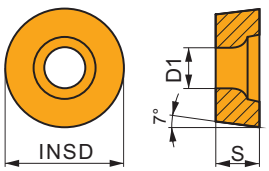
ECMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18



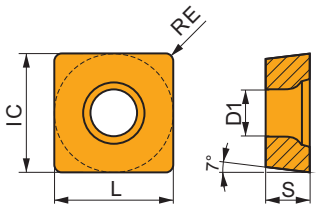
RCMW

	INSD (mm)	D1 (mm)	S (mm)
0602	6.000	2.80	2.38
0803	8.000	3.40	3.18
10T3	10.000	4.40	3.97
1204	12.000	4.40	4.76



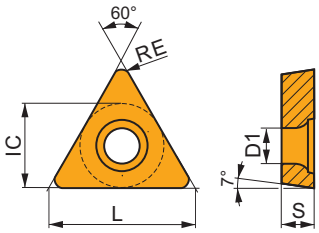
SCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



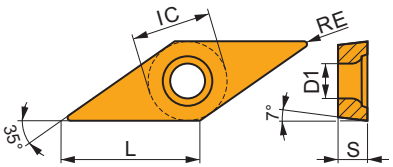
TCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



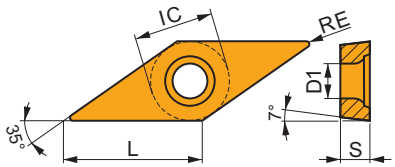
VCGW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18

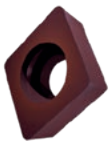
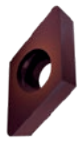


VCMW

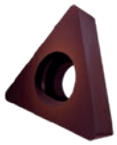
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76

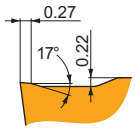
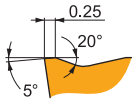


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

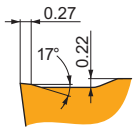
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
	.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																			
CCMW 060202:T5305	●	0.2	–	–	–	–	–	–	230	0.08	2.0	–	–	–	–	–	–	45	0.08	0.2
CCMW 060204:T5305	●	0.4	–	–	–	–	–	–	230	0.10	2.0	–	–	–	–	–	–	45	0.10	0.3
CCMW 060204:T5315	●	0.4	–	–	–	–	–	–	195	0.10	2.0	–	–	–	–	–	–	40	0.10	0.3
CCMW 060204:T6310	●	0.4	–	–	–	–	–	–	95	0.10	2.0	–	–	–	–	–	–	20	0.10	0.3
CCMW 060204:T8415	●	0.4	–	–	–	–	–	–	145	0.10	2.0	–	–	–	–	–	–	25	0.10	0.3
CCMW 09T304:T5305	●	0.4	–	–	–	–	–	–	215	0.10	3.0	–	–	–	–	–	–	45	0.10	0.3
CCMW 09T304:T5315	●	0.4	–	–	–	–	–	–	190	0.10	3.0	–	–	–	–	–	–	40	0.10	0.3
CCMW 09T304:T6310	●	0.4	–	–	–	–	–	–	95	0.10	3.0	–	–	–	–	–	–	20	0.10	0.3
CCMW 09T304:T8415	●	0.4	–	–	–	–	–	–	135	0.10	3.0	–	–	–	–	–	–	25	0.10	0.3
CCMW 09T308:T5305	●	0.8	–	–	–	–	–	–	200	0.20	3.0	–	–	–	–	–	–	40	0.11	0.7
CCMW 09T308:T5315	⊜	0.8	–	–	–	–	–	–	180	0.20	3.0	–	–	–	–	–	–	35	0.11	0.7
CCMW 09T308:T6310	⊜	0.8	–	–	–	–	–	–	90	0.20	3.0	–	–	–	–	–	–	20	0.11	0.7
CCMW 09T308:T8415	⊜	0.8	–	–	–	–	–	–	135	0.20	3.0	–	–	–	–	–	–	25	0.11	0.7
CCMW 120404:T5305	●	0.4	–	–	–	–	–	–	210	0.10	4.0	–	–	–	–	–	–	45	0.10	0.3
CCMW 120404:T5315	●	0.4	–	–	–	–	–	–	185	0.10	4.0	–	–	–	–	–	–	35	0.10	0.3
CCMW 120408:T5305	●	0.8	–	–	–	–	–	–	195	0.20	4.0	–	–	–	–	–	–	40	0.11	0.7
CCMW 120408:T5315	⊜	0.8	–	–	–	–	–	–	175	0.20	4.0	–	–	–	–	–	–	35	0.11	0.7
	.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																			
DCMW 070202:T5305	●	0.2	–	–	–	–	–	–	200	0.08	0.8	–	–	–	–	–	–	40	0.08	0.2
DCMW 070204:T5305	●	0.4	–	–	–	–	–	–	195	0.10	0.8	–	–	–	–	–	–	40	0.10	0.3
DCMW 070204:T6310	●	0.4	–	–	–	–	–	–	85	0.10	0.8	–	–	–	–	–	–	20	0.10	0.3
DCMW 070204:T8415	●	0.4	–	–	–	–	–	–	125	0.10	0.8	–	–	–	–	–	–	20	0.10	0.3
DCMW 11T304:T5305	●	0.4	–	–	–	–	–	–	190	0.10	1.2	–	–	–	–	–	–	40	0.10	0.3
DCMW 11T304:T5315	●	0.4	–	–	–	–	–	–	165	0.10	1.2	–	–	–	–	–	–	35	0.10	0.3
DCMW 11T304:T6310	●	0.4	–	–	–	–	–	–	80	0.10	1.2	–	–	–	–	–	–	20	0.10	0.3
DCMW 11T304:T8415	●	0.4	–	–	–	–	–	–	120	0.10	1.2	–	–	–	–	–	–	20	0.10	0.3
DCMW 11T308:T5305	●	0.8	–	–	–	–	–	–	185	0.18	1.2	–	–	–	–	–	–	35	0.11	0.7
DCMW 11T308:T5315	●	0.8	–	–	–	–	–	–	160	0.18	1.2	–	–	–	–	–	–	30	0.11	0.7
DCMW 11T308:T6310	●	0.8	–	–	–	–	–	–	80	0.18	1.2	–	–	–	–	–	–	20	0.11	0.7
DCMW 11T308:T8415	●	0.8	–	–	–	–	–	–	125	0.18	1.2	–	–	–	–	–	–	20	0.11	0.7
	.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																			
ECMW 060204:H07	●	0.4	–	–	–	–	–	–	100	0.10	2.0	–	–	–	–	–	–	–	–	–
ECMW 080304:H07	●	0.4	–	–	–	–	–	–	100	0.10	2.5	–	–	–	–	–	–	–	–	–
	.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																			
RCMW 0602M0:T5305	⊜	–	–	–	–	–	–	–	280	0.25	0.6	–	–	–	–	–	–	55	0.17	0.4
RCMW 0602M0:T5315	⊜	–	–	–	–	–	–	–	250	0.25	0.6	–	–	–	–	–	–	50	0.17	0.4
RCMW 0803M0:T5305	⊜	–	–	–	–	–	–	–	255	0.30	0.8	–	–	–	–	–	–	50	0.17	0.5
RCMW 0803M0:T5315	⊜	–	–	–	–	–	–	–	230	0.30	0.8	–	–	–	–	–	–	45	0.17	0.5
RCMW 10T3M0:T5305	⊜	–	–	–	–	–	–	–	225	0.40	1.0	–	–	–	–	–	–	45	0.20	0.7
RCMW 10T3M0:T5315	⊜	–	–	–	–	–	–	–	200	0.40	1.0	–	–	–	–	–	–	40	0.20	0.7
RCMW 1204M0:T5305	⊜	–	–	–	–	–	–	–	205	0.45	1.2	–	–	–	–	–	–	40	0.20	0.8

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。

Product		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)
.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
SCMW 09T304:T5305	●	0.4	–	–	–	–	–	–	240	0.10	2.0	–	–	–	–	–	–	50	0.10	0.3
SCMW 09T304:T5315	●	0.4	–	–	–	–	–	–	205	0.10	2.0	–	–	–	–	–	–	40	0.10	0.3
SCMW 09T308:T5305	●	0.8	–	–	–	–	–	–	220	0.20	2.0	–	–	–	–	–	–	45	0.11	0.7
SCMW 09T308:T5315	⬌	0.8	–	–	–	–	–	–	190	0.20	2.0	–	–	–	–	–	–	40	0.11	0.7
SCMW 120408:T5305	●	0.8	–	–	–	–	–	–	205	0.20	4.0	–	–	–	–	–	–	40	0.11	0.7
SCMW 120408:T5315	⬌	0.8	–	–	–	–	–	–	185	0.20	4.0	–	–	–	–	–	–	35	0.11	0.7
																				
.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
TCMW 110204:T5305	●	0.4	–	–	–	–	–	–	200	0.10	1.2	–	–	–	–	–	–	40	0.10	0.3
TCMW 110204:T5315	●	0.4	–	–	–	–	–	–	180	0.10	1.2	–	–	–	–	–	–	35	0.10	0.3
TCMW 16T304:T5305	●	0.4	–	–	–	–	–	–	195	0.10	1.5	–	–	–	–	–	–	40	0.10	0.3
TCMW 16T304:T5315	●	0.4	–	–	–	–	–	–	175	0.10	1.5	–	–	–	–	–	–	35	0.10	0.3
TCMW 16T308:T5305	●	0.8	–	–	–	–	–	–	190	0.18	1.5	–	–	–	–	–	–	40	0.11	0.7
TCMW 16T308:T5315	●	0.8	–	–	–	–	–	–	165	0.18	1.5	–	–	–	–	–	–	35	0.11	0.7
TCMW 16T308:T6310	●	0.8	–	–	–	–	–	–	85	0.18	1.5	–	–	–	–	–	–	20	0.11	0.7
TCMW 16T308:T8415	⬌	0.8	–	–	–	–	–	–	125	0.18	1.5	–	–	–	–	–	–	20	0.11	0.7
.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
VCGW 130302:T5305	●	0.2	–	–	–	–	–	–	170	0.08	1.3	–	–	–	–	–	–	35	0.08	0.2
VCGW 130304:T5305	●	0.4	–	–	–	–	–	–	165	0.10	1.3	–	–	–	–	–	–	35	0.10	0.3
.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
VCMW 110302:T5305	●	0.2	–	–	–	–	–	–	170	0.08	1.2	–	–	–	–	–	–	35	0.08	0.2
VCMW 110304:T5305	●	0.4	–	–	–	–	–	–	165	0.10	1.2	–	–	–	–	–	–	35	0.10	0.3
VCMW 110304:T6310	●	0.4	–	–	–	–	–	–	70	0.10	1.2	–	–	–	–	–	–	15	0.10	0.3
VCMW 110304:T8415	●	0.4	–	–	–	–	–	–	105	0.10	1.2	–	–	–	–	–	–	20	0.10	0.3
VCMW 160404:T5305	●	0.4	–	–	–	–	–	–	165	0.10	1.5	–	–	–	–	–	–	35	0.10	0.3
VCMW 160404:T6310	●	0.4	–	–	–	–	–	–	70	0.10	1.5	–	–	–	–	–	–	15	0.10	0.3
VCMW 160404:T8415	●	0.4	–	–	–	–	–	–	100	0.10	1.5	–	–	–	–	–	–	15	0.10	0.3
VCMW 160408:T5305	●	0.8	–	–	–	–	–	–	155	0.18	1.5	–	–	–	–	–	–	30	0.11	0.7
VCMW 160408:T5315	●	0.8	–	–	–	–	–	–	135	0.18	1.5	–	–	–	–	–	–	25	0.11	0.7
VCMW 160408:T6310	●	0.8	–	–	–	–	–	–	70	0.18	1.5	–	–	–	–	–	–	15	0.11	0.7
VCMW 160408:T8415	●	0.8	–	–	–	–	–	–	100	0.18	1.5	–	–	–	–	–	–	15	0.11	0.7

RM			RM 型断屑槽坚固耐用，是钢和铸铁粗加工的首选。它具有正前角和稳定开放的 T 倒棱。它还适用于不锈钢，并有条件地适用于超级合金和硬质材料。
RM3			RM3 断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。具有正前角和宽的T-型倒棱。也有条件地适用于不锈钢和硬质材料。

RM

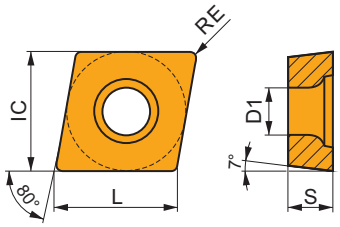


RM 型断屑槽坚固耐用，是钢和铸铁粗加工的首选。它具有正前角和稳定开放的 T 倒棱。它还适用于不锈钢，并有条件地适用于超级合金和硬质材料。

PRAMET

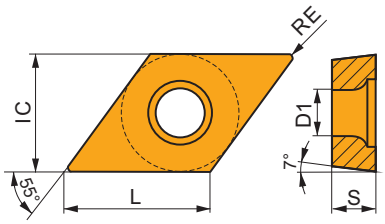
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



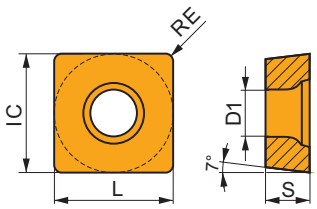
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



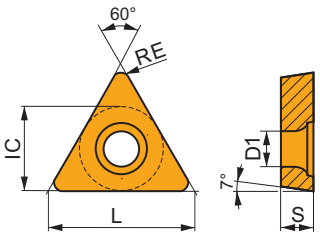
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



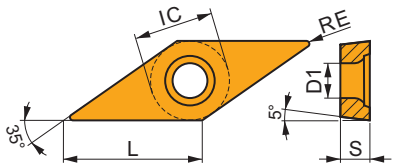
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

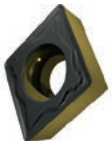


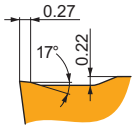
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	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。





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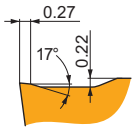
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CCMT 09T304E-RM:T5305	●	0.4	260	0.25	2.2	–	–	–	245	0.25	2.2	–	–	–	–	–	–	50	0.18	0.3
CCMT 09T304E-RM:T5315	●	0.4	235	0.25	2.2	–	–	–	220	0.25	2.2	–	–	–	–	–	–	45	0.18	0.3
CCMT 09T304E-RM:T7335	●	0.4	160	0.25	2.2	120	0.23	2.2	–	–	–	–	–	–	50	0.18	1.8	–	–	–
CCMT 09T304E-RM:T8430	●	0.4	155	0.25	2.2	85	0.23	2.2	130	0.25	2.2	–	–	–	30	0.18	1.8	25	0.18	0.3
CCMT 09T304E-RM:T9325	●	0.4	195	0.25	2.2	115	0.23	2.2	185	0.25	2.2	–	–	–	40	0.18	1.8	–	–	–
CCMT 09T304E-RM:T9415	●	0.4	255	0.25	2.2	–	–	–	240	0.25	2.2	–	–	–	–	–	–	50	0.18	0.3
CCMT 09T308E-RM:T5305	●	0.8	290	0.30	2.2	–	–	–	275	0.30	2.2	–	–	–	–	–	–	55	0.15	0.7
CCMT 09T308E-RM:T5315	⊛	0.8	265	0.30	2.2	–	–	–	250	0.30	2.2	–	–	–	–	–	–	50	0.15	0.7
CCMT 09T308E-RM:T7335	⊛	0.8	175	0.30	2.2	135	0.27	2.2	–	–	–	–	–	–	55	0.24	1.8	–	–	–
CCMT 09T308E-RM:T8430	⊛	0.8	180	0.30	2.2	95	0.27	2.2	145	0.30	2.2	–	–	–	35	0.24	1.8	30	0.15	0.7
CCMT 09T308E-RM:T9325	⊛	0.8	215	0.30	2.2	125	0.27	2.2	200	0.30	2.2	–	–	–	45	0.24	1.8	–	–	–
CCMT 09T308E-RM:T9415	⊛	0.8	285	0.30	2.2	–	–	–	270	0.30	2.2	–	–	–	–	–	–	55	0.15	0.7
CCMT 120408E-RM:T5305	●	0.8	290	0.30	2.7	–	–	–	275	0.30	2.7	–	–	–	–	–	–	55	0.15	0.7
CCMT 120408E-RM:T5315	⊛	0.8	260	0.30	2.7	–	–	–	245	0.30	2.7	–	–	–	–	–	–	50	0.15	0.7
CCMT 120408E-RM:T7335	⊛	0.8	175	0.30	2.7	135	0.27	2.7	–	–	–	–	–	–	55	0.24	2.2	–	–	–
CCMT 120408E-RM:T8430	⊛	0.8	175	0.30	2.7	95	0.27	2.7	140	0.30	2.7	–	–	–	35	0.24	2.2	30	0.15	0.7
CCMT 120408E-RM:T9325	⊛	0.8	210	0.30	2.7	125	0.27	2.7	195	0.30	2.7	–	–	–	45	0.24	2.2	–	–	–
CCMT 120408E-RM:T9415	⊛	0.8	280	0.30	2.7	–	–	–	265	0.30	2.7	–	–	–	–	–	–	55	0.15	0.7
CCMT 120412E-RM:T8430	⊛	1.2	180	0.33	2.7	95	0.30	2.7	145	0.33	2.7	–	–	–	35	0.23	2.2	30	0.17	1.0
CCMT 120412E-RM:T9325	⊛	1.2	215	0.33	2.7	125	0.30	2.7	200	0.33	2.7	–	–	–	45	0.23	2.2	–	–	–
CCMT 120412E-RM:T9415	⊛	1.2	280	0.33	2.7	–	–	–	265	0.33	2.7	–	–	–	–	–	–	55	0.17	1.0



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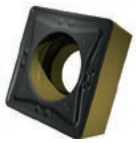
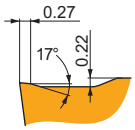
DCMT 11T304E-RM:T5305	●	0.4	250	0.20	1.0	–	–	–	235	0.20	1.0	–	–	–	–	–	–	50	0.14	0.3
DCMT 11T304E-RM:T5315	●	0.4	220	0.20	1.0	–	–	–	205	0.20	1.0	–	–	–	–	–	–	40	0.14	0.3
DCMT 11T304E-RM:T7335	●	0.4	145	0.20	1.0	110	0.18	1.0	–	–	–	–	–	–	45	0.14	0.8	–	–	–
DCMT 11T304E-RM:T8430	●	0.4	150	0.20	1.0	80	0.18	1.0	125	0.20	1.0	–	–	–	30	0.14	0.8	25	0.14	0.3
DCMT 11T304E-RM:T9325	●	0.4	185	0.20	1.0	110	0.18	1.0	175	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
DCMT 11T304E-RM:T9415	●	0.4	235	0.20	1.0	–	–	–	220	0.20	1.0	–	–	–	–	–	–	45	0.14	0.3
DCMT 11T308E-RM:T5305	●	0.8	270	0.27	0.8	–	–	–	255	0.27	0.8	–	–	–	–	–	–	50	0.14	0.7
DCMT 11T308E-RM:T5315	●	0.8	240	0.27	0.8	–	–	–	225	0.27	0.8	–	–	–	–	–	–	45	0.14	0.7
DCMT 11T308E-RM:T7335	●	0.8	165	0.27	0.8	125	0.24	0.8	–	–	–	–	–	–	50	0.19	0.6	–	–	–
DCMT 11T308E-RM:T8430	⊛	0.8	165	0.27	0.8	90	0.24	0.8	135	0.27	0.8	–	–	–	35	0.19	0.6	25	0.14	0.7
DCMT 11T308E-RM:T9325	●	0.8	200	0.27	0.8	120	0.24	0.8	190	0.27	0.8	–	–	–	45	0.19	0.6	–	–	–
DCMT 11T308E-RM:T9415	●	0.8	255	0.27	1.0	–	–	–	240	0.27	1.0	–	–	–	–	–	–	50	0.14	0.7
DCMT 11T312E-RM:T8430	⊛	1.2	170	0.27	1.2	90	0.24	1.2	135	0.27	1.2	–	–	–	35	0.19	1.2	25	0.14	0.9
DCMT 11T312E-RM:T9315	●	1.2	225	0.27	1.2	–	–	–	210	0.27	1.2	–	–	–	–	–	–	45	0.14	0.9
DCMT 11T312E-RM:T9325	⊛	1.2	200	0.27	1.2	120	0.24	1.2	190	0.27	1.2	–	–	–	45	0.19	1.2	–	–	–
DCMT 11T312E-RM:T9415	●	1.2	260	0.27	1.2	–	–	–	245	0.27	1.2	–	–	–	–	–	–	50	0.14	0.9
DCMT 150408E-RM:T8430	⊛	0.8	150	0.27	1.9	80	0.24	1.9	125	0.27	1.9	–	–	–	30	0.22	1.5	25	0.14	0.7
DCMT 150408E-RM:T9325	●	0.8	180	0.27	1.9	105	0.24	1.9	170	0.27	1.9	–	–	–	40	0.22	1.5	–	–	–
DCMT 150408E-RM:T9415	●	0.8	235	0.27	1.9	–	–	–	220	0.27	1.9	–	–	–	–	–	–	45	0.14	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。

Product		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)
 																				
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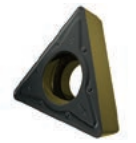
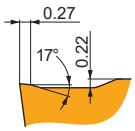
SCMT 09T308E-RM:T5315	⇕	0.8	◪	275	0.30	2.0		–	–	–	■	260	0.30	2.0		–	–	–		–	–	–	◪	55	0.15	0.7
SCMT 09T308E-RM:T7335	⇕	0.8	◪	190	0.30	2.0	■	145	0.27	2.0		–	–	–		–	–	–	◪	60	0.24	1.6		–	–	–
SCMT 09T308E-RM:T8430	⇕	0.8	■	190	0.30	2.0	■	105	0.27	2.0	◪	155	0.30	2.0		–	–	–	◪	40	0.24	1.6	◪	30	0.15	0.7
SCMT 09T308E-RM:T9325	⇕	0.8	■	230	0.30	2.0	■	135	0.27	2.0	◪	215	0.30	2.0		–	–	–	◪	50	0.24	1.6		–	–	–
SCMT 09T308E-RM:T9415	⇕	0.8	■	295	0.30	2.0		–	–	–	◪	280	0.30	2.0		–	–	–		–	–	–	◪	55	0.15	0.7
SCMT 120408E-RM:T5305	●	0.8	◪	305	0.30	2.3		–	–	–	■	285	0.30	2.3		–	–	–		–	–	–	◪	60	0.15	0.7
SCMT 120408E-RM:T5315	⇕	0.8	◪	275	0.30	2.3		–	–	–	■	260	0.30	2.3		–	–	–		–	–	–	◪	55	0.15	0.7
SCMT 120408E-RM:T7335	⇕	0.8	◪	185	0.30	2.3	■	140	0.27	2.3		–	–	–		–	–	–	◪	60	0.24	1.8		–	–	–
SCMT 120408E-RM:T8430	⇕	0.8	■	190	0.30	2.3	■	105	0.27	2.3	◪	155	0.30	2.3		–	–	–	◪	40	0.24	1.8	◪	30	0.15	0.7
SCMT 120408E-RM:T9325	⇕	0.8	■	225	0.30	2.3	■	135	0.27	2.3	◪	210	0.30	2.3		–	–	–	◪	50	0.24	1.8		–	–	–
SCMT 120408E-RM:T9415	⇕	0.8	■	295	0.30	2.3		–	–	–	◪	280	0.30	2.3		–	–	–		–	–	–	◪	55	0.15	0.7
 																				
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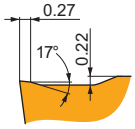
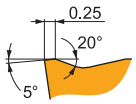
TCMT 16T308E-RM:T5305	●	0.8	◪	265	0.27	1.9		–	–	–	■	250	0.27	1.9		–	–	–		–	–	–	◪	50	0.14	0.7
TCMT 16T308E-RM:T5315	●	0.8	◪	235	0.27	1.9		–	–	–	■	220	0.27	1.9		–	–	–		–	–	–	◪	45	0.14	0.7
TCMT 16T308E-RM:T7335	●	0.8	◪	155	0.27	1.9	■	120	0.24	1.9		–	–	–		–	–	–	◪	50	0.19	1.5		–	–	–
TCMT 16T308E-RM:T8430	⇕	0.8	■	165	0.27	1.9	■	90	0.24	1.9	◪	135	0.27	1.9		–	–	–	◪	35	0.19	1.5	◪	25	0.14	0.7
TCMT 16T308E-RM:T9325	●	0.8	■	195	0.27	1.9	■	115	0.24	1.9	◪	185	0.27	1.9		–	–	–	◪	40	0.19	1.5		–	–	–
TCMT 16T308E-RM:T9415	●	0.8	■	250	0.27	1.9		–	–	–	◪	235	0.27	1.9		–	–	–		–	–	–	◪	50	0.14	0.7
TCMT 16T312E-RM:T5305	●	1.2	◪	280	0.27	1.9		–	–	–	■	265	0.27	1.9		–	–	–		–	–	–	◪	55	0.14	0.9
TCMT 16T312E-RM:T5315	●	1.2	◪	250	0.27	1.9		–	–	–	■	235	0.27	1.9		–	–	–		–	–	–	◪	50	0.14	0.9
TCMT 16T312E-RM:T8430	⇕	1.2	■	170	0.27	1.9	■	90	0.24	1.9	◪	135	0.27	1.9		–	–	–	◪	35	0.19	1.5	◪	25	0.14	0.9
TCMT 16T312E-RM:T9325	⇕	1.2	■	205	0.27	1.9	■	120	0.24	1.9	◪	190	0.27	1.9		–	–	–	◪	45	0.19	1.5		–	–	–
TCMT 16T312E-RM:T9415	⇕	1.2	■	265	0.27	1.9		–	–	–	◪	250	0.27	1.9		–	–	–		–	–	–	◪	50	0.14	0.9
																				
RM 型断屑槽坚固耐用，是钢和铸铁粗加工的首选。它具有正前角和稳定开放的T 倒棱。它还适用于不锈钢，并有条件地适用于超级合金和硬质材料。																				
VBMT 160404E-RM:T5305	●	0.4	◪	270	0.12	1.2		–	–	–	■	255	0.12	1.2		–	–	–		–	–	–	◪	50	0.12	0.3
VBMT 160404E-RM:T5315	●	0.4	◪	235	0.12	1.2		–	–	–	■	220	0.12	1.2		–	–	–		–	–	–	◪	45	0.12	0.3
VBMT 160404E-RM:T7335	●	0.4	◪	140	0.18	1.2	■	105	0.16	1.2		–	–	–		–	–	–	◪	45	0.16	1.0		–	–	–
VBMT 160404E-RM:T8430	●	0.4	■	170	0.12	1.2	■	90	0.11	1.2	◪	135	0.12	1.2		–	–	–	◪	35	0.11	1.0	◪	25	0.12	0.3
VBMT 160404E-RM:T9325	●	0.4	■	170	0.20	1.2	■	100	0.18	1.2	◪	160	0.20	1.2		–	–	–	◪	35	0.18	1.0		–	–	–
VBMT 160404E-RM:T9415	●	0.4	■	255	0.12	1.2		–	–	–	◪	240	0.12	1.2		–	–	–		–	–	–	◪	50	0.12	0.3
VBMT 160408E-RM:T5305	●	0.8	◪	285	0.17	1.2		–	–	–	■	270	0.17	1.2		–	–	–		–	–	–	◪	55	0.11	0.7
VBMT 160408E-RM:T5315	●	0.8	◪	250	0.17	1.2		–	–	–	■	235	0.17	1.2		–	–	–		–	–	–	◪	50	0.11	0.7
VBMT 160408E-RM:T7335	●	0.8	◪	155	0.20	1.2	■	120	0.18	1.2		–	–	–		–	–	–	◪	50	0.18	1.0		–	–	–
VBMT 160408E-RM:T8430	●	0.8	■	175	0.17	1.2	■	95	0.15	1.2	◪	140	0.17	1.2		–	–	–	◪	35	0.12	1.0	◪	30	0.11	0.7
VBMT 160408E-RM:T9325	●	0.8	■	200	0.20	1.2	■	120	0.18	1.2	◪	190	0.20	1.2		–	–	–	◪	45	0.18	1.0		–	–	–
VBMT 160408E-RM:T9415	●	0.8	■	270	0.17	1.2		–	–	–	◪	255	0.17	1.2		–	–	–		–	–	–	◪	50	0.12	0.7
VBMT 160412E-RM:T7335	●	1.2	◪	150	0.27	1.2	■	115	0.24	1.2		–	–	–		–	–	–	◪	45	0.19	1.0		–	–	–
VBMT 160412E-RM:T8430	⇕	1.2	■	155	0.27	1.2	■	85	0.24	1.2	◪	130	0.27	1.2		–	–	–	◪	30	0.19	1.0	◪	25	0.14	0.9
VBMT 160412E-RM:T9325	●	1.2	■	185	0.27	1.2	■	110	0.24	1.2	◪	175	0.27	1.2		–	–	–	◪	40	0.19	1.0		–	–	–
VBMT 160412E-RM:T9415	●	1.2	■	240	0.27	1.2		–	–	–	◪	225	0.27	1.2		–	–	–		–	–	–	◪	45	0.14	0.9

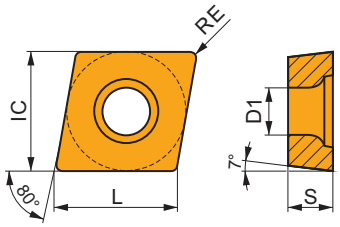
RM3



RM3 断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。具有正前角和宽的T-型倒棱。也有条件地适用于不锈钢和硬质材料。

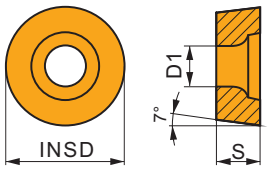
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.50	12.90	4.76



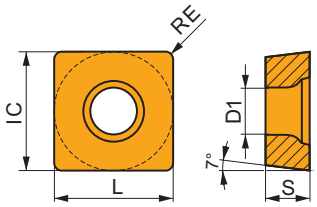
RCMT

	INSD (mm)	D1 (mm)	S (mm)
0803	8.000	3.40	3.18
1204	12.000	4.40	4.76
1606	16.000	5.50	6.35



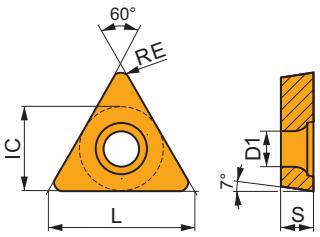
SCMT

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

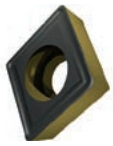
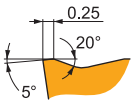
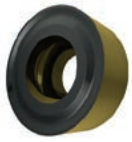
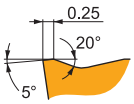
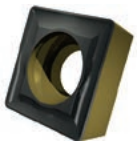
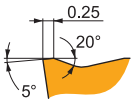
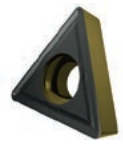
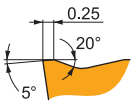


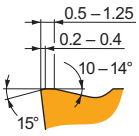
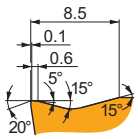
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

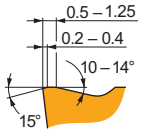


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
 																				
RM3 断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。具有正前角和宽的T-型倒棱。也有条件地适用于不锈钢和硬质材料。																				
CCMT 120404E-RM3:T9325	●	0.4	165	0.25	2.5	95	0.25	2.5	155	0.25	2.5	–	–	–	–	–	–	–	–	–
CCMT 120404E-RM3:T9415	●	0.4	215	0.25	2.5	–	–	–	200	0.25	2.5	–	–	–	–	–	–	40	0.13	0.3
CCMT 120408E-RM3:T6310	⬌	0.8	145	0.27	2.5	100	0.27	2.5	115	0.27	2.5	–	–	–	–	–	–	25	0.14	0.7
CCMT 120408E-RM3:T9325	⬌	0.8	195	0.27	2.5	115	0.27	2.5	185	0.27	2.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-RM3:T9415	●	0.8	250	0.27	2.5	–	–	–	235	0.27	2.5	–	–	–	–	–	–	50	0.14	0.7
CCMT 120412E-RM3:T9415	⬌	1.2	255	0.30	2.5	–	–	–	240	0.30	2.5	–	–	–	–	–	–	50	0.15	1.0
 																				
RM3 断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。具有正前角和宽的T-型倒棱。也有条件地适用于不锈钢和硬质材料。																				
RCMT 0803M0E-RM3:T9415	⬌	–	275	0.50	1.3	–	–	–	260	0.50	1.3	–	–	–	–	–	–	55	0.25	0.5
RCMT 1204M0E-RM3:H07	⬌	–	–	–	–	65	0.54	1.8	105	0.60	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-RM3:T7325	⬌	–	165	0.60	1.8	125	0.54	1.8	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-RM3:T8430	✱	–	150	0.60	1.8	80	0.54	1.8	125	0.60	1.8	–	–	–	–	–	–	25	0.30	0.8
RCMT 1204M0E-RM3:T9415	⬌	–	255	0.60	1.8	–	–	–	240	0.60	1.8	–	–	–	–	–	–	50	0.30	0.8
RCMT 1606M0E-RM3:T7325	⬌	–	160	0.65	2.0	120	0.59	2.0	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1606M0E-RM3:T8430	✱	–	145	0.65	2.0	80	0.59	2.0	120	0.65	2.0	–	–	–	–	–	–	25	0.33	1.1
RCMT 1606M0E-RM3:T9415	⬌	–	245	0.65	2.0	–	–	–	230	0.65	2.0	–	–	–	–	–	–	45	0.33	1.1
 																				
RM3 断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。具有正前角和宽的T-型倒棱。也有条件地适用于不锈钢和硬质材料。																				
SCMT 120408E-RM3:T8430	⬌	0.8	170	0.27	2.3	90	0.27	2.3	135	0.27	2.3	–	–	–	–	–	–	25	0.14	0.7
SCMT 120408E-RM3:T9325	⬌	0.8	205	0.27	2.3	120	0.27	2.3	190	0.27	2.3	–	–	–	–	–	–	–	–	–
SCMT 120408E-RM3:T9335	⬌	0.8	175	0.27	2.3	105	0.27	2.3	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-RM3:T9415	⬌	0.8	265	0.27	2.3	–	–	–	250	0.27	2.3	–	–	–	–	–	–	50	0.14	0.7
SCMT 120412E-RM3:T9325	⬌	1.2	205	0.30	2.3	120	0.27	2.3	190	0.30	2.3	–	–	–	–	–	–	–	–	–
 																				
RM3 断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。具有正前角和宽的T-型倒棱。也有条件地适用于不锈钢和硬质材料。																				
TCMT 16T304E-RM3:T6310	●	0.4	115	0.20	2.0	80	0.20	2.0	90	0.20	2.0	–	–	–	–	–	–	20	0.14	0.3
TCMT 16T304E-RM3:T8415	●	0.4	150	0.20	2.0	75	0.20	2.0	135	0.20	2.0	–	–	–	–	–	–	25	0.14	0.3
TCMT 16T304E-RM3:T8430	●	0.4	130	0.20	2.0	70	0.20	2.0	105	0.20	2.0	–	–	–	–	–	–	20	0.14	0.3
TCMT 16T304E-RM3:T9325	●	0.4	145	0.25	2.0	85	0.25	2.0	135	0.25	2.0	–	–	–	–	–	–	–	–	–
TCMT 16T304E-RM3:T9335	●	0.4	125	0.25	2.0	75	0.25	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T304E-RM3:T9415	●	0.4	205	0.20	2.0	–	–	–	190	0.20	2.0	–	–	–	–	–	–	40	0.14	0.3
TCMT 16T308E-RM3:T6310	●	0.8	125	0.27	2.0	90	0.27	2.0	100	0.27	2.0	–	–	–	–	–	–	25	0.14	0.7
TCMT 16T308E-RM3:T8415	●	0.8	160	0.27	2.0	85	0.27	2.0	145	0.27	2.0	–	–	–	–	–	–	25	0.14	0.7
TCMT 16T308E-RM3:T8430	⬌	0.8	135	0.27	2.0	75	0.27	2.0	110	0.27	2.0	–	–	–	–	–	–	20	0.14	0.7
TCMT 16T308E-RM3:T9325	●	0.8	170	0.27	2.0	100	0.27	2.0	160	0.27	2.0	–	–	–	–	–	–	–	–	–
TCMT 16T308E-RM3:T9335	●	0.8	145	0.27	2.0	85	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-RM3:T9415	●	0.8	220	0.27	2.0	–	–	–	205	0.27	2.0	–	–	–	–	–	–	40	0.14	0.7

OR			OR 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于钢、铸铁和有条件的超级合金。
DR4			DR4 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于粗加工至重载粗加工，连续切削至断续切削。它还适用于铸铁，并有条件地适用于不锈钢。

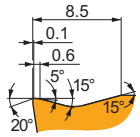
OR



OR 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于钢、铸铁和有条件的超级合金。

PRAMET

DR4

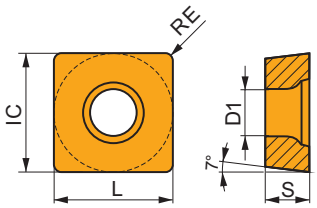


DR4 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于粗加工至重载粗加工，连续切削至断续切削。它还适用于铸铁，并有条件地适用于不锈钢。

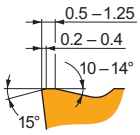
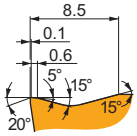
PRAMET

SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2509	25.400	8.70	25.40	9.53
3809	38.100	8.70	38.10	9.53



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。

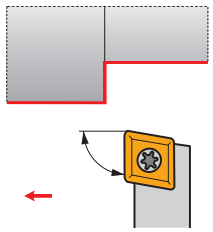
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
OR 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于钢、铸铁和有条件的超级合金。																				
SCMT 250924E-OR:T9226		2.4	80	1.00	10.0	45	0.90	10.0	75	1.00	10.0	–	–	–	15	0.70	8.0	–	–	–
SCMT 250924E-OR:T9325		2.4	90	1.00	10.0	50	0.90	10.0	85	1.00	10.0	–	–	–	20	0.70	8.0	–	–	–
SCMT 250924E-OR:T9335		2.4	70	1.00	10.0	40	0.90	10.0	–	–	–	–	–	–	15	0.70	8.0	–	–	–
SCMT 380932E-OR:6635		3.2	60	1.20	18.0	35	1.08	18.0	–	–	–	–	–	–	15	1.08	9.9	–	–	–
SCMT 380932E-OR:T9315		3.2	85	1.20	18.0	–	–	–	80	1.20	18.0	–	–	–	–	–	–	–	–	–
SCMT 380932E-OR:T9325		3.2	80	1.20	18.0	45	1.08	18.0	75	1.20	18.0	–	–	–	15	1.08	9.9	–	–	–
SCMT 380932E-OR:T9335		3.2	60	1.20	18.0	35	1.08	18.0	–	–	–	–	–	–	10	1.08	9.9	–	–	–
																				
DR4 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于粗加工至重载粗加工，连续切削至断续切削。它还适用于铸铁，并有条件地适用于不锈钢。																				
SCMT 380932E-DR4:T9335		3.2	50	1.33	16.0	30	1.20	16.0	–	–	–	–	–	–	–	–	–	–	–	–

CC

ISO 外圆车削 – 导航工具

SCAC(RL) EXT 90°

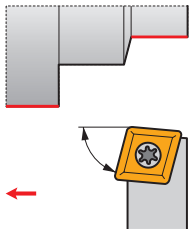
CC..



77

SCBC(RL) EXT 75°

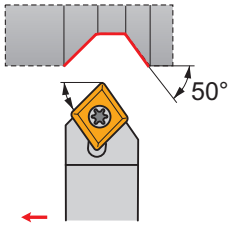
CC..



78

SCDCR EXT 45°

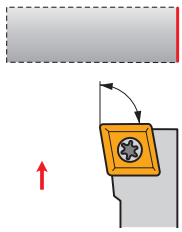
CC..



79

SCFC(RL) EXT 90°

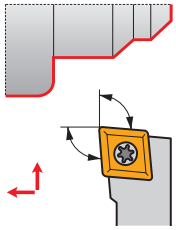
CC..



80

SCLC(RL) EXT 95°

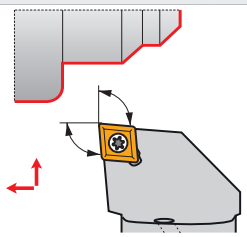
CC..



81

C.-SCLC(RL) EXT 95°

CC..



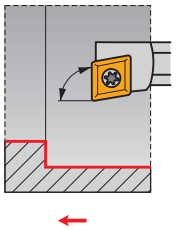
83

CC

ISO内孔车削 – 导航工具

SCFC(RL) INT 90°

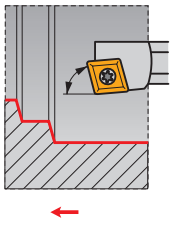
CC..



84

SCKC(RL) INT 75°

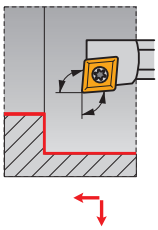
CC..



85

SCLC(RL) INT 45°

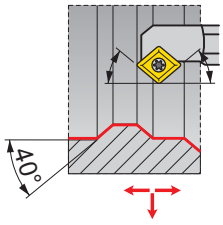
CC..



86

SCXC(RL) INT 90°

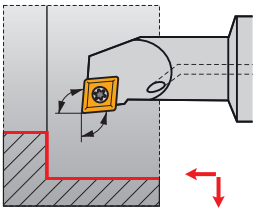
CC..



88

C.-SCLC(RL) INT 95°

CC..



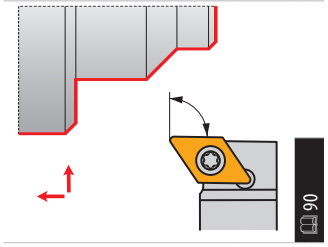
89

DC

ISO 外圆车削 – 导航工具

SDFC(RL) EXT 91°

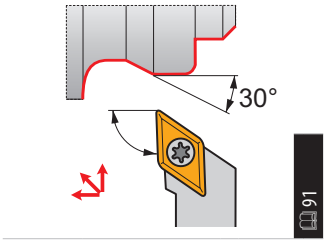
DC..



90

SDJC(RL) EXT 93°

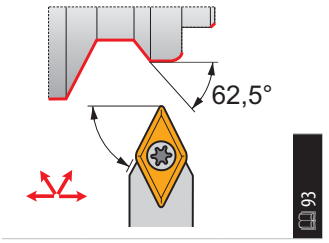
DC..



91

SDNCN EXT 62°30´

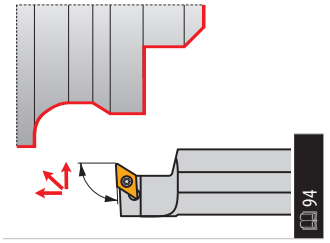
DC..



93

SDUCL EXT 93°

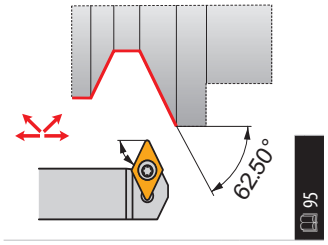
DC..



94

SDXC(RL) EXT 62°30´

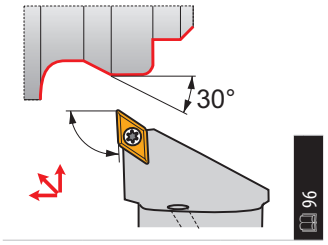
DC..



95

C.-SDJC(RL) EXT 93°

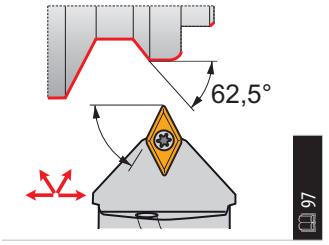
DC..



96

C.-SDNCN EXT 62°30´

DC..



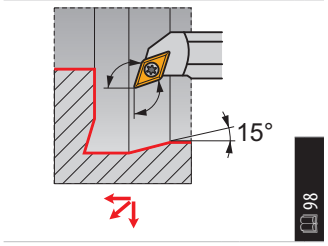
97

DC

ISO内孔车削 – 导航工具

SDQC(RL) INT 95°

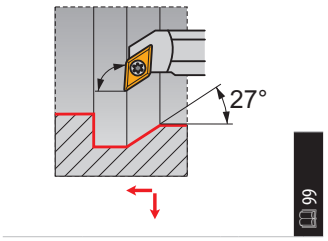
DC..



98

SDUC(RL) INT 93°

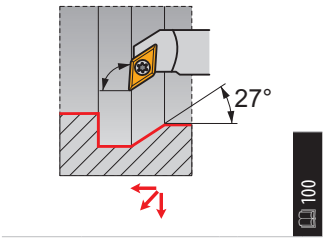
DC..



99

SDUC(RL)-E INT 62°30´

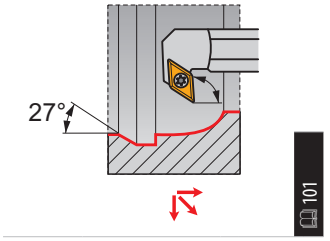
DC..



100

SDZC(RL) INT 90°

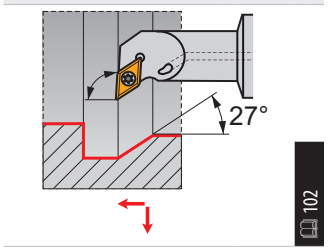
DC..



101

C.-SDUC(RL) INT 93°

DC..



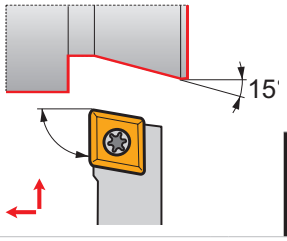
102

EC

ISO 外圆车削 – 导航工具

SEGC(RL) EXT 90°

EC..



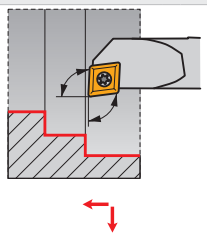
103

EC

ISO内孔车削 – 导航工具

SEUC(RL) INT 93°

EC..



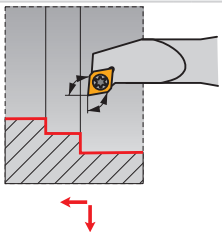
104

EP

ISO内孔车削 – 导航工具

SELP(RL) INT 95°

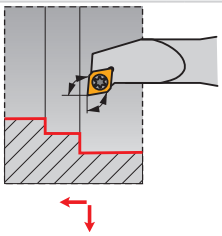
EP..



105

SELP(RL)-E INT 95°

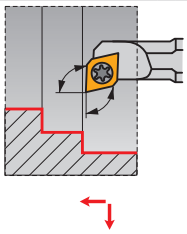
EP..



106

SEUP(RL) INT 93°

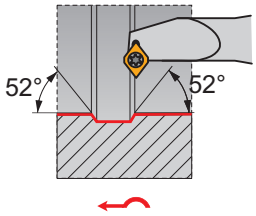
EP..



107

SEXP(RL) INT 52°30´

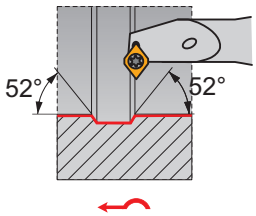
EP..



108

SEXP(RL)-E INT 52°30´

EP..



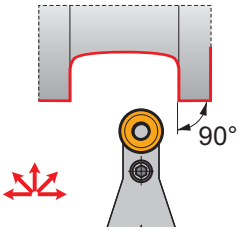
109

RC

ISO 外圆车削 – 导航工具

PRDCN EXT

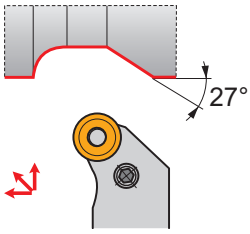
RC..



110

PRSC(RL) EXT

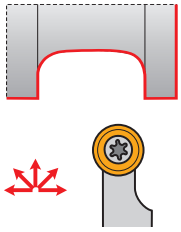
RC..



111

SRDC(RL) EXT

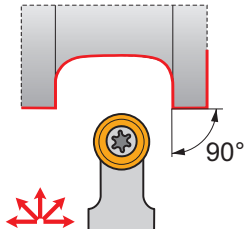
RC..



112

SRDCN EXT

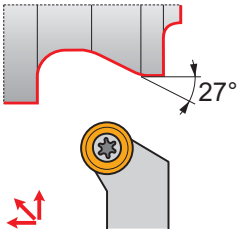
RC..



113

SRCS(RL) EXT

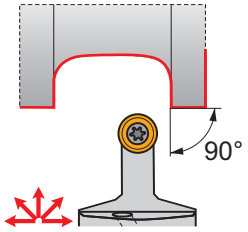
RC..



114

C.-SRDCN EXT

RC..



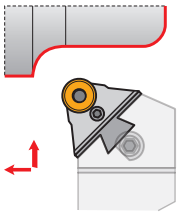
116

RC

ISO外圆重载车削 – 导航工具

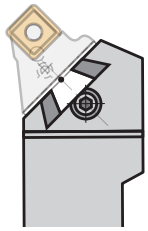
KHP-RSCR/L

RC..



117

DKH(RL)



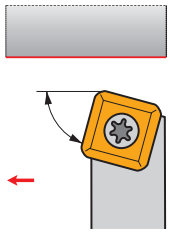
118

SC

ISO 外圆车削 – 导航工具

SSBC(RL) EXT 75°

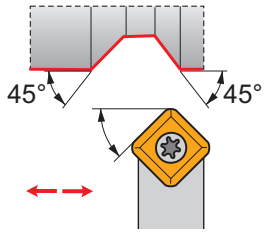
SC..



119

SSDCN EXT 45°

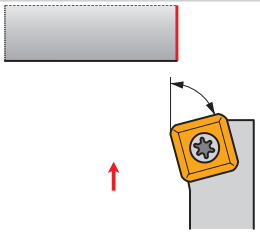
SC..



120

SSKC(RL) EXT 75°

SC..



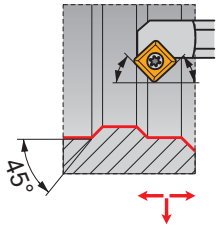
121

SC

ISO内孔车削 – 导航工具

SSSC(RL) INT 45°

SC..



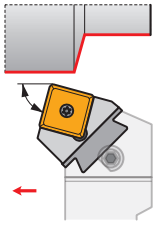
122

SC

ISO外圆重载车削 – 导航工具

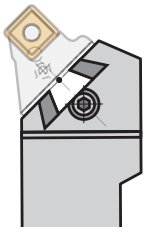
KHS-SBCR 75°

SC..



123

DKH(RL)



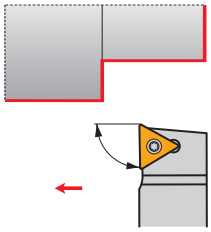
124

TC

ISO 外圆车削 – 导航工具

STAC(RL) EXT 90°

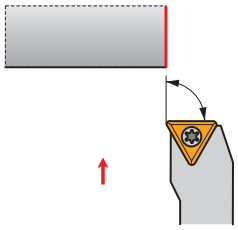
TC..



125

STFC(RL) EXT 90°

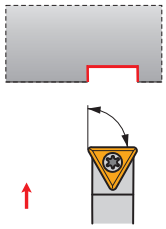
TC..



126

STFC(RL)-A EXT 90°

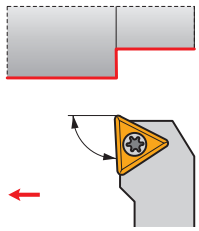
TC..



127

STJC(RL) EXT 93°

TC..



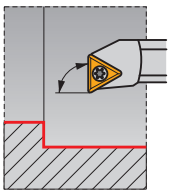
128

TC

ISO内孔车削 – 导航工具

STFC(RL) INT 90°

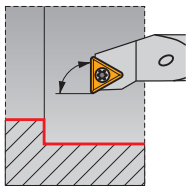
TC..



129

STFC(RL)-E INT 90°

TC..

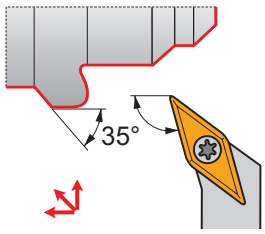


131

VB

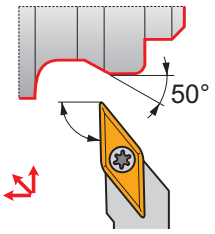
ISO 外圆车削 – 导航工具

SVHB(C)(RL) EXT 107°30´
VB, VC..



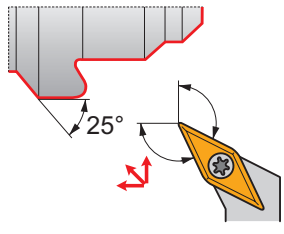
132

SVJB(C)(RL) EXT 93°
VB, VC..



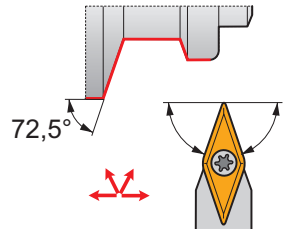
133

SVPB(C)(RL) EXT 117°30´
VB, VC..



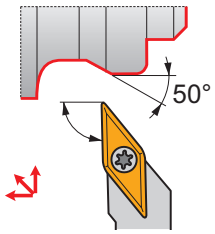
135

SVVB(C)N EXT 72°30´
VB, VC..



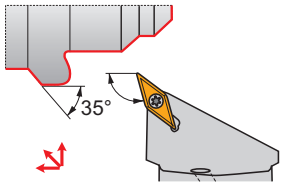
136

SVXB(C)(RL) EXT 98°
VB, VC..



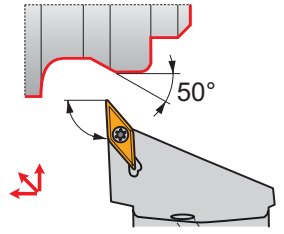
137

C.-SVHB(RL) EXT 107°30´
VB, VC..



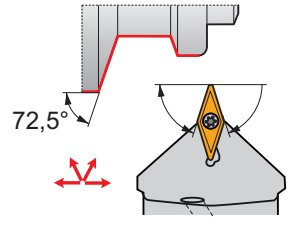
138

C.-SVJB(RL) EXT 93°
VB, VC..



139

C.-SVVBN EXT 72°30´
VB, VC..

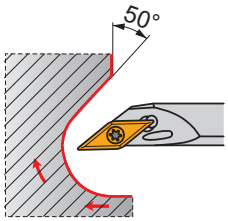


140

VB

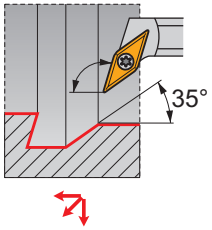
ISO内孔车削 – 导航工具

SVJB(RL) INT 93°
VB, VC..



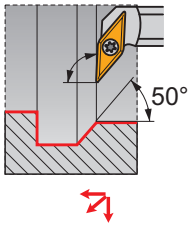
141

SVQB(C)(RL) INT 107°30´
VB, VC..



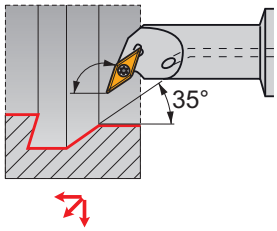
142

SVUB(C)(RL) INT 93°
VB, VC..



143

C.-SVQB(C)(RL) INT 108°
VB, VC..



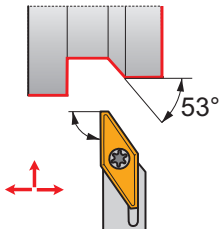
144

VC

ISO 外圆车削 – 导航工具

SVAC(RL)-DC EXT 90°

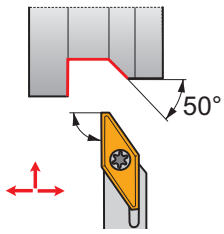
VC..



145

SVJC(RL)-DC EXT 93°

VC..



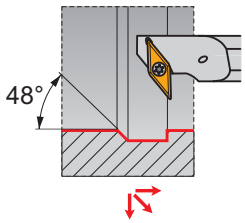
146

VC

ISO内孔车削 – 导航工具

SVLC(RL) INT 95°

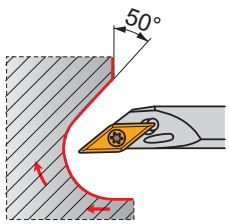
VC..



147

SVJB(RL) INT 93°

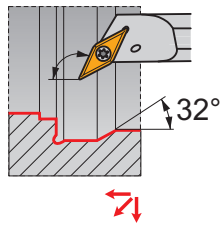
VB, VC..



148

SVXC(RL)-E INT 113°

VC..



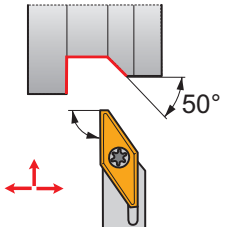
149

WC

ISO 外圆车削 – 导航工具

SWLC(RL) EXT 95°

WC..



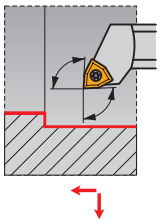
150

WC

ISO内孔车削 – 导航工具

SWLC(RL) INT 95°

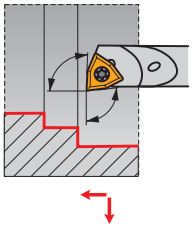
WC..



151

SWUC(RL) INT 93°

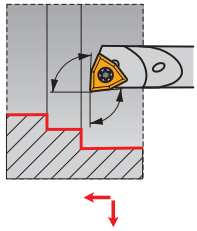
WC..



152

SWUC(RL)-E INT 93°

WC..



153

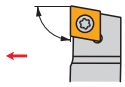
SCAC(RL) EXT

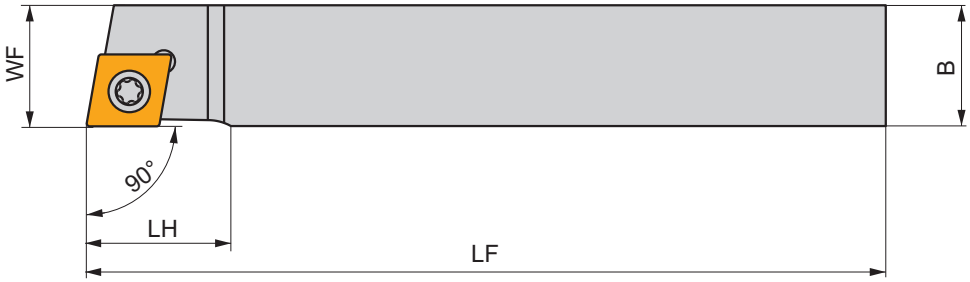
P M K N S H

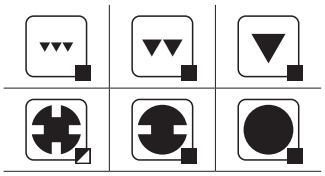
PRAMET

S

外圆用螺钉夹紧式车刀杆，主偏角为90°，使用CC.. 刀片
外圆左/右手车刀杆 ，主偏角为90°，使用正前角CC.. 06或09刀片。适用于外圆轴向车削、锥度车削和倒角车削。提供08×08至16×16mm的刀柄，其中一些可用纵切机床。刀杆经过处理，延长了使用寿命。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCACR 0808 D 06	8	8	8	8.5	60	–	0	0	0.04	GI045	S07
	SCACR 1010 E 06	10	10	10	10.5	70	–	0	0	0.08	GI045	S07
	SCACR 1212 F 09	12	12	12	12.5	80	–	0	0	0.11	GI041	S04
	SCACR 1212 K 09-S	12	12	12	12	125	19.0	0	0	0.14	GI041	S04
	SCACR 1616 H 09	16	16	16	16.5	100	–	0	0	0.22	GI041	S04
	SCACR 1616 K 09-S	16	16	16	16	125	19.0	0	0	0.24	GI041	S04
L	SCACL 0808 D 06	8	8	8	8.5	60	–	0	0	0.05	GI045	S07
	SCACL 1010 E 06	10	10	10	10.5	70	–	0	0	0.06	GI045	S07
	SCACL 1212 F 09	12	12	12	12.5	80	–	0	0	0.12	GI041	S04
	SCACL 1212 K 09-S	12	12	12	12	125	19.0	0	0	0.14	GI041	S04
	SCACL 1616 H 09	16	16	16	16.5	100	–	0	0	0.22	GI041	S04
	SCACL 1616 K 09-S	16	16	16	16	125	19.0	0	0	0.24	GI041	S04

GI041	CC.. 09T3..
GI045	CC.. 0602..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

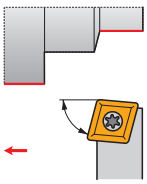
SCBC(RL) EXT

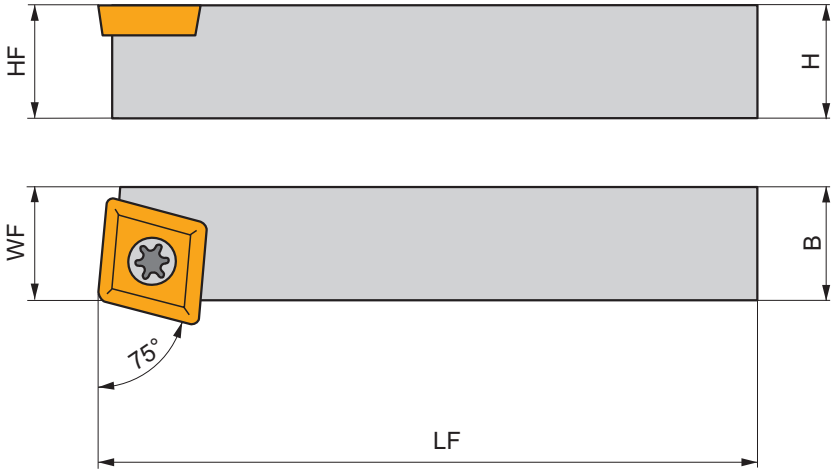
P M K N S H

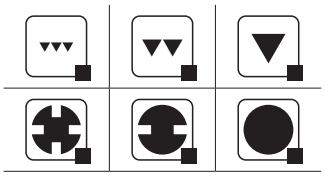
PRAMET

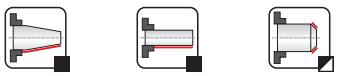
S

外圆用螺钉夹紧式车刀杆，使用CC..刀片，主偏角为75°。
外圆用左/右手车刀杆，螺钉锁紧式。主偏角为75°，使用CC..09或12正前角刀片。适用于无阶梯外圆的轴向车削，和倒角车削。可提供12x12至25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**SCBCR 1212 F 09**	12	12	12	11	80	0	0	0.10	GI041	S08
	SCBCR 1616 H 09	16	16	16	13	100	0	0	0.20	GI041	S08
	SCBCR 2020 K 12-M-A	20	20	20	17	125	0	0	0.45	GI011	SC20
	SCBCR 2525 M 12-M-A	25	25	25	22	150	0	0	0.61	GI011	SC20
L	**SCBCL 1212 F 09**	12	12	12	11	80	0	0	0.10	GI041	S08
	SCBCL 1616 H 09	16	16	16	13	100	0	0	0.22	GI041	S08
	SCBCL 2020 K 12-M-A	20	20	20	17	125	0	0	0.43	GI011	SC20
	SCBCL 2525 M 12-M-A	25	25	25	22	150	0	0	0.75	GI011	SC20

GI011	CC.. 1204..
GI041	CC.. 09T3..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

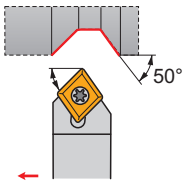
SCDCR EXT

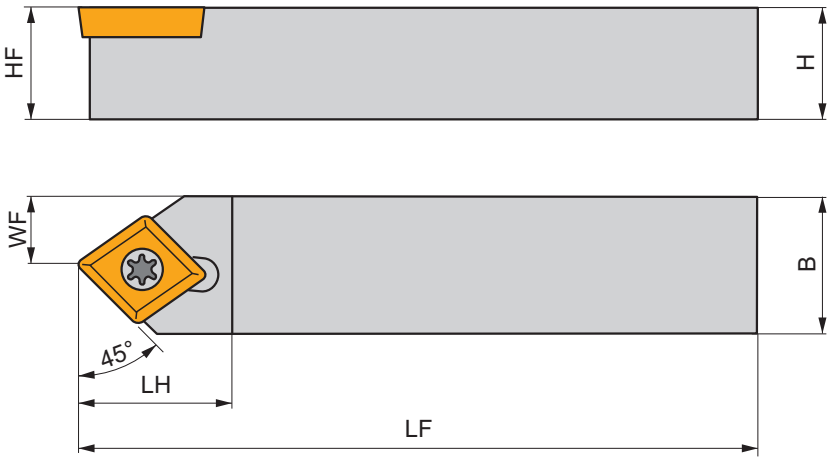
P M K N S H

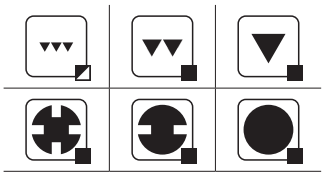
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用CC..刀片，主偏角度为45°
外圆用右手车刀杆，主偏角为45°。螺钉锁紧式。使用CC..06正前角刀片。适用于外圆无阶梯外圆的轴向切削，锥面，仿形车削和倒角车削。仅提供10x10mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SCDCR 1010 E 06**	10	10	10	5.11	70	11.0	0	0	0.06	GI045	SC21

GI045	CC.. 0602..

SC21	5513 020-03	0.8	M 2.5	6.5	PT-8001

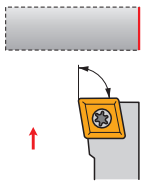
SCFC(RL) EXT

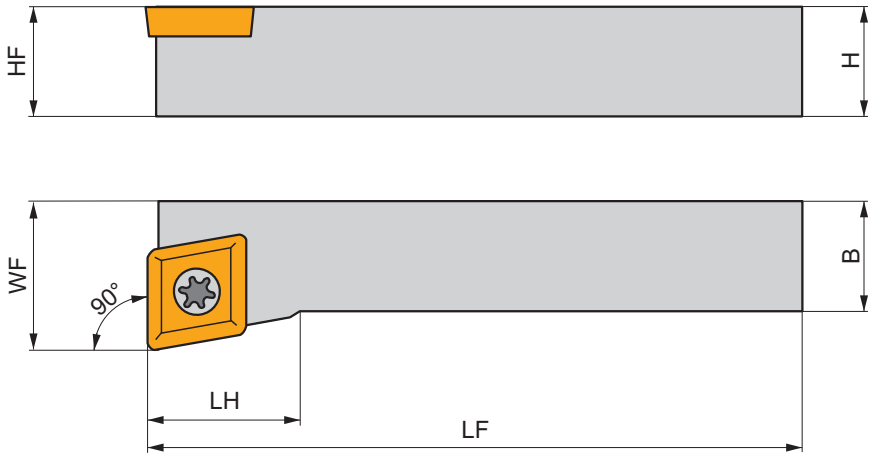
P M K N S H

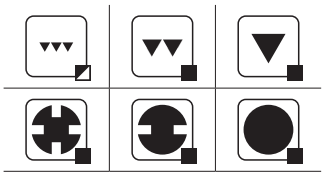
PRAMET

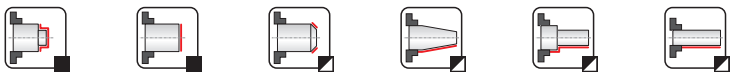
S

外圆用螺钉夹紧式车刀杆，使用CC..刀片，主偏角为90°。
外圆用左/右手车刀杆，主偏角为90°，螺钉锁紧式。使用CC..06或09正前角刀片。适用于外圆表面，有阶梯外圆的轴向车削，锥面和倒角车削。可提供08x08至16x16mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCFCR 0808 D 06	8	8	8	10	60	8.0	0	0	0.04	GI045	S07
	SCFCR 1010 E 06	10	10	10	12	70	8.0	0	0	0.07	GI045	S07
	SCFCR 1212 F 09	12	12	12	16	80	16.0	0	0	0.12	GI041	S04
	SCFCR 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S04
L	SCFCL 1010 E 06	10	10	10	12	70	8.0	0	0	0.06	GI045	S07
	SCFCL 1212 F 09	12	12	12	16	80	16.0	0	0	0.10	GI041	S04
	SCFCL 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S04

GI041	CC.. 09T3..
GI045	CC.. 0602..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

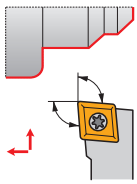
SCLC(RL) EXT

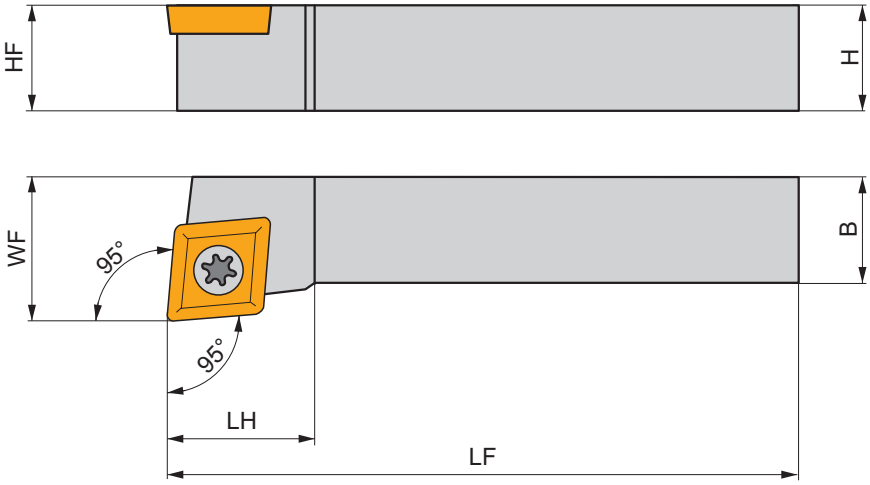
P M K N S H

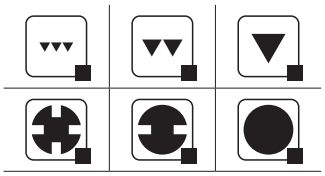
PRAMET

S

外圆用螺钉夹紧式车刀杆，主偏角为95°，使用CC.. 刀片
外圆左/右手车刀杆，主偏角为95°，使用正前角CC.. 06、08、09或12刀片。适用于外圆带肩轴向车削、锥度车削和倒角车削。提供08×08mm至25×25mm的刀柄，其中一些可用于纵切机床。刀杆经过处理，延长了使用寿命。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCLCR 0808 D 06	8	8	8	10	60	8.0	0	0	0.05	GI045	S01
	SCLCR 1010 E 06	10	10	10	12	70	8.0	0	0	0.09	GI045	S01
	SCLCR 1010 E 08	10	10	10	12	70	13.2	0	0	0.03	GI232	SC22
	SCLCR 1212 F 08	12	12	12	16	80	13.4	0	0	0.01	GI232	SC22
	SCLCR 1212 F 09	12	12	12	16	80	16.0	0	0	0.12	GI041	S08
	SCLCR 1212 K 09-S	12	12	12	12	125	21.3	0	0	0.13	GI041	S08
	SCLCR 1616 H 08	16	16	16	20	100	15.2	0	0	0.22	GI232	SC22
	SCLCR 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S08
	SCLCR 1616 K 09-S	16	16	16	16	125	21.3	0	0	0.24	GI041	S08
	SCLCR 2020 K 12-M-A	20	20	20	25	125	20.0	0	0	0.43	GI011	SC20
	SCLCR 2525 M 12-M-A	20	25	20	32	150	20.0	0	0	0.77	GI011	SC20
L	SCLCL 0808 D 06	8	8	8	10	60	8.0	0	0	0.06	GI045	S01
	SCLCL 1010 E 06	10	10	10	12	70	8.0	0	0	0.06	GI045	S01
	SCLCL 1212 F 08	12	12	12	16	80	13.4	0	0	0.03	GI232	SC22
	SCLCL 1212 F 09	12	12	12	16	80	16.0	0	0	0.10	GI041	S08
	SCLCL 1212 K 09-S	12	12	12	12	125	21.3	0	0	0.13	GI041	S08
	SCLCL 1616 H 08	16	16	16	20	100	15.2	0	0	0.23	GI232	SC22
	SCLCL 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S08
	SCLCL 1616 K 09-S	16	16	16	16	125	21.3	0	0	0.24	GI041	S08
	SCLCL 2020 K 12-M-A	20	20	20	25	125	20.0	0	0	0.40	GI011	SC20
	SCLCL 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	0.77	GI011	SC20

GI011	CC.. 1204..
GI041	CC.. 09T3..
GI045	CC.. 0602..

GI232	CC.. 0803..

SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
SC22	5513 020-04	1.5	M 3	7.2	–	–	PT-8003	–
SO1	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SO8	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

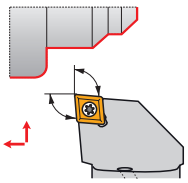
C.-SCLC(RL) EXT

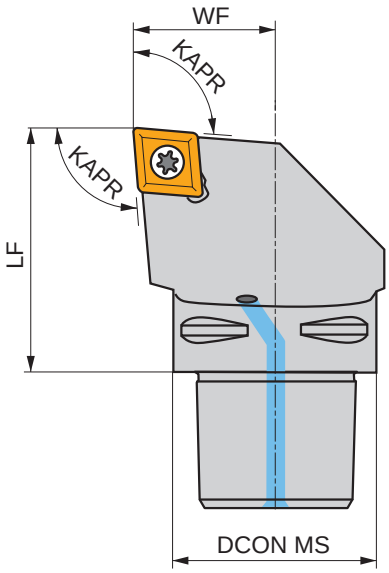
P M K N S H

PRAMET

S

外圆用PSC快速更换式刀柄，螺钉夹紧式，使用CC..刀片，主偏角为95°。
外圆用左/右车刀杆，有内冷通道，主偏角为95°。螺钉锁紧式。使用CC..09和12正前角刀片。适用于有阶梯外圆的轴向车削，锥面和倒角车削。可提供C3至C5的PSC刀柄。刀杆经过处理，使用寿命更长。





Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R										
C3-SCLCR-22040-09	32	22	40	95	0	0	✓	0.21	GI041	C-SC09S
C4-SCLCR-27050-09	40	27	50	95	0	0	✓	0.39	GI041	C-SC09S
C4-SCLCR-27050-12	40	27	50	95	0	0	✓	0.40	GI011	C-SC12-1
C5-SCLCR-35060-12	50	35	60	95	0	0	✓	0.72	GI011	C-SC12-2
L										
C3-SCLCL-22040-09	32	22	40	95	0	0	✓	0.21	GI041	C-SC09S
C4-SCLCL-27050-09	40	27	50	95	0	0	✓	0.39	GI041	C-SC09S
C5-SCLCL-35060-12	50	35	60	95	0	0	✓	0.72	GI011	C-SC12-2

GI011	CC.. 1204..
GI041	CC.. 09T3..

		Nm						
C-SC09S	US 2001-T15P	3.0	M 3.5	12.1	SCS 232-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SC12-1	US 2018-T15P	3.0	M 4	14	SCS 232-02	MS 9003	FLAG T15P/4	CN 034-01
C-SC12-2	US 2018-T15P	3.0	M 4	14	SCS 232-02	MS 9003	FLAG T15P/4	CN 034-02

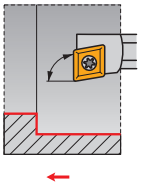
SCFC(RL) INT

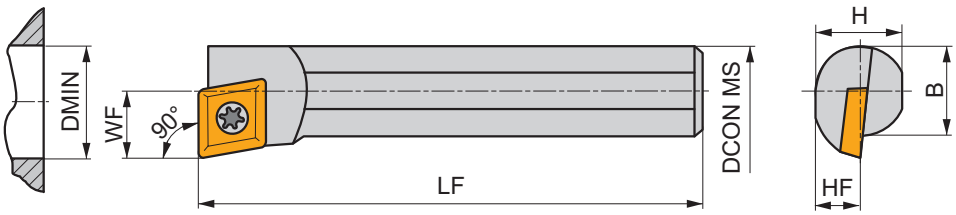
P M K N S H

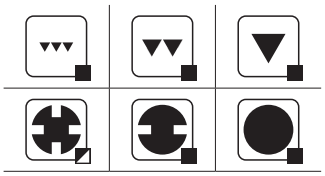
PRAMET

S

内孔镗杆,螺钉夹紧,使用CC..刀片,主偏角为90°。
内孔左/右手镗杆,主偏角为90°。螺钉夹紧。使用CC..型螺。适用于内孔表面和阶梯孔的轴向车削,锥面和倒角车削。刀杆经过处理,使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**S10H-SCFCR 06**	10	13	7	9	9.5	100	-10	0	0.08	GI045	S06
R	**S12K-SCFCR 06**	12	16	9	11	11.5	125	-7	0	0.11	GI045	S06
L	**S10H-SCFCL 06**	10	13	7	9	9.5	100	-10	0	0.08	GI045	S06
L	**S12K-SCFCL 06**	12	16	9	11	11.5	125	-7	0	0.13	GI045	S06

GI045	CC.. 0602..

S06	US 2505-T07P	0.9	M 2.5	5.2	FLAG T07P

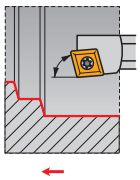
SCKC(RL) INT

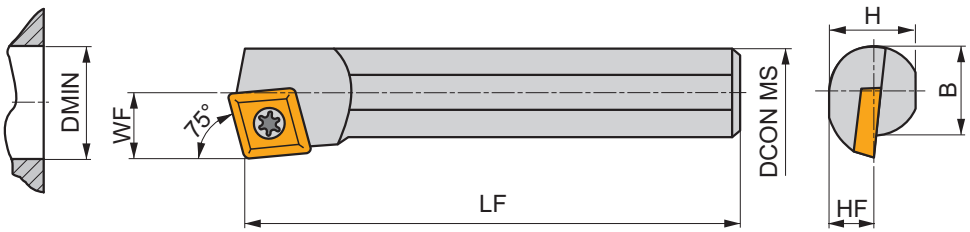
P M K N S H

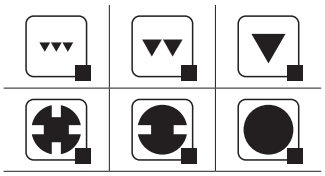
PRAMET

S

内孔镗杆,螺钉夹紧,使用CC..刀片,主偏角度为75°。
内孔左/右手镗杆,主偏角75°。螺钉夹紧。使用CC..刀片。适用于内孔无阶梯孔的轴向车削,锥面倒角车削。刀杆经过处理,使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**S08F-SCKCR 06**	8	11	6	7.2	7.6	80	-12	0	0.03	GI045	S02
R	**S12K-SCKCR 06**	12	16	9	11	11.5	125	-8	0	0.11	GI045	S02
R	**S16M-SCKCR 09-A**	16	20	11	14.5	15	150	-8	0	0.25	GI041	S05
R	**S20S-SCKCR 09**	20	25	13	18.5	18.5	250	-5	0	0.60	GI041	S08
R	**S25T-SCKCR 09**	25	32	17	23	23	300	-3	0	1.15	GI041	S08
R	**S32U-SCKCR 12-A**	32	40	22	30	30	350	-10	0	2.10	GI011	SC20
L	**S20S-SCKCL 09**	20	25	13	18.5	18.5	250	-5	0	0.60	GI041	S08

GI011	CC.. 1204..
GI041	CC.. 09T3..
GI045	CC.. 0602..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S05	US 4008-T15P	3.5	M 4	8	–	–	FLAG T15P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

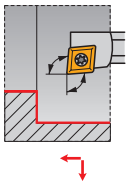
SCLC(RL) INT

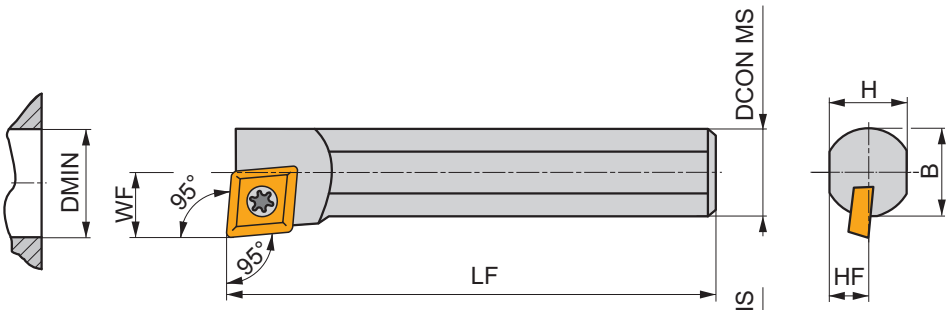
P M K N S H

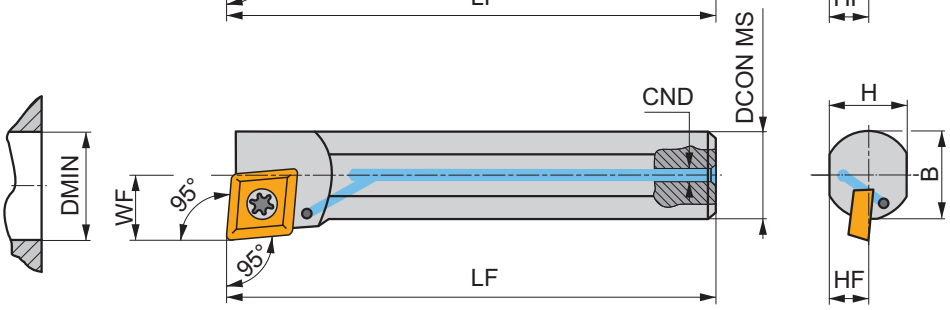
PRAMET

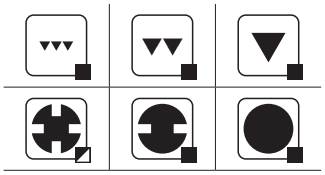
S

内孔螺钉夹紧镗杆，使用CC..刀片，主偏角为95°
内孔左/右手镗杆，有内冷通道，螺钉夹紧。主偏角为95°使用CC..刀片。适用于有阶梯孔的轴向车削，锥面和倒角车削。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A08H-SCLCR 06	8	11	6	7.2	7.6	100	3.5	-13	0	✓	0.03	GI045	S02
	S08F-SCLCR 06	8	11	6	7.2	7.6	80	–	-13	0	–	0.05	GI045	S02
	A10H-SCLCR 06	10	13	7	9	–	100	4	-10	0	✓	0.07	GI045	S02
	S10H-SCLCR 06	10	13	7	9	9.5	100	–	-10	0	–	0.07	GI045	S02
	A12K-SCLCR 06	12	16	9	11	–	125	5	-8	0	✓	0.09	GI045	S01
	S12K-SCLCR 06	12	16	9	11	11.5	125	–	-8	0	–	0.12	GI045	S01
	S16M-SCLCR 06	16	20	11	14.5	15	150	–	-8	0	–	0.25	GI045	S01
	A10K-SCLCR 08	10	12	6	9	9.5	125	4	-14	0	✓	0.09	GI232	SC22
	A12M-SCLCR 08	12	16	9	11	11.5	150	5	-5	0	✓	0.14	GI232	SC22
	A16R-SCLCR 08	16	20	11	14	15	200	6	-8	0	✓	0.28	GI232	SC22
	A16M-SCLCR 09-A	16	20	11	14.5	–	150	6	-8	0	✓	0.22	GI041	S05
	S16M-SCLCR 09-A	16	20	11	14.5	15	150	–	-8	0	–	0.25	GI041	S05
	A20Q-SCLCR 09	20	25	13	18	–	180	8	-5	0	✓	0.37	GI041	S08
	S20S-SCLCR 09	20	25	13	18	18.5	250	–	-5	0	–	0.59	GI041	S08
	A25R-SCLCR 09	25	32	17	23	23	200	8	-3	0	✓	0.60	GI041	S08
	S25T-SCLCR 09	25	32	17	23	23	300	–	-3	0	–	1.08	GI041	S08
	A32S-SCLCR 12-A	32	40	22	30	30	250	8	-10	0	✓	1.35	GI011	SC20
	S32U-SCLCR 12-A	32	40	22	30	30	350	–	-10	0	–	2.10	GI011	SC20
L	A08H-SCLCL 06	8	11	6	7.2	7.6	100	–	-13	0	✓	0.05	GI045	S02
	S08F-SCLCL 06	8	11	6	7.2	7.6	80	–	-13	0	–	0.05	GI045	S02
	A10H-SCLCL 06	10	13	7	9	–	100	4	-10	0	✓	0.06	GI045	S02
	S10H-SCLCL 06	10	13	7	9	9.5	100	–	-10	0	–	0.06	GI045	S02
	A12K-SCLCL 06	12	16	9	11	–	125	5	-8	0	✓	0.10	GI045	S01
	S12K-SCLCL 06	12	16	9	11	11.5	125	–	-8	0	–	0.11	GI045	S01
	S16M-SCLCL 06	16	20	11	14.5	15	150	–	-8	0	–	0.24	GI045	S01
	A10K-SCLCL 08	10	12	6	9	9.5	125	4	-14	0	✓	0.00	GI232	SC22
	A12M-SCLCL 08	12	16	9	11	11.5	150	5	-5	0	✓	0.14	GI232	SC22

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
L	**A16R-SCLCL 08**	16	20	11	14	15	200	6	-8	0	✓	0.30	GI232	SC22
	A16M-SCLCL 09-A	16	20	11	14.5	–	150	6	-8	0	✓	0.22	GI041	S05
	S16M-SCLCL 09-A	16	20	11	14.5	15	150	–	-8	0	–	0.24	GI041	S05
	A20Q-SCLCL 09	20	25	13	18	–	180	8	-5	0	✓	0.37	GI041	S08
	S20S-SCLCL 09	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI041	S08
	A25R-SCLCL 09	25	32	17	23	23	200	8	-3	0	✓	0.67	GI041	S08
	S25T-SCLCL 09	25	32	17	23	23	300	–	-3	0	–	1.08	GI041	S08
	A32S-SCLCL 12-A	32	40	22	30	30	250	8	-10	0	✓	1.35	GI011	SC20
	S32U-SCLCL 12-A	32	40	22	30	30	350	–	-10	0	–	2.00	GI011	SC20

GI011	CC.. 1204..
GI041	CC.. 09T3..
GI045	CC.. 0602..
GI232	CC.. 0803..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
SC22	5513 020-04	1.5	M 3	7.2	–	–	PT-8003	–
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S05	US 4008-T15P	3.5	M 4	8	–	–	FLAG T15P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

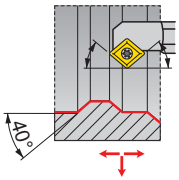
SCXC(RL) INT

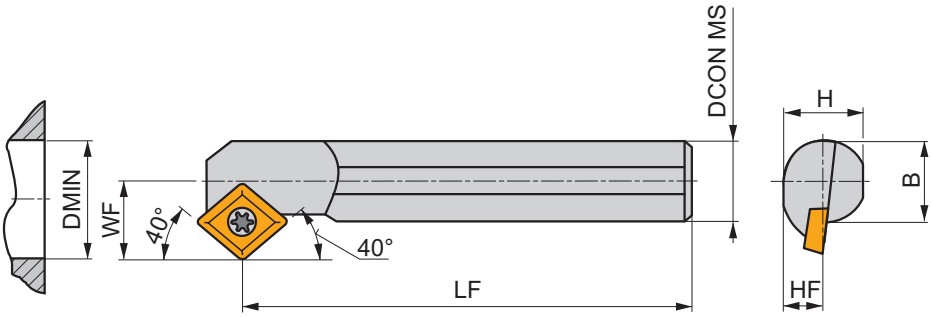
P M K N S H

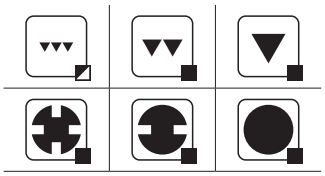
PRAMET

S

内孔螺钉夹紧镗杆，使用CC..刀片，主偏角为40°。
内孔左/右手镗杆，螺钉夹紧。主偏角为40°，使用CC..刀片。适用于内孔正反向倒角车削，无阶梯孔的轴向车削，和锥面车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**S10H-SCXCR 06**	10	13	7	9	9.5	100	-10	0	0.06	GI045	S06
	S12K-SCXCR 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S06
	S16Q-SCXCR 06	16	20	11	14.5	15	180	-7	0	0.29	GI045	S07
L	**S10H-SCXCL 06**	10	13	7	9	9.5	100	-10	0	0.06	GI045	S06
	S12K-SCXCL 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S06
	S16Q-SCXCL 06	16	20	11	14.5	15	180	-7	0	0.30	GI045	S07

GI045	CC.. 0602..

		Nm			
S06	US 2505-T07P	0.9	M 2.5	5.2	FLAG T07P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

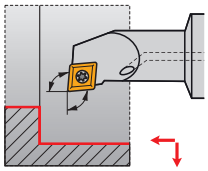
C.-SCLC(RL) INT

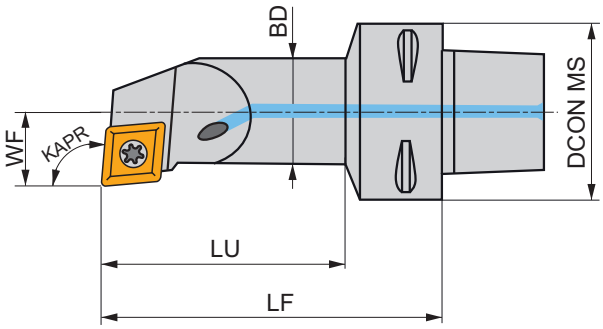
P M K N S H

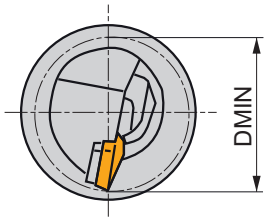
PRAMET

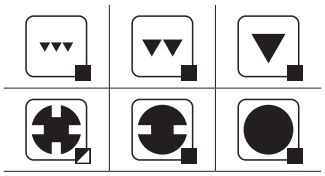
S

内孔PSC快换刀柄，螺钉夹紧，使用CC..刀片，主偏角为95°。
内孔左/右手刀具，有内冷通道，螺钉夹紧。主偏角为95°，使用CC..09刀片。广泛的应用于内孔车削。PSC刀柄尺寸C3至C5，可以选择长度。刀杆经过处理，使用寿命更长。









	Product	DCON MS	DMIN	WF	LF	LU	BD	KAPR	LAMS	GAMO		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)				
R	C3-SCLCR-11065-09	32	20	11	65	48	16	95	-8.4	0	✓	0.21	GI041	SC09M
R	C3-SCLCR-13075-09	32	25	13	75	58	20	95	-5.8	0	✓	0.26	GI041	SC09M
R	C4-SCLCR-11070-09	40	20	11	70	47	16	95	-8.4	0	✓	0.36	GI041	SC09M
R	C4-SCLCR-13080-09	40	25	13	80	57	20	95	-5.8	0	✓	0.41	GI041	SC09M
R	C4-SCLCR-17090-09	40	32	17	90	68	25	95	-3.4	0	✓	0.50	GI041	SC09M
R	C5-SCLCR-11070-09	50	20	11	70	46	16	95	-8.4	0	✓	0.55	GI041	SC09M
R	C5-SCLCR-13080-09	50	25	13	80	56	20	95	-5.8	0	✓	0.60	GI041	SC09M
L	C4-SCLCL-11070-09	40	20	11	70	47	16	95	-8.4	0	✓	0.36	GI041	SC09M
L	C4-SCLCL-13080-09	40	25	13	80	57	20	95	-5.8	0	✓	0.41	GI041	SC09M
L	C5-SCLCL-11070-09	50	20	11	70	46	16	95	-8.4	0	✓	0.55	GI041	SC09M
L	C5-SCLCL-13080-09	50	25	13	80	56	20	95	-5.8	0	✓	0.60	GI041	SC09M

GI041	CC.. 09T3..

SC09M	US 2009-T15P	3.0	M 3.5	8.1	FLAG T15P/3,5

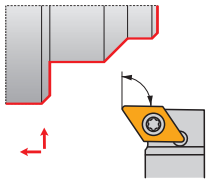
SDFC(RL) EXT

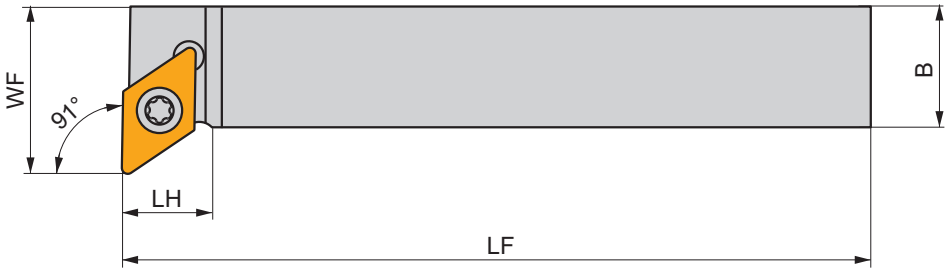
P M K N S H

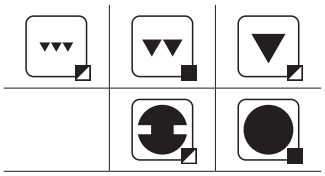
PRAMET

S

外圆用螺钉夹紧式车刀杆，主偏角为91°，使用DC.. 刀片
外圆用右/左手车刀杆，主偏角为91°，螺钉锁紧，使用正前角DC.. 07和11刀片。适用于外圆带肩轴向车削、仿形车削、端面车削、锥度车削和倒角车削。提供12×12mm至16×16mm的刀柄，可用于纵切机床。刀杆经过处理，延长了使用寿命。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SDFCR 1212 K 07-S	12	12	12	16	125	8.8	0	0	0.14	GI052	S01
R	SDFCR 1616 K 11-S	16	16	16	22	125	11.9	0	0	0.25	GI012	S08
L	SDFCL 1212 K 07-S	12	12	12	16	125	8.8	0	0	0.14	GI052	S01
L	SDFCL 1616 K 11-S	16	16	16	22	125	11.9	0	0	0.25	GI012	S08

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm			
S01	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P
S08	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P

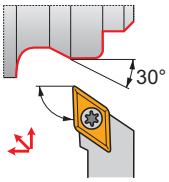
SDJC(RL) EXT

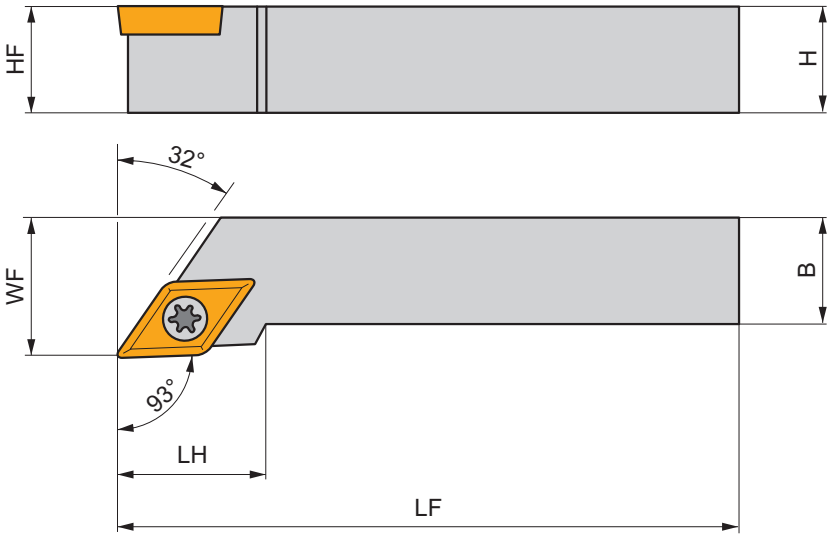
P M K N S H

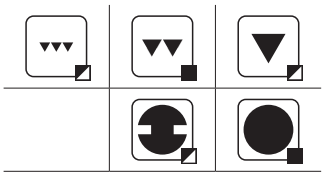
PRAMET

S

外圆用螺钉夹紧式车刀杆，主偏角为93°，使用DC.. 刀片
外圆用右/左手车刀杆，主偏角为93°，螺钉锁紧型，使用正前角DC..　07、11或15刀片。适用于外圆带肩轴向车削、仿形车削、锥度车削和倒角车削。提供08×08mm至25×25mm的刀柄，其中一些可用于纵切机床。刀杆经过处理，延长了使用寿命。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SDJCR 0808 D 07	8	8	8	10	60	14.0	0	0	0.05	GI052	S01
	SDJCR 1010 E 07	10	10	10	12	70	14.0	0	0	0.06	GI052	S01
	SDJCR 1212 F 07	12	12	12	16	80	14.0	0	0	0.11	GI052	S01
	SDJCR 1212 F 11	12	12	12	16	80	20.0	0	0	0.10	GI012	S08
	SDJCR 1212 K 07-S	12	12	12	12	125	18.2	0	0	0.13	GI052	S01
	SDJCR 1212 K 11-S	12	12	12	12	125	22.6	0	0	0.13	GI012	S08
	SDJCR 1616 H 11	16	16	16	20	100	20.0	0	0	0.22	GI012	S08
	SDJCR 1616 K 11-S	16	16	16	16	125	22.6	0	0	0.23	GI012	S08
	SDJCR 2020 K 11-M-A	20	20	20	25	125	20.0	0	0	0.40	GI012	SD10
	SDJCR 2525 M 11-M-A	25	25	25	32	150	20.0	0	0	0.74	GI012	SD10
	SDJCR 2525 M 15	25	25	25	32	150	28.0	0	0	0.74	GI243	SD11
L	SDJCL 0808 D 07	8	8	8	10	60	14.0	0	0	0.04	GI052	S01
	SDJCL 1010 E 07	10	10	10	12	70	14.0	0	0	0.07	GI052	S01
	SDJCL 1212 F 07	12	12	12	16	80	14.0	0	0	0.11	GI052	S01
	SDJCL 1212 F 11	12	12	12	16	80	20.0	0	0	0.11	GI012	S08
	SDJCL 1212 K 07-S	12	12	12	12	125	18.2	0	0	0.13	GI052	S01
	SDJCL 1212 K 11-S	12	12	12	12	125	22.6	0	0	0.13	GI012	S08
	SDJCL 1616 H 11	16	16	16	20	100	20.0	0	0	0.20	GI012	S08
	SDJCL 1616 K 11-S	16	16	16	16	125	22.6	0	0	0.23	GI012	S08
	SDJCL 2020 K 11-M-A	20	20	20	25	125	20.0	0	0	0.41	GI012	SD10
	SDJCL 2525 M 11-M-A	25	25	25	32	150	20.0	0	0	0.74	GI012	SD10
	SDJCL 2525 M 15	25	25	25	32	150	28.0	0	0	0.07	GI243	SD11

GI012	DC.. 11T3..
GI052	DC.. 0702..
GI243	DC.. 1504..

SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
SD11	US 64518-T15P	5.0	M 4.5	18	SDN 150304	MS 4512	FLAG T15P	HXK 5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

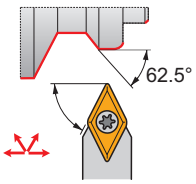
SDNCN EXT

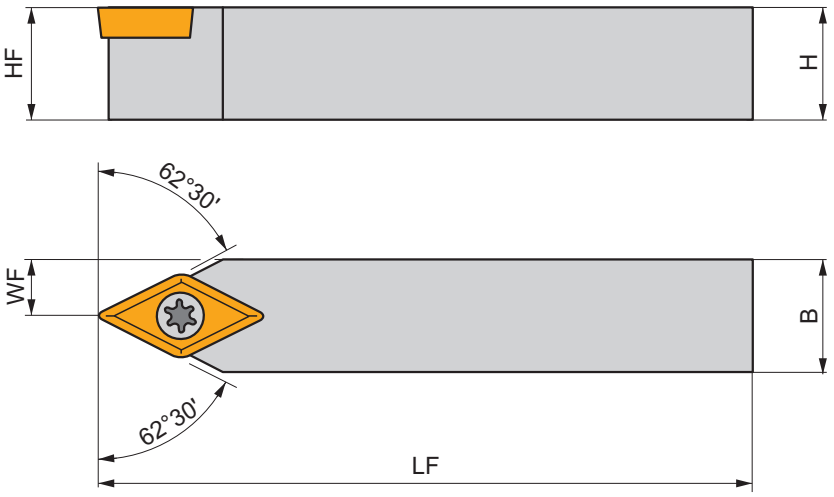
P M K N S H

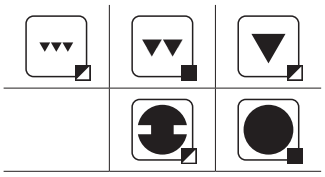
PRAMET

S

外圆用螺钉夹紧式车刀杆，主偏角为62.5°，使用DC.. 刀片
外圆用中置车刀杆，螺钉锁紧式。主偏角为62.5°。使用DC..07或11正前角刀片。适用于外圆无阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供08x08至25x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
N	**SDNCN 0808 D 07**	8	8	8	4	60	0	0	0.05	GI052	S01
	SDNCN 1010 E 07	10	10	10	5	70	0	0	0.07	GI052	S01
	SDNCN 1212 F 07	12	12	12	6	80	0	0	0.11	GI052	S01
	SDNCN 1212 F 11	12	12	12	6	80	0	0	0.11	GI012	S08
	SDNCN 1616 H 11	16	16	16	8	100	0	0	0.20	GI012	S08
	SDNCN 2020 K 11-M-A	20	20	20	10	125	0	0	0.35	GI012	SD10
	SDNCN 2525 M 11-M-A	25	25	25	12.5	150	0	0	0.70	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

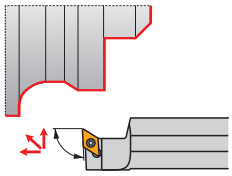
SDUCL EXT

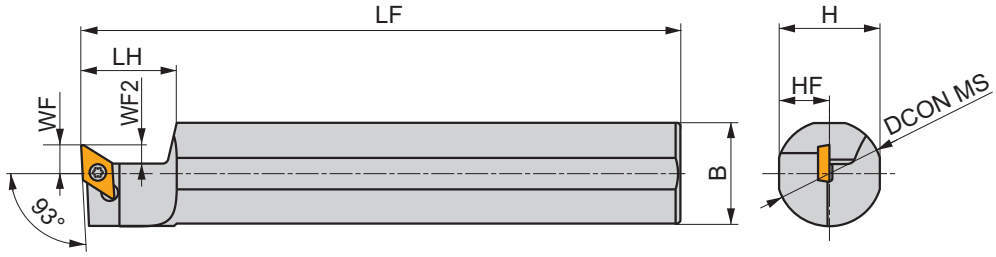
P M K N S H

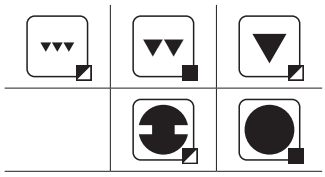
PRAMET

S

外圆用螺钉夹紧式车刀杆，主偏角为93°，使用DC.. 刀片
外圆用右/左手车刀杆，主偏角为93°，使用正前角DC..刀片。适用于外圆带肩轴向车削、仿形车削、端面车削、锥度车削和倒角车削。可用于纵切机床。刀杆经过处理，延长了使用寿命。







	Product	DCON MS (mm)	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	WF2 (mm)	LAMS (°)	GAMO (°)	kg		
L	S20K-SDUCL07-S	20	19	19	9.5	6	125	18.0	4	0	0	0.23	GI052	S01
	S22K-SDUCL07-S	22	21	21	10.5	6	125	18.0	4	0	0	0.27	GI052	S01

GI052	DC.. 0702..

S01	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

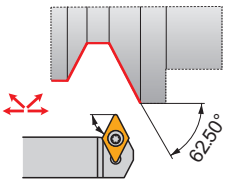
SDXC(RL) EXT

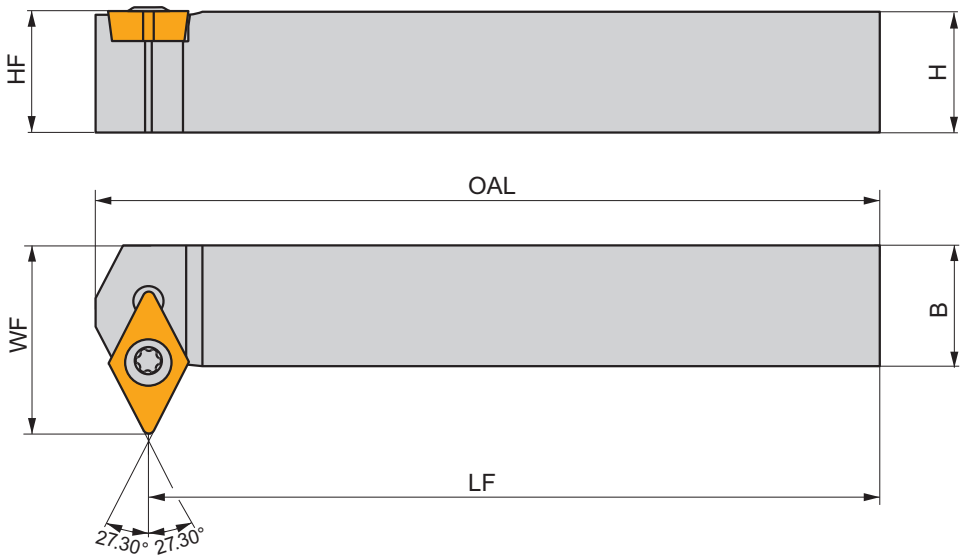
P M K N S H

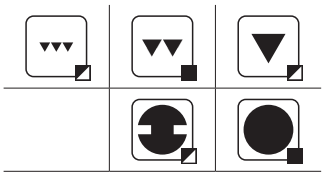
PRAMET

S

外圆用螺钉夹紧式车刀杆，主偏角为62.5°，使用DC.. 刀片
外圆用右/左手车刀杆，主偏角为62.5°，螺钉锁紧，使用正前角DC.. 07和11刀片。适用于外圆带肩轴向车削、仿形车削、锥度车削和倒角车削。可提供12 × 12mm至16 × 16mm的刀柄，用于纵切机床。刀杆经过处理，延长了使用寿命。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	OAL (mm)	LAMS (°)	GAMO (°)	kg		
R	**SDXCR 1212 K 07-S**	12	12	12	18	125	130	0	0	0.15	GI052	S01
R	**SDXCR 1616 K 11-S**	16	16	16	25	125	132	0	0	0.26	GI012	S08
L	**SDXCL 1212 K 07-S**	12	12	12	18	125	130	0	0	0.15	GI052	S01
L	**SDXCL 1616 K 11-S**	16	16	16	25	125	132	0	0	0.26	GI012	S08

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm			
S01	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P
S08	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P

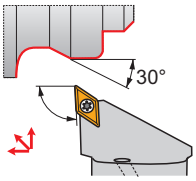
C.-SDJC(RL) EXT

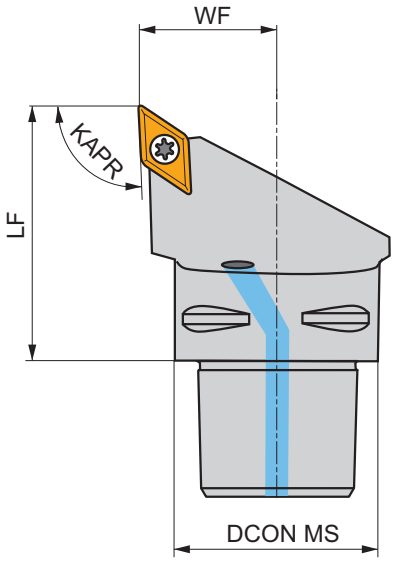
P M K N S H

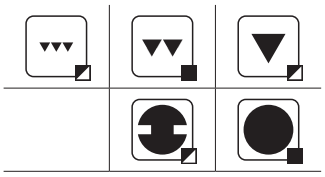
PRAMET

S

外圆用PSC快速更换式刀柄，螺钉夹紧式，DC..刀片，主偏角为93°。
外圆用左/右手车刀杆，有内冷通道，主偏角为93°。使用DC..07、11或15正前角刀片。适用于有阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供C3至C5的PSC刀柄。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SDJCR-22040-11	32	22	40	93	0	0	✓	0.20	GI012	C-SD11V-1
	C4-SDJCR-27050-11	40	27	50	93	0	0	✓	0.38	GI012	C-SD11V-1
	C5-SDJCR-35060-11	50	35	60	93	0	0	✓	0.69	GI012	C-SD11V-2
L	C3-SDJCL-22040-11	32	22	40	93	0	0	✓	0.20	GI012	C-SD11V-1
	C4-SDJCL-27050-11	40	27	50	93	0	0	✓	0.38	GI012	C-SD11V-1
	C5-SDJCL-35060-11	50	35	60	93	0	0	✓	0.70	GI012	C-SD11V-2

GI012	DC.. 11T3..

		Nm						
C-SD11V-1	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SD11V-2	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-02

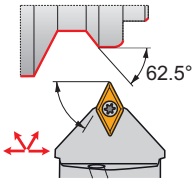
C.-SDNCN EXT

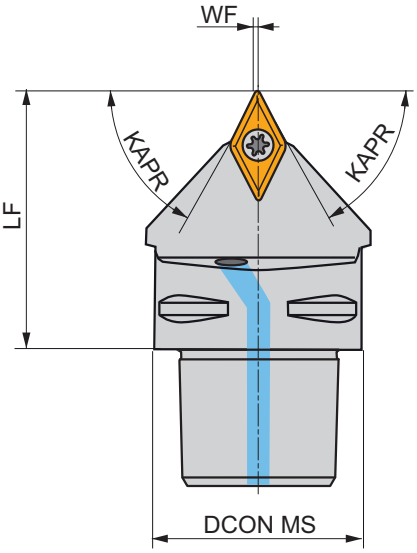
P M K N S H

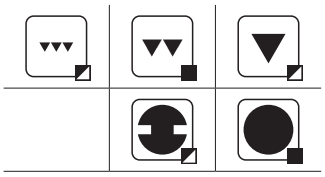
PRAMET

S

外圆用PSC快速更换式刀柄，螺钉夹紧式，DC..刀片，主偏角为62.5°。
外圆用左/右手车刀杆，有内冷通道，主偏角为62.5°。螺钉锁紧式。使用DC..11正前角刀片。适用于无阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供C4和C5的PSC刀柄。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
N	**C4-SDNCN-00050-11**	40	0.5	50	62.5	0	0	✓	0.35	GI012	C-SD11V-1
	C5-SDNCN-00060-11	50	0.5	60	62.5	0	0	✓	0.62	GI012	C-SD11V-2

GI012	DC.. 11T3..

		Nm						
C-SD11V-1	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SD11V-2	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-02

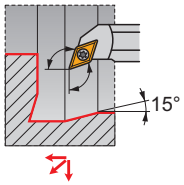
SDQC(RL) INT

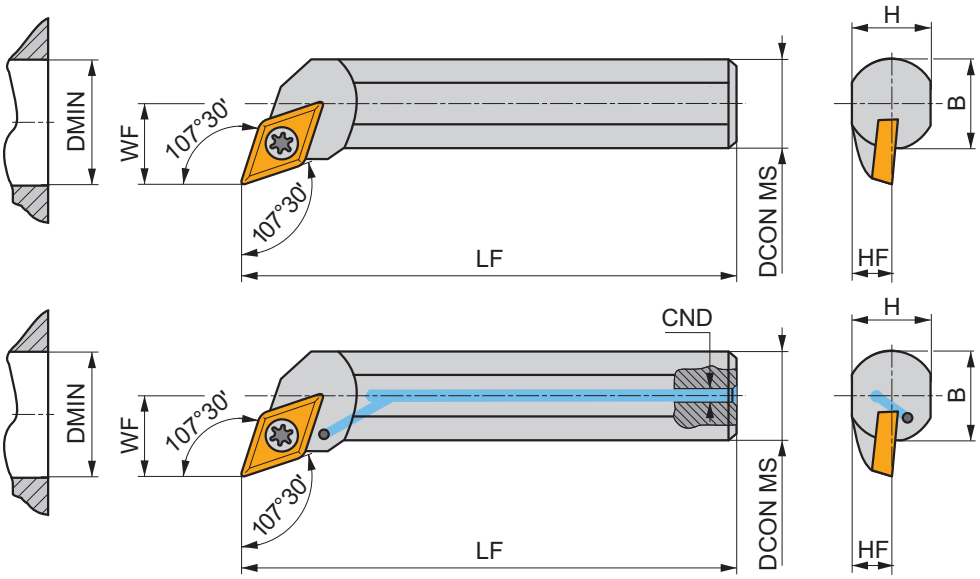
P M K N S H

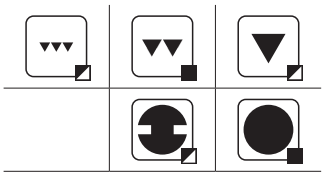
PRAMET

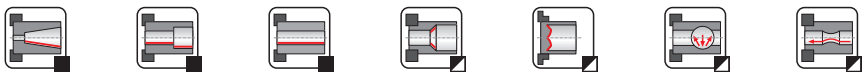
S

内孔镗杆,螺钉夹紧,使用DC..刀片,主偏角为107.5°。
内孔左/右手镗杆,有内冷通道,螺钉夹紧。主偏角为107.5⊠。使用DC..刀片。适用于有阶梯孔的轴向车削,锥面,仿形和倒角车削。刀杆经过处理,使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A10H-SDQCR 07	10	13	7	9	–	100	4	-10	0	✓	0.07	GI052	S02
	A12K-SDQCR 07	12	16	9	11	–	125	5	-7	0	✓	0.10	GI052	S02
	A16M-SDQCR 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDQCR 11	20	25	13	18	–	180	8	-5	0	✓	0.36	GI012	S08
	S20S-SDQCR 11	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI012	S08
	A25R-SDQCR 11	25	32	17	23	23	200	8	-3	0	✓	0.65	GI012	S08
	S25T-SDQCR 11	25	32	17	23	23	300	–	-3	0	–	1.08	GI012	S08
	A32S-SDQCR 11-A	32	40	22	30	30	250	8	-10	0	✓	1.25	GI012	SD10
	S32U-SDQCR 11-A	32	40	22	30	30	350	–	-10	0	–	2.10	GI012	SD10
L	A10H-SDQCL 07	10	13	7	9	–	100	4	-10	0	✓	0.06	GI052	S02
	A12K-SDQCL 07	12	16	9	11	–	125	5	-7	0	✓	0.11	GI052	S02
	A16M-SDQCL 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDQCL 11	20	25	13	18	–	180	8	-5	0	✓	0.37	GI012	S08
	S20S-SDQCL 11	20	25	13	18	18.5	250	–	-5	0	–	0.63	GI012	S08
	A25R-SDQCL 11	25	32	17	23	23	200	8	-3	0	✓	0.64	GI012	S08
	S25T-SDQCL 11	25	32	17	23	23	300	–	-3	0	–	1.15	GI012	S08
	A32S-SDQCL 11-A	32	40	22	30	30	250	8	-10	0	✓	1.32	GI012	SD10
	S32U-SDQCL 11-A	32	40	22	30	30	350	–	-10	0	–	2.08	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

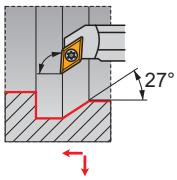
SDUC(RL) INT

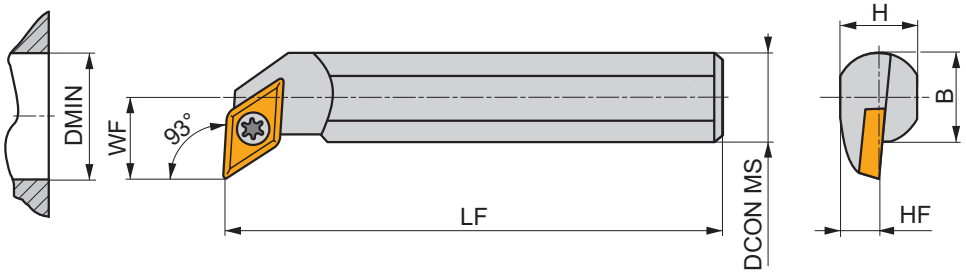
P M K N S H

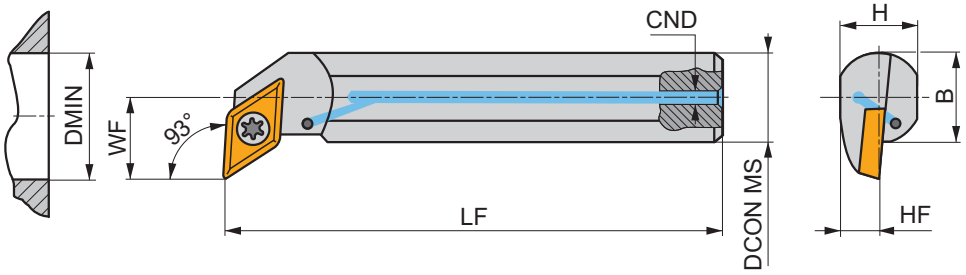
PRAMET

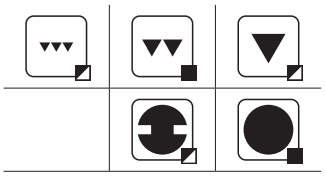
S

内孔螺钉夹紧镗杆，使用DC..刀片，主偏角为93°。
内孔左/右手镗杆，有内冷通道，螺钉夹紧。主偏角为93⊠，使用DC..刀片。适用于有阶梯孔的轴向车削，锥面，仿形和倒角车削。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A10H-SDUCR 07	10	13	7	9	–	100	4	-10	0	✓	0.07	GI052	S02
	A12K-SDUCR 07	12	16	9	11	–	125	5	-7	0	✓	0.12	GI052	S02
	A16M-SDUCR 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDUCR 11	20	25	13	18	–	180	8	-3	0	✓	0.37	GI012	S08
	S20S-SDUCR 11	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI012	S08
	A25R-SDUCR 11	25	32	17	23	23	200	8	-3	0	✓	0.60	GI012	S08
	S25T-SDUCR 11	25	32	17	23	23	300	–	-3	0	–	1.09	GI012	S08
	A32S-SDUCR 11-A	32	40	22	30	30	250	8	-10	0	✓	1.30	GI012	SD10
	S32U-SDUCR 11-A	32	40	22	30	30	350	–	-10	0	–	2.10	GI012	SD10
L	A10H-SDUCL 07	10	13	7	9	–	100	4	-10	0	✓	0.07	GI052	S02
	A12K-SDUCL 07	12	16	9	11	–	125	5	-7	0	✓	0.11	GI052	S02
	A16M-SDUCL 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDUCL 11	20	25	13	18	–	180	8	-3	0	✓	0.37	GI012	S08
	S20S-SDUCL 11	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI012	S08
	A25R-SDUCL 11	25	32	17	23	23	200	8	-3	0	✓	0.66	GI012	S08
	S25T-SDUCL 11	25	32	17	23	23	300	–	-3	0	–	1.09	GI012	S08
	A32S-SDUCL 11-A	32	40	22	30	30	250	8	-10	0	✓	0.00	GI012	SD10
	S32U-SDUCL 11-A	32	40	22	30	30	350	–	-10	0	–	2.09	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

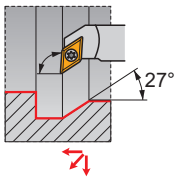
SDUC(RL)-E INT

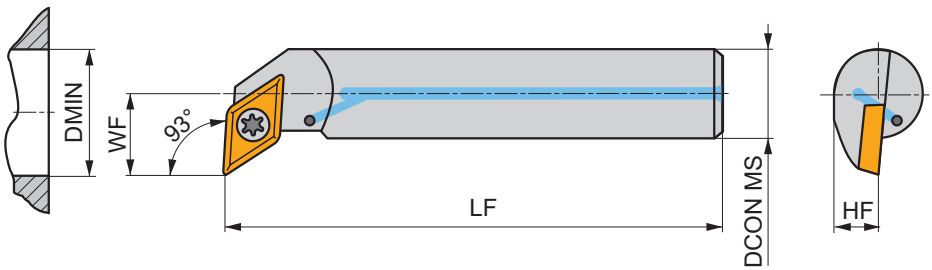
P M K N S H

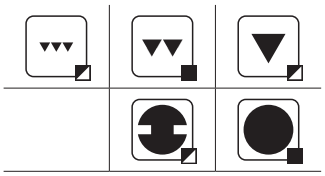
PRAMET

S

硬质合金内孔镗杆,螺钉夹紧,使用DC..刀片,主偏角为93°。
内孔左/右手硬质合金镗杆,有内冷通道,螺钉夹紧。主偏角为93°,使用DC..正前角刀片。适用于有阶梯孔的轴向车削,锥面,仿形和倒角车削。刀具悬伸>3xD。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	E10M-SDUCR 07-ER	10	15	9	5.6	150	-5	0	✓	0.14	GI052	SD21
	E12Q-SDUCR 07-ER	12	18	11	6.5	150	-5	0	✓	0.26	GI052	SD21
	E16R-SDUCR 07-ER	16	22	13	8.5	150	-5	0	✓	0.49	GI052	SD21
L	E10M-SDUCL 07-ER	10	15	9	5.6	150	-5	0	✓	0.15	GI052	SD21
	E12Q-SDUCL 07-ER	12	18	11	6.5	150	-5	0	✓	0.26	GI052	SD21
	E16R-SDUCL 07-ER	16	22	13	8.5	150	-5	0	✓	0.50	GI052	SD21

GI052	DC.. 0702..

SD21	5513 020-03	0.8	M 2.5	6.5	PT-8001

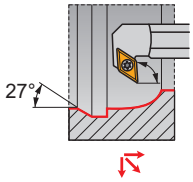
SDZC(RL) INT

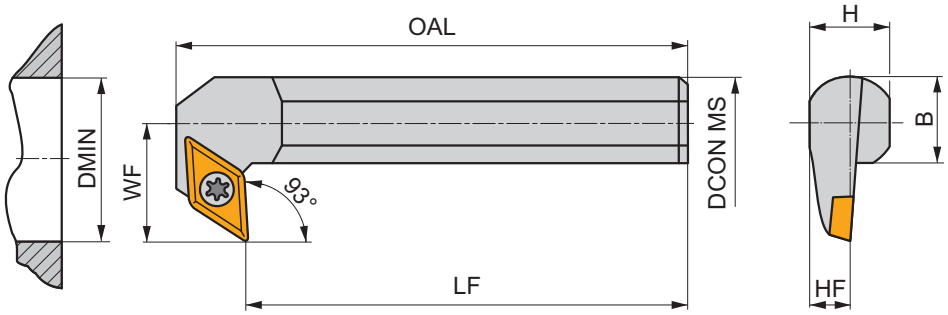
P M K N S H

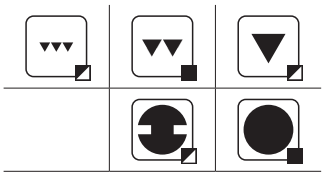
PRAMET

S

内孔镗杆,螺钉夹紧,使用DC..刀片,主偏角为93°。
内孔左/右手镗杆,主偏角为93°。螺钉夹紧。使用DC..刀片。适用于内孔有阶梯孔的轴向反向车削,锥面,仿形和倒角车削。刀杆经过处理,使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	OAL (mm)	LAMS (°)	GAMO (°)	kg		
R	**S16M-SDZCR 07-93**	16	27	17	14.5	15	150	163	-4	0	0.26	GI052	S01
	S20Q-SDZCR 11-93	20	35	22	18	18.5	180	198	-5	0	0.49	GI012	S08
	S25R-SDZCR 11-93	25	42	27	23	23	200	218	-3	0	0.79	GI012	S08
	S32S-SDZCR 11-93-A	32	53	35	30	30	250	268	-6	0	1.62	GI012	SD10
	S40T-SDZCR 11-93-A	40	65	43	38	38	300	322	-5	0	3.00	GI012	SD10
L	**S16M-SDZCL 07-93**	16	27	17	14.5	15	150	163	-4	0	0.27	GI052	S01
	S20Q-SDZCL 11-93	20	35	22	18	18.5	180	198	-5	0	0.48	GI012	S08
	S25R-SDZCL 11-93	25	42	27	23	23	200	218	-3	0	0.80	GI012	S08
	S32S-SDZCL 11-93-A	32	53	35	30	30	250	268	-6	0	1.60	GI012	SD10
	S40T-SDZCL 11-93-A	40	65	43	38	38	300	322	-5	0	3.00	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

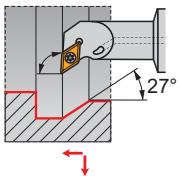
C.-SDUC(RL) INT

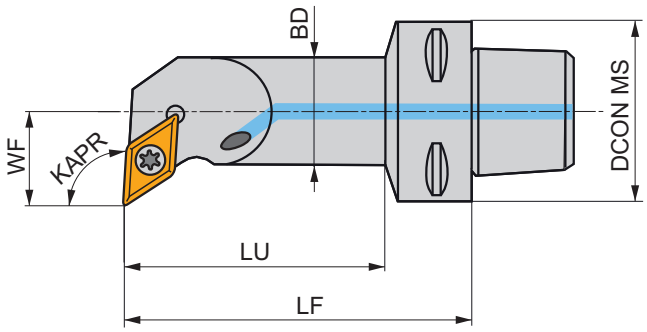
P M K N S H

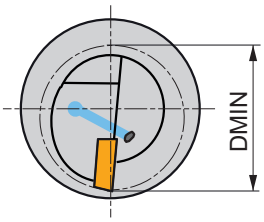
PRAMET

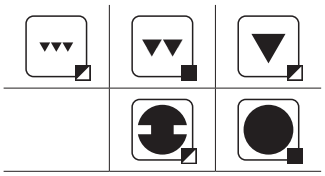
S

内孔PSC快换刀柄，螺钉夹紧，使用DC..刀片，主偏角为93°。
内孔左/右手刀具，有内冷通道，螺钉夹紧。主偏角为93°，使用DC..07或11刀片。广泛的应用于内孔车削。PSC刀柄尺寸C3至C5，可以选择长度。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SDUCR-11065-07	50	20	11	65	48	16	93	-4.3	0	✓	0.20	GI052	SV11
	C4-SDUCR-11070-07	40	20	11	70	47	16	93	-4.3	0	✓	0.35	GI052	SV11
	C4-SDUCR-13080-11	40	25	13	80	57	20	93	-5.8	0	✓	0.41	GI012	SC09M
	C4-SDUCR-17090-11	40	32	17	90	68	25	93	-3.4	0	✓	0.49	GI012	SV16
	C5-SDUCR-13080-11	50	25	13	80	56	20	93	-5.8	0	✓	0.60	GI012	SC09M
	C5-SDUCR-17090-11	50	32	17	90	67	25	93	-3.4	0	✓	0.68	GI012	SV16
L	C4-SDUCL-11070-07	40	20	11	70	47	16	93	-4.3	0	✓	0.35	GI052	SV11
	C4-SDUCL-13080-11	40	25	13	80	57	20	93	-5.8	0	✓	0.41	GI012	SC09M
	C4-SDUCL-17090-11	40	32	17	90	68	25	93	-3.4	0	✓	0.49	GI012	SV16
	C5-SDUCL-13080-11	50	25	13	80	56	20	93	-5.8	0	✓	0.60	GI012	SC09M

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm				
SC09M	US 2009-T15P	3.0	M 3.5	8.1	FLAG T15P/3,5	–
SV11	US 2003-T07P	0.8	M 2.5	6.5	–	FLAG T07P
SV16	US 2010-T15P	3.0	M 3.5	10.1	–	FLAG T15P/3,5

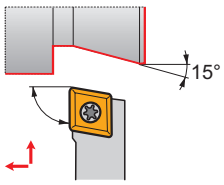
SEGC(RL) EXT

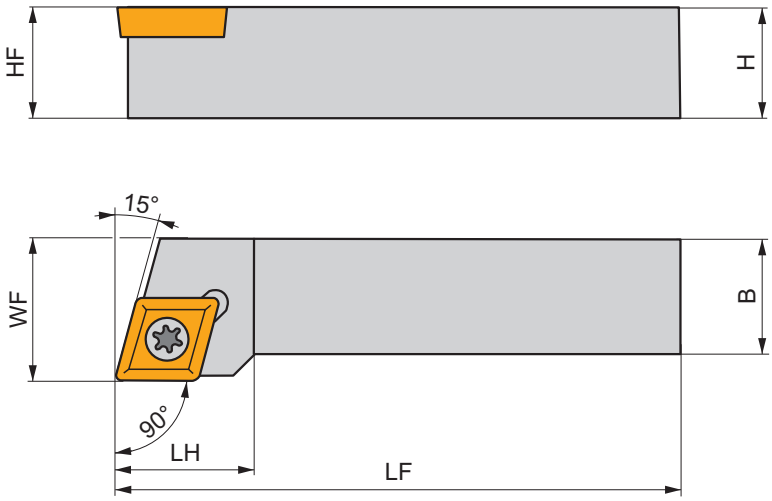
P M K N S H

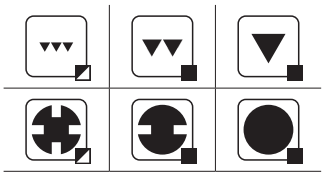
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用EC..刀片，主偏角为90°。
外圆用左/右手车刀杆，主偏角为90°，螺钉锁紧式。使用EC..08正前角刀片。适用于外圆表面，有阶梯外圆的轴向车削，锥面，倒角和端面车削。可提供12x12和16x16mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**SEGCR 1212 N 08**	12	12	12	16	160	12.0	0	0	0.15	GI210	SE08
	SEGCR 1616 H 08	16	16	16	20	100	12.0	0	0	0.22	GI210	SE08
L	**SEGCL 1212 N 08**	12	12	12	16	160	12.0	0	0	0.22	GI210	SE08
	SEGCL 1616 H 08	16	16	16	20	100	12.0	0	0	2.14	GI210	SE08

GI210	EC.. 0803..

SE08	416.1-832	3.6	M 3	8.5	PT-8002

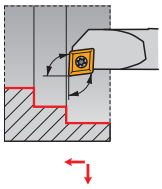
SEUC(RL) INT

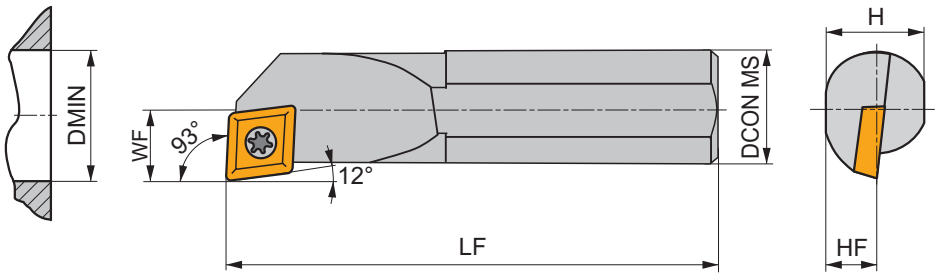
P M K N S H

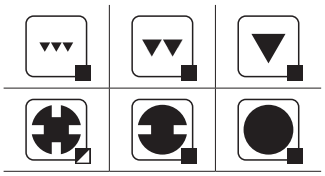
PRAMET

S

内孔镗杆,螺钉夹紧,使用EC..刀片,主偏角为93°
内孔左/右手镗杆,主偏角为93°。螺钉夹紧。使用EC..刀片。适用于内孔锥面,有阶梯孔的轴向车削,倒角车削。刀杆经过处理,使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	S08K-SEUCR 06	8	11	7	7	3.5	125	-5	0	0.06	GI213	SE23
	S10M-SEUCR 06	10	13	8	9	4.5	150	-5	0	0.10	GI213	SE23
	S12M-SEUCR 08	12	15	9	11	5.5	150	-5	0	0.14	GI210	SE24
	S16R-SEUCR 08	16	20	11	15	7.5	200	-5	0	0.32	GI210	SE24
	S20S-SEUCR 08	20	25	13	18	9	250	-5	0	0.58	GI210	SE24
	S25T-SEUCR 08	25	32	17	23	11.5	300	-4	0	1.06	GI210	SE24
L	S08K-SEUCL 06	8	11	7	7	3.5	125	-5	0	0.06	GI213	SE23
	S10M-SEUCL 06	10	13	8	9	4.5	150	-5	0	0.10	GI213	SE23
	S12M-SEUCL 08	12	15	9	11	5.5	150	-5	0	0.14	GI210	SE24
	S16R-SEUCL 08	16	20	11	15	7.5	200	-5	0	0.32	GI210	SE24
	S20S-SEUCL 08	20	25	13	18	9	250	-5	0	0.58	GI210	SE24

GI210	EC.. 0803..
GI213	EC.. 0602..

		Nm			
SE23	5513 020-03	0.8	M 2.5	6.5	PT-8001
SE24	416.1-832	3.6	M 3	8.5	PT-8003

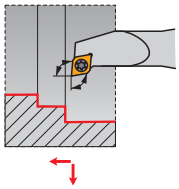
SELP(RL) INT

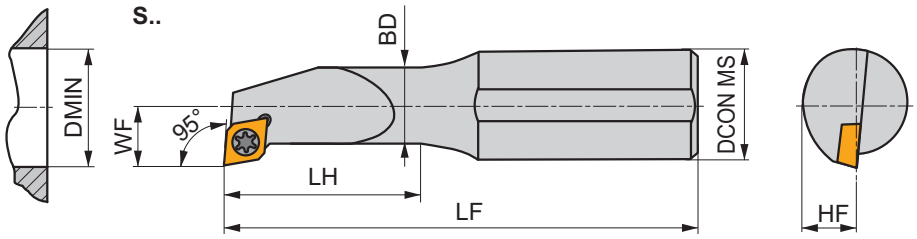
P M K N S H

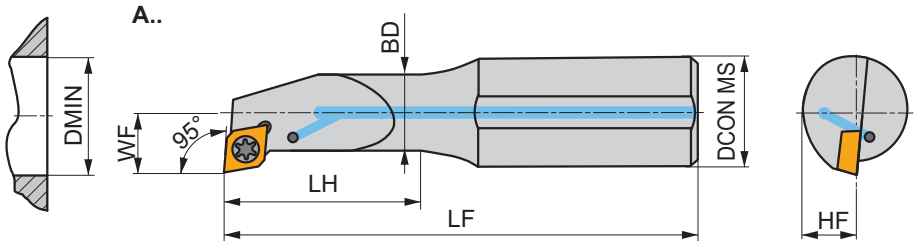
PRAMET

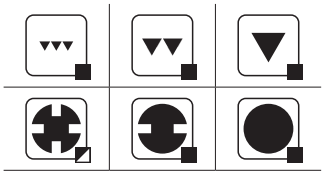
S

内孔螺钉夹紧镗杆，使用EP..刀片，主偏角为95°。
内孔左/右手镗杆，有内冷通道，螺钉夹紧。主偏角为95°。使用EP..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	S0608H-SELPR 05	8	8	6	4.5	100	20.0	-10	0	–	0.04	GI212	SE21
	S0810J-SELPR 05	10	11	8	6	110	26.0	-5	0	–	0.06	GI212	SE22
	S1012K-SELPR 05	12	13	10	7	125	32.0	-5	0	–	0.11	GI212	SE22
	A1216M-SELPR 05	16	16	12	9	150	40.0	-2	0	✓	0.18	GI212	SE22
	S1216M-SELPR 05	16	16	12	9	150	40.0	-2	0	–	0.21	GI212	SE22
L	S0608H-SELPL 05	8	8	6	4.5	100	20.0	-10	0	–	0.04	GI212	SE21
	S0810J-SELPL 05	10	11	8	6	110	26.0	-5	0	–	0.06	GI212	SE22
	S1012K-SELPL 05	12	13	10	7	125	32.0	-5	0	–	0.11	GI212	SE22
	S1216M-SELPL 05	16	16	12	9	150	40.0	-2	0	–	0.21	GI212	SE22

GI212	EP.. 0502..

		Nm			
SE21	28992	0.8	M 2.2	4.2	MA2-8304
SE22	28588	0.8	M 2.2	5.6	MA2-8304

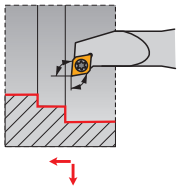
SELP(RL)-E INT

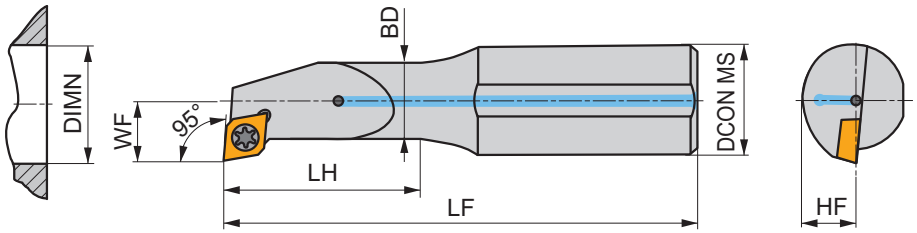
P M K N S H

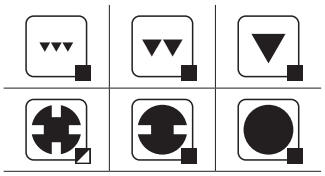
PRAMET

S

硬质合金内孔镗杆,螺钉夹紧,使用EP..刀片,主偏角为95°。
内孔左/右手硬质合金镗杆,有内冷通道,螺钉夹紧。主偏角为95°使用EP..刀片。适用于内孔锥面,有阶梯孔的轴向车削,和倒角车削。刀具悬伸>3xD。







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	E0608H-SELPR 05	8	8	6	4.5	100	28.0	-10	0	✓	0.06	GI212	SE22
	E0810J-SELPR 05	10	11	8	6	110	36.0	-5	0	✓	0.10	GI212	SE22
	E1012K-SELPR 05	12	13	10	7	125	44.0	-5	0	✓	0.17	GI212	SE22
L	E0608H-SELPL 05	8	8	6	4.5	100	28.0	-10	0	✓	0.06	GI212	SE22
	E0810J-SELPL 05	10	11	8	6	110	36.0	-5	0	✓	0.10	GI212	SE22
	E1216M-SELPL 05	16	16	12	9	150	55.0	-2	0	✓	0.33	GI212	SE22

GI212	EP.. 0502..

SE22	28588	0.8	M 2.2	5.6	MA2-8304

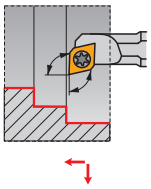
SEUP(RL) INT

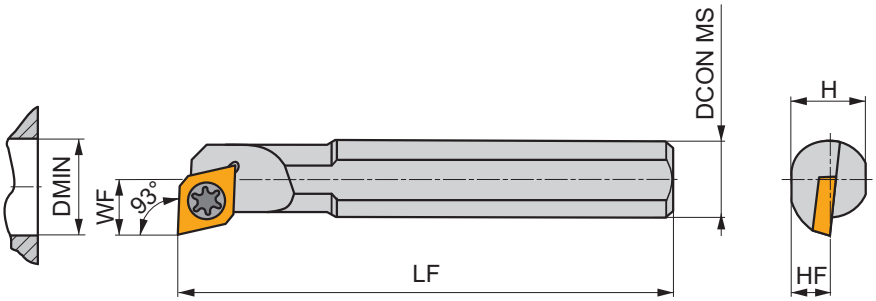
P M K N S H

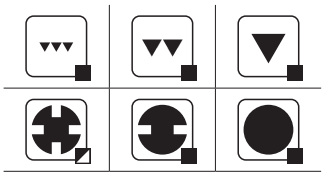
PRAMET

S

内孔镗杆,螺钉夹紧,使用EP..刀片,主偏角为93°。
内孔左/右手镗杆,主偏角为93°。螺钉夹紧。使用EP..刀片。适用于有用内孔锥面,有阶梯孔的轴向车削,和倒角车削。刀杆经过处理,使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**S06H-SEUPR 05**	6	8.3	5	5.4	2.7	100	-7	0	0.04	GI212	SE21
L	**S06H-SEUPL 05**	6	8.3	5	5.4	2.7	100	-7	0	0.05	GI212	SE21

GI212	EP.. 0502..

SE21	28992	0.8	M 2.2	4.2	MA2-8304

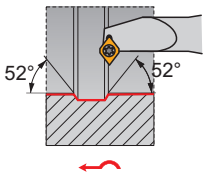
SEXP(RL) INT

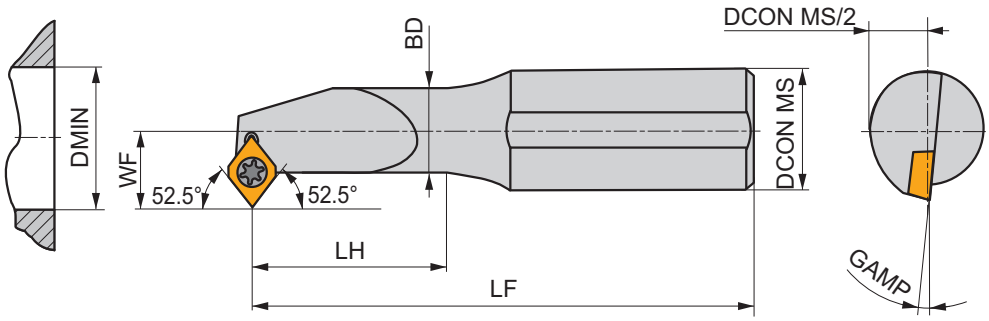
P M K N S H

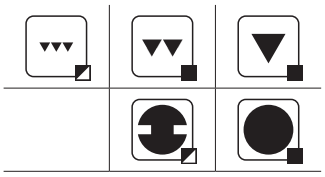
PRAMET

S

内孔螺钉夹紧式镗杆，使用EP..刀片，主偏角为52.5°。
内孔左/右手镗杆，螺钉夹紧。主偏角为52.5°，使用EP..刀片。适用于内孔反向倒角，锥面，仿形，倒角，和无阶梯孔的轴向车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)	kg		
R	S0608H-SEXPR 05	8	9.5	6	5.5	100	20.0	-7	0.04	GI212	SE21
	S0810J-SEXPR 05	10	11	8	6	110	26.0	-5	0.06	GI212	SE22
	S1012K-SEXPR 05	12	13	10	7	125	32.0	-5	0.11	GI212	SE22
	S1216M-SEXPR 05	16	16	12	9	150	40.0	-2	0.21	GI212	SE22
L	S0608H-SEXPL 05	8	9.5	6	5.5	100	20.0	-7	0.04	GI212	SE21
	S0810J-SEXPL 05	10	11	8	6	110	26.0	-5	0.06	GI212	SE22
	S1012K-SEXPL 05	12	13	10	7	125	32.0	-5	0.11	GI212	SE22
	S1216M-SEXPL 05	16	16	12	9	150	40.0	-2	0.21	GI212	SE22

GI212	EP.. 0502..

		Nm			
SE21	28992	0.8	M 2.2	4.2	MA2-8304
SE22	28588	0.8	M 2.2	5.6	MA2-8304

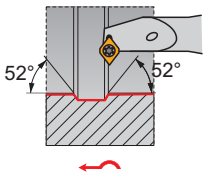
SEXP(RL)-E INT

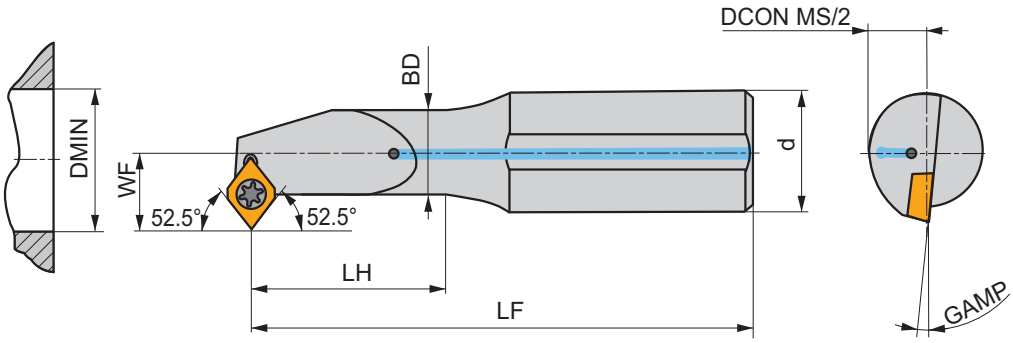
P M K N S H

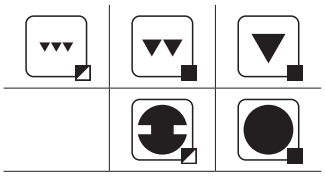
PRAMET

S

硬质合金内孔镗杆,螺钉夹紧,使用EP..刀片,主偏角为52.5°。
内孔左/右手硬质合金镗杆,有内冷通道,主偏角为52.5°,使用EP..刀片,螺钉夹紧。适用于内孔倒角车削,锥面,仿形,倒角,和无阶梯孔的轴向车削。刀具悬伸>3xD。







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		kg		
R	**E0608H-SEXPR 05**	8	9.5	6	5.5	100	28.0	-7	✓	0.07	GI212	SE21
R	**E0810J-SEXPR 05**	10	11	8	6	110	36.0	-5	✓	0.10	GI212	SE22
R	**E1012K-SEXPR 05**	12	13	10	7	125	44.0	-5	✓	0.16	GI212	SE22
R	**E1216M-SEXPR 05**	16	16	12	9	150	55.0	-2	✓	0.32	GI212	SE22
L	**E0608H-SEXPL 05**	8	9.5	6	5.5	100	28.0	-7	✓	0.06	GI212	SE21

GI212	EP.. 0502..

		Nm			
SE21	28992	0.8	M 2.2	4.2	MA2-8304
SE22	28588	0.8	M 2.2	5.6	MA2-8304

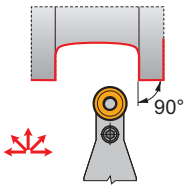
PRDCN EXT

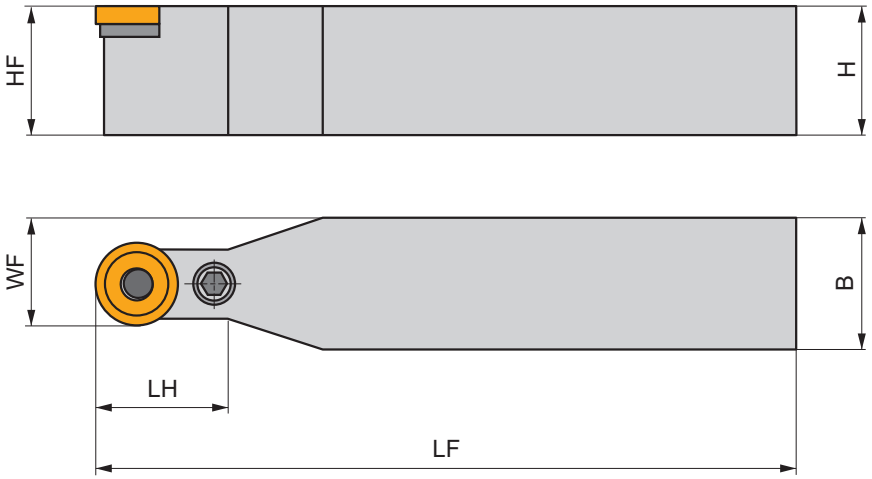
P M K N S H

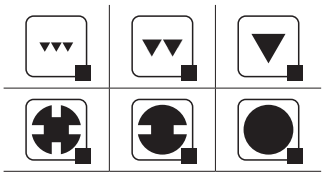
PRAMET

P

外圆用杠杆夹紧式车刀杆，使用圆形RC..刀片。
外圆用中置杠杆夹紧式车刀杆，使用RC..16至32正前角刀片。适用于外圆表面，无阶梯外圆的轴向车削，仿形车削角度最大为90°。锥面和倒角车削。可提供32x25至50x50mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	**PRDCN 3225 P 16**	32	25	32	20.5	170	34.0	0	0	0.80	GI090	PR01
	PRDCN 3232 P 20	32	32	32	26	170	42.0	0	0	1.16	GI069	PR03
	PRDCN 4040 S 20	40	40	40	30	250	40.0	0	0	2.82	GI069	PR03
	PRDCN 4040 S 25	40	40	40	32.5	250	40.0	0	0	2.75	GI122	PR02
	PRDCN 5050 V 32	50	50	50	41	400	52.0	0	0	7.30	GI096	PR04

GI069	RCMX 2006M0
GI090	RCMX 1606M0
GI096	RCMX 3209M0
GI122	RCMX 2507M0

				Nm					
PR01	PRS 816	CL 116	CS 706	2.0	M 6x1	20.7	TR 16	MT 05	HXK 2.5
PR02	PRS 825	CL 125	CS 710	3.5	M 10x1	30.4	TR 19	MT 06	HXK 4
PR03	PRS 820	CL 120	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3
PR04	PRS 832	CL 132	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5

PRSC(RL) EXT

P M K N S H

PRAMET

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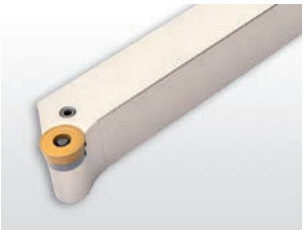
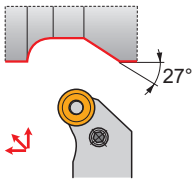
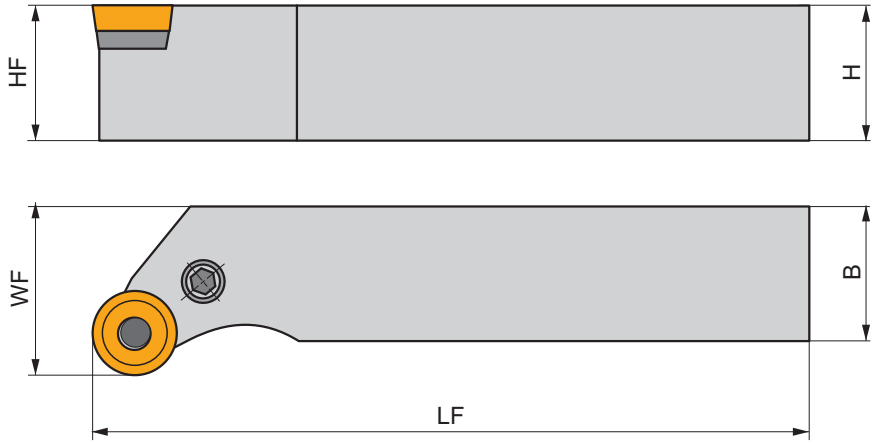
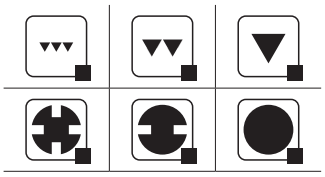
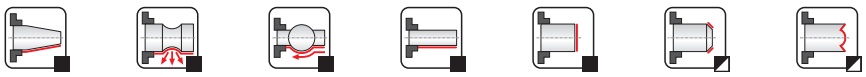


外圆用杠杆夹紧式车刀杆，使用圆形RC..刀片。
外圆用左/右手杠杆夹紧式车刀杆，使用RC..16至25正前角刀片。适用于外圆表面，无阶梯外圆的轴向车削，仿形车削角度最大为27°，锥面，倒角车削，包括端面仿形车削。可提供32x25至40x40mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**PRSCR 3225 P 16**	32	25	32	32	170	0	0	1.05	GI090	PR01
	PRSCR 3232 P 20	32	32	32	40	170	0	0	1.29	GI069	PR03
	PRSCR 4040 S 16	40	40	40	50	250	0	0	3.00	GI090	PR01
	PRSCR 4040 S 25	40	40	40	50	250	0	0	3.04	GI122	PR02
L	**PRSCL 3225 P 16**	32	25	32	32	170	0	0	0.90	GI090	PR01
	PRSCL 4040 S 16	40	40	40	50	250	0	0	2.38	GI090	PR01
	PRSCL 3232 P 20	32	32	32	40	170	0	0	1.32	GI069	PR03
	PRSCL 4040 S 25	40	40	40	50	250	0	0	3.06	GI122	PR02

GI069	RCMX 2006MO
GI090	RCMX 1606MO
GI122	RCMX 2507MO

				Nm					
PR01	PRS 816	CL 116	CS 706	2.0	M 6x1	20.7	TR 16	MT 05	HXK 2.5
PR02	PRS 825	CL 125	CS 710	3.5	M 10x1	30.4	TR 19	MT 06	HXK 4
PR03	PRS 820	CL 120	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3

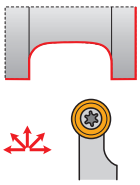
SRDC(RL) EXT

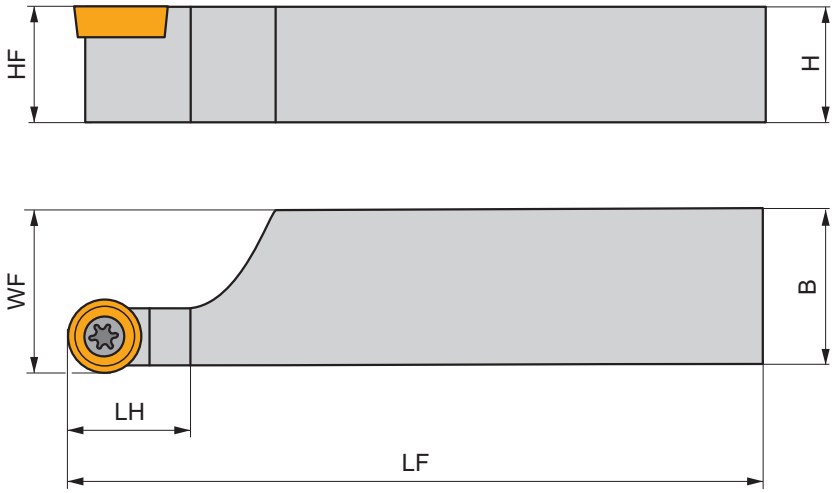
P M K N S H

PRAMET

S

外圆用螺钉夹紧式车刀杆，使用圆形RC..刀片。
外圆用左/右手车刀杆，螺钉锁紧式。使用RC..08正前角刀片。适用于外圆表面，无阶梯外圆的轴向车削，锥面倒角车削。可提供20x20至32x25mm的刀柄。刀杆经过处理，使用寿命更长。





	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**SRDCR 2020 K 08-A**	20	20	20	20.5	125	20.0	0	0	0.36	GI051	SR21
	SRDCR 2525 M 08-A	25	25	25	25.5	150	20.0	0	0	0.66	GI051	SR21
	SRDCR 3225 P 08-A	32	25	32	25.5	170	20.0	0	0	0.95	GI051	SR21
L	**SRDCL 2020 K 08-A**	20	20	20	20.5	125	20.0	0	0	0.37	GI051	SR21
	SRDCL 2525 M 08-A	25	25	25	25.5	150	20.0	0	0	0.66	GI051	SR21
	SRDCL 3225 P 08-A	32	25	32	25.5	170	20.0	0	0	0.96	GI051	SR21

GI051	RC.. 0803MO

SR21	5513 020-04	1.5	M 3	7.2	PT-8002

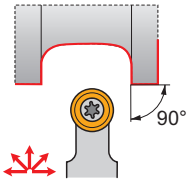
SRDCN EXT

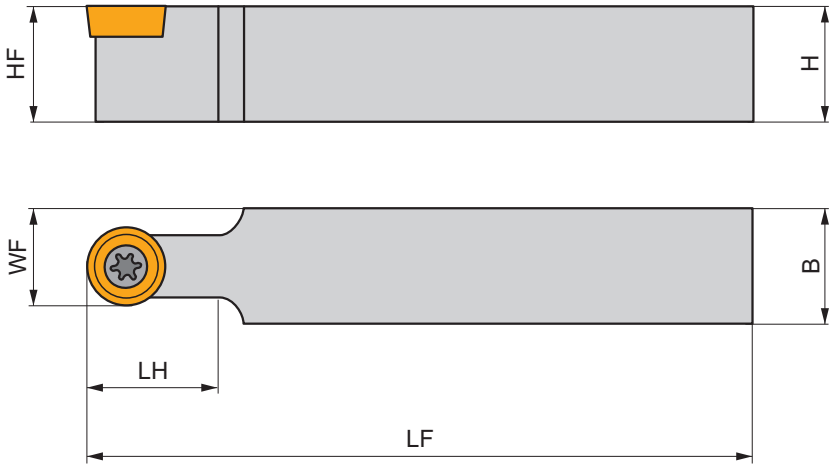
P M K N S H

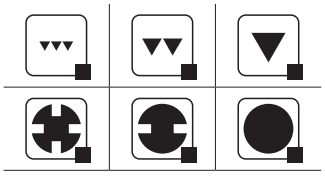
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用圆形RC..刀片。
外圆用中置车刀杆，螺钉锁紧式。使用RC..06至16正前角刀片。适用于外圆表面，无阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供12x12至32x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	**SRDCN 1212 F 06**	12	12	12	9	80	12.0	0	0	0.10	GI054	S01
	SRDCN 1616 H 06	16	16	16	11	100	12.0	0	0	0.20	GI054	S01
	SRDCN 2020 K 08	20	20	20	14	125	20.0	0	0	0.37	GI051	S03
	SRDCN 2020 K 1003-M-A	20	20	20	15	125	25.0	0	0	0.38	GI064	SR10
	SRDCN 2020 K 10-M-A	20	20	20	15	125	25.0	0	0	0.37	GI013	SR10
	SRDCN 2525 M 10-M-A	25	25	25	17.5	150	25.0	0	0	0.67	GI013	SR10
	SRDCN 2525 M 12-M-A	25	25	25	18.5	150	30.0	0	0	0.08	GI014	SR12
	SRDCN 3225 P 10-M	32	25	32	17.5	170	25.0	0	0	0.90	GI013	SR10
	SRDCN 3225 P 12-M	32	25	32	18.5	170	30.0	0	0	0.90	GI014	SR12
	SRDCN 3225 P 16-M	32	25	32	20.5	170	32.0	0	0	1.00	GI161	SR16

GI013	RC.. 10T3M0
GI014	RC.. 1204M0
GI051	RC.. 0803M0
GI054	RC.. 0602M0
GI064	RC.. 1003M0
GI161	RC.. 1606M0

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S03	US 3007-T09P	2.0	M 3	7.3	–	–	FLAG T09P	–
SR10	US 3510-T15P	3.0	M 3.5	10.6	SRN 100300	MS 3510	FLAG T15P	HXK 3.5
SR12	US 3510-T15P	3.0	M 3.5	10.6	SRN 120300	MS 3510	FLAG T15P	HXK 3.5
SR16	US 5018-T20P	5.0	M 5	18.2	SRN 16T3M0	MS 5015	FLAG T20P	HXK 5

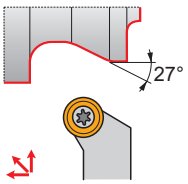
SRSC(RL) EXT

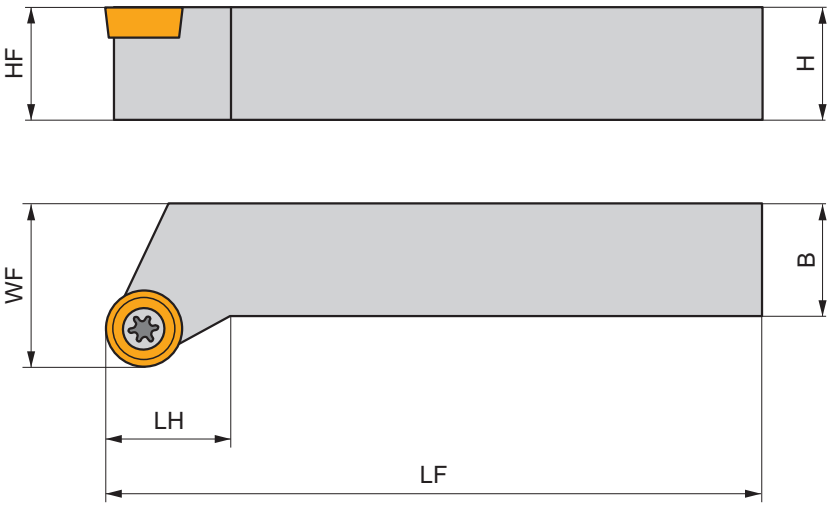
P M K N S H

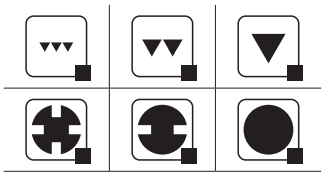
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用圆形RC..刀片。
外圆用左/右手车刀杆，螺钉锁紧式。使用RC..06至16正前角刀片。适用于外圆表面，无阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供12x12至32x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SRSCR 1212 F 06**	12	12	12	16	80	12.0	0	0	0.09	GI054	S01
	SRSCR 1616 H 06	16	16	16	20	100	12.0	0	0	0.21	GI054	S01
	SRSCR 2020 K 08	20	20	20	25	125	20.0	0	0	0.40	GI051	S03
	SRSCR 2020 K 10-M-A	20	20	20	25	125	20.0	0	0	0.41	GI013	SR10
	SRSCR 2525 M 10-M-A	25	25	25	32	150	20.0	0	0	0.75	GI013	SR10
	SRSCR 3225 P 10-M	32	25	32	32	170	20.0	0	0	1.06	GI013	SR10
	SRSCR 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	0.75	GI014	SR12
	SRSCR 3225 P 16-M	32	25	32	32	170	20.0	0	0	1.08	GI161	SR16
L	**SRSCL 1212 F 06**	12	12	12	16	80	12.0	0	0	0.10	GI054	S01
	SRSCL 1616 H 06	16	16	16	20	100	12.0	0	0	0.22	GI054	S01
	SRSCL 2020 K 08	20	20	20	25	125	20.0	0	0	0.45	GI051	S03
	SRSCL 2020 K 10-M-A	20	20	20	25	125	20.0	0	0	0.42	GI013	SR10
	SRSCL 2525 M 10-M-A	25	25	25	32	150	20.0	0	0	0.74	GI013	SR10
	SRSCL 3225 P 10-M	32	25	32	32	170	20.0	0	0	1.06	GI013	SR10
	SRSCL 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	0.75	GI014	SR12
	SRSCL 3225 P 16-M	32	25	32	32	170	20.0	0	0	1.08	GI161	SR16

GI013	RC.. 10T3M0
GI014	RC.. 1204M0
GI051	RC.. 0803M0
GI054	RC.. 0602M0
GI161	RC.. 1606M0

SO1	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SO3	US 3007-T09P	2.0	M 3	7.3	–	–	FLAG T09P	–
SR10	US 3510-T15P	3.0	M 3.5	10.6	SRN 100300	MS 3510	FLAG T15P	HXK 3.5
SR12	US 3510-T15P	3.0	M 3.5	10.6	SRN 120300	MS 3510	FLAG T15P	HXK 3.5
SR16	US 5018-T20P	5.0	M 5	18.2	SRN 16T3MO	MS 5015	FLAG T20P	HXK 5

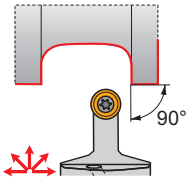
C.-SRDCN EXT

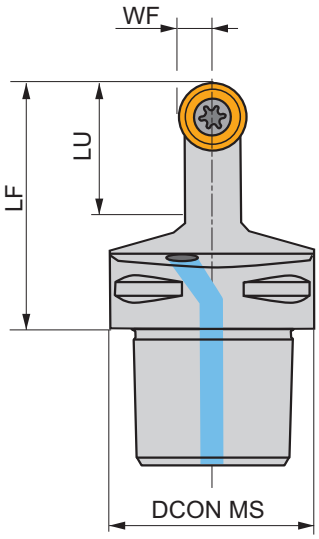
P M K N S H

PRAMET

S

外圆用PSC快速更换式刀柄，使用RC..刀片，螺钉夹紧式。
外圆用中置刀具，有内冷通道，螺钉锁紧式。使用RC..10至12正前角刀片。适用于外圆表面，无阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供C4和C5的PSC。刀杆经过处理，使用寿命更长。





Product	DCON MS (mm)	WF (mm)	LF (mm)	LU (mm)	LAMS (°)	GAMO (°)		kg		
N										
C4-SRDCN-00050-12A	40	6	50	28	0	0	✓	0.32	GI014	C-SR12V-1
C5-SRDCN-00060-10A	50	5	60	25	0	0	✓	0.56	GI013	C-SR10V
C5-SRDCN-00060-12A	50	6	60	28	0	0	✓	0.56	GI014	C-SR12V-2

GI013	RC.. 10T3M0
GI014	RC.. 1204M0

		Nm						
C-SR10V	US 2010-T15P	3.0	M 3.5	10.1	SRS 110-01	MS 9001	FLAG T15P/3,5	CN 034-02
C-SR12V-1	US 2001-T15P	3.0	M 3.5	12.1	SRS 110-02	MS 9001	FLAG T15P/3,5	CN 034-01
C-SR12V-2	US 2001-T15P	3.0	M 3.5	12.1	SRS 110-02	MS 9001	FLAG T15P/3,5	CN 034-02

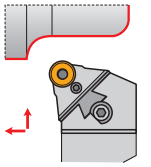
KHP-RSC(RL)

P M K

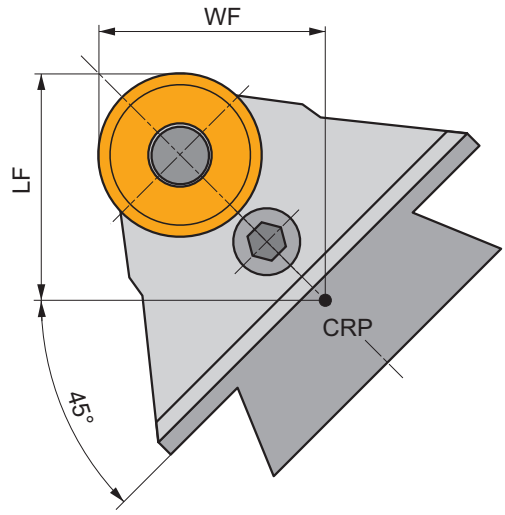
PRAMET

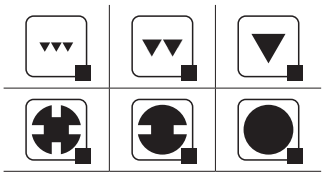
P

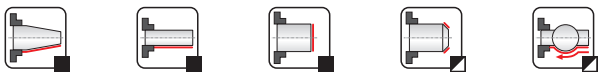
模块化KHP杠杆夹紧车刀刀夹，使用RC..刀片。
燕尾形左/右手杠杆夹紧车刀夹，安装在DKH刀杆上。使用RC..20至32负前角正前角刀片。适用于无阶梯外圆的重载轴向车削，端面车削，锥面和倒角车削。车刀杆经过处理，使用寿命更长。



DKHR+KHP-RSCR







	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-RSCR 20**	35	45	0	0	1.25	GI069	PRP90
	KHP-RSCL 20	35	45	0	0	1.30	GI069	PRP90

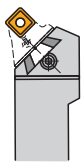
GI069	RCMX 2006MO

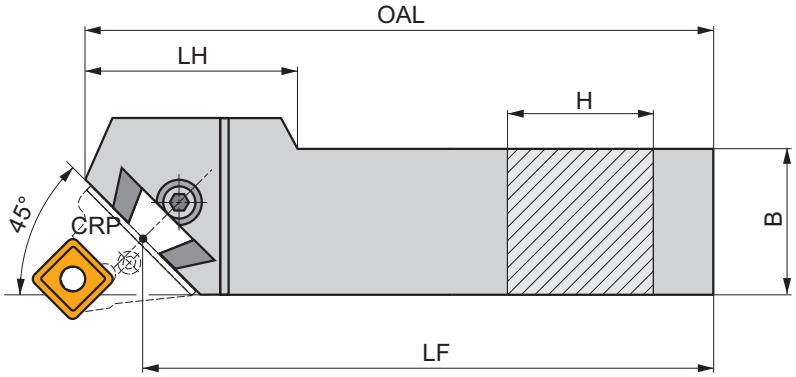
PRP90	RCU 200400	CL 120	US 36	6.0 Nm	M 8x1	26	NT 07	MT 07	HXK 4

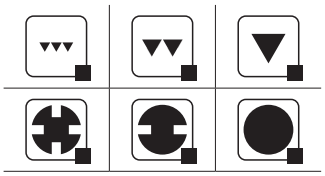
DKH(RL)

PRAMET

使用KHP/KHS重载车刀刀夹的外圆用刀柄
燕尾形左/右手模块化刀杆，使用KHP/KHS刀夹。适用于重载车削应用。可提供40x50至60x80mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

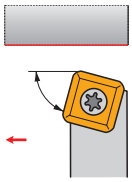
SSBC(RL) EXT

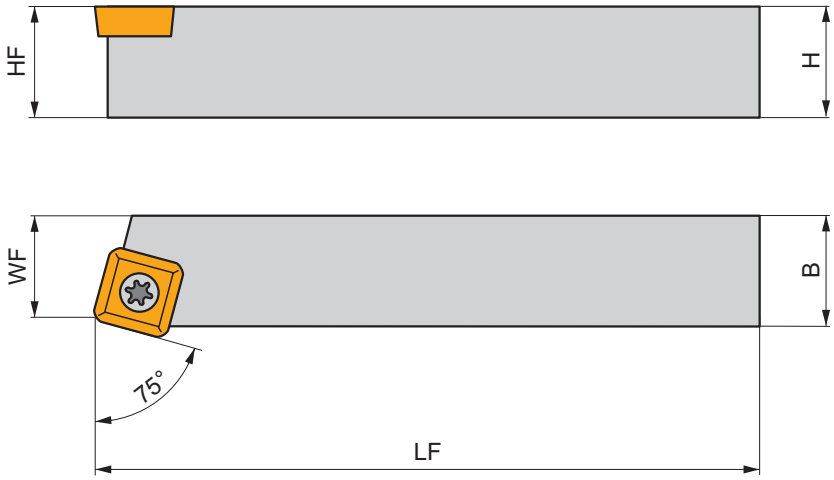
P M K N S H

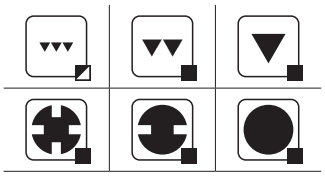
PRAMET

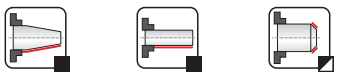
S

外圆用螺钉夹紧式车刀杆，使用SC..刀片，主偏角为75°
外圆用左/右手车刀杆，螺钉锁紧式。使用SC..09至38正前角刀片。适用于无阶梯外圆的轴向车削，锥面倒角车削。可提供的12x12至60x60mm刀柄。刀杆经过处理，使用寿命更长。









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	SSBCR 1212 F 09	12	12	12	11	80	0	0	0.10	GI053	S08
	SSBCR 1616 H 09	16	16	16	13	100	0	0	0.20	GI053	S08
	SSBCR 2020 K 12-M-A	20	20	20	17	125	0	0	0.40	GI015	SS20
	SSBCR 2525 M 12-M-A	25	25	25	22	150	0	0	0.76	GI015	SS20
	SSBCR 4040 S 25	40	40	40	35	250	0	0	3.01	GI131	SS25
	SSBCR 5050 T 25	50	50	50	43	300	0	0	5.65	GI131	SS25
	SSBCR 5050 T 38-A	50	50	50	43	300	0	0	4.84	GI164	SS38A
	SSBCR 6060 V 38-A	60	60	60	53	400	0	0	11.10	GI164	SS38A
L	SSBCL 1212 F 09	12	12	12	11	80	0	0	0.10	GI053	S08
	SSBCL 1616 H 09	16	16	16	13	100	0	0	0.22	GI053	S08
	SSBCL 2020 K 12-M-A	20	20	20	17	125	0	0	0.40	GI015	SS20
	SSBCL 2525 M 12-M-A	25	25	25	22	150	0	0	0.70	GI015	SS20
	SSBCL 4040 S 25	40	40	40	35	250	0	0	3.01	GI131	SS25
	SSBCL 5050 T 25	50	50	50	43	300	0	0	5.65	GI131	SS25
	SSBCL 5050 T 38-A	50	50	50	43	300	0	0	5.78	GI164	SS38A
	SSBCL 6060 V 38-A	60	60	60	53	400	0	0	11.16	GI164	SS38A

GI015	SC.. 1204..
GI053	SC.. 09T3..
GI131	SC.. 2509..
GI164	SC.. 3809..

		Nm							
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	–
SS20	US 5012-T15P	5.0	M 5	12.2	SSN 120304	MS 5008	FLAG T15P	HXK 5	–
SS25	US 8025-T30P	13.0	M 8	24.2	SSN 250620	MS 8020	–	HXK 5	SDR T30P
SS38A	US 8025-T30P	13.0	M 8	24.2	SSN 380920	MS 8020	–	HXK 5	SDR T30P

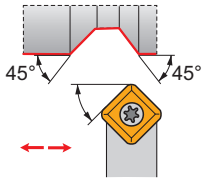
SSDCN EXT

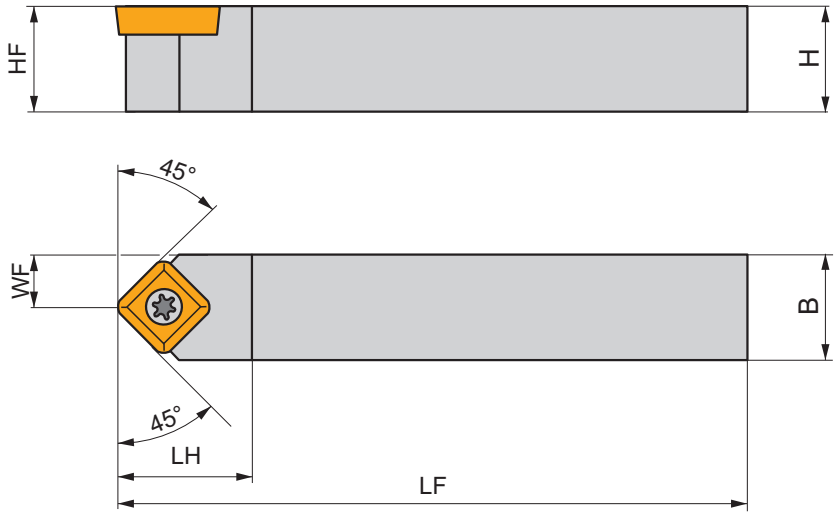
P M K N S H

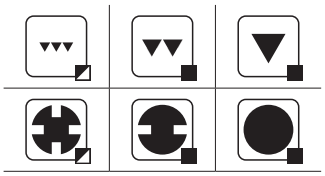
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用SC..刀片，主偏角为45°
外圆用中置车刀杆，螺钉锁紧式。使用SC..09或12正前角刀片。适用于无阶梯外圆的轴向切削，仿形，锥面和倒角车削。可提供12x12至25x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
N	**SSDCN 1212 F 09**	12	12	12	6	80	–	0	0	0.11	GI053	S08
	SSDCN 1616 H 09	16	16	16	8	100	–	0	0	0.20	GI053	S08
	SSDCN 2020 K 12-M-A	20	20	20	10	125	–	0	0	0.41	GI015	SS20
	SSDCN 2525 M 12-M-A	25	25	25	12.5	150	–	0	0	0.74	GI015	SS20

GI015	SC.. 1204..
GI053	SC.. 09T3..

		Nm						
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SS20	US 5012-T15P	5.0	M 5	12.2	SSN 120304	MS 5008	FLAG T15P	HXK 5

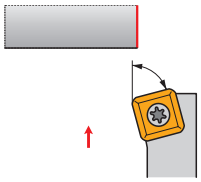
SSKC(RL) EXT

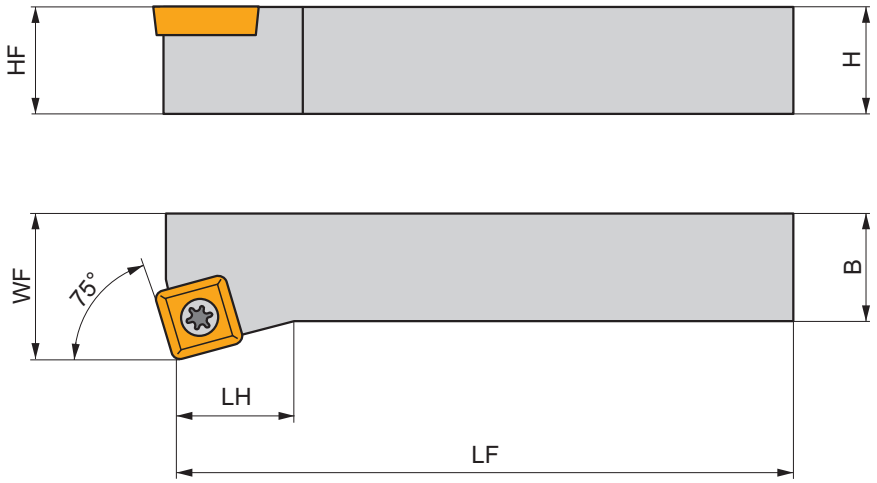
P M K N S H

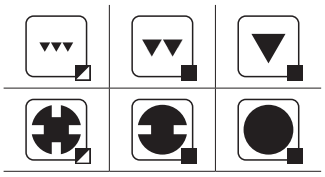
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用SC..刀片，主偏角为75°（端面车削）
外圆用左/右手车刀杆，螺钉锁紧式。使用SC..09至12正前角刀片。适用于无阶梯外圆车削，倒角车削。
可提供12x12至25x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**SSKCR 1212 F 09**	12	12	12	16	80	32.0	0	0	0.10	GI053	S08
	SSKCR 1616 H 09	16	16	16	20	100	32.0	0	0	0.25	GI053	S08
	SSKCR 2020 K 12-M-A	20	20	20	25	125	36.0	0	0	0.75	GI015	SS20
	SSKCR 2525 M 12-M-A	25	25	25	32	150	36.0	0	0	0.75	GI015	SS20

GI015	SC.. 1204..
GI053	SC.. 09T3..

		Nm						
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SS20	US 5012-T15P	5.0	M 5	12.2	SSN 120304	MS 5008	FLAG T15P	HXK 5

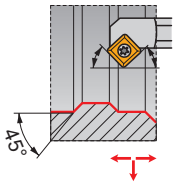
SSSC(RL) INT

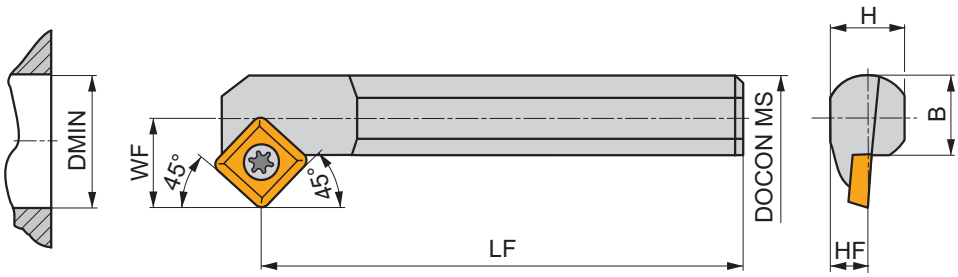
P M K N S H

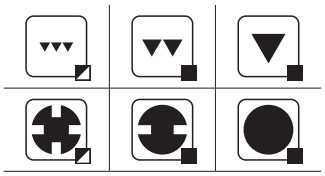
PRAMET

S

内孔镗杆,螺钉夹紧,使用SC..刀片,主偏角为45°。
内孔左/右手镗杆,螺钉夹紧。使用SC..刀片,主偏角为45°。适用于内孔用倒角车削,锥面,仿形,倒角和无阶梯孔的轴向车削。刀杆经过处理,使用寿命更长。







	Product	DCON MS	DMIN	WF	H	B	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**S20S-SSSCR 09**	20	25	13	18	18.5	250	-5	0	0.61	GI053	S04
	S25T-SSSCR 09	25	32	17	23	23	300	-3	0	1.10	GI053	S04
L	**S20S-SSSCL 09**	20	25	13	18	18.5	250	-5	0	0.05	GI053	S04
	S25T-SSSCL 09	25	32	17	23	23	300	-3	0	1.10	GI053	S04

GI053	SC.. 09T3..

S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P

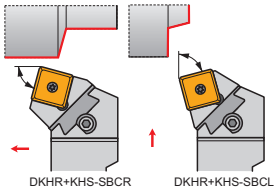
KHS-SBC(RL)

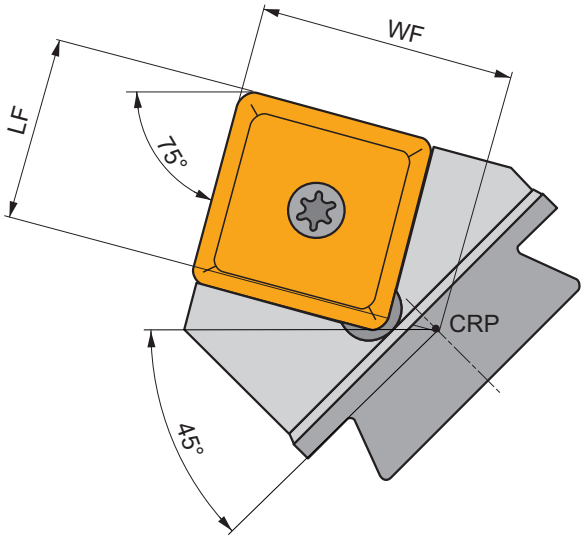
P M K

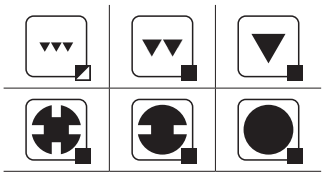
PRAMET

S

模块化KHS螺钉夹紧车刀刀夹，使用SC..刀片，主偏角为75°。
燕尾形左/右手杠杆夹紧车刀夹，主偏角为75°。安装在DKH刀杆上。使用SC..25或38正前角刀片。适用于无阶梯外圆的重载轴向车削，端面车削，锥面和倒角车削。车刀杆经过处理，使用寿命更长。







	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHS-SBCR 25**	47	36	0	0	1.50	GI131	SS26
	KHS-SBCR 38-A	47	36	0	0	1.47	GI164	SS38
L	**KHS-SBCL 25**	47	36	0	0	1.45	GI131	SS26
	KHS-SBCL 38-A	47	36	0	0	1.48	GI164	SS38

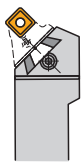
GI131	SC.. 2509..
GI164	SC.. 3809..

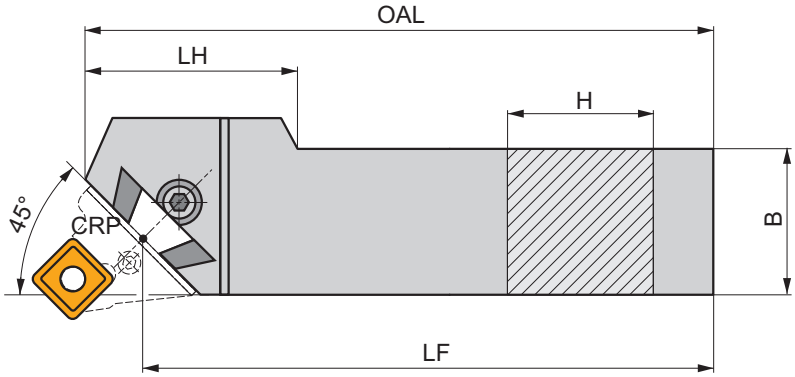
		Nm						
SS26	US 8025-T30P	13.0	M 8	24.2	SSN 250620	MS 8020	SDR T30P	HXK 5
SS38	US 8025-T30P	13.0	M 8	24.2	SSN 380620	MS 8020	SDR T30P	HXK 5

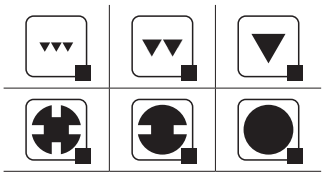
DKH(RL)

PRAMET

使用KHP/KHS重载车刀刀夹的外圆用刀柄
燕尾形左/右手模块化刀杆，使用KHP/KHS刀夹。适用于重载车削应用。可提供40x50至60x80mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

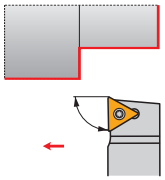
STAC(RL) EXT

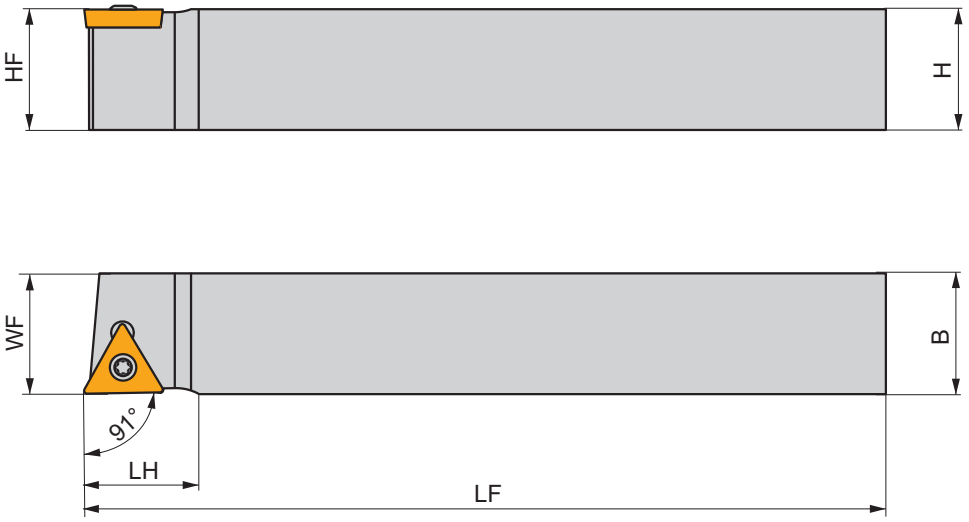
P M K N S H

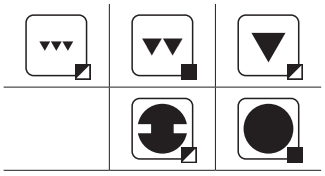
PRAMET

S

外圆用螺钉夹紧式车刀杆，主偏角为91°，使用TC.. 刀片
外圆用右/左手车刀杆，使用正前角TC.. 11和16刀片。适用于外圆带肩轴向车削、锥度车削和倒角车削。
提供12×12mm至16×16mm的刀柄，可用于纵切机床。刀杆经过处理，延长了使用寿命。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	STACR 1212 K 11-S	12	12	12	12	125	15.2	0	0	0.14	GI056	S01
	STACR 1616 K 11-S	16	16	16	16	125	15.2	0	0	0.25	GI056	S01
L	STACL 1212 K 11-S	12	12	12	12	125	15.2	0	0	0.14	GI056	S01
	STACL 1616 K 11-S	16	16	16	16	125	15.2	0	0	0.25	GI056	S01

GI056	TC.. 1102..

S01	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

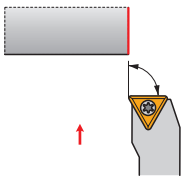
STFC(RL) EXT

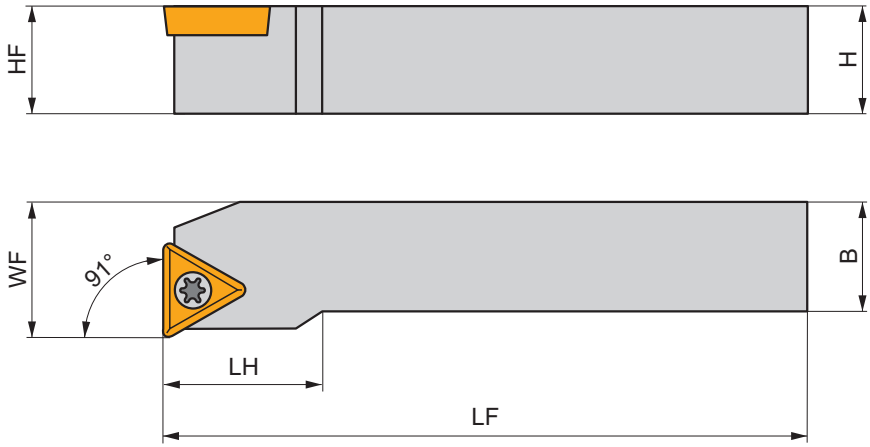
P M K N S H

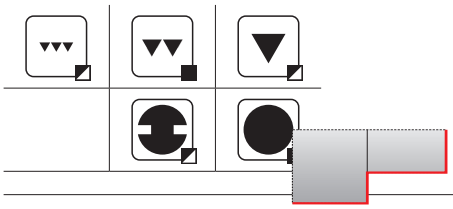
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用TC..刀片，主偏角为91°（端面车削）。
外圆用左/右手车刀杆，螺钉锁紧式。使用TC..11至16正前角刀片。适用于有阶梯外圆的端面车削，和倒角车削。可提供16x16至25x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**STFCR 1616 H 11**	16	16	16	20	100	18.0	0	0	0.20	GI056	S01
	STFCR 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.40	GI016	ST10
	STFCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.75	GI016	ST10
L	**STFCL 1616 H 11**	16	16	16	20	100	18.0	0	0	0.22	GI056	S01
	STFCL 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.40	GI016	ST10
	STFCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.75	GI016	ST10

GI016	TC.. 16T3..
GI056	TC.. 1102..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
ST10	US 3510-T15P	3.0	M 3.5	10.6	STN 160308	MS 3510	FLAG T15P	HXK 3.5

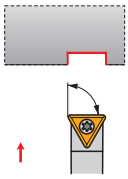
STFC(RL)-A EXT

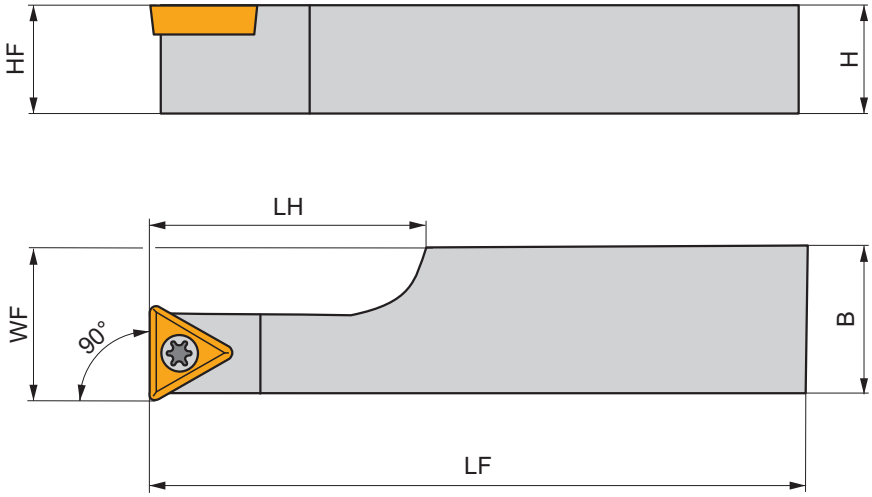
P M K N S H

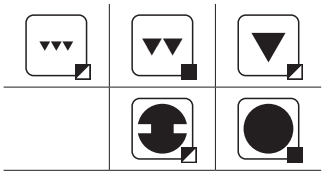
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用TC..刀片，主偏角为90°（端面车削）。
外圆用左/右手车刀杆，螺钉锁紧式。使用TC..11正前角刀片。适用于左右两侧有阶梯外圆的端面车削，和倒角车削。可提供20x20mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**STFCR 2020 K 11-A**	20	20	20	25	125	21.3	0	0	0.37	GI056	ST21
L	**STFCL 2020 K 11-A**	20	20	20	25	125	21.3	0	0	0.36	GI056	ST21

GI056	TC.. 1102..

ST21	5513 020-03	0.8	M 2.5	6.5	PT-8001

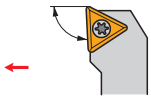
STJC(RL) EXT

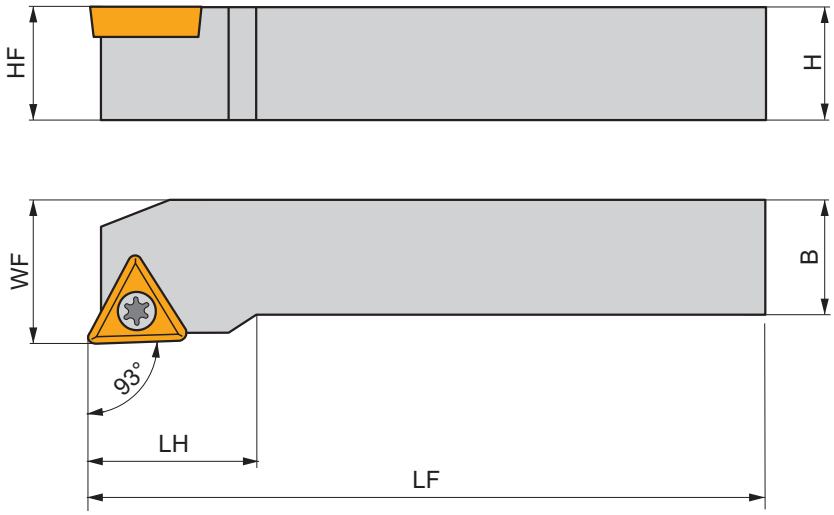
P M K N S H

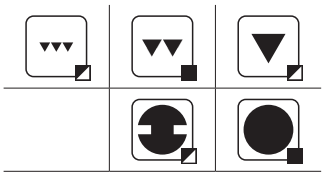
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用TC..刀片，主偏角为93°。
外圆用左/右手车刀杆，螺钉锁紧式。使用TC..11至16正前角刀片。适用于有阶梯外圆的轴向车削，锥面和倒角车削。可提供16x16至25x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**STJCR 1616 H 11**	16	16	16	20	100	18.0	0	0	0.22	GI056	S01
	STJCR 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.43	GI016	ST10
	STJCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.76	GI016	ST10
L	**STJCL 1616 H 11**	16	16	16	20	100	18.0	0	0	0.22	GI056	S01
	STJCL 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.43	GI016	ST10
	STJCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.75	GI016	ST10

GI016	TC.. 16T3..
GI056	TC.. 1102..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
ST10	US 3510-T15P	3.0	M 3.5	10.6	STN 160308	MS 3510	FLAG T15P	HXK 3.5

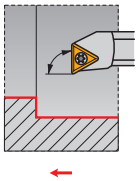
STFC(RL) INT

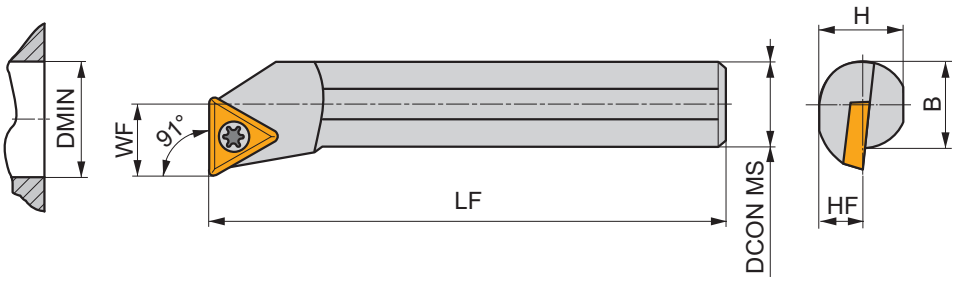
P M K N S H

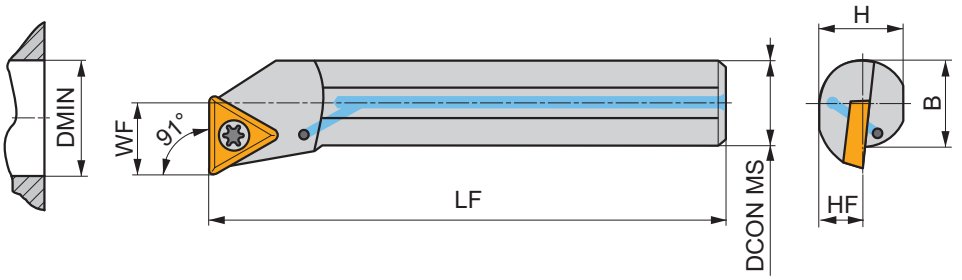
PRAMET

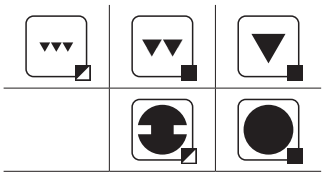
S

内孔螺钉夹紧镗杆，使用TC..刀片，主偏角为91°。
内孔左/右手镗杆，有内冷通道，螺钉夹紧。主偏角为91°，使用TC..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A06F-STFCR 06	6	8.5	4.5	5	–	80	-12	0	✓	0.02	GI217	ST12
	A08H-STFCR 06	8	11	5.9	7	–	100	-10	0	✓	0.05	GI217	ST13
	A10K-STFCR 09	10	13	7	9	–	125	-9	0	✓	0.06	GI218	ST14
	A12M-STFCR 09	12	16	9	11	–	150	-6.5	0	✓	0.12	GI218	ST14
	S10H-STFCR 11	10	13	7	9	9.5	100	-10	0	–	0.08	GI056	S02
	A12M-STFCR 11	12	16	9	11	11.5	150	-10	0	✓	0.14	GI056	S01
	S12K-STFCR 11	12	16	9	11	11.5	125	-7	0	–	0.13	GI056	S01
	A16R-STFCR 11	16	20	11	14.5	15	200	-7	0	✓	0.30	GI056	S01
	S16M-STFCR 11	16	20	11	14.5	15	150	-7	0	–	0.24	GI056	S01
	A20S-STFCR 11	20	25	13	18	18.5	250	-7	0	✓	0.53	GI056	S01
	S20Q-STFCR 11	20	25	13	18	18.5	180	-7	0	–	0.40	GI056	S01
	A25R-STFCR 16	25	32	17	23	23	200	-3	0	✓	0.66	GI016	S08
	S25T-STFCR 16	25	32	17	23	23	300	-3	0	–	1.08	GI016	S08
	A32S-STFCR 16	32	40	22	30	30	250	-10	0	✓	1.35	GI016	ST10
	S32U-STFCR 16-A	32	40	22	30	30	350	-10	0	–	2.10	GI016	ST10
L	A06F-STFCL 06	6	8.5	4.5	5	–	80	-12	0	✓	0.03	GI217	ST12
	A08H-STFCL 06	8	11	5.9	7	–	100	-10	0	✓	0.05	GI217	ST13
	A10K-STFCL 09	10	13	7	9	–	125	-9	0	✓	0.06	GI218	ST14
	A12M-STFCL 09	12	16	9	11	–	150	-6.5	0	✓	0.03	GI218	ST14
	S10H-STFCL 11	10	13	7	9	9.5	100	-10	0	–	0.06	GI056	S02
	A12M-STFCL 11	12	16	9	11	11.5	150	-10	0	✓	0.12	GI056	S01
	S12K-STFCL 11	12	16	9	11	11.5	125	-7	0	–	0.12	GI056	S01
	A16R-STFCL 11	16	20	11	14.5	15	200	-7	0	✓	0.00	GI056	S01
	S16M-STFCL 11	16	20	11	14.5	15	150	-7	0	–	0.24	GI056	S01
	A20S-STFCL 11	20	25	13	18	18.5	250	-7	0	✓	0.00	GI056	S01
	S20Q-STFCL 11	20	25	13	18	18.5	180	-7	0	–	0.42	GI056	S01
	A25R-STFCL 16	25	32	17	23	23	200	-3	0	✓	0.00	GI016	S08

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
L	**S25T-STFCL 16**	25	32	17	23	23	300	-3	0	–	1.08	GI016	S08
	A32S-STFCL 16	32	40	22	30	30	250	-10	0	✓	1.36	GI016	ST10
	S32U-STFCL 16-A	32	40	22	30	30	350	-10	0	–	2.06	GI016	ST10

GI016	TC.. 16T3..
GI056	TC.. 1102..
GI217	TC.. 06T1..
GI218	TC.. 0902..

		Nm							
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	–
ST10	US 3510-T15P	3.0	M 3.5	10.6	STN 160308	MS 3510	FLAG T15P	HXK 3.5	–
ST12	5513 020-28	0.6	M 2	4.2	–	–	–	–	PT-8000
ST13	5513 020-27	0.6	M 2	4.9	–	–	–	–	PT-8000
ST14	5513 020-05	0.8	M 2.2	6.4	–	–	–	–	PT-8001

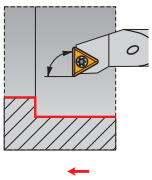
STFC(RL)-E INT

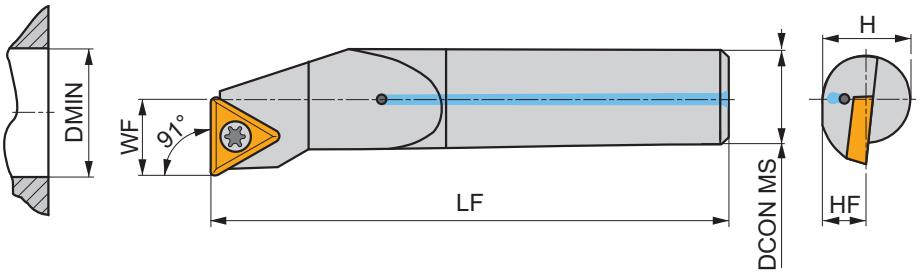
P M K N S H

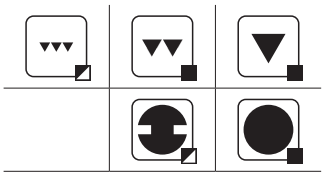
PRAMET

S

内孔螺钉夹紧式硬质合金镗杆，使用TC..刀片，主偏角为91°。
内孔左/右手硬质合金镗杆，有内冷通道，螺钉夹紧。主偏角为91°，使用TC..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可刀具悬伸>3xD。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**E06H-STFCR 06-R**	6	8.5	4.5	6	3	100	-10	0	✓	0.05	GI217	ST22
	E08K-STFCR 06-R	8	11	5.9	8	4	125	-10	0	✓	0.09	GI217	ST23
	E10M-STFCR 09-R	10	13	7	10	5	150	-8	0	✓	0.15	GI218	ST24
	E12Q-STFCR 09-R	12	16	9	12	6	180	-6	0	✓	0.26	GI218	ST24
	E16R-STFCR 11-R	16	20	11	16	8	200	-5	0	✓	0.48	GI056	ST21
L	**E06H-STFCL 06-R**	6	8.5	4.5	6	3	100	-10	0	✓	0.05	GI217	ST22
	E08K-STFCL 06-R	8	11	5.9	8	4	125	-10	0	✓	0.09	GI217	ST23
	E10M-STFCL 09-R	10	13	7	10	5	150	-8	0	✓	0.15	GI218	ST24
	E12Q-STFCL 09-R	12	16	9	12	6	180	-6	0	✓	0.26	GI218	ST24
	E16R-STFCL 11-R	16	20	11	16	8	200	-5	0	✓	0.48	GI056	ST21

GI056	TC.. 1102..
GI217	TC.. 06T1..
GI218	TC.. 0902..

		Nm			
ST21	5513 020-03	0.8	M 2.5	6.5	PT-8001
ST22	5513 020-28	0.6	M 2	4.2	PT-8000
ST23	5513 020-27	0.6	M 2	4.9	PT-8000
ST24	5513 020-05	0.8	M 2.2	6.4	PT-8001

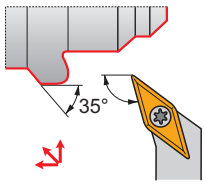
SVHB(C)(RL) EXT

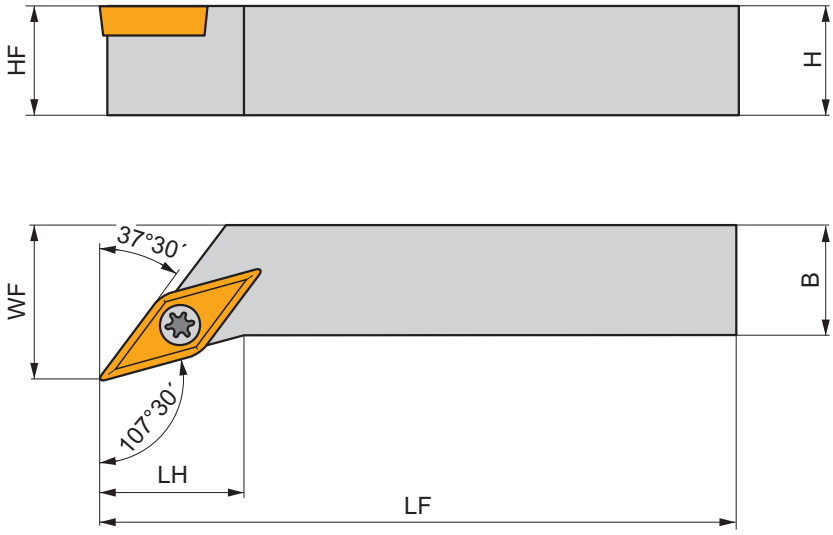
P M K N S H

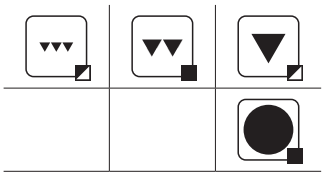
PRAMET

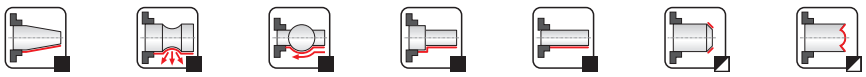
S

外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为107.5°。
外圆用左/右手车刀杆，螺钉锁紧式。使用VB..11或16和VC..11或16正前角刀片。适用于外圆表面，有阶梯外圆的轴向车削，锥面，端面，轴向仿形车削角度最大为35°，和倒角车削。可提供16x16至25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SVHBR 1616 H 11**	16	16	16	20	100	14.0	0	0	0.20	GI194	S01
	SVHCR 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.39	GI017	SV10
	SVHCR 2525 M 16-M-A	25	25	25	32	150	20.0	0	0	0.71	GI017	SV10
L	**SVHBL 1616 H 11**	16	16	16	20	100	14.0	0	0	0.19	GI194	S01
	SVHCL 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.40	GI017	SV10
	SVHCL 2525 M 16-M-A	25	25	25	32	150	20.0	0	0	0.07	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5

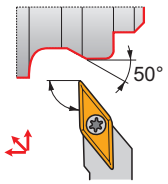
SVJB(C)(RL) EXT

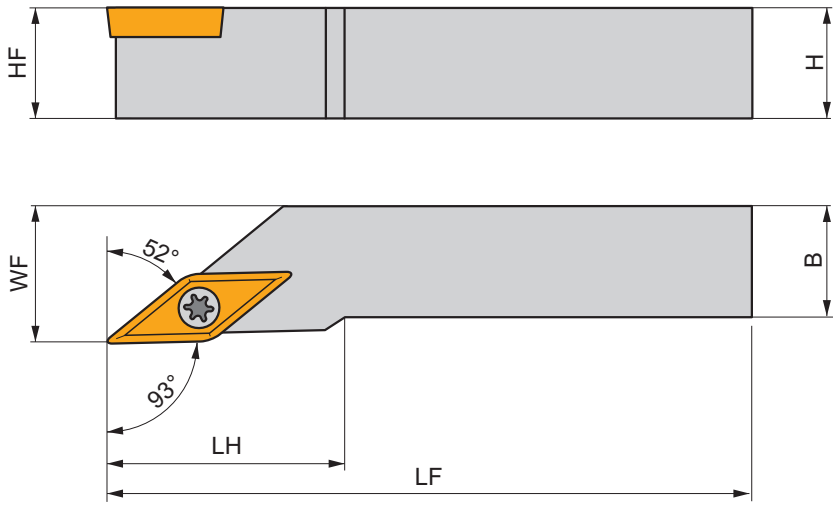
P M K N S H

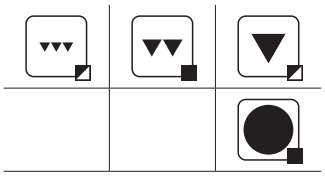
PRAMET

S

外圆用螺钉夹紧式车刀杆，主偏角为93°，使用VB/VC.. 刀片
外圆用右/左手车刀杆，使用正前角VB.. 11或16和VC.. 11至16刀片。适用于外圆带肩轴向车削、锥度车削、倒角车削和最大50°仿形车削。可提供12×12mm至32×25mm的刀柄，其中一些可用于纵切机床。刀杆经过处理，延长了使用寿命。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SVJBR 1212 F 11**	12	12	12	16	80	20.0	0	0	0.09	GI194	S01
	SVJBR 1212 K 11-S	12	12	12	12	125	25.6	0	0	0.13	GI194	S01
	SVJBR 1616 H 11	16	16	16	20	100	20.0	0	0	0.20	GI194	S01
	SVJBR 1616 K 11-S	16	16	16	16	125	25.6	0	0	0.22	GI194	S01
	SVJCR 1212 N 13	12	12	12	16	160	27.0	0	0	0.19	GI211	SV21
	SVJCR 1616 H 13	16	16	16	20	100	30.0	0	0	0.20	GI211	SV21
	SVJCR 2020 K 13	20	20	20	25	125	30.0	0	0	0.37	GI211	SV22
	SVJCR 2020 K 16-M-A	20	20	20	25	125	28.0	0	0	0.35	GI017	SV10
	SVJCR 2525 M 13	25	25	25	32	150	30.0	0	0	0.67	GI211	SV22
	SVJCR 2525 M 16-M-A	25	25	25	32	150	32.0	0	0	0.66	GI017	SV10
	SVJCR 3225 P 16-M-A	32	25	32	32	170	32.0	0	0	0.99	GI017	SV10
L	**SVJBL 1212 F 11**	12	12	12	16	80	20.0	0	0	0.09	GI194	S01
	SVJBL 1212 K 11-S	12	12	12	12	125	25.6	0	0	0.13	GI194	S01
	SVJBL 1616 H 11	16	16	16	20	100	20.0	0	0	0.19	GI194	S01
	SVJBL 1616 K 11-S	16	16	16	16	125	25.6	0	0	0.22	GI194	S01
	SVJCL 1212 N 13	12	12	12	16	160	27.0	0	0	0.19	GI211	SV21
	SVJCL 1616 H 13	16	16	16	20	100	30.0	0	0	0.20	GI211	SV21
	SVJCL 2020 K 13	20	20	20	25	125	30.0	0	0	0.37	GI211	SV22
	SVJCL 2020 K 16-M-A	20	20	20	25	125	28.0	0	0	0.38	GI017	SV10
	SVJCL 2525 M 13	25	25	25	32	150	30.0	0	0	0.67	GI211	SV22
	SVJCL 2525 M 16-M-A	25	25	25	32	150	32.0	0	0	0.68	GI017	SV10
	SVJCL 3225 P 16-M-A	32	25	32	32	170	32.0	0	0	0.99	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

SO1	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

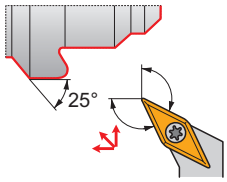
SVPB(C)(RL) EXT

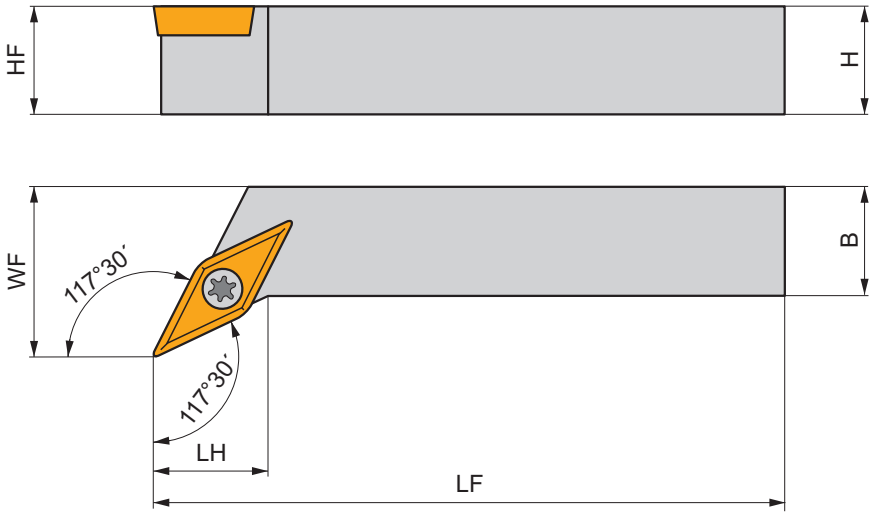
P M K N S H

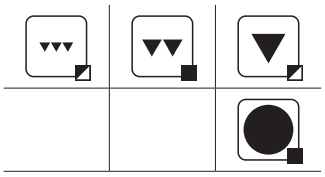
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为117.5°。
外圆用左/右手车刀杆，螺钉锁紧式。使用VB..11或16和VC..11或16正前角刀片。适用于外圆表面，有阶梯外圆的轴向车削，锥面，端面仿形车削角度最大为25°，和倒角车削。可提供16x16至32x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**SVPBR 1616 H 11**	16	16	16	20	100	12.0	0	0	0.20	GI194	S01
	SVPBR 2020 K 11	20	20	20	25	125	12.0	0	0	0.40	GI194	S01
	SVPCR 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.40	GI017	SV10
	SVPCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.73	GI017	SV10
	SVPCR 3225 P 16-M-A	32	25	32	32	170	25.0	0	0	1.03	GI017	SV10
L	**SVPBL 1616 H 11**	16	16	16	20	100	12.0	0	0	0.20	GI194	S01
	SVPBL 2020 K 11	20	20	20	25	125	12.0	0	0	0.39	GI194	S01
	SVPCL 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.40	GI017	SV10
	SVPCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.70	GI017	SV10
	SVPCL 3225 P 16-M-A	32	25	32	32	170	25.0	0	0	1.10	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5

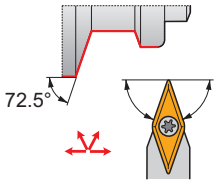
SVVB(C)N EXT

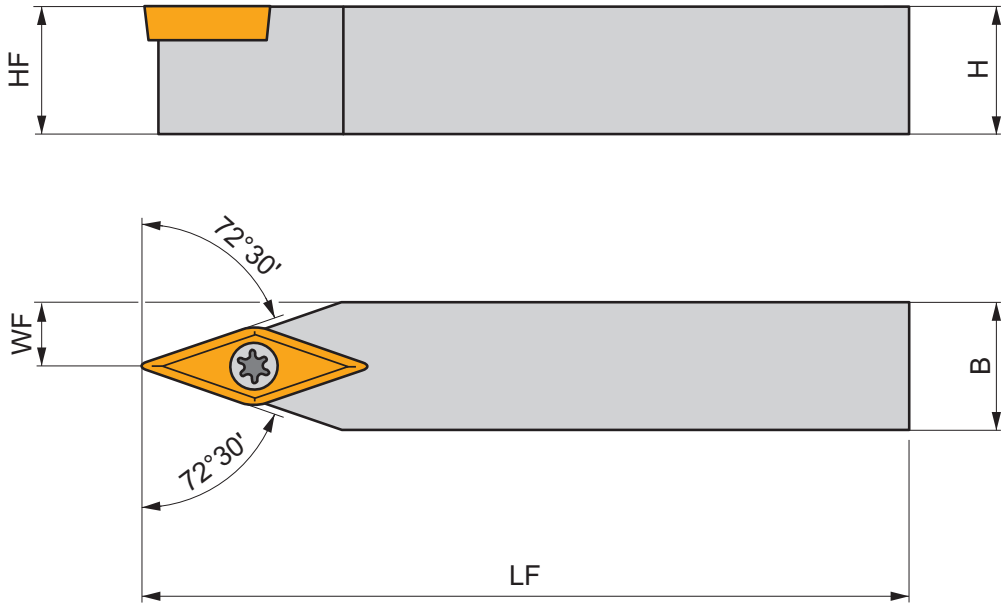
P M K N S H

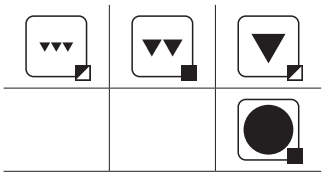
PRAMET

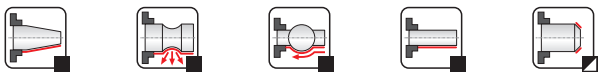
S

外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为72.5°。
外圆用中置车刀杆，螺钉锁紧式。使用VB..11或16和VC..11至16正前角刀片。适用于外圆无阶梯外圆的轴向车削，锥面，仿形车削角度最大为72.5°，和倒角车削。可提供12x12至32x25mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
N	**SVVBN 1212 F 11**	12	12	12	6	80	–	0	0	0.10	GI194	S01
	SVVBN 1616 H 11	16	16	16	8	100	–	0	0	0.20	GI194	S01
	SVVBN 2020 K 11	20	20	20	10	125	–	0	0	0.36	GI194	S01
	SVVCN 1212 N 13	12	12	12	6	160	–	0	0	0.19	GI211	SV21
	SVVCN 1616 H 13	16	16	16	8	100	–	0	0	0.20	GI211	SV21
	SVVCN 2020 K 13	20	20	20	10	125	–	0	0	0.36	GI211	SV22
	SVVCN 2525 M 13	25	25	25	12.5	150	–	0	0	0.66	GI211	SV22
	SVVCN 2020 K 16-M-A	20	20	20	10	125	–	0	0	0.34	GI017	SV10
	SVVCN 2525 M 16-M-A	25	25	25	12.5	150	–	0	0	0.67	GI017	SV10
	SVVCN 3225 P 16-M-A	32	25	32	12.5	170	–	0	0	0.97	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

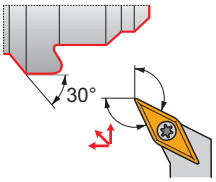
SVXB(C)(RL) EXT

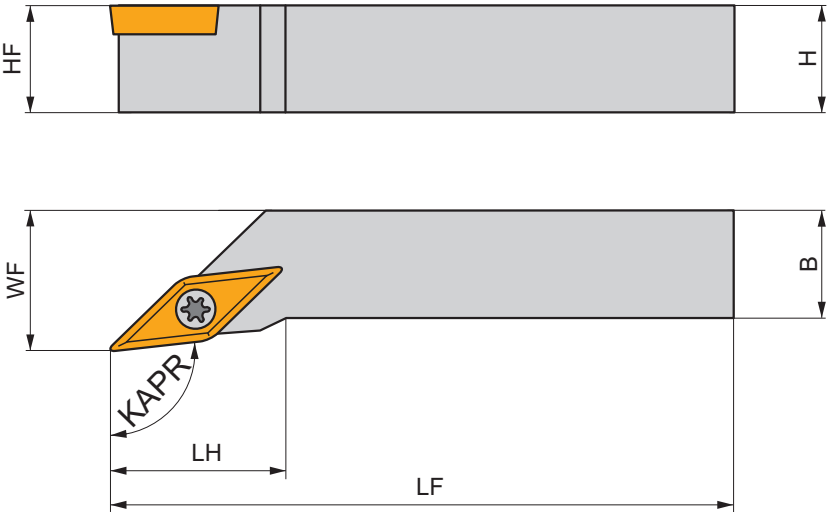
P M K N S H

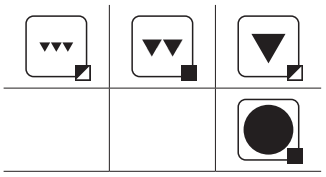
PRAMET

S

外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为98/113°。
外圆用左/右手车刀杆，螺钉锁紧式。使用VB..11或16和VC..11，至16正前角刀片。。适用于有阶梯外圆的轴向车削，锥面，仿形车削角度最大为30°，和倒角车削。可提供12x12至32x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	KAPR (°)	LAMS (°)	GAMO (°)	kg		
R	**SVXBR 1212 F 11**	12	12	12	16	80	20.0	98	0	0	0.09	GI194	S01
	SVXBR 1616 H 11	16	16	16	20	100	14.0	98	0	0	0.19	GI194	S01
	SVXCR 2020 K 13	20	20	20	25	125	12.0	113	0	0	0.41	GI211	SV22
	SVXCR 2020 K 16-M-A	20	20	20	25	125	28.0	98	0	0	0.38	GI017	SV10
	SVXCR 2525 M 16-M-A	25	25	25	32	150	32.0	98	0	0	0.68	GI017	SV10
	SVXCR 3225 P 16-M-A	32	25	32	32	170	32.0	98	0	0	1.00	GI017	SV10
L	**SVXBL 1212 F 11**	12	12	12	16	80	20.0	98	0	0	0.09	GI194	S01
	SVXBL 1616 H 11	16	16	16	20	100	14.0	98	0	0	0.19	GI194	S01
	SVXCL 2020 K 13	20	20	20	25	125	12.0	113	0	0	0.38	GI211	SV22
	SVXCL 2020 K 16-M-A	20	20	20	25	125	28.0	98	0	0	0.38	GI017	SV10
	SVXCL 2525 M 16-M-A	25	25	25	32	150	32.0	98	0	0	0.69	GI017	SV10
	SVXCL 3225 P 16-M-A	32	25	32	32	170	32.0	98	0	0	0.99	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

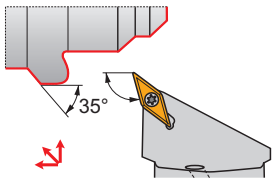
C.-SVHB(RL) EXT

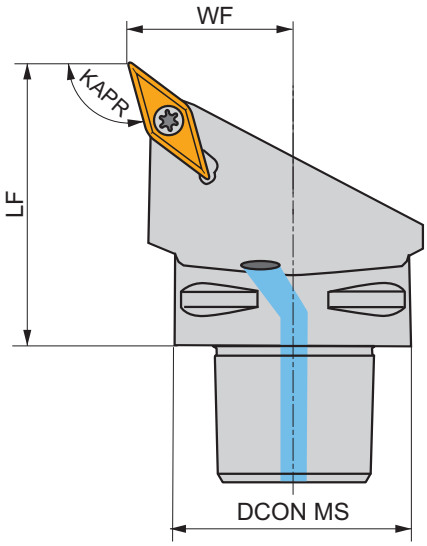
P M K N S H

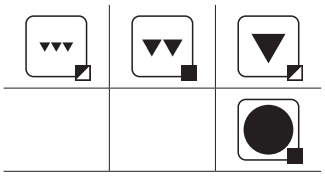
PRAMET

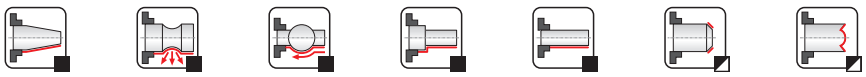
S

外圆用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为107.5°。
外圆用左/右手车刀杆，有内冷通道，螺钉锁紧式。使用VB..16和VC..16正前角刀片。适用于外圆表面，有阶梯外圆的轴向车削，锥面，仿形车削角度最大为35°，和倒角车削。可提供C4至C6的PSC刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	**C4-SVHBR-27050-16**	40	27	50	107.5	0	0	✓	0.35	GI017	C-SV16S-1
	C5-SVHBR-35060-16	50	35	60	107.5	0	0	✓	0.64	GI017	C-SV16S-2
	C6-SVHBR-45065-16	63	45	65	107.5	0	0	✓	1.13	GI017	C-SV16S-2
L	**C4-SVHBL-27050-16**	40	27	50	107.5	0	0	✓	0.35	GI017	C-SV16S-1
	C5-SVHBL-35060-16	50	35	60	107.5	0	0	✓	0.64	GI017	C-SV16S-2
	C6-SVHBL-45065-16	63	45	65	107.5	0	0	✓	1.12	GI017	C-SV16S-2

GI017	VB.. 1604..	VC.. 1604..

		Nm						
C-SV16S-1	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

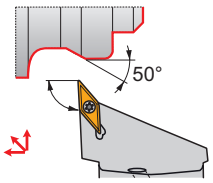
C.-SVJB(RL) EXT

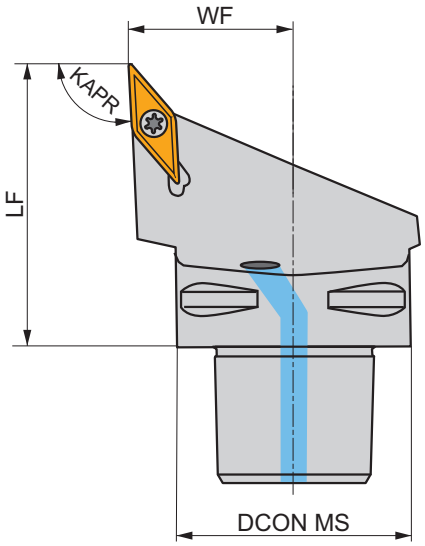
P M K N S H

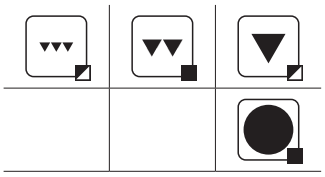
PRAMET

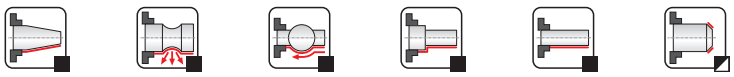
S

外圆用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为93°。
外圆用左/右手车刀杆，有内冷通道，螺钉锁紧式。使用VB..11或16，和VC..11至16正前角刀片。适用于外圆表面，有阶梯外圆的轴向车削，锥面，仿形车削角度最大为50°，和倒角车削。可提供C3至C6的PSC刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SVJBR-22040-11-B1	32	22	40	93	0	0	✓	0.17	GI194	C-SV11
	C4-SVJBR-27050-11-B1	40	27	50	93	0	0	✓	0.34	GI194	C-SV11
	C4-SVJBR-27050-16	40	27	50	93	0	0	✓	0.35	GI017	C-SV16S-1
	C5-SVJBR-35060-16	50	35	60	93	0	0	✓	0.63	GI017	C-SV16S-2
	C6-SVJBR-45065-16	63	45	65	93	0	0	✓	1.11	GI017	C-SV16S-2
L	C4-SVJBL-27050-16	40	27	50	93	0	0	✓	0.34	GI017	C-SV16S-1
	C5-SVJBL-35060-16	50	35	60	93	0	0	✓	0.64	GI017	C-SV16S-2
	C6-SVJBL-45065-16	63	45	65	93	0	0	✓	1.11	GI017	C-SV16S-2

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..

		Nm						
C-SV11	US 2003-T07P	0.8	M 2.5	6.5	–	–	FLAG T07P	CN 034-01
C-SV16S-1	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

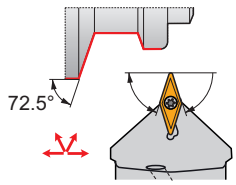
C.-SVVBN EXT

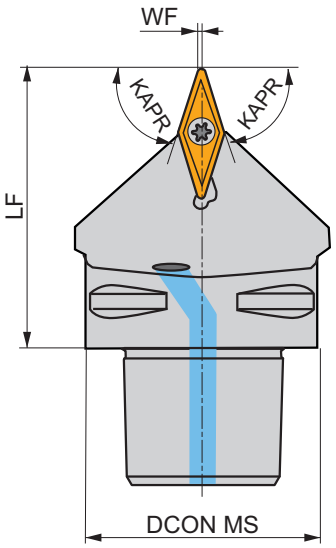
P M K N S H

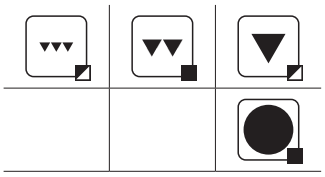
PRAMET

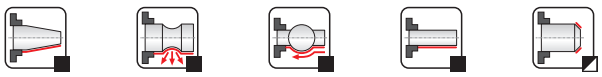
S

外圆用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为72.5°。
外圆用中置刀具，有内冷通道，螺钉锁紧式。使用VB..16和VC..16正前角刀片。适用于无阶梯外圆的轴向车削，锥面，可将复仿形车削角度最大为72.5°，和倒角车削。可提供C4至C6的PSC。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
N	**C4-SVVBN-00050-16**	40	0.6	50	72.5	0	0	✓	0.32	GI017	C-SV16S-1
	C5-SVVBN-00060-16	50	0.6	60	72.5	0	0	✓	0.56	GI017	C-SV16S-2
	C6-SVVBN-00065-16	63	0.6	65	72.5	0	0	✓	0.99	GI017	C-SV16S-2

GI017	VB.. 1604..	VC.. 1604..

		Nm						
C-SV16S-1	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

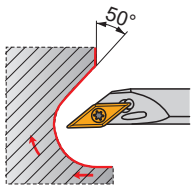
SVJB(RL) INT

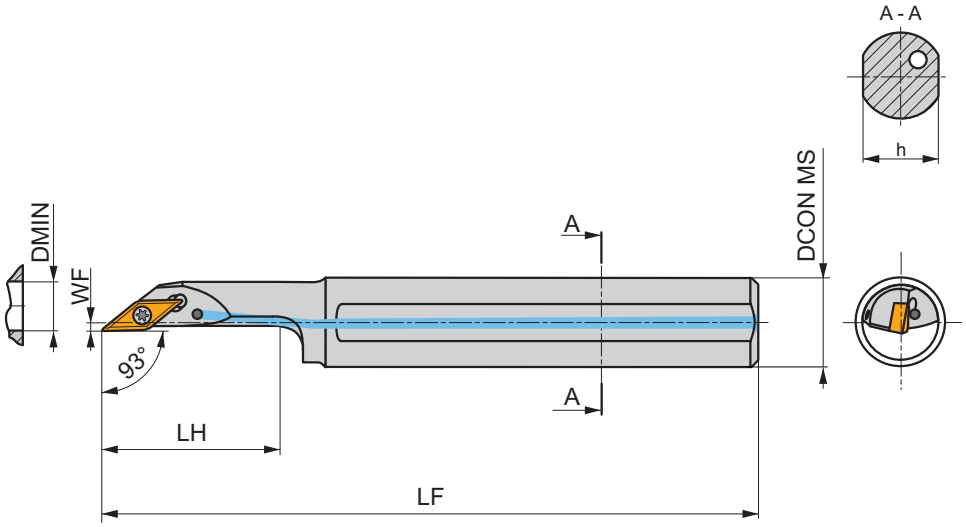
P M K N S H

PRAMET

S

内孔用螺钉夹紧式镗杆，使用VB/VC..刀片，主偏角为93°。
内孔左/右手镗杆，有内冷通道，螺钉夹紧。主偏角为93°，使用VB..和VC..刀片。适用于50⊠以下的端面仿形车削。刀杆经过处理，使用寿命更长。





▼▼▼	▼▼	▼
		●

Product		DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	A20R-SVJBR 11	20	25	2	18	200	40.0	-5	-5	✓	0.40	GI194	S07
R	A25S-SVJBR 11	25	32	3.5	23	250	50.0	-5	-5	✓	0.81	GI194	S07
L	A20R-SVJBL 11	20	25	2	18	200	40.0	-5	-5	✓	0.41	GI194	S07
L	A25S-SVJBL 11	25	32	3.5	23	250	50.0	-5	-5	✓	0.81	GI194	S07

GI194	VB.. 1103..	VC.. 1103..

S07	US 2506-T07P	0.9 Nm	M 2.5	6.3	FLAG T07P

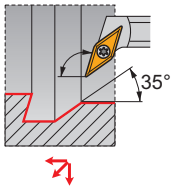
SVQB(C)(RL) INT

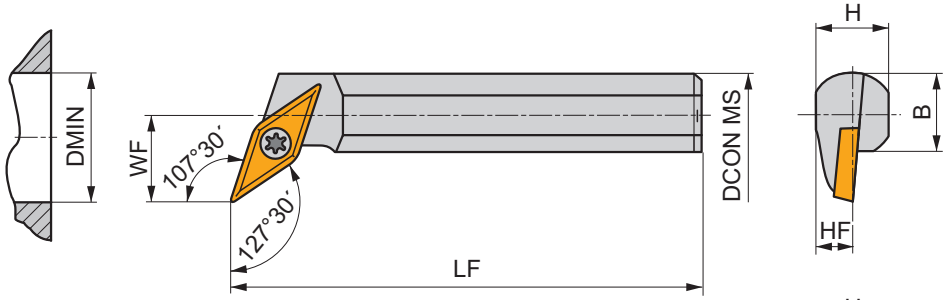
P M K N S H

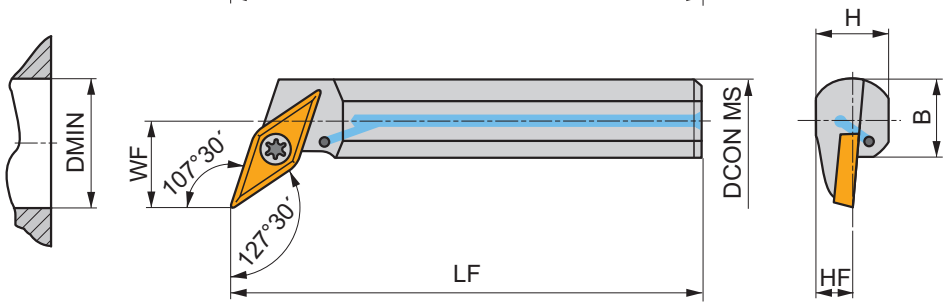
PRAMET

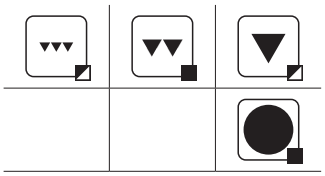
S

内孔用螺钉夹紧式镗杆，使用VB/VC..刀片，主偏角为107.5°。
内孔左/右手镗杆，有内冷通道，螺钉夹紧。主偏角为107.5°，使用VB../VC..刀片。广泛的应用于内孔车削。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16R-SVQBR 11	16	20	11	14.5	15	200	-5	0	✓	0.33	GI194	S01
	A20S-SVQBR 11	20	25	13	18	18.5	250	-4	0	✓	0.57	GI194	S01
	A16R-SVQCR 13	16	21	11	15	15	200	-6	0	✓	0.29	GI211	SV21
	A20S-SVQCR 13	20	25	13	18	18.5	250	-4	0	✓	0.12	GI211	SV21
	S25T-SVQCR 16	25	32	17	23	23	300	-7	0	–	1.08	GI017	S08
	S32U-SVQCR 16	32	40	22	30	30	350	-5	0	–	2.07	GI017	S08
	S40V-SVQCR 16-A	40	50	27	38	38	400	-5	0	–	3.80	GI017	SV10
L	A16R-SVQBL 11	16	20	11	14.5	15	200	-5	0	✓	0.32	GI194	S01
	A20S-SVQBL 11	20	25	13	18	18.5	250	-4	0	✓	0.57	GI194	S01
	A16R-SVQCL 13	16	21	11	15	15	200	-6	0	✓	0.29	GI211	SV21
	A20S-SVQCL 13	20	25	13	18	18.5	250	-4	0	✓	0.54	GI211	SV21
	S25T-SVQCL 16	25	32	17	23	23	300	-7	0	–	1.08	GI017	S08
	S32U-SVQCL 16	32	40	22	30	30	350	-5	0	–	2.07	GI017	S08
	S40V-SVQCL 16-A	40	50	27	38	38	400	-5	0	–	4.10	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–

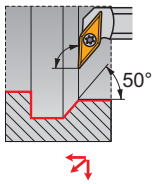
SVUB(C)(RL) INT

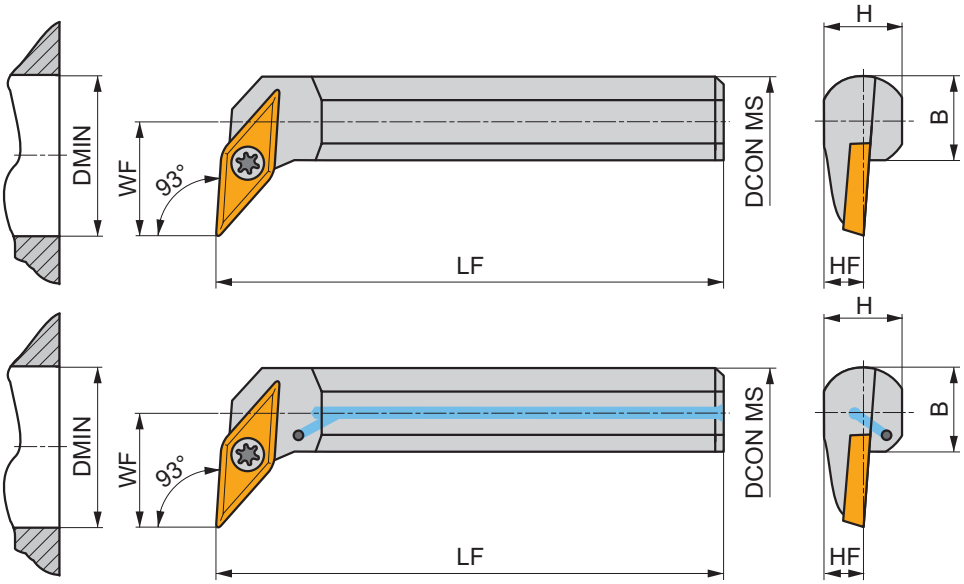
P M K N S H

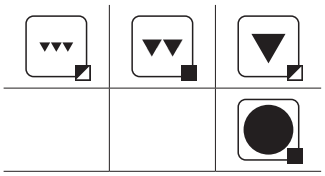
PRAMET

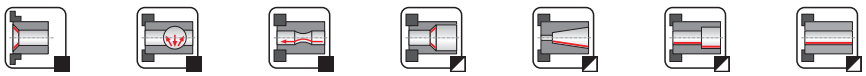
S

内孔用螺钉夹紧式镗杆，使用VB/VC..刀片，主偏角为93°。
内孔左/右手镗杆，有内冷通道，螺钉夹紧。主偏角为93°，使用VB../VC..刀片。广泛的应用于内孔车削，和50⊠以下的仿形车削。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A16R-SVUBR 11**	16	20	11	14.5	15	200	-5	0	✓	0.32	GI194	S01
	A20S-SVUBR 11	20	25	13	18	18.8	250	-4	0	✓	0.57	GI194	S01
	A20S-SVUCR 13	20	25	13	19	18.5	250	-4	2	✓	0.54	GI211	SV21
	A25T-SVUCR 13	25	32	17	24	23	300	-2	2	✓	0.96	GI211	SV22
	A32T-SVUCR 13	32	40	22	30	30	300	-1	2	✓	1.66	GI211	SV22
	S25T-SVUCR 16	25	32	17	23	23	300	-7	0	–	1.08	GI017	S08
	S32U-SVUCR 16	32	40	22	30	30	350	-5	0	–	2.10	GI017	S08
	S40V-SVUCR 16-A	40	50	27	38	38	400	-5	0	–	4.10	GI017	SV10
L	**A16R-SVUBL 11**	16	20	11	14.5	15	200	-5	0	✓	0.32	GI194	S01
	A20S-SVUBL 11	20	25	13	18	18.5	250	-4	0	✓	0.57	GI194	S01
	A20S-SVUCL 13	20	25	13	19	18.5	250	-4	2	✓	0.32	GI211	SV21
	A25T-SVUCL 13	25	32	17	24	23	300	-2	2	✓	0.96	GI211	SV22
	A32T-SVUCL 13	32	40	22	30	30	300	-1	2	✓	1.66	GI211	SV22
	S25T-SVUCL 16	25	32	17	23	23	300	-7	0	–	1.09	GI017	S08
	S32U-SVUCL 16	32	40	22	30	30	350	-5	0	–	2.10	GI017	S08
	S40V-SVUCL 16-A	40	50	27	38	38	400	-5	0	–	4.10	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

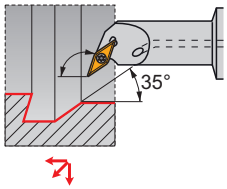
C.-SVQB(RL) INT

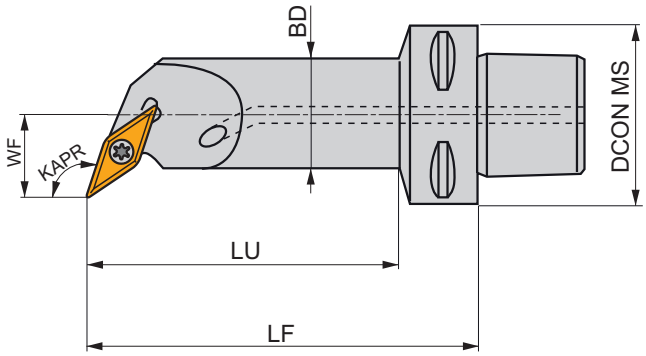
P M K N S H

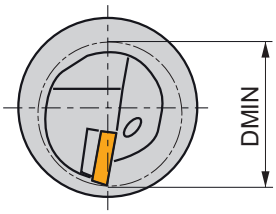
PRAMET

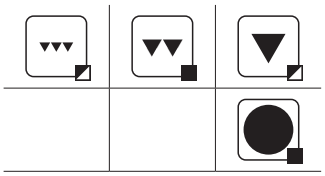
S

内孔用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为107.5°。
内孔左/右手刀具，有内冷通道，螺钉夹紧。主偏角107.5°，使用VB..16或VC..16刀片。广泛的应用于内孔车削。可提供PSC刀柄C4和C5，可以选择长度。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	**C4-SVQBR-18090-16**	40	33	18	90	68	25	107.5	-7.2	0	✓	0.48	GI017	SV16
R	**C5-SVQBR-18090-16**	50	33	18	90	67	25	107.5	-7.2	0	✓	0.67	GI017	SV16
L	**C4-SVQBL-18090-16**	40	33	18	90	68	25	107.5	-7.2	0	✓	0.48	GI017	SV16
L	**C5-SVQBL-18090-16**	50	33	18	90	67	25	107.5	-7.2	0	✓	0.68	GI017	SV16

GI017	VB.. 1604..	VC.. 1604..

SV16	US 2010-T15P	3.0	M 3.5	10.1	FLAG T15P/3,5

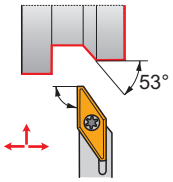
SVAC(RL)-DC EXT

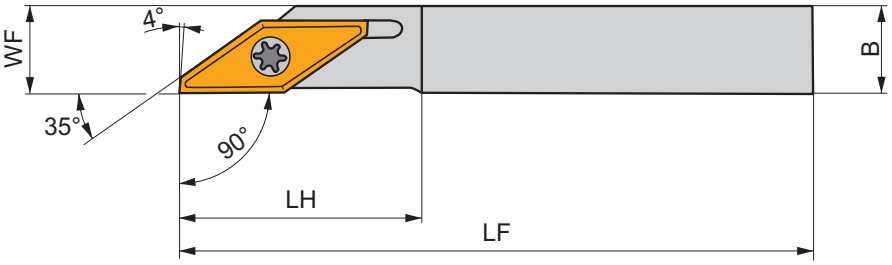
P M K N S H

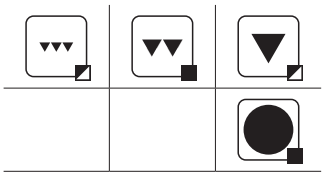
PRAMET

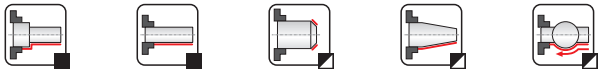
S

外圆用螺钉夹紧瑞士式车刀杆，使用VCGX13刀片，主偏角为90°。
外圆用左/右手车刀杆，螺钉锁紧式。使用VCGX13瑞士类型正前角刀片。适用于外圆表面，有阶梯外圆的轴向车削，锥面，仿形车削角度最大为53°，和倒角车削。可提供10x10至25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**SVACR 1010 L 13-DC**	10	10	10	10	140	25.0	0	0	0.12	GI222	SV20
	SVACR 1212 L 13-DC	12	12	12	12	140	25.0	0	0	0.17	GI222	SV20
	SVACR 1616 M 13-DC	16	16	16	16	150	25.0	0	0	0.29	GI222	SV20
	SVACR 2020 M 13-DC	20	20	20	20	150	25.0	0	0	0.46	GI222	SV20
L	**SVACL 1212 L 13-DC**	12	12	12	12	140	25.0	0	0	0.19	GI222	SV20
	SVACL 1616 M 13-DC	16	16	16	16	150	25.0	0	0	0.29	GI222	SV20
	SVACL 2020 M 13-DC	20	20	20	20	150	25.0	0	0	0.43	GI222	SV20
	SVACL 2525 M 13-DC	25	25	25	25	150	25.0	0	0	0.67	GI222	SV20

GI222	VCGX 1303..

SV20	5513 020-24	1.5	M 3	8.5	PT-8002

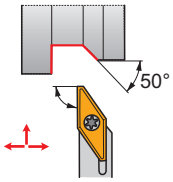
SVJC(RL)-DC EXT

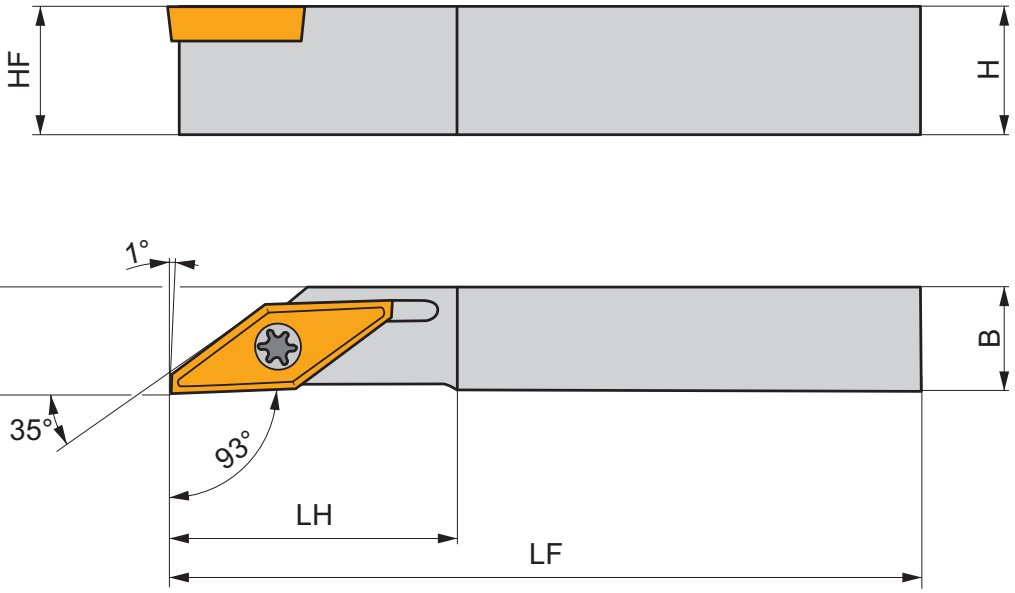
P M K N S H

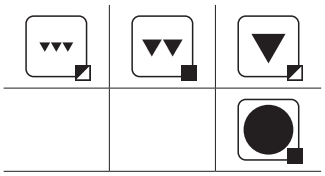
PRAMET

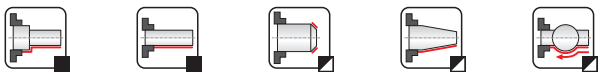
S

外圆用螺钉夹紧瑞士式车刀杆，使用VCGX13刀片，主偏角为93°。
外圆用左/右手车刀杆，螺钉锁紧式。使用VCGX 13瑞士类型的正前角刀片。适用于外圆表面，有阶梯外圆的轴向车削，锥面，仿形车削角度最大为50°，和倒角车削。可提供10x10至25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SVJCR 1212 L 13-DC	12	12	12	–	140	25.0	0	0	0.17	GI222	SV20
	SVJCR 1616 M 13-DC	16	16	16	–	150	25.0	0	0	0.29	GI222	SV20
	SVJCR 2020 M 13-DC	20	20	20	–	150	25.0	0	0	0.45	GI222	SV20
	SVJCR 2525 M 13-DC	25	25	25	–	150	25.0	0	0	0.68	GI222	SV20
L	SVJCL 1212 L 13-DC	12	12	12	–	140	25.0	0	0	0.17	GI222	SV20
	SVJCL 1616 M 13-DC	16	16	16	–	150	25.0	0	0	0.30	GI222	SV20
	SVJCL 2020 M 13-DC	20	20	20	–	150	25.0	0	0	0.47	GI222	SV20
	SVJCL 2525 M 13-DC	25	25	25	–	150	25.0	0	0	0.69	GI222	SV20

GI222	VCGX 1303..

SV20	5513 020-24	1.5	M 3	8.5	PT-8002

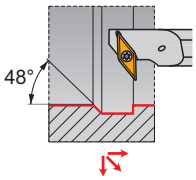
SVLC(RL) INT

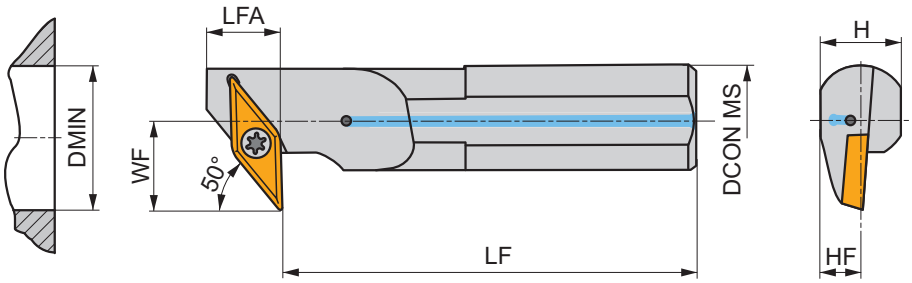
P M K N S H

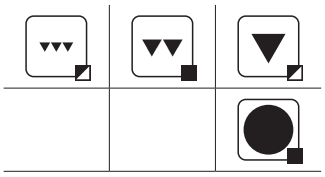
PRAMET

S

内孔镗杆,螺钉夹紧,使用VC..刀片,主偏角为50°。
内孔左/右手镗杆,有内冷通道,螺钉夹紧。主偏角为50°,使用VC..刀片。广泛的应用于内孔拉削应用,和48⊠以下的仿形车削。刀杆经过处理,使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	HF (mm)	LFA (mm)	LAMS (°)	GAMO (°)		kg		
R	A20S-SVLCR 13-X	20	27	15	18	250	9	15	-4	-2	✓	0.57	GI211	SV21
	A25T-SVLCR 13-X	25	35	20	24	300	12	18	-2	-2	✓	1.01	GI211	SV22
	A32T-SVLCR 13-X	32	43	25	30	300	15	18	-1	-2	✓	1.75	GI211	SV22
L	A20S-SVLCL 13-X	20	27	15	18	250	9	15	-4	-2	✓	0.57	GI211	SV21
	A25T-SVLCL 13-X	25	35	20	24	300	12	18	-2	-2	✓	0.05	GI211	SV22
	A32T-SVLCL 13-X	32	43	25	30	300	15	18	-1	-2	✓	1.75	GI211	SV22

GI211	VC.. 1303..

		Nm						
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

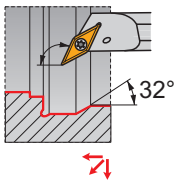
SVXC(RL) INT

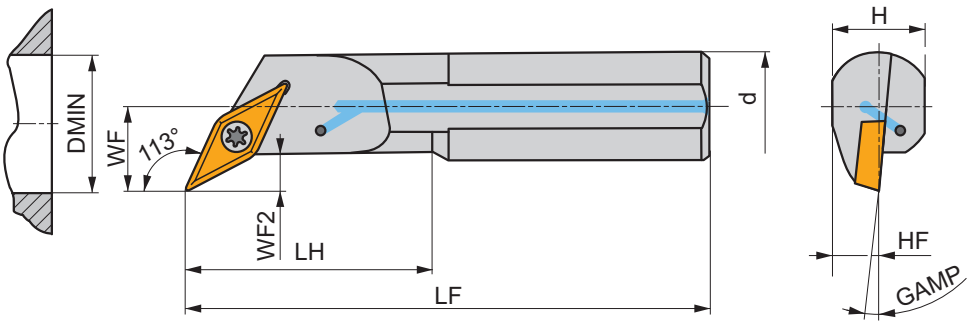
P M K N S H

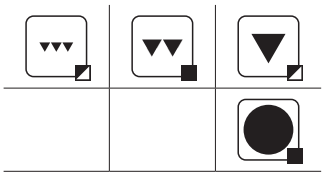
PRAMET

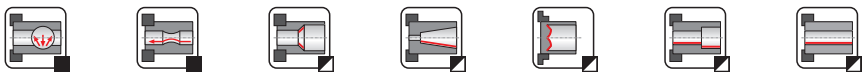
S

内孔镗杆,螺钉夹紧,使用VC..刀片，主偏角为113°。
内孔左/右手镗杆，有内冷通道，螺钉夹紧。主偏角为113°，使用VC..刀片。广泛的应用于内孔车削，和32°以下的仿形车削。刀杆经过处理，使用寿命更长。









	Product	DCON MS	DMIN	WF	H	LF	HF	LH	WF2	GAMP		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)				
R	**A10H-SVXCR 07**	10	12.5	7	9	100	4.5	22.0	3	-10	✓	0.06	GI234	SV23
	A12K-SVXCR 07	12	15.5	9	11	125	5.5	28.0	3	-8	✓	0.11	GI234	SV23
	A16M-SVXCR 07	16	17.5	11	15	150	7.5	36.0	3	-6	✓	0.19	GI234	SV23
L	**A10H-SVXCL 07**	10	12.5	7	9	100	4.5	22.0	3	-10	✓	0.06	GI234	SV23
	A12K-SVXCL 07	12	15.5	9	11	125	5.5	28.0	3	-8	✓	0.11	GI234	SV23
	A16M-SVXCL 07	16	17.5	11	15	150	7.5	36.0	3	-6	✓	0.20	GI234	SV23

GI234	VC.. 0702..

SV23	DVF 3584	0.6	M 2	5.5	DMD 1650

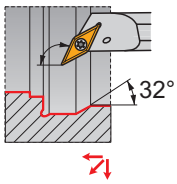
SVXC(RL)-E INT

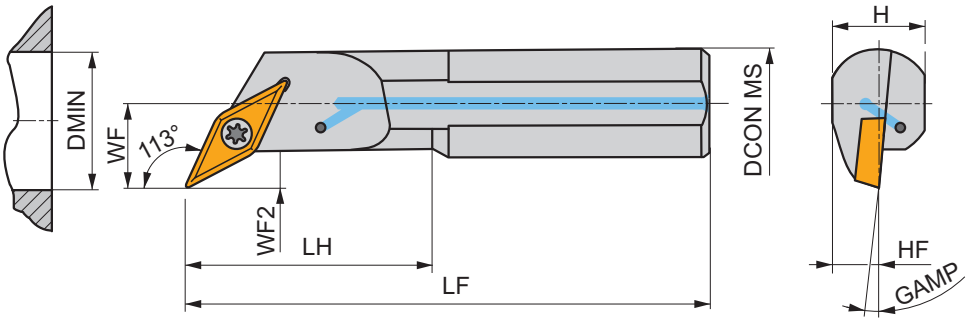
P M K N S H

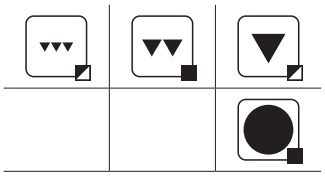
PRAMET

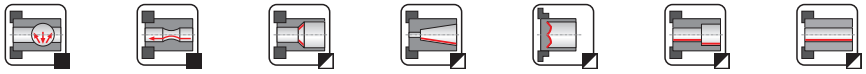
S

硬质合金内孔镗杆,螺钉夹紧,使用VC..刀片,主偏角为113°。
内孔左/右手硬质合金镗杆,有内冷通道,螺钉夹紧。主偏角为113°,使用VC..刀片。广泛的应用于内孔车削,和32⊠以下的仿形车削。刀具悬伸>3xD。









	Product	DCON MS	DMIN	WF	H	HF	LF	LH	WF2	GAMP		kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)				
R	**E10H-SVXCR 07**	10	12.5	7	9	4.5	100	22.0	3	-10	✓	0.10	GI234	SV23
R	**E12K-SVXCR 07**	12	15.5	9	11	5.5	125	28.0	3	-8	✓	0.18	GI234	SV23
R	**E16M-SVXCR 07**	16	17.5	11	15	7.5	150	36.0	3	-6	✓	0.33	GI234	SV23
L	**E10H-SVXCL 07**	10	12.5	7	9	4.5	100	22.0	3	-10	✓	0.10	GI234	SV23
L	**E16M-SVXCL 07**	16	17.5	11	15	7.5	150	36.0	3	-6	✓	0.33	GI234	SV23

GI234	VC.. 0702..

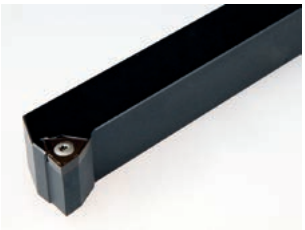
SV23	DVF 3584	0.6	M 2	5.5	DMD 1650

SWLC(RL) EXT

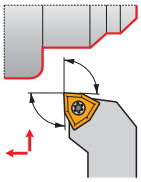
P M K N S H

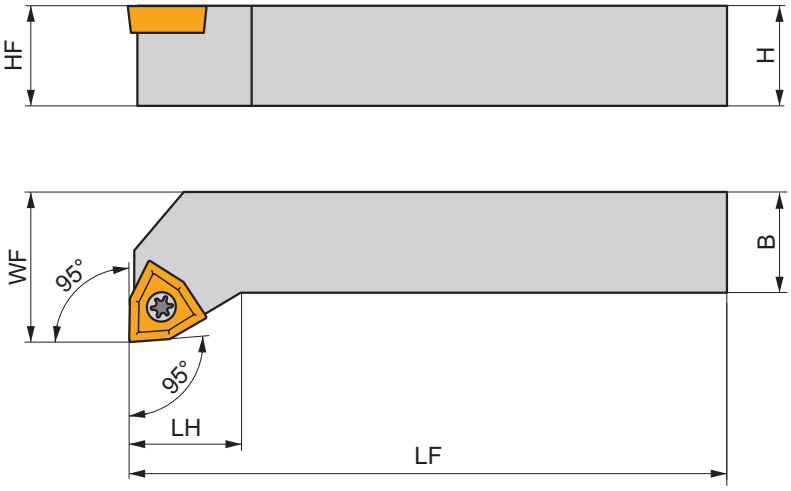
PRAMET

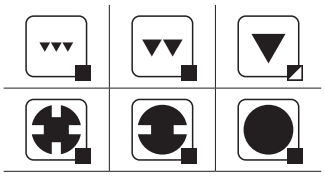
S



外圆用螺钉夹紧式车刀杆，使用WC..刀片，主偏角为95°
外圆用左/右手车刀杆，使用WC..06或08正前角刀片。适用于有阶梯外圆的端面和轴向车削，锥面和倒角车削。可提供16x16至25x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**SWLCR 1616 H 06**	16	16	16	20	100	15.0	0	0	0.23	GI055	S04
	SWLCR 2020 K 06	20	20	20	25	125	15.0	0	0	0.42	GI055	S04
	SWLCR 2525 M 08	25	25	25	32	150	20.0	0	0	0.76	GI049	S09
L	**SWLCL 1616 H 06**	16	16	16	20	100	15.0	0	0	0.23	GI055	S04
	SWLCL 2020 K 06	20	20	20	25	125	15.0	0	0	0.40	GI055	S04
	SWLCL 2525 M 08	25	25	25	32	150	20.0	0	0	0.75	GI049	S09

GI049	WC.. 0804..
GI055	WC.. 06T3..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S09	US 4512-T15P	5.0	M 4.5	12.2	FLAG T15P

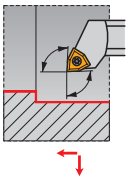
SWLC(RL) INT

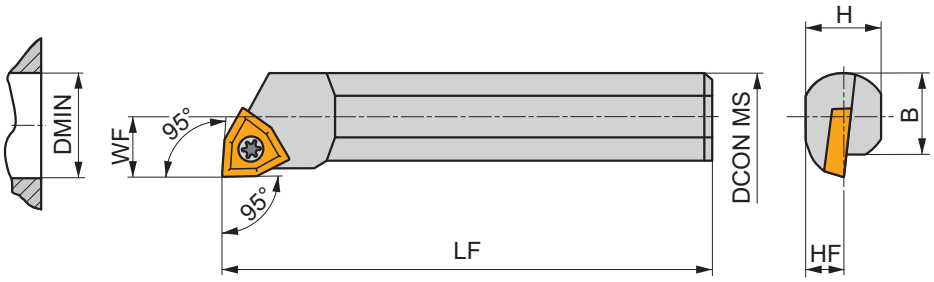
P M K N S H

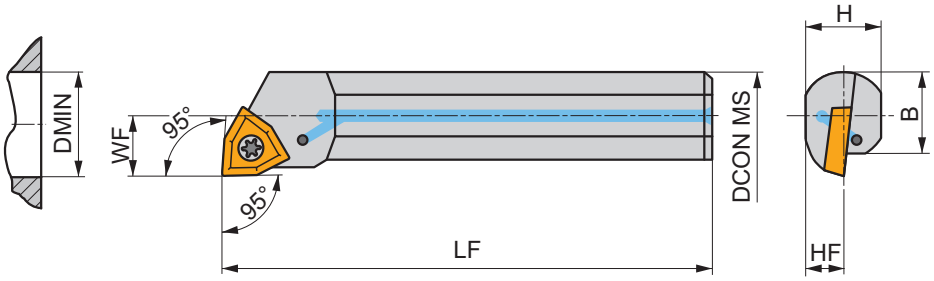
PRAMET

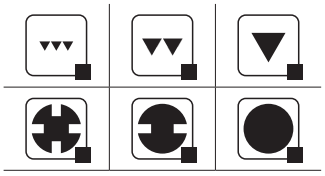
S

内孔螺钉夹紧镗杆，使用WC..刀片，主偏角为95°。
内孔左/右手镗杆，有内冷通道，螺钉夹紧。主偏角为95°，使用WC..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A20Q-SWLCR 06**	20	25	13	18	18.5	180	-7	0	✓	0.37	GI055	S04
	S20S-SWLCR 06	20	25	13	18	18.5	250	-7	0	–	0.60	GI055	S04
	S25T-SWLCR 06	25	32	17	23	23	300	-7	0	–	1.12	GI055	S04
	A25R-SWLCR 08	25	32	17	23	23	200	-7	0	✓	0.70	GI049	S04
	A32S-SWLCR 08	32	40	22	30	30	250	-5	0	✓	1.32	GI049	S09
	S32U-SWLCR 08	32	40	22	30	30	350	-5	0	–	2.05	GI049	S09
L	**A20Q-SWLCL 06**	20	25	13	18	18.5	180	-7	0	✓	0.00	GI055	S04
	S20S-SWLCL 06	20	25	13	18	18.5	250	-7	0	–	0.60	GI055	S04
	A25R-SWLCL 06	25	32	17	23	23	200	-7	0	✓	0.66	GI055	S04

GI049	WC.. 0804..
GI055	WC.. 06T3..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S09	US 4512-T15P	5.0	M 4.5	12.2	FLAG T15P

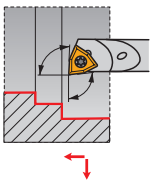
SWUC(RL) INT

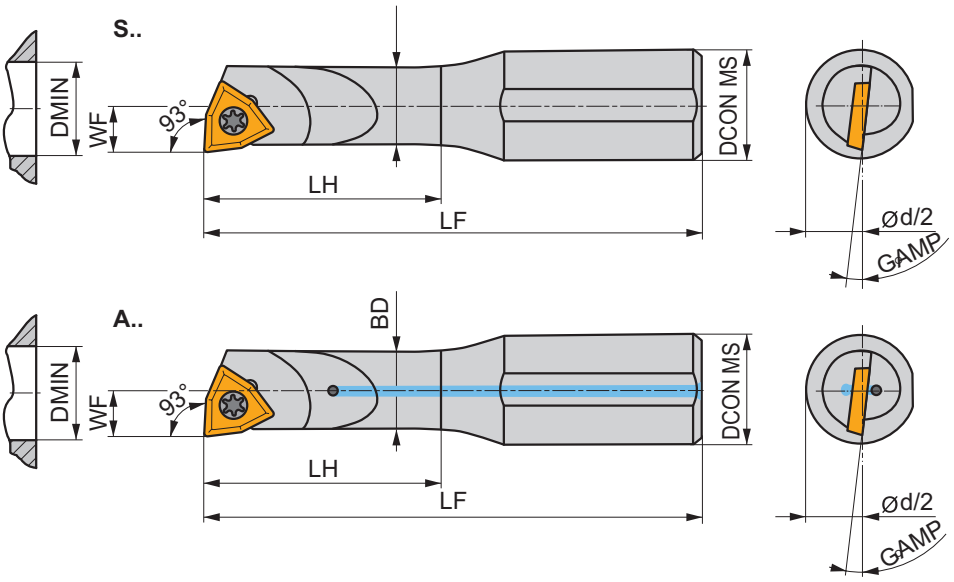
P M K N S H

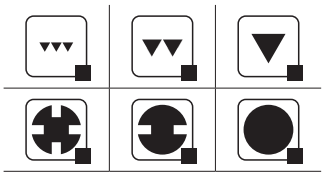
PRAMET

S

内孔螺钉夹紧镗杆，使用WC..刀片，主偏角为93°。
内孔左/右手镗杆，有内冷通道，螺钉夹紧。主偏角为93°，使用WC刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		kg		
R	A0508H-SWUCR 02	8	5.8	5	2.9	100	18.0	-17	✓	0.04	GI221	SW21
	S0508H-SWUCR 02	8	5.8	5	2.9	100	18.0	-17	–	0.03	GI221	SW21
	A0608H-SWUCR 02	8	7.8	6	3.9	100	24.0	-12	✓	0.04	GI221	SW21
	S0608H-SWUCR 02	8	7.8	6	3.9	100	24.0	-12	–	0.04	GI221	SW21
L	A0508H-SWUCL 02	8	5.8	5	2.9	100	18.0	-17	✓	0.04	GI221	SW21
	S0508H-SWUCL 02	8	5.8	5	2.9	100	18.0	-17	–	0.04	GI221	SW21
	A0608H-SWUCL 02	8	7.8	6	3.9	100	24.0	-12	✓	0.04	GI221	SW21
	S0608H-SWUCL 02	8	7.8	6	3.9	100	24.0	-12	–	0.04	GI221	SW21

GI221	WC.. 0201..

SW21	T20.037	0.6	M 2	3.7	DMD 1650

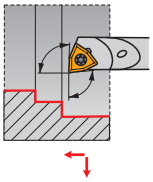
SWUC(RL)-E INT

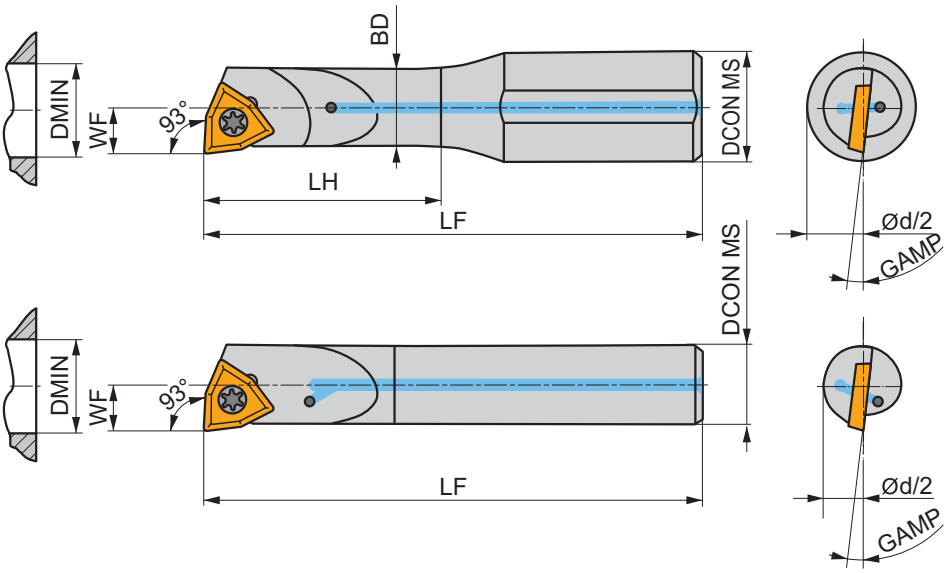
P M K N S H

PRAMET

S

内孔螺钉夹紧硬质合金镗杆，使用WC..刀片，主偏角为93°
内孔左/右手硬质合金镗杆，有内冷通道，螺钉夹紧。主偏角为93°，使用WC..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀具悬伸>3xD。



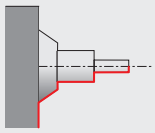


Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		kg		
R											
E0508H-SWUCR 02	8	5.8	5	2.9	100	24.0	-17	✓	0.06	GI221	SW21
E05F-SWUCR 02	5	5.8	–	2.9	85	–	-17	✓	0.03	GI221	SW21
E0608H-SWUCR 02	8	7.8	6	3.9	100	32.0	-12	✓	0.06	GI221	SW21
E06G-SWUCR 02	6	7.8	–	3.9	95	–	-12	✓	0.04	GI221	SW21
L											
E0508H-SWUCL 02	8	5.8	5	2.9	100	24.0	-17	✓	0.06	GI221	SW21
E05F-SWUCL 02	5	5.8	–	2.9	85	–	-17	✓	0.03	GI221	SW21
E0608H-SWUCL 02	8	7.8	6	3.9	100	32.0	-12	✓	0.06	GI221	SW21
E06G-SWUCL 02	6	7.8	–	3.9	95	–	-12	✓	0.04	GI221	SW21

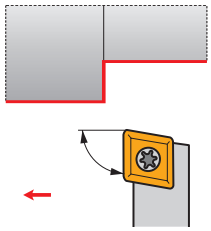
GI221	WC.. 0201..

SW21	T20.037	0.6	M 2	3.7	DMD 1650

ISO 外圆车削
长形和不稳定工件 (正角刀片)

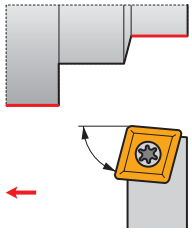


SCAC(RL) EXT 90°
CC..



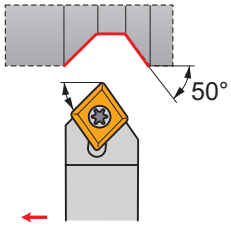
77

SCBC(RL) EXT 75°
CC..



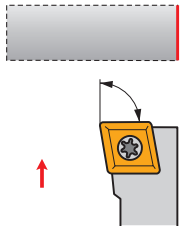
78

SCDCR EXT 45°
CC..



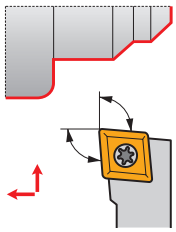
79

SCFC(RL) EXT 90°
CC..



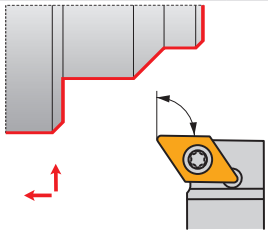
80

SCLC(RL) EXT 95°
CC..



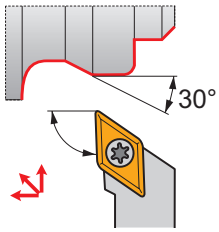
81

SDFC(RL) EXT 91°
DC..



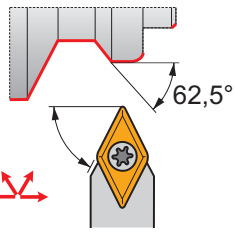
90

SDJC(RL) EXT 93°
DC..



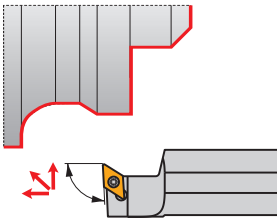
91

SDNCN EXT 62°30´
DC..



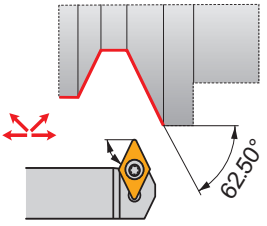
93

SDUCL EXT 93°
DC..



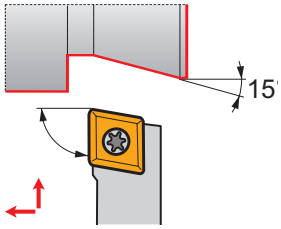
94

SDXC(RL) EXT 62°30´
DC..



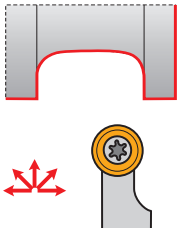
95

SEGC(RL) EXT 90°
EC..



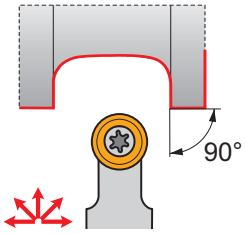
103

SRDC(RL) EXT
RC..



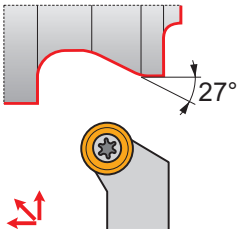
112

SRDCN EXT
RC..



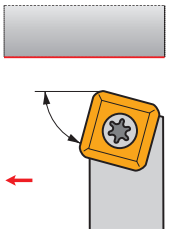
113

SRSC (RL) EXT
RC..



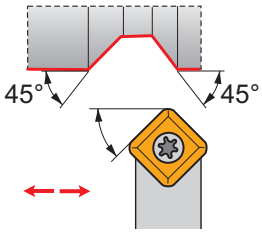
114

SSBC(RL) EXT 75°
SC..



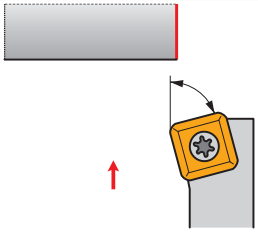
119

SSDCN EXT 45°
SC..



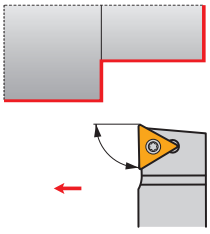
120

SSKC(RL) EXT 75°
SC..



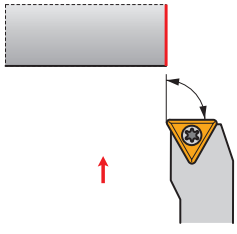
121

STAC(RL) EXT 90°
TC..



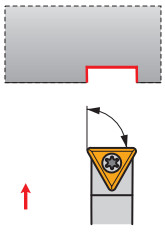
125

STFC(RL) EXT 90°
TC..



126

STFC(RL)-A EXT 90°
TC..

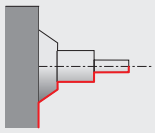


127

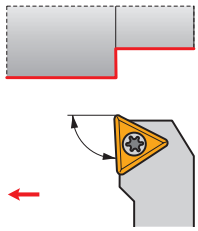
S 夹紧类型

刀具 – 导航工具

ISO 外圆车削
长形和不稳定工件 (正角刀片)

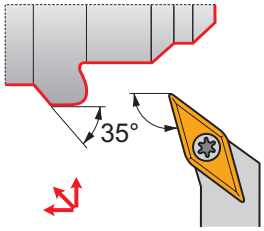


STJC(RL) EXT 93°
TC..



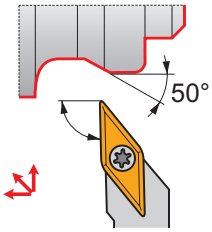
128

SVHB(C)(RL) EXT 107°30´
VB, VC..



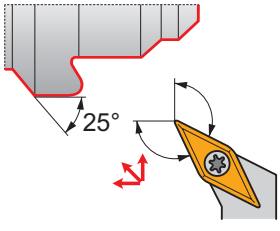
132

SVJB(C)(RL) EXT 93°
VB, VC..



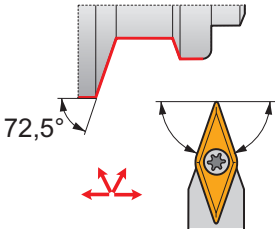
133

SVPB(C)(RL) EXT 117°30´
VB, VC..



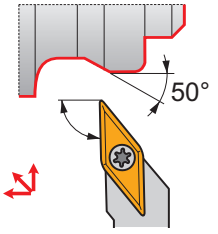
135

SVVB(C)N EXT 72°30´
VB, VC..



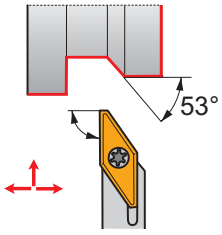
136

SVXB(C)(RL) EXT 98°
VB, VC..



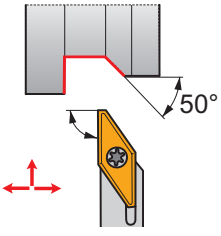
137

SVAC(RL)-DC EXT 90°
VC..



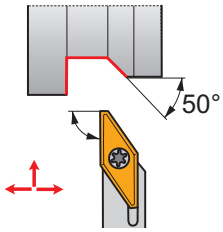
145

SVJC(RL)-DC EXT 93°
VC..



146

SWLC(RL) EXT 95°
WC..

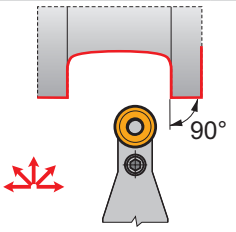


150

P 夹紧类型

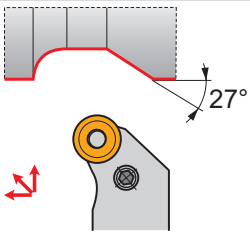
刀具 – 导航工具

PRDCN EXT
RC..



110

PRSC(RL) EXT
RC..

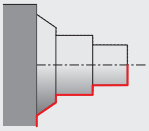


111

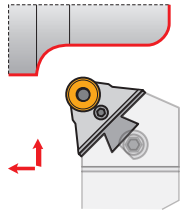
KHP / DKH 夹紧类型

刀具 – 导航工具

ISO 外圆重载车削
可换刀头(KH)

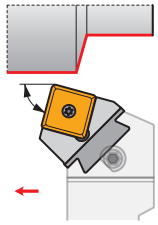


KHP-RSCR/L
RC..



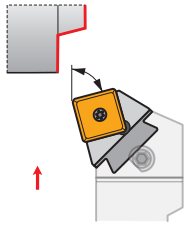
117

KHS-SBCR 75°
SC..



123

KHS-SBCL 75°
SC..



123

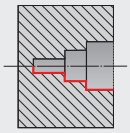
DKH(RL)

118, 124

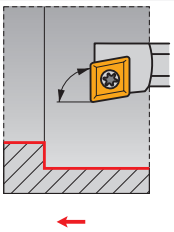
S 夹紧类型

ISO 内孔车削

长形和不稳定工件 (正角刀片)

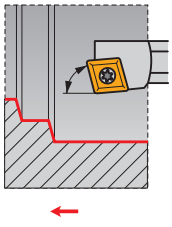


SCFC(RL) INT 90°
CC..



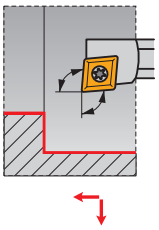
84

SCKC(RL) INT 75°
CC..



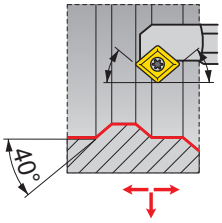
85

SCLC(RL) INT 45°
CC..



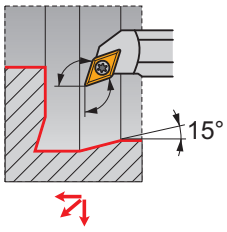
86

SCXC(RL) INT 90°
CC..



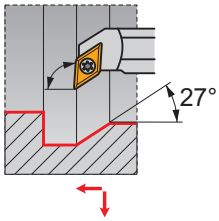
88

SDQC(RL) INT 95°
DC..



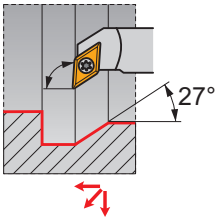
98

SDUC(RL) INT 93°
DC..



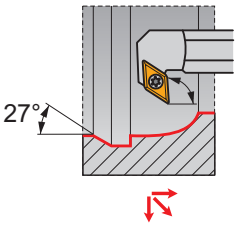
99

SDUC(RL)-E INT 62°30´
DC..



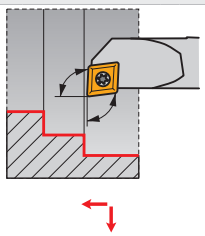
100

SDZC(RL) INT 90°
DC..



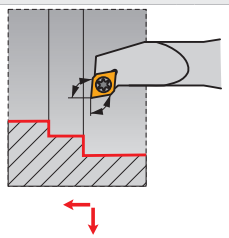
101

SEUC(RL) INT 93°
EC..



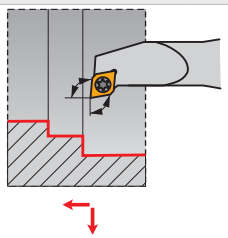
104

SELP(RL) INT 95°
EP..



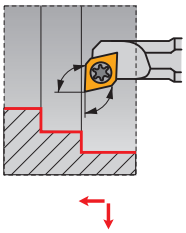
105

SELP(RL)-E INT 95°
EP..



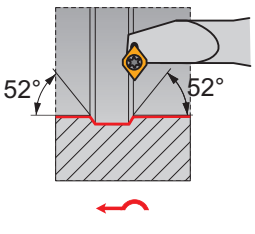
106

SEUP(RL) INT 93°
EP..



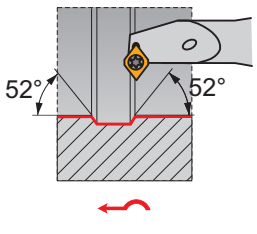
107

SEXP(RL) INT 52°30´
EP..



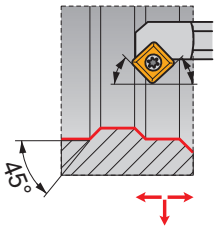
108

SEXP(RL)-E INT 52°30´
EP..



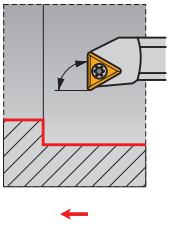
109

SSSC(RL) INT 45°
SC..



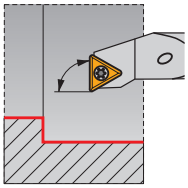
122

STFC(RL) INT 90°
TC..



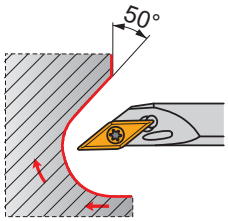
129

STFC(RL)-E INT 90°
TC..



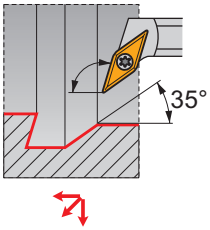
131

SVJB(RL) INT 93°
VB, VC..



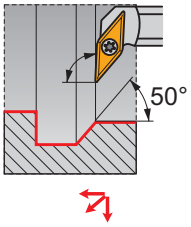
141

SVQB(C)(RL) INT 107°30´
VB, VC..



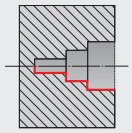
142

SVUB(C)(RL) INT 93°
VB, VC..

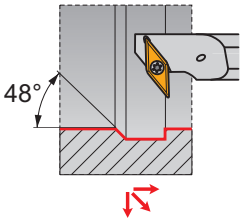


143

ISO 内孔车削
长形和不稳定工件 (正角刀片)

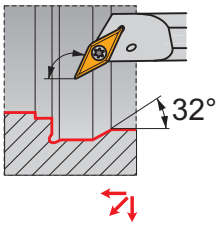


SVLC(RL) INT 95°
VC..



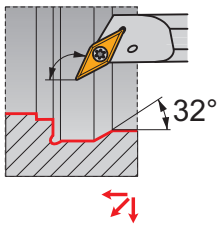
147

SVXC(RL) INT 113°
VC..



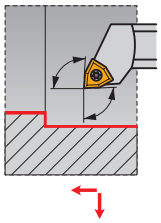
148

SVXC(RL)-E INT 113°
VC..



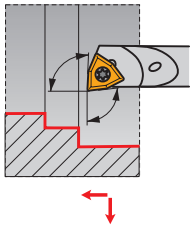
149

SWLC(RL) INT 95°
WC..



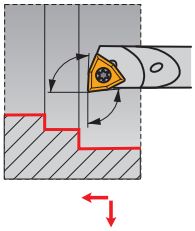
151

SWUC(RL) INT 93°
WC..



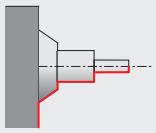
152

SWUC(RL)-E INT 93°
WC..

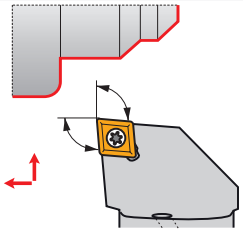


153

ISO 外圆车削 PSC
长形和不稳定工件 (正角刀片)

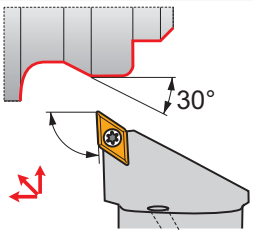


C.-SCLC(RL) EXT 95°
CC..



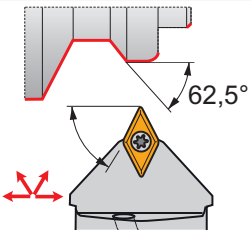
83

C.-SDJC(RL) EXT 93°
DC..



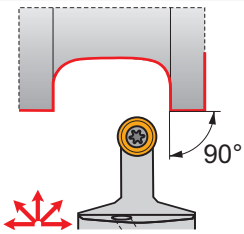
96

C.-SDNCN EXT 62°30´
DC..



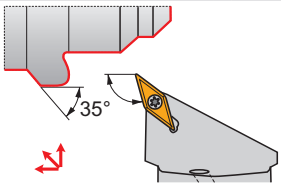
97

C.-SRDCN EXT
RC..



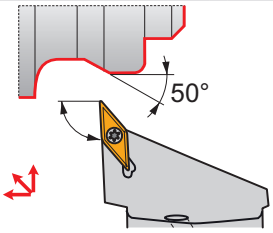
116

C.-SVHB(RL) EXT 107°30´
VB, VC..



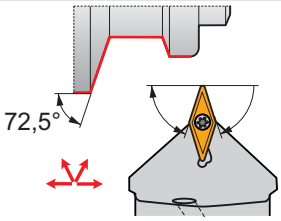
138

C.-SVJB(RL) EXT 93°
VB, VC..



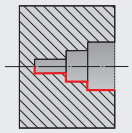
139

C.-SVVBN EXT 72°30´
VB, VC..

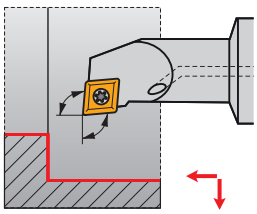


140

ISO 内孔车削 PSC
长形和不稳定工件 (正角刀片)

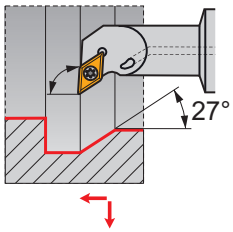


C.-SCLC(RL) INT 95°
CC..



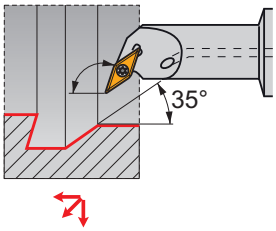
89

C.-SDUC(RL) INT 93°
DC..

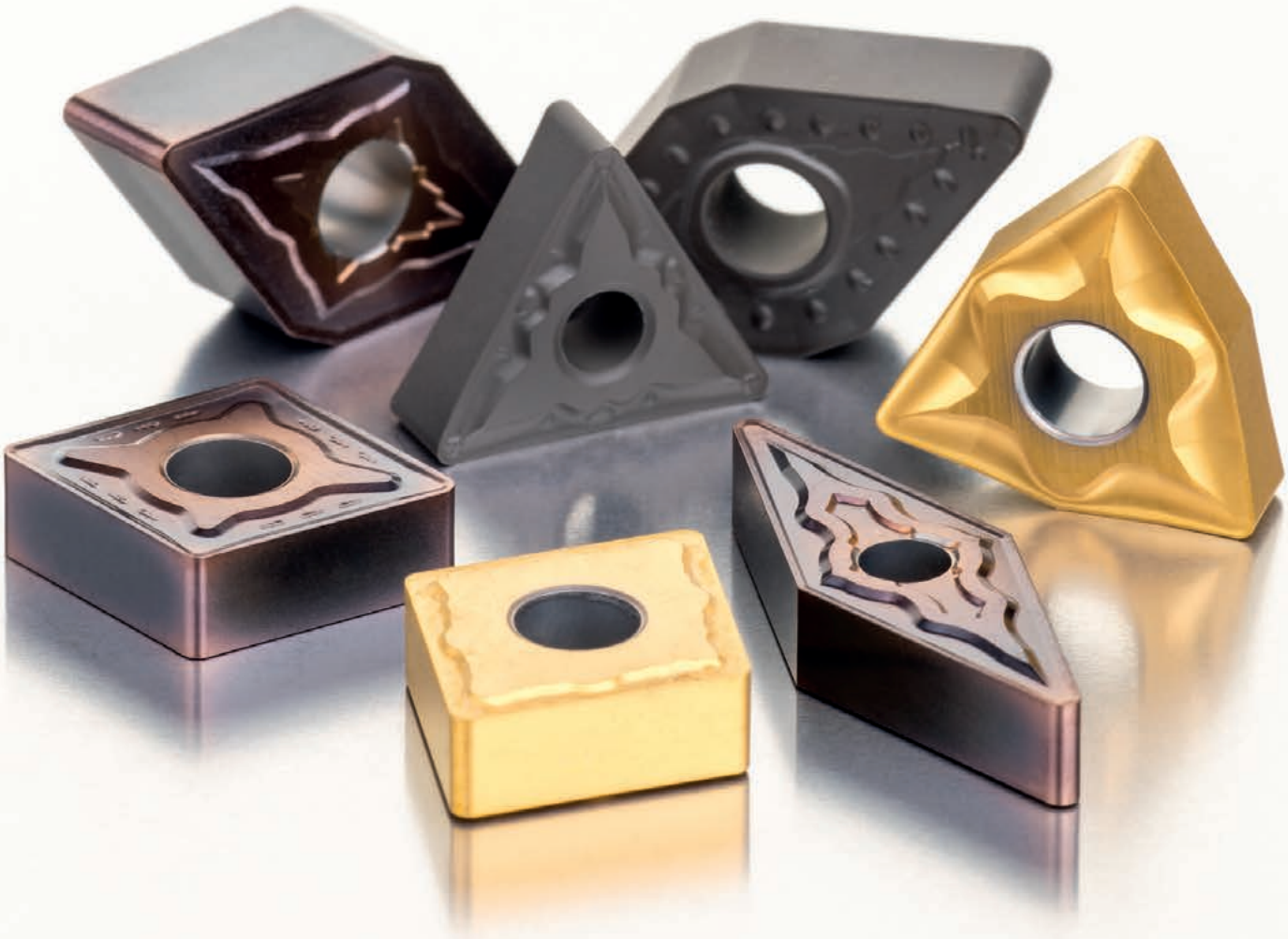


102

C.-SVQB(C)(RL) INT 108°
VB, VC..



144

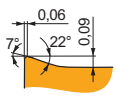
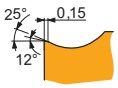
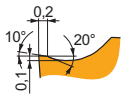


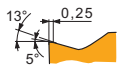
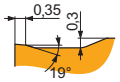
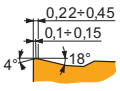
负前角刀片

负前角ISO刀片 – 断屑槽导航工具

P

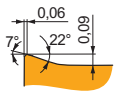
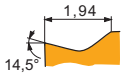
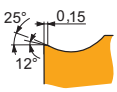
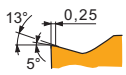
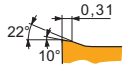
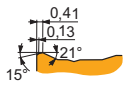
	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

FF		大正前角槽型，设计用于不锈钢和钢，部分铸铁，连续切削
NF		大正前角槽型，设计用于超精加工和中等精度加工，不锈钢，钢，部分铸铁，有色金属材料和高温合金，连续切削
FM		正前角槽型，设计用于精加工至半粗加工，钢和铸铁，也可以用于加工有色金属材料和高温合金，连续切削及适度断续切削

SM		正前角槽型，设计用于中等精度加工，不锈钢、高温合金、钢和铸铁，部分有色金属和硬质材料，并且用于加工薄壁，连续切削和断续切削
RM		设计用于半粗加工和粗加工，钢、不锈钢和铸铁，部分高温合金，连续切削及断续切削
OR		设计用于精加工至重载粗加工，钢和铸铁，部分不锈钢和高温合金，连续切削及断续切削

M

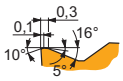
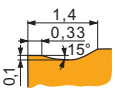
	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

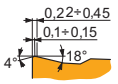
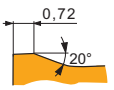
FF		大正前角槽型，设计用于超精加工，不锈钢和钢，部分铸铁，连续切削
SF		通用正前角槽型，设计用于超精加工，钢、不锈钢、铸铁和高温合金，以及硬质材料，部分有色金属材料，并且用于加工薄壁，连续切削
NF		大正前角槽型，设计用于超精加工和中等精度加工，不锈钢，钢，部分铸铁，有色金属材料和高温合金，连续切削
SM		正前角槽型，设计用于中等精度加工，不锈钢、高温合金、钢和铸铁，部分有色金属和硬质材料，并且用于加工薄壁，连续切削和断续切削
NMR		正前角槽型，设计用于中等精度加工至粗加工，不锈钢和软钢以及高温合金，连续切削
NR2		设计用于精加工至粗加工，不锈钢和钢，部分铸铁和高温合金，连续切削及断续切削

负前角ISO刀片 – 断屑槽导航工具

K

	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

.NMA		设计用于超精加工至半粗加工，铸铁，部分硬质材料，连续切削及轻断续切削
M		设计用于精加工和半粗加工，铸铁，部分钢和硬质材料，连续切削及断续切削
KR		设计用于半粗加工和粗加工，铸铁，部分钢和硬质材料，连续切削及断续切削

OR		设计用于精加工至重载粗加工，钢和铸铁，部分不锈钢和高温合金，连续切削及断续切削
HR2		设计用于快进给粗加工至重载粗加工，钢和铸铁，部分不锈钢，连续切削及断续切削

负前角ISO刀片 – 断屑槽导航工具

N

非常不稳定工况

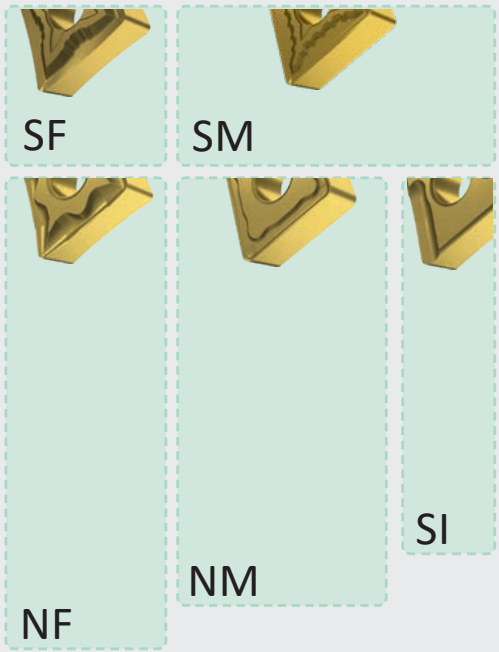
不稳定工况

稳定工况

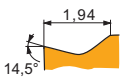
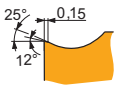
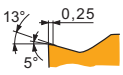
薄壁和细长工件

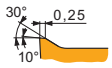
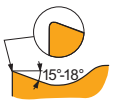
首选

可以使用



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF		通用正前角槽型，设计用于超精加工，钢、不锈钢、铸铁和高温合金，以及硬质材料，部分有色金属材料，并且用于加工薄壁，连续切削
NF		大正前角设计，用于超精加工和中等精度加工，不锈钢，钢，部分铸铁，有色金属材料和高温合金，连续切削
SM		正前角槽型，设计用于中等精度加工，不锈钢、高温合金、钢和铸铁，部分有色金属和硬质材料，并且用于加工薄壁，连续切削和断续切削

NM		大正前角槽型，设计用于超精加工、中等精度加工和粗加工，不锈钢，钢，部分有色金属材料和高温合金，连续切削
SI		正前角槽型，设计用于超精加工至半粗加工，钢、不锈钢和铸铁以及部分有色金属材料，连续切削

负前角ISO刀片 – 断屑槽导航工具

S

首选

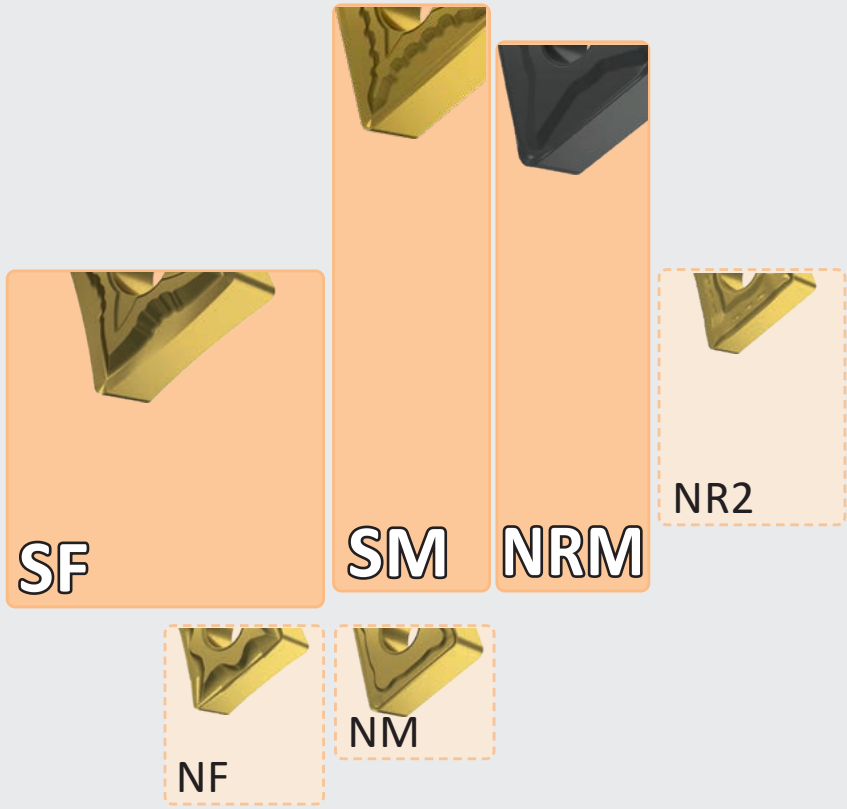
可以使用

非常不稳定工况

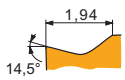
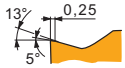
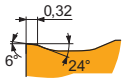
不稳定工况

稳定工况

薄壁和细长工件

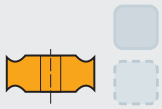


	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF		通用正前角槽型，设计用于超精加工，钢、不锈钢、铸铁和高温合金，以及硬质材料，部分有色金属材料，并且用于加工薄壁，连续切削
SM		正前角槽型，设计用于中等精度加工，不锈钢、高温合金、钢和铸铁，部分有色金属和硬质材料，并且用于加工薄壁，连续切削和断续切削
NRM		正前角槽型，设计用于半粗加工和粗加工，不锈钢、软钢和高温合金，连续切削

负前角ISO刀片 – 断屑槽导航工具

H



首选

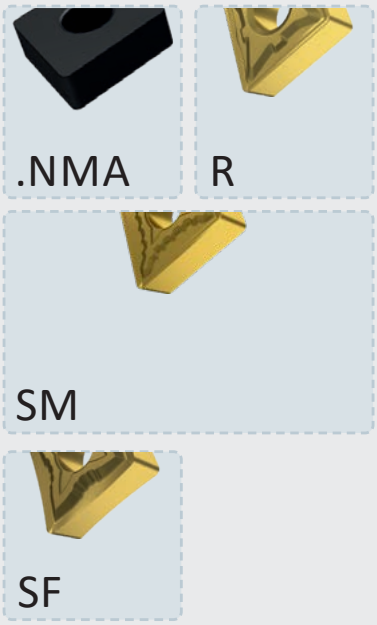
可以使用

非常不稳定工况

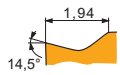
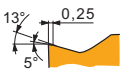
不稳定工况

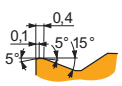
稳定工况

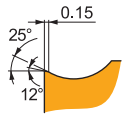
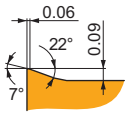
薄壁和细长工件



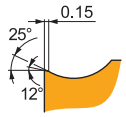
	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF		通用正前角槽型，设计用于超精加工，钢、不锈钢、铸铁和高温合金，以及硬质材料，部分有色金属材料，并且用于加工薄壁，连续切削
SM		正前角槽型，设计用于中等精度加工，不锈钢、高温合金、钢和铸铁，部分有色金属和硬质材料，并且用于加工薄壁，连续切削和断续切削
.NMA		设计用于超精加工至半粗加工，铸铁，部分硬质材料，连续切削及轻断续切削

R		设计用于半粗加工和粗加工，铸铁，部分钢和硬质材料，连续切削及断续切削

NF			NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。
FF			FF 断屑槽型锋利，专为钢和不锈钢的精加工而设计。具有正前角和窄的T-型倒棱。也有条件地适用于铸铁。

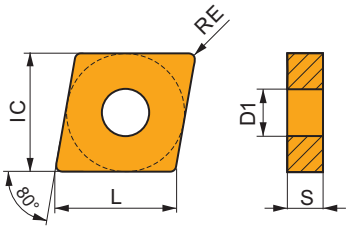
NF



NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。

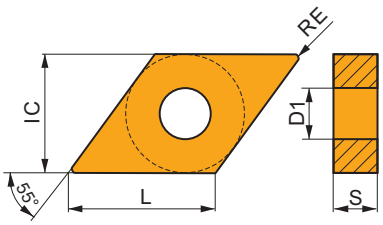
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76



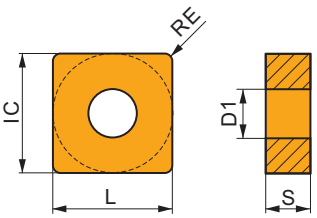
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



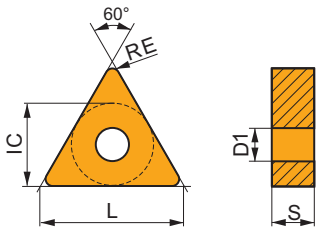
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



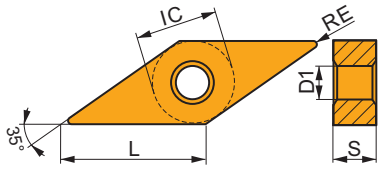
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76



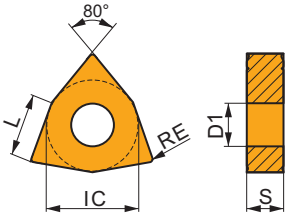
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



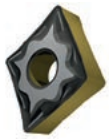
WNMG

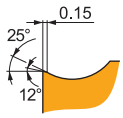
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



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。

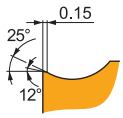
Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)





NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。

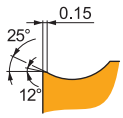
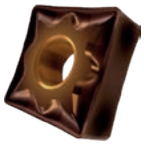
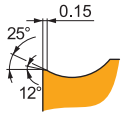
CNMG 090304E-NF:T6310	●	0.4	■	190	0.17	0.8	■	135	0.15	0.8	◪	150	0.17	0.8	◪	570	0.20	0.8	◪	55	0.12	0.6	–	–	–
CNMG 090304E-NF:T7335	●	0.4	◪	210	0.18	0.8	■	160	0.16	0.8		–	–	–		–	–	–	◪	65	0.16	0.6	–	–	–
CNMG 090304E-NF:T8430	●	0.4	■	225	0.17	0.8	■	120	0.15	0.8	◪	185	0.17	0.8	◪	615	0.20	0.8	◪	45	0.12	0.6	–	–	–
CNMG 090304E-NF:T9325	●	0.4	■	265	0.18	0.8	■	155	0.16	0.8	◪	250	0.18	0.8		–	–	–	◪	55	0.16	0.6	–	–	–
CNMG 090308E-NF:T8430	⬌	0.8	■	245	0.19	1.0	■	135	0.17	1.0	◪	200	0.19	1.0	◪	675	0.23	1.0	◪	50	0.15	0.8	–	–	–
CNMG 090308E-NF:T9325	●	0.8	■	300	0.19	1.0	■	180	0.17	1.0	◪	285	0.19	1.0		–	–	–	◪	65	0.15	0.8	–	–	–
CNMG 120404E-NF:HF7	●	0.4		–	–	–	◪	95	0.15	1.7	◪	155	0.17	1.7	◪	495	0.20	1.7		–	–	–	–	–	–
CNMG 120404E-NF:T6310	●	0.4	■	180	0.17	1.7	■	125	0.15	1.7	◪	145	0.17	1.7	◪	540	0.20	1.7	◪	50	0.14	1.4	–	–	–
CNMG 120404E-NF:T7325	●	0.4	◪	200	0.18	1.7	■	155	0.16	1.7		–	–	–		–	–	–	◪	65	0.16	1.4	–	–	–
CNMG 120404E-NF:T7335	●	0.4	◪	195	0.18	1.7	■	150	0.16	1.7		–	–	–		–	–	–	◪	60	0.16	1.4	–	–	–
CNMG 120404E-NF:T8315	●	0.4	◪	185	0.17	1.7	■	110	0.15	1.7	◪	175	0.17	1.7	◪	555	0.20	1.7	◪	45	0.14	1.4	–	–	–
CNMG 120404E-NF:T8430	●	0.4	■	200	0.17	1.7	■	110	0.15	1.7	◪	165	0.17	1.7	◪	555	0.20	1.7	◪	40	0.14	1.4	–	–	–
CNMG 120404E-NF:T9325	●	0.4	■	250	0.18	1.7	■	150	0.16	1.7	◪	235	0.18	1.7		–	–	–	◪	55	0.16	1.4	–	–	–
CNMG 120404E-NF:T9415	●	0.4	■	315	0.17	1.7		–	–	–	◪	295	0.17	1.7		–	–	–		–	–	–	–	–	–
CNMG 120408E-NF:HF7	●	0.8		–	–	–	◪	110	0.17	1.7	◪	180	0.19	1.7	◪	570	0.23	1.7		–	–	–	–	–	–
CNMG 120408E-NF:T6310	⬌	0.8	■	200	0.19	1.7	■	140	0.17	1.7	◪	160	0.19	1.7	◪	600	0.23	1.7	◪	60	0.15	1.4	–	–	–
CNMG 120408E-NF:T7325	⬌	0.8	◪	235	0.19	1.7	■	180	0.17	1.7		–	–	–		–	–	–	◪	75	0.15	1.4	–	–	–
CNMG 120408E-NF:T7335	⬌	0.8	◪	225	0.19	1.7	■	175	0.17	1.7		–	–	–		–	–	–	◪	70	0.15	1.4	–	–	–
CNMG 120408E-NF:T8315	⬌	0.8	◪	215	0.19	1.7	■	125	0.17	1.7	◪	200	0.19	1.7	◪	645	0.23	1.7	◪	50	0.15	1.4	–	–	–
CNMG 120408E-NF:T8430	⬌	0.8	■	235	0.19	1.7	■	125	0.17	1.7	◪	190	0.19	1.7	◪	645	0.23	1.7	◪	50	0.15	1.4	–	–	–
CNMG 120408E-NF:T9325	⬌	0.8	■	285	0.19	1.7	■	170	0.17	1.7	◪	270	0.19	1.7		–	–	–	◪	60	0.15	1.4	–	–	–
CNMG 120408E-NF:T9415	●	0.8	■	360	0.19	1.7		–	–	–	◪	340	0.19	1.7		–	–	–		–	–	–	–	–	–
CNMG 120412E-NF:T6310	⬌	1.2	■	185	0.30	2.1	■	130	0.27	2.1	◪	145	0.30	2.1	◪	555	0.36	2.1	◪	55	0.21	1.7	–	–	–
CNMG 120412E-NF:T7325	⬌	1.2	◪	205	0.30	2.1	■	155	0.27	2.1		–	–	–		–	–	–	◪	65	0.21	1.7	–	–	–
CNMG 120412E-NF:T7335	⬌	1.2	◪	200	0.30	2.1	■	155	0.27	2.1		–	–	–		–	–	–	◪	65	0.21	1.7	–	–	–
CNMG 120412E-NF:T8430	⬌	1.2	■	200	0.30	2.1	■	110	0.27	2.1	◪	165	0.30	2.1	◪	555	0.36	2.1	◪	40	0.21	1.7	–	–	–
CNMG 120412E-NF:T9415	⬌	1.2	■	315	0.30	2.1		–	–	–	◪	295	0.30	2.1		–	–	–		–	–	–	–	–	–



NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。

DNMG 110404E-NF:T6310	●	0.4	■	155	0.15	0.8	■	110	0.14	0.8	◪	125	0.15	0.8	◪	465	0.18	0.8	◪	45	0.12	0.6	–	–	–
DNMG 110404E-NF:T7325	●	0.4	◪	170	0.18	0.8	■	130	0.16	0.8		–	–	–		–	–	–	◪	55	0.16	0.6	–	–	–
DNMG 110404E-NF:T7335	●	0.4	◪	165	0.18	0.8	■	125	0.16	0.8		–	–	–		–	–	–	◪	50	0.16	0.6	–	–	–
DNMG 110404E-NF:T8430	●	0.4	■	190	0.15	0.8	■	105	0.14	0.8	◪	155	0.15	0.8	◪	525	0.18	0.8	◪	40	0.12	0.6	–	–	–
DNMG 110404E-NF:T9325	●	0.4	■	210	0.18	0.8	■	125	0.16	0.8	◪	195	0.18	0.8		–	–	–	◪	45	0.16	0.6	–	–	–
DNMG 110408E-NF:T6310	●	0.8	■	175	0.17	1.0	■	125	0.15	1.0	◪	140	0.17	1.0	◪	525	0.20	1.0	◪	50	0.14	0.8	–	–	–
DNMG 110408E-NF:T7325	●	0.8	◪	200	0.18	1.0	■	155	0.16	1.0		–	–	–		–	–	–	◪	65	0.16	0.8	–	–	–
DNMG 110408E-NF:T7335	●	0.8	◪	195	0.18	1.0	■	150	0.16	1.0		–	–	–		–	–	–	◪	60	0.16	0.8	–	–	–
DNMG 110408E-NF:T8430	●	0.8	■	205	0.17	1.0	■	110	0.15	1.0	◪	170	0.17	1.0	◪	570	0.20	1.0	◪	45	0.14	0.8	–	–	–
DNMG 110408E-NF:T9325	●	0.8	■	250	0.18	1.0	■	150	0.16	1.0	◪	235	0.18	1.0		–	–	–	◪	55	0.16	0.8	–	–	–
DNMG 110408E-NF:T9415	●	0.8	■	315	0.17	1.0		–	–	–	◪	295	0.17	1.0		–	–	–		–	–	–	–	–	–
DNMG 150404E-NF:T6310	●	0.4	■	140	0.17	1.7	■	100	0.15	1.7	◪	110	0.17	1.7	◪	420	0.20	1.7	◪	40	0.15	1.4	–	–	–
DNMG 150404E-NF:T7325	●	0.4	◪	160	0.18	1.7	■	120	0.16	1.7		–	–	–		–	–	–	◪	50	0.16	1.4	–	–	–
DNMG 150404E-NF:T7335	●	0.4	◪	155	0.18	1.7	■	120	0.16	1.7		–	–	–		–	–	–	◪	50	0.16	1.4	–	–	–
DNMG 150404E-NF:T8430	●	0.4	■	165	0.17	1.7	■	90	0.15	1.7	◪	135	0.17	1.7	◪	450	0.20	1.7	◪	35	0.15	1.4	–	–	–
DNMG 150404E-NF:T9325	●	0.4	■	200	0.18	1.7	■	120	0.16	1.7	◪	190	0.18	1.7		–	–	–	◪	45	0.16	1.4	–	–	–
DNMG 150404E-NF:T9415	●	0.4	■	260	0.15	1.7		–	–	–	◪	245	0.15	1.7		–	–	–		–	–	–	–	–	–
DNMG 150408E-NF:T6310	●	0.8	■	165	0.18	1.7	■	115	0.16	1.7	◪	130	0.18	1.7	◪	495	0.22	1.7	◪	45	0.16	1.4	–	–	–
DNMG 150408E-NF:T7325	●	0.8	◪	190	0.18	1.7	■	145	0.16	1.7		–	–	–		–	–	–	◪	60	0.16	1.4	–	–	–
DNMG 150408E-NF:T7335	●	0.8	◪	185	0.18	1.7	■	140	0.16	1.7		–	–	–		–	–	–	◪	60	0.16	1.4	–	–	–
DNMG 150408E-NF:T8430	●	0.8	■	190	0.18	1.7	■	105	0.16	1.7	◪	155	0.18	1.7	◪	525	0.22	1.7	◪	40	0.16	1.4	–	–	–
DNMG 150408E-NF:T9325	●	0.8	■	235	0.18	1.7	■	140	0.16	1.7	◪	220	0.18	1.7		–	–	–	◪	50	0.16	1.4	–	–	–
DNMG 150408E-NF:T9415	●	0.8	■	300	0.17	1.7		–	–	–	◪	285	0.17	1.7		–	–	–		–	–	–	–	–	–

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/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)
																				
NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。																				
DNMG 150604E-NF:HF7	●	0.4	–	–	–	80	0.14	1.9	130	0.15	1.9	420	0.18	1.9	–	–	–	–	–	–
DNMG 150604E-NF:T6310	●	0.4	140	0.17	1.9	100	0.15	1.9	110	0.17	1.9	420	0.20	1.9	40	0.15	1.5	–	–	–
DNMG 150604E-NF:T7325	●	0.4	155	0.18	1.9	120	0.16	1.9	–	–	–	–	–	–	50	0.16	1.5	–	–	–
DNMG 150604E-NF:T7335	●	0.4	150	0.18	1.9	115	0.16	1.9	–	–	–	–	–	–	45	0.16	1.5	–	–	–
DNMG 150604E-NF:T8315	●	0.4	145	0.17	1.9	85	0.15	1.9	135	0.17	1.9	435	0.20	1.9	35	0.15	1.5	–	–	–
DNMG 150604E-NF:T8430	●	0.4	165	0.17	1.9	90	0.15	1.9	135	0.17	1.9	450	0.20	1.9	35	0.15	1.5	–	–	–
DNMG 150604E-NF:T9325	●	0.4	195	0.18	1.9	115	0.16	1.9	185	0.18	1.9	–	–	–	40	0.16	1.5	–	–	–
DNMG 150604E-NF:T9415	●	0.4	260	0.15	1.9	–	–	–	245	0.15	1.9	–	–	–	–	–	–	–	–	–
DNMG 150608E-NF:HF7	●	0.8	–	–	–	90	0.15	1.9	145	0.17	1.9	465	0.20	1.9	–	–	–	–	–	–
DNMG 150608E-NF:T6310	●	0.8	165	0.18	1.9	115	0.16	1.9	130	0.18	1.9	495	0.22	1.9	45	0.16	1.5	–	–	–
DNMG 150608E-NF:T7325	●	0.8	185	0.18	1.9	140	0.16	1.9	–	–	–	–	–	–	60	0.16	1.5	–	–	–
DNMG 150608E-NF:T7335	●	0.8	180	0.18	1.9	140	0.16	1.9	–	–	–	–	–	–	55	0.16	1.5	–	–	–
DNMG 150608E-NF:T8315	●	0.8	175	0.18	1.9	105	0.16	1.9	165	0.18	1.9	525	0.22	1.9	40	0.16	1.5	–	–	–
DNMG 150608E-NF:T8430	●	0.8	190	0.18	1.9	105	0.16	1.9	155	0.18	1.9	525	0.22	1.9	40	0.16	1.5	–	–	–
DNMG 150608E-NF:T9325	●	0.8	230	0.18	1.9	135	0.16	1.9	215	0.18	1.9	–	–	–	50	0.16	1.5	–	–	–
DNMG 150608E-NF:T9415	●	0.8	295	0.17	1.9	–	–	–	280	0.17	1.9	–	–	–	–	–	–	–	–	–
DNMG 150612E-NF:T6310	●	1.2	150	0.30	1.5	105	0.27	1.5	120	0.30	1.5	450	0.36	1.5	45	0.21	1.2	–	–	–
DNMG 150612E-NF:T8430	⬌	1.2	165	0.30	1.5	90	0.27	1.5	135	0.30	1.5	450	0.36	1.5	35	0.21	1.2	–	–	–
 																				
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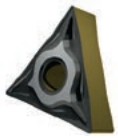
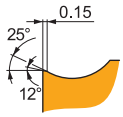
SNMG 120404E-NF:T6310	●	0.4	185	0.17	1.7	130	0.15	1.7	145	0.17	1.7	555	0.20	1.7	55	0.14	1.4	–	–	–
SNMG 120404E-NF:T7335	●	0.4	205	0.18	1.7	155	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–
SNMG 120404E-NF:T8430	●	0.4	210	0.17	1.7	115	0.15	1.7	175	0.17	1.7	585	0.20	1.7	45	0.14	1.4	–	–	–
SNMG 120404E-NF:T9325	●	0.4	260	0.18	1.7	155	0.16	1.7	245	0.18	1.7	–	–	–	55	0.16	1.4	–	–	–
SNMG 120408E-NF:HF7	⬌	0.8	–	–	–	120	0.17	1.7	190	0.19	1.7	600	0.23	1.7	–	–	–	–	–	–
SNMG 120408E-NF:T6310	⬌	0.8	210	0.19	1.7	150	0.17	1.7	165	0.19	1.7	630	0.23	1.7	60	0.15	1.4	–	–	–
SNMG 120408E-NF:T7325	⬌	0.8	245	0.19	1.7	190	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
SNMG 120408E-NF:T7335	⬌	0.8	240	0.19	1.7	185	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
SNMG 120408E-NF:T8315	⬌	0.8	230	0.19	1.7	135	0.17	1.7	215	0.19	1.7	690	0.23	1.7	55	0.15	1.4	–	–	–
SNMG 120408E-NF:T8430	⬌	0.8	250	0.19	1.7	135	0.17	1.7	205	0.19	1.7	690	0.23	1.7	50	0.15	1.4	–	–	–
SNMG 120408E-NF:T9325	⬌	0.8	300	0.19	1.7	180	0.17	1.7	285	0.19	1.7	–	–	–	65	0.15	1.4	–	–	–
 																				
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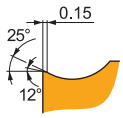
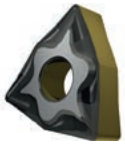
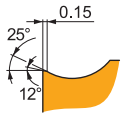
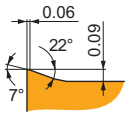
TNMG 160404E-NF:HF7	●	0.4	–	–	–	90	0.14	1.4	140	0.15	1.4	450	0.18	1.4	–	–	–	–	–	–
TNMG 160404E-NF:T6310	●	0.4	150	0.17	1.4	105	0.15	1.4	120	0.17	1.4	450	0.20	1.4	45	0.15	1.1	–	–	–
TNMG 160404E-NF:T7325	●	0.4	170	0.18	1.4	130	0.16	1.4	–	–	–	–	–	–	55	0.16	1.1	–	–	–
TNMG 160404E-NF:T7335	●	0.4	165	0.18	1.4	125	0.16	1.4	–	–	–	–	–	–	50	0.16	1.1	–	–	–
TNMG 160404E-NF:T8315	●	0.4	160	0.17	1.4	95	0.15	1.4	150	0.17	1.4	480	0.20	1.4	40	0.15	1.1	–	–	–
TNMG 160404E-NF:T8430	●	0.4	175	0.17	1.4	95	0.15	1.4	140	0.17	1.4	480	0.20	1.4	35	0.15	1.1	–	–	–
TNMG 160404E-NF:T9325	●	0.4	215	0.18	1.4	125	0.16	1.4	200	0.18	1.4	–	–	–	45	0.16	1.1	–	–	–
TNMG 160404E-NF:T9415	●	0.4	285	0.15	1.4	–	–	–	270	0.15	1.4	–	–	–	–	–	–	–	–	–
TNMG 160408E-NF:HF7	●	0.8	–	–	–	100	0.15	1.4	160	0.17	1.4	510	0.20	1.4	–	–	–	–	–	–
TNMG 160408E-NF:T6310	●	0.8	180	0.18	1.4	125	0.16	1.4	145	0.18	1.4	540	0.22	1.4	50	0.16	1.1	–	–	–
TNMG 160408E-NF:T7325	●	0.8	200	0.18	1.4	155	0.16	1.4	–	–	–	–	–	–	65	0.16	1.1	–	–	–
TNMG 160408E-NF:T7335	●	0.8	195	0.18	1.4	150	0.16	1.4	–	–	–	–	–	–	60	0.16	1.1	–	–	–
TNMG 160408E-NF:T8315	●	0.8	190	0.18	1.4	110	0.16	1.4	180	0.18	1.4	570	0.22	1.4	45	0.16	1.1	–	–	–
TNMG 160408E-NF:T8430	●	0.8	205	0.18	1.4	110	0.16	1.4	170	0.18	1.4	570	0.22	1.4	45	0.16	1.1	–	–	–
TNMG 160408E-NF:T9325	●	0.8	255	0.18	1.4	150	0.16	1.4	240	0.18	1.4	–	–	–	55	0.16	1.1	–	–	–

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。

Product	●	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)
																				
NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。																				
VNMG 160404E-NF:T6310	●	0.4	140	0.12	1.2	100	0.11	1.2	110	0.12	1.2	420	0.14	1.2	40	0.11	1.0	–	–	–
VNMG 160404E-NF:T7325	●	0.4	140	0.18	1.2	105	0.16	1.2	–	–	–	–	–	–	45	0.16	1.0	–	–	–
VNMG 160404E-NF:T7335	●	0.4	140	0.18	1.2	105	0.16	1.2	–	–	–	–	–	–	45	0.16	1.0	–	–	–
VNMG 160404E-NF:T8315	●	0.4	150	0.12	1.2	90	0.11	1.2	140	0.12	1.2	450	0.14	1.2	35	0.11	1.0	–	–	–
VNMG 160404E-NF:T8430	●	0.4	175	0.12	1.2	95	0.11	1.2	140	0.12	1.2	480	0.14	1.2	35	0.11	1.0	–	–	–
VNMG 160404E-NF:T9325	●	0.4	180	0.18	1.2	105	0.16	1.2	170	0.18	1.2	–	–	–	40	0.16	1.0	–	–	–
VNMG 160404E-NF:T9415	●	0.4	255	0.12	1.2	–	–	–	240	0.12	1.2	–	–	–	–	–	–	–	–	–
VNMG 160408E-NF:T6310	●	0.8	145	0.17	1.4	100	0.15	1.4	115	0.17	1.4	435	0.20	1.4	40	0.14	1.1	–	–	–
VNMG 160408E-NF:T7325	●	0.8	165	0.18	1.4	125	0.16	1.4	–	–	–	–	–	–	50	0.16	1.1	–	–	–
VNMG 160408E-NF:T7335	●	0.8	160	0.18	1.4	120	0.16	1.4	–	–	–	–	–	–	50	0.16	1.1	–	–	–
VNMG 160408E-NF:T8315	●	0.8	160	0.17	1.4	95	0.15	1.4	150	0.17	1.4	480	0.20	1.4	40	0.14	1.1	–	–	–
VNMG 160408E-NF:T8430	●	0.8	175	0.17	1.4	95	0.15	1.4	140	0.17	1.4	480	0.20	1.4	35	0.14	1.1	–	–	–
VNMG 160408E-NF:T9325	●	0.8	210	0.18	1.4	125	0.16	1.4	195	0.18	1.4	–	–	–	45	0.16	1.1	–	–	–
VNMG 160408E-NF:T9415	●	0.8	270	0.17	1.4	–	–	–	255	0.17	1.4	–	–	–	–	–	–	–	–	–
 																				
NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。																				
WNMG 060404E-NF:T6310	●	0.4	190	0.17	0.8	135	0.15	0.8	150	0.17	0.8	570	0.20	0.8	55	0.12	0.6	–	–	–
WNMG 060404E-NF:T7325	●	0.4	215	0.18	0.8	165	0.16	0.8	–	–	–	–	–	–	65	0.16	0.6	–	–	–
WNMG 060404E-NF:T7335	●	0.4	210	0.18	0.8	160	0.16	0.8	–	–	–	–	–	–	65	0.16	0.6	–	–	–
WNMG 060404E-NF:T8315	●	0.4	200	0.17	0.8	120	0.15	0.8	190	0.17	0.8	600	0.20	0.8	50	0.12	0.6	–	–	–
WNMG 060404E-NF:T8430	●	0.4	225	0.17	0.8	120	0.15	0.8	185	0.17	0.8	615	0.20	0.8	45	0.12	0.6	–	–	–
WNMG 060404E-NF:T9325	●	0.4	265	0.18	0.8	155	0.16	0.8	250	0.18	0.8	–	–	–	55	0.16	0.6	–	–	–
WNMG 060404E-NF:T9415	●	0.4	340	0.17	0.8	–	–	–	320	0.17	0.8	–	–	–	–	–	–	–	–	–
WNMG 060408E-NF:T6310	⬌	0.8	215	0.19	1.0	150	0.17	1.0	170	0.19	1.0	645	0.23	1.0	60	0.15	0.8	–	–	–
WNMG 060408E-NF:T7325	⬌	0.8	245	0.19	1.0	190	0.17	1.0	–	–	–	–	–	–	75	0.15	0.8	–	–	–
WNMG 060408E-NF:T8430	⬌	0.8	245	0.19	1.0	135	0.17	1.0	200	0.19	1.0	675	0.23	1.0	50	0.15	0.8	–	–	–
WNMG 060408E-NF:T9325	⬌	0.8	300	0.19	1.0	180	0.17	1.0	285	0.19	1.0	–	–	–	65	0.15	0.8	–	–	–
WNMG 060408E-NF:T9415	●	0.8	380	0.19	1.0	–	–	–	360	0.19	1.0	–	–	–	–	–	–	–	–	–
WNMG 080404E-NF:HF7	●	0.4	–	–	–	95	0.15	1.7	155	0.17	1.7	495	0.20	1.7	–	–	–	–	–	–
WNMG 080404E-NF:T6310	●	0.4	180	0.17	1.7	125	0.15	1.7	145	0.17	1.7	540	0.20	1.7	50	0.14	1.4	–	–	–
WNMG 080404E-NF:T7325	●	0.4	200	0.18	1.7	155	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–
WNMG 080404E-NF:T7335	●	0.4	195	0.18	1.7	150	0.16	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
WNMG 080404E-NF:T8315	●	0.4	185	0.17	1.7	110	0.15	1.7	175	0.17	1.7	555	0.20	1.7	45	0.14	1.4	–	–	–
WNMG 080404E-NF:T8430	●	0.4	200	0.17	1.7	110	0.15	1.7	165	0.17	1.7	555	0.20	1.7	40	0.14	1.4	–	–	–
WNMG 080404E-NF:T9325	●	0.4	250	0.18	1.7	150	0.16	1.7	235	0.18	1.7	–	–	–	55	0.16	1.4	–	–	–
WNMG 080408E-NF:HF7	●	0.8	–	–	–	110	0.17	1.7	180	0.19	1.7	570	0.23	1.7	–	–	–	–	–	–
WNMG 080408E-NF:T6310	⬌	0.8	200	0.19	1.7	140	0.17	1.7	160	0.19	1.7	600	0.23	1.7	60	0.15	1.4	–	–	–
WNMG 080408E-NF:T7325	⬌	0.8	235	0.19	1.7	180	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
WNMG 080408E-NF:T7335	⬌	0.8	225	0.19	1.7	175	0.17	1.7	–	–	–	–	–	–	70	0.15	1.4	–	–	–
WNMG 080408E-NF:T8315	⬌	0.8	215	0.19	1.7	125	0.17	1.7	200	0.19	1.7	645	0.23	1.7	50	0.15	1.4	–	–	–
WNMG 080408E-NF:T8430	⬌	0.8	235	0.19	1.7	125	0.17	1.7	190	0.19	1.7	645	0.23	1.7	50	0.15	1.4	–	–	–
WNMG 080408E-NF:T9325	⬌	0.8	285	0.19	1.7	170	0.17	1.7	270	0.19	1.7	–	–	–	60	0.15	1.4	–	–	–
WNMG 080408E-NF:T9415	●	0.8	360	0.19	1.7	–	–	–	340	0.19	1.7	–	–	–	–	–	–	–	–	–
WNMG 080412E-NF:T6310	⬌	1.2	185	0.30	2.1	130	0.27	2.1	145	0.30	2.1	555	0.36	2.1	55	0.21	1.7	–	–	–
WNMG 080412E-NF:T7325	⬌	1.2	205	0.30	2.1	155	0.27	2.1	–	–	–	–	–	–	65	0.21	1.7	–	–	–
WNMG 080412E-NF:T8430	⬌	1.2	200	0.30	2.1	110	0.27	2.1	165	0.30	2.1	555	0.36	2.1	40	0.21	1.7	–	–	–
WNMG 080412E-NF:T9415	⬌	1.2	315	0.30	2.1	–	–	–	295	0.30	2.1	–	–	–	–	–	–	–	–	–

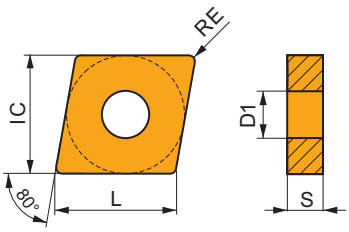
FF



FF 断屑槽型锋利，专为钢和不锈钢的精加工而设计。具有正前角和窄的T-型倒棱。也有条件地适用于铸铁。

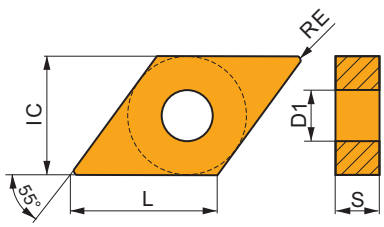
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



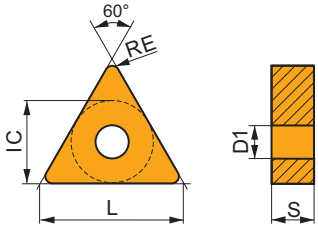
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



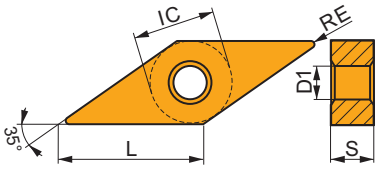
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76



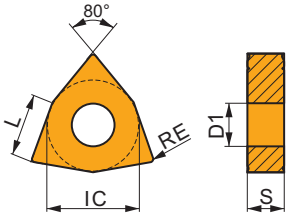
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

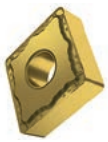
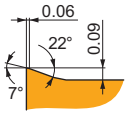


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	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/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)
 																				
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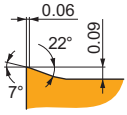
CNMG 120404E-FF:T7325	●	0.4	◪ 235	0.12	1.0	■ 180	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120404E-FF:T8315	●	0.4	◪ 220	0.12	1.0	■ 130	0.11	1.0	◪ 205	0.12	1.0	–	–	–	–	–	–	–	–	–
CNMG 120404E-FF:T8415	●	0.4	■ 260	0.12	1.0	■ 135	0.11	1.0	◪ 240	0.12	1.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-FF:T7325	●	0.8	◪ 265	0.15	1.0	■ 205	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-FF:T8315	●	0.8	◪ 245	0.15	1.0	■ 145	0.14	1.0	◪ 230	0.15	1.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-FF:T8415	●	0.8	■ 300	0.15	1.0	■ 155	0.14	1.0	◪ 270	0.15	1.0	–	–	–	–	–	–	–	–	–
																				
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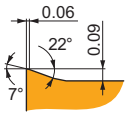
DNMG 110402E-FF:T8315	●	0.2	◪ 175	0.10	0.8	■ 105	0.09	0.8	◪ 165	0.10	0.8	–	–	–	–	–	–	–	–	–
DNMG 110402E-FF:T8415	●	0.4	■ 215	0.10	0.8	■ 110	0.09	0.8	◪ 195	0.10	0.8	–	–	–	–	–	–	–	–	–
DNMG 110404E-FF:T8315	●	0.4	◪ 175	0.12	0.8	■ 105	0.11	0.8	◪ 165	0.12	0.8	–	–	–	–	–	–	–	–	–
DNMG 110404E-FF:T8415	●	0.4	■ 215	0.12	0.8	■ 110	0.11	0.8	◪ 195	0.12	0.8	–	–	–	–	–	–	–	–	–
DNMG 110404E-FF:T8430	●	0.4	■ 205	0.12	0.8	■ 110	0.11	0.8	◪ 170	0.12	0.8	–	–	–	–	–	–	–	–	–
DNMG 110408E-FF:T8315	●	0.8	◪ 200	0.15	0.8	■ 120	0.14	0.8	◪ 190	0.15	0.8	–	–	–	–	–	–	–	–	–
DNMG 110408E-FF:T8415	●	0.4	■ 240	0.15	0.8	■ 125	0.14	0.8	◪ 215	0.15	0.8	–	–	–	–	–	–	–	–	–
DNMG 150404E-FF:T8315	●	0.4	◪ 175	0.12	1.0	■ 105	0.11	1.0	◪ 165	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150604E-FF:T8315	●	0.4	◪ 175	0.12	1.0	■ 105	0.11	1.0	◪ 165	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150604E-FF:T8415	●	0.8	■ 210	0.12	1.0	■ 110	0.11	1.0	◪ 190	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-FF:T7325	●	0.8	◪ 210	0.15	1.0	■ 160	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-FF:T8315	●	0.8	◪ 195	0.15	1.0	■ 115	0.14	1.0	◪ 185	0.15	1.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-FF:T8415	●	0.8	■ 240	0.15	1.0	■ 125	0.14	1.0	◪ 215	0.15	1.0	–	–	–	–	–	–	–	–	–
																				
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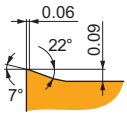
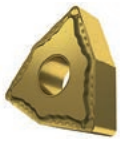
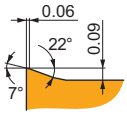
TNMG 160404E-FF:T7325	●	0.4	◪ 200	0.12	1.0	■ 155	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160404E-FF:T8315	●	0.4	◪ 185	0.12	1.0	■ 110	0.11	1.0	◪ 175	0.12	1.0	–	–	–	–	–	–	–	–	–
TNMG 160404E-FF:T8415	●	0.4	■ 225	0.12	1.0	■ 115	0.11	1.0	◪ 205	0.12	1.0	–	–	–	–	–	–	–	–	–
TNMG 160404E-FF:T8430	●	0.4	■ 210	0.12	1.0	■ 115	0.11	1.0	◪ 175	0.12	1.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-FF:T8315	●	0.8	◪ 205	0.15	1.0	■ 120	0.14	1.0	◪ 190	0.15	1.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-FF:T8415	●	0.8	■ 250	0.15	1.0	■ 130	0.14	1.0	◪ 225	0.15	1.0	–	–	–	–	–	–	–	–	–
																				
FF 断屑槽型锋利，专为钢和不锈钢的精加工而设计。具有正前角和窄的T-型倒棱。也有条件地适用于铸铁。																				
VNMG 160404E-FF:T7325	●	0.4	◪ 165	0.12	1.0	■ 125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
VNMG 160404E-FF:T8315	●	0.4	◪ 150	0.12	1.0	■ 90	0.11	1.0	◪ 140	0.12	1.0	–	–	–	–	–	–	–	–	–
VNMG 160404E-FF:T8415	●	0.4	■ 185	0.12	1.0	■ 95	0.11	1.0	◪ 165	0.12	1.0	–	–	–	–	–	–	–	–	–
VNMG 160404E-FF:T8430	●	0.4	■ 175	0.12	1.0	■ 95	0.11	1.0	◪ 140	0.12	1.0	–	–	–	–	–	–	–	–	–
 																				
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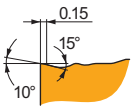
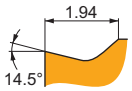
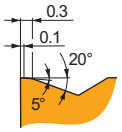
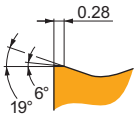
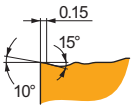
WNMG 060402E-FF:T8315	●	0.2	◪ 215	0.10	1.0	■ 125	0.09	1.0	◪ 200	0.10	1.0	–	–	–	–	–	–	–	–	–
WNMG 060402E-FF:T8415	●	0.2	■ 260	0.10	1.0	■ 135	0.09	1.0	◪ 240	0.10	1.0	–	–	–	–	–	–	–	–	–
WNMG 060404E-FF:T8315	●	0.4	◪ 220	0.12	1.0	■ 130	0.11	1.0	◪ 205	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 060404E-FF:T8415	●	0.4	■ 260	0.12	1.0	■ 135	0.11	1.0	◪ 240	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 080404E-FF:T7325	●	0.4	◪ 235	0.12	1.0	■ 180	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080404E-FF:T8315	●	0.4	◪ 220	0.12	1.0	■ 130	0.11	1.0	◪ 205	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 080404E-FF:T8415	●	0.4	■ 260	0.12	1.0	■ 135	0.11	1.0	◪ 240	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-FF:T7325	●	0.8	◪ 265	0.15	1.0	■ 205	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-FF:T8315	●	0.8	◪ 245	0.15	1.0	■ 145	0.14	1.0	◪ 230	0.15	1.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-FF:T8415	●	0.8	■ 300	0.15	1.0	■ 155	0.14	1.0	◪ 270	0.15	1.0	–	–	–	–	–	–	–	–	–

FM			FM 断屑槽用途广泛，是钢和铸铁精加工的首选。它的特点是小正前角和窄的T-型倒棱。也有条件地适用于不锈钢和耐热合金。
SF			SF 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。特点是小正前角，无T-型倒棱。还适用于钢、铸铁和硬质材料，有条件时也适用于有色金属合金。
W-M			W-M 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和适中的 T 倒棱。它也有条件地适用于铸铁。
W-MR			W-MR 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和稳定、宽阔的 T 倒棱。它也有条件地适用于不锈钢和铸铁。

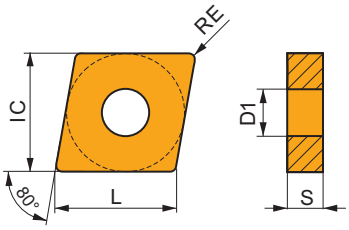
FM



FM 断屑槽用途广泛，是钢和铸铁精加工的首选。它的特点是小正前角和窄的T-型倒棱。也有条件地适用于不锈钢和耐热合金。

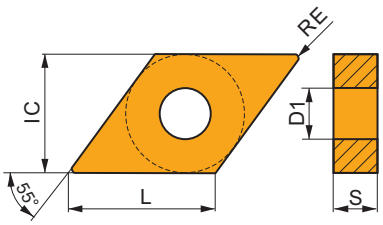
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76



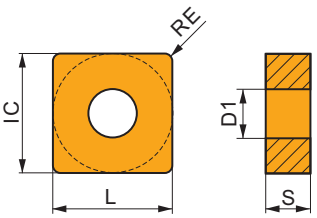
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



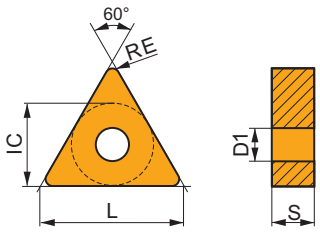
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



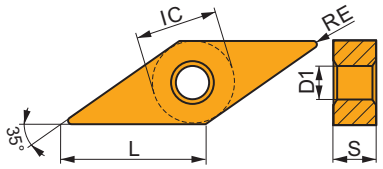
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



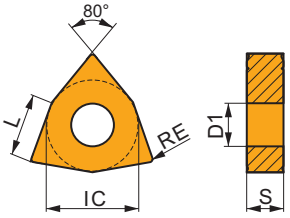
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

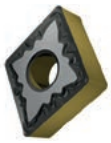
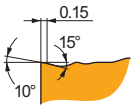


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
06T3	9.525	3.81	6.50	3.97
0804	12.700	5.16	8.70	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/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)
 																				
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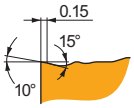
CNMG 090304E-FM:T8430	●	0.4	■	195	0.20	1.4	◪	105	0.18	1.4	◪	160	0.20	1.4	–	–	–	◪	40	0.14	1.1	–	–	–
CNMG 090304E-FM:T9325	●	0.4	■	240	0.20	1.4	◪	140	0.18	1.4	◪	225	0.20	1.4	–	–	–	◪	50	0.16	1.1	–	–	–
CNMG 090304E-FM:T9415	●	0.4	■	305	0.20	1.4		–	–	–	◪	285	0.20	1.4	–	–	–		–	–	–	–	–	–
CNMG 090308E-FM:T8430	⬌	0.8	■	235	0.20	1.4	◪	125	0.18	1.4	◪	190	0.20	1.4	–	–	–	◪	50	0.14	1.1	–	–	–
CNMG 090308E-FM:T9325	●	0.8	■	285	0.20	1.4	◪	170	0.18	1.4	◪	270	0.20	1.4	–	–	–	◪	60	0.16	1.1	–	–	–
CNMG 090308E-FM:T9415	●	0.8	■	365	0.20	1.4		–	–	–	◪	345	0.20	1.4	–	–	–		–	–	–	–	–	–
CNMG 120404E-FM:T7325	●	0.4	◪	185	0.20	2.1	◪	140	0.18	2.1		–	–	–	–	–	–	◪	60	0.16	1.7	–	–	–
CNMG 120404E-FM:T7335	●	0.4	◪	180	0.20	2.1	◪	140	0.18	2.1		–	–	–	–	–	–	◪	55	0.16	1.7	–	–	–
CNMG 120404E-FM:T8315	●	0.4	◪	175	0.20	2.1	◪	105	0.18	2.1	■	165	0.20	2.1	–	–	–	◪	40	0.14	1.7	–	–	–
CNMG 120404E-FM:T8415	●	0.4	■	215	0.20	2.1	◪	110	0.18	2.1	■	195	0.20	2.1	–	–	–	◪	45	0.14	1.7	–	–	–
CNMG 120404E-FM:T8430	●	0.4	■	190	0.20	2.1	◪	105	0.18	2.1	◪	155	0.20	2.1	–	–	–	◪	40	0.14	1.7	–	–	–
CNMG 120404E-FM:T9325	●	0.4	■	230	0.20	2.1	◪	135	0.18	2.1	◪	215	0.20	2.1	–	–	–	◪	50	0.16	1.7	–	–	–
CNMG 120404E-FM:T9415	●	0.4	■	290	0.20	2.1		–	–	–	◪	275	0.20	2.1	–	–	–		–	–	–	–	–	–
CNMG 120404E-FM:TT310	●	0.4	■	260	0.20	2.1	◪	155	0.18	2.1		–	–	–	–	–	–		–	–	–	–	–	–
CNMG 120408E-FM:T7325	⬌	0.8	◪	220	0.20	2.1	◪	170	0.18	2.1		–	–	–	–	–	–	◪	70	0.16	1.7	–	–	–
CNMG 120408E-FM:T7335	⬌	0.8	◪	215	0.20	2.1	◪	165	0.18	2.1		–	–	–	–	–	–	◪	65	0.16	1.7	–	–	–
CNMG 120408E-FM:T8315	⬌	0.8	◪	205	0.20	2.1	◪	120	0.18	2.1	■	190	0.20	2.1	–	–	–	◪	50	0.16	1.7	–	–	–
CNMG 120408E-FM:T8415	⬌	0.8	■	250	0.20	2.1	◪	130	0.18	2.1	■	225	0.20	2.1	–	–	–	◪	55	0.16	1.7	–	–	–
CNMG 120408E-FM:T8430	⬌	0.8	■	225	0.20	2.1	◪	120	0.18	2.1	◪	185	0.20	2.1	–	–	–	◪	45	0.16	1.7	–	–	–
CNMG 120408E-FM:T9310	●	0.8	■	335	0.20	2.1		–	–	–	◪	315	0.20	2.1	–	–	–		–	–	–	–	–	–
CNMG 120408E-FM:T9315	●	0.8	■	305	0.20	2.1		–	–	–	◪	285	0.20	2.1	–	–	–		–	–	–	–	–	–
CNMG 120408E-FM:T9325	●	0.8	■	275	0.20	2.1	◪	165	0.18	2.1	◪	260	0.20	2.1	–	–	–	◪	60	0.16	1.7	–	–	–
CNMG 120408E-FM:T9415	●	0.8	■	350	0.20	2.1		–	–	–	◪	330	0.20	2.1	–	–	–		–	–	–	–	–	–
CNMG 120408E-FM:TT310	●	0.8	■	310	0.20	2.1	◪	185	0.18	2.1		–	–	–	–	–	–		–	–	–	–	–	–
CNMG 120412E-FM:T7325	⬌	1.2	◪	210	0.27	2.1	◪	160	0.24	2.1		–	–	–	–	–	–	◪	65	0.19	1.7	–	–	–
CNMG 120412E-FM:T9325	⬌	1.2	■	255	0.27	2.1	◪	150	0.24	2.1	◪	240	0.27	2.1	–	–	–	◪	55	0.19	1.7	–	–	–
CNMG 120412E-FM:T9415	⬌	1.2	■	330	0.27	2.1		–	–	–	◪	310	0.27	2.1	–	–	–		–	–	–	–	–	–
																				
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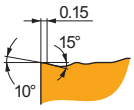
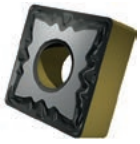
DNMG 110404E-FM:T8315	●	0.4	◪	150	0.20	0.8	◪	90	0.18	0.8	■	140	0.20	0.8	–	–	–	◪	35	0.14	0.6	–	–	–
DNMG 110404E-FM:T8415	●	0.4	■	185	0.20	0.8	◪	95	0.18	0.8	■	165	0.20	0.8	–	–	–	◪	40	0.14	0.6	–	–	–
DNMG 110404E-FM:T8430	●	0.4	■	165	0.20	0.8	◪	90	0.18	0.8	◪	135	0.20	0.8	–	–	–	◪	35	0.14	0.6	–	–	–
DNMG 110404E-FM:T9325	●	0.4	■	200	0.20	0.8	◪	120	0.18	0.8	◪	190	0.20	0.8	–	–	–	◪	45	0.20	0.6	–	–	–
DNMG 110404E-FM:T9415	●	0.4	■	260	0.20	0.8		–	–	–	◪	245	0.20	0.8	–	–	–		–	–	–	–	–	–
DNMG 110408E-FM:T7325	●	0.8	◪	200	0.20	0.8	◪	155	0.18	0.8		–	–	–	–	–	–	◪	65	0.16	0.6	–	–	–
DNMG 110408E-FM:T8315	●	0.8	◪	180	0.20	0.8	◪	105	0.18	0.8	■	170	0.20	0.8	–	–	–	◪	45	0.14	0.6	–	–	–
DNMG 110408E-FM:T8415	●	0.8	■	220	0.20	0.8	◪	115	0.18	0.8	■	200	0.20	0.8	–	–	–	◪	50	0.14	0.6	–	–	–
DNMG 110408E-FM:T8430	●	0.8	■	195	0.20	0.8	◪	105	0.18	0.8	◪	160	0.20	0.8	–	–	–	◪	40	0.14	0.6	–	–	–
DNMG 110408E-FM:T9310	●	0.8	■	295	0.20	0.8		–	–	–	◪	280	0.20	0.8	–	–	–		–	–	–	–	–	–
DNMG 110408E-FM:T9325	●	0.8	■	240	0.20	0.8	◪	140	0.18	0.8	◪	225	0.20	0.8	–	–	–	◪	50	0.16	0.6	–	–	–
DNMG 110408E-FM:T9415	●	0.8	■	305	0.20	0.8		–	–	–	◪	285	0.20	0.8	–	–	–		–	–	–	–	–	–
DNMG 150404E-FM:T7325	●	0.4	◪	150	0.20	1.7	◪	115	0.18	1.7		–	–	–	–	–	–	◪	45	0.20	1.4	–	–	–
DNMG 150404E-FM:T8430	●	0.4	■	150	0.20	1.7	◪	80	0.18	1.7	◪	125	0.20	1.7	–	–	–	◪	30	0.14	1.4	–	–	–
DNMG 150404E-FM:T9325	●	0.4	■	190	0.20	1.7	◪	110	0.18	1.7	◪	180	0.20	1.7	–	–	–	◪	40	0.20	1.4	–	–	–
DNMG 150404E-FM:T9415	●	0.4	■	235	0.20	1.7		–	–	–	◪	220	0.20	1.7	–	–	–		–	–	–	–	–	–
DNMG 150408E-FM:T7325	●	0.8	◪	180	0.20	1.7	◪	140	0.18	1.7		–	–	–	–	–	–	◪	55	0.16	1.4	–	–	–
DNMG 150408E-FM:T8430	●	0.8	■	185	0.20	1.7	◪	100	0.18	1.7	◪	150	0.20	1.7	–	–	–	◪	40	0.16	1.4	–	–	–
DNMG 150408E-FM:T9325	●	0.8	■	225	0.20	1.7	◪	135	0.18	1.7	◪	210	0.20	1.7	–	–	–	◪	50	0.16	1.4	–	–	–
DNMG 150408E-FM:T9415	●	0.8	■	280	0.20	1.7		–	–	–	◪	265	0.20	1.7	–	–	–		–	–	–	–	–	–

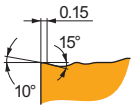
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。



FM 断屑槽用途广泛，是钢和铸铁精加工的首选。它的特点是小正前角和窄的T-型倒棱。也有条件地适用于不锈钢和耐热合金。

Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
DNMG 150604E-FM:T7325	●	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.20	1.4	–	–	–
DNMG 150604E-FM:T7335	●	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.20	1.4	–	–	–
DNMG 150604E-FM:T8315	●	0.4	140	0.20	1.7	80	0.18	1.7	130	0.20	1.7	–	–	–	35	0.14	1.4	–	–	–
DNMG 150604E-FM:T8415	●	0.4	170	0.20	1.7	90	0.18	1.7	155	0.20	1.7	–	–	–	35	0.14	1.4	–	–	–
DNMG 150604E-FM:T8430	●	0.4	150	0.20	1.7	80	0.18	1.7	125	0.20	1.7	–	–	–	30	0.14	1.4	–	–	–
DNMG 150604E-FM:T9310	●	0.4	230	0.20	1.7	–	–	–	215	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150604E-FM:T9315	●	0.4	210	0.20	1.7	–	–	–	195	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150604E-FM:T9325	●	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.20	1.4	–	–	–
DNMG 150604E-FM:T9415	●	0.4	235	0.20	1.7	–	–	–	220	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150608E-FM:T7325	●	0.8	180	0.20	1.7	140	0.18	1.7	–	–	–	–	–	–	55	0.16	1.4	–	–	–
DNMG 150608E-FM:T7335	●	0.8	175	0.20	1.7	135	0.18	1.7	–	–	–	–	–	–	55	0.16	1.4	–	–	–
DNMG 150608E-FM:T8315	●	0.8	170	0.20	1.7	100	0.18	1.7	160	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
DNMG 150608E-FM:T8415	●	0.8	210	0.20	1.7	110	0.18	1.7	190	0.20	1.7	–	–	–	45	0.16	1.4	–	–	–
DNMG 150608E-FM:T8430	●	0.8	185	0.20	1.7	100	0.18	1.7	150	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
DNMG 150608E-FM:T9310	●	0.8	275	0.20	1.7	–	–	–	260	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150608E-FM:T9315	●	0.8	250	0.20	1.7	–	–	–	235	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150608E-FM:T9325	●	0.8	225	0.20	1.7	135	0.18	1.7	210	0.20	1.7	–	–	–	50	0.16	1.4	–	–	–
DNMG 150608E-FM:T9415	●	0.8	280	0.20	1.7	–	–	–	265	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150612E-FM:T7325	●	1.2	180	0.25	1.7	140	0.23	1.7	–	–	–	–	–	–	55	0.18	1.4	–	–	–
DNMG 150612E-FM:T8430	⬌	1.2	175	0.25	1.7	95	0.23	1.7	140	0.25	1.7	–	–	–	35	0.18	1.4	–	–	–
DNMG 150612E-FM:T9315	●	1.2	240	0.25	1.7	–	–	–	225	0.25	1.7	–	–	–	–	–	–	–	–	–
DNMG 150612E-FM:T9325	●	1.2	215	0.25	1.7	125	0.23	1.7	200	0.25	1.7	–	–	–	45	0.18	1.4	–	–	–
DNMG 150612E-FM:T9415	●	1.2	275	0.25	1.7	–	–	–	260	0.25	1.7	–	–	–	–	–	–	–	–	–
DNMG 150616E-FM:T9315	●	1.6	235	0.30	1.7	–	–	–	220	0.30	1.7	–	–	–	–	–	–	–	–	–
DNMG 150616E-FM:T9325	●	1.6	210	0.30	1.7	125	0.27	1.7	195	0.30	1.7	–	–	–	45	0.21	1.4	–	–	–
DNMG 150616E-FM:T9415	●	1.6	270	0.30	1.7	–	–	–	255	0.30	1.7	–	–	–	–	–	–	–	–	–





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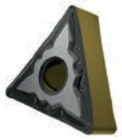
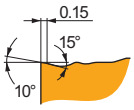
SNMG 120404E-FM:T6310	●	0.4	175	0.20	2.1	125	0.18	2.1	140	0.20	2.1	–	–	–	50	0.14	1.7	–	–	–
SNMG 120404E-FM:T7325	●	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
SNMG 120404E-FM:T8315	●	0.4	180	0.20	2.1	105	0.18	2.1	170	0.20	2.1	–	–	–	45	0.14	1.7	–	–	–
SNMG 120404E-FM:T8415	●	0.4	220	0.20	2.1	115	0.18	2.1	200	0.20	2.1	–	–	–	50	0.14	1.7	–	–	–
SNMG 120404E-FM:T8430	●	0.4	195	0.20	2.1	105	0.18	2.1	160	0.20	2.1	–	–	–	40	0.14	1.7	–	–	–
SNMG 120404E-FM:T9325	●	0.4	240	0.20	2.1	140	0.18	2.1	225	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
SNMG 120404E-FM:T9415	●	0.4	305	0.20	2.1	–	–	–	285	0.20	2.1	–	–	–	–	–	–	–	–	–
SNMG 120408E-FM:T7325	⬌	0.8	235	0.20	2.1	180	0.18	2.1	–	–	–	–	–	–	75	0.16	1.7	–	–	–
SNMG 120408E-FM:T8315	⬌	0.8	215	0.20	2.1	125	0.18	2.1	200	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
SNMG 120408E-FM:T8415	⬌	0.8	260	0.20	2.1	135	0.18	2.1	240	0.20	2.1	–	–	–	60	0.16	1.7	–	–	–
SNMG 120408E-FM:T8430	⬌	0.8	235	0.20	2.1	125	0.18	2.1	190	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
SNMG 120408E-FM:T9325	⬌	0.8	290	0.20	2.1	170	0.18	2.1	275	0.20	2.1	–	–	–	65	0.16	1.7	–	–	–
SNMG 120408E-FM:T9415	●	0.8	365	0.20	2.1	–	–	–	345	0.20	2.1	–	–	–	–	–	–	–	–	–
SNMG 120412E-FM:T8430	⬌	1.2	220	0.27	2.1	120	0.24	2.1	180	0.27	2.1	–	–	–	45	0.19	1.7	–	–	–
SNMG 120412E-FM:T9325	⬌	1.2	270	0.27	2.1	160	0.24	2.1	255	0.27	2.1	–	–	–	60	0.19	1.7	–	–	–
SNMG 120412E-FM:T9415	⬌	1.2	345	0.27	2.1	–	–	–	325	0.27	2.1	–	–	–	–	–	–	–	–	–
SNMG 120416E-FM:T8430	⬌	1.6	220	0.32	2.1	120	0.29	2.1	180	0.32	2.1	–	–	–	45	0.22	1.7	–	–	–

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/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)
 																				
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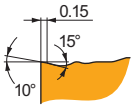
TNMG 160404E-FM:T7325	●	0.4	◪	160	0.20	1.7	◪	120	0.18	1.7		–	–	–		–	–	–	◪	50	0.20	1.4		–	–	–
TNMG 160404E-FM:T7335	●	0.4	◪	160	0.20	1.7	◪	120	0.18	1.7		–	–	–		–	–	–	◪	50	0.20	1.4		–	–	–
TNMG 160404E-FM:T8315	●	0.4	◪	150	0.20	1.7	◪	90	0.18	1.7	■	140	0.20	1.7		–	–	–	◪	35	0.14	1.4		–	–	–
TNMG 160404E-FM:T8415	●	0.4	■	185	0.20	1.7	◪	95	0.18	1.7	■	165	0.20	1.7		–	–	–	◪	40	0.14	1.4		–	–	–
TNMG 160404E-FM:T8430	●	0.4	■	165	0.20	1.7	◪	90	0.18	1.7	◪	135	0.20	1.7		–	–	–	◪	35	0.14	1.4		–	–	–
TNMG 160404E-FM:T9325	●	0.4	■	200	0.20	1.7	◪	120	0.18	1.7	◪	190	0.20	1.7		–	–	–	◪	45	0.20	1.4		–	–	–
TNMG 160404E-FM:T9415	●	0.4	■	250	0.20	1.7		–	–	–	◪	235	0.20	1.7		–	–	–		–	–	–		–	–	–
TNMG 160404E-FM:TT310	●	0.4	■	225	0.20	1.7	◪	135	0.18	1.7		–	–	–		–	–	–		–	–	–		–	–	–
TNMG 160408E-FM:T7325	●	0.8	◪	195	0.20	1.7	◪	150	0.18	1.7		–	–	–		–	–	–	◪	60	0.16	1.4		–	–	–
TNMG 160408E-FM:T7335	●	0.8	◪	190	0.20	1.7	◪	145	0.18	1.7		–	–	–		–	–	–	◪	60	0.16	1.4		–	–	–
TNMG 160408E-FM:T8315	●	0.8	◪	180	0.20	1.7	◪	105	0.18	1.7	■	170	0.20	1.7		–	–	–	◪	45	0.16	1.4		–	–	–
TNMG 160408E-FM:T8415	●	0.8	■	220	0.20	1.7	◪	115	0.18	1.7	■	200	0.20	1.7		–	–	–	◪	50	0.16	1.4		–	–	–
TNMG 160408E-FM:T8430	●	0.8	■	195	0.20	1.7	◪	105	0.18	1.7	◪	160	0.20	1.7		–	–	–	◪	40	0.16	1.4		–	–	–
TNMG 160408E-FM:T9310	●	0.8	■	290	0.20	1.7		–	–	–	◪	275	0.20	1.7		–	–	–		–	–	–		–	–	–
TNMG 160408E-FM:T9325	●	0.8	■	235	0.20	1.7	◪	140	0.18	1.7	◪	220	0.20	1.7		–	–	–	◪	50	0.16	1.4		–	–	–
TNMG 160408E-FM:T9415	●	0.8	■	300	0.20	1.7		–	–	–	◪	285	0.20	1.7		–	–	–		–	–	–		–	–	–
TNMG 160408E-FM:TT310	●	0.8	■	270	0.20	1.7	◪	160	0.18	1.7		–	–	–		–	–	–		–	–	–		–	–	–
TNMG 160412E-FM:T8430	⬌	1.2	■	185	0.25	1.7	◪	100	0.23	1.7	◪	150	0.25	1.7		–	–	–	◪	40	0.18	1.4		–	–	–
TNMG 160412E-FM:T9325	●	1.2	■	225	0.25	1.7	◪	135	0.23	1.7	◪	210	0.25	1.7		–	–	–	◪	50	0.18	1.4		–	–	–
TNMG 160412E-FM:T9415	●	1.2	■	290	0.25	1.7		–	–	–	◪	275	0.25	1.7		–	–	–		–	–	–		–	–	–
TNMG 220404E-FM:T8430	●	0.4	■	165	0.20	1.7	◪	90	0.18	1.7	◪	135	0.20	1.7		–	–	–	◪	35	0.18	1.4		–	–	–
TNMG 220404E-FM:T9325	●	0.4	■	200	0.20	1.7	◪	120	0.18	1.7	◪	190	0.20	1.7		–	–	–	◪	45	0.18	1.4		–	–	–
TNMG 220404E-FM:T9415	●	0.4	■	250	0.20	1.7		–	–	–	◪	235	0.20	1.7		–	–	–		–	–	–		–	–	–
TNMG 220408E-FM:T8430	●	0.8	■	195	0.20	1.7	◪	105	0.18	1.7	◪	160	0.20	1.7		–	–	–	◪	40	0.16	1.4		–	–	–
TNMG 220408E-FM:T9325	●	0.8	■	235	0.20	1.7	◪	140	0.18	1.7	◪	220	0.20	1.7		–	–	–	◪	50	0.16	1.4		–	–	–
TNMG 220408E-FM:T9415	●	0.8	■	300	0.20	1.7		–	–	–	◪	285	0.20	1.7		–	–	–		–	–	–		–	–	–
																				
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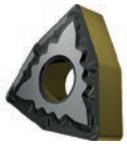
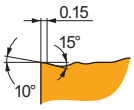
VNMG 160404E-FM:T7325	●	0.4	◪	140	0.20	1.2	◪	105	0.18	1.2		–	–	–		–	–	–	◪	45	0.20	1.0		–	–	–
VNMG 160404E-FM:T8430	●	0.4	■	135	0.20	1.2	◪	75	0.18	1.2	◪	110	0.20	1.2		–	–	–	◪	25	0.14	1.0		–	–	–
VNMG 160404E-FM:T9315	●	0.4	■	190	0.20	1.2		–	–	–	◪	180	0.20	1.2		–	–	–		–	–	–		–	–	–
VNMG 160404E-FM:T9325	●	0.4	■	170	0.20	1.2	◪	100	0.18	1.2	◪	160	0.20	1.2		–	–	–	◪	35	0.20	1.0		–	–	–
VNMG 160404E-FM:T9415	●	0.4	■	215	0.20	1.2		–	–	–	◪	200	0.20	1.2		–	–	–		–	–	–		–	–	–
VNMG 160408E-FM:T7325	●	0.8	◪	160	0.20	1.4	◪	120	0.18	1.4		–	–	–		–	–	–	◪	50	0.16	1.1		–	–	–
VNMG 160408E-FM:T8430	●	0.8	■	165	0.20	1.4	◪	90	0.18	1.4	◪	135	0.20	1.4		–	–	–	◪	35	0.16	1.1		–	–	–
VNMG 160408E-FM:T9315	●	0.8	■	220	0.20	1.4		–	–	–	◪	205	0.20	1.4		–	–	–		–	–	–		–	–	–
VNMG 160408E-FM:T9325	●	0.8	■	200	0.20	1.4	◪	120	0.18	1.4	◪	190	0.20	1.4		–	–	–	◪	45	0.16	1.1		–	–	–
VNMG 160408E-FM:T9415	●	0.8	■	255	0.20	1.4		–	–	–	◪	240	0.20	1.4		–	–	–		–	–	–		–	–	–
VNMG 160412E-FM:T8430	●	1.2	■	165	0.22	1.4	◪	90	0.20	1.4	◪	135	0.22	1.4		–	–	–	◪	35	0.18	1.1		–	–	–
VNMG 160412E-FM:T9315	●	1.2	■	225	0.22	1.4		–	–	–	◪	210	0.22	1.4		–	–	–		–	–	–		–	–	–
VNMG 160412E-FM:T9325	●	1.2	■	200	0.22	1.4	◪	120	0.20	1.4	◪	190	0.22	1.4		–	–	–	◪	45	0.18	1.1		–	–	–
VNMG 160412E-FM:T9415	●	1.2	■	255	0.22	1.4		–	–	–	◪	240	0.22	1.4		–	–	–		–	–	–		–	–	–

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。

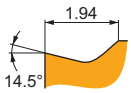




FM 断屑槽用途广泛，是钢和铸铁精加工的首选。它的特点是小正前角和窄的T-型倒棱。也有条件地适用于不锈钢和耐热合金。

Product		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)
WNMG 060404E-FM:T7325	●	0.4	195	0.20	1.4	150	0.18	1.4	–	–	–	–	–	–	60	0.16	1.1	–	–	–
WNMG 060404E-FM:T8315	●	0.4	180	0.20	1.4	105	0.18	1.4	170	0.20	1.4	–	–	–	45	0.14	1.1	–	–	–
WNMG 060404E-FM:T8415	●	0.4	220	0.20	1.4	115	0.18	1.4	200	0.20	1.4	–	–	–	50	0.14	1.1	–	–	–
WNMG 060404E-FM:T8430	●	0.4	195	0.20	1.4	105	0.18	1.4	160	0.20	1.4	–	–	–	40	0.14	1.1	–	–	–
WNMG 060404E-FM:T9325	●	0.4	240	0.20	1.4	140	0.18	1.4	225	0.20	1.4	–	–	–	50	0.16	1.1	–	–	–
WNMG 060404E-FM:T9415	●	0.4	305	0.20	1.4	–	–	–	285	0.20	1.4	–	–	–	–	–	–	–	–	–
WNMG 060404E-FM:TT310	●	0.4	275	0.20	1.4	165	0.18	1.4	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 060408E-FM:T7325	⊜	0.8	235	0.20	1.4	180	0.18	1.4	–	–	–	–	–	–	75	0.16	1.1	–	–	–
WNMG 060408E-FM:T8430	⊜	0.8	235	0.20	1.4	125	0.18	1.4	190	0.20	1.4	–	–	–	50	0.14	1.1	–	–	–
WNMG 060408E-FM:T9315	●	0.8	315	0.20	1.4	–	–	–	295	0.20	1.4	–	–	–	–	–	–	–	–	–
WNMG 060408E-FM:T9325	●	0.8	285	0.20	1.4	170	0.18	1.4	270	0.20	1.4	–	–	–	60	0.16	1.1	–	–	–
WNMG 060408E-FM:T9415	●	0.8	365	0.20	1.4	–	–	–	345	0.20	1.4	–	–	–	–	–	–	–	–	–
WNMG 060412E-FM:T9415	⊜	1.2	350	0.27	1.2	–	–	–	330	0.27	1.2	–	–	–	–	–	–	–	–	–
WNMG 06T304E-FM:T8430	●	0.4	195	0.20	1.4	105	0.18	1.4	160	0.20	1.4	–	–	–	40	0.14	1.1	–	–	–
WNMG 06T304E-FM:T9325	●	0.4	240	0.20	1.4	140	0.18	1.4	225	0.20	1.4	–	–	–	50	0.16	1.1	–	–	–
WNMG 06T308E-FM:T8430	⊜	0.8	235	0.20	1.4	125	0.18	1.4	190	0.20	1.4	–	–	–	50	0.14	1.1	–	–	–
WNMG 06T308E-FM:T9325	●	0.8	285	0.20	1.4	170	0.18	1.4	270	0.20	1.4	–	–	–	60	0.16	1.1	–	–	–
WNMG 080404E-FM:T7325	●	0.4	190	0.20	1.9	145	0.18	1.9	–	–	–	–	–	–	60	0.16	1.5	–	–	–
WNMG 080404E-FM:T7335	●	0.4	180	0.20	1.9	140	0.18	1.9	–	–	–	–	–	–	55	0.16	1.5	–	–	–
WNMG 080404E-FM:T8315	●	0.4	180	0.20	1.9	105	0.18	1.9	170	0.20	1.9	–	–	–	45	0.14	1.5	–	–	–
WNMG 080404E-FM:T8415	●	0.4	215	0.20	1.9	110	0.18	1.9	195	0.20	1.9	–	–	–	45	0.14	1.5	–	–	–
WNMG 080404E-FM:T8430	●	0.4	190	0.20	1.9	105	0.18	1.9	155	0.20	1.9	–	–	–	40	0.14	1.5	–	–	–
WNMG 080404E-FM:T9325	●	0.4	245	0.20	1.2	145	0.18	1.2	230	0.20	1.2	–	–	–	55	0.16	1.0	–	–	–
WNMG 080404E-FM:T9415	●	0.4	310	0.20	1.2	–	–	–	290	0.20	1.2	–	–	–	–	–	–	–	–	–
WNMG 080408E-FM:T7325	⊜	0.8	225	0.20	1.9	175	0.18	1.9	–	–	–	–	–	–	70	0.16	1.5	–	–	–
WNMG 080408E-FM:T7335	⊜	0.8	215	0.20	1.9	165	0.18	1.9	–	–	–	–	–	–	65	0.16	1.5	–	–	–
WNMG 080408E-FM:T8315	⊜	0.8	210	0.20	1.9	125	0.18	1.9	195	0.20	1.9	–	–	–	50	0.16	1.5	–	–	–
WNMG 080408E-FM:T8415	⊜	0.8	250	0.20	1.9	130	0.18	1.9	225	0.20	1.9	–	–	–	55	0.16	1.5	–	–	–
WNMG 080408E-FM:T8430	⊜	0.8	225	0.20	1.9	120	0.18	1.9	185	0.20	1.9	–	–	–	45	0.16	1.5	–	–	–
WNMG 080408E-FM:T9325	●	0.8	280	0.20	1.9	165	0.18	1.9	265	0.20	1.9	–	–	–	60	0.16	1.5	–	–	–
WNMG 080408E-FM:T9415	●	0.8	350	0.20	1.9	–	–	–	330	0.20	1.9	–	–	–	–	–	–	–	–	–
WNMG 080412E-FM:T7325	⊜	1.2	220	0.27	1.9	170	0.24	1.9	–	–	–	–	–	–	70	0.19	1.5	–	–	–
WNMG 080412E-FM:T7335	⊜	1.2	205	0.27	1.9	155	0.24	1.9	–	–	–	–	–	–	65	0.19	1.5	–	–	–
WNMG 080412E-FM:T8430	⊜	1.2	210	0.27	1.9	115	0.24	1.9	175	0.27	1.9	–	–	–	45	0.19	1.5	–	–	–
WNMG 080412E-FM:T9310	⊜	1.2	310	0.27	1.9	–	–	–	290	0.27	1.9	–	–	–	–	–	–	–	–	–
WNMG 080412E-FM:T9325	⊜	1.2	255	0.27	1.9	150	0.24	1.9	240	0.27	1.9	–	–	–	55	0.19	1.5	–	–	–
WNMG 080412E-FM:T9415	⊜	1.2	335	0.27	1.9	–	–	–	315	0.27	1.9	–	–	–	–	–	–	–	–	–

SF

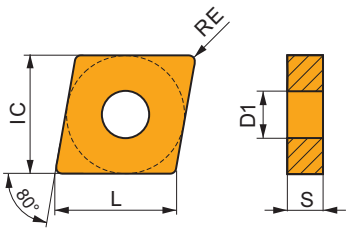


SF 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。特点是小正前角，无T-型倒棱。还适用于钢、铸铁和硬质材料，有条件时也适用于有色金属合金。

PRAMET

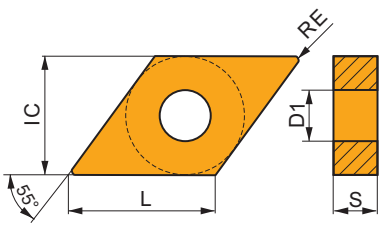
CNGG / CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



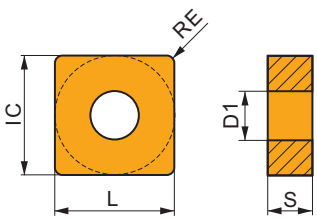
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



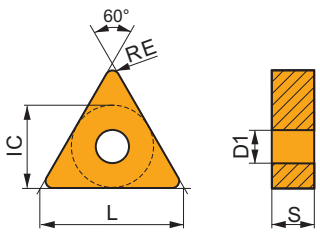
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



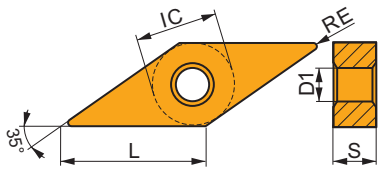
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



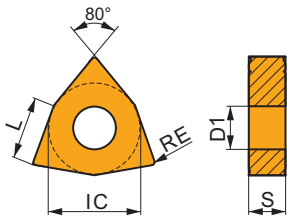
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

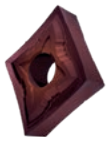
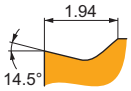
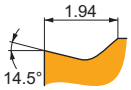
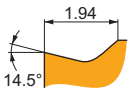


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76

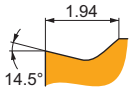


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	RE (mm)	P vc (m/min)	P f (mm/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)
 																				
SF 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。特点是小正前角，无T-型倒棱。还适用于钢、铸铁和硬质材料，有条件时也适用于有色金属合金。																				
CNGG 120402E-SF:H07	●	0.2		–	–	–	◪	105	0.09	1.0	■	165	0.10	1.0	◪	525	0.12	1.0	■	50	0.08	0.8		–	–	–
CNGG 120402E-SF:T6310	●	0.2	■	195	0.10	1.0	■	140	0.09	1.0	■	155	0.10	1.0	◪	585	0.12	1.0	■	55	0.08	0.8	■	35	0.10	0.2
CNGG 120402E-SF:T8315	●	0.2	◪	205	0.10	1.0	■	120	0.09	1.0	■	190	0.10	1.0	◪	615	0.12	1.0	◪	50	0.08	0.8	■	40	0.10	0.2
CNGG 120402E-SF:T8415	●	0.2	■	250	0.10	1.0	■	130	0.09	1.0	■	225	0.10	1.0	◪	630	0.12	1.0	■	55	0.08	0.8	■	40	0.10	0.2
CNGG 120402E-SF:T8430	●	0.2	■	240	0.10	1.0	■	130	0.09	1.0	◪	195	0.10	1.0	◪	660	0.12	1.0	◪	50	0.08	0.8	◪	40	0.10	0.2
																				
SF 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。特点是小正前角，无T-型倒棱。还适用于钢、铸铁和硬质材料，有条件时也适用于有色金属合金。																				
CNMG 120404E-SF:H07	●	0.4		–	–	–	◪	90	0.14	1.0	■	145	0.15	1.0	◪	470	0.18	1.0	■	45	0.12	0.8		–	–	–
CNMG 120404E-SF:T6310	●	0.4	■	180	0.15	1.0	■	125	0.14	1.0	■	145	0.15	1.0	◪	540	0.18	1.0	■	50	0.12	0.8	■	35	0.11	0.3
CNMG 120404E-SF:T7325	●	0.4	◪	205	0.17	1.0	■	155	0.15	1.0		–	–	–		–	–	–	■	65	0.15	0.8		–	–	–
CNMG 120404E-SF:T8315	●	0.4	◪	195	0.15	1.0	■	115	0.14	1.0	■	185	0.15	1.0	◪	585	0.18	1.0	◪	45	0.12	0.8	■	35	0.11	0.3
CNMG 120404E-SF:T8415	●	0.4	■	240	0.15	1.0	■	125	0.14	1.0	■	215	0.15	1.0	◪	600	0.18	1.0	■	55	0.12	0.8	■	40	0.10	0.3
CNMG 120404E-SF:T8430	●	0.4	■	220	0.15	1.0	■	120	0.14	1.0	◪	180	0.15	1.0	◪	600	0.18	1.0	◪	45	0.12	0.8	◪	35	0.11	0.3
CNMG 120404E-SF:T9325	●	0.4	■	255	0.17	1.0	■	150	0.15	1.0	◪	240	0.17	1.0		–	–	–	◪	55	0.15	0.8		–	–	–
CNMG 120404E-SF:T9415	●	0.4	■	315	0.17	1.0		–	–	–	◪	295	0.17	1.0		–	–	–		–	–	–	◪	60	0.13	0.3
CNMG 120408E-SF:H07	⬌	0.8		–	–	–	◪	95	0.18	1.0	■	155	0.20	1.0	◪	495	0.24	1.0	■	50	0.15	0.8		–	–	–
CNMG 120408E-SF:T6310	⬌	0.8	■	200	0.20	1.0	■	140	0.18	1.0	■	160	0.20	1.0	◪	600	0.24	1.0	■	60	0.14	0.8	■	40	0.10	0.7
CNMG 120408E-SF:T7325	⬌	0.8	◪	230	0.20	1.0	■	175	0.18	1.0		–	–	–		–	–	–	■	70	0.16	0.8		–	–	–
CNMG 120408E-SF:T7335	⬌	0.8	◪	220	0.20	1.0	■	170	0.18	1.0		–	–	–		–	–	–	■	70	0.16	0.8		–	–	–
CNMG 120408E-SF:T8315	⬌	0.8	◪	210	0.20	1.0	■	125	0.18	1.0	■	195	0.20	1.0	◪	630	0.24	1.0	◪	50	0.14	0.8	■	40	0.10	0.7
CNMG 120408E-SF:T8415	⬌	0.8	■	255	0.20	1.0	■	135	0.18	1.0	■	230	0.20	1.0	◪	645	0.24	1.0	■	55	0.14	0.8	■	45	0.10	0.7
CNMG 120408E-SF:T8430	⬌	0.8	■	230	0.20	1.0	■	125	0.18	1.0	◪	185	0.20	1.0	◪	630	0.24	1.0	◪	45	0.14	0.8	◪	35	0.10	0.7
CNMG 120408E-SF:T9325	⬌	0.8	■	280	0.20	1.0	■	165	0.18	1.0	◪	265	0.20	1.0		–	–	–	◪	60	0.16	0.8		–	–	–
CNMG 120412E-SF:T6310	⬌	1.2	■	190	0.25	1.5	■	135	0.23	1.5	■	150	0.25	1.5	◪	570	0.30	1.5	■	55	0.18	1.2	■	35	0.13	1.0
CNMG 120412E-SF:T8315	⬌	1.2	◪	200	0.25	1.5	■	120	0.23	1.5	■	190	0.25	1.5	◪	600	0.30	1.5	◪	50	0.18	1.2	■	40	0.13	1.0
CNMG 120412E-SF:T8415	⬌	1.2	■	250	0.25	1.5	■	130	0.23	1.5	■	225	0.25	1.5	◪	630	0.30	1.5	■	55	0.17	1.2	■	40	0.13	1.0
CNMG 120412E-SF:T8430	⬌	1.2	■	210	0.25	1.5	■	115	0.23	1.5	◪	175	0.25	1.5	◪	585	0.30	1.5	◪	45	0.18	1.2	◪	35	0.13	1.0
																				
SF 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。特点是小正前角，无T-型倒棱。还适用于钢、铸铁和硬质材料，有条件时也适用于有色金属合金。																				
DNMG 110404E-SF:T6310	●	0.4	■	150	0.15	0.8	■	105	0.14	0.8	■	120	0.15	0.8	◪	450	0.18	0.8	■	45	0.12	0.6	■	30	0.11	0.3
DNMG 110404E-SF:T8315	●	0.4	◪	160	0.15	0.8	■	95	0.14	0.8	■	150	0.15	0.8	◪	480	0.18	0.8	◪	40	0.12	0.6	■	30	0.11	0.3
DNMG 110404E-SF:T8415	●	0.4	■	190	0.15	0.8	■	100	0.14	0.8	■	170	0.15	0.8	◪	480	0.18	0.8	■	40	0.12	0.6	■	30	0.10	0.3
DNMG 110404E-SF:T8430	●	0.4	■	180	0.15	0.8	■	95	0.14	0.8	◪	145	0.15	0.8	◪	495	0.18	0.8	◪	35	0.12	0.6	◪	30	0.11	0.3
DNMG 110408E-SF:T6310	●	0.8	■	175	0.17	0.8	■	125	0.15	0.8	■	140	0.17	0.8	◪	525	0.20	0.8	■	50	0.14	0.6	■	35	0.11	0.7
DNMG 110408E-SF:T8415	●	0.8	■	220	0.17	0.8	■	115	0.15	0.8	■	200	0.17	0.8	◪	555	0.20	0.8	■	50	0.14	0.6	■	35	0.11	0.7
DNMG 110408E-SF:T8430	●	0.8	■	200	0.17	0.8	■	110	0.15	0.8	◪	165	0.17	0.8	◪	555	0.20	0.8	◪	40	0.14	0.6	◪	35	0.11	0.7
DNMG 150404E-SF:T6310	●	0.4	■	140	0.15	1.5	■	100	0.14	1.5	■	110	0.15	1.5	◪	420	0.18	1.5	■	40	0.12	1.2	■	25	0.11	0.3
DNMG 150404E-SF:T8315	●	0.4	◪	150	0.15	1.5	■	90	0.14	1.5	■	140	0.15	1.5	◪	450	0.18	1.5	◪	35	0.12	1.2	■	30	0.11	0.3
DNMG 150404E-SF:T8415	●	0.4	■	180	0.15	1.5	■	90	0.14	1.5	■	160	0.15	1.5	◪	450	0.18	1.5	■	40	0.12	1.2	■	30	0.10	0.3
DNMG 150404E-SF:T8430	●	0.4	■	165	0.15	1.5	■	90	0.14	1.5	◪	135	0.15	1.5	◪	450	0.18	1.5	◪	35	0.12	1.2	◪	25	0.11	0.3
DNMG 150408E-SF:T6310	●	0.8	■	160	0.17	1.5	■	115	0.15	1.5	■	125	0.17	1.5	◪	480	0.20	1.5	■	45	0.14	1.2	■	30	0.11	0.7
DNMG 150408E-SF:T8315	●	0.8	◪	170	0.17	1.5	■	100	0.15	1.5	■	160	0.17	1.5	◪	510	0.20	1.5	◪	40	0.14	1.2	■	30	0.11	0.7
DNMG 150408E-SF:T8415	●	0.8	■	210	0.17	1.5	■	110	0.15	1.5	■	190	0.17	1.5	◪	525	0.20	1.5	■	45	0.14	1.2	■	35	0.11	0.7
DNMG 150408E-SF:T8430	●	0.8	■	190	0.17	1.5	■	105	0.15	1.5	◪	155	0.17	1.5	◪	525	0.20	1.5	◪	40	0.14	1.2	◪	30	0.11	0.7
DNMG 150604E-SF:H07	●	0.4		–	–	–	◪	70	0.14	1.5	■	115	0.15	1.5	◪	360	0.18	1.5	■	35	0.12	1.2		–	–	–
DNMG 150604E-SF:T6310	●	0.4	■	140	0.15	1.5	■	100	0.14	1.5	■	110	0.15	1.5	◪	420	0.18	1.5	■	40	0.12	1.2	■	25	0.11	0.3
DNMG 150604E-SF:T7325	●	0.4	◪	155	0.17	1.5	■	120	0.15	1.5		–	–	–		–	–	–	■	50	0.15	1.2		–	–	–
DNMG 150604E-SF:T8315	●	0.4	◪	150	0.15	1.5	■	90	0.14	1.5	■	140	0.15	1.5	◪	450	0.18	1.5	◪	35	0.12	1.2	■	30	0.11	0.3
DNMG 150604E-SF:T8415	●	0.4	■	180	0.15	1.5	■	90	0.14	1.5	■	160	0.15	1.5	◪	450	0.18	1.5	■	40	0.12	1.2	■	30	0.10	0.3
DNMG 150604E-SF:T8430	●	0.4	■	165	0.15	1.5	■	90	0.14	1.5	◪	135	0.15	1.5	◪	450	0.18	1.5	◪	35	0.12	1.2	◪	25	0.11	0.3

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/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)
DNMG 150608E-SF:H07	●	0.8	–	–	–	◪ 80	0.15	1.5	■ 130	0.17	1.5	◪ 415	0.20	1.5	■ 40	0.14	1.2	–	–	–
DNMG 150608E-SF:T6310	●	0.8	■ 160	0.17	1.5	■ 115	0.15	1.5	■ 125	0.17	1.5	◪ 480	0.20	1.5	■ 45	0.14	1.2	■ 30	0.11	0.7
DNMG 150608E-SF:T7325	●	0.8	◪ 185	0.17	1.5	■ 140	0.15	1.5	–	–	–	–	–	–	■ 60	0.15	1.2	–	–	–
DNMG 150608E-SF:T8315	●	0.8	◪ 170	0.17	1.5	■ 100	0.15	1.5	■ 160	0.17	1.5	◪ 510	0.20	1.5	◪ 40	0.14	1.2	■ 30	0.11	0.7
DNMG 150608E-SF:T8415	●	0.8	■ 210	0.17	1.5	■ 110	0.15	1.5	■ 190	0.17	1.5	◪ 525	0.20	1.5	■ 45	0.14	1.2	■ 35	0.11	0.7
DNMG 150608E-SF:T8430	⊛	0.8	■ 190	0.17	1.5	■ 105	0.15	1.5	◪ 155	0.17	1.5	◪ 525	0.20	1.5	◪ 40	0.14	1.2	◪ 30	0.11	0.7
DNMG 150608E-SF:T9325	●	0.8	■ 235	0.17	1.5	■ 140	0.15	1.5	◪ 220	0.17	1.5	–	–	–	◪ 50	0.15	1.2	–	–	–
DNMG 150608E-SF:T9415	●	0.8	■ 290	0.17	1.5	–	–	–	◪ 275	0.17	1.5	–	–	–	–	–	–	◪ 55	0.12	0.7
DNMG 150612E-SF:T6310	⊛	1.2	■ 155	0.25	1.5	■ 110	0.23	1.5	■ 125	0.25	1.5	◪ 465	0.30	1.5	■ 45	0.18	1.2	■ 30	0.13	0.9
DNMG 150612E-SF:T8415	⊛	1.2	■ 195	0.25	1.5	■ 100	0.23	1.5	■ 180	0.25	1.5	◪ 495	0.30	1.5	■ 45	0.17	1.2	■ 30	0.13	0.9



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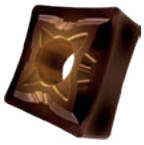
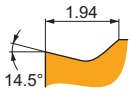
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
SNMG 120408E-SF:H07	⊛	0.8	–	–	–	◪ 105	0.18	1.0	■ 165	0.20	1.0	◪ 525	0.24	1.0	■ 50	0.14	0.8	–	–	–
SNMG 120408E-SF:T6310	⊛	0.8	■ 210	0.20	1.0	■ 150	0.18	1.0	■ 165	0.20	1.0	◪ 630	0.24	1.0	■ 60	0.14	0.8	■ 40	0.10	0.7
SNMG 120408E-SF:T8415	⊛	0.8	■ 275	0.20	1.0	■ 140	0.18	1.0	■ 250	0.20	1.0	◪ 690	0.24	1.0	■ 60	0.14	0.8	■ 45	0.10	0.7
SNMG 120408E-SF:T8430	⊛	0.8	■ 245	0.20	1.0	■ 135	0.18	1.0	◪ 200	0.20	1.0	◪ 675	0.24	1.0	◪ 50	0.14	0.8	◪ 40	0.10	0.7
SNMG 120408E-SF:T9325	⊛	0.8	■ 295	0.20	1.0	■ 175	0.18	1.0	◪ 280	0.20	1.0	–	–	–	◪ 65	0.16	0.8	–	–	–
SNMG 120412E-SF:T6310	⊛	1.2	■ 200	0.25	1.5	■ 140	0.23	1.5	■ 160	0.25	1.5	◪ 600	0.30	1.5	■ 60	0.18	1.2	■ 40	0.13	1.0
SNMG 120412E-SF:T8415	⊛	1.2	■ 260	0.25	1.5	■ 135	0.23	1.5	■ 240	0.25	1.5	◪ 660	0.30	1.5	■ 60	0.17	1.2	■ 45	0.13	1.0
SNMG 120412E-SF:T8430	⊛	1.2	■ 225	0.25	1.5	■ 120	0.23	1.5	◪ 185	0.25	1.5	◪ 615	0.30	1.5	◪ 45	0.18	1.2	◪ 35	0.13	1.0





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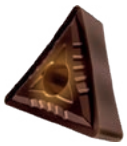
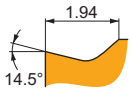
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
TNMG 160404E-SF:T6310	●	0.4	■ 150	0.15	1.3	■ 105	0.14	1.3	■ 120	0.15	1.3	◪ 450	0.18	1.3	■ 45	0.12	1.0	■ 30	0.11	0.3
TNMG 160404E-SF:T7325	●	0.4	◪ 170	0.17	1.3	■ 130	0.15	1.3	–	–	–	–	–	–	■ 55	0.15	1.0	–	–	–
TNMG 160404E-SF:T8315	●	0.4	◪ 160	0.15	1.3	■ 95	0.14	1.3	■ 150	0.15	1.3	◪ 480	0.18	1.3	◪ 40	0.12	1.0	■ 30	0.11	0.3
TNMG 160404E-SF:T8415	●	0.4	■ 195	0.15	1.3	■ 100	0.14	1.3	■ 180	0.15	1.3	◪ 495	0.18	1.3	■ 45	0.12	1.0	■ 30	0.10	0.3
TNMG 160404E-SF:T8430	●	0.4	■ 180	0.15	1.3	■ 95	0.14	1.3	◪ 145	0.15	1.3	◪ 495	0.18	1.3	◪ 35	0.12	1.0	◪ 30	0.11	0.3
TNMG 160408E-SF:T6310	●	0.8	■ 175	0.17	1.3	■ 125	0.15	1.3	■ 140	0.17	1.3	◪ 525	0.20	1.3	■ 50	0.14	1.0	■ 35	0.11	0.7
TNMG 160408E-SF:T8315	●	0.8	◪ 185	0.17	1.3	■ 110	0.15	1.3	■ 175	0.17	1.3	◪ 555	0.20	1.3	◪ 45	0.14	1.0	■ 35	0.11	0.7
TNMG 160408E-SF:T8415	●	0.8	■ 225	0.17	1.3	■ 115	0.15	1.3	■ 205	0.17	1.3	◪ 570	0.20	1.3	■ 50	0.14	1.0	■ 35	0.11	0.7
TNMG 160408E-SF:T8430	⊛	0.8	■ 205	0.17	1.3	■ 110	0.15	1.3	◪ 170	0.17	1.3	◪ 570	0.20	1.3	◪ 45	0.14	1.0	◪ 35	0.11	0.7
TNMG 160412E-SF:T6310	⊛	1.2	■ 165	0.25	1.5	■ 115	0.23	1.5	■ 130	0.25	1.5	◪ 495	0.30	1.5	■ 45	0.18	1.2	■ 30	0.13	0.9
TNMG 160412E-SF:T8415	⊛	1.2	■ 210	0.25	1.5	■ 110	0.23	1.5	■ 190	0.25	1.5	◪ 525	0.30	1.5	■ 45	0.17	1.2	■ 35	0.13	0.9
TNMG 220404E-SF:T6310	●	0.4	■ 145	0.17	1.7	■ 100	0.15	1.7	■ 115	0.17	1.7	◪ 435	0.20	1.7	■ 40	0.15	1.4	■ 25	0.12	0.3
TNMG 220404E-SF:T8415	●	0.4	■ 185	0.17	1.7	■ 95	0.15	1.7	■ 165	0.17	1.7	◪ 465	0.20	1.7	■ 40	0.15	1.4	■ 30	0.12	0.3
TNMG 220408E-SF:T6310	●	0.8	■ 170	0.17	1.7	■ 120	0.15	1.7	■ 135	0.17	1.7	◪ 510	0.20	1.7	■ 50	0.15	1.4	■ 30	0.12	0.7
TNMG 220408E-SF:T8315	●	0.8	◪ 180	0.17	1.7	■ 105	0.15	1.7	■ 170	0.17	1.7	◪ 540	0.20	1.7	◪ 45	0.15	1.4	■ 35	0.12	0.7
TNMG 220408E-SF:T8415	●	0.8	■ 220	0.17	1.7	■ 115	0.15	1.7	■ 200	0.17	1.7	◪ 555	0.20	1.7	■ 50	0.15	1.4	■ 35	0.12	0.7
TNMG 220408E-SF:T8430	⊛	0.8	■ 195	0.17	1.7	■ 105	0.15	1.7	◪ 160	0.17	1.7	◪ 540	0.20	1.7	◪ 40	0.15	1.4	◪ 30	0.12	0.7
TNMG 220412E-SF:T6310	⊛	1.2	■ 155	0.30	1.7	■ 110	0.27	1.7	■ 125	0.30	1.7	◪ 465	0.36	1.7	■ 45	0.21	1.4	■ 30	0.15	0.9
TNMG 220412E-SF:T8415	⊛	1.2	■ 195	0.30	1.7	■ 100	0.27	1.7	■ 180	0.30	1.7	◪ 495	0.36	1.7	■ 45	0.21	1.4	■ 30	0.15	0.9





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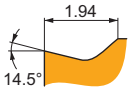
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。



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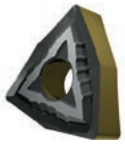
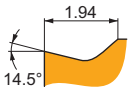
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
VNMG 160404E-SF:T6310	●	0.4	125	0.15	1.2	90	0.14	1.2	100	0.15	1.2	375	0.18	1.2	35	0.14	1.0	25	0.15	0.3
VNMG 160404E-SF:T7325	●	0.4	145	0.15	1.2	110	0.14	1.2	–	–	–	–	–	–	45	0.14	1.0	–	–	–
VNMG 160404E-SF:T8315	●	0.4	135	0.15	1.2	80	0.14	1.2	125	0.15	1.2	405	0.18	1.2	30	0.14	1.0	25	0.15	0.3
VNMG 160404E-SF:T8415	●	0.4	160	0.15	1.2	85	0.14	1.2	145	0.15	1.2	405	0.18	1.2	35	0.14	1.0	25	0.15	0.3
VNMG 160404E-SF:T8430	●	0.4	145	0.15	1.2	80	0.14	1.2	120	0.15	1.2	405	0.18	1.2	30	0.14	1.0	25	0.15	0.3
VNMG 160408E-SF:T6310	●	0.8	140	0.17	1.4	100	0.15	1.4	110	0.17	1.4	420	0.20	1.4	40	0.14	1.1	25	0.11	0.7
VNMG 160408E-SF:T8315	●	0.8	150	0.17	1.4	90	0.15	1.4	140	0.17	1.4	450	0.20	1.4	35	0.14	1.1	30	0.11	0.7
VNMG 160408E-SF:T8415	●	0.8	185	0.17	1.4	95	0.15	1.4	165	0.17	1.4	465	0.20	1.4	40	0.14	1.1	30	0.11	0.7
VNMG 160408E-SF:T8430	●	0.8	165	0.17	1.4	90	0.15	1.4	135	0.17	1.4	450	0.20	1.4	35	0.14	1.1	25	0.11	0.7
VNMG 160408E-SF:T9325	●	0.8	205	0.17	1.4	120	0.15	1.4	190	0.17	1.4	–	–	–	45	0.15	1.1	–	–	–
VNMG 160408E-SF:T9415	●	0.8	255	0.17	1.4	–	–	–	240	0.17	1.4	–	–	–	–	–	–	50	0.12	0.7

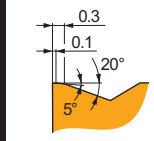




SF 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。特点是小正前角，无T-型倒棱。还适用于钢、铸铁和硬质材料，有条件时也适用于有色金属合金。

Product		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)
WNMG 060404E-SF:T6310	●	0.4	180	0.15	1.0	125	0.14	1.0	145	0.15	1.0	540	0.18	1.0	50	0.12	0.8	35	0.11	0.3
WNMG 060404E-SF:T8315	●	0.4	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	585	0.18	1.0	45	0.12	0.8	35	0.11	0.3
WNMG 060404E-SF:T8415	●	0.4	240	0.15	1.0	125	0.14	1.0	215	0.15	1.0	600	0.18	1.0	55	0.12	0.8	40	0.10	0.3
WNMG 060404E-SF:T8430	●	0.4	220	0.15	1.0	120	0.14	1.0	180	0.15	1.0	600	0.18	1.0	45	0.12	0.8	35	0.11	0.3
WNMG 060408E-SF:T6310	⬌	0.8	200	0.20	1.0	140	0.18	1.0	160	0.20	1.0	600	0.24	1.0	60	0.14	0.8	40	0.10	0.7
WNMG 060408E-SF:T8315	⬌	0.8	210	0.20	1.0	125	0.18	1.0	195	0.20	1.0	630	0.24	1.0	50	0.14	0.8	40	0.10	0.7
WNMG 060408E-SF:T8415	⬌	0.8	255	0.20	1.0	135	0.18	1.0	230	0.20	1.0	645	0.24	1.0	55	0.14	0.8	45	0.10	0.7
WNMG 060408E-SF:T8430	⬌	0.8	230	0.20	1.0	125	0.18	1.0	185	0.20	1.0	630	0.24	1.0	45	0.14	0.8	35	0.10	0.7
WNMG 080404E-SF:H07	●	0.4	–	–	–	90	0.14	1.0	145	0.15	1.0	470	0.18	1.0	45	0.12	0.8	–	–	–
WNMG 080404E-SF:T6310	●	0.4	180	0.15	1.0	125	0.14	1.0	145	0.15	1.0	540	0.18	1.0	50	0.12	0.8	35	0.11	0.3
WNMG 080404E-SF:T7325	●	0.4	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
WNMG 080404E-SF:T8315	●	0.4	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	585	0.18	1.0	45	0.12	0.8	35	0.11	0.3
WNMG 080404E-SF:T8415	●	0.4	240	0.15	1.0	125	0.14	1.0	215	0.15	1.0	600	0.18	1.0	55	0.12	0.8	40	0.10	0.3
WNMG 080404E-SF:T8430	●	0.4	220	0.15	1.0	120	0.14	1.0	180	0.15	1.0	600	0.18	1.0	45	0.12	0.8	35	0.11	0.3
WNMG 080408E-SF:H07	⬌	0.8	–	–	–	95	0.18	1.0	155	0.20	1.0	495	0.24	1.0	50	0.14	0.8	–	–	–
WNMG 080408E-SF:T6310	⬌	0.8	200	0.20	1.0	140	0.18	1.0	160	0.20	1.0	600	0.24	1.0	60	0.14	0.8	40	0.10	0.7
WNMG 080408E-SF:T7325	⬌	0.8	230	0.20	1.0	175	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
WNMG 080408E-SF:T7335	⬌	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
WNMG 080408E-SF:T8315	⬌	0.8	210	0.20	1.0	125	0.18	1.0	195	0.20	1.0	630	0.24	1.0	50	0.14	0.8	40	0.10	0.7
WNMG 080408E-SF:T8415	⬌	0.8	255	0.20	1.0	135	0.18	1.0	230	0.20	1.0	645	0.24	1.0	55	0.14	0.8	45	0.10	0.7
WNMG 080408E-SF:T8430	⬌	0.8	230	0.20	1.0	125	0.18	1.0	185	0.20	1.0	630	0.24	1.0	45	0.14	0.8	35	0.10	0.7
WNMG 080408E-SF:T9325	⬌	0.8	280	0.20	1.0	165	0.18	1.0	265	0.20	1.0	–	–	–	60	0.16	0.8	–	–	–
WNMG 080408E-SF:T9415	●	0.8	355	0.20	1.0	–	–	–	335	0.20	1.0	–	–	–	–	–	–	70	0.13	0.7

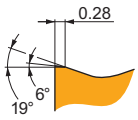
W-M



W-M 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和适中的 T 倒棱。它也有条件地适用于铸铁。

PRAMET

W-MR

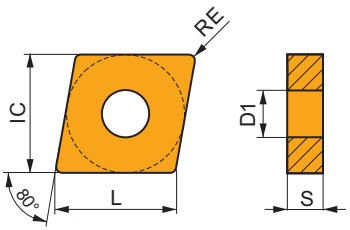


W-MR 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和稳定、宽阔的 T 倒棱。它也有条件地适用于不锈钢和铸钢。

PRAMET

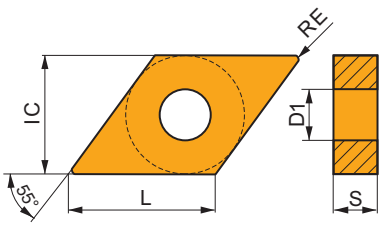
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



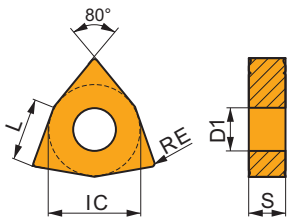
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35

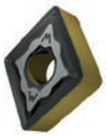
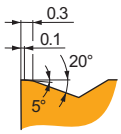
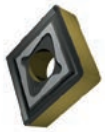
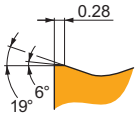
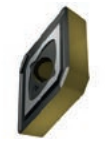
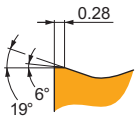
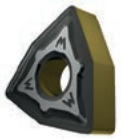
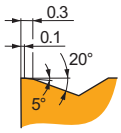
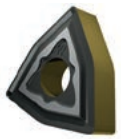
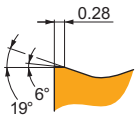


WNMG

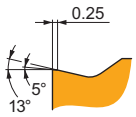
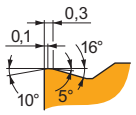
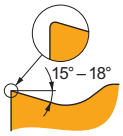
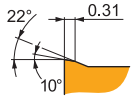
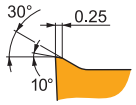
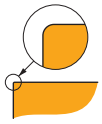
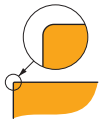
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



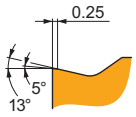
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
 																				
W-M 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和适中的 T 倒棱。它也有条件地适用于铸铁。																				
CNMG 120408W-M:T5315		0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-M:T9315		0.8	200	0.45	1.5	–	–	–	190	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-M:T9325		0.8	185	0.45	1.5	–	–	–	175	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-M:T9415		0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
 																				
W-MR 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和稳定、宽阔的 T 倒棱。它也有条件地适用于不锈钢和铸铁。																				
CNMG 120404W-MR:T9415		0.4	240	0.30	1.5	–	–	–	225	0.30	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR:T5315		0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR:T9325		0.8	185	0.45	1.5	110	0.41	1.5	175	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR:T9415		0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T5315		1.2	230	0.55	1.5	–	–	–	215	0.55	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T9315		1.2	200	0.55	1.5	–	–	–	190	0.55	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T9325		1.2	180	0.55	1.5	105	0.50	1.5	170	0.55	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T9415		1.2	245	0.55	1.5	–	–	–	230	0.55	1.5	–	–	–	–	–	–	–	–	–
 																				
W-MR 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和稳定、宽阔的 T 倒棱。它也有条件地适用于不锈钢和铸铁。																				
DNMG 150608W-MR:T9325		0.8	155	0.40	1.5	90	0.36	1.5	145	0.40	1.5	–	–	–	–	–	–	–	–	–
DNMG 150608W-MR:T9415		0.8	205	0.40	1.5	–	–	–	190	0.40	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR:T9315		1.2	160	0.50	1.5	–	–	–	150	0.50	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR:T9325		1.2	145	0.50	1.5	85	0.45	1.5	135	0.50	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR:T9415		1.2	200	0.50	1.5	–	–	–	190	0.50	1.5	–	–	–	–	–	–	–	–	–
 																				
W-M 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和适中的 T 倒棱。它也有条件地适用于铸铁。																				
WNMG 060408W-M:T9325		0.8	190	0.45	1.2	–	–	–	180	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 060408W-M:T9415		0.8	255	0.45	1.2	–	–	–	240	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 060412W-M:T5315		1.2	235	0.55	1.2	–	–	–	220	0.55	1.2	–	–	–	–	–	–	–	–	–
WNMG 060412W-M:T9415		1.2	250	0.55	1.2	–	–	–	235	0.55	1.2	–	–	–	–	–	–	–	–	–
WNMG 080408W-M:T9325		0.8	185	0.45	1.5	–	–	–	175	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-M:T9415		0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-M:T9325		1.2	180	0.55	1.5	–	–	–	170	0.55	1.5	–	–	–	–	–	–	–	–	–
 																				
W-MR 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和稳定、宽阔的 T 倒棱。它也有条件地适用于不锈钢和铸铁。																				
WNMG 060408W-MR:T9415		0.8	255	0.45	1.2	–	–	–	240	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 080404W-MR:T9415		0.4	240	0.30	1.5	–	–	–	225	0.30	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T5315		0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T9310		0.8	215	0.45	1.5	–	–	–	200	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T9325		0.8	185	0.45	1.5	110	0.41	1.5	175	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T9415		0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-MR:T5315		1.2	230	0.55	1.5	–	–	–	215	0.55	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-MR:T9415		1.2	245	0.55	1.5	–	–	–	230	0.55	1.5	–	–	–	–	–	–	–	–	–

半精加工 – 导航工具

SM			SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。
M			M 型断屑槽用途广泛，是铸铁中型加工的首选。它具有正前角和负/稳定、适中的 T 倒棱。它也适用于钢材和有条件的硬质材料。
SI			SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。
NMR			NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。
NM			NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。
.NMA			.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。
.NMA ..S			.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。

SM

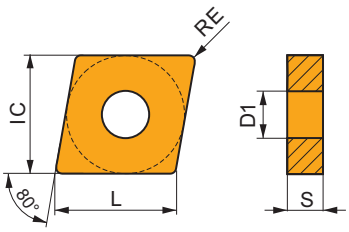


SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。

PRAMET

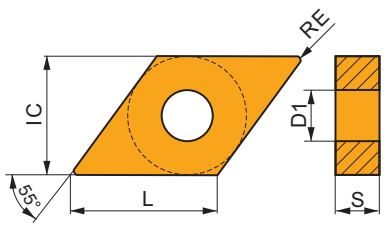
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



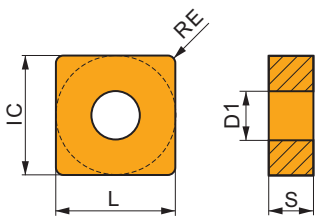
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



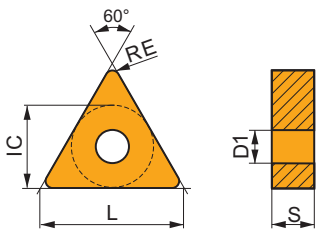
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1906	19.050	7.94	19.05	6.35



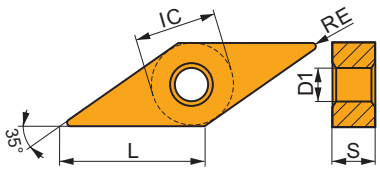
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



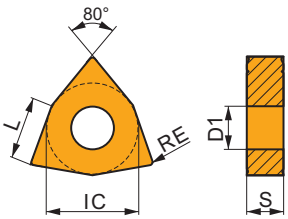
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

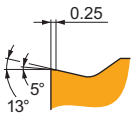


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



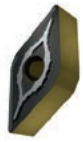
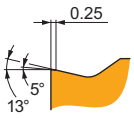
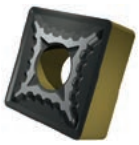
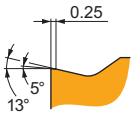
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。



SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。

Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
CNMG 120404E-SM:T6310	●	0.4	155	0.20	2.0	110	0.18	2.0	125	0.20	2.0	465	0.24	2.0	45	0.18	1.6	30	0.13	0.3
CNMG 120404E-SM:T7325	●	0.4	180	0.20	2.0	140	0.18	2.0	–	–	–	–	–	–	55	0.18	1.6	–	–	–
CNMG 120404E-SM:T7335	●	0.4	175	0.20	2.0	135	0.18	2.0	–	–	–	–	–	–	55	0.18	1.6	–	–	–
CNMG 120404E-SM:T8415	●	0.4	200	0.20	2.0	105	0.18	2.0	185	0.20	2.0	510	0.24	2.0	45	0.18	1.6	35	0.13	0.3
CNMG 120404E-SM:T8430	●	0.4	180	0.20	2.0	95	0.18	2.0	145	0.20	2.0	495	0.24	2.0	35	0.18	1.6	30	0.13	0.3
CNMG 120404E-SM:T9325	●	0.4	220	0.20	2.0	130	0.18	2.0	205	0.20	2.0	–	–	–	45	0.18	1.6	–	–	–
CNMG 120404E-SM:T9415	●	0.4	280	0.20	2.0	–	–	–	265	0.20	2.0	–	–	–	–	–	–	55	0.13	0.3
CNMG 120408E-SM:T6310	⬌	0.8	175	0.25	2.0	125	0.23	2.0	140	0.25	2.0	525	0.30	2.0	50	0.20	1.6	35	0.13	0.7
CNMG 120408E-SM:T7325	⬌	0.8	200	0.25	2.0	155	0.23	2.0	–	–	–	–	–	–	65	0.20	1.6	–	–	–
CNMG 120408E-SM:T7335	⬌	0.8	190	0.25	2.0	145	0.23	2.0	–	–	–	–	–	–	60	0.20	1.6	–	–	–
CNMG 120408E-SM:T8415	⬌	0.8	225	0.25	2.0	115	0.23	2.0	205	0.25	2.0	570	0.30	2.0	50	0.20	1.6	35	0.13	0.7
CNMG 120408E-SM:T8430	⬌	0.8	195	0.25	2.0	105	0.23	2.0	160	0.25	2.0	540	0.30	2.0	40	0.20	1.6	30	0.13	0.7
CNMG 120408E-SM:T9325	⬌	0.8	235	0.25	2.0	140	0.23	2.0	220	0.25	2.0	–	–	–	50	0.20	1.6	–	–	–
CNMG 120408E-SM:T9415	⬌	0.8	305	0.25	2.0	–	–	–	285	0.25	2.0	–	–	–	–	–	–	60	0.13	0.7
CNMG 120412E-SM:T6310	⬌	1.2	175	0.30	2.0	125	0.27	2.0	140	0.30	2.0	525	0.36	2.0	50	0.24	1.6	35	0.15	1.0
CNMG 120412E-SM:T7325	⬌	1.2	195	0.30	2.0	150	0.27	2.0	–	–	–	–	–	–	60	0.24	1.6	–	–	–
CNMG 120412E-SM:T7335	⬌	1.2	190	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	60	0.24	1.6	–	–	–
CNMG 120412E-SM:T8415	⬌	1.2	225	0.30	2.0	115	0.27	2.0	205	0.30	2.0	570	0.36	2.0	50	0.24	1.6	35	0.15	1.0
CNMG 120412E-SM:T8430	⬌	1.2	190	0.30	2.0	105	0.27	2.0	155	0.30	2.0	525	0.36	2.0	40	0.24	1.6	30	0.15	1.0
CNMG 120412E-SM:T9325	⬌	1.2	235	0.30	2.0	140	0.27	2.0	220	0.30	2.0	–	–	–	50	0.24	1.6	–	–	–
CNMG 120412E-SM:T9415	⬌	1.2	300	0.30	2.0	–	–	–	285	0.30	2.0	–	–	–	–	–	–	60	0.15	1.0
CNMG 160608E-SM:T7325	⬌	0.8	185	0.26	3.0	140	0.23	3.0	–	–	–	–	–	–	60	0.23	2.4	–	–	–
CNMG 160608E-SM:T8430	⬌	0.8	180	0.26	3.0	95	0.23	3.0	145	0.26	3.0	495	0.31	3.0	35	0.23	2.4	30	0.13	0.7
CNMG 160608E-SM:T9325	⬌	0.8	225	0.26	3.0	135	0.23	3.0	210	0.26	3.0	–	–	–	50	0.23	2.4	–	–	–
CNMG 160612E-SM:T6310	⬌	1.2	170	0.30	3.0	120	0.27	3.0	135	0.30	3.0	510	0.36	3.0	50	0.27	2.4	30	0.15	1.0
CNMG 160612E-SM:T7325	⬌	1.2	190	0.30	3.0	145	0.27	3.0	–	–	–	–	–	–	60	0.27	2.4	–	–	–
CNMG 160612E-SM:T7335	⬌	1.2	180	0.30	3.0	140	0.27	3.0	–	–	–	–	–	–	55	0.27	2.4	–	–	–
CNMG 160612E-SM:T8415	⬌	1.2	215	0.30	3.0	110	0.27	3.0	195	0.30	3.0	540	0.36	3.0	45	0.27	2.4	35	0.15	1.0
CNMG 160612E-SM:T9325	⬌	1.2	225	0.30	3.0	135	0.27	3.0	210	0.30	3.0	–	–	–	50	0.27	2.4	–	–	–
CNMG 160612E-SM:T9415	⬌	1.2	290	0.30	3.0	–	–	–	275	0.30	3.0	–	–	–	–	–	–	55	0.15	1.0
CNMG 190612E-SM:T6310	⬌	1.2	165	0.30	4.0	115	0.27	4.0	130	0.30	4.0	495	0.36	4.0	45	0.27	3.2	30	0.15	1.0
CNMG 190612E-SM:T7325	⬌	1.2	185	0.30	4.0	140	0.27	4.0	–	–	–	–	–	–	60	0.27	3.2	–	–	–
CNMG 190612E-SM:T7335	⬌	1.2	175	0.30	4.0	135	0.27	4.0	–	–	–	–	–	–	55	0.27	3.2	–	–	–
CNMG 190612E-SM:T8415	⬌	1.2	210	0.30	4.0	110	0.27	4.0	190	0.30	4.0	525	0.36	4.0	45	0.27	3.2	35	0.15	1.0
CNMG 190612E-SM:T9415	⬌	1.2	280	0.30	4.0	–	–	–	265	0.30	4.0	–	–	–	–	–	–	55	0.15	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/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)
 																				
DNMG 110404E-SM:T6310	●	0.4	140	0.20	0.8	100	0.18	0.8	110	0.20	0.8	420	0.24	0.8	40	0.18	0.6	25	0.14	0.3
DNMG 110404E-SM:T7325	●	0.4	160	0.20	0.8	120	0.18	0.8	–	–	–	–	–	–	50	0.18	0.6	–	–	–
DNMG 110404E-SM:T8415	●	0.4	180	0.20	0.8	90	0.18	0.8	160	0.20	0.8	450	0.24	0.8	40	0.18	0.6	30	0.14	0.3
DNMG 110404E-SM:T8430	●	0.4	155	0.20	0.8	85	0.18	0.8	130	0.20	0.8	435	0.24	0.8	30	0.18	0.6	25	0.14	0.3
DNMG 110404E-SM:T9325	●	0.4	190	0.20	0.8	110	0.18	0.8	180	0.20	0.8	–	–	–	40	0.18	0.6	–	–	–
DNMG 110408E-SM:T6310	●	0.8	150	0.25	1.2	105	0.23	1.2	120	0.25	1.2	450	0.30	1.2	45	0.20	1.0	30	0.13	0.7
DNMG 110408E-SM:T7325	●	0.8	170	0.25	1.2	130	0.23	1.2	–	–	–	–	–	–	55	0.20	1.0	–	–	–
DNMG 110408E-SM:T7335	●	0.8	160	0.25	1.2	120	0.23	1.2	–	–	–	–	–	–	50	0.20	1.0	–	–	–
DNMG 110408E-SM:T8415	●	0.8	190	0.25	1.2	100	0.23	1.2	170	0.25	1.2	480	0.30	1.2	40	0.20	1.0	30	0.13	0.7
DNMG 110408E-SM:T8430	⬌	0.8	170	0.25	1.2	90	0.23	1.2	135	0.25	1.2	465	0.30	1.2	35	0.20	1.0	25	0.13	0.7
DNMG 110408E-SM:T9325	●	0.8	200	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	45	0.20	1.0	–	–	–
DNMG 150404E-SM:T6310	●	0.4	130	0.20	1.7	90	0.18	1.7	100	0.20	1.7	390	0.24	1.7	35	0.18	1.4	25	0.14	0.3
DNMG 150404E-SM:T8415	●	0.4	165	0.20	1.7	85	0.18	1.7	150	0.20	1.7	420	0.24	1.7	35	0.18	1.4	25	0.14	0.3
DNMG 150408E-SM:T6310	●	0.8	140	0.25	1.7	100	0.23	1.7	110	0.25	1.7	420	0.30	1.7	40	0.20	1.4	25	0.13	0.7
DNMG 150408E-SM:T8415	●	0.8	185	0.25	1.7	95	0.23	1.7	165	0.25	1.7	465	0.30	1.7	40	0.20	1.4	30	0.13	0.7
DNMG 150604E-SM:T6310	●	0.4	130	0.20	1.7	90	0.18	1.7	100	0.20	1.7	390	0.24	1.7	35	0.18	1.4	25	0.14	0.3
DNMG 150604E-SM:T7325	●	0.4	145	0.20	1.7	110	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
DNMG 150604E-SM:T7335	●	0.4	140	0.20	1.7	105	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
DNMG 150604E-SM:T8415	●	0.4	165	0.20	1.7	85	0.18	1.7	150	0.20	1.7	420	0.24	1.7	35	0.18	1.4	25	0.14	0.3
DNMG 150604E-SM:T8430	●	0.4	145	0.20	1.7	80	0.18	1.7	120	0.20	1.7	405	0.24	1.7	30	0.18	1.4	25	0.14	0.3
DNMG 150604E-SM:T9325	●	0.4	180	0.20	1.7	105	0.18	1.7	170	0.20	1.7	–	–	–	40	0.18	1.4	–	–	–
DNMG 150604E-SM:T9415	●	0.4	225	0.20	1.7	–	–	–	210	0.20	1.7	–	–	–	–	–	–	45	0.14	0.3
DNMG 150608E-SM:T6310	●	0.8	140	0.25	1.7	100	0.23	1.7	110	0.25	1.7	420	0.30	1.7	40	0.20	1.4	25	0.13	0.7
DNMG 150608E-SM:T7325	●	0.8	160	0.25	1.7	120	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
DNMG 150608E-SM:T7335	●	0.8	155	0.25	1.7	120	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
DNMG 150608E-SM:T8415	●	0.8	185	0.25	1.7	95	0.23	1.7	165	0.25	1.7	465	0.30	1.7	40	0.20	1.4	30	0.13	0.7
DNMG 150608E-SM:T8430	⬌	0.8	155	0.25	1.7	85	0.23	1.7	130	0.25	1.7	435	0.30	1.7	30	0.20	1.4	25	0.13	0.7
DNMG 150608E-SM:T9325	●	0.8	195	0.25	1.7	115	0.23	1.7	185	0.25	1.7	–	–	–	40	0.20	1.4	–	–	–
DNMG 150608E-SM:T9415	●	0.8	250	0.25	1.7	–	–	–	235	0.25	1.7	–	–	–	–	–	–	50	0.13	0.7
DNMG 150612E-SM:T6310	⬌	1.2	145	0.30	1.7	100	0.27	1.7	115	0.30	1.7	435	0.36	1.7	40	0.24	1.4	25	0.15	0.9
DNMG 150612E-SM:T7325	⬌	1.2	160	0.30	1.7	120	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
DNMG 150612E-SM:T8415	⬌	1.2	185	0.30	1.7	95	0.27	1.7	165	0.30	1.7	465	0.36	1.7	40	0.24	1.4	30	0.15	0.9
DNMG 150612E-SM:T8430	⬌	1.2	155	0.30	1.7	85	0.27	1.7	130	0.30	1.7	435	0.36	1.7	30	0.24	1.4	25	0.15	0.9
DNMG 150612E-SM:T9415	●	1.2	245	0.30	1.7	–	–	–	230	0.30	1.7	–	–	–	–	–	–	45	0.15	0.9
 																				
SNMG 120408E-SM:T6310	⬌	0.8	185	0.25	1.8	130	0.23	1.8	145	0.25	1.8	555	0.30	1.8	55	0.20	1.4	35	0.13	0.7
SNMG 120408E-SM:T7325	⬌	0.8	210	0.25	1.8	160	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
SNMG 120408E-SM:T7335	⬌	0.8	205	0.25	1.8	155	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
SNMG 120408E-SM:T8415	⬌	0.8	240	0.25	1.8	125	0.23	1.8	215	0.25	1.8	600	0.30	1.8	55	0.20	1.4	40	0.13	0.7
SNMG 120408E-SM:T8430	⬌	0.8	205	0.25	1.8	110	0.23	1.8	170	0.25	1.8	570	0.30	1.8	45	0.20	1.4	35	0.13	0.7
SNMG 120408E-SM:T9325	⬌	0.8	255	0.25	1.8	150	0.23	1.8	240	0.25	1.8	–	–	–	55	0.20	1.4	–	–	–
SNMG 120408E-SM:T9415	⬌	0.8	325	0.25	1.8	–	–	–	305	0.25	1.8	–	–	–	–	–	–	65	0.13	0.7
SNMG 120412E-SM:T7325	⬌	1.2	210	0.30	1.8	160	0.27	1.8	–	–	–	–	–	–	65	0.24	1.4	–	–	–
SNMG 120412E-SM:T9415	⬌	1.2	325	0.30	1.8	–	–	–	305	0.30	1.8	–	–	–	–	–	–	65	0.15	1.0
SNMG 190612E-SM:T6310	⬌	1.2	175	0.30	4.0	125	0.27	4.0	140	0.30	4.0	525	0.36	4.0	50	0.27	3.2	35	0.15	1.0
SNMG 190612E-SM:T7325	⬌	1.2	195	0.30	4.0	150	0.27	4.0	–	–	–	–	–	–	60	0.27	3.2	–	–	–
SNMG 190612E-SM:T7335	⬌	1.2	185	0.30	4.0	140	0.27	4.0	–	–	–	–	–	–	60	0.27	3.2	–	–	–
SNMG 190612E-SM:T8415	⬌	1.2	220	0.30	4.0	115	0.27	4.0	200	0.30	4.0	555	0.36	4.0	50	0.27	3.2	35	0.15	1.0
SNMG 190612E-SM:T9325	⬌	1.2	230	0.30	4.0	135	0.27	4.0	215	0.30	4.0	–	–	–	50	0.27	3.2	–	–	–
SNMG 190616E-SM:T7335	⬌	1.6	175	0.40	4.0	135	0.36	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
SNMG 190616E-SM:T9325	⬌	1.6	210	0.40	4.0	125	0.36	4.0	195	0.40	4.0	–	–	–	45	0.32	3.2	–	–	–

SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。

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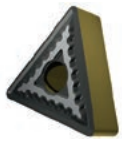
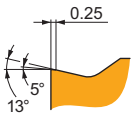
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
 																				
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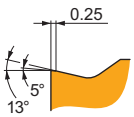
TNMG 160404E-SM:T6310	●	0.4	135	0.20	1.7	95	0.18	1.7	105	0.20	1.7	405	0.24	1.7	40	0.18	1.4	25	0.14	0.3
TNMG 160404E-SM:T7325	●	0.4	155	0.20	1.7	120	0.18	1.7	–	–	–	–	–	–	50	0.18	1.4	–	–	–
TNMG 160404E-SM:T7335	●	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
TNMG 160404E-SM:T8415	●	0.4	170	0.20	1.7	90	0.18	1.7	155	0.20	1.7	435	0.24	1.7	35	0.18	1.4	30	0.14	0.3
TNMG 160404E-SM:T8430	●	0.4	155	0.20	1.7	85	0.18	1.7	130	0.20	1.7	435	0.24	1.7	30	0.18	1.4	25	0.14	0.3
TNMG 160404E-SM:T9325	●	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.18	1.4	–	–	–
TNMG 160404E-SM:T9415	●	0.4	240	0.20	1.7	–	–	–	225	0.20	1.7	–	–	–	–	–	–	45	0.14	0.3
TNMG 160408E-SM:T6310	●	0.8	150	0.25	1.7	105	0.23	1.7	120	0.25	1.7	450	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 160408E-SM:T7325	●	0.8	170	0.25	1.7	130	0.23	1.7	–	–	–	–	–	–	55	0.20	1.4	–	–	–
TNMG 160408E-SM:T7335	●	0.8	165	0.25	1.7	125	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
TNMG 160408E-SM:T8415	●	0.8	195	0.25	1.7	100	0.23	1.7	180	0.25	1.7	495	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 160408E-SM:T8430	⬌	0.8	170	0.25	1.7	90	0.23	1.7	135	0.25	1.7	465	0.30	1.7	35	0.20	1.4	25	0.13	0.7
TNMG 160408E-SM:T9325	●	0.8	205	0.25	1.7	120	0.23	1.7	190	0.25	1.7	–	–	–	45	0.20	1.4	–	–	–
TNMG 160408E-SM:T9415	●	0.8	265	0.25	1.7	–	–	–	250	0.25	1.7	–	–	–	–	–	–	50	0.13	0.7
TNMG 160412E-SM:T6310	⬌	1.2	155	0.30	1.7	110	0.27	1.7	125	0.30	1.7	465	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 160412E-SM:T7325	⬌	1.2	170	0.30	1.7	130	0.27	1.7	–	–	–	–	–	–	55	0.24	1.4	–	–	–
TNMG 160412E-SM:T7335	⬌	1.2	165	0.30	1.7	125	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 160412E-SM:T8415	⬌	1.2	195	0.30	1.7	100	0.27	1.7	180	0.30	1.7	495	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 160412E-SM:T9325	⬌	1.2	205	0.30	1.7	120	0.27	1.7	190	0.30	1.7	–	–	–	45	0.24	1.4	–	–	–
TNMG 220404E-SM:T6310	●	0.4	135	0.20	1.7	95	0.18	1.7	105	0.20	1.7	405	0.24	1.7	40	0.18	1.4	25	0.14	0.3
TNMG 220404E-SM:T7325	●	0.4	155	0.20	1.7	120	0.18	1.7	–	–	–	–	–	–	50	0.18	1.4	–	–	–
TNMG 220404E-SM:T8415	●	0.4	170	0.20	1.7	90	0.18	1.7	155	0.20	1.7	435	0.24	1.7	35	0.18	1.4	30	0.14	0.3
TNMG 220404E-SM:T8430	●	0.4	155	0.20	1.7	85	0.18	1.7	130	0.20	1.7	435	0.24	1.7	30	0.18	1.4	25	0.14	0.3
TNMG 220404E-SM:T9325	●	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.18	1.4	–	–	–
TNMG 220408E-SM:T6310	●	0.8	150	0.25	1.7	105	0.23	1.7	120	0.25	1.7	450	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 220408E-SM:T7325	●	0.8	170	0.25	1.7	130	0.23	1.7	–	–	–	–	–	–	55	0.20	1.4	–	–	–
TNMG 220408E-SM:T7335	●	0.8	165	0.25	1.7	125	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
TNMG 220408E-SM:T8415	●	0.8	195	0.25	1.7	100	0.23	1.7	180	0.25	1.7	495	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 220408E-SM:T8430	⬌	0.8	170	0.25	1.7	90	0.23	1.7	135	0.25	1.7	465	0.30	1.7	35	0.20	1.4	25	0.13	0.7
TNMG 220408E-SM:T9325	●	0.8	205	0.25	1.7	120	0.23	1.7	190	0.25	1.7	–	–	–	45	0.20	1.4	–	–	–
TNMG 220408E-SM:T9415	●	0.8	265	0.25	1.7	–	–	–	250	0.25	1.7	–	–	–	–	–	–	50	0.13	0.7
TNMG 220412E-SM:T6310	⬌	1.2	155	0.30	1.7	110	0.27	1.7	125	0.30	1.7	465	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 220412E-SM:T7325	⬌	1.2	170	0.30	1.7	130	0.27	1.7	–	–	–	–	–	–	55	0.24	1.4	–	–	–
TNMG 220412E-SM:T7335	⬌	1.2	165	0.30	1.7	125	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 220412E-SM:T8415	⬌	1.2	195	0.30	1.7	100	0.27	1.7	180	0.30	1.7	495	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 220412E-SM:T9325	⬌	1.2	205	0.30	1.7	120	0.27	1.7	190	0.30	1.7	–	–	–	45	0.24	1.4	–	–	–
TNMG 220412E-SM:T9415	●	1.2	260	0.30	1.7	–	–	–	245	0.30	1.7	–	–	–	–	–	–	50	0.15	0.9
																				
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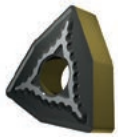
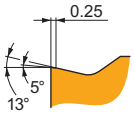
VNMG 160404E-SM:T6310	●	0.4	120	0.18	1.2	85	0.16	1.2	95	0.18	1.2	360	0.22	1.2	35	0.16	1.0	20	0.13	0.3
VNMG 160404E-SM:T7325	●	0.4	135	0.18	1.2	105	0.16	1.2	–	–	–	–	–	–	40	0.16	1.0	–	–	–
VNMG 160404E-SM:T8415	●	0.4	155	0.18	1.2	80	0.16	1.2	140	0.18	1.2	390	0.22	1.2	35	0.16	1.0	25	0.13	0.3
VNMG 160404E-SM:T8430	●	0.4	135	0.18	1.2	75	0.16	1.2	110	0.18	1.2	375	0.22	1.2	25	0.16	1.0	20	0.13	0.3
VNMG 160404E-SM:T9325	●	0.4	170	0.18	1.2	100	0.16	1.2	160	0.18	1.2	–	–	–	35	0.16	1.0	–	–	–
VNMG 160404E-SM:T9415	●	0.4	210	0.18	1.2	–	–	–	195	0.18	1.2	–	–	–	–	–	–	40	0.13	0.3
VNMG 160408E-SM:T6310	●	0.8	125	0.25	1.4	90	0.23	1.4	100	0.25	1.4	375	0.30	1.4	35	0.20	1.1	25	0.13	0.7
VNMG 160408E-SM:T7325	●	0.8	145	0.25	1.4	110	0.23	1.4	–	–	–	–	–	–	45	0.20	1.1	–	–	–
VNMG 160408E-SM:T8415	●	0.8	160	0.25	1.4	85	0.23	1.4	145	0.25	1.4	405	0.30	1.4	35	0.20	1.1	25	0.13	0.7
VNMG 160408E-SM:T8430	●	0.8	140	0.25	1.4	75	0.23	1.4	115	0.25	1.4	390	0.30	1.4	30	0.20	1.1	20	0.13	0.7
VNMG 160408E-SM:T9325	●	0.8	170	0.25	1.4	100	0.23	1.4	160	0.25	1.4	–	–	–	35	0.20	1.1	–	–	–

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。





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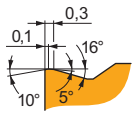
Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
WNMG 060404E-SM:T7335	●	0.4	◪ 180	0.20	1.7	■ 140	0.18	1.7	–	–	–	–	–	–	■ 55	0.18	1.4	–	–	–
WNMG 060404E-SM:T8430	●	0.4	■ 185	0.20	1.7	■ 100	0.18	1.7	◪ 150	0.20	1.7	◪ 510	0.24	1.7	◪ 40	0.18	1.4	◪ 30	0.13	0.3
WNMG 060404E-SM:T9325	●	0.4	■ 225	0.20	1.7	■ 135	0.18	1.7	◪ 210	0.20	1.7	–	–	–	◪ 50	0.18	1.4	–	–	–
WNMG 060408E-SM:T6310	⊜	0.8	■ 175	0.25	1.7	■ 125	0.23	1.7	■ 140	0.25	1.7	◪ 525	0.30	1.7	■ 50	0.20	1.4	◪ 35	0.13	0.7
WNMG 060408E-SM:T7325	⊜	0.8	◪ 200	0.25	1.7	■ 155	0.23	1.7	–	–	–	–	–	–	■ 65	0.20	1.4	–	–	–
WNMG 060408E-SM:T7335	⊜	0.8	◪ 195	0.25	1.7	■ 150	0.23	1.7	–	–	–	–	–	–	■ 60	0.20	1.4	–	–	–
WNMG 060408E-SM:T8415	⊜	0.8	■ 225	0.25	1.7	■ 115	0.23	1.7	■ 205	0.25	1.7	◪ 570	0.30	1.7	■ 50	0.20	1.4	◪ 35	0.13	0.7
WNMG 060408E-SM:T8430	⊜	0.8	■ 195	0.25	1.7	■ 105	0.23	1.7	◪ 160	0.25	1.7	◪ 540	0.30	1.7	◪ 40	0.20	1.4	◪ 30	0.13	0.7
WNMG 060408E-SM:T9325	⊜	0.8	■ 240	0.25	1.7	■ 140	0.23	1.7	◪ 225	0.25	1.7	–	–	–	◪ 50	0.20	1.4	–	–	–
WNMG 060412E-SM:T7325	⊜	1.2	◪ 200	0.30	1.7	■ 155	0.27	1.7	–	–	–	–	–	–	■ 65	0.24	1.4	–	–	–
WNMG 060412E-SM:T8430	⊜	1.2	■ 195	0.30	1.7	■ 105	0.27	1.7	◪ 160	0.30	1.7	◪ 540	0.36	1.7	◪ 40	0.24	1.4	◪ 30	0.15	1.0
WNMG 060412E-SM:T9325	⊜	1.2	■ 240	0.30	1.7	■ 140	0.27	1.7	◪ 225	0.30	1.7	–	–	–	◪ 50	0.24	1.4	–	–	–
WNMG 080404E-SM:T6310	●	0.4	■ 155	0.20	2.0	■ 110	0.18	2.0	■ 125	0.20	2.0	◪ 465	0.24	2.0	■ 45	0.18	1.6	◪ 30	0.13	0.3
WNMG 080404E-SM:T7325	●	0.4	◪ 180	0.20	2.0	■ 140	0.18	2.0	–	–	–	–	–	–	■ 55	0.18	1.6	–	–	–
WNMG 080404E-SM:T7335	●	0.4	◪ 175	0.20	2.0	■ 135	0.18	2.0	–	–	–	–	–	–	■ 55	0.18	1.6	–	–	–
WNMG 080404E-SM:T8415	●	0.4	■ 200	0.20	2.0	■ 105	0.18	2.0	■ 185	0.20	2.0	◪ 510	0.24	2.0	■ 45	0.18	1.6	◪ 35	0.13	0.3
WNMG 080404E-SM:T8430	●	0.4	■ 180	0.20	2.0	■ 95	0.18	2.0	◪ 145	0.20	2.0	◪ 495	0.24	2.0	◪ 35	0.18	1.6	◪ 30	0.13	0.3
WNMG 080404E-SM:T9325	●	0.4	■ 220	0.20	2.0	■ 130	0.18	2.0	◪ 205	0.20	2.0	–	–	–	◪ 45	0.18	1.6	–	–	–
WNMG 080404E-SM:T9415	●	0.4	■ 280	0.20	2.0	–	–	–	◪ 265	0.20	2.0	–	–	–	–	–	–	◪ 55	0.13	0.3
WNMG 080408E-SM:T6310	⊜	0.8	■ 175	0.25	2.0	■ 125	0.23	2.0	■ 140	0.25	2.0	◪ 525	0.30	2.0	■ 50	0.20	1.6	◪ 35	0.13	0.7
WNMG 080408E-SM:T7325	⊜	0.8	◪ 200	0.25	2.0	■ 155	0.23	2.0	–	–	–	–	–	–	■ 65	0.20	1.6	–	–	–
WNMG 080408E-SM:T7335	⊜	0.8	◪ 190	0.25	2.0	■ 145	0.23	2.0	–	–	–	–	–	–	■ 60	0.20	1.6	–	–	–
WNMG 080408E-SM:T8415	⊜	0.8	■ 225	0.25	2.0	■ 115	0.23	2.0	■ 205	0.25	2.0	◪ 570	0.30	2.0	■ 50	0.20	1.6	◪ 35	0.13	0.7
WNMG 080408E-SM:T8430	⊜	0.8	■ 195	0.25	2.0	■ 105	0.23	2.0	◪ 160	0.25	2.0	◪ 540	0.30	2.0	◪ 40	0.20	1.6	◪ 30	0.13	0.7
WNMG 080408E-SM:T9325	⊜	0.8	■ 235	0.25	2.0	■ 140	0.23	2.0	◪ 220	0.25	2.0	–	–	–	◪ 50	0.20	1.6	–	–	–
WNMG 080408E-SM:T9415	⊜	0.8	■ 305	0.25	2.0	–	–	–	◪ 285	0.25	2.0	–	–	–	–	–	–	◪ 60	0.13	0.7
WNMG 080412E-SM:T6310	⊜	1.2	■ 175	0.30	2.0	■ 125	0.27	2.0	■ 140	0.30	2.0	◪ 525	0.36	2.0	■ 50	0.24	1.6	◪ 35	0.15	1.0
WNMG 080412E-SM:T7325	⊜	1.2	◪ 195	0.30	2.0	■ 150	0.27	2.0	–	–	–	–	–	–	■ 60	0.24	1.6	–	–	–
WNMG 080412E-SM:T7335	⊜	1.2	◪ 190	0.30	2.0	■ 145	0.27	2.0	–	–	–	–	–	–	■ 60	0.24	1.6	–	–	–
WNMG 080412E-SM:T8415	⊜	1.2	■ 225	0.30	2.0	■ 115	0.27	2.0	■ 205	0.30	2.0	◪ 570	0.36	2.0	■ 50	0.24	1.6	◪ 35	0.15	1.0
WNMG 080412E-SM:T8430	⊜	1.2	■ 190	0.30	2.0	■ 105	0.27	2.0	◪ 155	0.30	2.0	◪ 525	0.36	2.0	◪ 40	0.24	1.6	◪ 30	0.15	1.0
WNMG 080412E-SM:T9325	⊜	1.2	■ 235	0.30	2.0	■ 140	0.27	2.0	◪ 220	0.30	2.0	–	–	–	◪ 50	0.24	1.6	–	–	–
WNMG 080412E-SM:T9415	⊜	1.2	■ 300	0.30	2.0	–	–	–	◪ 285	0.30	2.0	–	–	–	–	–	–	◪ 60	0.15	1.0

M

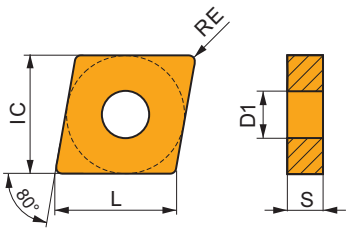


M 型断屑槽用途广泛，是铸铁中型加工的首选。它具有正前角和负/稳定、适中的 T 倒棱。它也适用于钢材和有条件的硬质材料。

PRAMET

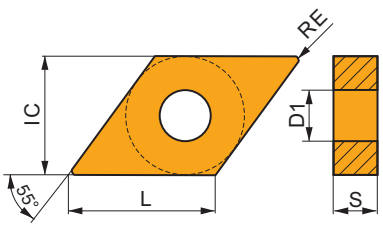
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



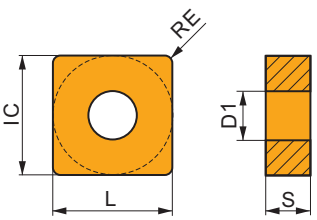
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



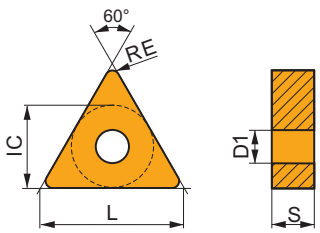
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35



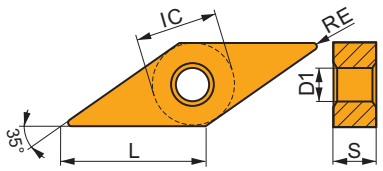
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



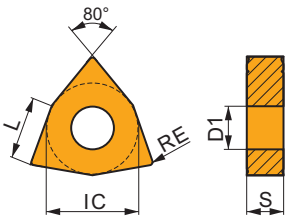
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

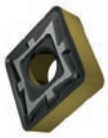


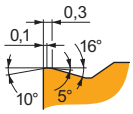
WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	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。





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Product		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)
CNMG 090308E-M:T9325	⁂	0.8	205	0.32	1.8	–	–	–	190	0.32	1.8	–	–	–	–	–	–	–	–	–
CNMG 090308E-M:T9335	⁂	0.8	180	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 090308E-M:T9415	●	0.8	275	0.32	1.8	–	–	–	260	0.32	1.8	–	–	–	–	–	–	55	0.16	0.5
CNMG 120404E-M:T5315	●	0.4	245	0.20	2.1	–	–	–	230	0.20	2.1	–	–	–	–	–	–	45	0.13	0.3
CNMG 120404E-M:T9325	●	0.4	210	0.20	2.1	–	–	–	195	0.20	2.1	–	–	–	–	–	–	–	–	–
CNMG 120404E-M:T9335	⁂	0.4	180	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120404E-M:T9415	⁂	0.4	265	0.20	2.1	–	–	–	250	0.20	2.1	–	–	–	–	–	–	50	0.13	0.3
CNMG 120408E-M:6640	⁂	0.8	165	0.32	2.1	–	–	–	155	0.32	2.1	–	–	–	–	–	–	–	–	–
CNMG 120408E-M:T5305	⁂	0.8	280	0.32	2.1	–	–	–	265	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
CNMG 120408E-M:T5315	⁂	0.8	250	0.32	2.1	–	–	–	235	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
CNMG 120408E-M:T8430	⁂	0.8	170	0.32	2.1	–	–	–	135	0.32	2.1	–	–	–	–	–	–	25	0.16	0.7
CNMG 120408E-M:T9310	⁂	0.8	245	0.32	2.1	–	–	–	230	0.32	2.1	–	–	–	–	–	–	45	0.16	0.7
CNMG 120408E-M:T9315	⁂	0.8	225	0.32	2.1	–	–	–	210	0.32	2.1	–	–	–	–	–	–	45	0.16	0.7
CNMG 120408E-M:T9325	⁂	0.8	200	0.32	2.1	–	–	–	190	0.32	2.1	–	–	–	–	–	–	–	–	–
CNMG 120408E-M:T9335	⁂	0.8	180	0.32	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-M:T9415	⁂	0.8	270	0.32	2.1	–	–	–	255	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
CNMG 120412E-M:T5305	⁂	1.2	275	0.40	2.1	–	–	–	260	0.40	2.1	–	–	–	–	–	–	55	0.20	1.0
CNMG 120412E-M:T5315	⁂	1.2	245	0.40	2.1	–	–	–	230	0.40	2.1	–	–	–	–	–	–	45	0.20	1.0
CNMG 120412E-M:T9315	⁂	1.2	220	0.40	2.1	–	–	–	205	0.40	2.1	–	–	–	–	–	–	40	0.20	1.0
CNMG 120412E-M:T9325	⁂	1.2	195	0.40	2.1	–	–	–	185	0.40	2.1	–	–	–	–	–	–	–	–	–
CNMG 120412E-M:T9335	⁂	1.2	170	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-M:T9415	⁂	1.2	265	0.40	2.1	–	–	–	250	0.40	2.1	–	–	–	–	–	–	50	0.20	1.0
CNMG 120416E-M:T9325	⁂	1.6	200	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	–	–	–
CNMG 120416E-M:T9335	⁂	1.6	175	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160608E-M:T9310	⁂	0.8	235	0.32	3.6	–	–	–	220	0.32	3.6	–	–	–	–	–	–	45	0.16	0.7
CNMG 160608E-M:T9325	⁂	0.8	190	0.32	3.6	–	–	–	180	0.32	3.6	–	–	–	–	–	–	–	–	–
CNMG 160608E-M:T9335	⁂	0.8	170	0.32	3.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160608E-M:T9415	⁂	0.8	255	0.32	3.6	–	–	–	240	0.32	3.6	–	–	–	–	–	–	50	0.16	0.7
CNMG 160612E-M:T9325	⁂	1.2	185	0.40	3.6	–	–	–	175	0.40	3.6	–	–	–	–	–	–	–	–	–
CNMG 160612E-M:T9335	⁂	1.2	160	0.40	3.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612E-M:T9415	⁂	1.2	250	0.40	3.6	–	–	–	235	0.40	3.6	–	–	–	–	–	–	50	0.20	1.0
CNMG 160616E-M:T9325	⁂	1.6	190	0.40	3.6	–	–	–	180	0.40	3.6	–	–	–	–	–	–	–	–	–
CNMG 160616E-M:T9335	⁂	1.6	165	0.40	3.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190608E-M:6630	⁂	0.8	175	0.32	4.2	–	–	–	165	0.32	4.2	–	–	–	–	–	–	–	–	–
CNMG 190608E-M:T9325	⁂	0.8	190	0.32	4.2	–	–	–	180	0.32	4.2	–	–	–	–	–	–	–	–	–
CNMG 190608E-M:T9335	⁂	0.8	165	0.32	4.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190608E-M:T9415	⁂	0.8	250	0.32	4.2	–	–	–	235	0.32	4.2	–	–	–	–	–	–	50	0.16	0.7
CNMG 190612E-M:6630	⁂	1.2	170	0.40	4.2	–	–	–	160	0.40	4.2	–	–	–	–	–	–	–	–	–
CNMG 190612E-M:6640	⁂	1.2	145	0.40	4.2	–	–	–	135	0.40	4.2	–	–	–	–	–	–	–	–	–
CNMG 190612E-M:T9325	●	1.2	185	0.40	4.2	–	–	–	175	0.40	4.2	–	–	–	–	–	–	–	–	–
CNMG 190612E-M:T9335	●	1.2	160	0.40	4.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612E-M:T9415	●	1.2	245	0.40	4.2	–	–	–	230	0.40	4.2	–	–	–	–	–	–	45	0.20	1.0
CNMG 190616E-M:T9325	●	1.6	190	0.40	4.2	–	–	–	180	0.40	4.2	–	–	–	–	–	–	–	–	–
CNMG 190616E-M:T9335	●	1.6	165	0.40	4.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190616E-M:T9415	●	1.6	255	0.40	4.2	–	–	–	240	0.40	4.2	–	–	–	–	–	–	50	0.20	1.3

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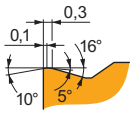

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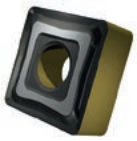
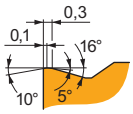
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
DNMG 110404E-M:T5315	●	0.4	210	0.20	1.2	–	–	–	195	0.20	1.2	–	–	–	–	–	–	40	0.14	0.3
DNMG 110404E-M:T9325	●	0.4	175	0.20	1.2	–	–	–	165	0.20	1.2	–	–	–	–	–	–	–	–	–
DNMG 110404E-M:T9335	●	0.4	150	0.20	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110404E-M:T9415	●	0.4	225	0.20	1.2	–	–	–	210	0.20	1.2	–	–	–	–	–	–	45	0.14	0.3
DNMG 110408E-M:T5315	●	0.8	215	0.30	1.2	–	–	–	200	0.30	1.2	–	–	–	–	–	–	40	0.15	0.7
DNMG 110408E-M:T9325	●	0.8	175	0.30	1.2	–	–	–	165	0.30	1.2	–	–	–	–	–	–	–	–	–
DNMG 110408E-M:T9335	●	0.8	155	0.30	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110408E-M:T9415	●	0.8	235	0.30	1.2	–	–	–	220	0.30	1.2	–	–	–	–	–	–	45	0.15	0.7
DNMG 110412E-M:T9325	●	1.2	165	0.40	1.2	–	–	–	155	0.40	1.2	–	–	–	–	–	–	–	–	–
DNMG 110412E-M:T9415	⊛	1.2	220	0.40	1.2	–	–	–	205	0.40	1.2	–	–	–	–	–	–	40	0.20	0.9
DNMG 150404E-M:T5315	●	0.4	200	0.20	1.9	–	–	–	190	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150404E-M:T9325	●	0.4	170	0.20	1.9	–	–	–	160	0.20	1.9	–	–	–	–	–	–	–	–	–
DNMG 150404E-M:T9415	●	0.4	210	0.20	1.9	–	–	–	195	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150408E-M:T5315	●	0.8	205	0.30	1.9	–	–	–	190	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150408E-M:T9315	●	0.8	190	0.30	1.9	–	–	–	180	0.30	1.9	–	–	–	–	–	–	35	0.15	0.7
DNMG 150408E-M:T9325	●	0.8	170	0.30	1.9	–	–	–	160	0.30	1.9	–	–	–	–	–	–	–	–	–
DNMG 150408E-M:T9335	●	0.8	145	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150408E-M:T9415	●	0.8	220	0.30	1.9	–	–	–	205	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150412E-M:T5315	●	1.2	200	0.40	1.9	–	–	–	190	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9
DNMG 150412E-M:T9315	●	1.2	175	0.40	1.9	–	–	–	165	0.40	1.9	–	–	–	–	–	–	35	0.20	0.9
DNMG 150412E-M:T9325	●	1.2	160	0.40	1.9	–	–	–	150	0.40	1.9	–	–	–	–	–	–	–	–	–
DNMG 150412E-M:T9415	⊛	1.2	210	0.40	1.9	–	–	–	195	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9
DNMG 150604E-M:T5315	⊛	0.4	200	0.20	1.9	–	–	–	190	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150604E-M:T9325	⊛	0.4	170	0.20	1.9	–	–	–	160	0.20	1.9	–	–	–	–	–	–	–	–	–
DNMG 150604E-M:T9335	⊛	0.4	145	0.20	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150604E-M:T9415	⊛	0.4	210	0.20	1.9	–	–	–	195	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150608E-M:T5315	⊛	0.8	205	0.30	1.9	–	–	–	190	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150608E-M:T9310	⊛	0.8	205	0.30	1.9	–	–	–	190	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150608E-M:T9315	⊛	0.8	190	0.30	1.9	–	–	–	180	0.30	1.9	–	–	–	–	–	–	35	0.15	0.7
DNMG 150608E-M:T9325	⊛	0.8	170	0.30	1.9	–	–	–	160	0.30	1.9	–	–	–	–	–	–	–	–	–
DNMG 150608E-M:T9335	⊛	0.8	145	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-M:T9415	⊛	0.8	220	0.30	1.9	–	–	–	205	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150612E-M:T5315	⊛	1.2	200	0.40	1.9	–	–	–	190	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9
DNMG 150612E-M:T9310	⊛	1.2	190	0.40	1.9	–	–	–	180	0.40	1.9	–	–	–	–	–	–	35	0.20	0.9
DNMG 150612E-M:T9315	⊛	1.2	175	0.40	1.9	–	–	–	165	0.40	1.9	–	–	–	–	–	–	35	0.20	0.9
DNMG 150612E-M:T9325	⊛	1.2	160	0.40	1.9	–	–	–	150	0.40	1.9	–	–	–	–	–	–	–	–	–
DNMG 150612E-M:T9335	⊛	1.2	140	0.40	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-M:T9415	⊛	1.2	210	0.40	1.9	–	–	–	195	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9

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。





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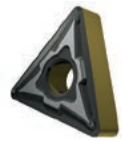
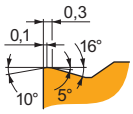
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
SNMG 120408E-M:T5305	●	0.8	290	0.32	2.1	–	–	–	275	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
SNMG 120408E-M:T5315	⇕	0.8	260	0.32	2.1	–	–	–	245	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
SNMG 120408E-M:T9325	⇕	0.8	210	0.32	2.1	–	–	–	195	0.32	2.1	–	–	–	–	–	–	–	–	–
SNMG 120408E-M:T9335	●	0.8	185	0.32	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120408E-M:T9415	●	0.8	280	0.32	2.1	–	–	–	265	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
SNMG 120412E-M:T9325	●	1.2	200	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	–	–	–
SNMG 120412E-M:T9335	●	1.2	175	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120412E-M:T9415	●	1.2	275	0.40	2.1	–	–	–	260	0.40	2.1	–	–	–	–	–	–	55	0.20	1.0
SNMG 120416E-M:T9325	●	1.6	210	0.40	2.1	–	–	–	195	0.40	2.1	–	–	–	–	–	–	–	–	–
SNMG 150612E-M:T9325	●	1.2	195	0.40	3.4	–	–	–	185	0.40	3.4	–	–	–	–	–	–	–	–	–
SNMG 150612E-M:T9335	●	1.2	170	0.40	3.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 150612E-M:T9415	⇕	1.2	260	0.40	3.4	–	–	–	245	0.40	3.4	–	–	–	–	–	–	50	0.20	1.0
SNMG 190612E-M:6630	⇕	1.2	175	0.40	4.0	–	–	–	165	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-M:T9325	●	1.2	190	0.40	4.0	–	–	–	180	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-M:T9335	●	1.2	165	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190612E-M:T9415	●	1.2	255	0.40	4.0	–	–	–	240	0.40	4.0	–	–	–	–	–	–	50	0.20	1.0
SNMG 190616E-M:T9325	●	1.6	200	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-M:T9335	●	1.6	175	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-M:T9415	⇕	1.6	270	0.40	4.0	–	–	–	255	0.40	4.0	–	–	–	–	–	–	50	0.20	1.3





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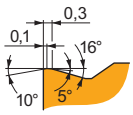
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
TNMG 160404E-M:T5315	●	0.4	215	0.20	1.6	–	–	–	200	0.20	1.6	–	–	–	–	–	–	40	0.14	0.3
TNMG 160404E-M:T9325	●	0.4	180	0.20	1.6	–	–	–	170	0.20	1.6	–	–	–	–	–	–	–	–	–
TNMG 160404E-M:T9335	⇕	0.4	155	0.20	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160404E-M:T9415	⇕	0.4	230	0.20	1.6	–	–	–	215	0.20	1.6	–	–	–	–	–	–	45	0.14	0.3
TNMG 160408E-M:T5305	●	0.8	250	0.30	1.6	–	–	–	235	0.30	1.6	–	–	–	–	–	–	50	0.15	0.7
TNMG 160408E-M:T5315	●	0.8	225	0.30	1.6	–	–	–	210	0.30	1.6	–	–	–	–	–	–	45	0.15	0.7
TNMG 160408E-M:T9310	●	0.8	220	0.30	1.6	–	–	–	205	0.30	1.6	–	–	–	–	–	–	40	0.15	0.7
TNMG 160408E-M:T9325	●	0.8	185	0.30	1.6	–	–	–	175	0.30	1.6	–	–	–	–	–	–	–	–	–
TNMG 160408E-M:T9335	●	0.8	160	0.30	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160408E-M:T9415	●	0.8	240	0.30	1.6	–	–	–	225	0.30	1.6	–	–	–	–	–	–	45	0.15	0.7
TNMG 160412E-M:T5315	●	1.2	215	0.40	1.6	–	–	–	200	0.40	1.6	–	–	–	–	–	–	40	0.20	0.9
TNMG 160412E-M:T9325	●	1.2	170	0.40	1.6	–	–	–	160	0.40	1.6	–	–	–	–	–	–	–	–	–
TNMG 160412E-M:T9335	●	1.2	145	0.40	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-M:T9415	●	1.2	225	0.40	1.6	–	–	–	210	0.40	1.6	–	–	–	–	–	–	45	0.20	0.9
TNMG 220408E-M:T5315	●	0.8	215	0.30	2.1	–	–	–	200	0.30	2.1	–	–	–	–	–	–	40	0.15	0.7
TNMG 220408E-M:T9325	⇕	0.8	180	0.30	2.1	–	–	–	170	0.30	2.1	–	–	–	–	–	–	–	–	–
TNMG 220408E-M:T9335	⇕	0.8	155	0.30	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-M:T9415	⇕	0.8	230	0.30	2.1	–	–	–	215	0.30	2.1	–	–	–	–	–	–	45	0.15	0.7
TNMG 220412E-M:T5315	●	1.2	205	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	40	0.20	0.9
TNMG 220412E-M:T9325	⇕	1.2	165	0.40	2.1	–	–	–	155	0.40	2.1	–	–	–	–	–	–	–	–	–
TNMG 220412E-M:T9335	●	1.2	140	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220412E-M:T9415	⇕	1.2	225	0.40	2.1	–	–	–	210	0.40	2.1	–	–	–	–	–	–	45	0.20	0.9



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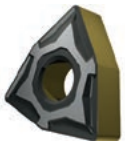
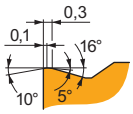
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
VNMG 160404E-M:T5315	⇕	0.4	180	0.20	1.2	–	–	–	170	0.20	1.2	–	–	–	–	–	–	35	0.14	0.3
VNMG 160404E-M:T9325	⇕	0.4	155	0.20	1.2	–	–	–	145	0.20	1.2	–	–	–	–	–	–	–	–	–
VNMG 160404E-M:T9415	⇕	0.4	195	0.20	1.2	–	–	–	185	0.20	1.2	–	–	–	–	–	–	35	0.14	0.3
VNMG 160408E-M:T5305	⇕	0.8	205	0.30	1.4	–	–	–	190	0.30	1.4	–	–	–	–	–	–	40	0.15	0.7
VNMG 160408E-M:T5315	⇕	0.8	185	0.30	1.4	–	–	–	175	0.30	1.4	–	–	–	–	–	–	35	0.15	0.7
VNMG 160408E-M:T9325	⇕	0.8	150	0.30	1.4	–	–	–	140	0.30	1.4	–	–	–	–	–	–	–	–	–
VNMG 160408E-M:T9335	⇕	0.8	130	0.30	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG 160408E-M:T9415	⇕	0.8	200	0.30	1.4	–	–	–	190	0.30	1.4	–	–	–	–	–	–	40	0.15	0.7
VNMG 160412E-M:T9325	⇕	1.2	140	0.40	1.4	–	–	–	130	0.40	1.4	–	–	–	–	–	–	–	–	–

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。





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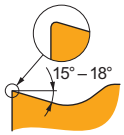
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
WNMG 060404E-M:T5315	⊛	0.4	250	0.20	1.8	–	–	–	235	0.20	1.8	–	–	–	–	–	–	50	0.13	0.3
WNMG 060404E-M:T9325	●	0.4	215	0.20	1.8	–	–	–	200	0.20	1.8	–	–	–	–	–	–	–	–	–
WNMG 060404E-M:T9415	●	0.4	270	0.20	1.8	–	–	–	255	0.20	1.8	–	–	–	–	–	–	50	0.13	0.3
WNMG 060408E-M:T5315	⊛	0.8	255	0.32	1.8	–	–	–	240	0.32	1.8	–	–	–	–	–	–	50	0.16	0.7
WNMG 060408E-M:T9325	⊛	0.8	205	0.32	1.8	–	–	–	190	0.32	1.8	–	–	–	–	–	–	–	–	–
WNMG 060408E-M:T9335	⊛	0.8	180	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 060408E-M:T9415	⊛	0.8	275	0.32	1.8	–	–	–	260	0.32	1.8	–	–	–	–	–	–	55	0.16	0.7
WNMG 080404E-M:T5315	●	0.4	260	0.20	1.2	–	–	–	245	0.20	1.2	–	–	–	–	–	–	50	0.13	0.3
WNMG 080404E-M:T9325	●	0.4	210	0.20	2.1	–	–	–	195	0.20	2.1	–	–	–	–	–	–	–	–	–
WNMG 080404E-M:T9335	●	0.4	180	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080404E-M:T9415	●	0.4	265	0.20	2.1	–	–	–	250	0.20	2.1	–	–	–	–	–	–	50	0.13	0.3
WNMG 080408E-M:T5305	●	0.8	280	0.32	2.1	–	–	–	265	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
WNMG 080408E-M:T5315	●	0.8	250	0.32	2.1	–	–	–	235	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
WNMG 080408E-M:T8430	⊛	0.8	170	0.32	2.1	–	–	–	135	0.32	2.1	–	–	–	–	–	–	25	0.16	0.7
WNMG 080408E-M:T9310	●	0.8	245	0.32	2.1	–	–	–	230	0.32	2.1	–	–	–	–	–	–	45	0.16	0.7
WNMG 080408E-M:T9315	●	0.8	225	0.32	2.1	–	–	–	210	0.32	2.1	–	–	–	–	–	–	45	0.16	0.7
WNMG 080408E-M:T9325	●	0.8	200	0.32	2.1	–	–	–	190	0.32	2.1	–	–	–	–	–	–	–	–	–
WNMG 080408E-M:T9335	⊛	0.8	180	0.32	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-M:T9415	⊛	0.8	270	0.32	2.1	–	–	–	255	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
WNMG 080412E-M:T5305	⊛	1.2	275	0.40	2.1	–	–	–	260	0.40	2.1	–	–	–	–	–	–	55	0.20	1.0
WNMG 080412E-M:T5315	⊛	1.2	245	0.40	2.1	–	–	–	230	0.40	2.1	–	–	–	–	–	–	45	0.20	1.0
WNMG 080412E-M:T9310	⊛	1.2	235	0.40	2.1	–	–	–	220	0.40	2.1	–	–	–	–	–	–	45	0.20	1.0
WNMG 080412E-M:T9315	●	1.2	220	0.40	2.1	–	–	–	205	0.40	2.1	–	–	–	–	–	–	40	0.20	1.0
WNMG 080412E-M:T9325	●	1.2	195	0.40	2.1	–	–	–	185	0.40	2.1	–	–	–	–	–	–	–	–	–
WNMG 080412E-M:T9335	⊛	1.2	170	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-M:T9415	●	1.2	265	0.40	2.1	–	–	–	250	0.40	2.1	–	–	–	–	–	–	50	0.20	1.0

SI

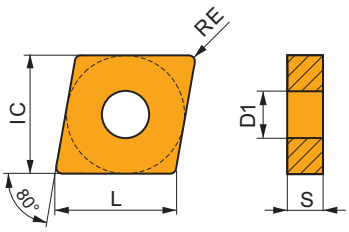


SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。

PRAMET

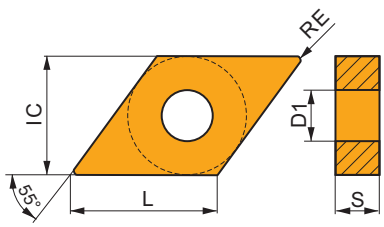
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



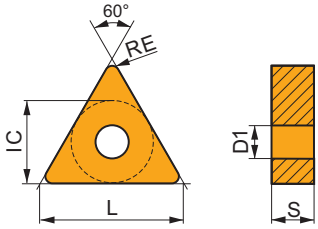
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



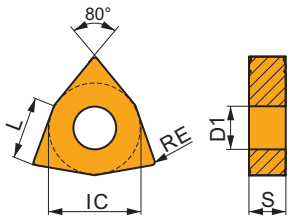
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76

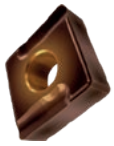
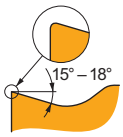


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	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/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)
																				
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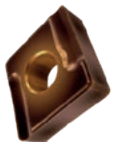
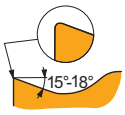
CNMG 120404ER-SI:T7335	●	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
CNMG 120404ER-SI:T8430	●	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
CNMG 120404ER-SI:T9325	●	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
CNMG 120408ER-SI:T7325	⬌	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408ER-SI:T7335	⬌	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408ER-SI:T8430	⬌	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
CNMG 120408ER-SI:T9325	●	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
CNMG 120412ER-SI:T8430	⬌	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–
																				
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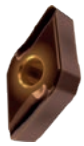
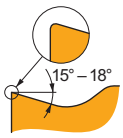
CNMG 120404EL-SI:T7335	●	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
CNMG 120404EL-SI:T8430	●	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
CNMG 120404EL-SI:T9325	●	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
CNMG 120408EL-SI:T7325	⬌	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408EL-SI:T7335	⬌	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408EL-SI:T8430	⬌	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
CNMG 120408EL-SI:T9325	●	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
CNMG 120412EL-SI:T8430	⬌	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–
																				
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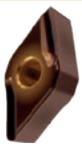
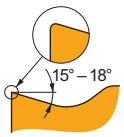
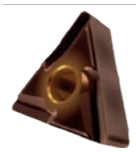
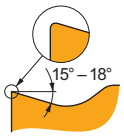
DNMG 110404ER-SI:T7325	●	0.4	185	0.20	1.0	140	0.18	1.0	–	–	–	–	–	–	60	0.18	0.8	–	–	–
DNMG 110404ER-SI:T7335	●	0.4	180	0.20	1.0	140	0.18	1.0	–	–	–	–	–	–	55	0.18	0.8	–	–	–
DNMG 110404ER-SI:T8430	●	0.4	185	0.20	1.0	100	0.18	1.0	–	–	–	510	0.24	1.0	40	0.18	0.8	–	–	–
DNMG 110404ER-SI:T9325	●	0.4	225	0.20	1.0	135	0.18	1.0	–	–	–	–	–	–	50	0.18	0.8	–	–	–
DNMG 110408ER-SI:T7335	●	0.8	175	0.35	1.0	135	0.32	1.0	–	–	–	–	–	–	55	0.25	0.8	–	–	–
DNMG 110408ER-SI:T8430	●	0.8	180	0.35	1.0	95	0.32	1.0	–	–	–	495	0.42	1.0	35	0.25	0.8	–	–	–
DNMG 110408ER-SI:T9325	●	0.8	210	0.35	1.0	125	0.32	1.0	–	–	–	–	–	–	45	0.25	0.8	–	–	–
DNMG 150404ER-SI:T8430	●	0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150404ER-SI:T9325	●	0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150408ER-SI:T8430	●	0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150408ER-SI:T9325	●	0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150604ER-SI:T7325	●	0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604ER-SI:T7335	●	0.4	170	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604ER-SI:T8315	●	0.4	165	0.20	1.5	95	0.18	1.5	–	–	–	495	0.24	1.5	40	0.18	1.2	–	–	–
DNMG 150604ER-SI:T8415	●	0.4	195	0.20	1.5	100	0.18	1.5	–	–	–	495	0.24	1.5	45	0.18	1.2	–	–	–
DNMG 150604ER-SI:T8430	●	0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150604ER-SI:T9325	●	0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150604ER-SI:T9335	●	0.4	185	0.20	1.5	110	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
DNMG 150608ER-SI:T7325	●	0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608ER-SI:T7335	●	0.8	170	0.35	1.5	130	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608ER-SI:T8315	●	0.8	165	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	40	0.25	1.2	–	–	–
DNMG 150608ER-SI:T8415	●	0.8	200	0.35	1.5	105	0.32	1.5	–	–	–	510	0.42	1.5	45	0.24	1.2	–	–	–
DNMG 150608ER-SI:T8430	●	0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150608ER-SI:T9325	●	0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150608ER-SI:T9335	●	0.8	180	0.35	1.5	105	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–

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。

Product		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)
																				
SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。																				
DNMG 110404EL-SI:T8430	●	0.4	185	0.20	1.0	100	0.18	1.0	–	–	–	510	0.24	1.0	40	0.18	0.8	–	–	–
DNMG 110404EL-SI:T9325	●	0.4	225	0.20	1.0	135	0.18	1.0	–	–	–	–	–	–	50	0.18	0.8	–	–	–
DNMG 110408EL-SI:T8430	●	0.8	180	0.35	1.0	95	0.32	1.0	–	–	–	495	0.42	1.0	35	0.25	0.8	–	–	–
DNMG 110408EL-SI:T9325	●	0.8	210	0.35	1.0	125	0.32	1.0	–	–	–	–	–	–	45	0.25	0.8	–	–	–
DNMG 150404EL-SI:T8430	●	0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150404EL-SI:T9325	●	0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150408EL-SI:T7335	●	0.8	170	0.35	1.5	130	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150408EL-SI:T8430	●	0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150408EL-SI:T9325	●	0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150604EL-SI:T7325	●	0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604EL-SI:T7335	●	0.4	170	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604EL-SI:T8315	●	0.4	165	0.20	1.5	95	0.18	1.5	–	–	–	495	0.24	1.5	40	0.18	1.2	–	–	–
DNMG 150604EL-SI:T8430	●	0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150604EL-SI:T9325	●	0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150604EL-SI:T9335	●	0.4	185	0.20	1.5	110	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
DNMG 150608EL-SI:T7325	●	0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608EL-SI:T7335	●	0.8	170	0.35	1.5	130	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608EL-SI:T8315	●	0.8	165	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	40	0.25	1.2	–	–	–
DNMG 150608EL-SI:T8415	●	0.8	200	0.35	1.5	105	0.32	1.5	–	–	–	510	0.42	1.5	45	0.24	1.2	–	–	–
DNMG 150608EL-SI:T8430	●	0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150608EL-SI:T9325	●	0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150608EL-SI:T9335	●	0.8	180	0.35	1.5	105	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–
																				
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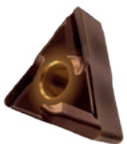
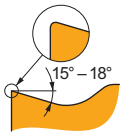
TNMG 160404ER-SI:T7325	●	0.4	190	0.20	1.5	145	0.18	1.5	–	–	–	–	–	–	60	0.18	1.2	–	–	–
TNMG 160404ER-SI:T7335	●	0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
TNMG 160404ER-SI:T8315	●	0.4	175	0.20	1.5	105	0.18	1.5	–	–	–	525	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404ER-SI:T8415	●	0.4	210	0.20	1.5	110	0.18	1.5	–	–	–	525	0.24	1.5	45	0.18	1.2	–	–	–
TNMG 160404ER-SI:T8430	●	0.4	185	0.20	1.5	100	0.18	1.5	–	–	–	510	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404ER-SI:T9325	●	0.4	230	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	50	0.18	1.2	–	–	–
TNMG 160404ER-SI:T9335	●	0.4	195	0.20	1.5	115	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
TNMG 160408ER-SI:T7325	●	0.8	190	0.35	1.5	145	0.32	1.5	–	–	–	–	–	–	60	0.25	1.2	–	–	–
TNMG 160408ER-SI:T7335	●	0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
TNMG 160408ER-SI:T8315	●	0.8	175	0.35	1.5	105	0.32	1.5	–	–	–	525	0.42	1.5	40	0.25	1.2	–	–	–
TNMG 160408ER-SI:T8415	●	0.8	215	0.35	1.5	110	0.32	1.5	–	–	–	540	0.42	1.5	45	0.24	1.2	–	–	–
TNMG 160408ER-SI:T8430	●	0.8	180	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	35	0.25	1.2	–	–	–
TNMG 160408ER-SI:T9325	●	0.8	215	0.35	1.5	125	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
TNMG 160408ER-SI:T9335	●	0.8	190	0.35	1.5	110	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–
																				
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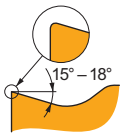
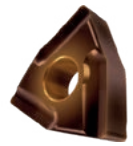
TNMG 160404EL-SI:T7325	●	0.4	190	0.20	1.5	145	0.18	1.5	–	–	–	–	–	–	60	0.18	1.2	–	–	–
TNMG 160404EL-SI:T7335	●	0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
TNMG 160404EL-SI:T8315	●	0.4	175	0.20	1.5	105	0.18	1.5	–	–	–	525	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404EL-SI:T8415	●	0.4	210	0.20	1.5	110	0.18	1.5	–	–	–	525	0.24	1.5	45	0.18	1.2	–	–	–
TNMG 160404EL-SI:T8430	●	0.4	185	0.20	1.5	100	0.18	1.5	–	–	–	510	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404EL-SI:T9325	●	0.4	230	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	50	0.18	1.2	–	–	–
TNMG 160404EL-SI:T9335	●	0.4	195	0.20	1.5	115	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
TNMG 160408EL-SI:T7325	●	0.8	190	0.35	1.5	145	0.32	1.5	–	–	–	–	–	–	60	0.25	1.2	–	–	–
TNMG 160408EL-SI:T7335	●	0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
TNMG 160408EL-SI:T8315	●	0.8	175	0.35	1.5	105	0.32	1.5	–	–	–	525	0.42	1.5	40	0.25	1.2	–	–	–
TNMG 160408EL-SI:T8415	●	0.8	215	0.35	1.5	110	0.32	1.5	–	–	–	540	0.42	1.5	45	0.24	1.2	–	–	–
TNMG 160408EL-SI:T8430	●	0.8	180	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	35	0.25	1.2	–	–	–
TNMG 160408EL-SI:T9325	●	0.8	215	0.35	1.5	125	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
TNMG 160408EL-SI:T9335	●	0.8	190	0.35	1.5	110	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–

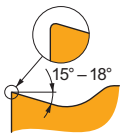
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。



SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。

Product		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)
WNMG 060404ER-SI:T8430	●	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 060404ER-SI:T9325	●	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080404ER-SI:T7325	●	0.4	220	0.20	1.7	170	0.18	1.7	–	–	–	–	–	–	70	0.18	1.4	–	–	–
WNMG 080404ER-SI:T7335	●	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
WNMG 080404ER-SI:T8315	●	0.4	205	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	50	0.18	1.4	–	–	–
WNMG 080404ER-SI:T8415	●	0.4	250	0.20	1.7	130	0.18	1.7	–	–	–	630	0.24	1.7	55	0.18	1.4	–	–	–
WNMG 080404ER-SI:T8430	●	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 080404ER-SI:T9325	●	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080408ER-SI:T7325	⬌	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408ER-SI:T7335	⬌	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408ER-SI:T8315	⬌	0.8	205	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	50	0.25	1.4	–	–	–
WNMG 080408ER-SI:T8430	⬌	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
WNMG 080408ER-SI:T9325	●	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
WNMG 080412ER-SI:T8430	⬌	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–

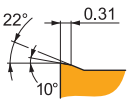




SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。

WNMG 060404EL-SI:T8430	●	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 060404EL-SI:T9325	●	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080404EL-SI:T7325	●	0.4	220	0.20	1.7	170	0.18	1.7	–	–	–	–	–	–	70	0.18	1.4	–	–	–
WNMG 080404EL-SI:T7335	●	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
WNMG 080404EL-SI:T8315	●	0.4	205	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	50	0.18	1.4	–	–	–
WNMG 080404EL-SI:T8415	●	0.4	250	0.20	1.7	130	0.18	1.7	–	–	–	630	0.24	1.7	55	0.18	1.4	–	–	–
WNMG 080404EL-SI:T8430	●	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 080404EL-SI:T9325	●	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080408EL-SI:T7325	⬌	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408EL-SI:T7335	⬌	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408EL-SI:T8315	⬌	0.8	205	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	50	0.25	1.4	–	–	–
WNMG 080408EL-SI:T8430	⬌	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
WNMG 080408EL-SI:T9325	●	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
WNMG 080412EL-SI:T8430	⬌	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–

NMR

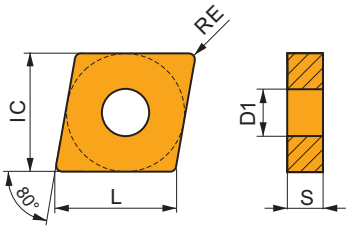


NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。

PRAMET

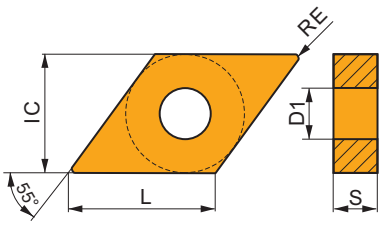
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



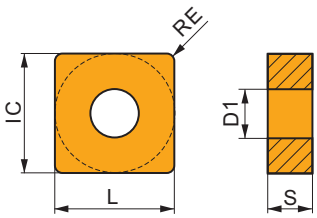
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



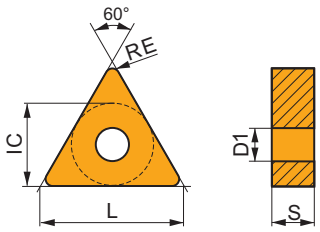
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35



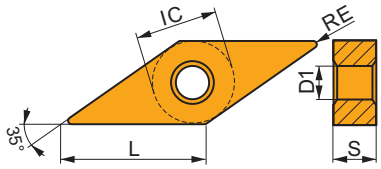
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



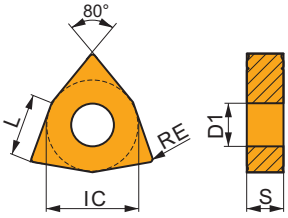
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

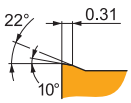


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



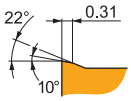
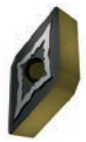
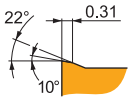
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。



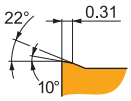
NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。

Product	Interrupted/ Continuous cut	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)
CNMG 090308E-NMR:T7325	⇕	0.8	175	0.35	1.6	135	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
CNMG 090308E-NMR:T7335	⇕	0.8	170	0.35	1.6	130	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
CNMG 120404E-NMR:T7325	●	0.4	155	0.25	2.7	120	0.23	2.7	–	–	–	–	–	–	50	0.20	2.2	–	–	–
CNMG 120404E-NMR:T7335	●	0.4	155	0.25	2.0	120	0.23	2.0	–	–	–	–	–	–	50	0.20	1.6	–	–	–
CNMG 120404E-NMR:T8430	⇕	0.4	150	0.25	2.7	80	0.23	2.7	–	–	–	–	–	–	30	0.20	2.2	–	–	–
CNMG 120404E-NMR:T9325	●	0.4	190	0.25	2.0	110	0.23	2.0	–	–	–	–	–	–	40	0.20	1.6	–	–	–
CNMG 120404E-NMR:T9415	●	0.4	245	0.25	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。

Product	● ⁞ ✱	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)
 NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
CNMG 120408E-NMR:T6310	⁞	0.8	150	0.35	2.7	105	0.32	2.7	–	–	–	–	–	–	45	0.25	2.2	–	–	–
CNMG 120408E-NMR:T7325	⁞	0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.25	2.2	–	–	–
CNMG 120408E-NMR:T7335	⁞	0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.25	2.2	–	–	–
CNMG 120408E-NMR:T8430	⁞	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
CNMG 120408E-NMR:T9325	⁞	0.8	190	0.35	2.7	110	0.32	2.7	–	–	–	–	–	–	40	0.25	2.2	–	–	–
CNMG 120408E-NMR:T9415	⁞	0.8	255	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-NMR:T6310	⁞	1.2	150	0.40	2.7	105	0.36	2.7	–	–	–	–	–	–	45	0.28	2.2	–	–	–
CNMG 120412E-NMR:T7325	⁞	1.2	170	0.40	2.7	130	0.36	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
CNMG 120412E-NMR:T7335	⁞	1.2	160	0.40	2.7	120	0.36	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
CNMG 120412E-NMR:T8430	✱	1.2	155	0.40	2.7	85	0.36	2.7	–	–	–	–	–	–	30	0.28	2.2	–	–	–
CNMG 120412E-NMR:T9325	⁞	1.2	190	0.40	2.7	110	0.36	2.7	–	–	–	–	–	–	40	0.28	2.2	–	–	–
CNMG 120412E-NMR:T9415	⁞	1.2	255	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120416E-NMR:T7325	⁞	1.6	170	0.45	2.7	130	0.41	2.7	–	–	–	–	–	–	55	0.32	2.2	–	–	–
CNMG 120416E-NMR:T7335	⁞	1.6	160	0.45	2.7	120	0.41	2.7	–	–	–	–	–	–	50	0.32	2.2	–	–	–
CNMG 120416E-NMR:T8430	✱	1.6	155	0.45	2.7	85	0.41	2.7	–	–	–	–	–	–	30	0.32	2.2	–	–	–
CNMG 160608E-NMR:T7325	⁞	0.8	160	0.35	4.0	120	0.32	4.0	–	–	–	–	–	–	50	0.25	3.2	–	–	–
CNMG 160608E-NMR:T7335	⁞	0.8	150	0.35	4.0	115	0.32	4.0	–	–	–	–	–	–	45	0.25	3.2	–	–	–
CNMG 160608E-NMR:T9325	⁞	0.8	185	0.35	4.0	110	0.32	4.0	–	–	–	–	–	–	40	0.25	3.2	–	–	–
CNMG 160608E-NMR:T9415	⁞	0.8	245	0.35	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612E-NMR:T7325	⁞	1.2	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 160612E-NMR:T7335	⁞	1.2	155	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 160612E-NMR:T8430	✱	1.2	150	0.40	4.0	80	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
CNMG 160612E-NMR:T9325	⁞	1.2	185	0.40	4.0	110	0.36	4.0	–	–	–	–	–	–	40	0.28	3.2	–	–	–
CNMG 160612E-NMR:T9415	⁞	1.2	245	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160616E-NMR:T7325	✱	1.6	165	0.45	4.0	125	0.41	4.0	–	–	–	–	–	–	50	0.32	3.2	–	–	–
CNMG 160616E-NMR:T7335	✱	1.6	155	0.45	4.0	120	0.41	4.0	–	–	–	–	–	–	50	0.32	3.2	–	–	–
CNMG 160616E-NMR:T8430	✱	1.6	150	0.45	4.0	80	0.41	4.0	–	–	–	–	–	–	30	0.32	3.2	–	–	–
CNMG 160616E-NMR:T9325	⁞	1.6	180	0.45	4.0	105	0.41	4.0	–	–	–	–	–	–	40	0.32	3.2	–	–	–
CNMG 160616E-NMR:T9415	⁞	1.6	240	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190608E-NMR:T6310	⁞	0.8	140	0.35	5.2	100	0.32	5.2	–	–	–	–	–	–	40	0.25	4.2	–	–	–
CNMG 190608E-NMR:T7325	⁞	0.8	155	0.35	5.2	120	0.32	5.2	–	–	–	–	–	–	50	0.25	4.2	–	–	–
CNMG 190608E-NMR:T7335	⁞	0.8	150	0.35	5.2	115	0.32	5.2	–	–	–	–	–	–	45	0.25	4.2	–	–	–
CNMG 190608E-NMR:T9325	⁞	0.8	180	0.35	5.2	105	0.32	5.2	–	–	–	–	–	–	40	0.25	4.2	–	–	–
CNMG 190608E-NMR:T9415	⁞	0.8	225	0.35	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612E-NMR:T6310	⁞	1.2	140	0.40	5.2	100	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
CNMG 190612E-NMR:T7325	⁞	1.2	160	0.40	5.2	120	0.36	5.2	–	–	–	–	–	–	50	0.28	4.2	–	–	–
CNMG 190612E-NMR:T7335	⁞	1.2	150	0.40	5.2	115	0.36	5.2	–	–	–	–	–	–	45	0.28	4.2	–	–	–
CNMG 190612E-NMR:T8430	✱	1.2	145	0.40	5.2	80	0.36	5.2	–	–	–	–	–	–	30	0.28	4.2	–	–	–
CNMG 190612E-NMR:T9325	⁞	1.2	180	0.40	5.2	105	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
CNMG 190616E-NMR:T7325	✱	1.6	160	0.45	5.2	120	0.41	5.2	–	–	–	–	–	–	50	0.32	4.2	–	–	–
CNMG 190616E-NMR:T7335	✱	1.6	150	0.45	5.2	115	0.41	5.2	–	–	–	–	–	–	45	0.32	4.2	–	–	–
CNMG 190616E-NMR:T8430	✱	1.6	145	0.45	5.2	80	0.41	5.2	–	–	–	–	–	–	30	0.32	4.2	–	–	–
CNMG 190616E-NMR:T9325	⁞	1.6	175	0.45	5.2	105	0.41	5.2	–	–	–	–	–	–	35	0.32	4.2	–	–	–
CNMG 190616E-NMR:T9415	⁞	1.6	240	0.45	5.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
  NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
DNMG 110404E-NMR:T7325	●	0.4	150	0.20	0.8	115	0.18	0.8	–	–	–	–	–	–	45	0.18	0.6	–	–	–
DNMG 110404E-NMR:T9325	●	0.4	185	0.20	0.8	110	0.18	0.8	–	–	–	–	–	–	40	0.18	0.6	–	–	–
DNMG 110408E-NMR:T7325	⁞	0.8	155	0.30	0.8	120	0.27	0.8	–	–	–	–	–	–	50	0.24	0.6	–	–	–
DNMG 110408E-NMR:T9415	●	0.8	240	0.30	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110412E-NMR:T7325	⁞	1.2	155	0.30	1.6	120	0.27	1.6	–	–	–	–	–	–	50	0.24	1.3	–	–	–
DNMG 110412E-NMR:T9325	⁞	1.2	180	0.30	1.6	105	0.27	1.6	–	–	–	–	–	–	40	0.24	1.3	–	–	–

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/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)
																				
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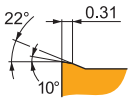
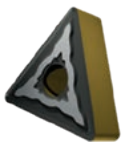
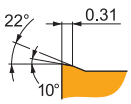
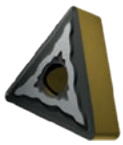
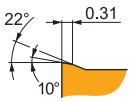
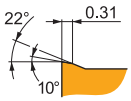
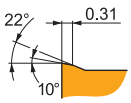
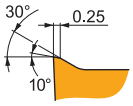
DNMG 150404E-NMR:T7325	●	0.4	140	0.20	1.9	105	0.18	1.9	–	–	–	–	–	–	45	0.18	1.5	–	–	–
DNMG 150404E-NMR:T9325	●	0.4	170	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	35	0.18	1.5	–	–	–
DNMG 150408E-NMR:T7325	⁞	0.8	145	0.30	1.9	110	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
DNMG 150408E-NMR:T8430	⁞	0.8	135	0.30	1.9	75	0.27	1.9	–	–	–	–	–	–	25	0.24	1.5	–	–	–
DNMG 150408E-NMR:T9325	⁞	0.8	170	0.30	1.9	100	0.27	1.9	–	–	–	–	–	–	35	0.24	1.5	–	–	–
DNMG 150408E-NMR:T9415	●	0.8	220	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150604E-NMR:T7325	●	0.4	140	0.20	1.9	105	0.18	1.9	–	–	–	–	–	–	45	0.18	1.5	–	–	–
DNMG 150604E-NMR:T7335	●	0.4	130	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	40	0.18	1.5	–	–	–
DNMG 150604E-NMR:T8430	●	0.4	135	0.20	1.9	75	0.18	1.9	–	–	–	–	–	–	25	0.18	1.5	–	–	–
DNMG 150604E-NMR:T9325	●	0.4	170	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	35	0.18	1.5	–	–	–
DNMG 150604E-NMR:T9415	●	0.4	210	0.20	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-NMR:T6310	⁞	0.8	125	0.30	1.9	90	0.27	1.9	–	–	–	–	–	–	35	0.24	1.5	–	–	–
DNMG 150608E-NMR:T7325	⁞	0.8	145	0.30	1.9	110	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
DNMG 150608E-NMR:T7335	⁞	0.8	140	0.30	1.9	105	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
DNMG 150608E-NMR:T8430	⁞	0.8	135	0.30	1.9	75	0.27	1.9	–	–	–	–	–	–	25	0.24	1.5	–	–	–
DNMG 150608E-NMR:T9325	⁞	0.8	170	0.30	1.9	100	0.27	1.9	–	–	–	–	–	–	35	0.24	1.5	–	–	–
DNMG 150608E-NMR:T9415	●	0.8	220	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-NMR:T7325	⁞	1.2	155	0.30	1.9	120	0.27	1.9	–	–	–	–	–	–	50	0.24	1.5	–	–	–
DNMG 150612E-NMR:T8430	⁞	1.2	145	0.30	1.9	80	0.27	1.9	–	–	–	–	–	–	30	0.24	1.5	–	–	–
DNMG 150612E-NMR:T9325	⁞	1.2	180	0.30	1.9	105	0.27	1.9	–	–	–	–	–	–	40	0.24	1.5	–	–	–
DNMG 150612E-NMR:T9415	⁞	1.2	235	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
SNMG 120408E-NMR:T7325	⁞	0.8	175	0.35	2.6	135	0.32	2.6	–	–	–	–	–	–	55	0.25	2.1	–	–	–
SNMG 120408E-NMR:T7335	⁞	0.8	165	0.35	2.6	125	0.32	2.6	–	–	–	–	–	–	50	0.25	2.1	–	–	–
SNMG 120408E-NMR:T8430	⁞	0.8	165	0.35	2.6	90	0.32	2.6	–	–	–	–	–	–	35	0.25	2.1	–	–	–
SNMG 120408E-NMR:T9325	⁞	0.8	200	0.35	2.6	120	0.32	2.6	–	–	–	–	–	–	45	0.25	2.1	–	–	–
SNMG 120412E-NMR:T6310	⁞	1.2	160	0.40	2.6	115	0.36	2.6	–	–	–	–	–	–	45	0.28	2.1	–	–	–
SNMG 120412E-NMR:T7335	⁞	1.2	165	0.40	2.6	125	0.36	2.6	–	–	–	–	–	–	50	0.28	2.1	–	–	–
SNMG 120412E-NMR:T9325	⁞	1.2	200	0.40	2.6	120	0.36	2.6	–	–	–	–	–	–	45	0.28	2.1	–	–	–
SNMG 120416E-NMR:T7325	✱	1.6	180	0.45	2.6	140	0.41	2.6	–	–	–	–	–	–	55	0.32	2.1	–	–	–
SNMG 150612E-NMR:T6310	✱	1.2	150	0.40	3.8	105	0.36	3.8	–	–	–	–	–	–	45	0.28	3.0	–	–	–
SNMG 150612E-NMR:T7325	✱	1.2	170	0.40	3.8	130	0.36	3.8	–	–	–	–	–	–	55	0.28	3.0	–	–	–
SNMG 150612E-NMR:T8430	✱	1.2	155	0.40	3.8	85	0.36	3.8	–	–	–	–	–	–	30	0.28	3.0	–	–	–
SNMG 150612E-NMR:T9325	⁞	1.2	190	0.40	3.8	110	0.36	3.8	–	–	–	–	–	–	40	0.28	3.0	–	–	–
SNMG 190612E-NMR:T6310	✱	1.2	145	0.40	5.2	100	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
SNMG 190612E-NMR:T7325	✱	1.2	165	0.40	5.2	125	0.36	5.2	–	–	–	–	–	–	50	0.28	4.2	–	–	–
SNMG 190612E-NMR:T7335	✱	1.2	155	0.40	5.2	120	0.36	5.2	–	–	–	–	–	–	50	0.28	4.2	–	–	–
SNMG 190612E-NMR:T9325	⁞	1.2	185	0.40	5.2	110	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
SNMG 190616E-NMR:T6310	✱	1.6	150	0.45	5.2	105	0.41	5.2	–	–	–	–	–	–	45	0.32	4.2	–	–	–
SNMG 190616E-NMR:T7325	✱	1.6	170	0.45	5.2	130	0.41	5.2	–	–	–	–	–	–	55	0.32	4.2	–	–	–
SNMG 190616E-NMR:T7335	✱	1.6	155	0.45	5.2	120	0.41	5.2	–	–	–	–	–	–	50	0.32	4.2	–	–	–
SNMG 190616E-NMR:T8430	✱	1.6	150	0.45	5.2	80	0.41	5.2	–	–	–	–	–	–	30	0.32	4.2	–	–	–
SNMG 190616E-NMR:T9415	⁞	1.6	250	0.45	5.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																				
NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
TNMG 160404E-NMR:T6310	●	0.4	130	0.20	1.7	90	0.18	1.7	–	–	–	–	–	–	35	0.18	1.4	–	–	–
TNMG 160404E-NMR:T7325	●	0.4	145	0.20	1.7	110	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
TNMG 160404E-NMR:T7335	●	0.4	145	0.20	1.7	110	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
TNMG 160404E-NMR:T8430	●	0.4	145	0.20	1.7	80	0.18	1.7	–	–	–	–	–	–	30	0.18	1.4	–	–	–
TNMG 160404E-NMR:T9325	●	0.4	180	0.20	1.7	105	0.18	1.7	–	–	–	–	–	–	40	0.18	1.4	–	–	–

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/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)
  NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
TNMG 160408E-NMR:T6310	⁞	0.8	140	0.30	1.7	100	0.27	1.7	–	–	–	–	–	–	40	0.24	1.4	–	–	–
TNMG 160408E-NMR:T7325	⁞	0.8	155	0.30	1.7	120	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 160408E-NMR:T7335	⁞	0.8	145	0.30	1.7	110	0.27	1.7	–	–	–	–	–	–	45	0.24	1.4	–	–	–
TNMG 160408E-NMR:T8430	⁞	0.8	150	0.30	1.7	80	0.27	1.7	–	–	–	–	–	–	30	0.24	1.4	–	–	–
TNMG 160408E-NMR:T9325	⁞	0.8	185	0.30	1.7	110	0.27	1.7	–	–	–	–	–	–	40	0.24	1.4	–	–	–
TNMG 160408E-NMR:T9415	●	0.8	235	0.30	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-NMR:T7325	⁞	1.2	165	0.30	1.7	125	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 160412E-NMR:T8430	⁞	1.2	155	0.30	1.7	85	0.27	1.7	–	–	–	–	–	–	30	0.24	1.4	–	–	–
TNMG 160412E-NMR:T9415	⁞	1.2	250	0.30	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-NMR:T6310	⁞	0.8	135	0.30	2.1	95	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220408E-NMR:T7325	⁞	0.8	150	0.30	2.1	115	0.27	2.1	–	–	–	–	–	–	45	0.24	1.7	–	–	–
TNMG 220408E-NMR:T7335	⁞	0.8	145	0.30	2.1	110	0.27	2.1	–	–	–	–	–	–	45	0.24	1.7	–	–	–
TNMG 220408E-NMR:T8430	⁞	0.8	145	0.30	2.1	80	0.27	2.1	–	–	–	–	–	–	30	0.24	1.7	–	–	–
TNMG 220408E-NMR:T9325	⁞	0.8	180	0.30	2.1	105	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220412E-NMR:T6310	⁞	1.2	140	0.30	2.1	100	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220412E-NMR:T7325	⁞	1.2	160	0.30	2.1	120	0.27	2.1	–	–	–	–	–	–	50	0.24	1.7	–	–	–
TNMG 220412E-NMR:T9325	⁞	1.2	190	0.30	2.1	110	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220412E-NMR:T9415	⁞	1.2	245	0.30	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
VNMG 160404E-NMR:T7325	●	0.4	125	0.20	1.2	95	0.18	1.2	–	–	–	–	–	–	40	0.18	1.0	–	–	–
VNMG 160404E-NMR:T9325	●	0.4	155	0.20	1.2	90	0.18	1.2	–	–	–	–	–	–	30	0.18	1.0	–	–	–
VNMG 160408E-NMR:T7325	●	0.8	130	0.30	1.4	100	0.27	1.4	–	–	–	–	–	–	40	0.24	1.1	–	–	–
VNMG 160408E-NMR:T8430	⁞	0.8	125	0.30	1.4	65	0.27	1.4	–	–	–	–	–	–	25	0.24	1.1	–	–	–
VNMG 160408E-NMR:T9325	●	0.8	150	0.30	1.4	90	0.27	1.4	–	–	–	–	–	–	30	0.24	1.1	–	–	–
VNMG 160408E-NMR:T9415	●	0.8	200	0.30	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG 160412E-NMR:T8430	⁞	1.2	130	0.30	1.4	70	0.27	1.4	–	–	–	–	–	–	25	0.24	1.1	–	–	–
 NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
WNMG 060404E-NMR:T6310	●	0.4	145	0.25	1.6	100	0.23	1.6	–	–	–	–	–	–	40	0.20	1.3	–	–	–
WNMG 060404E-NMR:T7325	●	0.4	160	0.25	1.6	120	0.23	1.6	–	–	–	–	–	–	50	0.20	1.3	–	–	–
WNMG 060404E-NMR:T8430	⁞	0.4	165	0.25	1.6	90	0.23	1.6	–	–	–	–	–	–	35	0.20	1.3	–	–	–
WNMG 060404E-NMR:T9325	●	0.4	200	0.25	1.6	120	0.23	1.6	–	–	–	–	–	–	45	0.20	1.3	–	–	–
WNMG 060408E-NMR:T7325	⁞	0.8	175	0.35	1.6	135	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
WNMG 060408E-NMR:T7335	⁞	0.8	170	0.35	1.6	130	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
WNMG 060408E-NMR:T8430	⁞	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
WNMG 060408E-NMR:T9325	⁞	0.8	200	0.35	1.6	120	0.32	1.6	–	–	–	–	–	–	45	0.25	1.3	–	–	–
WNMG 080404E-NMR:T6310	●	0.4	140	0.25	2.7	100	0.23	2.7	–	–	–	–	–	–	40	0.20	2.2	–	–	–
WNMG 080404E-NMR:T7325	●	0.4	155	0.25	2.7	120	0.23	2.7	–	–	–	–	–	–	50	0.20	2.2	–	–	–
WNMG 080404E-NMR:T7335	●	0.4	150	0.25	2.7	115	0.23	2.7	–	–	–	–	–	–	45	0.20	2.2	–	–	–
WNMG 080404E-NMR:T8430	⁞	0.4	150	0.25	2.7	80	0.23	2.7	–	–	–	–	–	–	30	0.20	2.2	–	–	–
WNMG 080404E-NMR:T9415	●	0.4	240	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-NMR:T6310	⁞	0.8	150	0.35	2.7	105	0.32	2.7	–	–	–	–	–	–	45	0.25	2.2	–	–	–
WNMG 080408E-NMR:T7325	⁞	0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.25	2.2	–	–	–
WNMG 080408E-NMR:T7335	⁞	0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.25	2.2	–	–	–
WNMG 080408E-NMR:T8430	⁞	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
WNMG 080408E-NMR:T9325	⁞	0.8	190	0.35	2.7	110	0.32	2.7	–	–	–	–	–	–	40	0.25	2.2	–	–	–
WNMG 080408E-NMR:T9415	⁞	0.8	255	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-NMR:T6310	⁞	1.2	150	0.40	2.7	105	0.36	2.7	–	–	–	–	–	–	45	0.28	2.2	–	–	–
WNMG 080412E-NMR:T7325	⁞	1.2	170	0.40	2.7	130	0.36	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
WNMG 080412E-NMR:T7335	⁞	1.2	160	0.40	2.7	120	0.36	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
WNMG 080412E-NMR:T8430	✱	1.2	155	0.40	2.7	85	0.36	2.7	–	–	–	–	–	–	30	0.28	2.2	–	–	–
WNMG 080412E-NMR:T9325	⁞	1.2	190	0.40	2.7	110	0.36	2.7	–	–	–	–	–	–	40	0.28	2.2	–	–	–
WNMG 080412E-NMR:T9415	⁞	1.2	255	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

NM

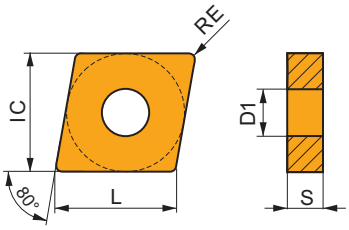


NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。

PRAMET

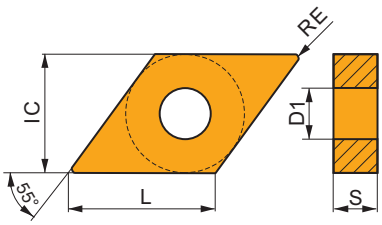
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



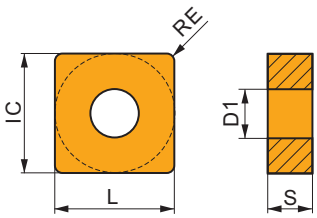
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



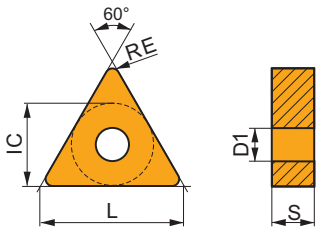
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



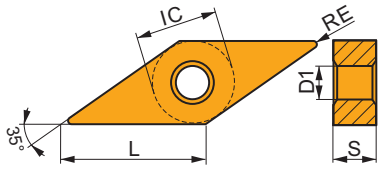
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



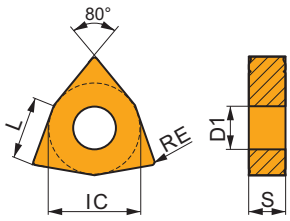
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

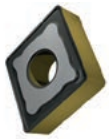
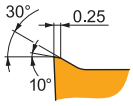
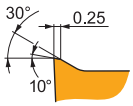


WNMG

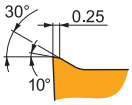
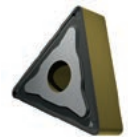
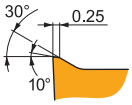
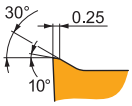
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



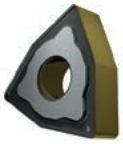
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

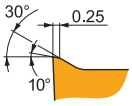
Product	● ⁝ ⁝	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。																				
CNMG 120404E-NM:T7325	●	0.4	◪ 195	0.20	2.1	■ 150	0.18	2.1	–	–	–	–	–	–	■ 60	0.16	1.7	–	–	–
CNMG 120404E-NM:T7335	●	0.4	◪ 190	0.20	2.1	■ 145	0.18	2.1	–	–	–	–	–	–	■ 60	0.16	1.7	–	–	–
CNMG 120404E-NM:T8430	●	0.4	■ 195	0.20	2.1	■ 105	0.18	2.1	–	–	–	◪ 540	0.24	2.1	◪ 40	0.16	1.7	–	–	–
CNMG 120404E-NM:T9325	●	0.4	■ 240	0.20	2.1	■ 140	0.18	2.1	–	–	–	–	–	–	◪ 50	0.16	1.7	–	–	–
CNMG 120404E-NM:T9415	●	0.4	■ 305	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-NM:T7325	⁝	0.8	◪ 215	0.25	2.1	■ 165	0.23	2.1	–	–	–	–	–	–	■ 65	0.20	1.7	–	–	–
CNMG 120408E-NM:T7335	⁝	0.8	◪ 210	0.25	2.1	■ 160	0.23	2.1	–	–	–	–	–	–	■ 65	0.20	1.7	–	–	–
CNMG 120408E-NM:T8315	⁝	0.8	◪ 205	0.25	2.1	■ 120	0.23	2.1	–	–	–	◪ 615	0.30	2.1	◪ 50	0.20	1.7	–	–	–
CNMG 120408E-NM:T8415	⁝	0.8	■ 245	0.25	2.1	■ 125	0.23	2.1	–	–	–	◪ 615	0.30	2.1	■ 55	0.20	1.7	–	–	–
CNMG 120408E-NM:T8430	⁝	0.8	■ 210	0.25	2.1	■ 115	0.23	2.1	–	–	–	◪ 585	0.30	2.1	◪ 45	0.20	1.7	–	–	–
CNMG 120408E-NM:T9315	⁝	0.8	■ 290	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-NM:T9325	⁝	0.8	■ 260	0.25	2.1	■ 155	0.23	2.1	–	–	–	–	–	–	◪ 55	0.20	1.7	–	–	–
CNMG 120408E-NM:T9415	⁝	0.8	■ 335	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-NM:T7325	⁝	1.2	◪ 215	0.30	2.1	■ 165	0.27	2.1	–	–	–	–	–	–	■ 65	0.24	1.7	–	–	–
CNMG 120412E-NM:T7335	⁝	1.2	◪ 210	0.30	2.1	■ 160	0.27	2.1	–	–	–	–	–	–	■ 65	0.24	1.7	–	–	–
CNMG 120412E-NM:T8430	⁝	1.2	■ 210	0.30	2.1	■ 115	0.27	2.1	–	–	–	◪ 585	0.36	2.1	◪ 45	0.24	1.7	–	–	–
CNMG 120412E-NM:T9325	⁝	1.2	■ 255	0.30	2.1	■ 150	0.27	2.1	–	–	–	–	–	–	◪ 55	0.24	1.7	–	–	–
CNMG 160608E-NM:T7325	⁝	0.8	◪ 195	0.30	3.6	■ 150	0.27	3.6	–	–	–	–	–	–	■ 60	0.27	2.9	–	–	–
CNMG 160608E-NM:T7335	⁝	0.8	◪ 190	0.30	3.6	■ 145	0.27	3.6	–	–	–	–	–	–	■ 60	0.27	2.9	–	–	–
CNMG 160608E-NM:T8430	⁝	0.8	■ 185	0.30	3.6	■ 100	0.27	3.6	–	–	–	◪ 510	0.36	3.6	◪ 40	0.27	2.9	–	–	–
CNMG 160608E-NM:T9325	⁝	0.8	■ 225	0.30	3.6	■ 135	0.27	3.6	–	–	–	–	–	–	◪ 50	0.27	2.9	–	–	–
CNMG 160612E-NM:T7325	⁝	1.2	◪ 205	0.30	3.6	■ 155	0.27	3.6	–	–	–	–	–	–	■ 65	0.27	2.9	–	–	–
CNMG 160612E-NM:T7335	⁝	1.2	◪ 200	0.30	3.6	■ 155	0.27	3.6	–	–	–	–	–	–	■ 65	0.27	2.9	–	–	–
CNMG 160612E-NM:T8315	⁝	1.2	◪ 195	0.30	3.6	■ 115	0.27	3.6	–	–	–	◪ 585	0.36	3.6	◪ 45	0.27	2.9	–	–	–
CNMG 160612E-NM:T9325	⁝	1.2	■ 240	0.30	3.6	■ 140	0.27	3.6	–	–	–	–	–	–	◪ 50	0.27	2.9	–	–	–
CNMG 190612E-NM:T7325	⁝	1.2	◪ 195	0.35	4.2	■ 150	0.32	4.2	–	–	–	–	–	–	■ 60	0.32	3.4	–	–	–
CNMG 190612E-NM:T7335	⁝	1.2	◪ 180	0.35	4.2	■ 140	0.32	4.2	–	–	–	–	–	–	■ 55	0.32	3.4	–	–	–
CNMG 190612E-NM:T8430	⁝	1.2	■ 180	0.35	4.2	■ 95	0.32	4.2	–	–	–	◪ 495	0.42	4.2	◪ 35	0.32	3.4	–	–	–
CNMG 190612E-NM:T9325	⁝	1.2	■ 220	0.35	4.2	■ 130	0.32	4.2	–	–	–	–	–	–	◪ 45	0.32	3.4	–	–	–
																				
NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。																				
DNMG 110404E-NM:T7325	●	0.4	◪ 175	0.20	0.8	■ 135	0.18	0.8	–	–	–	–	–	–	■ 55	0.20	0.6	–	–	–
DNMG 110404E-NM:T7335	●	0.4	◪ 165	0.20	0.8	■ 125	0.18	0.8	–	–	–	–	–	–	■ 50	0.20	0.6	–	–	–
DNMG 110404E-NM:T8430	●	0.4	■ 175	0.20	0.8	■ 95	0.18	0.8	–	–	–	◪ 480	0.24	0.8	◪ 35	0.20	0.6	–	–	–
DNMG 110404E-NM:T9325	●	0.4	■ 210	0.20	0.8	■ 125	0.18	0.8	–	–	–	–	–	–	◪ 45	0.20	0.6	–	–	–
DNMG 110408E-NM:T7325	●	0.8	◪ 190	0.25	0.8	■ 145	0.23	0.8	–	–	–	–	–	–	■ 60	0.20	0.6	–	–	–
DNMG 110408E-NM:T7335	●	0.8	◪ 185	0.25	0.8	■ 140	0.23	0.8	–	–	–	–	–	–	■ 60	0.20	0.6	–	–	–
DNMG 110408E-NM:T8315	●	0.8	◪ 180	0.25	0.8	■ 105	0.23	0.8	–	–	–	◪ 540	0.30	0.8	◪ 45	0.20	0.6	–	–	–
DNMG 110408E-NM:T8415	●	0.8	■ 215	0.25	0.8	■ 110	0.23	0.8	–	–	–	◪ 540	0.30	0.8	■ 45	0.20	0.6	–	–	–
DNMG 110408E-NM:T8430	⁝	0.8	■ 190	0.25	0.8	■ 105	0.23	0.8	–	–	–	◪ 525	0.30	0.8	◪ 40	0.20	0.6	–	–	–
DNMG 110408E-NM:T9325	●	0.8	■ 230	0.25	0.8	■ 135	0.23	0.8	–	–	–	–	–	–	◪ 50	0.20	0.6	–	–	–
DNMG 150408E-NM:T8430	⁝	0.8	■ 175	0.25	1.9	■ 95	0.23	1.9	–	–	–	◪ 480	0.30	1.9	◪ 35	0.20	1.5	–	–	–
DNMG 150408E-NM:T9325	●	0.8	■ 210	0.25	1.9	■ 125	0.23	1.9	–	–	–	–	–	–	◪ 45	0.20	1.5	–	–	–
DNMG 150604E-NM:T7325	●	0.4	◪ 160	0.20	1.9	■ 120	0.18	1.9	–	–	–	–	–	–	■ 50	0.20	1.5	–	–	–
DNMG 150604E-NM:T7335	●	0.4	◪ 150	0.20	1.9	■ 115	0.18	1.9	–	–	–	–	–	–	■ 45	0.20	1.5	–	–	–
DNMG 150604E-NM:T8430	●	0.4	■ 155	0.20	1.9	■ 85	0.18	1.9	–	–	–	◪ 435	0.24	1.9	◪ 30	0.20	1.5	–	–	–
DNMG 150604E-NM:T9325	●	0.4	■ 195	0.20	1.9	■ 115	0.18	1.9	–	–	–	–	–	–	◪ 40	0.20	1.5	–	–	–
DNMG 150608E-NM:T7325	●	0.8	◪ 175	0.25	1.9	■ 135	0.23	1.9	–	–	–	–	–	–	■ 55	0.20	1.5	–	–	–
DNMG 150608E-NM:T7335	●	0.8	◪ 170	0.25	1.9	■ 130	0.23	1.9	–	–	–	–	–	–	■ 55	0.20	1.5	–	–	–
DNMG 150608E-NM:T8315	●	0.8	◪ 165	0.25	1.9	■ 95	0.23	1.9	–	–	–	◪ 495	0.30	1.9	◪ 40	0.20	1.5	–	–	–
DNMG 150608E-NM:T8430	⁝	0.8	■ 175	0.25	1.9	■ 95	0.23	1.9	–	–	–	◪ 480	0.30	1.9	◪ 35	0.20	1.5	–	–	–
DNMG 150608E-NM:T9325	●	0.8	■ 210	0.25	1.9	■ 125	0.23	1.9	–	–	–	–	–	–	◪ 45	0.20	1.5	–	–	–
DNMG 150608E-NM:T9415	●	0.8	■ 275	0.25	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-NM:T7325	⁝	1.2	◪ 175	0.30	1.9	■ 135	0.27	1.9	–	–	–	–	–	–	■ 55	0.24	1.5	–	–	–
DNMG 150612E-NM:T7335	⁝	1.2	◪ 170	0.30	1.9	■ 130	0.27	1.9	–	–	–	–	–	–	■ 55	0.24	1.5	–	–	–
DNMG 150612E-NM:T9325	⁝	1.2	■ 205	0.30	1.9	■ 120	0.27	1.9	–	–	–	–	–	–	◪ 45	0.24	1.5	–	–	–

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。

Product		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)
																				
NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。																				
SNMG 120408E-NM:T7325	⬌	0.8	◪	225	0.25	2.1	■	175	0.23	2.1	–	–	–	–	–	–	■	70	0.20	1.7	–	–	–
SNMG 120408E-NM:T7335	⬌	0.8	◪	220	0.25	2.1	■	170	0.23	2.1	–	–	–	–	–	–	■	70	0.20	1.7	–	–	–
SNMG 120408E-NM:T8430	⬌	0.8	■	225	0.25	2.1	■	120	0.23	2.1	–	–	–	◪	615	0.30	2.1	◪	45	0.20	1.7	–	–	–
SNMG 120408E-NM:T9325	⬌	0.8	■	275	0.25	2.1	■	165	0.23	2.1	–	–	–	–	–	–	–	◪	60	0.20	1.7	–	–	–
SNMG 120412E-NM:T7325	⬌	1.2	◪	225	0.30	2.1	■	175	0.27	2.1	–	–	–	–	–	–	■	70	0.24	1.7	–	–	–
SNMG 120412E-NM:T7335	⬌	1.2	◪	220	0.30	2.1	■	170	0.27	2.1	–	–	–	–	–	–	■	70	0.24	1.7	–	–	–
SNMG 120412E-NM:T9325	⬌	1.2	■	270	0.30	2.1	■	160	0.27	2.1	–	–	–	–	–	–	◪	60	0.24	1.7	–	–	–
 																				
NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。																				
TNMG 160404E-NM:T7325	●	0.4	◪	170	0.20	1.9	■	130	0.18	1.9	–	–	–	–	–	–	■	55	0.20	1.5	–	–	–
TNMG 160404E-NM:T7335	●	0.4	◪	160	0.20	1.9	■	120	0.18	1.9	–	–	–	–	–	–	■	50	0.20	1.5	–	–	–
TNMG 160404E-NM:T8430	●	0.4	■	170	0.20	1.9	■	90	0.18	1.9	–	–	–	◪	465	0.24	1.9	◪	35	0.20	1.5	–	–	–
TNMG 160404E-NM:T9325	●	0.4	■	210	0.20	1.9	■	125	0.18	1.9	–	–	–	–	–	–	–	◪	45	0.20	1.5	–	–	–
TNMG 160408E-NM:T7325	●	0.8	◪	190	0.25	1.9	■	145	0.23	1.9	–	–	–	–	–	–	–	■	60	0.20	1.5	–	–	–
TNMG 160408E-NM:T7335	●	0.8	◪	180	0.25	1.9	■	140	0.23	1.9	–	–	–	–	–	–	–	■	55	0.20	1.5	–	–	–
TNMG 160408E-NM:T8315	●	0.8	◪	175	0.25	1.9	■	105	0.23	1.9	–	–	–	◪	525	0.30	1.9	◪	40	0.20	1.5	–	–	–
TNMG 160408E-NM:T8415	●	0.8	■	215	0.25	1.9	■	110	0.23	1.9	–	–	–	◪	540	0.30	1.9	■	45	0.20	1.5	–	–	–
TNMG 160408E-NM:T8430	⬌	0.8	■	185	0.25	1.9	■	100	0.23	1.9	–	–	–	◪	510	0.30	1.9	◪	40	0.20	1.5	–	–	–
TNMG 160408E-NM:T9325	●	0.8	■	225	0.25	1.9	■	135	0.23	1.9	–	–	–	–	–	–	–	◪	50	0.20	1.5	–	–	–
TNMG 160408E-NM:T9415	●	0.8	■	290	0.25	1.9		–	–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
TNMG 220408E-NM:T7325	●	0.8	◪	190	0.25	1.7	■	145	0.23	1.7	–	–	–	–	–	–	–	■	60	0.20	1.4	–	–	–
TNMG 220408E-NM:T7335	●	0.8	◪	185	0.25	1.7	■	140	0.23	1.7	–	–	–	–	–	–	–	■	60	0.20	1.4	–	–	–
TNMG 220408E-NM:T8315	●	0.8	◪	175	0.25	1.7	■	105	0.23	1.7	–	–	–	◪	525	0.30	1.7	◪	40	0.20	1.4	–	–	–
TNMG 220408E-NM:T8415	●	0.8	■	215	0.25	1.7	■	110	0.23	1.7	–	–	–	◪	540	0.30	1.7	■	45	0.20	1.4	–	–	–
TNMG 220408E-NM:T8430	⬌	0.8	■	185	0.25	1.7	■	100	0.23	1.7	–	–	–	◪	510	0.30	1.7	◪	40	0.20	1.4	–	–	–
TNMG 220408E-NM:T9325	●	0.8	■	225	0.25	1.7	■	135	0.23	1.7	–	–	–	–	–	–	–	◪	50	0.20	1.4	–	–	–
TNMG 220412E-NM:T7325	⬌	1.2	◪	190	0.30	1.7	■	145	0.27	1.7	–	–	–	–	–	–	–	■	60	0.24	1.4	–	–	–
TNMG 220412E-NM:T7335	⬌	1.2	◪	180	0.30	2.1	■	140	0.27	2.1	–	–	–	–	–	–	–	■	55	0.24	1.7	–	–	–
TNMG 220412E-NM:T9325	⬌	1.2	■	215	0.30	2.1	■	125	0.27	2.1	–	–	–	–	–	–	–	◪	45	0.24	1.7	–	–	–
																				
NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。																				
VNMG 160404E-NM:T7325	●	0.4	◪	145	0.20	1.2	■	110	0.18	1.2	–	–	–	–	–	–	■	45	0.20	1.0	–	–	–
VNMG 160404E-NM:T7335	●	0.4	◪	140	0.20	1.2	■	105	0.18	1.2	–	–	–	–	–	–	■	45	0.20	1.0	–	–	–
VNMG 160404E-NM:T8315	●	0.4	◪	135	0.20	1.2	■	80	0.18	1.2	–	–	–	◪	405	0.24	1.2	◪	30	0.20	1.0	–	–	–
VNMG 160404E-NM:T8415	●	0.4	■	160	0.20	1.2	■	85	0.18	1.2	–	–	–	◪	405	0.24	1.2	■	35	0.20	1.0	–	–	–
VNMG 160404E-NM:T8430	●	0.4	■	145	0.20	1.2	■	80	0.18	1.2	–	–	–	◪	405	0.24	1.2	◪	30	0.20	1.0	–	–	–
VNMG 160404E-NM:T9325	●	0.4	■	180	0.20	1.2	■	105	0.18	1.2	–	–	–	–	–	–	–	◪	40	0.20	1.0	–	–	–
VNMG 160408E-NM:T7325	●	0.8	◪	160	0.25	1.4	■	120	0.23	1.4	–	–	–	–	–	–	–	■	50	0.20	1.1	–	–	–
VNMG 160408E-NM:T7335	●	0.8	◪	155	0.25	1.4	■	120	0.23	1.4	–	–	–	–	–	–	–	■	50	0.20	1.1	–	–	–
VNMG 160408E-NM:T8315	●	0.8	◪	145	0.25	1.4	■	85	0.23	1.4	–	–	–	◪	435	0.30	1.4	◪	35	0.20	1.1	–	–	–
VNMG 160408E-NM:T8415	●	0.8	■	180	0.25	1.4	■	90	0.23	1.4	–	–	–	◪	450	0.30	1.4	■	40	0.20	1.1	–	–	–
VNMG 160408E-NM:T8430	●	0.8	■	155	0.25	1.4	■	85	0.23	1.4	–	–	–	◪	435	0.30	1.4	◪	30	0.20	1.1	–	–	–
VNMG 160408E-NM:T9325	●	0.8	■	190	0.25	1.4	■	110	0.23	1.4	–	–	–	–	–	–	–	◪	40	0.20	1.1	–	–	–

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。





NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。

Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
WNMG 060404E-NM:T7325	●	0.4	200	0.20	1.8	155	0.18	1.8	–	–	–	–	–	–	65	0.16	1.4	–	–	–
WNMG 060404E-NM:T7335	●	0.4	195	0.20	1.8	150	0.18	1.8	–	–	–	–	–	–	60	0.16	1.4	–	–	–
WNMG 060404E-NM:T8430	●	0.4	185	0.25	1.8	100	0.23	1.8	–	–	–	510	0.30	1.8	40	0.20	1.4	–	–	–
WNMG 060404E-NM:T9325	●	0.4	245	0.20	1.8	145	0.18	1.8	–	–	–	–	–	–	55	0.16	1.4	–	–	–
WNMG 060408E-NM:T7325	⬌	0.8	220	0.25	1.8	170	0.23	1.8	–	–	–	–	–	–	70	0.20	1.4	–	–	–
WNMG 060408E-NM:T7335	⬌	0.8	215	0.25	1.8	165	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
WNMG 060408E-NM:T8430	⬌	0.8	220	0.25	1.8	120	0.23	1.8	–	–	–	600	0.30	1.8	45	0.20	1.4	–	–	–
WNMG 060408E-NM:T9325	⬌	0.8	265	0.25	1.8	155	0.23	1.8	–	–	–	–	–	–	55	0.20	1.4	–	–	–
WNMG 060412E-NM:T7325	⬌	1.2	220	0.30	1.8	170	0.27	1.8	–	–	–	–	–	–	70	0.24	1.4	–	–	–
WNMG 060412E-NM:T7335	⬌	1.2	220	0.30	1.2	170	0.27	1.2	–	–	–	–	–	–	70	0.24	1.0	–	–	–
WNMG 060412E-NM:T9325	⬌	1.2	255	0.30	1.8	150	0.27	1.8	–	–	–	–	–	–	55	0.24	1.4	–	–	–
WNMG 080404E-NM:T7325	●	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
WNMG 080404E-NM:T7335	●	0.4	190	0.20	2.1	145	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
WNMG 080404E-NM:T8430	●	0.4	180	0.25	2.1	95	0.23	2.1	–	–	–	495	0.30	2.1	35	0.20	1.7	–	–	–
WNMG 080404E-NM:T9315	●	0.4	270	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080404E-NM:T9325	●	0.4	240	0.20	2.1	140	0.18	2.1	–	–	–	–	–	–	50	0.16	1.7	–	–	–
WNMG 080404E-NM:T9415	●	0.4	305	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-NM:T7325	⬌	0.8	215	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
WNMG 080408E-NM:T7335	⬌	0.8	210	0.25	2.1	160	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
WNMG 080408E-NM:T8315	⬌	0.8	205	0.25	2.1	120	0.23	2.1	–	–	–	615	0.30	2.1	50	0.20	1.7	–	–	–
WNMG 080408E-NM:T8430	⬌	0.8	210	0.25	2.1	115	0.23	2.1	–	–	–	585	0.30	2.1	45	0.20	1.7	–	–	–
WNMG 080408E-NM:T9315	⬌	0.8	290	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-NM:T9325	⬌	0.8	260	0.25	2.1	155	0.23	2.1	–	–	–	–	–	–	55	0.20	1.7	–	–	–
WNMG 080408E-NM:T9415	⬌	0.8	335	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-NM:T7325	⬌	1.2	215	0.30	2.1	165	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
WNMG 080412E-NM:T7335	⬌	1.2	210	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
WNMG 080412E-NM:T8315	⬌	1.2	205	0.30	2.1	120	0.27	2.1	–	–	–	615	0.36	2.1	50	0.24	1.7	–	–	–
WNMG 080412E-NM:T8415	⬌	1.2	245	0.30	2.1	125	0.27	2.1	–	–	–	615	0.36	2.1	55	0.24	1.7	–	–	–
WNMG 080412E-NM:T9325	⬌	1.2	255	0.30	2.1	150	0.27	2.1	–	–	–	–	–	–	55	0.24	1.7	–	–	–

.NMA

.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。

PRAMET

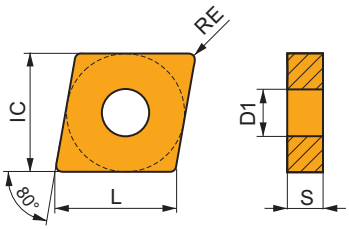
.NMA ..S

.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。

PRAMET

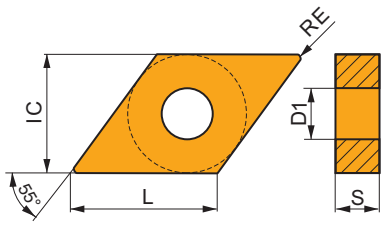
CNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



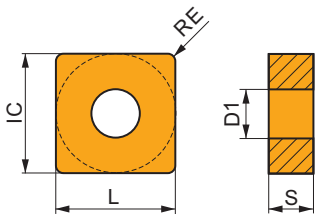
DNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



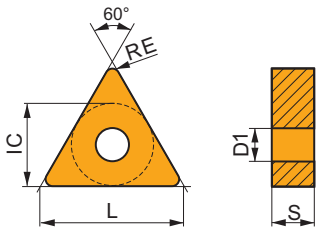
SNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



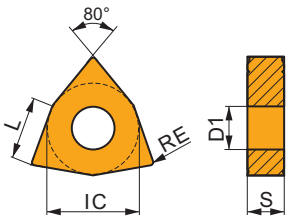
TNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

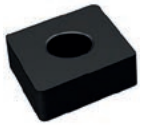
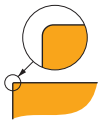


WNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	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/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)
 																				
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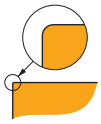
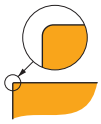
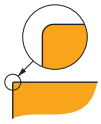
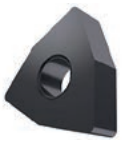
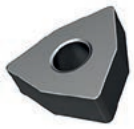
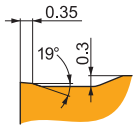
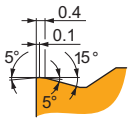
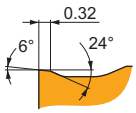
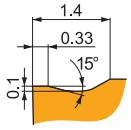
CNMA 120404:T5305	●	0.4	–	–	–	–	–	–	235	0.10	4.0	–	–	–	–	–	–	50	0.10	0.3
CNMA 120404:T5315	●	0.4	–	–	–	–	–	–	200	0.10	4.0	–	–	–	–	–	–	40	0.10	0.3
CNMA 120408:T5305	●	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
CNMA 120408:T5315	⬢	0.8	–	–	–	–	–	–	190	0.20	4.0	–	–	–	–	–	–	40	0.10	0.7
CNMA 120408:T6310	⬢	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.10	0.7
CNMA 120408:T8415	⬢	0.8	–	–	–	–	–	–	145	0.20	4.0	–	–	–	–	–	–	25	0.14	0.5
CNMA 120412:T5305	⬢	1.2	–	–	–	–	–	–	195	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 120412:T5315	⬢	1.2	–	–	–	–	–	–	180	0.30	4.0	–	–	–	–	–	–	35	0.15	1.0
CNMA 120412:T6310	⬢	1.2	–	–	–	–	–	–	95	0.30	4.0	–	–	–	–	–	–	20	0.15	1.0
CNMA 120412:T8415	⬢	1.2	–	–	–	–	–	–	135	0.30	4.0	–	–	–	–	–	–	25	0.21	0.5
CNMA 120416:T5305	⬢	1.6	–	–	–	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.20	1.3
CNMA 120416:T5315	⬢	1.6	–	–	–	–	–	–	170	0.40	4.0	–	–	–	–	–	–	35	0.20	1.3
CNMA 160612:T5305	⬢	1.2	–	–	–	–	–	–	190	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 160612:T5315	⬢	1.2	–	–	–	–	–	–	175	0.30	5.0	–	–	–	–	–	–	35	0.15	1.0
CNMA 160616:T5315	⬢	1.6	–	–	–	–	–	–	165	0.40	5.0	–	–	–	–	–	–	35	0.20	1.3
CNMA 190612:T5305	⬢	1.2	–	–	–	–	–	–	190	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 190612:T5315	⬢	1.2	–	–	–	–	–	–	170	0.30	6.0	–	–	–	–	–	–	35	0.15	1.0
CNMA 190616:T5305	⬢	1.6	–	–	–	–	–	–	180	0.40	6.0	–	–	–	–	–	–	35	0.20	1.3
CNMA 190616:T5315	⬢	1.6	–	–	–	–	–	–	160	0.40	6.0	–	–	–	–	–	–	30	0.20	1.3
																				
.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。																				
CNMA 120408S:T5305	⬢	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
CNMA 120412S:T5305	⬢	1.2	–	–	–	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.20	1.3
CNMA 160612S:T5305	⬢	1.2	–	–	–	–	–	–	190	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 190616S:T5305	⬢	1.6	–	–	–	–	–	–	180	0.40	6.0	–	–	–	–	–	–	35	0.20	1.3
.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
DNMA 150408:T5305	●	0.8	–	–	–	–	–	–	190	0.20	1.7	–	–	–	–	–	–	40	0.10	0.7
DNMA 150408:T5315	●	0.8	–	–	–	–	–	–	165	0.20	1.7	–	–	–	–	–	–	35	0.10	0.7
DNMA 150604:T5305	●	0.4	–	–	–	–	–	–	205	0.10	1.7	–	–	–	–	–	–	40	0.10	0.3
DNMA 150604:T5315	●	0.4	–	–	–	–	–	–	180	0.10	1.7	–	–	–	–	–	–	35	0.10	0.3
DNMA 150604:T6310	●	0.4	–	–	–	–	–	–	85	0.10	1.7	–	–	–	–	–	–	20	0.07	0.3
DNMA 150604:T8415	●	0.4	–	–	–	–	–	–	130	0.10	1.7	–	–	–	–	–	–	25	0.07	0.5
DNMA 150608:T5305	●	0.8	–	–	–	–	–	–	190	0.20	1.7	–	–	–	–	–	–	40	0.10	0.7
DNMA 150608:T5315	●	0.8	–	–	–	–	–	–	165	0.20	1.7	–	–	–	–	–	–	35	0.10	0.7
DNMA 150608:T6310	⬢	0.8	–	–	–	–	–	–	85	0.20	1.7	–	–	–	–	–	–	20	0.10	0.7
DNMA 150608:T8415	⬢	0.8	–	–	–	–	–	–	125	0.20	1.7	–	–	–	–	–	–	20	0.14	0.5
DNMA 150612:T5305	●	1.2	–	–	–	–	–	–	200	0.20	1.7	–	–	–	–	–	–	40	0.10	0.9
DNMA 150612:T5315	⬢	1.2	–	–	–	–	–	–	175	0.20	1.7	–	–	–	–	–	–	35	0.10	0.9
.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
SNMA 120408:T5305	⬢	0.8	–	–	–	–	–	–	230	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
SNMA 120408:T5315	⬢	0.8	–	–	–	–	–	–	200	0.20	4.0	–	–	–	–	–	–	40	0.10	0.7
SNMA 120408:T6310	⬢	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.10	0.7
SNMA 120408:T8415	⬢	0.8	–	–	–	–	–	–	150	0.20	4.0	–	–	–	–	–	–	25	0.14	0.5
SNMA 120412:T5305	⬢	1.2	–	–	–	–	–	–	205	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 120412:T5315	⬢	1.2	–	–	–	–	–	–	190	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 150612:T5305	⬢	1.2	–	–	–	–	–	–	200	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 150612:T5315	⬢	1.2	–	–	–	–	–	–	185	0.30	5.0	–	–	–	–	–	–	35	0.15	1.0
SNMA 190612:T5305	⬢	1.2	–	–	–	–	–	–	195	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 190612:T5315	⬢	1.2	–	–	–	–	–	–	180	0.30	6.0	–	–	–	–	–	–	35	0.15	1.0

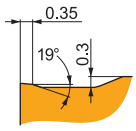
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
																				
.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
SNMA 190616:T5305	●	1.6	–	–	–	–	–	–	190	0.40	6.0	–	–	–	–	–	–	40	0.20	1.3
SNMA 190616:T5315	●	1.6	–	–	–	–	–	–	170	0.40	6.0	–	–	–	–	–	–	35	0.20	1.3
SNMA 250724:T5305	●	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.30	2.0
SNMA 250724:T5315	●	2.4	–	–	–	–	–	–	90	0.60	8.0	–	–	–	–	–	–	15	0.30	2.0
SNMA 250924:T5305	●	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.30	2.0
SNMA 250924:T5315	●	2.4	–	–	–	–	–	–	90	0.60	8.0	–	–	–	–	–	–	15	0.30	2.0
.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。																				
SNMA 190616S:T5305	●	1.6	–	–	–	–	–	–	195	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 250924S:T5305	●	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.30	2.0
																				
.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
TNMA 160404:T5305	●	0.4	–	–	–	–	–	–	220	0.10	1.5	–	–	–	–	–	–	45	0.10	0.3
TNMA 160404:T5315	●	0.4	–	–	–	–	–	–	190	0.10	1.5	–	–	–	–	–	–	40	0.10	0.3
TNMA 160408:T5305	●	0.8	–	–	–	–	–	–	205	0.20	1.5	–	–	–	–	–	–	40	0.10	0.7
TNMA 160408:T5315	●	0.8	–	–	–	–	–	–	180	0.20	1.5	–	–	–	–	–	–	35	0.10	0.7
TNMA 160408:T6310	●	0.8	–	–	–	–	–	–	90	0.20	1.5	–	–	–	–	–	–	20	0.10	0.7
TNMA 160408:T8415	●	0.8	–	–	–	–	–	–	135	0.20	1.5	–	–	–	–	–	–	25	0.14	0.5
TNMA 160412:T5305	●	1.2	–	–	–	–	–	–	215	0.20	1.5	–	–	–	–	–	–	45	0.10	0.9
TNMA 160412:T5315	●	1.2	–	–	–	–	–	–	190	0.20	1.5	–	–	–	–	–	–	40	0.10	0.9
TNMA 220408:T5305	●	0.8	–	–	–	–	–	–	195	0.20	2.0	–	–	–	–	–	–	40	0.10	0.7
TNMA 220408:T5315	●	0.8	–	–	–	–	–	–	175	0.20	2.0	–	–	–	–	–	–	35	0.10	0.7
TNMA 220408:T6310	●	0.8	–	–	–	–	–	–	90	0.20	2.0	–	–	–	–	–	–	20	0.10	0.7
TNMA 220408:T8415	●	0.8	–	–	–	–	–	–	130	0.20	2.0	–	–	–	–	–	–	25	0.14	0.5
TNMA 220412:T5305	●	1.2	–	–	–	–	–	–	205	0.20	2.0	–	–	–	–	–	–	40	0.10	0.9
TNMA 220412:T5315	●	1.2	–	–	–	–	–	–	185	0.20	2.0	–	–	–	–	–	–	35	0.10	0.9
.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。																				
TNMA 160408S:T5305	●	0.8	–	–	–	–	–	–	205	0.20	1.5	–	–	–	–	–	–	40	0.10	0.7
																				
.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
WNMA 080404:T5305	●	0.4	–	–	–	–	–	–	235	0.10	4.0	–	–	–	–	–	–	50	0.10	0.3
WNMA 080404:T5315	●	0.4	–	–	–	–	–	–	200	0.10	4.0	–	–	–	–	–	–	40	0.10	0.3
WNMA 080408:T5305	●	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
WNMA 080408:T5315	●	0.8	–	–	–	–	–	–	190	0.20	4.0	–	–	–	–	–	–	40	0.10	0.7
WNMA 080408:T6310	●	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.10	0.7
WNMA 080408:T8415	●	0.8	–	–	–	–	–	–	145	0.20	4.0	–	–	–	–	–	–	25	0.14	0.5
WNMA 080412:T5305	●	1.2	–	–	–	–	–	–	195	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
WNMA 080412:T5315	●	1.2	–	–	–	–	–	–	180	0.30	4.0	–	–	–	–	–	–	35	0.15	1.0
WNMA 080412:T6310	●	1.2	–	–	–	–	–	–	95	0.30	4.0	–	–	–	–	–	–	20	0.15	1.0
WNMA 080412:T8415	●	1.2	–	–	–	–	–	–	135	0.30	4.0	–	–	–	–	–	–	25	0.21	0.5
																				
.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。																				
WNMA 080408S:T5305	●	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7

粗加工 – 导航工具

RM			RM 断屑槽坚固耐用，是钢件粗加工的首选。具有正前角和宽的稳定T-型倒棱。还适用于不锈钢、铸铁，有条件的用于耐热合金。
R			R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。
NRM			NRM 型断屑槽用途广泛，是不锈钢粗加工的首选。它具有正前角和稳定、宽大的 T 倒棱。它还适用于钢和超级合金。
KR			KR 型断屑槽坚固耐用，是铸铁粗加工的首选。它的特点是略带正前角和宽 T 倒棱。它还适用于钢材，有条件时也适用于硬质材料。

RM

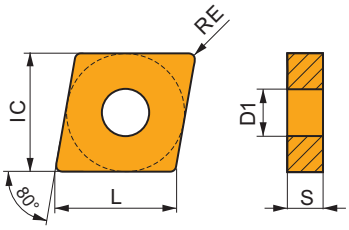


RM 断屑槽坚固耐用，是钢件粗加工的首选。具有正前角和宽的稳定T-型倒棱。还适用于不锈钢、铸铁，有条件的用于耐热合金。

PRAMET

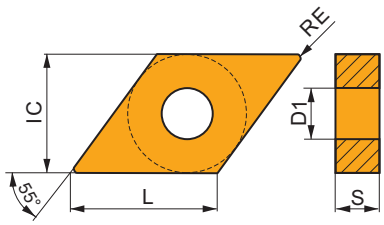
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



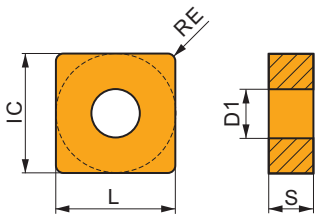
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



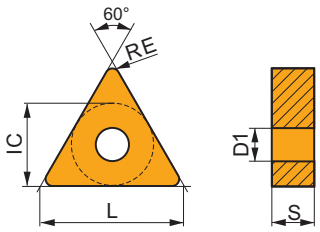
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2509	25.400	9.12	25.40	9.53



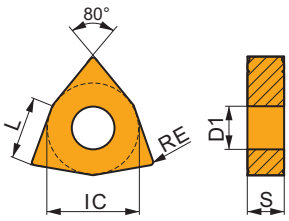
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76
2706	15.875	6.35	27.50	6.35
3309	19.050	7.94	33.00	9.53

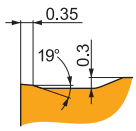


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



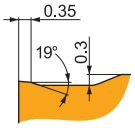
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。



RM 断屑槽坚固耐用，是钢件粗加工的首选。具有正前角和宽的稳定T-型倒棱。还适用于不锈钢、铸铁，有条件的用于耐热合金。

Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
CNMG 120408E-RM:T5305	●	0.8	275	0.40	4.0	–	–	–	260	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-RM:T5315	⁘	0.8	250	0.40	4.0	–	–	–	235	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-RM:T6310	⁘	0.8	155	0.40	4.0	110	0.36	4.0	125	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
CNMG 120408E-RM:T7325	⁘	0.8	180	0.40	4.0	140	0.36	4.0	–	–	–	–	–	–	55	0.28	3.2	–	–	–
CNMG 120408E-RM:T7335	⁘	0.8	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 120408E-RM:T8315	⁘	0.8	165	0.40	4.0	95	0.36	4.0	155	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
CNMG 120408E-RM:T8415	⁘	0.8	195	0.40	4.0	100	0.36	4.0	180	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
CNMG 120408E-RM:T8430	⁘	0.8	165	0.40	4.0	90	0.36	4.0	135	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
CNMG 120408E-RM:T9310	⁘	0.8	240	0.40	4.0	–	–	–	225	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-RM:T9315	⁘	0.8	220	0.40	4.0	–	–	–	205	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-RM:T9325	⁘	0.8	200	0.40	4.0	120	0.36	4.0	190	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
CNMG 120408E-RM:T9335	⁘	0.8	170	0.40	4.0	100	0.36	4.0	–	–	–	–	–	–	35	0.28	3.2	–	–	–
CNMG 120408E-RM:T9415	⁘	0.8	265	0.40	4.0	–	–	–	250	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-RM:T5305	⁘	1.2	280	0.45	4.0	–	–	–	265	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-RM:T5315	⁘	1.2	250	0.45	4.0	–	–	–	235	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-RM:T6310	⁘	1.2	160	0.45	4.0	115	0.41	4.0	125	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
CNMG 120412E-RM:T7325	⁘	1.2	180	0.45	4.0	140	0.41	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
CNMG 120412E-RM:T7335	⁘	1.2	170	0.45	4.0	130	0.41	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
CNMG 120412E-RM:T8415	⁘	1.2	200	0.45	4.0	105	0.41	4.0	185	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
CNMG 120412E-RM:T8430	✱	1.2	170	0.45	4.0	90	0.41	4.0	135	0.45	4.0	–	–	–	35	0.32	3.2	–	–	–
CNMG 120412E-RM:T9310	⁘	1.2	240	0.45	4.0	–	–	–	225	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-RM:T9315	⁘	1.2	220	0.45	4.0	–	–	–	205	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-RM:T9325	⁘	1.2	200	0.45	4.0	120	0.41	4.0	190	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
CNMG 120412E-RM:T9335	⁘	1.2	175	0.45	4.0	105	0.41	4.0	–	–	–	–	–	–	35	0.32	3.2	–	–	–
CNMG 120412E-RM:T9415	⁘	1.2	270	0.45	4.0	–	–	–	255	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120416E-RM:T5315	⁘	1.6	255	0.50	4.0	–	–	–	240	0.50	4.0	–	–	–	–	–	–	–	–	–
CNMG 120416E-RM:T7335	⁘	1.6	175	0.50	4.0	135	0.45	4.0	–	–	–	–	–	–	55	0.35	3.2	–	–	–
CNMG 120416E-RM:T8430	✱	1.6	170	0.50	4.0	90	0.45	4.0	135	0.50	4.0	–	–	–	35	0.35	3.2	–	–	–
CNMG 120416E-RM:T9325	⁘	1.6	205	0.50	4.0	120	0.45	4.0	190	0.50	4.0	–	–	–	45	0.35	3.2	–	–	–
CNMG 120416E-RM:T9335	⁘	1.6	175	0.50	4.0	105	0.45	4.0	–	–	–	–	–	–	35	0.35	3.2	–	–	–
CNMG 120416E-RM:T9415	⁘	1.6	275	0.50	4.0	–	–	–	260	0.50	4.0	–	–	–	–	–	–	–	–	–
CNMG 160608E-RM:T5305	⁘	0.8	265	0.40	6.0	–	–	–	250	0.40	6.0	–	–	–	–	–	–	–	–	–
CNMG 160608E-RM:T5315	⁘	0.8	240	0.40	6.0	–	–	–	225	0.40	6.0	–	–	–	–	–	–	–	–	–
CNMG 160608E-RM:T8430	⁘	0.8	155	0.40	6.0	85	0.36	6.0	130	0.40	6.0	–	–	–	30	0.28	4.8	–	–	–
CNMG 160608E-RM:T9325	⁘	0.8	190	0.40	6.0	110	0.36	6.0	180	0.40	6.0	–	–	–	40	0.28	4.8	–	–	–
CNMG 160608E-RM:T9335	⁘	0.8	165	0.40	6.0	95	0.36	6.0	–	–	–	–	–	–	35	0.28	4.8	–	–	–
CNMG 160608E-RM:T9415	⁘	0.8	255	0.40	6.0	–	–	–	240	0.40	6.0	–	–	–	–	–	–	–	–	–
CNMG 160612E-RM:T5305	⁘	1.2	270	0.45	6.0	–	–	–	255	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMG 160612E-RM:T6310	⁘	1.2	155	0.45	6.0	110	0.41	6.0	125	0.45	6.0	–	–	–	45	0.32	4.8	–	–	–
CNMG 160612E-RM:T7325	⁘	1.2	170	0.45	6.0	130	0.41	6.0	–	–	–	–	–	–	55	0.32	4.8	–	–	–
CNMG 160612E-RM:T7335	⁘	1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.32	4.8	–	–	–
CNMG 160612E-RM:T8415	⁘	1.2	195	0.45	6.0	100	0.41	6.0	180	0.45	6.0	–	–	–	45	0.32	4.8	–	–	–
CNMG 160612E-RM:T8430	✱	1.2	155	0.45	6.0	85	0.41	6.0	130	0.45	6.0	–	–	–	30	0.32	4.8	–	–	–
CNMG 160612E-RM:T9310	⁘	1.2	230	0.45	6.0	–	–	–	215	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMG 160612E-RM:T9315	⁘	1.2	215	0.45	6.0	–	–	–	200	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMG 160612E-RM:T9325	⁘	1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0	–	–	–	40	0.32	4.8	–	–	–
CNMG 160612E-RM:T9335	⁘	1.2	165	0.45	6.0	95	0.41	6.0	–	–	–	–	–	–	35	0.32	4.8	–	–	–
CNMG 160612E-RM:T9415	⁘	1.2	260	0.45	6.0	–	–	–	245	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM:T5305	⁘	1.6	270	0.50	6.0	–	–	–	255	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM:T5315	⁘	1.6	245	0.50	6.0	–	–	–	230	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM:T7325	⁘	1.6	175	0.50	6.0	135	0.45	6.0	–	–	–	–	–	–	55	0.35	4.8	–	–	–
CNMG 160616E-RM:T7335	⁘	1.6	165	0.50	6.0	125	0.45	6.0	–	–	–	–	–	–	50	0.35	4.8	–	–	–
CNMG 160616E-RM:T9310	⁘	1.6	225	0.50	6.0	–	–	–	210	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM:T9315	⁘	1.6	215	0.50	6.0	–	–	–	200	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM:T9325	⁘	1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0	–	–	–	40	0.35	4.8	–	–	–
CNMG 160616E-RM:T9335	⁘	1.6	165	0.50	6.0	95	0.45	6.0	–	–	–	–	–	–	35	0.35	4.8	–	–	–
CNMG 160616E-RM:T9415	⁘	1.6	265	0.50	6.0	–	–	–	250	0.50	6.0	–	–	–	–	–	–	–	–	–

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。



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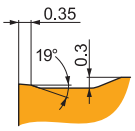
Product	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CNMG 190608E-RM:T5305	⇕	0.8	260	0.40	7.5	–	–	–	245	0.40	7.5	–	–	–	–	–	–	–	–	–
CNMG 190608E-RM:T5315	⇕	0.8	230	0.40	7.5	–	–	–	215	0.40	7.5	–	–	–	–	–	–	–	–	–
CNMG 190608E-RM:T7335	⇕	0.8	155	0.40	7.5	120	0.36	7.5	–	–	–	–	–	–	50	0.28	6.0	–	–	–
CNMG 190608E-RM:T9325	⇕	0.8	190	0.40	7.5	110	0.36	7.5	180	0.40	7.5	–	–	–	40	0.28	6.0	–	–	–
CNMG 190608E-RM:T9335	⇕	0.8	160	0.40	7.5	95	0.36	7.5	–	–	–	–	–	–	35	0.28	6.0	–	–	–
CNMG 190608E-RM:T9415	⇕	0.8	250	0.40	7.5	–	–	–	235	0.40	7.5	–	–	–	–	–	–	–	–	–
CNMG 190612E-RM:T5305	⇕	1.2	260	0.45	7.5	–	–	–	245	0.45	7.5	–	–	–	–	–	–	–	–	–
CNMG 190612E-RM:T5315	⇕	1.2	240	0.45	7.5	–	–	–	225	0.45	7.5	–	–	–	–	–	–	–	–	–
CNMG 190612E-RM:T6310	⇕	1.2	155	0.45	7.5	110	0.41	7.5	125	0.45	7.5	–	–	–	45	0.32	6.0	–	–	–
CNMG 190612E-RM:T7325	⇕	1.2	170	0.45	7.5	130	0.41	7.5	–	–	–	–	–	–	55	0.32	6.0	–	–	–
CNMG 190612E-RM:T7335	⇕	1.2	160	0.45	7.5	120	0.41	7.5	–	–	–	–	–	–	50	0.32	6.0	–	–	–
CNMG 190612E-RM:T8415	⇕	1.2	195	0.45	7.5	100	0.41	7.5	180	0.45	7.5	–	–	–	45	0.32	6.0	–	–	–
CNMG 190612E-RM:T8430	✱	1.2	150	0.45	7.5	80	0.41	7.5	125	0.45	7.5	–	–	–	30	0.32	6.0	–	–	–
CNMG 190612E-RM:T9325	⇕	1.2	185	0.45	7.5	110	0.41	7.5	175	0.45	7.5	–	–	–	40	0.32	6.0	–	–	–
CNMG 190612E-RM:T9335	⇕	1.2	165	0.45	7.5	95	0.41	7.5	–	–	–	–	–	–	35	0.32	6.0	–	–	–
CNMG 190612E-RM:T9415	⇕	1.2	250	0.45	7.5	–	–	–	235	0.45	7.5	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM:T5305	⇕	1.6	265	0.50	7.5	–	–	–	250	0.50	7.5	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM:T6310	⇕	1.6	155	0.50	7.5	110	0.45	7.5	125	0.50	7.5	–	–	–	45	0.35	6.0	–	–	–
CNMG 190616E-RM:T7325	⇕	1.6	175	0.50	7.5	135	0.45	7.5	–	–	–	–	–	–	55	0.35	6.0	–	–	–
CNMG 190616E-RM:T7335	⇕	1.6	160	0.50	7.5	120	0.45	7.5	–	–	–	–	–	–	50	0.35	6.0	–	–	–
CNMG 190616E-RM:T8415	⇕	1.6	195	0.50	7.5	100	0.45	7.5	180	0.50	7.5	–	–	–	45	0.35	6.0	–	–	–
CNMG 190616E-RM:T8430	✱	1.6	150	0.50	7.5	80	0.45	7.5	125	0.50	7.5	–	–	–	30	0.35	6.0	–	–	–
CNMG 190616E-RM:T9315	⇕	1.6	210	0.50	7.5	–	–	–	195	0.50	7.5	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM:T9325	⇕	1.6	190	0.50	7.5	110	0.45	7.5	180	0.50	7.5	–	–	–	40	0.35	6.0	–	–	–
CNMG 190616E-RM:T9335	⇕	1.6	160	0.50	7.5	95	0.45	7.5	–	–	–	–	–	–	35	0.35	6.0	–	–	–
CNMG 190616E-RM:T9415	⇕	1.6	255	0.50	7.5	–	–	–	240	0.50	7.5	–	–	–	–	–	–	–	–	–
CNMG 250924E-RM:T7325	✱	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
CNMG 250924E-RM:T7335	✱	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
CNMG 250924E-RM:T9226	⇕	2.4	90	0.80	12.0	50	0.72	12.0	85	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
CNMG 250924E-RM:T9325	⇕	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
CNMG 250924E-RM:T9335	✱	2.4	85	0.80	12.0	50	0.72	12.0	–	–	–	–	–	–	15	0.56	9.6	–	–	–
CNMG 250924E-RM:T9415	⇕	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–



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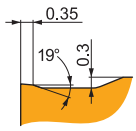
Product	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
DNMG 110408E-RM:T9325	●	0.8	170	0.40	2.0	100	0.36	2.0	160	0.40	2.0	–	–	–	35	0.28	1.6	–	–	–
DNMG 110408E-RM:T9415	●	0.8	230	0.40	2.0	–	–	–	215	0.40	2.0	–	–	–	–	–	–	–	–	–
DNMG 110412E-RM:T9325	⇕	1.2	205	0.30	2.0	120	0.27	2.0	190	0.30	2.0	–	–	–	45	0.21	1.6	–	–	–
DNMG 110412E-RM:T9415	⇕	1.2	265	0.30	2.0	–	–	–	250	0.30	2.0	–	–	–	–	–	–	–	–	–
DNMG 150408E-RM:T9325	●	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150408E-RM:T9335	⇕	0.8	140	0.40	3.0	80	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150408E-RM:T9415	●	0.8	220	0.40	3.0	–	–	–	205	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150412E-RM:T7325	⇕	1.2	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	50	0.28	2.4	–	–	–
DNMG 150412E-RM:T9325	⇕	1.2	170	0.40	3.0	100	0.36	3.0	160	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150412E-RM:T9335	⇕	1.2	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150412E-RM:T9415	⇕	1.2	230	0.40	3.0	–	–	–	215	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-RM:T5305	●	0.8	230	0.40	3.0	–	–	–	215	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-RM:T5315	●	0.8	205	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-RM:T7325	⇕	0.8	145	0.40	3.0	110	0.36	3.0	–	–	–	–	–	–	45	0.28	2.4	–	–	–
DNMG 150608E-RM:T7335	⇕	0.8	135	0.40	3.0	105	0.36	3.0	–	–	–	–	–	–	40	0.28	2.4	–	–	–
DNMG 150608E-RM:T8315	⇕	0.8	135	0.40	3.0	80	0.36	3.0	125	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
DNMG 150608E-RM:T8415	⇕	0.8	160	0.40	3.0	85	0.36	3.0	145	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150608E-RM:T8430	⇕	0.8	135	0.40	3.0	75	0.36	3.0	110	0.40	3.0	–	–	–	25	0.28	2.4	–	–	–
DNMG 150608E-RM:T9325	⇕	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150608E-RM:T9335	⇕	0.8	140	0.40	3.0	80	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150608E-RM:T9415	●	0.8	220	0.40	3.0	–	–	–	205	0.40	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。



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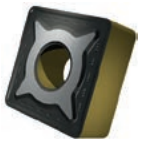
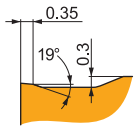
Product	●	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
DNMG 150612E-RM:T5305	●	1.2	240	0.40	3.0	–	–	–	225	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-RM:T5315	⬌	1.2	215	0.40	3.0	–	–	–	200	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-RM:T7325	⬌	1.2	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	50	0.28	2.4	–	–	–
DNMG 150612E-RM:T8430	⬌	1.2	140	0.40	3.0	75	0.36	3.0	115	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
DNMG 150612E-RM:T9325	⬌	1.2	170	0.40	3.0	100	0.36	3.0	160	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150612E-RM:T9335	⬌	1.2	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150612E-RM:T9415	⬌	1.2	230	0.40	3.0	–	–	–	215	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150616E-RM:T5315	⬌	1.6	225	0.40	3.0	–	–	–	210	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150616E-RM:T9325	⬌	1.6	180	0.40	3.0	105	0.36	3.0	170	0.40	3.0	–	–	–	40	0.28	2.4	–	–	–
DNMG 150616E-RM:T9335	⬌	1.6	155	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150616E-RM:T9415	⬌	1.6	245	0.40	3.0	–	–	–	230	0.40	3.0	–	–	–	–	–	–	–	–	–





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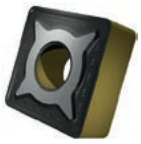
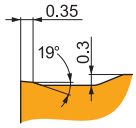
Product	●	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
SNMG 120408E-RM:T5305	⬌	0.8	290	0.40	4.0	–	–	–	275	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 120408E-RM:T6310	⬌	0.8	165	0.40	4.0	115	0.36	4.0	130	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
SNMG 120408E-RM:T7325	⬌	0.8	185	0.40	4.0	140	0.36	4.0	–	–	–	–	–	–	60	0.28	3.2	–	–	–
SNMG 120408E-RM:T7335	⬌	0.8	175	0.40	4.0	135	0.36	4.0	–	–	–	–	–	–	55	0.28	3.2	–	–	–
SNMG 120408E-RM:T8315	⬌	0.8	175	0.40	4.0	105	0.36	4.0	165	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
SNMG 120408E-RM:T8415	⬌	0.8	210	0.40	4.0	110	0.36	4.0	190	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
SNMG 120408E-RM:T8430	⬌	0.8	175	0.40	4.0	95	0.36	4.0	140	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
SNMG 120408E-RM:T9325	⬌	0.8	210	0.40	4.0	125	0.36	4.0	195	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
SNMG 120408E-RM:T9335	⬌	0.8	180	0.40	4.0	105	0.36	4.0	–	–	–	–	–	–	40	0.28	3.2	–	–	–
SNMG 120408E-RM:T9415	⬌	0.8	280	0.40	4.0	–	–	–	265	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 120412E-RM:T6310	⬌	1.2	165	0.45	4.0	115	0.41	4.0	130	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
SNMG 120412E-RM:T7325	⬌	1.2	190	0.45	4.0	145	0.41	4.0	–	–	–	–	–	–	60	0.32	3.2	–	–	–
SNMG 120412E-RM:T7335	⬌	1.2	180	0.45	4.0	140	0.41	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
SNMG 120412E-RM:T8415	⬌	1.2	215	0.45	4.0	110	0.41	4.0	195	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
SNMG 120412E-RM:T9325	⬌	1.2	210	0.45	4.0	125	0.41	4.0	195	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
SNMG 120412E-RM:T9335	⬌	1.2	185	0.45	4.0	110	0.41	4.0	–	–	–	–	–	–	40	0.32	3.2	–	–	–
SNMG 120412E-RM:T9415	⬌	1.2	280	0.45	4.0	–	–	–	265	0.45	4.0	–	–	–	–	–	–	–	–	–
SNMG 120416E-RM:T8430	✱	1.6	175	0.50	4.0	95	0.45	4.0	140	0.50	4.0	–	–	–	35	0.35	3.2	–	–	–
SNMG 120416E-RM:T9325	⬌	1.6	215	0.50	4.0	125	0.45	4.0	200	0.50	4.0	–	–	–	45	0.35	3.2	–	–	–
SNMG 120416E-RM:T9335	⬌	1.6	180	0.50	4.0	105	0.45	4.0	–	–	–	–	–	–	40	0.35	3.2	–	–	–
SNMG 120416E-RM:T9415	⬌	1.6	290	0.50	4.0	–	–	–	275	0.50	4.0	–	–	–	–	–	–	–	–	–
SNMG 150612E-RM:T6310	⬌	1.2	165	0.45	5.0	115	0.41	5.0	130	0.45	5.0	–	–	–	45	0.32	4.0	–	–	–
SNMG 150612E-RM:T7325	⬌	1.2	185	0.45	5.0	140	0.41	5.0	–	–	–	–	–	–	60	0.32	4.0	–	–	–
SNMG 150612E-RM:T8415	⬌	1.2	215	0.45	5.0	110	0.41	5.0	195	0.45	5.0	–	–	–	45	0.32	4.0	–	–	–
SNMG 150612E-RM:T9325	⬌	1.2	205	0.45	5.0	120	0.41	5.0	190	0.45	5.0	–	–	–	45	0.32	4.0	–	–	–
SNMG 150612E-RM:T9335	⬌	1.2	180	0.45	5.0	105	0.41	5.0	–	–	–	–	–	–	40	0.32	4.0	–	–	–
SNMG 150612E-RM:T9415	⬌	1.2	275	0.45	5.0	–	–	–	260	0.45	5.0	–	–	–	–	–	–	–	–	–
SNMG 150616E-RM:T7335	⬌	1.6	175	0.50	5.0	135	0.45	5.0	–	–	–	–	–	–	55	0.35	4.0	–	–	–
SNMG 150616E-RM:T9325	⬌	1.6	205	0.50	5.0	120	0.45	5.0	190	0.50	5.0	–	–	–	45	0.35	4.0	–	–	–
SNMG 150616E-RM:T9335	⬌	1.6	180	0.50	5.0	105	0.45	5.0	–	–	–	–	–	–	40	0.35	4.0	–	–	–
SNMG 150616E-RM:T9415	⬌	1.6	285	0.50	5.0	–	–	–	270	0.50	5.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM:T5305	⬌	1.2	275	0.45	7.0	–	–	–	260	0.45	7.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM:T5315	⬌	1.2	250	0.45	7.0	–	–	–	235	0.45	7.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM:T7325	⬌	1.2	180	0.45	7.0	140	0.41	7.0	–	–	–	–	–	–	55	0.32	5.6	–	–	–
SNMG 190612E-RM:T7335	⬌	1.2	165	0.45	7.0	125	0.41	7.0	–	–	–	–	–	–	50	0.32	5.6	–	–	–
SNMG 190612E-RM:T9325	⬌	1.2	195	0.45	7.0	115	0.41	7.0	185	0.45	7.0	–	–	–	40	0.32	5.6	–	–	–
SNMG 190612E-RM:T9335	⬌	1.2	175	0.45	7.0	105	0.41	7.0	–	–	–	–	–	–	35	0.32	5.6	–	–	–
SNMG 190612E-RM:T9415	⬌	1.2	270	0.45	7.0	–	–	–	255	0.45	7.0	–	–	–	–	–	–	–	–	–

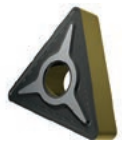
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

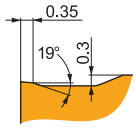




RM 断屑槽坚固耐用，是钢件粗加工的首选。具有正前角和宽的稳定T-型倒棱。还适用于不锈钢、铸铁，有条件的用于耐热合金。

Product	● ⇕ ✱	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)
SNMG 190616E-RM:T5305	⇕	1.6	285	0.50	7.0	–	–	–	270	0.50	7.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-RM:T6310	⇕	1.6	160	0.50	7.0	115	0.45	7.0	125	0.50	7.0	–	–	–	45	0.35	5.6	–	–	–
SNMG 190616E-RM:T7335	⇕	1.6	170	0.50	7.0	130	0.45	7.0	–	–	–	–	–	–	55	0.35	5.6	–	–	–
SNMG 190616E-RM:T8415	✱	1.6	210	0.50	7.0	110	0.45	7.0	190	0.50	7.0	–	–	–	45	0.35	5.6	–	–	–
SNMG 190616E-RM:T8430	✱	1.6	165	0.50	7.0	90	0.45	7.0	135	0.50	7.0	–	–	–	35	0.35	5.6	–	–	–
SNMG 190616E-RM:T9325	⇕	1.6	200	0.50	7.0	120	0.45	7.0	190	0.50	7.0	–	–	–	45	0.35	5.6	–	–	–
SNMG 190616E-RM:T9335	⇕	1.6	175	0.50	7.0	105	0.45	7.0	–	–	–	–	–	–	35	0.35	5.6	–	–	–
SNMG 190616E-RM:T9415	⇕	1.6	270	0.50	7.0	–	–	–	255	0.50	7.0	–	–	–	–	–	–	–	–	–
SNMG 250924E-RM:T7325	✱	2.4	110	0.80	12.0	85	0.72	12.0	–	–	–	–	–	–	35	0.56	9.6	–	–	–
SNMG 250924E-RM:T7335	✱	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMG 250924E-RM:T9226	⇕	2.4	95	0.80	12.0	55	0.72	12.0	90	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMG 250924E-RM:T9315	⇕	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–
SNMG 250924E-RM:T9325	⇕	2.4	110	0.80	12.0	65	0.72	12.0	100	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMG 250924E-RM:T9335	✱	2.4	90	0.80	12.0	50	0.72	12.0	–	–	–	–	–	–	20	0.56	9.6	–	–	–
SNMG 250924E-RM:T9415	⇕	2.4	130	0.80	12.0	–	–	–	120	0.80	12.0	–	–	–	–	–	–	–	–	–





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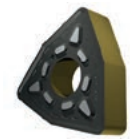
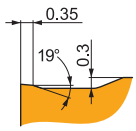
Product	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
TNMG 160408E-RM:T5305	●	0.8	245	0.40	3.0	–	–	–	230	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-RM:T5315	●	0.8	215	0.40	3.0	–	–	–	200	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-RM:T7325	⇕	0.8	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	50	0.28	2.4	–	–	–
TNMG 160408E-RM:T7335	⇕	0.8	145	0.40	3.0	110	0.36	3.0	–	–	–	–	–	–	45	0.28	2.4	–	–	–
TNMG 160408E-RM:T9325	⇕	0.8	175	0.40	3.0	105	0.36	3.0	165	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
TNMG 160408E-RM:T9335	⇕	0.8	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
TNMG 160408E-RM:T9415	●	0.8	235	0.40	3.0	–	–	–	220	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412E-RM:T5305	●	1.2	255	0.40	3.0	–	–	–	240	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412E-RM:T7335	⇕	1.2	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	50	0.28	2.4	–	–	–
TNMG 160412E-RM:T8430	⇕	1.2	150	0.40	3.0	80	0.36	3.0	125	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
TNMG 160412E-RM:T9325	⇕	1.2	185	0.40	3.0	110	0.36	3.0	175	0.40	3.0	–	–	–	40	0.28	2.4	–	–	–
TNMG 160412E-RM:T9335	⇕	1.2	160	0.40	3.0	95	0.36	3.0	–	–	–	–	–	–	35	0.28	2.4	–	–	–
TNMG 160412E-RM:T9415	⇕	1.2	245	0.40	3.0	–	–	–	230	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 220408E-RM:T7325	⇕	0.8	150	0.40	4.0	115	0.36	4.0	–	–	–	–	–	–	45	0.28	3.2	–	–	–
TNMG 220408E-RM:T9325	⇕	0.8	170	0.40	4.0	100	0.36	4.0	160	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
TNMG 220408E-RM:T9335	⇕	0.8	145	0.40	4.0	85	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
TNMG 220408E-RM:T9415	●	0.8	225	0.40	4.0	–	–	–	210	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220412E-RM:T5305	●	1.2	245	0.40	4.0	–	–	–	230	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220412E-RM:T7325	⇕	1.2	160	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
TNMG 220412E-RM:T7335	⇕	1.2	150	0.40	4.0	115	0.36	4.0	–	–	–	–	–	–	45	0.28	3.2	–	–	–
TNMG 220412E-RM:T9325	⇕	1.2	180	0.40	4.0	105	0.36	4.0	170	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
TNMG 220412E-RM:T9335	⇕	1.2	155	0.40	4.0	90	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
TNMG 220412E-RM:T9415	⇕	1.2	235	0.40	4.0	–	–	–	220	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220416E-RM:T7325	⇕	1.6	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
TNMG 220416E-RM:T9325	⇕	1.6	185	0.40	4.0	110	0.36	4.0	175	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
TNMG 220416E-RM:T9335	⇕	1.6	160	0.40	4.0	95	0.36	4.0	–	–	–	–	–	–	35	0.28	3.2	–	–	–
TNMG 220416E-RM:T9415	⇕	1.6	250	0.40	4.0	–	–	–	235	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 270612E-RM:T7325	⇕	1.2	110	0.40	6.0	85	0.36	6.0	–	–	–	–	–	–	35	0.28	4.8	–	–	–
TNMG 270612E-RM:T9325	⇕	1.2	120	0.40	6.0	70	0.36	6.0	110	0.40	6.0	–	–	–	25	0.28	4.8	–	–	–
TNMG 270616E-RM:T7325	⇕	1.6	115	0.40	6.0	85	0.36	6.0	–	–	–	–	–	–	35	0.28	4.8	–	–	–
TNMG 270616E-RM:T9325	⇕	1.6	125	0.40	6.0	75	0.36	6.0	115	0.40	6.0	–	–	–	25	0.28	4.8	–	–	–
TNMG 270616E-RM:T9335	⇕	1.6	100	0.40	6.0	60	0.36	6.0	–	–	–	–	–	–	20	0.28	4.8	–	–	–
TNMG 270616E-RM:T9415	⇕	1.6	140	0.40	6.0	–	–	–	130	0.40	6.0	–	–	–	–	–	–	–	–	–
TNMG 270624E-RM:T7325	⇕	2.4	115	0.50	6.0	85	0.45	6.0	–	–	–	–	–	–	35	0.35	4.8	–	–	–
TNMG 270624E-RM:T9325	⇕	2.4	120	0.50	6.0	70	0.45	6.0	110	0.50	6.0	–	–	–	25	0.35	4.8	–	–	–
TNMG 270624E-RM:T9335	⇕	2.4	95	0.50	6.0	55	0.45	6.0	–	–	–	–	–	–	20	0.35	4.8	–	–	–
TNMG 270632E-RM:T9335	⇕	3.2	90	0.60	6.0	50	0.54	6.0	–	–	–	–	–	–	20	0.42	4.8	–	–	–
TNMG 330924E-RM:T9226	⇕	2.4	100	0.50	10.0	60	0.45	10.0	95	0.50	10.0	–	–	–	20	0.35	8.0	–	–	–
TNMG 330924E-RM:T9335	⇕	2.4	90	0.50	10.0	50	0.45	10.0	–	–	–	–	–	–	20	0.35	8.0	–	–	–

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。





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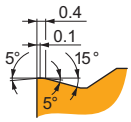
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
WNMG 060412E-RM:T9315	⁂	1.2	■ 230	0.45	3.0	–	–	–	◪ 215	0.45	3.0	–	–	–	–	–	–	–	–	–
WNMG 060412E-RM:T9325	⁂	1.2	■ 230	0.45	1.2	■ 135	0.41	1.2	◪ 215	0.45	1.2	–	–	–	◪ 50	0.32	1.0	–	–	–
WNMG 060412E-RM:T9415	⁂	1.2	■ 280	0.45	3.0	–	–	–	◪ 265	0.45	3.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM:T5305	●	0.8	◪ 275	0.40	4.0	–	–	–	■ 260	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM:T5315	⁂	0.8	◪ 250	0.40	4.0	–	–	–	■ 235	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM:T7325	⁂	0.8	◪ 180	0.40	4.0	■ 140	0.36	4.0	–	–	–	–	–	–	◪ 55	0.28	3.2	–	–	–
WNMG 080408E-RM:T7335	⁂	0.8	◪ 165	0.40	4.0	■ 125	0.36	4.0	–	–	–	–	–	–	◪ 50	0.28	3.2	–	–	–
WNMG 080408E-RM:T8315	⁂	0.8	◪ 165	0.40	4.0	■ 95	0.36	4.0	■ 155	0.40	4.0	–	–	–	◪ 40	0.28	3.2	–	–	–
WNMG 080408E-RM:T8415	⁂	0.8	■ 195	0.40	4.0	■ 100	0.36	4.0	■ 180	0.40	4.0	–	–	–	◪ 45	0.28	3.2	–	–	–
WNMG 080408E-RM:T8430	⁂	0.8	■ 165	0.40	4.0	■ 90	0.36	4.0	◪ 135	0.40	4.0	–	–	–	◪ 35	0.28	3.2	–	–	–
WNMG 080408E-RM:T9310	⁂	0.8	■ 240	0.40	4.0	–	–	–	◪ 225	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM:T9315	⁂	0.8	■ 220	0.40	4.0	–	–	–	◪ 205	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM:T9325	⁂	0.8	■ 200	0.40	4.0	■ 120	0.36	4.0	◪ 190	0.40	4.0	–	–	–	◪ 45	0.28	3.2	–	–	–
WNMG 080408E-RM:T9335	⁂	0.8	■ 170	0.40	4.0	■ 100	0.36	4.0	–	–	–	–	–	–	◪ 35	0.28	3.2	–	–	–
WNMG 080408E-RM:T9415	⁂	0.8	■ 265	0.40	4.0	–	–	–	◪ 250	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080412E-RM:T5305	⁂	1.2	◪ 280	0.45	4.0	–	–	–	■ 265	0.45	4.0	–	–	–	–	–	–	–	–	–
WNMG 080412E-RM:T5315	⁂	1.2	◪ 250	0.45	4.0	–	–	–	■ 235	0.45	4.0	–	–	–	–	–	–	–	–	–
WNMG 080412E-RM:T9325	⁂	1.2	■ 200	0.45	4.0	■ 120	0.41	4.0	◪ 190	0.45	4.0	–	–	–	◪ 45	0.32	3.2	–	–	–
WNMG 080412E-RM:T9335	⁂	1.2	■ 175	0.45	4.0	■ 105	0.41	4.0	–	–	–	–	–	–	◪ 35	0.32	3.2	–	–	–
WNMG 080412E-RM:T9415	⁂	1.2	■ 270	0.45	4.0	–	–	–	◪ 255	0.45	4.0	–	–	–	–	–	–	–	–	–
WNMG 080416E-RM:T5305	⁂	1.6	◪ 280	0.50	4.0	–	–	–	■ 265	0.50	4.0	–	–	–	–	–	–	–	–	–
WNMG 080416E-RM:T5315	⁂	1.6	◪ 255	0.50	4.0	–	–	–	■ 240	0.50	4.0	–	–	–	–	–	–	–	–	–
WNMG 080416E-RM:T8430	✱	1.6	■ 170	0.50	4.0	■ 90	0.45	4.0	◪ 135	0.50	4.0	–	–	–	◪ 35	0.35	3.2	–	–	–
WNMG 080416E-RM:T9310	⁂	1.6	■ 240	0.50	4.0	–	–	–	◪ 225	0.50	4.0	–	–	–	–	–	–	–	–	–
WNMG 080416E-RM:T9325	⁂	1.6	■ 205	0.50	4.0	■ 120	0.45	4.0	◪ 190	0.50	4.0	–	–	–	◪ 45	0.35	3.2	–	–	–
WNMG 080416E-RM:T9335	⁂	1.6	■ 175	0.50	4.0	■ 105	0.45	4.0	–	–	–	–	–	–	◪ 35	0.35	3.2	–	–	–
WNMG 080416E-RM:T9415	⁂	1.6	■ 275	0.50	4.0	–	–	–	◪ 260	0.50	4.0	–	–	–	–	–	–	–	–	–

R

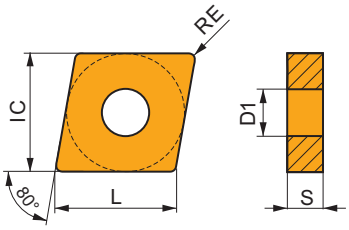


R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。

PRAMET

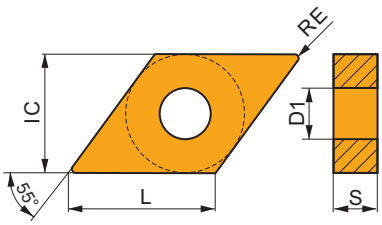
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.880	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



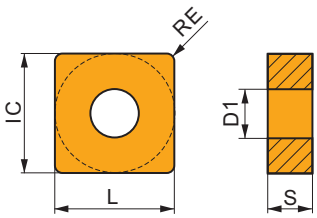
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



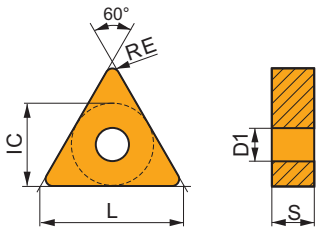
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35



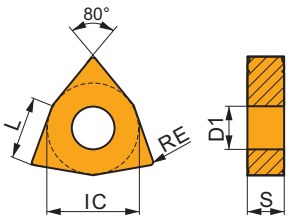
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

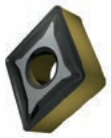
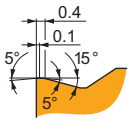
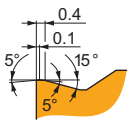
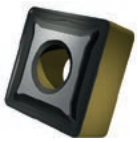
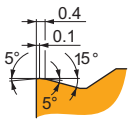


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	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/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)
 																				
R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																				
CNMG 120408E-R:6640	⚙	0.8	140	0.40	4.0	–	–	–	130	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-R:T5305	⚙	0.8	240	0.40	4.0	–	–	–	225	0.40	4.0	–	–	–	–	–	–	45	0.20	0.7
CNMG 120408E-R:T5315	⚙	0.8	215	0.40	4.0	–	–	–	200	0.40	4.0	–	–	–	–	–	–	40	0.20	0.7
CNMG 120408E-R:T9325	⚙	0.8	175	0.40	4.0	–	–	–	165	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-R:T9335	⚙	0.8	150	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-R:T9415	⚙	0.8	230	0.40	4.0	–	–	–	215	0.40	4.0	–	–	–	–	–	–	45	0.20	0.7
CNMG 120412E-R:T9325	⚙	1.2	175	0.45	4.0	–	–	–	165	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-R:T9335	✱	1.2	155	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-R:T9415	⚙	1.2	235	0.45	4.0	–	–	–	220	0.45	4.0	–	–	–	–	–	–	45	0.23	1.0
CNMG 120416E-R:T5315	⚙	1.6	225	0.50	4.0	–	–	–	210	0.50	4.0	–	–	–	–	–	–	45	0.25	1.3
CNMG 120416E-R:T9335	✱	1.6	150	0.50	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160608E-R:T5315	⚙	0.8	210	0.40	5.5	–	–	–	195	0.40	5.5	–	–	–	–	–	–	40	0.20	0.7
CNMG 160612E-R:T5315	⚙	1.2	215	0.45	5.5	–	–	–	200	0.45	5.5	–	–	–	–	–	–	40	0.23	1.0
CNMG 160612E-R:T7335	✱	1.2	145	0.45	5.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612E-R:T9315	⚙	1.2	190	0.45	5.5	–	–	–	180	0.45	5.5	–	–	–	–	–	–	35	0.23	1.0
CNMG 160612E-R:T9325	⚙	1.2	170	0.45	5.5	–	–	–	160	0.45	5.5	–	–	–	–	–	–	–	–	–
CNMG 160612E-R:T9415	⚙	1.2	230	0.45	5.5	–	–	–	215	0.45	5.5	–	–	–	–	–	–	45	0.23	1.0
CNMG 190612E-R:6630	✱	1.2	150	0.45	7.0	–	–	–	140	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:6640	✱	1.2	135	0.45	7.0	–	–	–	125	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T5315	⚙	1.2	210	0.45	7.0	–	–	–	195	0.45	7.0	–	–	–	–	–	–	40	0.23	1.0
CNMG 190612E-R:T9325	⚙	1.2	165	0.45	7.0	–	–	–	155	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T9335	✱	1.2	145	0.45	7.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T9415	⚙	1.2	225	0.45	7.0	–	–	–	210	0.45	7.0	–	–	–	–	–	–	45	0.23	1.0
CNMG 190616E-R:6630	✱	1.6	150	0.50	7.0	–	–	–	140	0.50	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:6640	✱	1.6	130	0.50	7.0	–	–	–	120	0.50	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:T5315	⚙	1.6	210	0.50	7.0	–	–	–	195	0.50	7.0	–	–	–	–	–	–	40	0.25	1.3
CNMG 190616E-R:T9315	⚙	1.6	180	0.50	7.0	–	–	–	170	0.50	7.0	–	–	–	–	–	–	35	0.25	1.3
CNMG 190616E-R:T9325	✱	1.6	165	0.50	7.0	–	–	–	155	0.50	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:T9335	✱	1.6	145	0.50	7.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:T9415	⚙	1.6	225	0.50	7.0	–	–	–	210	0.50	7.0	–	–	–	–	–	–	45	0.25	1.3
																				
R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																				
DNMG 150408E-R:T5315	●	0.8	175	0.40	3.0	–	–	–	165	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
DNMG 150608E-R:T5305	●	0.8	200	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
DNMG 150608E-R:T5315	⚙	0.8	175	0.40	3.0	–	–	–	165	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
DNMG 150608E-R:T9325	⚙	0.8	140	0.40	3.0	–	–	–	130	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-R:T9415	⚙	0.8	190	0.40	3.0	–	–	–	180	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
DNMG 150612E-R:T5315	⚙	1.2	185	0.40	3.0	–	–	–	175	0.40	3.0	–	–	–	–	–	–	35	0.20	0.9
DNMG 150612E-R:T9325	⚙	1.2	150	0.40	3.0	–	–	–	140	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-R:T9415	⚙	1.2	200	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.9
DNMG 150616E-R:T9325	⚙	1.6	155	0.40	3.0	–	–	–	145	0.40	3.0	–	–	–	–	–	–	–	–	–
 																				
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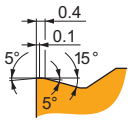
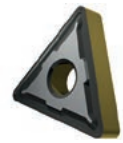
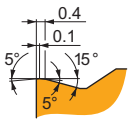
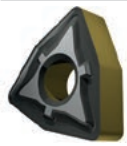
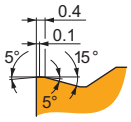
SNMG 120408E-R:6640	⚙	0.8	145	0.40	3.8	–	–	–	135	0.40	3.8	–	–	–	–	–	–	–	–	–
SNMG 120408E-R:T5305	⚙	0.8	250	0.40	3.8	–	–	–	235	0.40	3.8	–	–	–	–	–	–	50	0.20	0.7
SNMG 120408E-R:T9325	⚙	0.8	180	0.40	3.8	–	–	–	170	0.40	3.8	–	–	–	–	–	–	–	–	–
SNMG 120408E-R:T9335	⚙	0.8	155	0.40	3.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120412E-R:T9325	⚙	1.2	180	0.45	3.8	–	–	–	170	0.45	3.8	–	–	–	–	–	–	–	–	–
SNMG 120412E-R:T9335	✱	1.2	160	0.45	3.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120416E-R:T9325	✱	1.6	185	0.50	3.8	–	–	–	175	0.50	3.8	–	–	–	–	–	–	–	–	–
SNMG 120416E-R:T9415	⚙	1.6	250	0.50	3.8	–	–	–	235	0.50	3.8	–	–	–	–	–	–	50	0.25	1.3

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/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)
																				
R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																				
SNMG 150612E-R:T5315		1.2	230	0.45	4.5	–	–	–	215	0.45	4.5	–	–	–	–	–	–	45	0.23	1.0
SNMG 150612E-R:T9325		1.2	180	0.45	4.5	–	–	–	170	0.45	4.5	–	–	–	–	–	–	–	–	–
SNMG 150612E-R:T9415		1.2	245	0.45	4.5	–	–	–	230	0.45	4.5	–	–	–	–	–	–	45	0.23	1.0
SNMG 150616E-R:T5315		1.6	230	0.50	4.5	–	–	–	215	0.50	4.5	–	–	–	–	–	–	45	0.25	1.3
SNMG 150616E-R:T9325		1.6	180	0.50	4.5	–	–	–	170	0.50	4.5	–	–	–	–	–	–	–	–	–
SNMG 190612E-R:6630		1.2	160	0.45	6.0	–	–	–	150	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-R:6640		1.2	140	0.45	6.0	–	–	–	130	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-R:T9325		1.2	175	0.45	6.0	–	–	–	165	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:6630		1.6	165	0.50	6.0	–	–	–	155	0.50	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:T9325		1.6	175	0.50	6.0	–	–	–	165	0.50	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:T9335		1.6	150	0.50	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:T9415		1.6	240	0.50	6.0	–	–	–	225	0.50	6.0	–	–	–	–	–	–	45	0.25	1.3
 																				
R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																				
TNMG 160408E-R:T5305		0.8	210	0.40	3.0	–	–	–	195	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
TNMG 160408E-R:T5315		0.8	185	0.40	3.0	–	–	–	175	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
TNMG 160408E-R:T9325		0.8	150	0.40	3.0	–	–	–	140	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-R:T9335		0.8	130	0.40	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160408E-R:T9415		0.8	205	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
TNMG 160412E-R:T5315		1.2	195	0.40	3.0	–	–	–	185	0.40	3.0	–	–	–	–	–	–	35	0.20	0.9
TNMG 160412E-R:T9325		1.2	160	0.40	3.0	–	–	–	150	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412E-R:T9335		1.2	140	0.40	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-R:T9415		1.2	215	0.40	3.0	–	–	–	200	0.40	3.0	–	–	–	–	–	–	40	0.20	0.9
TNMG 220408E-R:T9325		0.8	145	0.40	4.0	–	–	–	135	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220408E-R:T9335		0.8	125	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-R:T9415		0.8	195	0.40	4.0	–	–	–	185	0.40	4.0	–	–	–	–	–	–	35	0.20	0.7
TNMG 220412E-R:T9325		1.2	155	0.40	4.0	–	–	–	145	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220412E-R:T9415		1.2	205	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.20	0.9
TNMG 220416E-R:T9325		1.6	165	0.40	4.0	–	–	–	155	0.40	4.0	–	–	–	–	–	–	–	–	–
 																				
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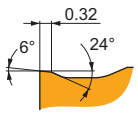
WNMG 080408E-R:T5305		0.8	245	0.40	3.5	–	–	–	230	0.40	3.5	–	–	–	–	–	–	45	0.20	0.7
WNMG 080408E-R:T5315		0.8	220	0.40	3.5	–	–	–	205	0.40	3.5	–	–	–	–	–	–	40	0.20	0.7
WNMG 080408E-R:T9310		0.8	210	0.40	3.5	–	–	–	195	0.40	3.5	–	–	–	–	–	–	40	0.20	0.7
WNMG 080408E-R:T9325		0.8	175	0.40	3.5	–	–	–	165	0.40	3.5	–	–	–	–	–	–	–	–	–
WNMG 080408E-R:T9335		0.8	155	0.40	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-R:T9415		0.8	235	0.40	3.5	–	–	–	220	0.40	3.5	–	–	–	–	–	–	45	0.20	0.7
WNMG 080412E-R:T5305		1.2	250	0.45	3.5	–	–	–	235	0.45	3.5	–	–	–	–	–	–	50	0.23	1.0
WNMG 080412E-R:T5315		1.2	225	0.45	3.5	–	–	–	210	0.45	3.5	–	–	–	–	–	–	45	0.23	1.0
WNMG 080412E-R:T9310		1.2	215	0.45	3.5	–	–	–	200	0.45	3.5	–	–	–	–	–	–	40	0.23	1.0
WNMG 080412E-R:T9325		1.2	180	0.45	3.5	–	–	–	170	0.45	3.5	–	–	–	–	–	–	–	–	–
WNMG 080412E-R:T9335		1.2	155	0.45	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-R:T9415		1.2	240	0.45	3.5	–	–	–	225	0.45	3.5	–	–	–	–	–	–	45	0.23	1.0

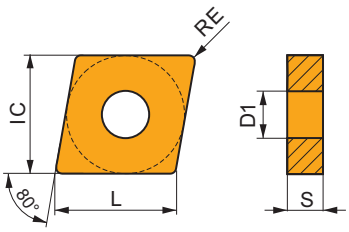
NRM



NRM 型断屑槽用途广泛，是不锈钢粗加工的首选。它具有正前角和稳定、宽大的 T 倒棱。它还适用于钢和超级合金。

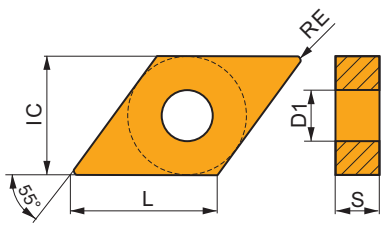
CNMG / CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



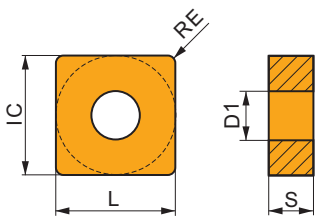
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



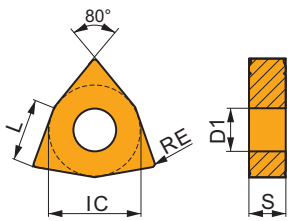
SNMG / SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53

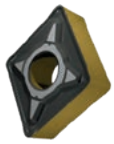
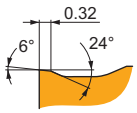


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	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/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)
 																				
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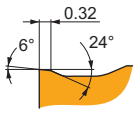
CNMG 120408-NRM:T7325		0.8	160	0.35	4.0	120	0.32	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 120408-NRM:T8430		0.8	150	0.35	4.0	80	0.32	4.0	–	–	–	–	–	–	30	0.25	3.2	–	–	–
CNMG 120408-NRM:T9415		0.8	245	0.35	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412-NRM:T7325		1.2	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 120412-NRM:T8430		1.2	150	0.40	4.0	80	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
CNMG 120412-NRM:T9415		1.2	245	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160608-NRM:T7325		0.8	155	0.35	6.0	120	0.32	6.0	–	–	–	–	–	–	50	0.28	4.8	–	–	–
CNMG 160608-NRM:T9415		0.8	235	0.35	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612-NRM:T7325		1.2	155	0.40	6.0	120	0.36	6.0	–	–	–	–	–	–	50	0.32	4.8	–	–	–
CNMG 160612-NRM:T7335		1.2	150	0.40	6.0	115	0.36	6.0	–	–	–	–	–	–	45	0.32	4.8	–	–	–
CNMG 160612-NRM:T9415		1.2	235	0.40	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160616-NRM:T7325		1.6	155	0.45	6.0	120	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
CNMG 160616-NRM:T7335		1.6	150	0.45	6.0	115	0.41	6.0	–	–	–	–	–	–	45	0.36	4.8	–	–	–
CNMG 160616-NRM:T8430		1.6	145	0.45	6.0	80	0.41	6.0	–	–	–	–	–	–	30	0.32	4.8	–	–	–
CNMG 160616-NRM:T9415		1.6	240	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612-NRM:T7325		1.2	155	0.40	8.0	120	0.36	8.0	–	–	–	–	–	–	50	0.32	6.4	–	–	–
CNMG 190612-NRM:T8430		1.2	140	0.40	8.0	75	0.36	8.0	–	–	–	–	–	–	30	0.28	6.4	–	–	–
CNMG 190612-NRM:T9415		1.2	230	0.40	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190616-NRM:T7325		1.6	150	0.45	8.0	115	0.41	8.0	–	–	–	–	–	–	45	0.36	6.4	–	–	–
CNMG 190616-NRM:T7335		1.6	145	0.45	8.0	110	0.41	8.0	–	–	–	–	–	–	45	0.36	6.4	–	–	–
CNMG 190616-NRM:T8430		1.6	140	0.45	8.0	75	0.41	8.0	–	–	–	–	–	–	30	0.32	6.4	–	–	–
CNMG 190616-NRM:T9415		1.6	230	0.45	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 250924-NRM:T7325		2.4	95	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	30	0.49	8.0	–	–	–
CNMG 250924-NRM:T7335		2.4	90	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	25	0.49	8.0	–	–	–
																				
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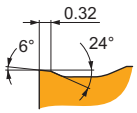
CNMM 250924-NRM:T7325		2.4	95	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	30	0.49	8.0	–	–	–
CNMM 250924-NRM:T7335		2.4	90	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	25	0.49	8.0	–	–	–
																				
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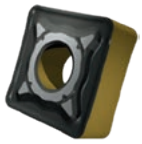
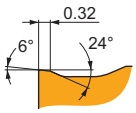
DNMG 150608-NRM:T7335		0.8	130	0.30	3.0	100	0.27	3.0	–	–	–	–	–	–	40	0.24	2.4	–	–	–
DNMG 150608-NRM:T9415		0.8	210	0.30	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

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。





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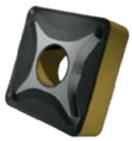
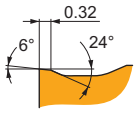
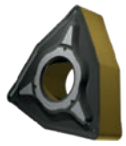
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
SNMG 120408-NRM:T7325	0.8	175	0.35	2.6	135	0.32	2.6	–	–	–	–	–	–	55	0.28	2.1	–	–	–
SNMG 120412-NRM:T8430	1.2	165	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	35	0.28	2.4	–	–	–
SNMG 120412-NRM:T9415	1.2	265	0.40	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 150612-NRM:T7325	1.2	170	0.40	4.0	130	0.36	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
SNMG 150616-NRM:T7325	1.6	170	0.45	5.0	130	0.41	5.0	–	–	–	–	–	–	55	0.36	4.0	–	–	–
SNMG 150616-NRM:T8430	1.6	150	0.45	5.0	80	0.41	5.0	–	–	–	–	–	–	30	0.32	4.0	–	–	–
SNMG 150616-NRM:T9415	1.6	250	0.45	5.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 250924-NRM:T7325	2.4	105	0.70	9.0	80	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
SNMG 250924-NRM:T9415	2.4	125	0.70	9.0	–	–	–	115	0.70	9.0	–	–	–	–	–	–	–	–	–

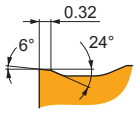




NRM 型断屑槽用途广泛，是不锈钢粗加工的首选。它具有正前角和稳定、宽大的 T 倒棱。它还适用于钢和超级合金。

Product	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)
SNMM 250716-NRM:T9415	1.6	140	0.45	9.0	–	–	–	130	0.45	9.0	–	–	–	–	–	–	–	–	–
SNMM 250724-NRM:T9415	2.4	130	0.65	9.0	–	–	–	120	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 250924-NRM:T7325	2.4	105	0.70	9.0	80	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
SNMM 250924-NRM:T7335	2.4	95	0.70	9.0	70	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
SNMM 250924-NRM:T8430	2.4	130	0.70	9.0	70	0.63	9.0	105	0.70	9.0	–	–	–	25	0.49	7.2	–	–	–

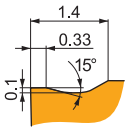




NRM 型断屑槽用途广泛，是不锈钢粗加工的首选。它具有正前角和稳定、宽大的 T 倒棱。它还适用于钢和超级合金。

Product	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)
WNMG 080408-NRM:T7325	0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
WNMG 080408-NRM:T7335	0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
WNMG 080408-NRM:T9415	0.8	255	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412-NRM:T7325	1.2	170	0.40	2.7	130	0.36	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
WNMG 080412-NRM:T8430	1.2	155	0.40	2.7	85	0.36	2.7	–	–	–	–	–	–	30	0.28	2.2	–	–	–
WNMG 080412-NRM:T9315	1.2	215	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412-NRM:T9415	1.2	255	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

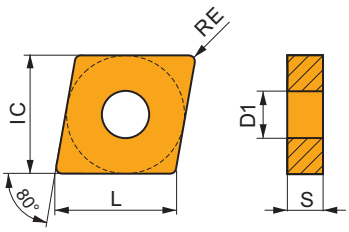
KR



KR 型断屑槽坚固耐用，是铸铁粗加工的首选。它的特点是略带正前角和宽 T 倒棱。它还适用于钢材，有条件时也适用于硬质材料。

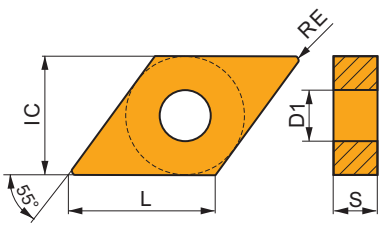
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



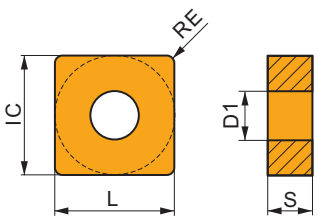
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



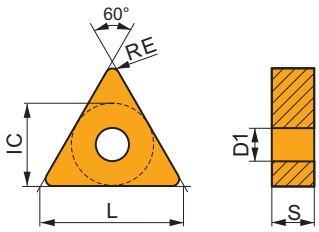
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



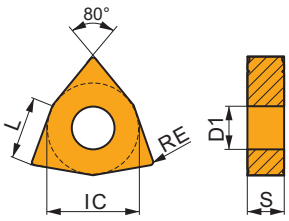
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76

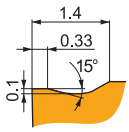
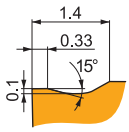
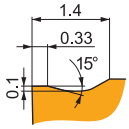
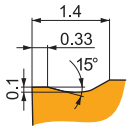


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	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/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)
																				
KR 型断屑槽坚固耐用，是铸铁粗加工的首选。它的特点是略带正前角和宽 T 倒棱。它还适用于钢材，有条件时也适用于硬质材料。																				
CNMG 120408E-KR:T5305	●	0.8	255	0.35	4.0	–	–	–	240	0.35	4.0	–	–	–	–	–	–	50	0.18	0.7
CNMG 120408E-KR:T5315	⬌	0.8	225	0.35	4.0	–	–	–	210	0.35	4.0	–	–	–	–	–	–	45	0.18	0.7
CNMG 120412E-KR:T5305	⬌	1.2	255	0.40	4.0	–	–	–	240	0.40	4.0	–	–	–	–	–	–	50	0.20	1.0
CNMG 120412E-KR:T5315	⬌	1.2	230	0.40	4.0	–	–	–	215	0.40	4.0	–	–	–	–	–	–	45	0.20	1.0
CNMG 120416E-KR:T5315	⬌	1.6	230	0.45	4.0	–	–	–	215	0.45	4.0	–	–	–	–	–	–	45	0.32	0.8
CNMG 160612E-KR:T5315	⬌	1.2	230	0.45	4.5	–	–	–	215	0.45	4.5	–	–	–	–	–	–	45	0.32	0.8
CNMG 160616E-KR:T5315	⬌	1.6	230	0.50	4.5	–	–	–	215	0.50	4.5	–	–	–	–	–	–	45	0.35	0.8
CNMG 190612E-KR:T5315	⬌	1.2	220	0.45	7.0	–	–	–	205	0.45	7.0	–	–	–	–	–	–	40	0.32	0.8
CNMG 190616E-KR:T5315	⬌	1.6	220	0.50	7.0	–	–	–	205	0.50	7.0	–	–	–	–	–	–	40	0.35	0.8
																				
KR 型断屑槽坚固耐用，是铸铁粗加工的首选。它的特点是略带正前角和宽 T 倒棱。它还适用于钢材，有条件时也适用于硬质材料。																				
DNMG 150608E-KR:T5315	●	0.8	195	0.35	3.0	–	–	–	185	0.35	3.0	–	–	–	–	–	–	35	0.25	0.8
DNMG 150612E-KR:T5315	●	1.2	195	0.40	3.0	–	–	–	185	0.40	3.0	–	–	–	–	–	–	35	0.28	0.8
																				
KR 型断屑槽坚固耐用，是铸铁粗加工的首选。它的特点是略带正前角和宽 T 倒棱。它还适用于钢材，有条件时也适用于硬质材料。																				
SNMG 120408E-KR:T5305	⬌	0.8	265	0.35	3.8	–	–	–	250	0.35	3.8	–	–	–	–	–	–	50	0.18	0.7
SNMG 120408E-KR:T5315	⬌	0.8	235	0.35	3.8	–	–	–	220	0.35	3.8	–	–	–	–	–	–	45	0.18	0.7
SNMG 120412E-KR:T5315	⬌	1.2	240	0.40	3.8	–	–	–	225	0.40	3.8	–	–	–	–	–	–	45	0.20	1.0
SNMG 120416E-KR:T5315	⬌	1.6	260	0.45	3.8	–	–	–	245	0.45	3.8	–	–	–	–	–	–	50	0.32	0.8
SNMG 150612E-KR:T5315	⬌	1.2	240	0.45	4.5	–	–	–	225	0.45	4.5	–	–	–	–	–	–	45	0.32	0.8
SNMG 150616E-KR:T5315	⬌	1.6	240	0.50	4.5	–	–	–	225	0.50	4.5	–	–	–	–	–	–	45	0.35	0.8
SNMG 190616E-KR:T5315	⬌	1.6	230	0.50	7.0	–	–	–	215	0.50	7.0	–	–	–	–	–	–	45	0.35	0.8
																				
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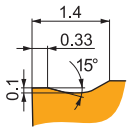
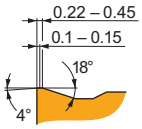
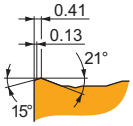
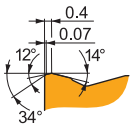
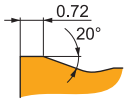
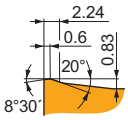
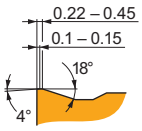
TNMG 160408E-KR:T5305	●	0.8	220	0.35	3.0	–	–	–	205	0.35	3.0	–	–	–	–	–	–	40	0.18	0.7
TNMG 160408E-KR:T5315	●	0.8	200	0.35	3.0	–	–	–	190	0.35	3.0	–	–	–	–	–	–	40	0.18	0.7
TNMG 220408E-KR:T5315	●	0.8	200	0.35	4.0	–	–	–	190	0.35	4.0	–	–	–	–	–	–	40	0.25	0.8
TNMG 220412E-KR:T5315	●	1.2	205	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.28	0.8
																				
KR 型断屑槽坚固耐用，是铸铁粗加工的首选。它的特点是略带正前角和宽 T 倒棱。它还适用于钢材，有条件时也适用于硬质材料。																				
WNMG 080408E-KR:T5305	●	0.8	255	0.35	3.5	–	–	–	240	0.35	3.5	–	–	–	–	–	–	50	0.18	0.7
WNMG 080408E-KR:T5315	⬌	0.8	230	0.35	3.5	–	–	–	215	0.35	3.5	–	–	–	–	–	–	45	0.18	0.7
WNMG 080412E-KR:T5315	⬌	1.2	235	0.40	3.5	–	–	–	220	0.40	3.5	–	–	–	–	–	–	45	0.20	1.0

OR		P	OR 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于铸铁，并有条件地适用于不锈钢和超级合金。
NR2		P	NR2 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于粗加工至重载粗加工，连续切削至间断切削。它还适用于钢材，并有条件地适用于铸铁和超级合金。
HR		P	HR 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。
HR2		S	HR2 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。
923		S	923 型断屑槽坚固耐用，专为重型不锈钢粗加工而设计。适用于中粗加工至重载粗加工，连续至重断续切削。它也有条件地适用于钢和铸铁。

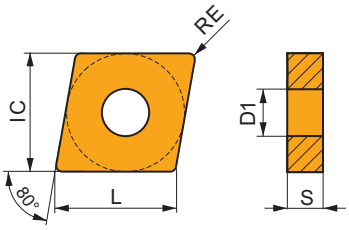
OR



OR 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于铸铁，并有条件地适用于不锈钢和超级合金。

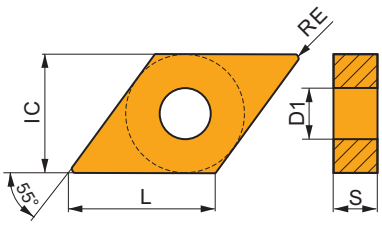
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



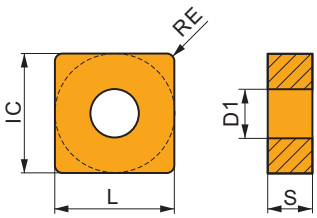
DNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



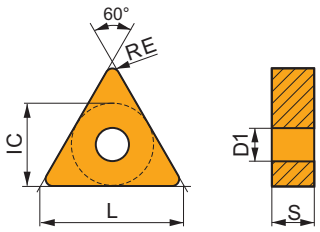
SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



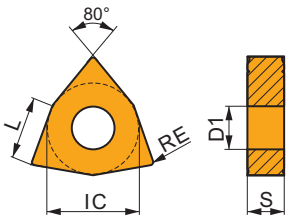
TNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

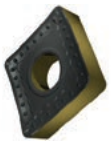


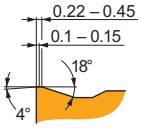
WNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76
1306	19.050	7.94	13.00	6.35



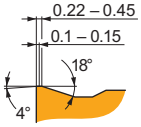
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。





OR 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于铸铁，并有条件地适用于不锈钢和超级合金。

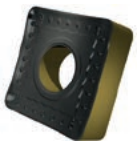
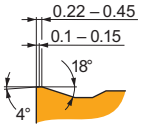
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CNMM 120408E-OR:T8430	✱	0.8	150	0.40	5.0	80	0.36	5.0	125	0.40	5.0	–	–	–	30	0.28	4.0	–	–	–
CNMM 120408E-OR:T9325	●	0.8	185	0.40	5.0	110	0.36	5.0	175	0.40	5.0	–	–	–	40	0.28	4.0	–	–	–
CNMM 120408E-OR:T9335	●	0.8	160	0.40	5.0	95	0.36	5.0	–	–	–	–	–	–	35	0.28	4.0	–	–	–
CNMM 120408E-OR:T9415	●	0.8	250	0.40	5.0	–	–	–	235	0.40	5.0	–	–	–	–	–	–	–	–	–
CNMM 120412E-OR:T9325	✱	1.2	185	0.45	5.0	110	0.41	5.0	175	0.45	5.0	–	–	–	40	0.36	4.0	–	–	–
CNMM 120412E-OR:T9335	✱	1.2	165	0.45	5.0	95	0.41	5.0	–	–	–	–	–	–	35	0.36	4.0	–	–	–
CNMM 120412E-OR:T9415	●	1.2	250	0.45	5.0	–	–	–	235	0.45	5.0	–	–	–	–	–	–	–	–	–
CNMM 120416E-OR:T9325	✱	1.6	190	0.50	5.0	110	0.45	5.0	180	0.50	5.0	–	–	–	40	0.40	4.0	–	–	–
CNMM 160608E-OR:T9325	●	0.8	180	0.40	6.0	105	0.36	6.0	170	0.40	6.0	–	–	–	40	0.32	4.8	–	–	–
CNMM 160608E-OR:T9415	●	0.8	245	0.40	6.0	–	–	–	230	0.40	6.0	–	–	–	–	–	–	–	–	–
CNMM 160612E-OR:T8430	✱	1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	–	–	–	30	0.36	4.8	–	–	–
CNMM 160612E-OR:T9325	✱	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
CNMM 160612E-OR:T9415	●	1.2	250	0.45	6.0	–	–	–	235	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMM 160616E-OR:T9325	✱	1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
CNMM 160616E-OR:T9415	●	1.6	250	0.50	6.0	–	–	–	235	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMM 190612E-OR:T8430	✱	1.2	140	0.45	9.0	75	0.41	9.0	115	0.45	9.0	–	–	–	30	0.36	7.2	–	–	–
CNMM 190612E-OR:T9325	✱	1.2	175	0.45	9.0	105	0.41	9.0	165	0.45	9.0	–	–	–	35	0.36	7.2	–	–	–
CNMM 190612E-OR:T9335	✱	1.2	150	0.45	9.0	90	0.41	9.0	–	–	–	–	–	–	30	0.36	7.2	–	–	–
CNMM 190612E-OR:T9415	●	1.2	240	0.45	9.0	–	–	–	225	0.45	9.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-OR:6630	✱	1.6	160	0.50	9.0	95	0.45	9.0	150	0.50	9.0	–	–	–	40	0.40	7.2	–	–	–
CNMM 190616E-OR:T8430	✱	1.6	140	0.50	9.0	75	0.45	9.0	115	0.50	9.0	–	–	–	30	0.40	7.2	–	–	–
CNMM 190616E-OR:T9325	✱	1.6	175	0.50	9.0	105	0.45	9.0	165	0.50	9.0	–	–	–	35	0.40	7.2	–	–	–
CNMM 190616E-OR:T9335	✱	1.6	155	0.50	9.0	90	0.45	9.0	–	–	–	–	–	–	30	0.40	7.2	–	–	–
CNMM 190616E-OR:T9415	●	1.6	240	0.50	9.0	–	–	–	225	0.50	9.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-OR:T9315	✱	2.4	165	0.80	9.0	–	–	–	155	0.80	9.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-OR:T9325	✱	2.4	150	0.80	9.0	90	0.72	9.0	140	0.80	9.0	–	–	–	30	0.56	7.2	–	–	–
CNMM 190624E-OR:T9415	✱	2.4	215	0.80	9.0	–	–	–	200	0.80	9.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-OR:6630	✱	2.4	80	1.00	12.0	45	0.90	12.0	75	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
CNMM 250924E-OR:T8430	✱	2.4	75	1.00	12.0	40	0.90	12.0	60	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
CNMM 250924E-OR:T9325	✱	2.4	95	1.00	12.0	55	0.90	12.0	90	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
CNMM 250924E-OR:T9335	✱	2.4	75	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
CNMM 250924E-OR:T9415	✱	2.4	110	1.00	12.0	–	–	–	100	1.00	12.0	–	–	–	–	–	–	–	–	–



OR 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于铸铁，并有条件地适用于不锈钢和超级合金。

DNMM 150608E-OR:T9325	●	0.8	155	0.40	3.0	90	0.36	3.0	145	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
DNMM 150612E-OR:T9325	●	1.2	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.32	2.4	–	–	–
DNMM 150612E-OR:T9335	●	1.2	145	0.40	3.0	85	0.36	3.0	–	–	–	–	–	–	30	0.32	2.4	–	–	–
DNMM 150612E-OR:T9415	●	1.2	220	0.40	3.0	–	–	–	205	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMM 150616E-OR:T9325	●	1.6	165	0.45	3.0	95	0.41	3.0	155	0.45	3.0	–	–	–	35	0.41	2.4	–	–	–

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/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)
 																				
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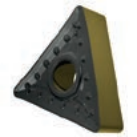
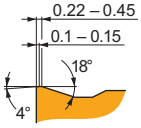
SNMM 120408E-OR:T9325		0.8	195	0.40	4.7	115	0.36	4.7	185	0.40	4.7	–	–	–	40	0.32	3.8	–	–	–
SNMM 120408E-OR:T9335		0.8	175	0.40	4.7	105	0.36	4.7	–	–	–	–	–	–	35	0.32	3.8	–	–	–
SNMM 120408E-OR:T9415		0.8	265	0.40	4.7	–	–	–	250	0.40	4.7	–	–	–	–	–	–	–	–	–
SNMM 120412E-OR:T9325		1.2	200	0.45	4.7	120	0.41	4.7	190	0.45	4.7	–	–	–	45	0.36	3.8	–	–	–
SNMM 120412E-OR:T9415		1.2	270	0.45	4.7	–	–	–	255	0.45	4.7	–	–	–	–	–	–	–	–	–
SNMM 120416E-OR:T9325		1.6	200	0.50	4.7	120	0.45	4.7	190	0.50	4.7	–	–	–	45	0.40	3.8	–	–	–
SNMM 150608E-OR:T9325		0.8	190	0.40	6.0	110	0.36	6.0	180	0.40	6.0	–	–	–	40	0.36	4.8	–	–	–
SNMM 150612E-OR:T9325		1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
SNMM 150616E-OR:T9325		1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
SNMM 150616E-OR:T9415		1.6	265	0.50	6.0	–	–	–	250	0.50	6.0	–	–	–	–	–	–	–	–	–
SNMM 190612E-OR:T8430		1.2	150	0.45	8.0	80	0.41	8.0	125	0.45	8.0	–	–	–	30	0.36	6.4	–	–	–
SNMM 190612E-OR:T9325		1.2	190	0.45	8.0	110	0.41	8.0	180	0.45	8.0	–	–	–	40	0.36	6.4	–	–	–
SNMM 190612E-OR:T9335		1.2	165	0.45	8.0	95	0.41	8.0	–	–	–	–	–	–	35	0.36	6.4	–	–	–
SNMM 190612E-OR:T9415		1.2	250	0.45	8.0	–	–	–	235	0.45	8.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-OR:6630		1.6	175	0.50	8.0	105	0.45	8.0	165	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190616E-OR:T8345		1.6	125	0.50	8.0	75	0.45	8.0	115	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
SNMM 190616E-OR:T8430		1.6	155	0.50	8.0	85	0.45	8.0	130	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
SNMM 190616E-OR:T9325		1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190616E-OR:T9335		1.6	160	0.50	8.0	95	0.45	8.0	–	–	–	–	–	–	35	0.40	6.4	–	–	–
SNMM 190616E-OR:T9415		1.6	260	0.50	8.0	–	–	–	245	0.50	8.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-OR:T9325		2.4	165	0.80	8.0	95	0.72	8.0	155	0.80	8.0	–	–	–	35	0.56	6.4	–	–	–
SNMM 190624E-OR:T9415		2.4	225	0.80	8.0	–	–	–	210	0.80	8.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-OR:T9226		1.6	115	0.50	12.0	65	0.45	12.0	105	0.50	12.0	–	–	–	20	0.45	9.6	–	–	–
SNMM 250716E-OR:T9325		1.6	120	0.55	12.0	70	0.50	12.0	110	0.55	12.0	–	–	–	25	0.50	9.6	–	–	–
SNMM 250724E-OR:T8345		2.4	55	1.00	12.0	30	0.90	12.0	50	1.00	12.0	–	–	–	10	0.70	9.6	–	–	–
SNMM 250724E-OR:T8430		2.4	80	1.00	12.0	45	0.90	12.0	65	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
SNMM 250724E-OR:T9325		2.4	100	1.00	12.0	60	0.90	12.0	95	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
SNMM 250724E-OR:T9335		2.4	80	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
SNMM 250724E-OR:T9415		2.4	120	1.00	12.0	–	–	–	110	1.00	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-OR:T8430		2.4	80	1.00	12.0	45	0.90	12.0	65	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
SNMM 250924E-OR:T9325		2.4	100	1.00	12.0	60	0.90	12.0	95	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
SNMM 250924E-OR:T9335		2.4	80	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
SNMM 250924E-OR:T9415		2.4	120	1.00	12.0	–	–	–	110	1.00	12.0	–	–	–	–	–	–	–	–	–
 																				
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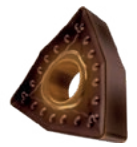
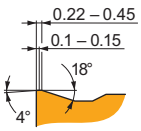
TNMM 160408E-OR:T9325		0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
TNMM 160408E-OR:T9415		0.8	225	0.40	3.0	–	–	–	210	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMM 220408E-OR:T9325		0.8	160	0.40	4.0	95	0.36	4.0	150	0.40	4.0	–	–	–	35	0.32	3.2	–	–	–
TNMM 220408E-OR:T9335		0.8	140	0.40	4.0	80	0.36	4.0	–	–	–	–	–	–	30	0.32	3.2	–	–	–
TNMM 220412E-OR:T9325		1.2	175	0.40	3.0	105	0.36	3.0	165	0.40	3.0	–	–	–	35	0.32	2.4	–	–	–
TNMM 220412E-OR:T9335		1.2	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.32	2.4	–	–	–
 																				
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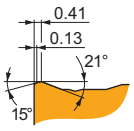
WNMM 080408E-OR:T8430		0.8	155	0.40	4.0	85	0.36	4.0	130	0.40	4.0	–	–	–	30	0.28	3.2	–	–	–
WNMM 080408E-OR:T9325		0.8	190	0.40	4.0	110	0.36	4.0	180	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
WNMM 080408E-OR:T9335		0.8	165	0.40	4.0	95	0.36	4.0	–	–	–	–	–	–	35	0.28	3.2	–	–	–
WNMM 080412E-OR:T9325		1.2	190	0.45	4.0	110	0.41	4.0	180	0.45	4.0	–	–	–	40	0.36	3.2	–	–	–
WNMM 080416E-OR:T9325		1.6	195	0.50	4.0	115	0.45	4.0	185	0.50	4.0	–	–	–	40	0.40	3.2	–	–	–
WNMM 130612E-OR:T9325		1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
WNMM 130616E-OR:T9325		1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–

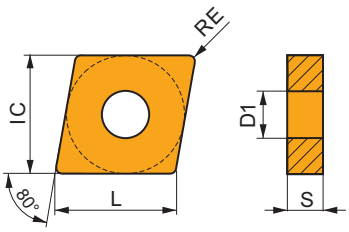
NR2



NR2 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于粗加工至重载粗加工，连续切削至间断切削。它还适用于钢材，并有条件地适用于铸铁和超级合金。

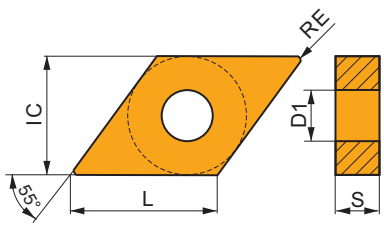
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



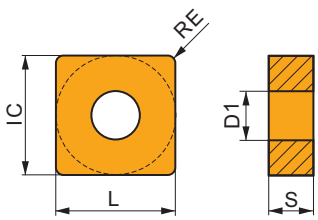
DNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



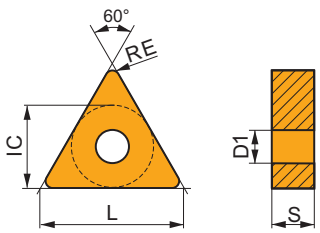
SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



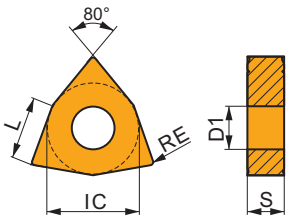
TNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

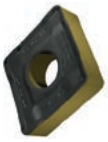


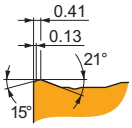
WNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	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。





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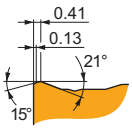
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CNMM 120408E-NR2:T7325		0.8	165	0.40	5.0	125	0.36	5.0	–	–	–	–	–	–	50	0.28	4.0	–	–	–
CNMM 120408E-NR2:T7335		0.8	155	0.40	5.0	120	0.36	5.0	–	–	–	–	–	–	50	0.28	4.0	–	–	–
CNMM 120408E-NR2:T8430		0.8	150	0.40	5.0	80	0.36	5.0	125	0.40	5.0	–	–	–	30	0.28	4.0	–	–	–
CNMM 120408E-NR2:T9325		0.8	185	0.40	5.0	110	0.36	5.0	175	0.40	5.0	–	–	–	40	0.28	4.0	–	–	–
CNMM 120408E-NR2:T9415		0.8	250	0.40	5.0	–	–	–	235	0.40	5.0	–	–	–	–	–	–	–	–	–
CNMM 120412E-NR2:T7335		1.2	155	0.45	5.0	120	0.41	5.0	–	–	–	–	–	–	50	0.32	4.0	–	–	–
CNMM 120412E-NR2:T8430		1.2	150	0.45	5.0	80	0.41	5.0	125	0.45	5.0	–	–	–	30	0.32	4.0	–	–	–
CNMM 120412E-NR2:T9325		1.2	185	0.45	5.0	110	0.41	5.0	175	0.45	5.0	–	–	–	40	0.32	4.0	–	–	–
CNMM 160608E-NR2:T8430		0.8	150	0.40	6.0	80	0.36	6.0	125	0.40	6.0	–	–	–	30	0.32	4.8	–	–	–
CNMM 160608E-NR2:T9325		0.8	180	0.40	6.0	105	0.36	6.0	170	0.40	6.0	–	–	–	40	0.32	4.8	–	–	–
CNMM 160612E-NR2:T7325		1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
CNMM 160612E-NR2:T7335		1.2	155	0.45	6.0	120	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
CNMM 160612E-NR2:T8430		1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	–	–	–	30	0.36	4.8	–	–	–
CNMM 160612E-NR2:T9325		1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
CNMM 160616E-NR2:T7325		1.6	165	0.50	6.0	125	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
CNMM 160616E-NR2:T7335		1.6	160	0.50	6.0	120	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
CNMM 160616E-NR2:T9325		1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
CNMM 190612E-NR2:T7325		1.2	155	0.45	9.0	120	0.41	9.0	–	–	–	–	–	–	50	0.36	7.2	–	–	–
CNMM 190612E-NR2:T7335		1.2	145	0.45	9.0	110	0.41	9.0	–	–	–	–	–	–	45	0.36	7.2	–	–	–
CNMM 190612E-NR2:T8430		1.2	140	0.45	9.0	75	0.41	9.0	115	0.45	9.0	–	–	–	30	0.36	7.2	–	–	–
CNMM 190612E-NR2:T9325		1.2	175	0.45	9.0	105	0.41	9.0	165	0.45	9.0	–	–	–	35	0.36	7.2	–	–	–
CNMM 190616E-NR2:T7325		1.6	160	0.50	9.0	120	0.45	9.0	–	–	–	–	–	–	50	0.40	7.2	–	–	–
CNMM 190616E-NR2:T7335		1.6	150	0.50	9.0	115	0.45	9.0	–	–	–	–	–	–	45	0.40	7.2	–	–	–
CNMM 190616E-NR2:T8430		1.6	140	0.50	9.0	75	0.45	9.0	115	0.50	9.0	–	–	–	30	0.40	7.2	–	–	–
CNMM 190616E-NR2:T9325		1.6	175	0.50	9.0	105	0.45	9.0	165	0.50	9.0	–	–	–	35	0.40	7.2	–	–	–
CNMM 190616E-NR2:T9415		1.6	240	0.50	9.0	–	–	–	225	0.50	9.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-NR2:T7335		2.4	130	0.80	9.0	100	0.72	9.0	–	–	–	–	–	–	40	0.56	7.2	–	–	–
CNMM 190624E-NR2:T9325		2.4	150	0.80	9.0	90	0.72	9.0	140	0.80	9.0	–	–	–	30	0.56	7.2	–	–	–
CNMM 250924E-NR2:T7335		2.4	95	0.80	12.0	70	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
CNMM 250924E-NR2:T8430		2.4	80	0.80	12.0	45	0.72	12.0	65	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
CNMM 250924E-NR2:T9325		2.4	100	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
CNMM 250924E-NR2:T9415		2.4	120	0.80	12.0	–	–	–	110	0.80	12.0	–	–	–	–	–	–	–	–	–



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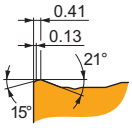
DNMM 150608E-NR2:T9325		0.8	155	0.40	3.0	90	0.36	3.0	145	0.40	3.0	–	–	–	30	0.32	2.4	–	–	–

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/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)
																				
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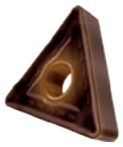
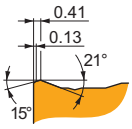
SNMM 120408E-NR2:T7325		0.8	175	0.40	4.7	135	0.36	4.7	–	–	–	–	–	–	55	0.32	3.8	–	–	–
SNMM 120408E-NR2:T7335		0.8	170	0.40	4.7	130	0.36	4.7	–	–	–	–	–	–	55	0.32	3.8	–	–	–
SNMM 120408E-NR2:T8430		0.8	165	0.40	4.7	90	0.36	4.7	135	0.40	4.7	–	–	–	35	0.32	3.8	–	–	–
SNMM 120408E-NR2:T9325		0.8	195	0.40	4.7	115	0.36	4.7	185	0.40	4.7	–	–	–	40	0.32	3.8	–	–	–
SNMM 120412E-NR2:T7335		1.2	165	0.45	4.7	125	0.41	4.7	–	–	–	–	–	–	50	0.36	3.8	–	–	–
SNMM 120412E-NR2:T8430		1.2	165	0.45	4.7	90	0.41	4.7	135	0.45	4.7	–	–	–	35	0.36	3.8	–	–	–
SNMM 120412E-NR2:T9325		1.2	200	0.45	4.7	120	0.41	4.7	190	0.45	4.7	–	–	–	45	0.36	3.8	–	–	–
SNMM 150612E-NR2:T7335		1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
SNMM 150612E-NR2:T8430		1.2	165	0.45	6.0	90	0.41	6.0	135	0.45	6.0	–	–	–	35	0.36	4.8	–	–	–
SNMM 150612E-NR2:T9325		1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
SNMM 150616E-NR2:T7335		1.6	165	0.50	6.0	125	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
SNMM 150616E-NR2:T9325		1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
SNMM 190612E-NR2:T7335		1.2	160	0.45	8.0	120	0.41	8.0	–	–	–	–	–	–	50	0.36	6.4	–	–	–
SNMM 190612E-NR2:T9325		1.2	190	0.45	8.0	110	0.41	8.0	180	0.45	8.0	–	–	–	40	0.36	6.4	–	–	–
SNMM 190616E-NR2:T7325		1.6	175	0.50	8.0	135	0.45	8.0	–	–	–	–	–	–	55	0.40	6.4	–	–	–
SNMM 190616E-NR2:T7335		1.6	160	0.50	8.0	120	0.45	8.0	–	–	–	–	–	–	50	0.40	6.4	–	–	–
SNMM 190616E-NR2:T8430		1.6	155	0.50	8.0	85	0.45	8.0	130	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
SNMM 190616E-NR2:T9325		1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190616E-NR2:T9415		1.6	260	0.50	8.0	–	–	–	245	0.50	8.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-NR2:T7325		2.4	155	0.80	8.0	120	0.72	8.0	–	–	–	–	–	–	50	0.56	6.4	–	–	–
SNMM 190624E-NR2:T7335		2.4	145	0.80	8.0	110	0.72	8.0	–	–	–	–	–	–	45	0.56	6.4	–	–	–
SNMM 190624E-NR2:T9325		2.4	165	0.80	8.0	95	0.72	8.0	155	0.80	8.0	–	–	–	35	0.56	6.4	–	–	–
SNMM 250724E-NR2:T7335		2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMM 250724E-NR2:T8430		2.4	85	0.80	12.0	45	0.72	12.0	70	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
SNMM 250724E-NR2:T9226		2.4	95	0.80	12.0	55	0.72	12.0	90	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMM 250724E-NR2:T9325		2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMM 250724E-NR2:T9415		2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-NR2:T7325		2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMM 250924E-NR2:T7335		2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMM 250924E-NR2:T9325		2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMM 250924E-NR2:T9415		2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–
 																				
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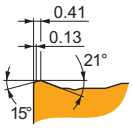
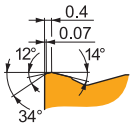
TNMM 160408E-NR2:T9325		0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
TNMM 220408E-NR2:T9325		0.8	160	0.40	4.0	95	0.36	4.0	150	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
TNMM 220412E-NR2:T8430		1.2	140	0.40	4.0	75	0.36	4.0	115	0.40	4.0	–	–	–	30	0.32	3.2	–	–	–
TNMM 220412E-NR2:T9325		1.2	170	0.40	4.0	100	0.36	4.0	160	0.40	4.0	–	–	–	35	0.32	3.2	–	–	–
																				
NR2 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于粗加工至重载粗加工，连续切削至间断切削。它还适用于钢材，并有条件地适用于铸铁和超级合金。																				
WNMM 080408E-NR2:T7335		0.8	160	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
WNMM 080408E-NR2:T9325		0.8	190	0.40	4.0	110	0.36	4.0	180	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
WNMM 080412E-NR2:T9325		1.2	190	0.45	4.0	110	0.41	4.0	180	0.45	4.0	–	–	–	40	0.32	3.2	–	–	–

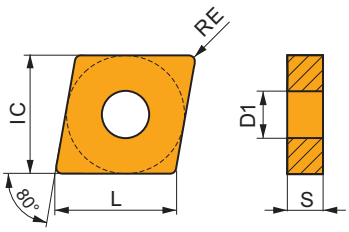
HR



HR 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。

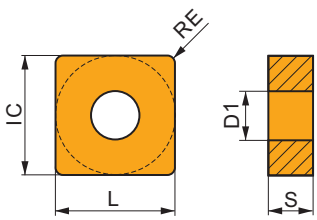
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



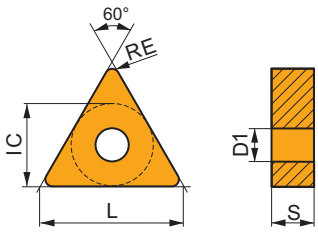
SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53

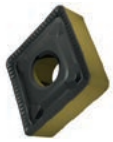
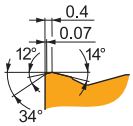
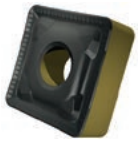
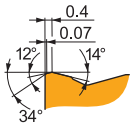
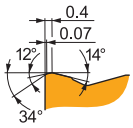


TNMM

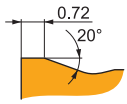
	IC (mm)	D1 (mm)	L (mm)	S (mm)
2706	15.875	6.35	27.50	6.35



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。

Product		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)
 																				
HR 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。																				
CNMM 190616E-HR:6630		1.6	85	0.60	10.0	50	0.54	10.0	80	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:6640		1.6	75	0.60	10.0	45	0.54	10.0	70	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:T8345		1.6	55	0.60	10.0	30	0.54	10.0	50	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:T9325		1.6	105	0.60	10.0	60	0.54	10.0	95	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:T9335		1.6	80	0.60	10.0	45	0.54	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:6630		2.4	90	0.65	10.0	50	0.59	10.0	85	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T8345		2.4	60	0.65	10.0	35	0.59	10.0	55	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T9325		2.4	100	0.65	10.0	60	0.59	10.0	95	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T9335		2.4	85	0.65	10.0	50	0.59	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T9415		2.4	120	0.65	10.0	–	–	–	110	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:6630		2.4	85	0.65	14.0	50	0.59	14.0	80	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:6640		2.4	75	0.65	14.0	45	0.59	14.0	70	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T8345		2.4	55	0.65	14.0	30	0.59	14.0	50	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9315		2.4	110	0.65	14.0	–	–	–	100	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9325		2.4	100	0.65	14.0	60	0.59	14.0	95	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9335		2.4	80	0.65	14.0	45	0.59	14.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9415		2.4	120	0.65	14.0	–	–	–	110	0.65	14.0	–	–	–	–	–	–	–	–	–
 																				
HR 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。																				
SNMM 190616E-HR:6630		1.6	90	0.60	9.0	50	0.54	9.0	85	0.60	9.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-HR:T8345		1.6	60	0.60	9.0	35	0.54	9.0	55	0.60	9.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-HR:T9325		1.6	110	0.60	9.0	65	0.54	9.0	100	0.60	9.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-HR:T9335		1.6	85	0.60	9.0	50	0.54	9.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9315		2.4	120	0.65	9.0	–	–	–	110	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9325		2.4	115	0.65	9.0	65	0.59	9.0	105	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9335		2.4	90	0.65	9.0	50	0.59	9.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9415		2.4	130	0.65	9.0	–	–	–	120	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR:T8345		1.6	60	0.60	13.0	35	0.54	13.0	55	0.60	13.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR:T9325		1.6	100	0.60	13.0	60	0.54	13.0	95	0.60	13.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR:T9335		1.6	85	0.60	13.0	50	0.54	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:6630		2.4	90	0.65	13.0	50	0.59	13.0	85	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:6640		2.4	80	0.65	13.0	45	0.59	13.0	75	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T8345		2.4	55	0.65	13.0	30	0.59	13.0	50	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T9325		2.4	105	0.65	13.0	60	0.59	13.0	95	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T9335		2.4	85	0.65	13.0	50	0.59	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T9415		2.4	125	0.65	13.0	–	–	–	115	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250732E-HR:T9325		3.2	95	0.80	13.0	55	0.72	13.0	90	0.80	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:6630		2.4	90	0.65	13.0	50	0.59	13.0	85	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T8345		2.4	55	0.65	13.0	30	0.59	13.0	50	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T9325		2.4	105	0.65	13.0	60	0.59	13.0	95	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T9335		2.4	85	0.65	13.0	50	0.59	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T9415		2.4	125	0.65	13.0	–	–	–	115	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250932E-HR:T9325		3.2	95	0.80	13.0	55	0.72	13.0	90	0.80	13.0	–	–	–	–	–	–	–	–	–
																				
HR 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。																				
TNMM 270616E-HR:T9325		1.6	90	0.60	7.0	50	0.54	7.0	85	0.60	7.0	–	–	–	–	–	–	–	–	–
TNMM 270616E-HR:T9335		1.6	75	0.60	7.0	45	0.54	7.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMM 270624E-HR:T9226		2.4	80	0.65	7.0	45	0.59	7.0	75	0.65	7.0	–	–	–	–	–	–	–	–	–

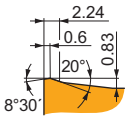
HR2



HR2 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。

PRAMET

923

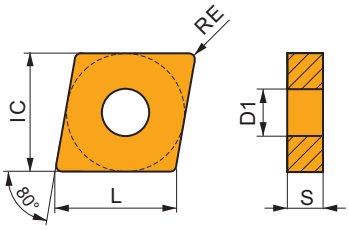


923 型断屑槽坚固耐用，专为重型不锈钢粗加工而设计。适用于中粗加工至重载粗加工，连续至重断续切削。它也有条件地适用于钢和铸铁。

PRAMET

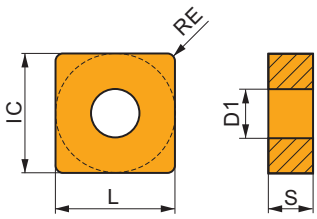
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53

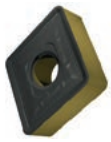


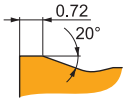
SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



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。





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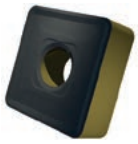
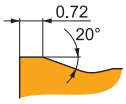
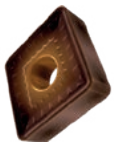
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CNMM 190616-HR2:T9226	1.6	85	0.65	10.0	50	0.59	10.0	80	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616-HR2:T9335	1.6	80	0.65	10.0	45	0.59	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190616-HR2:T9415	1.6	115	0.65	10.0	–	–	–	105	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624-HR2:T9226	2.4	80	0.85	10.0	45	0.77	10.0	75	0.85	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624-HR2:T9415	2.4	110	0.85	10.0	–	–	–	100	0.85	10.0	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2:T9315	2.4	100	0.85	12.0	–	–	–	95	0.85	12.0	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2:T9335	2.4	75	0.85	12.0	45	0.77	12.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2:T9415	2.4	110	0.85	12.0	–	–	–	100	0.85	12.0	–	–	–	–	–	–	–	–	–

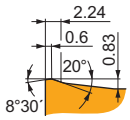




HR2 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。

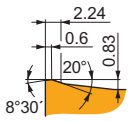
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
SNMM 190616-HR2:T9335	1.6	85	0.65	8.9	50	0.59	8.9	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190616-HR2:T9415	1.6	125	0.65	8.9	–	–	–	115	0.65	8.9	–	–	–	–	–	–	–	–	–
SNMM 190624-HR2:T9335	2.4	80	0.85	8.9	45	0.77	8.9	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624-HR2:T9415	2.4	120	0.85	8.9	–	–	–	110	0.85	8.9	–	–	–	–	–	–	–	–	–
SNMM 250724-HR2:T9226	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250724-HR2:T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9226	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9315	2.4	105	0.85	11.0	–	–	–	95	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9415	2.4	115	0.85	11.0	–	–	–	105	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250932-HR2:T9335	3.2	75	1.00	11.0	45	0.90	11.0	–	–	–	–	–	–	–	–	–	–	–	–





923 型断屑槽坚固耐用，专为重型不锈钢粗加工而设计。适用于中粗加工至重载粗加工，连续至重断续切削。它也有条件地适用于钢和铸铁。

Product	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)
CNMM 250924S-923:T8430	2.4	75	0.85	12.0	40	0.77	12.0	60	0.85	12.0	–	–	–	15	0.60	9.6	–	–	–
CNMM 250924S-923:T9335	2.4	75	0.85	12.0	45	0.77	12.0	–	–	–	–	–	–	15	0.60	9.6	–	–	–



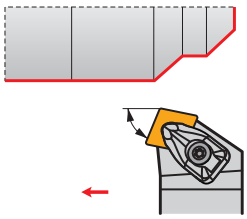
923 型断屑槽坚固耐用，专为重型不锈钢粗加工而设计。适用于中粗加工至重载粗加工，连续至重断续切削。它也有条件地适用于钢和铸铁。

Product	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)
SNMM 190616S-923:T8345	1.6	100	0.65	8.9	60	0.59	8.9	95	0.65	8.9	–	–	–	25	0.52	7.1	–	–	–
SNMM 190616S-923:T8430	1.6	125	0.65	8.9	65	0.59	8.9	100	0.65	8.9	–	–	–	25	0.52	7.1	–	–	–
SNMM 190616S-923:T9335	1.6	130	0.65	8.9	75	0.59	8.9	–	–	–	–	–	–	25	0.52	7.1	–	–	–
SNMM 250724S-923:T8430	2.4	80	0.85	11.0	45	0.77	11.0	65	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
SNMM 250724S-923:T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T8345	2.4	55	0.85	11.0	30	0.77	11.0	50	0.85	11.0	–	–	–	10	0.60	8.8	–	–	–
SNMM 250924S-923:T8430	2.4	80	0.85	11.0	45	0.77	11.0	65	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T9226	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T9415	2.4	115	0.85	11.0	–	–	–	105	0.85	11.0	–	–	–	–	–	–	–	–	–

CN

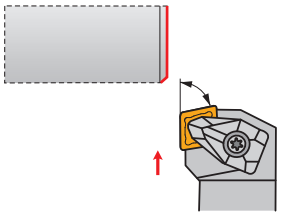
ISO 外圆车削 – 导航工具

DCBN(RL) EXT 75°
CN..



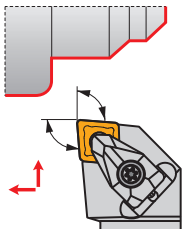
246

DCKN(RL) EXT 75°
CN..



248

DCLN(RL) EXT 95°
CN..



249

PCBN(RL) EXT 75°
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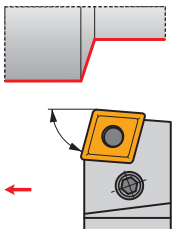

251

PCKN(RL) EXT 75°
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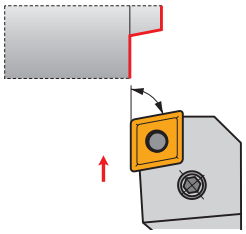
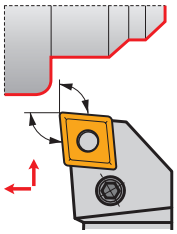


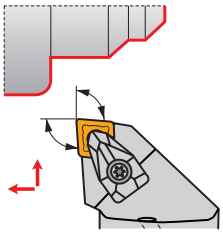
252

PCLN(RL) EXT 95°
CN..



253

C.-DCLN(RL) EXT 95°
CN..

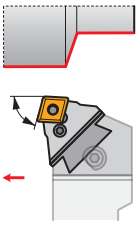


254

CN

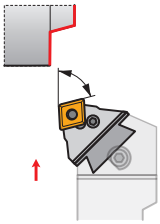
ISO外圆重载车削 – 导航工具

KHP-CBNR 75°
CN..



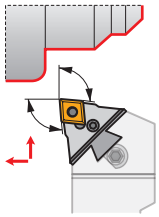
256

KHP-CBNL 75°
CN..



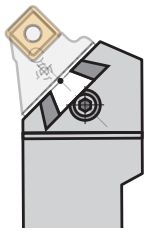
257

KHP-CLNR 95°
CN..



257

DKH(RL)

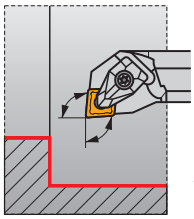


258

CN

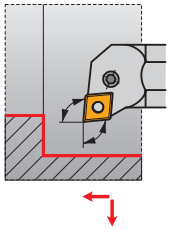
ISO内孔车削 – 导航工具

DCLN(RL) INT 95°
CN..



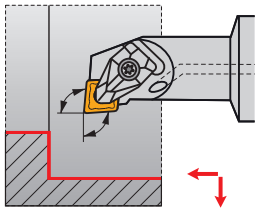
259

PCLN(RL) INT 95°
CN..



260

C.-DCLN(RL) INT 95°
CN..



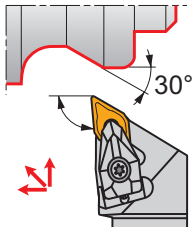
262

DN

ISO 外圆车削 – 导航工具

DDJN(RL) EXT 93°

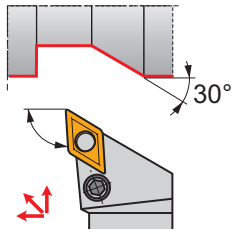
DN..



263

PDJN(RL) EXT 93°

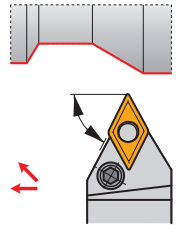
DN..



264

PDNN(RL) EXT 62°30´

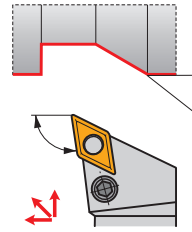
DN..



265

PDXN(RL) EXT 98°

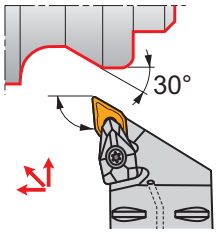
DN..



266

C.-DDJN(RL) EXT 93°

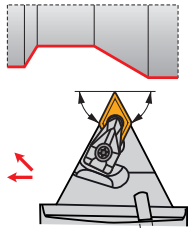
DN..



267

C.-DDNNN EXT 62.5°

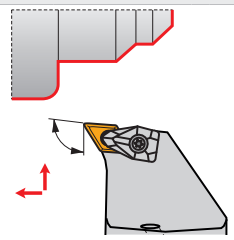
DN..



268

C.-DDUN(RL) EXT 93°

DN..



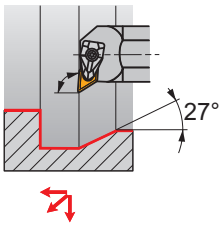
269

DN

ISO内孔车削 – 导航工具

DDUN(RL) INT 93°

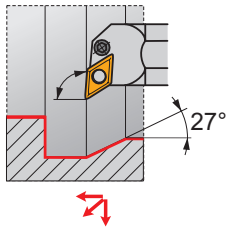
DN..



270

PDUN(RL) INT 93°

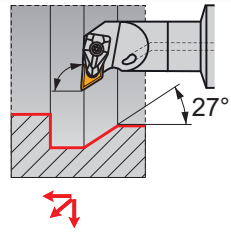
DN..



271

C.-DDUN(RL) INT 93°

DN..



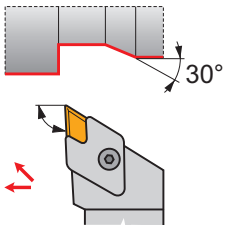
272

KN

ISO 外圆车削 – 导航工具

CKJN(RL) EXT 93°

KN..



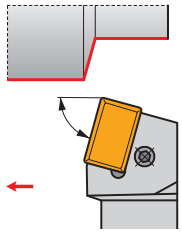
273

LN

ISO 外圆车削 – 导航工具

PLBN(RL) EXT 75°

LN..



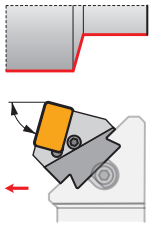
274

LN

ISO外圆重载车削 – 导航工具

KHP-LBNR 75°

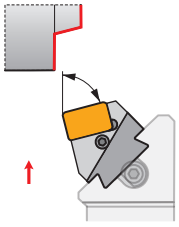
LN..



275

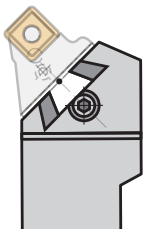
KHP-LBNL 75°

LN..



275

DKH(RL)



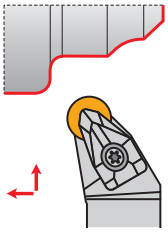
276

RN

ISO 外圆车削 – 导航工具

DRSN(RL) EXT

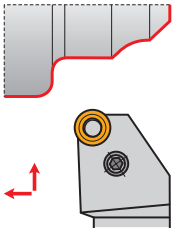
RN..



277

PRSN(RL) EXT

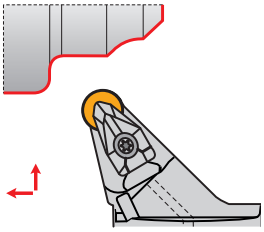
RN..



278

C.-DRSN(RL) EXT

RN..

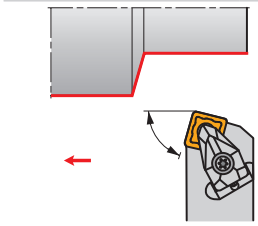


279

SN

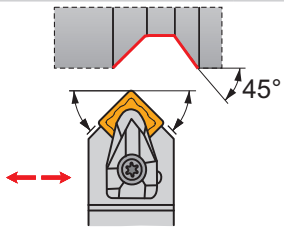
ISO 外圆车削 – 导航工具

DSBN(RL) EXT 45°
SN..



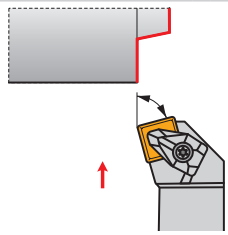
280

DSDNN EXT 45°
SN..



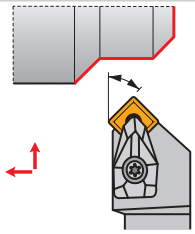
281

DSKN(RL) EXT 75°
SN..



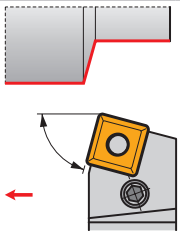
282

DSSN(RL) EXT 45°
SN..



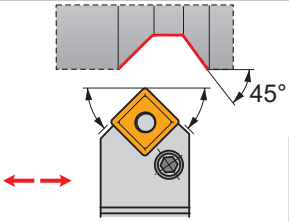
283

PSBN(RL) EXT 75°
SN..



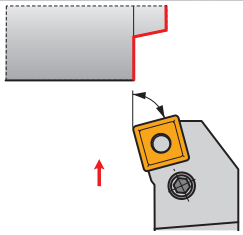
285

PSDNN EXT 45°
SN..



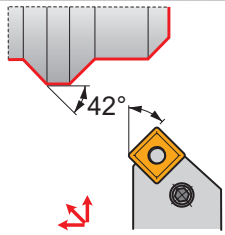
287

PSKN(RL) EXT 75°
SN..



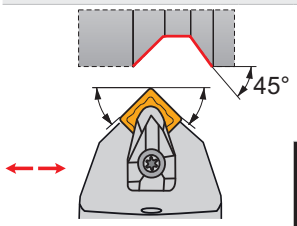
288

PSSN(RL) EXT 45°
SN..



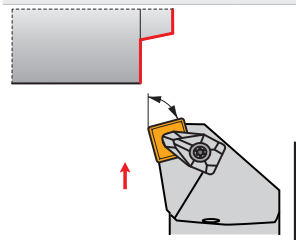
290

C.-DSDNN EXT 45°
SN..



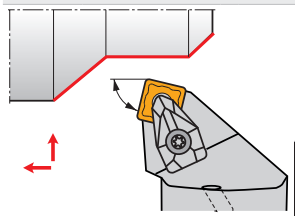
291

C.-DSKN(RL) EXT 75°
SN..



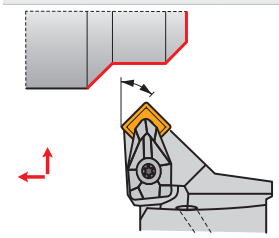
292

C.-DSRN(RL) EXT 75°
SN..



293

C.-DSSN(RL) EXT 45°
SN..

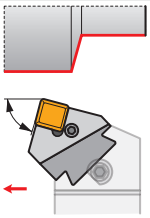


294

SN

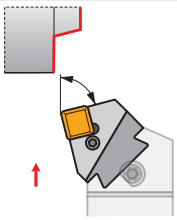
ISO 外圆车削 – 导航工具

KHP-SBNR 75°
SN..



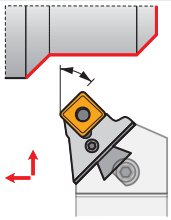
295

KHP-SBNL 75°
SN..



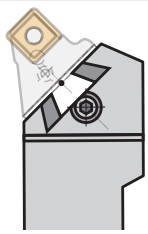
295

KHP-SSNR/L 45°
SN..



296

DKH(RL)

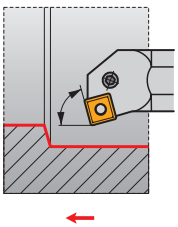


297

SN

ISO内孔车削 – 导航工具

PSKN(RL) INT 75°
SN..



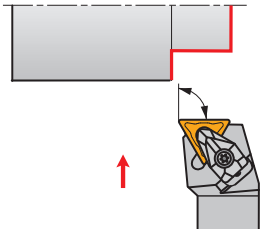
298

TN

ISO 外圆车削 – 导航工具

DTFN(RL) EXT 90°

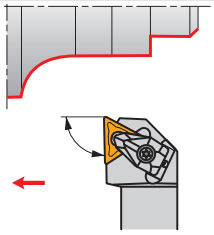
TN..



299

DTGN(RL) EXT 90°

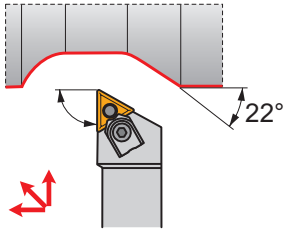
TN..



300

MTJN(RL) EXT 93°

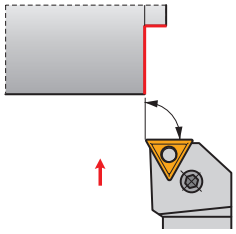
TN..



301

PTFN(RL) EXT 90°

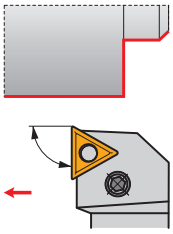
TN..



302

PTGN(RL) EXT 90°

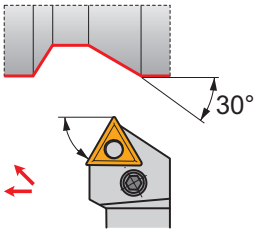
TN..



303

PTTN(RL) EXT 60°

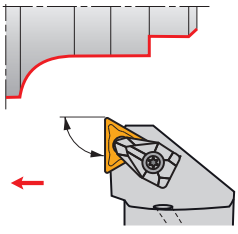
TN..



304

C.-DTJN(RL) EXT 93°

TN..



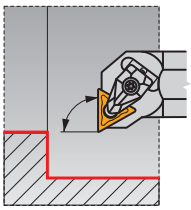
305

TN

ISO内孔车削 – 导航工具

DTFN(RL) INT 90°

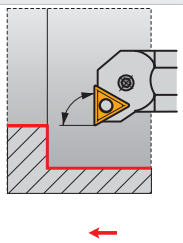
TN..



306

PTFN(RL) INT 90°

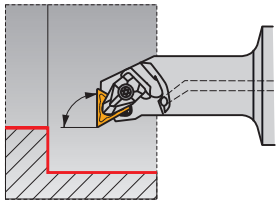
TN..



307

C.-DTFN(RL) INT 91°

TN..



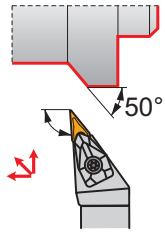
308

VN

ISO 外圆车削 – 导航工具

DVJN(RL) EXT 93°

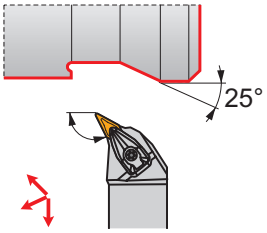
VN..



309

DVPN(RL) EXT 62°30´

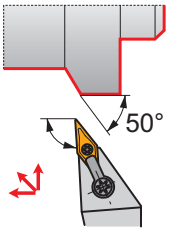
VN..



310

MVJN(RL) EXT 93°

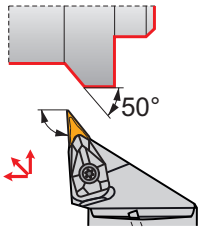
VN..



311

C.-DVJN(RL) EXT 93°

VN..



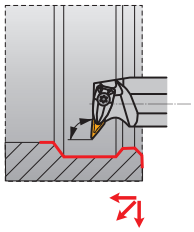
312

VN

ISO内孔车削 – 导航工具

DVUN(RL) INT

VN..



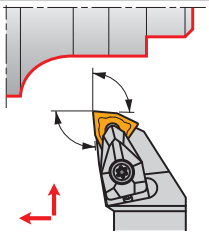
313

WN

ISO 外圆车削 – 导航工具

DWLN(RL) EXT 95°

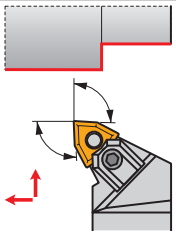
WN..



314

MWLN(RL) EXT 95°

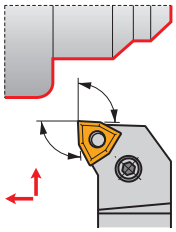
WN..



316

PWLN(RL) EXT 95°

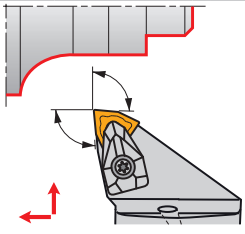
WN..



317

C.-DWLN(RL) EXT 95°

WN..



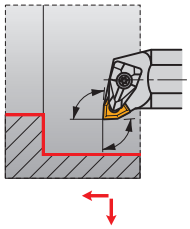
318

WN

ISO内孔车削 – 导航工具

DWLN(RL) INT 95°

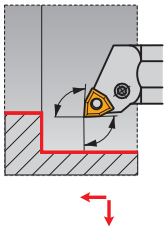
WN..



319

PWLN(RL) INT 95°

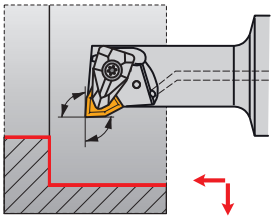
WN..



320

C.-DWLN(RL) INT 95°

WN..



321

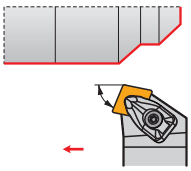
DCBN(RL) EXT

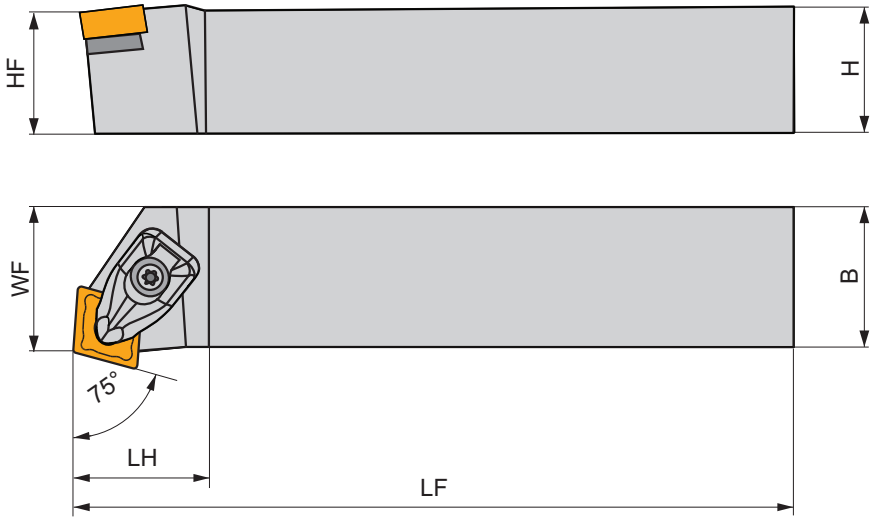
P M K N S H

PRAMET

D

外圆用双重夹紧车刀杆，使用CN..刀片，主偏角为75°。
外圆用左/右手双重夹紧75°车刀杆。使用CN.12至19尺寸的负前角刀片。适用于轴向和无阶梯外圆端面车削和倒角车削。可提供20x20至40x40mm的刀柄。刀杆经过处理，使用寿命更长。





	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	**DCBNR 2020 K 12**	20	20	20	17	125	34.2	-6	-6	0.43	GI043	DC12	AT001
	DCBNR 2525 M 12	25	25	25	22	150	34.6	-6	-6	0.76	GI043	DC12	AT001
	DCBNR 3225 P 12	32	25	32	22	170	34.6	-6	-6	1.09	GI043	DC12	AT001
	DCBNR 2525 M 16	25	25	25	22	150	41.5	-6	-6	0.80	GI050	DC16	AT005
	DCBNR 3225 P 16	32	25	32	22	170	32.0	-6	-6	1.11	GI050	DC16	AT005
	DCBNR 3232 P 19	32	32	32	27	170	46.1	-6	-6	1.39	GI042	DC19	–
L	**DCBNL 2525 M 12**	25	25	25	22	150	34.6	-6	-6	0.76	GI043	DC12	AT001
	DCBNL 3225 P 12	32	25	32	22	170	34.6	-6	-6	1.09	GI043	DC12	AT001
	DCBNL 2525 M 16	25	25	25	22	150	41.5	-6	-6	0.79	GI050	DC16	AT005
	DCBNL 3225 P 16	32	25	32	22	170	32.0	-6	-6	1.11	GI050	DC16	AT005
	DCBNL 3232 P 19	32	32	32	27	170	46.1	-6	-6	1.39	GI042	DC19	–

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..

		Nm				
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

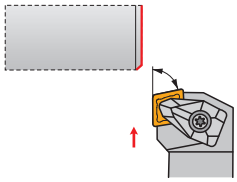
DCKN(RL) EXT

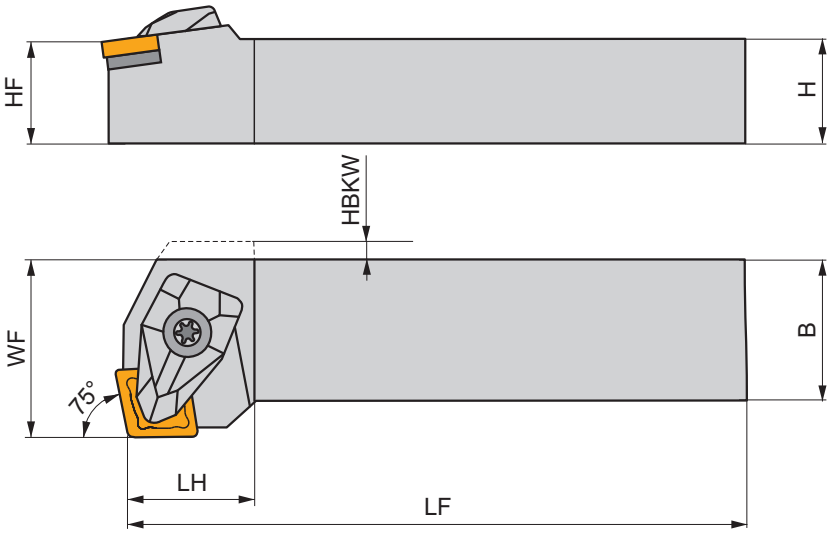
P M K N S H

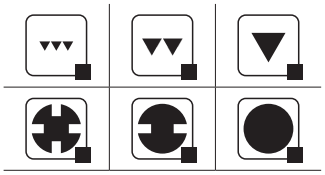
PRAMET

D

外圆用双重夹紧车刀杆，使用CN..刀片，主偏角为75°（端面）。
外圆用左/右手双重夹紧75°车刀杆。使用CN..12或16尺寸的负前角刀片，适用于端面车削和偶尔倒角车削。可提供20x20至32x32mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DCKNR 2020 K 12	20	20	20	25	125	21.2	4.5	-6	-6	0.46	GI043	DC12	AT001
	DCKNR 2525 M 12	25	25	25	32	150	21.1	–	-6	-6	0.80	GI043	DC12	AT001
	DCKNR 3225 P 12	32	25	32	32	170	21.1	–	-6	-6	1.14	GI043	DC12	AT001
	DCKNR 3232 P 16	32	32	32	40	170	26.0	–	-6	-6	1.46	GI050	DC16	AT005
L	DCKNL 2525 M 12	25	25	25	32	150	21.1	–	-6	-6	0.80	GI043	DC12	AT001
	DCKNL 3225 P 12	32	25	32	32	170	21.1	–	-6	-6	1.13	GI043	DC12	AT001
	DCKNL 3232 P 16	32	32	32	40	170	26.0	–	-6	-6	1.45	GI050	DC16	AT005

GI043	CN.. 1204..
GI050	CN.. 1606..

		Nm				
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–

AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

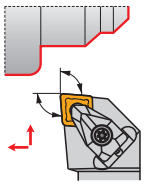
DCLN(RL) EXT

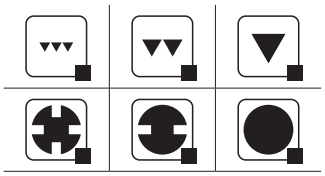
P M K N S H

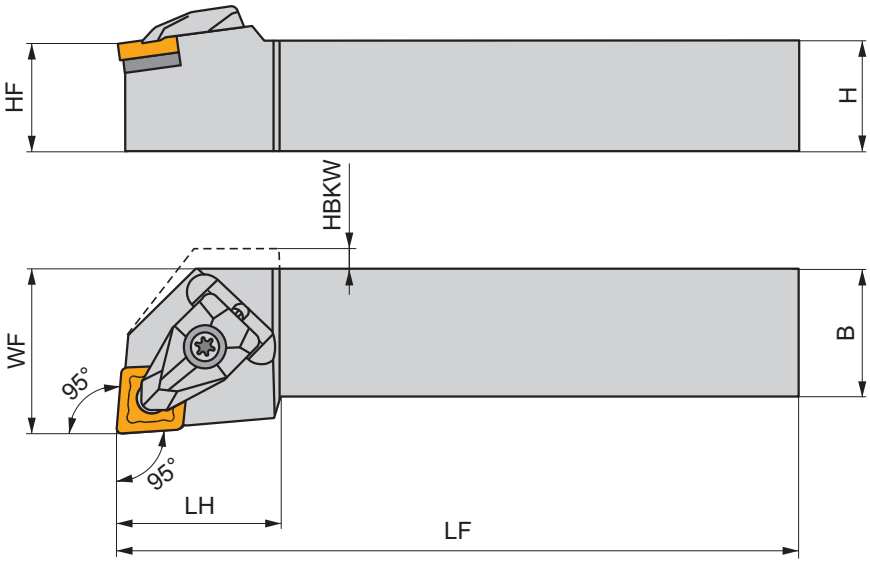
PRAMET

D

外圆用双重夹紧车削刀杆，使用CN..刀片，主偏角为95°。
外圆用左/右手双重夹紧95°车刀杆。使用CN..09至19尺寸的负前角刀片。适用于轴向车削，倒角和有阶梯外圆的端面车削。可提供16x16至40x40mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DCLNR 1616 H 09	16	16	16	20	100	25.0	–	-6	-6	0.24	GI133	DC09	–
	DCLNR 2020 K 09	20	20	20	25	125	25.0	–	-6	-6	0.44	GI133	DC09	–
	DCLNR 2525 M 09	25	25	25	32	150	25.0	–	-6	-6	0.77	GI133	DC09	–
	DCLNR 1616 H 12	16	16	16	20	100	32.3	4.5	-6	-6	0.26	GI043	DCI12	AT001
	DCLNR 2020 K 12	20	20	20	25	125	30.0	–	-6	-6	0.44	GI043	DC12	AT001
	DCLNR 2525 M 12	25	25	25	32	150	30.0	–	-6	-6	0.78	GI043	DC12	AT001
	DCLNR 3225 P 12	32	25	32	32	170	30.0	–	-6	-6	1.07	GI043	DC12	AT001
	DCLNR 2525 M 16	25	25	25	32	150	39.0	–	-6	-6	0.81	GI050	DC16	AT005
	DCLNR 3225 P 16	32	25	32	32	170	35.0	–	-6	-6	1.13	GI050	DC16	AT005
	DCLNR 3232 P 19	32	32	32	40	170	40.0	–	-6	-6	1.40	GI042	DC19	–
	DCLNR 4040 S 19	40	40	40	50	250	43.4	–	-6	-6	3.20	GI042	DC19	–
L	DCLNL 1616 H 09	16	16	16	20	100	24.8	–	-6	-6	0.22	GI133	DC09	–
	DCLNL 2020 K 09	20	20	20	25	125	24.8	–	-6	-6	0.42	GI133	DC09	–
	DCLNL 2525 M 09	25	25	25	32	150	24.8	–	-6	-6	0.76	GI133	DC09	–
	DCLNL 1616 H 12	16	16	16	20	100	32.2	4.5	-6	-6	0.26	GI043	DCI12	AT001
	DCLNL 2020 K 12	20	20	20	25	125	32.0	–	-6	-6	0.44	GI043	DC12	AT001
	DCLNL 2525 M 12	25	25	25	32	150	32.0	–	-6	-6	0.78	GI043	DC12	AT001
	DCLNL 3225 P 12	32	25	32	32	170	32.0	–	-6	-6	1.10	GI043	DC12	AT001
	DCLNL 2525 M 16	25	25	25	32	150	39.0	–	-6	-6	0.81	GI050	DC16	AT005
	DCLNL 3225 P 16	32	25	32	32	170	39.0	–	-6	-6	1.10	GI050	DC16	AT005
	DCLNL 3232 P 19	32	32	32	40	170	43.2	–	-6	-6	1.41	GI042	DC19	–
	DCLNL 4040 S 19	40	40	40	50	250	43.4	–	-6	-6	3.26	GI042	DC19	–

GI042	CN.. 1906..
GI043	CN.. 1204..

GI050	CN.. 1606..
GI133	CN.. 0903..

		Nm				
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	–
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5	–

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

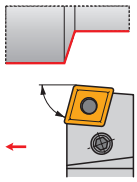
PCBN(RL) EXT

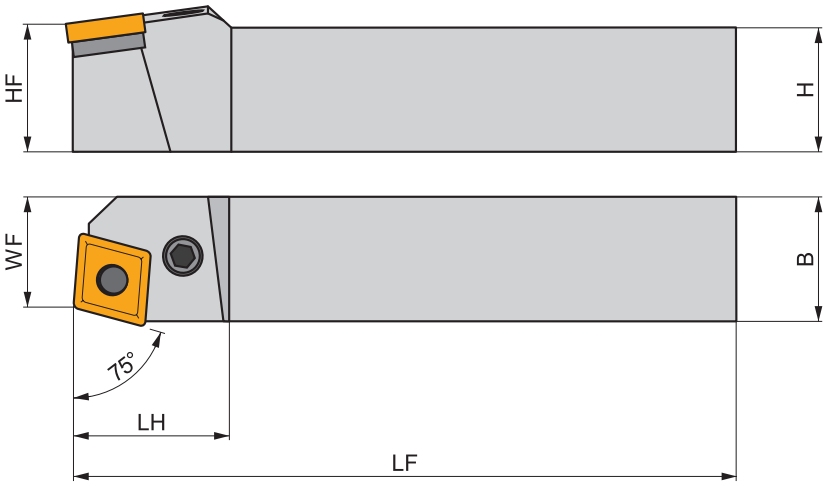
P M K N S H

PRAMET

P

外圆用杠杆锁车削刀杆，使用CN..刀片，主偏角为75°。
外圆用左/右手杠杆夹紧式75°车刀杆。使用CN..12、16、19或25尺寸的负前角刀片。适用于外圆倒角，锥面和无阶梯外圆的轴向车削。可提供20x20至50x50mm的刀柄。刀杆经过处理，使用寿命更长。





	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PCBNR 2020 K 12**	20	20	20	17	125	28.0	-5	-6	0.40	GI043	PC01
	PCBNR 2525 M 12	25	25	25	22	150	36.0	-6	-6	0.74	GI043	PC01
	PCBNR 3232 P 16	32	32	32	27	170	34.0	-5	-6	1.34	GI050	PC02
	PCBNR 3232 P 19	32	32	32	27	170	42.0	-5	-6	1.10	GI042	PC03
	PCBNR 4040 S 19	40	40	40	35	250	45.0	-6	-6	3.05	GI042	PC03
	PCBNR 4040 S 25	40	40	40	41	250	48.0	-5	-6	3.09	GI062	PC04
	PCBNR 5050 T 25	50	50	50	51	300	50.0	-5	-6	5.80	GI062	PC04
L	**PCBNL 2020 K 12**	20	20	20	17	125	28.0	-5	-6	0.38	GI043	PC01
	PCBNL 2525 M 12	25	25	25	22	150	28.0	-5	-6	0.73	GI043	PC01
	PCBNL 3232 P 16	32	32	32	27	170	34.0	-5	-6	1.25	GI050	PC02
	PCBNL 3232 P 19	32	32	32	27	170	42.0	-5	-6	1.10	GI042	PC03
	PCBNL 4040 S 19	40	40	40	35	250	48.0	-5	-6	3.10	GI042	PC03
	PCBNL 4040 S 25	40	40	40	41	250	48.0	-5	-6	3.12	GI062	PC04
	PCBNL 5050 T 25	50	50	50	51	300	50.0	-5	-6	5.80	GI062	PC04

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..
GI062	CN.. 2509..

				Nm					
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PC04	PCS 625	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5

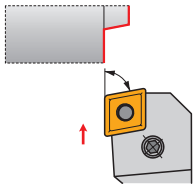
PCKN(RL) EXT

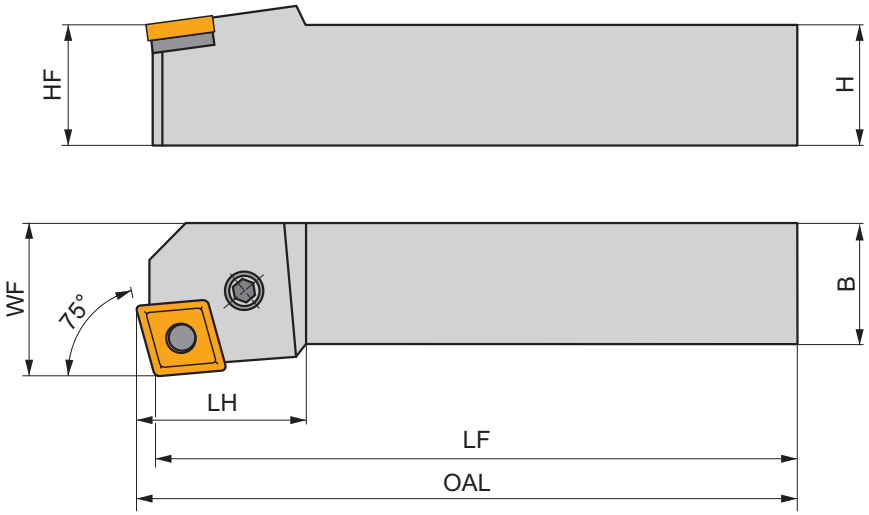
P M K N S H

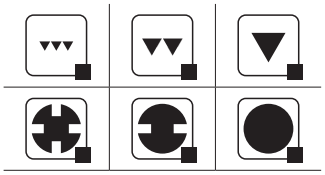
PRAMET

P

外圆用杠杆夹紧式车刀杆，使用CN..刀片，主偏角为75°（端面车削）。
外圆用左/右手杠杆夹紧式75°车刀杆。使用CN..12、16或19尺寸的负前角刀片。适用于外圆倒角，有阶梯外圆的端面车削。可提供20x20至40x40mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PCKNR 2020 K 12**	20	20	20	25	125	28.0	-6	-5	0.42	GI043	PC01
	PCKNR 2525 M 12	25	25	25	32	150	28.0	-6	-5	0.76	GI043	PC01
	PCKNR 3232 P 16	32	32	32	40	170	34.0	-6	-5	1.42	GI050	PC02
	PCKNR 3232 P 19	32	32	32	40	170	34.0	-6	-5	1.40	GI042	PC03
	PCKNR 4040 S 19	40	40	40	50	250	45.0	-6	-5	3.25	GI042	PC03
L	**PCKNL 2020 K 12**	20	20	20	25	125	28.0	-6	-5	0.42	GI043	PC01
	PCKNL 2525 M 12	25	25	25	32	150	28.0	-6	-5	0.77	GI043	PC01
	PCKNL 3232 P 16	32	32	32	40	170	34.0	-6	-5	1.40	GI050	PC02
	PCKNL 3232 P 19	32	32	32	40	170	45.0	-6	-6	1.40	GI042	PC03
	PCKNL 4040 S 19	40	40	40	50	250	45.0	-6	-5	3.27	GI042	PC03

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..

				Nm					
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4

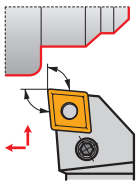
PCLN(RL) EXT

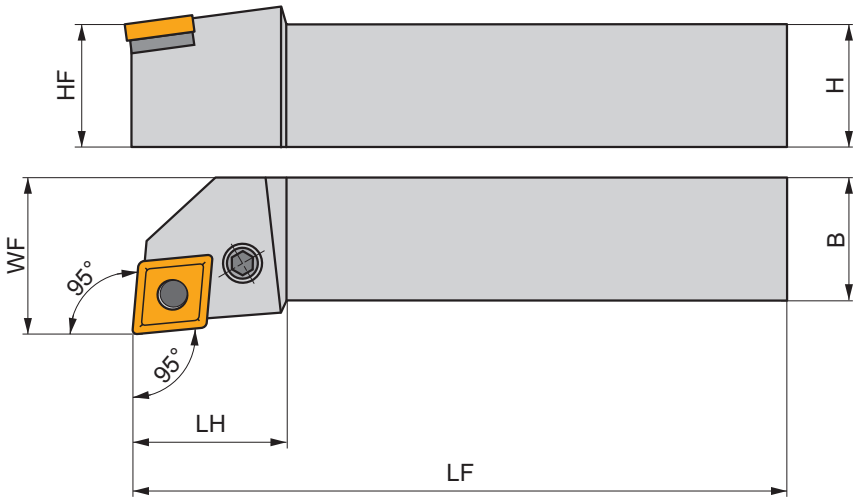
P M K N S H

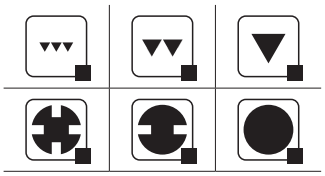
PRAMET

P

外圆用杠杆锁车削刀杆，使用CN..刀片，主偏角为95°。
外圆用左/右手杠杆夹紧式95°车刀杆。使用CN.12、16、19或25尺寸的负前角刀片。适用于外圆锥面，端面，有阶梯外圆的轴向车削和倒角车削。可提供20x20至50x50mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PCLNR 2020 K 12**	20	20	20	25	125	28.0	-6	-6	0.42	GI043	PC01
	PCLNR 2525 M 12	25	25	25	32	150	28.0	-6	-6	0.68	GI043	PC01
	PCLNR 3225 P 12	32	25	32	32	170	28.0	-6	-6	0.98	GI043	PC01
	PCLNR 3225 P 16	32	25	32	32	170	34.0	-6	-6	1.09	GI050	PC02
	PCLNR 3232 P 19	32	32	32	40	170	45.0	-6	-6	1.38	GI042	PC03
	PCLNR 4040 S 19	40	40	40	50	250	45.0	-6	-6	3.10	GI042	PC03
	PCLNR 4040 S 25	40	40	40	50	250	45.0	-6	-6	3.15	GI062	PC04
	PCLNR 5050 T 25	50	50	50	60	300	50.0	-6	-6	5.90	GI062	PC04
L	**PCLNL 2020 K 12**	20	20	20	25	125	28.0	-6	-6	0.42	GI043	PC01
	PCLNL 2525 M 12	25	25	25	32	150	28.0	-6	-6	0.75	GI043	PC01
	PCLNL 3225 P 12	32	25	32	32	170	28.0	-6	-6	1.06	GI043	PC01
	PCLNL 3225 P 16	32	25	32	32	170	34.0	-6	-6	1.08	GI050	PC02
	PCLNL 3232 P 19	32	32	32	40	170	42.0	-6	-6	1.38	GI042	PC03
	PCLNL 4040 S 19	40	40	40	50	250	45.0	-6	-6	3.16	GI042	PC03
	PCLNL 4040 S 25	40	40	40	50	250	45.0	-6	-6	3.17	GI062	PC04
	PCLNL 5050 T 25	50	50	50	60	300	50.0	-6	-6	5.90	GI062	PC04

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..
GI062	CN.. 2509..

				Nm					
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PC04	PCS 625	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5

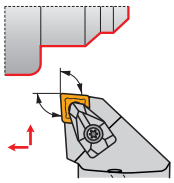
C.-DCLN(RL) EXT

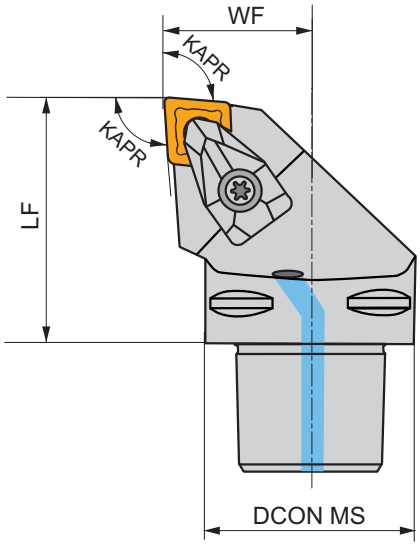
P M K N S H

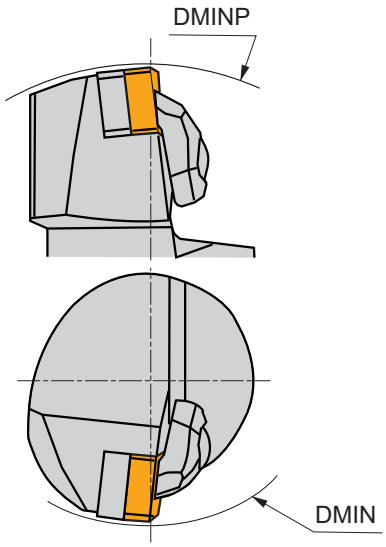
PRAMET

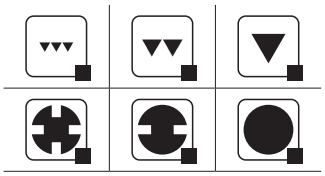
D

外圆用PSC快速更换式刀柄，双重夹紧，使用CN..刀片，主偏角为95°。
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为95°。使用CN..12至19尺寸的负前角刀片。适用于轴向车削，倒角和有阶梯外圆的端面车削。可提供C3至C8刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C3-DCLNR-22045-12	32	60	121	22	45	95	-6	-6	✓	0.25	GI043	C-DC12	AT001
	C4-DCLNR-27050-12	40	110	140	27	50	95	-6	-6	✓	0.44	GI043	C-DC12	AT001
	C4-DCLNR-27055-16	40	125	145	27	55	95	-6	-6	✓	0.47	GI050	C-DC16	AT005
	C5-DCLNR-35060-12	50	110	165	35	60	95	-6	-6	✓	0.79	GI043	C-DC12	AT001
	C5-DCLNR-35060-16	50	125	165	35	60	95	-6	-6	✓	0.80	GI050	C-DC16	AT005
	C6-DCLNR-45065-12	63	110	190	45	65	95	-6	-6	✓	1.32	GI043	C-DC12	AT001
	C6-DCLNR-45065-16	63	125	190	45	65	95	-6	-6	✓	1.34	GI050	C-DC16	AT005
	C6-DCLNR-45065-19	63	81	190	45	65	95	-6	-6	✓	1.34	GI042	C-DC19	–
	C8-DCLNR-55080-19	80	100	250	55	80	95	-6	-6	✓	2.58	GI042	C-DC19	–
L	C4-DCLNL-27050-12	40	110	140	27	50	95	-6	-6	✓	0.44	GI043	C-DC12	AT001
	C4-DCLNL-27055-16	40	125	145	27	55	95	-6	-6	✓	0.47	GI050	C-DC16	AT005
	C5-DCLNL-35060-12	50	110	165	35	60	95	-6	-6	✓	0.79	GI043	C-DC12	AT001
	C5-DCLNL-35060-16	50	125	165	35	60	95	-6	-6	✓	0.80	GI050	C-DC16	AT005
	C6-DCLNL-45065-12	63	110	190	45	65	95	-6	-6	✓	1.32	GI043	C-DC12	AT001
	C6-DCLNL-45065-16	63	125	190	45	65	95	-6	-6	✓	1.34	GI050	C-DC16	AT005
	C6-DCLNL-45065-19	63	81	190	45	65	95	-6	-6	✓	1.34	GI042	C-DC19	–
	C8-DCLNL-55080-16	80	125	250	55	80	95	-6	-6	✓	2.58	GI050	C-DC16	AT005
	C8-DCLNL-55080-19	80	100	250	55	80	95	-6	-6	✓	2.58	GI042	C-DC19	–

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..

C-DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–	CN 045-01
C-DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P	CN 045-01
C-DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P	CN 045-01

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

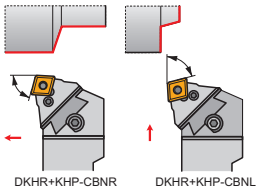
KHP-CBN(RL)

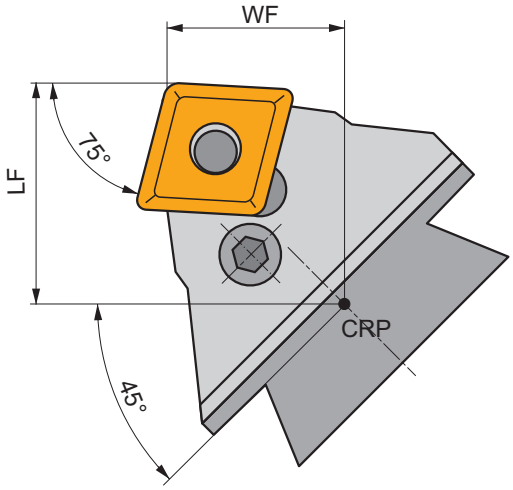
P M K

PRAMET

P

模块化KHP杠杆夹紧式车刀刀夹，使用CN..刀片，主偏角为75°。
燕尾形左/右手杠杆夹紧车刀夹，主偏角为75°。安装在DKH刀杆上。使用CN..25负前角刀片。适用于无阶梯外圆的重载轴向车削，端面车削，锥面和倒角车削。车刀杆经过处理，使用寿命更长。





	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	KHP-CBNR 25	32	47	-6	-6	1.54	GI062	PC60
L	KHP-CBNL 25	32	47	-6	-6	1.56	GI062	PC60

GI062	CN.. 2509..

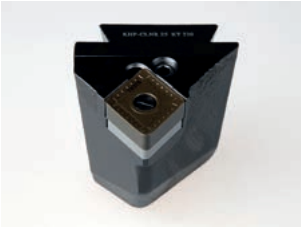
PC60	CNU 250620	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXK 5

KHP-CLN(RL)

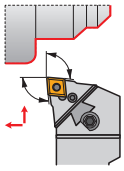
P M K

PRAMET

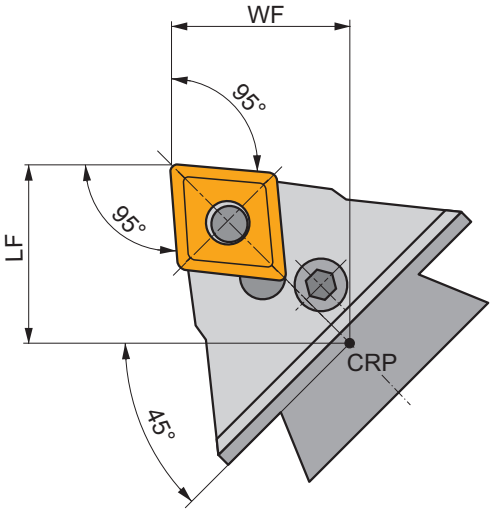
P

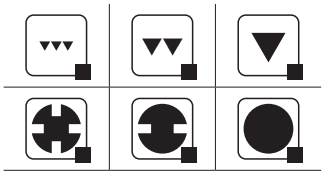


模块化KHP杠杆夹紧式车刀刀夹，使用CN..刀片，主偏角为95°。
燕尾形左/右手杠杆夹紧车刀夹，主偏角为95°。安装在DKH刀杆上。使用CN..19或25负前角刀片。适用于有阶梯外圆的重载轴向车削，有阶梯外圆的端面车削，锥面和倒角车削。车刀杆经过处理，使用寿命更长。



DKHR+KHP-CLNR





	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-CLNR 19**	35	45	-6	-6	1.69	GI042	PC50
	KHP-CLNR 25	35	45	-6	-6	1.25	GI062	PC60
L	**KHP-CLNL 19**	35	45	-6	-6	1.30	GI042	PC50
	KHP-CLNL 25	35	45	-6	-6	1.25	GI062	PC60

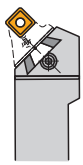
GI042	CN.. 1906..
GI062	CN.. 2509..

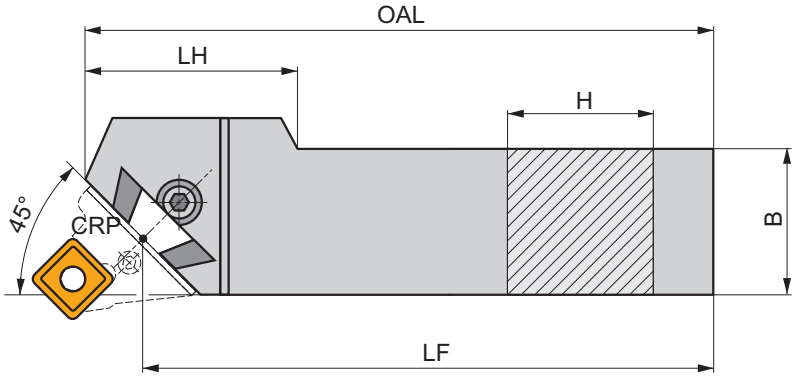
				Nm					
PC50	CNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5
PC60	CNU 250620	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXK 5

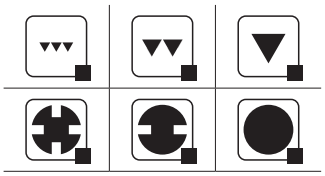
DKH(RL)

PRAMET

使用KHP/KHS重载车刀刀夹的外圆用刀柄
燕尾形左/右手模块化刀杆，使用KHP/KHS刀夹。适用于重载车削应用。可提供40x50至60x80mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

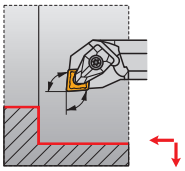
DCLN(RL) INT

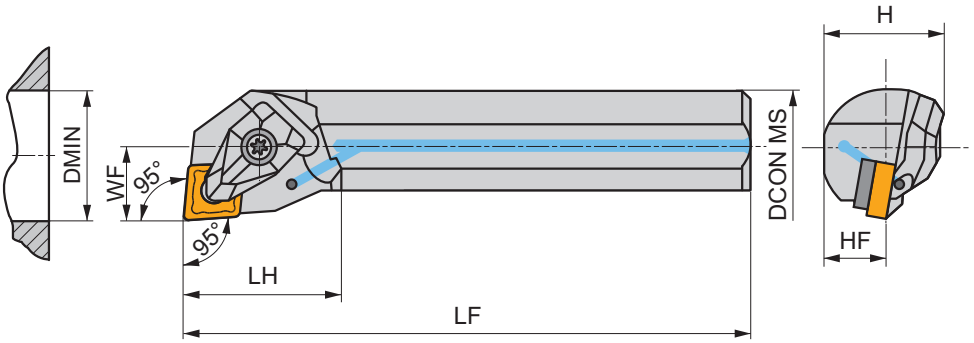
P M K N S H

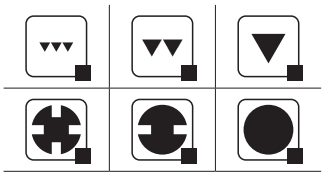
PRAMET

D

内孔双重刚性夹紧镗杆，使用CN..刀片，主偏角为95°
内孔左/右手双重刚性夹紧镗杆，有内冷通道，主偏角为95°，使用CN..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	**A25T-DCLNR 09**	25	32	17	23	11.5	300	31.0	-11	-6	✓	0.98	GI133	DC09
	A25T-DCLNR 12	25	32	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI043	DCI12
	A32T-DCLNR 12	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI043	DCI12
	A40T-DCLNR 12	40	50	27	37	18.5	300	32.0	-15	-6	✓	2.56	GI043	DC12
L	**A25T-DCLNL 09**	25	32	17	23	11.5	300	31.0	-11	-6	✓	0.99	GI133	DC09
	A25T-DCLNL 12	25	32	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI043	DCI12
	A32T-DCLNL 12	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI043	DCI12
	A40T-DCLNL 12	40	50	27	37	18.5	300	32.0	-15	-6	✓	2.55	GI043	DC12

GI043	CN.. 1204..
GI133	CN.. 0903..

		Nm			
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5

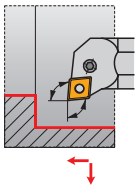
PCLN(RL) INT

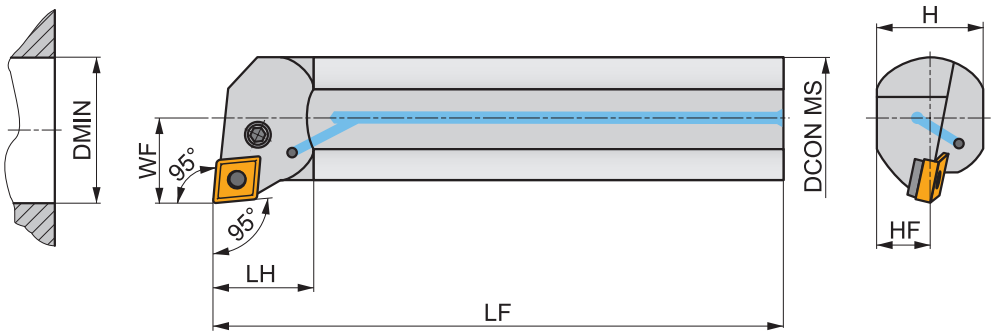
P M K N S H

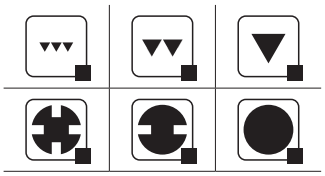
PRAMET

P

外圆杠杆夹紧镗杆，使用CN..刀片，主偏角为95°。
内孔左/右手杠杆夹紧镗杆，有内冷通道，主偏角为95°，使用CN..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16M-PCLNR 09	16	20	11	15	–	150	-14	-4	✓	0.22	GI133	PC05
R	A20Q-PCLNR 09	20	25	13	18	18	180	-13.5	-5	✓	0.33	GI133	PC05
R	A25R-PCLNR 12	25	31	17	23	–	200	-14	-4	–	0.70	GI043	PC06
R	A32S-PCLNR 12	32	39	22	30	–	250	-12	-4	✓	1.40	GI043	PC07
R	A40T-PCLNR 12	40	48	27	37	–	300	-12	-4	✓	2.40	GI043	PC01
R	A40T-PCLNR 16	40	48	27	37	–	300	-12	-4	✓	2.65	GI050	PC02
R	A50U-PCLNR 16	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI050	PC02
R	A60V-PCLNR 16	60	80	43	57	–	400	-12	-4	✓	8.70	GI050	PC02
R	A50U-PCLNR 19	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI042	PC08
R	A60V-PCLNR 19	60	80	43	57	–	400	-11	-6	✓	8.22	GI042	PC08
L	A16M-PCLNL 09	16	20	11	15	–	150	-14	-4	✓	0.20	GI133	PC05
L	A20Q-PCLNL 09	20	25	13	18	–	180	-13	-4	–	0.34	GI133	PC05
L	A25R-PCLNL 12	25	31	17	23	–	200	-14	-4	✓	0.65	GI043	PC06
L	A32S-PCLNL 12	32	39	22	30	–	250	-12	-4	✓	1.40	GI043	PC07
L	A40T-PCLNL 12	40	50	27	38	38	300	-12	-6	✓	2.58	GI043	PC01
L	A40T-PCLNL 16	40	48	27	37	–	300	-12	-4	✓	2.58	GI050	PC02
L	A50U-PCLNL 16	50	61	35	47	–	350	-12	-4	✓	4.95	GI050	PC02
L	A60V-PCLNL 16	60	80	43	57	–	400	-12	-4	✓	8.70	GI050	PC02

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..
GI133	CN.. 0903..

				Nm					
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC05	–	CL 005	CS 605	1.4	M 5x1	12	–	–	HXK 2
PC07	PCS 612	CL 312	CS 648	3.0	M 8x1	17	TR 12	MT 05	HXK 3
PC06	–	CL 212	CS 626	2.0	M 6x1	13.4	–	–	HXK 2.5
PC08	PCS 619	CL 219	CS 610	3.5	M 10x1	27.2	TR 29	MT 06	HXK 4

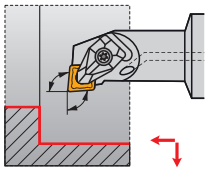
C.-DCLN(RL) INT

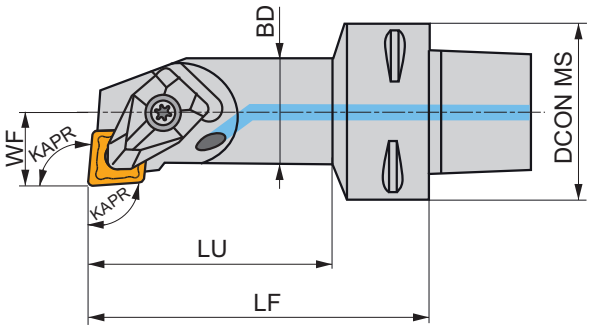
P M K N S H

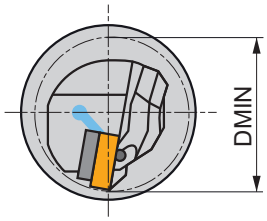
PRAMET

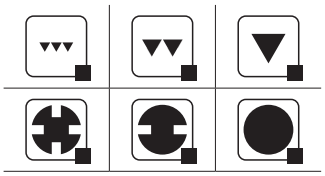
D

内孔PSC快换刀柄，双重夹紧，使用CN..刀片，主偏角为95°。
内孔左/右手双重刚性夹紧刀具，有内冷通道，主偏角为95°。使用CN..09至16的负前角刀片，广泛的应用于内孔车削。PSC刀柄尺寸从C4至C6，并可以选择长度。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	**C4-DCLNR-13080-09**	40	25	13	80	57	20	95	-14	-6	✓	0.43	GI133	DC09
R	**C4-DCLNR-17090-12**	40	32	17	90	68	25	95	-12	-6	✓	0.53	GI043	DCI12
R	**C5-DCLNR-17090-12**	50	32	17	90	66	25	95	-12	-6	✓	0.72	GI043	DCI12
R	**C6-DCLNR-17100-12**	63	32	17	100	72	25	95	-12	-6	✓	1.15	GI043	DCI12
R	**C6-DCLNR-27140-16**	63	50	27	140	114	40	95	-16	-6	✓	1.81	GI050	DC16
L	**C4-DCLNL-17090-12**	40	32	17	90	68	25	95	-12	-6	✓	0.53	GI043	DCI12
L	**C5-DCLNL-17090-12**	50	32	17	90	66	25	95	-12	-6	✓	0.72	GI043	DCI12

GI043	CN.. 1204..
GI050	CN.. 1606..
GI133	CN.. 0903..

		Nm				
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5	–

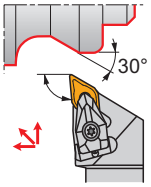
DDJN(RL) EXT

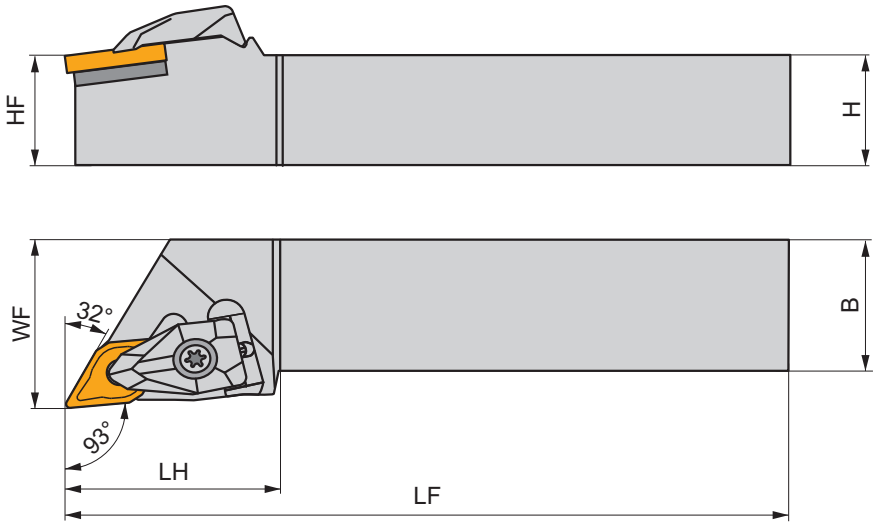
P M K N S H

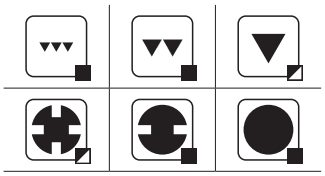
PRAMET

D

外圆用双重夹紧车刀杆，使用DN..刀片，主偏角为93°。
外圆用左/右手双重夹紧车刀杆，主偏角为93°。使用DN..11或15尺寸的负前角刀片。适用于有阶梯外圆的轴向车削，仿形，倒角和端面车削。可提供20x20至32x32mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg			
R	**DDJNR 2020 K 11**	20	20	20	25	125	30.2	-7	-6	0.41	GI046	DD11	–
	DDJNR 2525 M 11	25	25	25	32	150	30.2	-7	-6	0.74	GI046	DD11	–
	DDJNR 2020 K 15	20	20	20	25	125	39.4	-7	-6	0.42	GI044	DD154	AT002
	DDJNR 2525 M 15	25	25	25	32	150	39.4	-7	-6	0.74	GI044	DD154	AT002
	DDJNR 3225 P 15	32	25	32	32	170	39.4	-7	-6	1.07	GI044	DD154	AT002
	DDJNR 3232 P 15	32	32	32	40	170	39.4	-7	-6	1.33	GI044	DD154	AT002
L	**DDJNL 2020 K 11**	20	20	20	25	125	30.2	-7	-6	0.42	GI046	DD11	–
	DDJNL 2525 M 11	25	25	25	32	150	30.2	-7	-6	0.74	GI046	DD11	–
	DDJNL 2020 K 15	20	20	20	25	125	39.4	-7	-6	0.42	GI044	DD154	AT002
	DDJNL 2525 M 15	25	25	25	32	150	39.4	-7	-6	0.74	GI044	DD154	AT002
	DDJNL 3225 P 15	32	25	32	32	170	39.4	-7	-6	1.01	GI044	DD154	AT002
	DDJNL 3232 P 15	32	32	32	40	170	39.4	-7	-6	1.34	GI044	DD154	AT002

GI044	DN.. 1506..
GI046	DN.. 1104..

		Nm			
DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

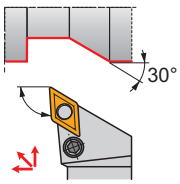
PDJN(RL) EXT

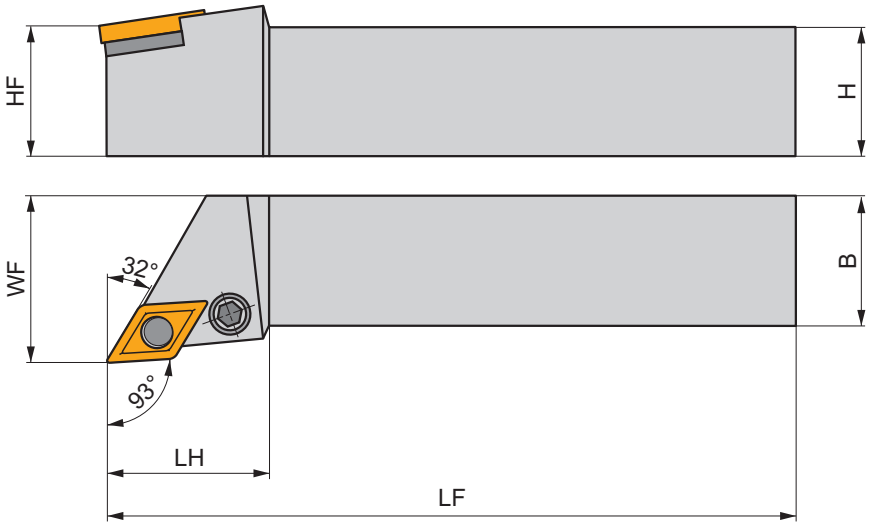
P M K N S H

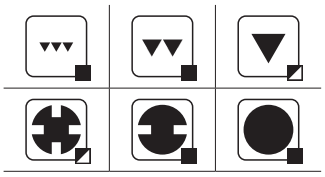
PRAMET

P

外圆用杠杆夹紧式车刀杆，使用DN..刀片，主偏角为93°。
外圆用左/右手杠杆夹紧式刀具刀杆，主偏角为93°。使用DN..11和15尺寸的负前角刀片。适用于有阶梯外圆的轴向车削，仿形车削角度最大为30°，和倒角车削。可提供为20x20至32x32mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PDJNR 2020 K 11**	20	20	20	25	125	28.0	-7	-6	0.40	GI046	PD02
R	**PDJNR 2525 M 11**	25	25	25	32	150	28.0	-7	-6	0.73	GI046	PD02
R	**PDJNR 2020 K 15**	20	20	20	25	125	34.0	-7	-6	0.39	GI044	PD01
R	**PDJNR 2525 M 15**	25	25	25	32	150	34.0	-7	-6	0.73	GI044	PD01
R	**PDJNR 3225 P 15**	32	25	32	32	170	34.0	-7	-6	1.04	GI044	PD01
R	**PDJNR 3232 P 15**	32	32	32	40	170	34.0	-7	-6	1.30	GI044	PD01
L	**PDJNL 2020 K 11**	20	20	20	25	125	28.0	-7	-6	0.40	GI046	PD02
L	**PDJNL 2525 M 11**	25	25	25	32	150	28.0	-7	-6	0.73	GI046	PD02
L	**PDJNL 2020 K 15**	20	20	20	25	125	40.0	-6	-6	0.42	GI044	PD01
L	**PDJNL 2525 M 15**	25	25	25	32	150	34.0	-7	-6	0.73	GI044	PD01
L	**PDJNL 3225 P 15**	32	25	32	32	170	34.0	-7	-6	0.98	GI044	PD01
L	**PDJNL 3232 P 15**	32	32	32	40	170	34.0	-7	-6	1.30	GI044	PD01

GI044	DN.. 1506..
GI046	DN.. 1104..

				Nm					
PD01	PDS 715	CL 415	CS 638	3.0	M 8x1	21.1	TR 12	MT 05	HXK 3
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5

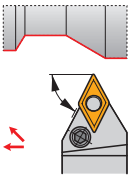
PDNN(RL) EXT

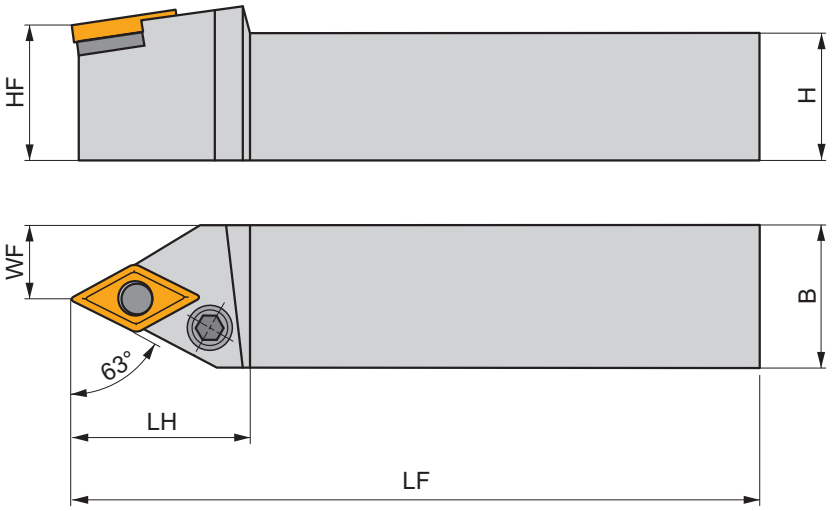
P M K N S H

PRAMET

P

外圆用杠杆夹紧式车刀杆，使用DN..刀片，主偏角为63°。
外圆用左/右手63°（中置）车刀杆。使用DN15..尺寸的负前角刀片。适用于无阶梯外圆的轴向车削，锥面，仿形和倒角车削。可提供20x20至32x25mm的PSC刀柄。刀杆经过处理，使用寿命更长。





	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PDNNR 2020 K 11**	20	20	20	10	125	28.0	-6	-6	0.37	GI046	PD02
	PDNNR 2525 M 11	25	25	25	12.5	150	25.0	-6	-6	0.60	GI046	PD02
	PDNNR 2525 M 15	25	25	25	12.5	150	34.0	-6	-6	0.69	GI044	PD01
	PDNNR 3225 P 15	32	25	32	12.5	170	34.0	-6	-6	1.00	GI044	PD01
L	**PDNNL 2020 K 11**	20	20	20	10	125	28.0	-6	-6	0.40	GI046	PD02
	PDNNL 2525 M 11	25	25	25	12.5	150	25.0	-6	-6	0.60	GI046	PD02
	PDNNL 2525 M 15	25	25	25	12.5	150	34.0	-6	-6	0.07	GI044	PD01
	PDNNL 3225 P 15	32	25	32	12.5	170	34.0	-6	-6	1.00	GI044	PD01

GI044	DN.. 1506..
GI046	DN.. 1104..

				Nm					
PD01	PDS 715	CL 415	CS 638	3.0	M 8x1	21.1	TR 12	MT 05	HXK 3
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5

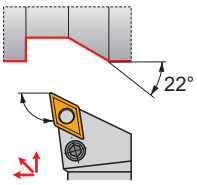
PDXN(RL) EXT

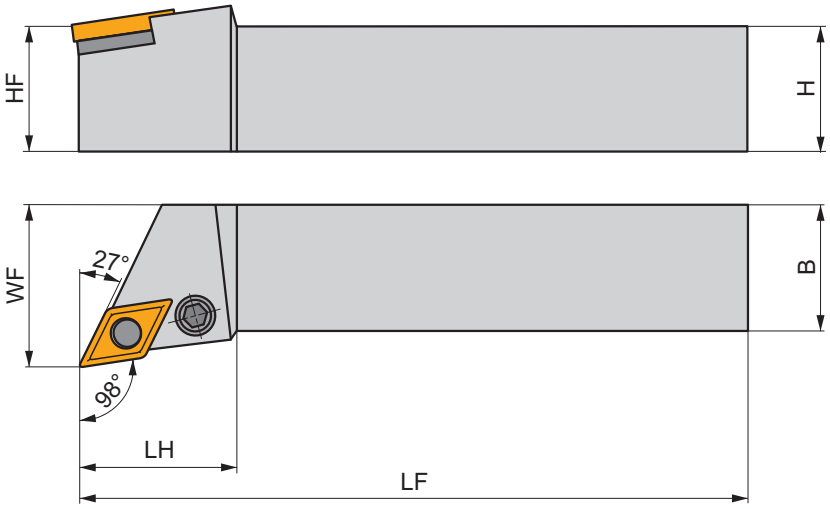
P M K N S H

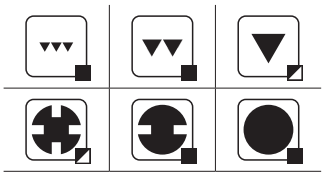
PRAMET

P

外圆用杠杆夹紧式车刀杆，使用DN..刀片，主偏角为98°。
外圆用左/右手杠杆夹紧式刀具刀杆，主偏角为98°。使用DN..15尺寸的负前角刀片。适用于锥面，有阶梯外圆的轴向车削，仿形车削角度最大为22°，和倒角车削。可提供20x20至32x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PDXNR 2020 K 15**	20	20	20	25	125	40.0	-6	-6	0.38	GI044	PD01
	PDXNR 2525 M 15	25	25	25	32	150	40.0	-6	-6	0.73	GI044	PD01
	PDXNR 3225 P 15	32	25	32	32	170	34.0	-8	-3	0.80	GI044	PD01
L	**PDXNL 2020 K 15**	20	20	20	25	125	34.0	-8	-3	0.40	GI044	PD01
	PDXNL 2525 M 15	25	25	25	32	150	34.0	-8	-3	0.71	GI044	PD01
	PDXNL 3225 P 15	32	25	32	32	170	34.0	-8	-3	0.95	GI044	PD01

GI044	DN.. 1506..

PD01	PDS 715	CL 415	CS 638	3.0 Nm	M 8x1	21.1	TR 12	MT 05	HXK 3

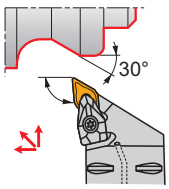
C.-DDJN(RL) EXT

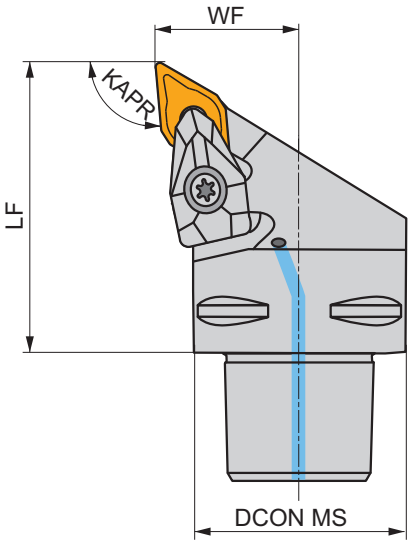
P M K N S H

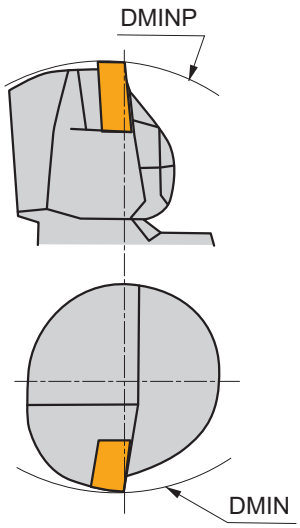
PRAMET

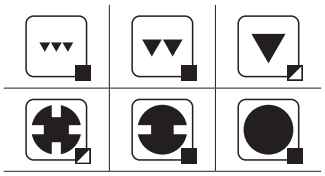
D

外圆用PSC快速更换式刀柄，双重夹紧，使用DN..刀片，主偏角为93°。
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为93°。使用DN..11或15尺寸的负前角刀片。适用于锥面，有阶梯外圆的轴向车削，仿形和倒角车削。可提供C4至C6刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C4-DDJNR-27050-11	40	60	140	27	50	93	-7	-6	✓	0.38	GI046	C-DD11	–
	C4-DDJNR-27055-15	40	110	145	27	55	93	-7	-6	✓	0.43	GI044	C-DD154-1	AT002
	C5-DDJNR-35060-15	50	110	165	35	60	93	-7	-6	✓	0.72	GI044	C-DD154-2	AT002
	C6-DDJNR-45065-15	63	110	190	45	65	93	-7	-6	✓	1.18	GI044	C-DD154-3	AT002
L	C4-DDJNL-27050-11	40	60	140	27	50	93	-7	-6	✓	0.39	GI046	C-DD11	–
	C4-DDJNL-27055-15	40	110	145	27	55	93	-7	-6	✓	0.43	GI044	C-DD154-1	AT002
	C5-DDJNL-35060-15	50	110	165	35	60	93	-7	-6	✓	0.72	GI044	C-DD154-2	AT002
	C6-DDJNL-45065-15	63	110	190	45	65	93	-7	-6	✓	1.18	GI044	C-DD154-3	AT002

GI044	DN.. 1506..
GI046	DN.. 1104..

		Nm				
C-DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P	CN 034-01
C-DD154-1	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DD154-2	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01
C-DD154-3	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

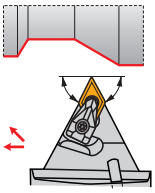
C.-DDNNN EXT

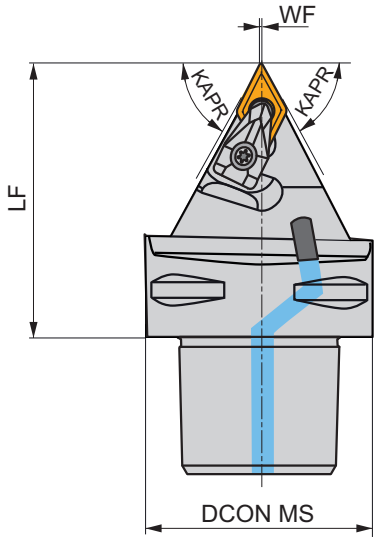
P M K N S H

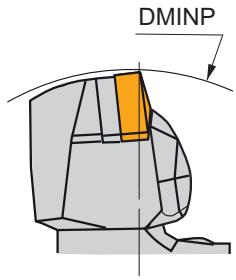
PRAMET

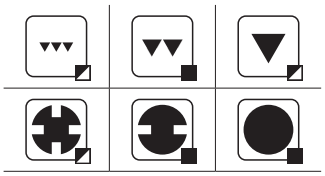
D

外圆用PSC快速更换式刀柄，双重夹紧，使用DN..刀片，主偏角为62.5°。
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为62.5°。使用DN..15尺寸的负前角刀片。适用于锥面和无阶梯外圆的轴向车削，仿形和倒角车削。可提供C5和C6刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
N	**C5-DDNNN-00060-15**	50	165	0.5	60	62.5	-9	-5	✓	0.62	GI044	C-DD154-2	AT002
	C6-DDNNN-00065-15	63	190	0.5	65	62.5	-9	-5	✓	1.06	GI044	C-DD154-2	AT002

GI044	DN.. 1506..

C-DD154-2	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

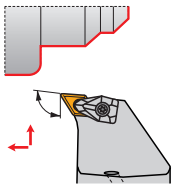
C.-DDUN(RL) EXT

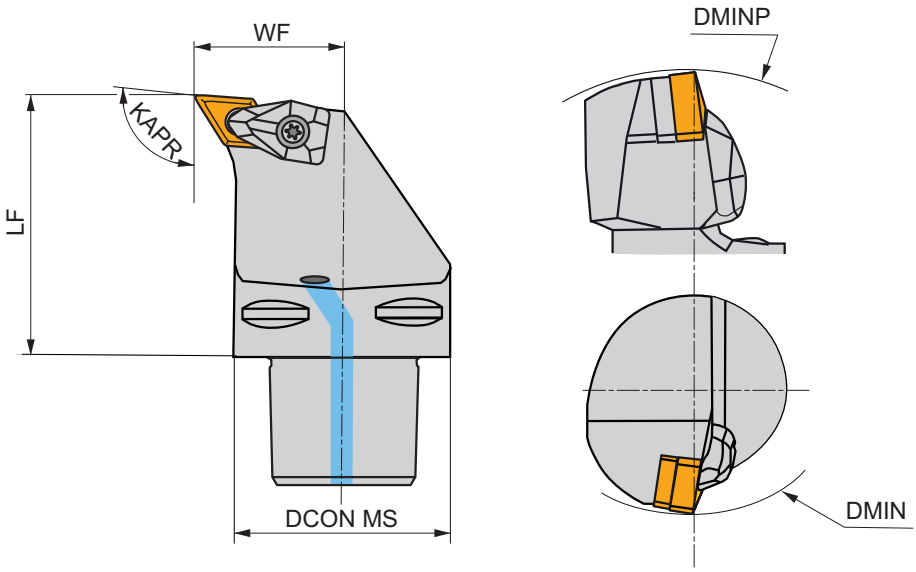
P M K N S H

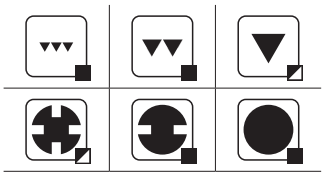
PRAMET

D

外圆用PSC快速更换式刀柄，双重夹紧，使用DN..刀片，主偏角为93°（端面）。
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为93°。使用DN..15尺寸的负前角刀片。适用于有阶梯外圆的端面车削，端面仿形，锥面，轴向车削和倒角车削。可提供C5和C6刀柄。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C5-DDUNR-35060-15	50	110	165	35	60	93	-7	-6	✓	0.82	GI044	C-DD154-3	AT002
R	C6-DDUNR-45065-15	63	110	190	45	65	93	-7	-6	✓	1.39	GI044	C-DD154-3	AT002
L	C5-DDUNL-35060-15	50	110	165	35	60	93	-7	-6	✓	0.82	GI044	C-DD154-3	AT002

GI044	DN.. 1506..

C-DD154-3	DCS 12	3.9 Nm	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

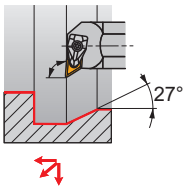
DDUN(RL) INT

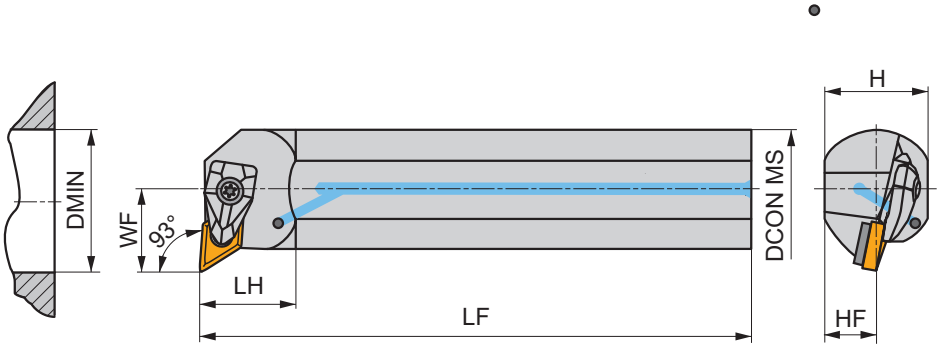
P M K N S H

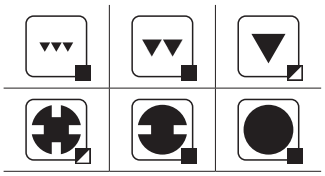
PRAMET

D

内孔双重刚性夹紧镗杆，使用DN..刀片，主偏角为93°。
内孔左/右手双重刚性夹紧镗杆，有内冷通道，主偏角为93°，使用DN..刀片。广泛的应用于内孔车削，仿形车削角度最大为27°。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg			
R	**A25T-DDUNR 11**	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNR 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI046	DD11	–
	A40T-DDUNR 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.58	GI044	DD154	AT002
	A50U-DDUNR 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.23	GI044	DD154	AT002
L	**A25T-DDUNL 11**	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNL 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.69	GI046	DD11	–
	A40T-DDUNL 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.59	GI044	DD154	AT002
	A50U-DDUNL 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.25	GI044	DD154	AT002

GI044	DN.. 1506..
GI046	DN.. 1104..

		Nm			
DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

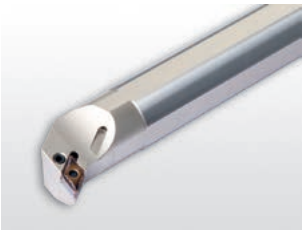
AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

PDUN(RL) INT

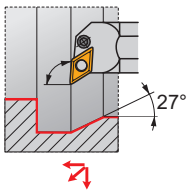
P M K N S H

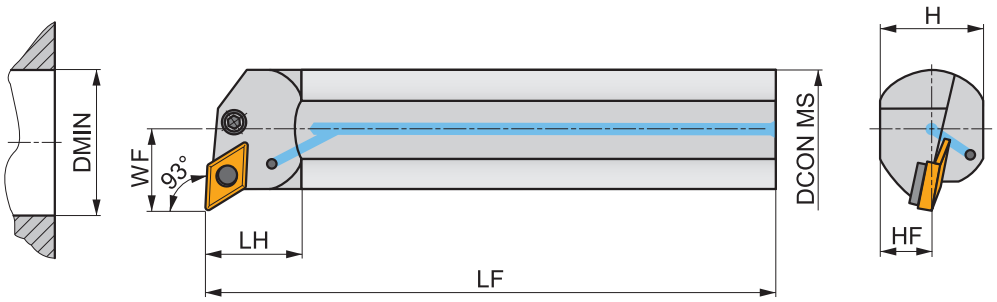
PRAMET

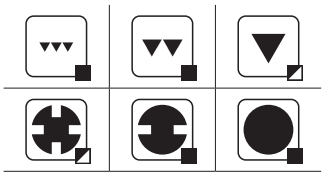
P



外圆用杠杆夹紧式车刀杆，使用DN..刀片，主偏角为93°。
内孔左/右手杠杆夹紧式镗杆，有内冷通道，主偏角为93°，使用DN..刀片。广泛的应用于内孔车削，仿形车削角度最大为27°。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A25R-PDUNR 11**	25	31	17	23	–	200	-14	-5	✓	0.70	GI046	PD02
R	**A32S-PDUNR 11**	32	39	22	30	–	250	-14	-5	✓	1.42	GI046	PD02
R	**A32S-PDUNR 15**	32	39	22	30	–	250	-14	-4	✓	1.44	GI097	PD04
R	**A40T-PDUNR 15**	40	48	27	37	–	300	-11	-6	✓	2.40	GI097	PD03
R	**A50U-PDUNR 15**	50	61	35	47	–	350	-14	-4	✓	4.95	GI097	PD03
R	**A60V-PDUNR 15**	60	80	43	57	–	400	-14	-4	✓	8.22	GI097	PD03
L	**A25R-PDUNL 11**	25	31	17	23	–	200	-14	-5	✓	0.70	GI046	PD02
L	**A32S-PDUNL 11**	32	39	22	30	–	250	-14	-5	✓	1.42	GI046	PD02
L	**A32S-PDUNL 15**	32	39	22	30	–	250	-14	-4	✓	1.44	GI097	PD04
L	**A40T-PDUNL 15**	40	48	27	37	–	300	-11	-6	✓	2.56	GI097	PD03
L	**A60V-PDUNL 15**	60	80	43	57	–	400	-14	-4	✓	8.16	GI097	PD03

GI044	DN.. 1506..
GI046	DN.. 1104..

				Nm							
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5	–	–
PD03	PDS 715	CL 415	CS 638	3.0	M 8x1	21.1	TR 12	MT 05	HXK 3	PDS 725	TR 35
PD04	PDS 715	CL 415	CS 648	3.0	M 8x1	17	TR 12	MT 05	HXK 3	PDS 725	TR 35

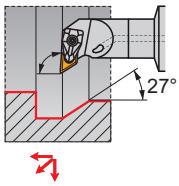
C.-DDUN(RL) INT

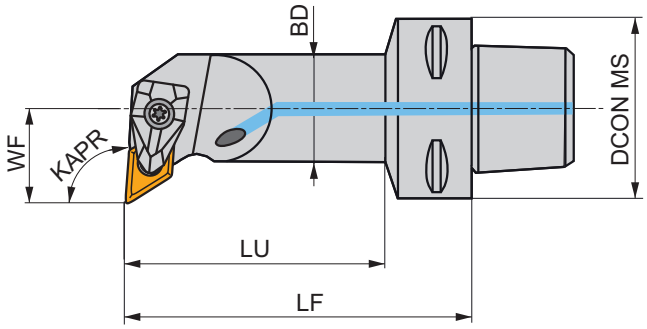
P M K N S H

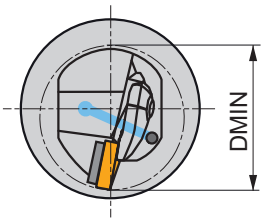
PRAMET

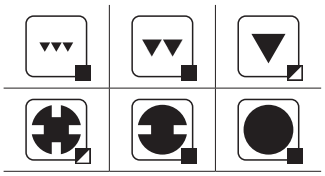
D

内孔用PSC快速更换式刀柄，双重夹紧，使用DN..刀片，主偏角为93°。
内孔左/右手双重刚性夹紧刀具，有内冷通道，主偏角为93°，使用DN..11刀片。适用于内孔车削应用，仿形车削角度最大为27°。可提供C4的PSC刀柄，车削长度为68mm。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DDUNR-17090-11	40	32	17	90	68	25	93	-12	-6	✓	0.51	GI046	DD11
L	C4-DDUNL-17090-11	40	32	17	90	68	25	93	-12	-6	✓	0.51	GI046	DD11

GI046	DN.. 1104..

DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P

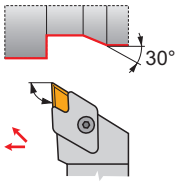
CKJN(RL) EXT

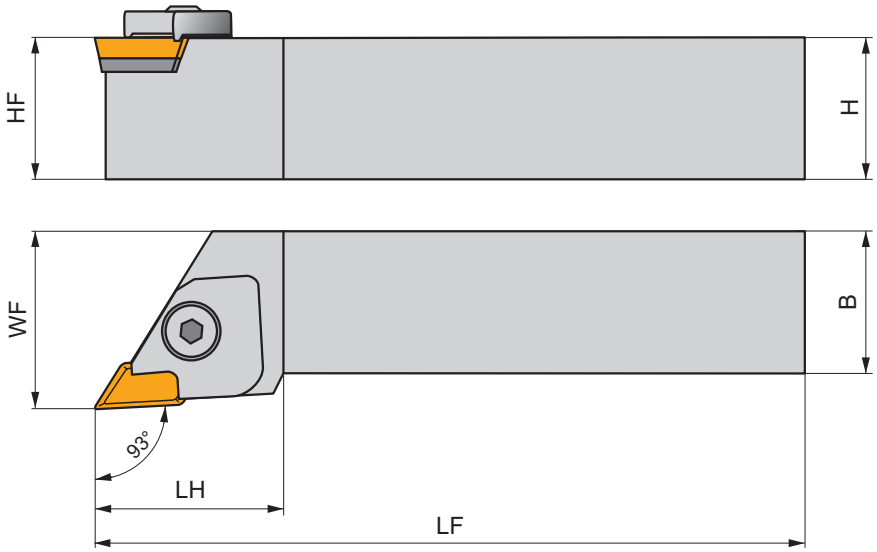
P M K N S H

PRAMET

C

外圆用顶部夹紧车削刀杆，使用KN..16刀片，主偏角为93°。
外圆用左/右手顶部加紧车刀杆，主偏角为93°。使用KN..16尺寸的负前角刀片。适用于锥面，有阶梯外圆的轴向车削，仿形车削角度最大为30°，和倒角车削。可提供20x20至32x25mm的刀柄。刀杆经过处理，使用寿命更长。





Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R											
CKJNR 2020 K 16	20	20	20	30	125	34.0	1	-5	0.40	GI066	R1
CKJNR 2525 M 16	25	25	25	32	150	34.0	1	-5	0.70	GI066	R
CKJNR 3225 P 16	32	25	32	32	170	34.0	1	-5	1.06	GI066	R
L											
CKJNL 2020 K 16	20	20	20	30	125	34.0	1	-5	0.42	GI067	L1
CKJNL 2525 M 16	25	25	25	32	150	34.0	1	-5	0.74	GI067	L
CKJNL 3225 P 16	32	25	32	32	170	34.0	1	-5	1.06	GI067	L

GI066	KN.X 1604…R
GI067	KN.X 1604…L

						Nm					
L	KNN 190412L	NT 03	–	UP 26	US 83	6.0	–	–	PR 07	K 23	HXK 4
L1	KNN 190412L	NT 03	–	UP 26	US 83	6.0	–	–	PR 07	K 22	HXK 4
R1	KNN 190412R	NT 03	UP 25	–	US 83	6.0	–	–	PR 07	K 22	HXK 4

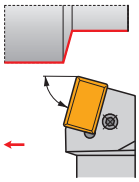
PLBN(RL) EXT

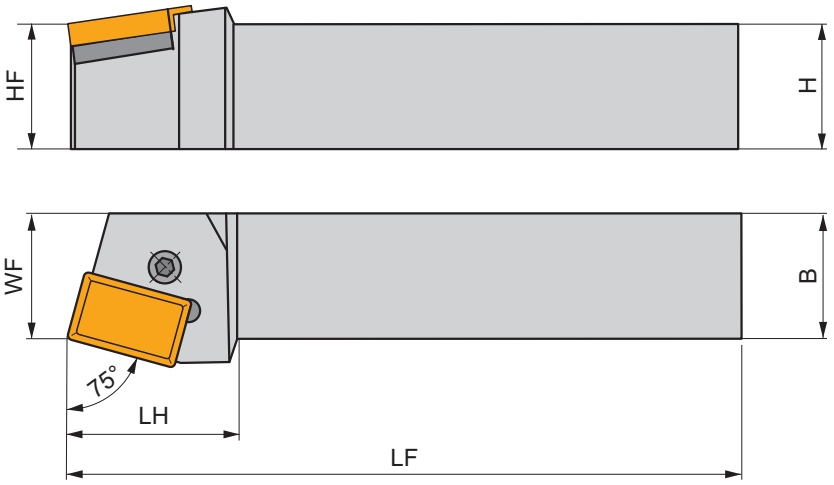
P M K

PRAMET

P

外圆用杠杆夹紧式重载车刀杆，使用LNUX刀片，主偏角为75°。
外圆用左/右手杠杆夹紧式刀具刀杆，主偏角为75°。可重载车削。使用LN..40和50尺寸的负前角刀片。适用于无阶梯外圆的轴向车削，锥面和倒角车削。可提供60x60mm的刀柄。刀杆经过处理，使用寿命更长。





Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R											
PLBNR 6060 V 40-A	60	60	60	60	400	64.0	-6	-6	13.00	GI102	PL71
PLBNR 6060 V 50	60	60	60	60	400	70.0	-6	-6	12.75	GI145	PL72
PLBNR 6060 V 50-2	60	60	60	60	400	70.0	-6	-6	11.60	GI291	PL73
L											
PLBNL 6060 V 40-A	60	60	60	60	400	64.0	-6	-6	11.14	GI102	PL71
PLBNL 6060 V 50	60	60	60	60	400	70.0	-6	-6	13.09	GI145	PL72

GI102	LNUX 40....
GI145	LNUX 50....
GI291	LNMX 50....

				Nm							
PL71	LNX 400632	PU 06	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5	–	–
PL72	LNX 500632	PU 06	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5	–	–
PL73	LNX 500432P	–	–	–	–	–	–	–	–	UP 1515A-T15P	SDR T15P

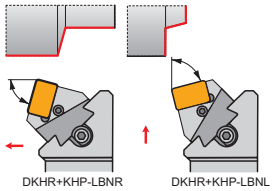
KHP-LBN(RL)

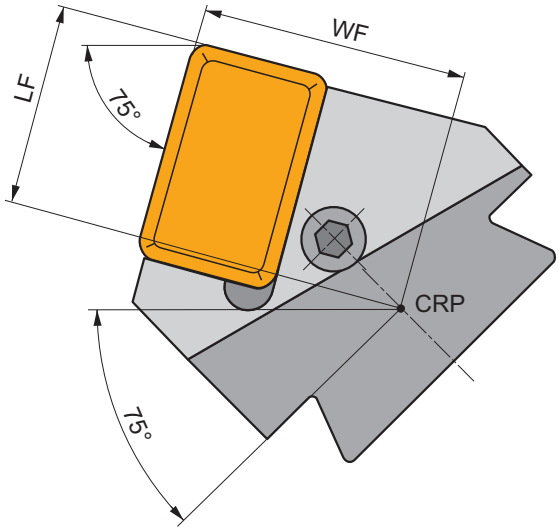
P M K

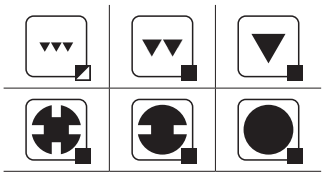
PRAMET

P

模块化KHP杠杆夹紧式车刀刀夹，使用LNUX刀片，主偏角为75°
燕尾形左/右手杠杆夹紧车刀夹，主偏角为75°。安装在DKH刀杆上。使用LNUX40负前角刀片。适用于无阶梯外圆的重载轴向车削，锥面和倒角车削。车刀杆经过处理，使用寿命更长。







	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
L	**KHP-LBNR 40-A**	48	36	-6	-6	1.50	GI102	PL71
	KHP-LBNL 40-A	48	36	-6	-6	1.47	GI102	PL71

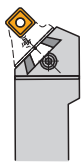
GI102	LNUX 40....

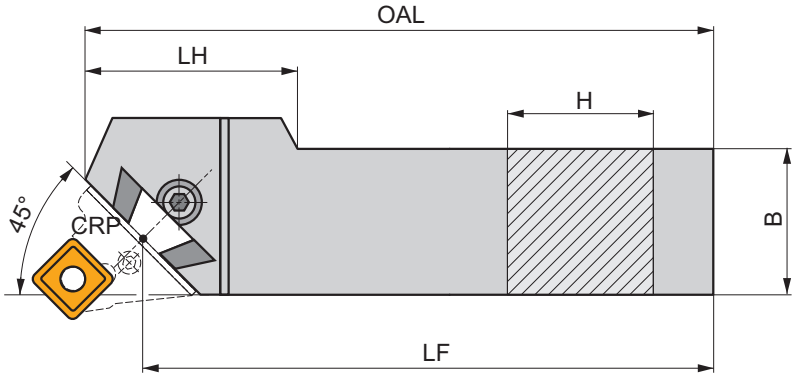
PL71	LNX 400632	PU 06	PS 12040	8.0 Nm	M 12x1	40	NT 08	MT 08	HXK 5

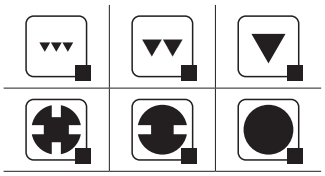
DKH(RL)

PRAMET

使用KHP/KHS重载车刀刀夹的外圆用刀柄
燕尾形左/右手模块化刀杆，使用KHP/KHS刀夹。适用于重载车削应用。可提供40x50至60x80mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

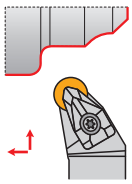
DRSN(RL) EXT

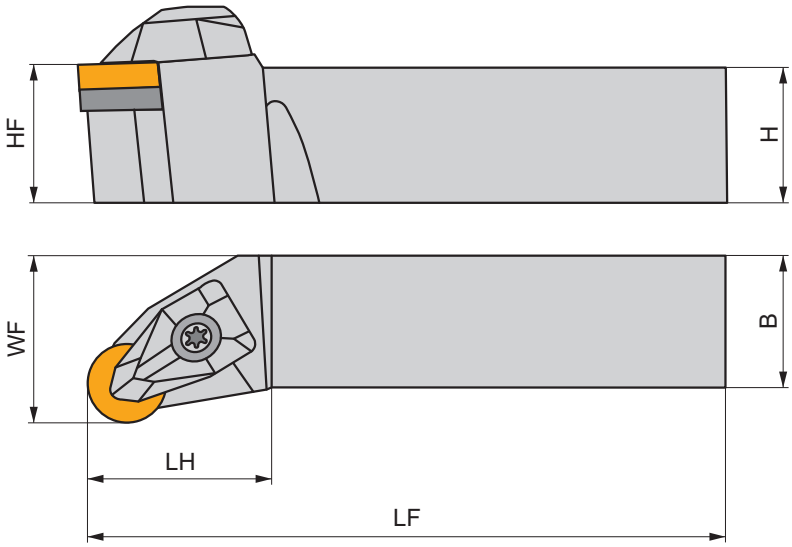
P M K H

PRAMET

D

外圆用双重夹紧刀杆，使用RN..刀片。
外圆用左/右手双重夹紧车刀杆。使用圆形RN..12尺寸的负前角刀片。适用于无阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。





Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R DRSNR 2525 M 12	25	25	25	32	150	31.6	-6	-6	0.74	GI083	DR12
L DRSNL 2525 M 12	25	25	25	32	150	31.6	-6	-6	0.75	GI083	DR12

GI083	RN.. 120400

DR12	DCS 12	3.9	DRS 155-02	US 2002-T15P	FLAG T15P/3,5

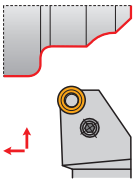
PRSN(RL) EXT

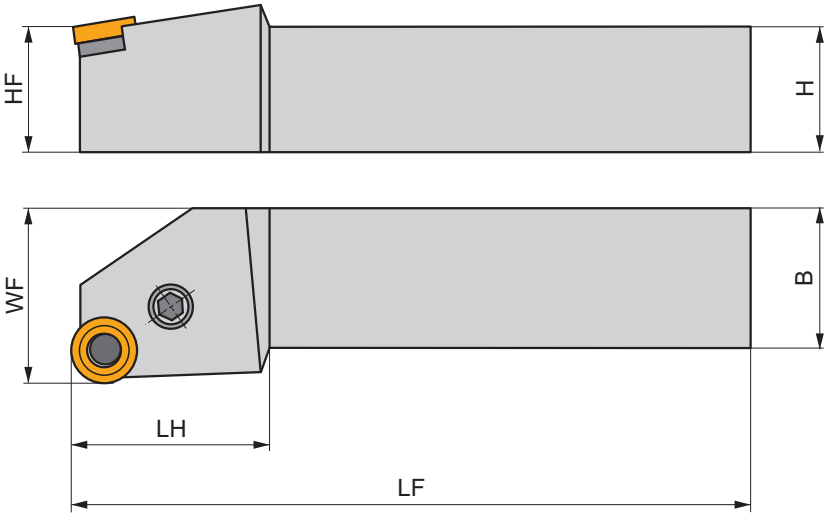
P M K H

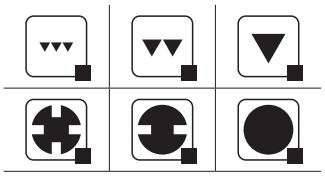
PRAMET

P

外圆用杠杆夹紧式车刀杆，使用RN..刀片。
外圆用左/右手杠杆夹紧式车刀杆。使用圆形RN..12、15和19尺寸的负前角刀片。适用于轴向车削，仿形车削角度最大为90°，锥面和倒角车削，可提供25x25至40x40mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PRSNR 2525 M 12**	25	25	25	32	150	28.0	-6	-6	0.68	GI083	PR05
	PRSNR 3225 P 15	32	25	32	32	170	34.0	-6	-6	1.00	GI105	PR06
	PRSNR 4040 S 19	40	40	40	50	250	45.0	-6	-6	2.49	GI106	PR07
L	**PRSNL 2525 M 12**	25	25	25	32	150	28.0	-6	-6	0.74	GI083	PR05
	PRSNL 3225 P 15	32	25	32	32	170	34.0	-6	-6	1.00	GI105	PR06
	PRSNL 4040 S 19	40	40	40	50	250	45.0	-6	-6	2.49	GI106	PR07

GI083	RN.. 120400
GI105	RN.. 150600
GI106	RN.. 190600

				Nm					
PR05	PRS 912	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PR06	PRS 915	CL 015	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3
PR07	PRS 919	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4

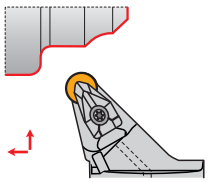
C.-DRSN(RL) EXT

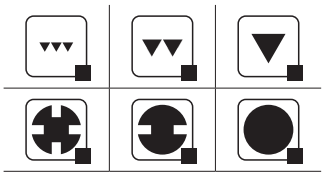
P M K H

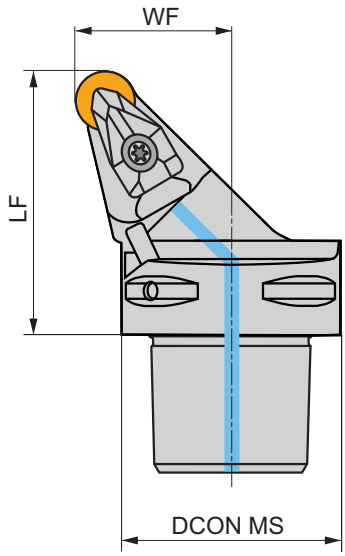
PRAMET

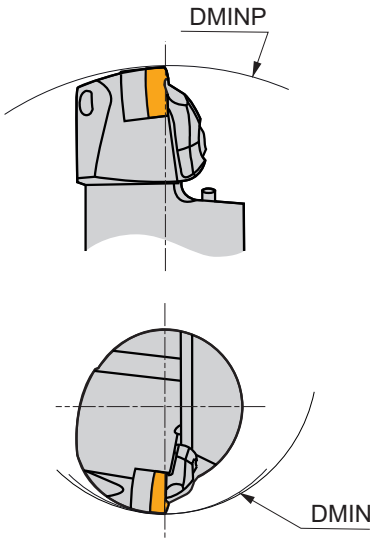
D

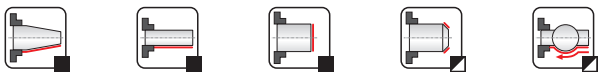
外圆用PSC快速更换式刀柄，双重夹紧，使用RN..刀片。
外圆用左/右手双重夹紧紧刀具，有内冷通道，使用圆形RN..12尺寸负前角刀片。适用于无阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供C6刀柄。刀杆经过处理，使用寿命更长。











	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg			
R	**C6-DRSNR-45065-12**	63	110	190	45	65	-6	-6	✓	1.11	GI083	C-DR12	–
L	**C6-DRSNL-45065-12**	63	110	190	45	65	-6	-6	✓	1.10	GI083	C-DR12	–

GI083	RN.. 120400

C-DR12	DCS 12	3.9	DRS 155-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01

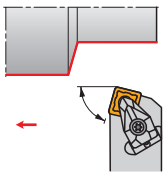
DSBN(RL) EXT

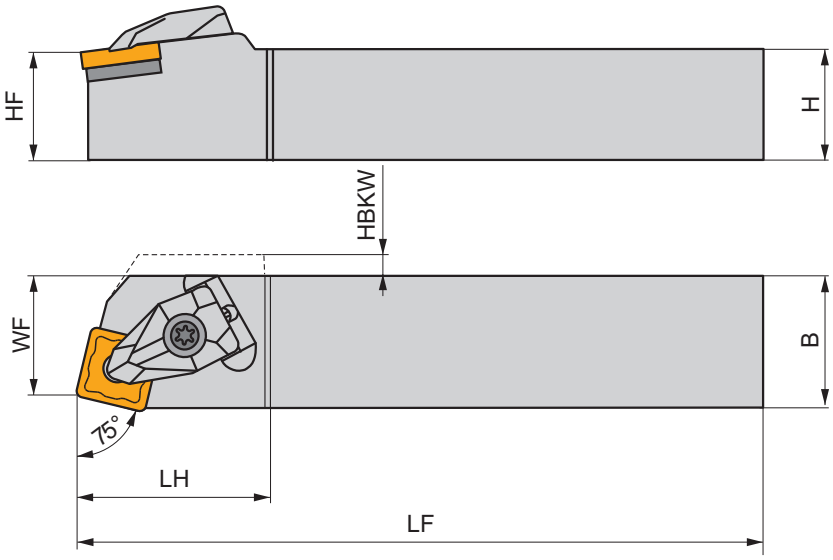
P M K N S H

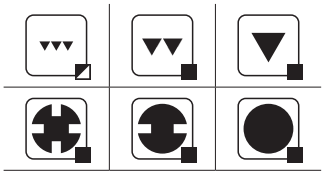
PRAMET

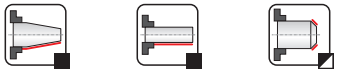
D

外圆用双重夹紧车刀杆，使用SN..刀片，主偏角为75°。
外圆用左/右手双重夹紧车刀杆，主偏角为75°。使用SN..12、15或19尺寸的负前角刀片，适用于无阶梯外圆的轴向车削，锥面和倒角车削。可提供20x20至40x40mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	**DSBNR 2525 M 12**	25	25	25	22	150	34.3	–	-6	-6	0.74	GI029	DS12	AT003
	DSBNR 2525 M 15	25	25	25	22	150	41.6	2	-6	-6	0.80	GI082	DS15	AT006
	DSBNR 3225 P 15	32	25	32	22	170	41.7	2	-6	-6	1.07	GI082	DS15	AT006
	DSBNR 3232 P 19	32	32	32	27	170	46.4	–	-6	-6	1.38	GI026	DS19	–
	DSBNR 4040 S 19	40	40	40	35	250	46.5	–	-6	-6	3.14	GI026	DS19	–
L	**DSBNL 2525 M 12**	25	25	25	22	150	34.3	–	-6	-6	0.74	GI029	DS12	AT003
	DSBNL 2525 M 15	25	25	25	22	150	41.6	2	-6	-6	0.80	GI082	DS15	AT006
	DSBNL 3225 P 15	32	25	32	22	170	41.7	2	-6	-6	1.12	GI082	DS15	AT006
	DSBNL 4040 S 19	40	40	40	35	250	46.5	–	-6	-6	3.18	GI026	DS19	–

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

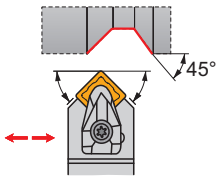
DSDNN EXT

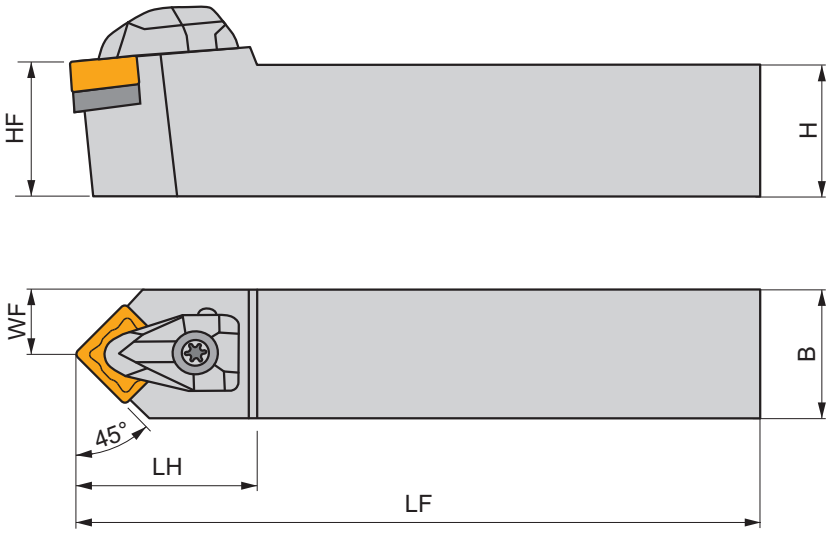
P M K N S H

PRAMET

D

外圆用双重夹紧车刀杆，使用SN..刀片，主偏角为45°。
外圆用中置双重夹紧车刀杆，主偏角为45°。使用SN..15、19或25负前角刀片，适用于无阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供25x25至40x40mm的刀柄。刀杆经过处理，使用寿命更长。





Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg			
N												
DSDNN 2525 M 12	25	25	25	12.8	150	36.5	-6	-6	0.74	GI029	DS12	AT003
DSDNN 2525 M 15	25	25	25	12.8	150	44.8	-6	-6	0.76	GI082	DS15	AT006
DSDNN 3232 P 19	32	32	32	16.5	170	49.5	-6	-6	1.35	GI026	DS19	–
DSDNN 4040 S 25	40	40	40	21	250	57.2	-6	-6	3.13	GI027	DS25	–

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P
DS25	DCS 25	9.5	DSS 425-07	US 2008-T25P	–	LK T25P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

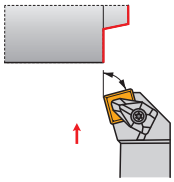
DSKN(RL) EXT

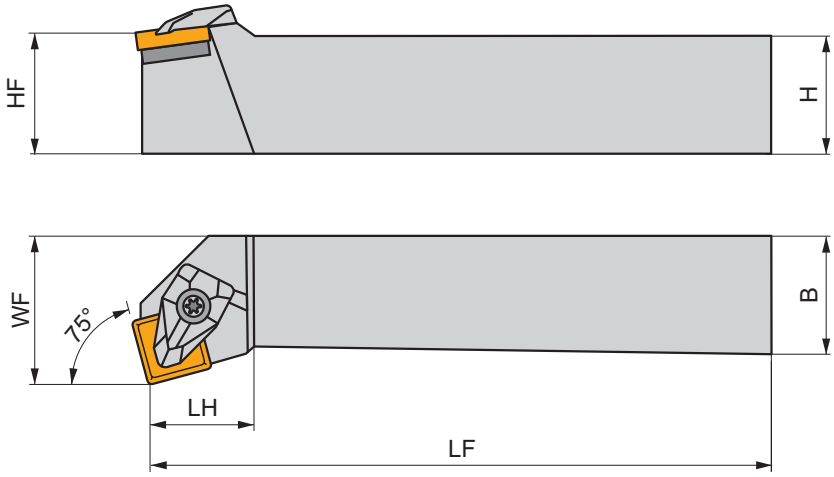
P M K N S H

PRAMET

D

外圆用双重夹紧车刀杆，使用SN..刀片，主偏角为75°（端面）。
外圆用左/右手双重夹紧车刀杆，主偏角为75°。使用SN..12..或19...尺寸刀片。适用于无阶梯端面，倒角车削。可提供25x25至32x32mm的刀柄。刀杆经过处理，使用寿命更长。





	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg			
R	**DSKNR 2525 M 12**	25	25	25	32	150	23.6	-6	-6	0.77	GI029	DS12	AT003
R	**DSKNR 3232 P 19**	32	32	32	40	170	32.1	-6	-6	1.46	GI026	DS19	–
L	**DSKNL 2525 M 12**	25	25	25	32	150	23.6	-6	-6	0.79	GI029	DS12	AT003
L	**DSKNL 3232 P 19**	32	32	32	40	170	32.1	-6	-6	1.46	GI026	DS19	–

GI029	SN.. 1204..
GI026	SN.. 1906..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

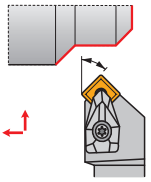
DSSN(RL) EXT

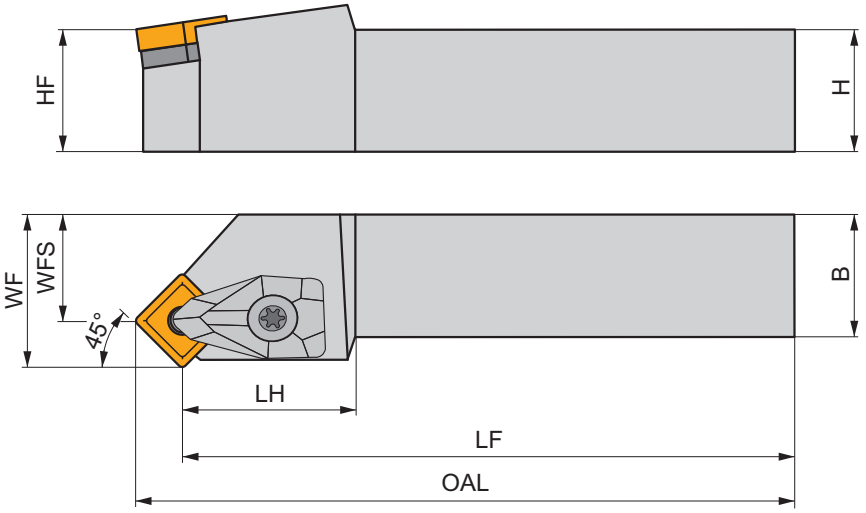
P M K N S H

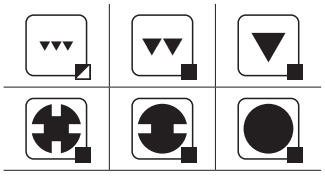
PRAMET

D

外圆用双重夹紧车刀杆，使用SN..刀片，主偏角为45°。
外圆用左/右手双重夹紧车刀杆，主偏角为45°。使用SN..12、15或19尺寸的负前角刀片。适用于轴向和无阶梯端面，锥面，仿形车削和倒角车削。可提供20x20至40x40mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	WFS (mm)	LF (mm)	OAL (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg			
R	**DSSNR 2020 K 12**	20	20	20	25	16.7	125	133.3	27.5	0	-8	0.45	GI029	DS12	AT003
	DSSNR 2525 M 12	25	25	25	32	23.7	150	158.3	27.5	0	-8	0.80	GI029	DS12	AT003
	DSSNR 2525 M 15	25	25	25	32	21.8	150	160.2	32.0	0	-8	0.83	GI082	DS15	AT006
	DSSNR 3225 P 15	32	25	32	32	21.8	170	180.2	34.9	0	-8	1.16	GI082	DS15	AT006
	DSSNR 3232 P 19	32	32	32	40	27.5	170	182.5	37.0	0	-8	1.48	GI026	DS19	–
L	**DSSNL 2525 M 12**	25	25	25	32	23.7	150	158.3	27.5	0	-8	0.19	GI029	DS12	AT003
	DSSNL 2525 M 15	25	25	25	32	21.8	150	160.2	32.0	0	-8	0.83	GI082	DS15	AT006
	DSSNL 3225 P 15	32	25	32	32	21.8	170	180.2	34.9	0	-8	1.16	GI082	DS15	AT006
	DSSNL 3232 P 19	32	32	32	40	27.5	170	182.5	37.0	0	-8	1.48	GI026	DS19	–
	DSSNL 4040 S 19	40	40	40	50	37.5	250	262.5	37.7	0	-8	3.27	GI026	DS19	–

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

PSBN(RL) EXT

P M K N S H

PRAMET

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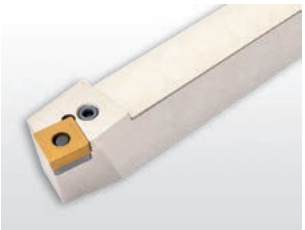
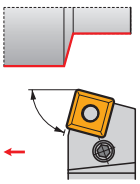
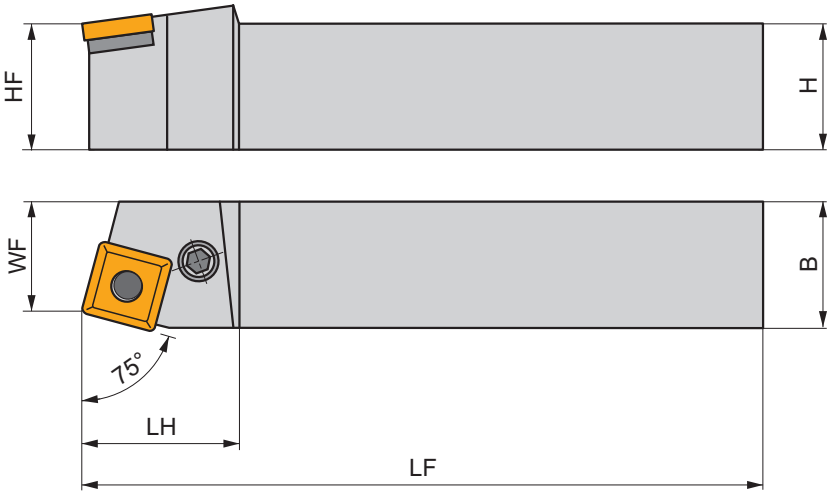
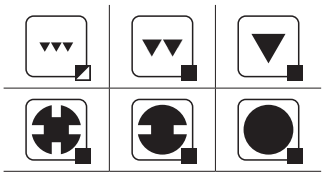
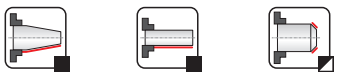


外圆用杠杆夹紧式车刀杆，使用SN..刀片，主偏角为75°。
外圆用左/右手杠杆夹紧式刀具刀杆，主偏角为75°。使用SN..12、15、19或25尺寸的负前角刀片。适用于无阶梯外圆的轴向车削，锥面和倒角车削。可提供20x20至50x50mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PSBNR 2020 K 12**	20	20	20	17	125	36.0	-6	-6	0.42	GI029	PS01
	PSBNR 2525 M 12	25	25	25	22	150	28.0	-6	-6	0.74	GI029	PS01
	PSBNR 3232 P 15	32	32	32	27	170	34.0	-6	-6	1.33	GI082	PS04
	PSBNR 3232 P 19	32	32	32	27	170	42.0	-6	-6	1.30	GI026	PS02
	PSBNR 4040 S 19	40	40	40	35	250	48.0	-6	-6	3.10	GI026	PS02
	PSBNR 4040 S 25	40	40	40	35	250	48.0	-6	-6	2.85	GI027	PS03
	PSBNR 4040 S 2509	40	40	40	35	250	48.0	-6	-6	2.50	GI040	PS03
	PSBNR 4040 S 2512	40	40	40	35	250	48.0	-6	-6	3.00	GI162	PS05
	PSBNR 5050 T 2512	50	50	50	43	300	50.0	-6	-6	5.78	GI162	PS05
	PSBNR 5050 T 25	50	50	50	43	300	50.0	-6	-6	5.76	GI027	PS03
	PSBNR 5050 T 2509	50	50	50	43	300	50.0	-6	-6	5.50	GI040	PS03
L	**PSBNL 2020 K 12**	20	20	20	17	125	28.0	-6	-6	0.40	GI029	PS01
	PSBNL 2525 M 12	25	25	25	22	150	28.0	-6	-6	0.73	GI029	PS01
	PSBNL 3232 P 15	32	32	32	27	170	34.0	-6	-6	1.33	GI082	PS04
	PSBNL 4040 S 2512	40	40	40	35	250	48.0	-6	-6	3.11	GI162	PS05
	PSBNL 5050 T 2512	50	50	50	43	300	50.0	-6	-6	5.76	GI162	PS05
	PSBNL 3232 P 19	32	32	32	27	170	42.0	-6	-6	1.33	GI026	PS02
	PSBNL 4040 S 19	40	40	40	35	250	48.0	-6	-6	3.09	GI026	PS02
	PSBNL 4040 S 25	40	40	40	35	250	48.0	-6	-6	3.06	GI027	PS03
	PSBNL 4040 S 2509	40	40	40	35	250	50.0	-6	-6	2.50	GI040	PS03
	PSBNL 5050 T 25	50	50	50	43	300	50.0	-6	-6	5.84	GI027	PS03
	PSBNL 5050 T 2509	50	50	50	43	300	50.0	-6	-6	5.80	GI040	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..

GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..
GI162	SN.. 2512..

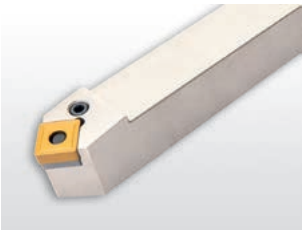
				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PS05	SNU 250624	PU 10-N	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5

PSDNN EXT

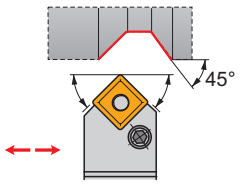
P M K N S H

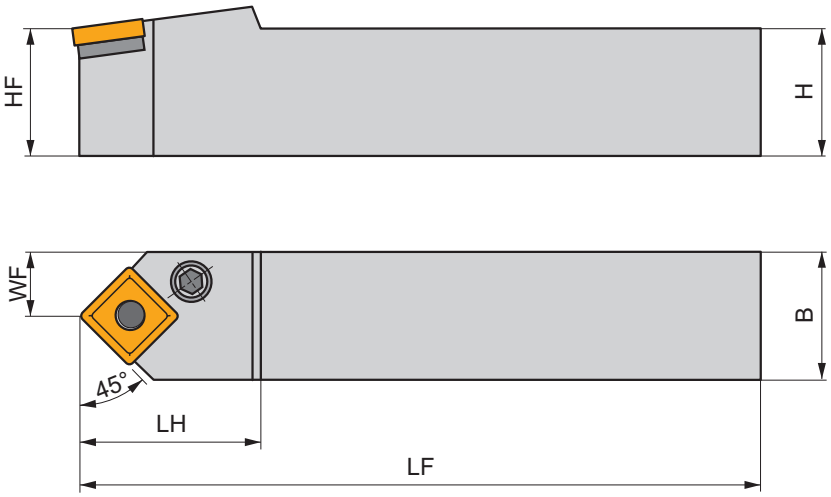
PRAMET

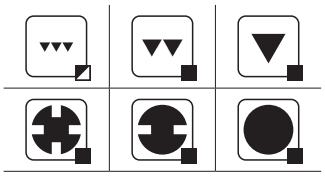
P



外圆用杠杆夹紧式车刀杆，使用SN..刀片，主偏角为45°。
外圆用中置杠杆夹紧式车刀杆，主偏角为45°。使用SN..12、15、19或25尺寸的负前角刀片。适用于无阶梯外圆的轴向切削，仿形和锥面车削，倒角车削。可提供20x20至50x50mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	**PSDNN 2020 K 12**	20	20	20	10	125	28.0	-5	-5	0.39	GI029	PS01
	PSDNN 2525 M 12	25	25	25	12.5	150	28.0	-5	-5	0.68	GI029	PS01
	PSDNN 3232 P 15	32	32	32	16	170	34.0	-5	-5	1.30	GI082	PS04
	PSDNN 3232 P 19	32	32	32	16	170	42.0	-5	-5	1.25	GI026	PS02
	PSDNN 4040 S 19	40	40	40	20	250	42.0	-5	-5	3.03	GI026	PS02
	PSDNN 4040 S 25	40	40	40	20	250	48.0	-5	-5	3.02	GI027	PS03
	PSDNN 5050 T 25	50	50	50	25	300	50.0	-5	-5	5.65	GI027	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..

				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3

PSKN(RL) EXT

P M K N S H

PRAMET

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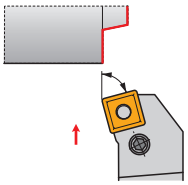
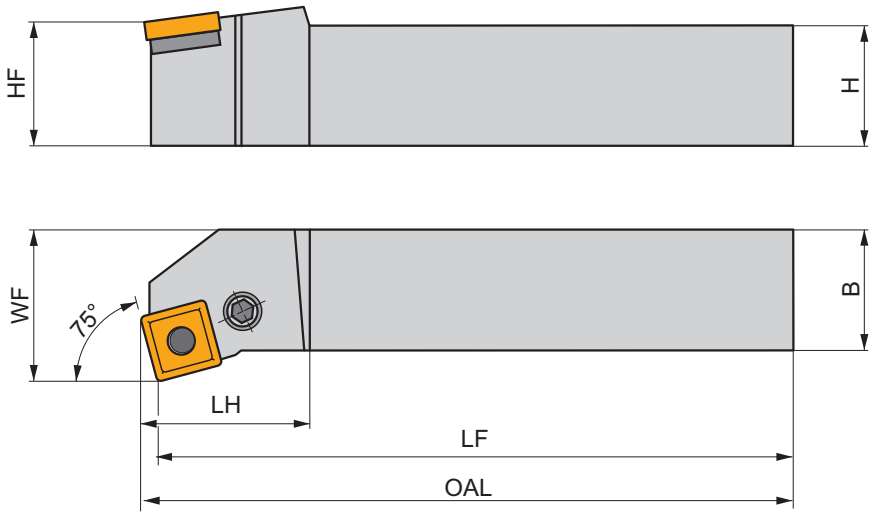
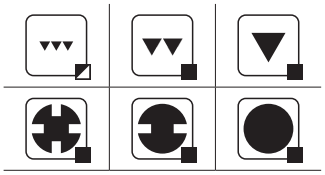
外圆用杠杆锁车削刀杆，使用SN..刀片，主偏角为75°（端面车削）。
外圆用左/右手杠杆夹紧式刀具刀杆，主偏角为75°。使用SN..12、15、19或25尺寸的负前角刀片。适用于无阶梯外圆的倒角和倒角车削。可提供20x20至50x50mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	OAL	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PSKNR 2020 K 12**	20	20	20	25	125	128.1	28.0	-6	-6	0.42	GI029	PS01
	PSKNR 2525 M 12	25	25	25	32	150	153.1	28.0	-6	-6	0.76	GI029	PS01
	PSKNR 3232 P 19	32	32	32	40	170	174.6	45.0	-6	-6	1.40	GI026	PS02
	PSKNR 4040 S 19	40	40	40	50	250	254.6	45.0	-6	-6	3.23	GI026	PS02
	PSKNR 4040 S 25	40	40	40	50	250	256.5	50.0	-6	-6	3.28	GI027	PS03
	PSKNR 3232 P 15	32	32	32	40	170	173.9	42.0	-6	-6	1.40	GI082	PS04
	PSKNR 5050 T 25	50	50	50	60	300	306.5	50.0	-6	-6	6.05	GI027	PS03
	PSKNR 5050 T 2509	50	50	50	60	300	306.5	50.0	-6	-6	6.20	GI040	PS03
L	**PSKNL 2020 K 12**	20	20	20	25	125	128.1	28.0	-6	-6	0.42	GI029	PS01
	PSKNL 2525 M 12	25	25	25	32	150	153.1	28.0	-6	-6	0.79	GI029	PS01
	PSKNL 3232 P 15	32	32	32	40	170	173.9	42.0	-6	-6	1.05	GI082	PS04
	PSKNL 3232 P 19	32	32	32	40	170	174.6	42.0	-6	-6	1.41	GI026	PS02
	PSKNL 4040 S 19	40	40	40	50	250	254.6	45.0	-6	-6	3.26	GI026	PS02
	PSKNL 4040 S 25	40	40	40	50	250	256.5	50.0	-6	-6	3.28	GI027	PS03
	PSKNL 5050 T 25	50	50	50	60	300	306.5	50.0	-6	-6	6.00	GI027	PS03
	PSKNL 5050 T 2509	50	50	50	60	300	306.5	50.0	-6	-6	6.20	GI040	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..

				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3

PSSN(RL) EXT

P M K N S H

PRAMET

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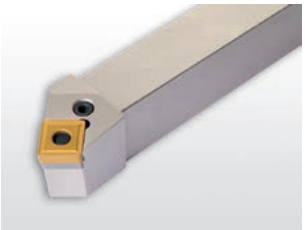
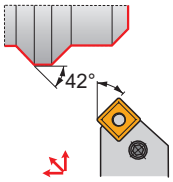
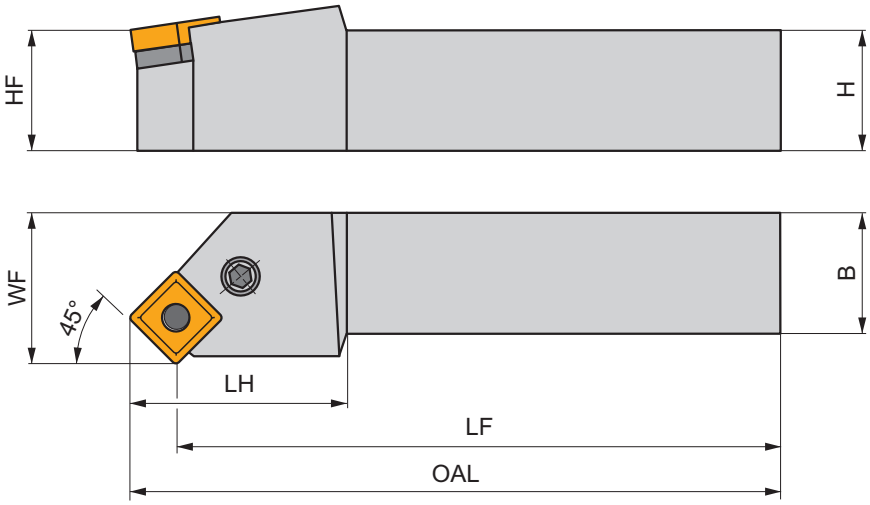
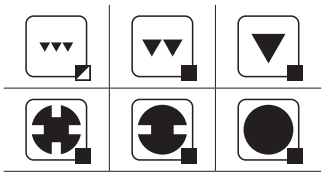


外圆用杠杆夹紧式车刀杆，使用SN..刀片，主偏角为45°。
外圆用左/右手杠杆夹紧式刀具刀杆，主偏角为45°。使用SN..12、15、19或25尺寸的负前角刀片。适用于无阶梯外圆的轴向和端面车削，仿形，锥面和倒角车削。可提供20x20至50x50mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	OAL (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PSSNR 2020 K 12**	20	20	20	25	125	133.3	28.0	0	-8	0.42	GI029	PS01
	PSSNR 2525 M 12	25	25	25	32	150	158.3	28.0	0	-8	0.75	GI029	PS01
	PSSNR 3225 P 15	32	25	32	32	170	180.2	42.0	0	-8	1.11	GI082	PS04
	PSSNR 3232 P 19	32	32	32	40	170	182.5	45.0	0	-8	1.42	GI026	PS02
	PSSNR 5050 T 25	50	50	50	60	300	316	50.0	0	-8	6.00	GI027	PS03
	PSSNR 4040 S 19	40	40	40	50	250	262.5	45.0	0	-8	3.18	GI026	PS02
	PSSNR 5050 T 2509	50	50	50	60	300	316	50.0	0	-8	6.05	GI040	PS03
L	**PSSNL 2020 K 12**	20	20	20	25	125	133.3	28.0	0	-8	0.41	GI029	PS01
	PSSNL 2525 M 12	25	25	25	32	150	158.3	28.0	0	-8	0.76	GI029	PS01
	PSSNL 3225 P 15	32	25	32	32	170	180.2	42.0	0	-8	1.13	GI082	PS04
	PSSNL 3232 P 19	32	32	32	40	170	182.5	45.0	0	-8	1.43	GI026	PS02
	PSSNL 4040 S 19	40	40	40	50	250	262.5	45.0	0	-8	3.16	GI026	PS02
	PSSNL 5050 T 25	50	50	50	60	300	316	50.0	0	-8	6.00	GI027	PS03
	PSSNL 5050 T 2509	50	50	50	60	300	316	50.0	0	-8	5.98	GI040	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..

				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3

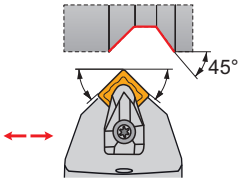
C.-DSDNN EXT

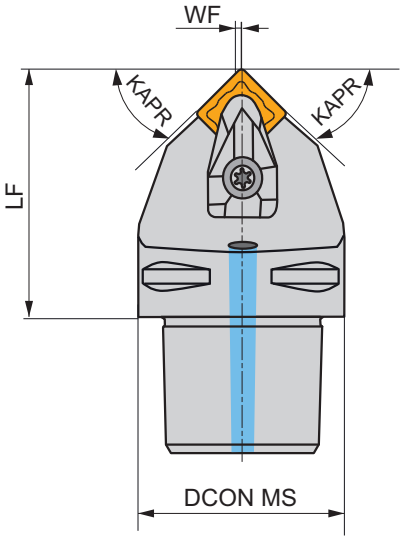
P M K N S H

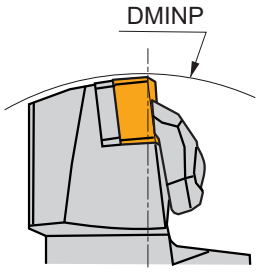
PRAMET

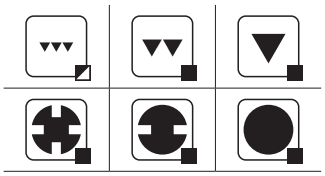
D

外圆用PSC快速更换式刀柄，双重夹紧，使用SN..刀片，主偏角为45°。
外圆用中置双重夹紧车刀杆，有内冷通道，主偏角为45°。使用SN..12或19尺寸的负前角刀片。适用于无阶梯外圆的轴向车削，仿形，锥面和倒角车削，可提供PSC(多边形柄联接)C4至C6刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
N	**C4-DSDNN-00050-12**	40	140	0.3	50	45	-6	-6	✓	0.39	GI029	C-DS12-2	AT003
	C5-DSDNN-00060-12	50	165	0.3	60	45	-6	-6	✓	0.69	GI029	C-DS12-2	AT003
	C6-DSDNN-00070-19	63	195	0.5	70	45	-6	-6	✓	1.28	GI026	C-DS19	–

GI029	SN.. 1204..
GI026	SN.. 1906..

		Nm					
C-DS12-2	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–	CN 045-01
C-DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P	CN 045-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

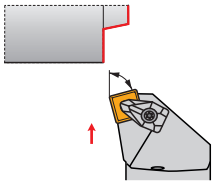
C.-DSKN(RL) EXT

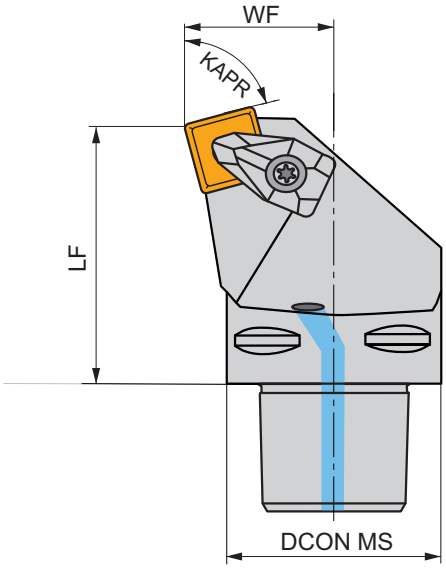
P M K N S H

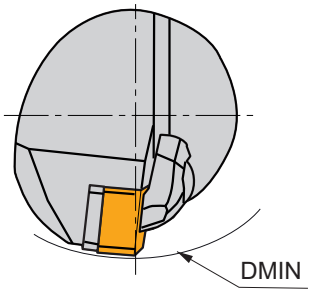
PRAMET

D

外圆用PSC快速更换式刀柄，双重夹紧，使用SN..刀片，主偏角为75°（端面）。
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为75°。使用SN..12..尺寸的负前角刀片。适用于无阶梯外圆的情况下进行端面车削，倒角车削。可提供C4。刀杆经过处理，使用寿命更长。







Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R C4-DSKNR-27050-12	40	110	27	50	75	-6	-6	✓	0.46	GI029	C-DS12-1	AT003
L C4-DSKNL-27050-12	40	110	27	50	75	-6	-6	✓	0.46	GI029	C-DS12-1	AT003

GI029	SN.. 1204..

C-DS12-1	DCS 12	3.9 Nm	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

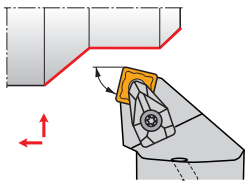
C.-DSRN(RL) EXT

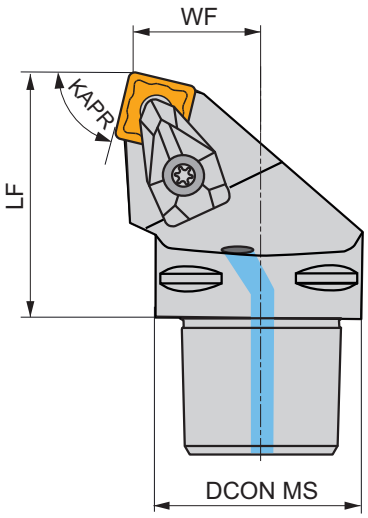
P M K N S H

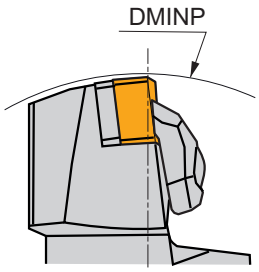
PRAMET

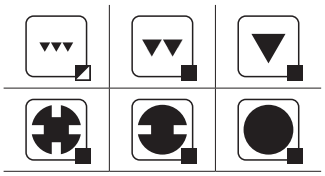
D

外圆用PSC快速更换式刀柄，双重夹紧，使用SN..刀片，主偏角为75°。
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为75°。使用SN..12或19尺寸的负前角刀片。适用于无阶梯外圆的轴向车削，锥面和倒角车削。可提供C4至C6刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	**C4-DSRNR-22050-12**	40	140	22	50	75	-6	-6	✓	0.40	GI029	C-DS12-1	AT003
R	**C6-DSRNR-35065-19**	63	190	35	65	75	-6	-6	✓	1.30	GI026	C-DS19	–
L	**C4-DSRNL-22050-12**	40	140	22	50	75	-6	-6	✓	0.41	GI029	C-DS12-1	AT003
L	**C6-DSRNL-35065-19**	63	190	35	65	75	-6	-6	✓	1.30	GI026	C-DS19	–

GI029	SN.. 1204..
GI026	SN.. 1906..

		Nm					
C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–	CN 034-01
C-DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P	CN 045-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

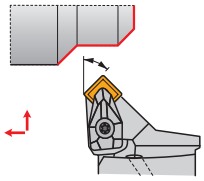
C.-DSSN(RL) EXT

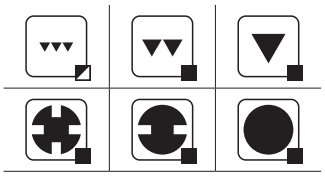
P M K N S H

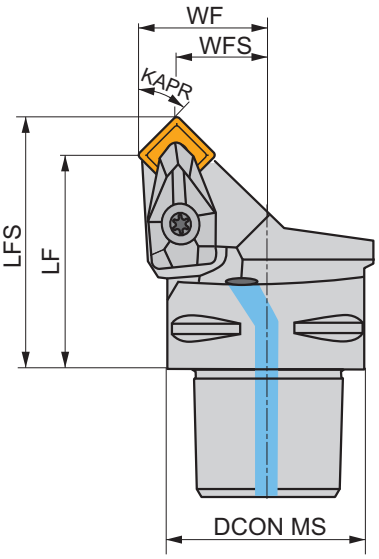
PRAMET

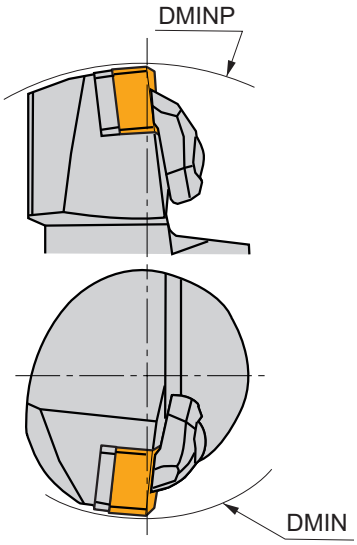
D

外圆用PSC快速更换式刀柄，双重夹紧，使用SN..刀片，主偏角为45°。
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为45°，使用SN..12尺寸的负前角刀片。适用于无阶梯外圆的轴向和端面车削，锥面，仿形和倒角车削。可提供C4和C5刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	WFS (mm)	LF (mm)	LFS (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	**C4-DSSNR-27042-12**	40	110	140	27	18.7	42	50.3	45	0	-8	✓	0.38	GI029	C-DS12-1	AT003
	C5-DSSNR-35052-12	50	110	165	35	26.7	52	60.3	45	0	-8	✓	0.68	GI029	C-DS12-3	AT003
L	**C4-DSSNL-27042-12**	40	110	140	27	18.7	42	50.3	45	0	-8	✓	0.36	GI029	C-DS12-1	AT003
	C5-DSSNL-35052-12	50	110	165	35	26.7	52	60.3	45	0	-8	✓	0.69	GI029	C-DS12-3	AT003

GI029	SN.. 1204..

		Nm				
C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DS12-3	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

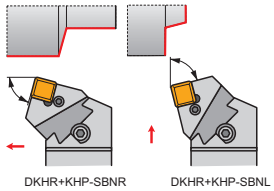
KHP-SBN(RL)

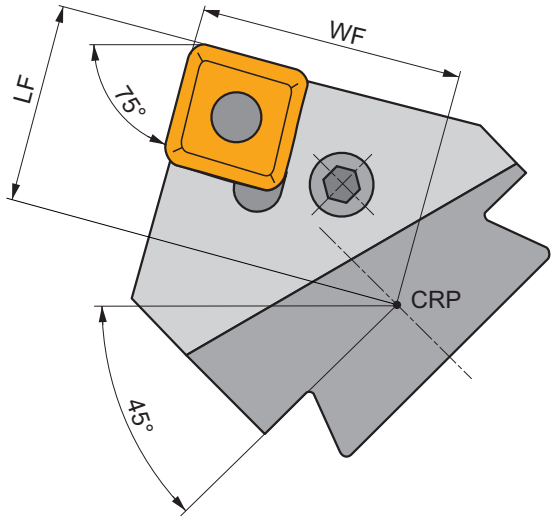
P M K

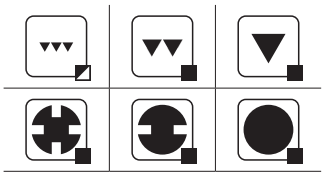
PRAMET

P

模块化KHP杠杆夹紧式车刀刀夹，使用SN..刀片，主偏角为75°。
燕尾形左/右手杠杆夹紧车刀夹，主偏角为75°。安装在DKH刀杆上。使用SN..19或25负前角刀片。适用于无阶梯外圆的重载轴向车削，端面车削，锥面和倒角车削。车刀杆经过处理，使用寿命更长。







	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-SBNR 19**	47	36	-6	-6	1.51	GI026	PS50
	KHP-SBNR 25	47	36	-6	-6	1.47	GI027	PS60
	KHP-SBNR 2509	47	36	-6	-6	1.45	GI040	PS70
L	**KHP-SBNL 19**	47	36	-6	-6	1.92	GI026	PS50
	KHP-SBNL 25	47	36	-6	-6	1.48	GI027	PS60
	KHP-SBNL 2509	47	36	-6	-6	1.46	GI040	PS70

GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..

				Nm					
PS50	SNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5
PS60	SNU 250624	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXK 5
PS70	SNU 250624	PU 06	US 47	8.0	M 12x1	36	NT 08	MT 08	HXK 5

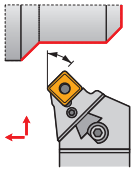
KHP-SSN(RL)

P M K

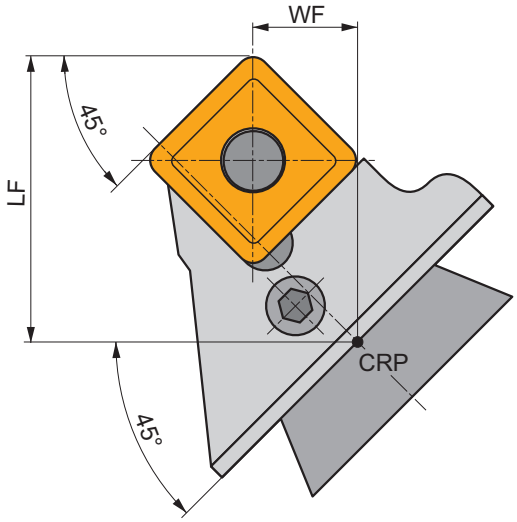
PRAMET

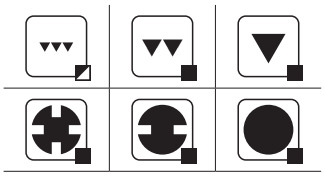
P

模块化KHP杠杆夹紧式车刀刀夹，使用SN..刀片，主偏角为45°
燕尾形左/右手杠杆夹紧车刀夹，主偏角为45°。安装在DKH刀杆上。使用SN..19或25负前角刀片。适用于无阶梯外圆的重载轴向车削，端面车削，仿形，锥面和倒角车削。车刀杆经过处理，使用寿命更长。



DKHR+KHP-SSNR





	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-SSNR 25**	15	45	-6	-6	0.98	GI027	PS60
L	**KHP-SSNL 25**	15	45	-6	-6	1.30	GI027	PS60

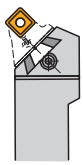
GI027	SN.. 2507..

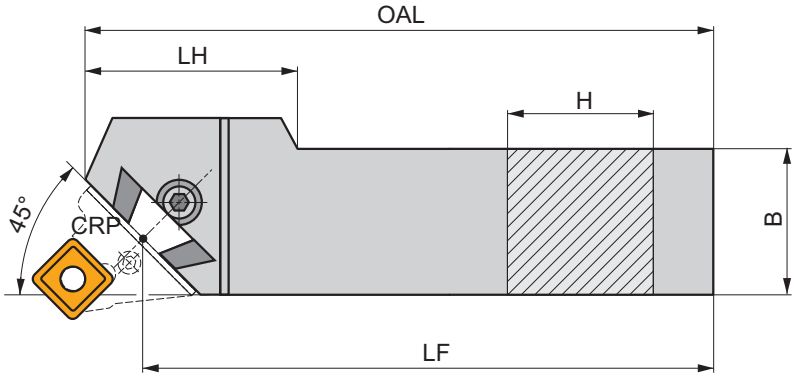
PS60	SNU 250624	PU 06	US 39	8.0 Nm	M 10x1	33	NT 08	MT 08	HXK 5

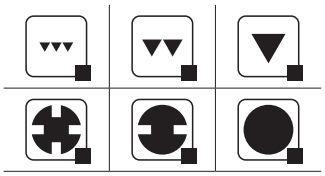
DKH(RL)

PRAMET

使用KHP/KHS重载车刀刀夹的外圆用刀柄
燕尾形左/右手模块化刀杆，使用KHP/KHS刀夹。适用于重载车削应用。可提供40x50至60x80mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

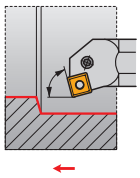
PSKN(RL) INT

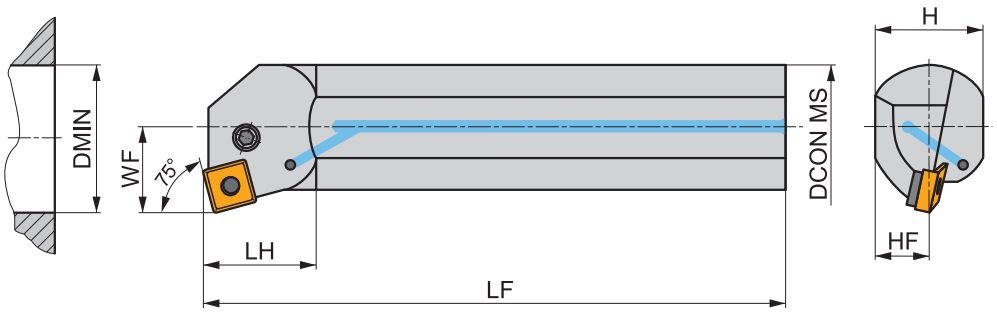
P M K N S H

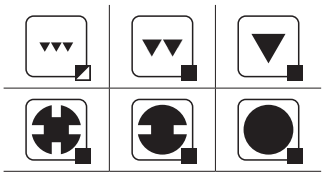
PRAMET

P

外圆用杠杆夹紧式镗杆，使用SN..刀片，主偏角为75°。
内孔左/右手杠杆夹紧镗杆，有内冷通道，主偏角为75°，使用SN..刀片。适用于内孔锥面，无阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A32S-PSKNR 12**	32	39	22	30	–	250	-10	-6	✓	1.45	GI029	PS06
R	**A40T-PSKNR 15**	40	48	27	37	–	300	-11	-6	✓	2.90	GI082	PS04
R	**A50U-PSKNR 15**	50	61	35	47	–	350	-11	-6	✓	5.20	GI082	PS04
R	**A50U-PSKNR 19**	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI026	PS07
L	**A50U-PSKNL 15**	50	61	35	47	–	350	-11	-6	✓	5.20	GI082	PS04

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..

				Nm					
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PS06	PSS 512	CL 312	CS 648	3.0	M 8x1	17	TR 12	MT 05	HXK 3
PS07	PSS 519	CL 219	CS 710	3.5	M 10x1	30.4	TR 29	MT 06	HXK 4

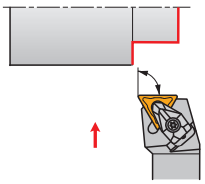
DTFN(RL) EXT

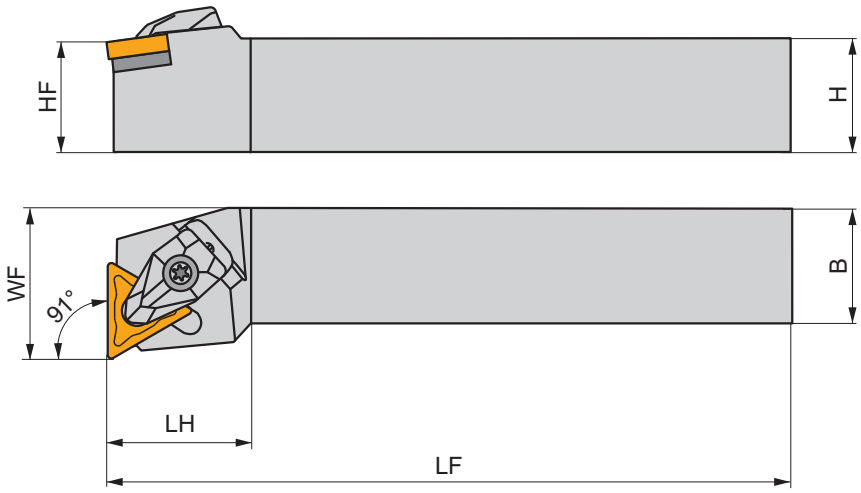
P M K N S H

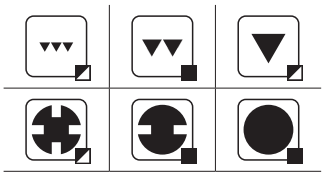
PRAMET

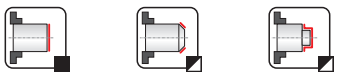
D

外圆用双重夹紧车刀杆，使用TN..刀片，主偏角为91°（端面）。
外圆用左/右手双重夹紧车刀杆，主偏角为91°。使用TN..16或22尺寸的负前角刀片。适用于有阶梯外圆的端面车削。可提供20x20和25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**DTFNR 2020 K 16**	20	20	20	25	125	23.6	-6	-6	0.43	GI024	DT16
R	**DTFNR 2525 M 16**	25	25	25	32	150	23.6	-6	-6	0.77	GI024	DT16
R	**DTFNR 2525 M 22**	25	25	25	32	150	30.5	-6	-6	0.79	GI025	DT22
L	**DTFNL 2020 K 16**	20	20	20	25	125	23.6	-6	-6	0.43	GI024	DT16
L	**DTFNL 2525 M 16**	25	25	25	32	150	23.6	-6	-6	0.76	GI024	DT16

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm			
DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5

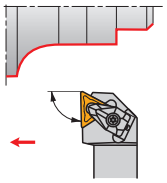
DTGN(RL) EXT

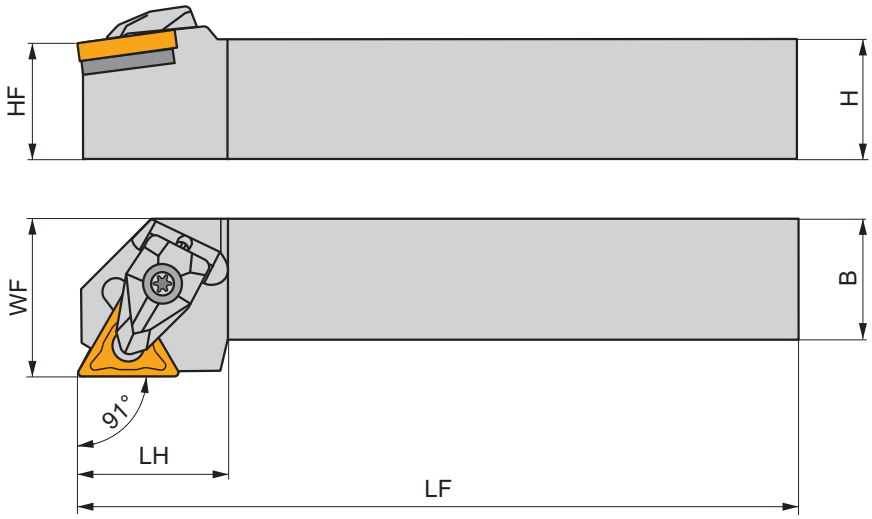
P M K N S H

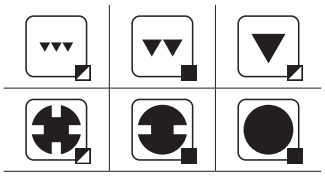
PRAMET

D

外圆用双重夹紧车刀杆，使用TN..刀片，主偏角为91°。
外圆用左/右手双重夹紧车刀杆，主偏角为91°。使用TN..16或22尺寸的负前角刀片。适用于有阶梯外圆的轴向车削，锥面车削。可提供20x20至32x32mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**DTGNR 2020 K 16**	20	20	20	25	125	25.4	-6	-6	0.42	GI024	DT16
	DTGNR 2525 M 16	25	25	25	32	150	24.6	-6	-6	0.76	GI024	DT16
	DTGNR 2525 M 22	25	25	25	32	150	32.1	-6	-6	0.81	GI025	DT22
	DTGNR 3232 P 22	32	32	32	40	170	33.1	-6	-6	1.41	GI025	DT22
L	**DTGNL 2020 K 16**	20	20	20	25	125	25.4	-6	-6	0.44	GI024	DT16
	DTGNL 2525 M 16	25	25	25	32	150	24.6	-6	-6	0.78	GI024	DT16
	DTGNL 2525 M 22	25	25	25	32	150	32.1	-6	-6	0.78	GI025	DT22

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm			
DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5

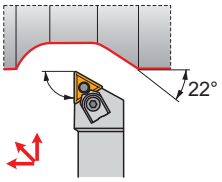
MTJN(RL) EXT

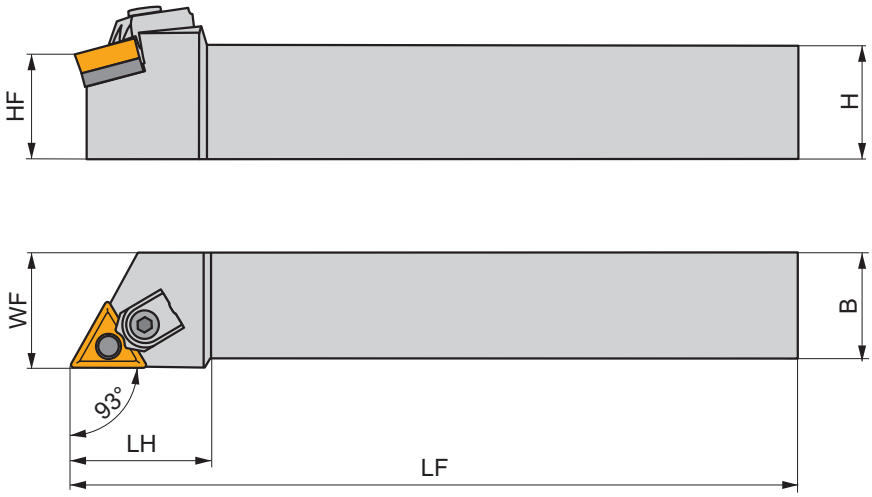
P M K N S H

PRAMET

M

外圆用多重锁紧车刀杆，使用TN..刀片，主偏角为93°。
外圆用左/右手多重夹紧车刀杆，主偏角为93°。使用TN..16或22尺寸的负前角刀片。适用于有阶梯外圆的轴向车削，锥面，仿形车削角度最大为22°，和倒角车削。可提供20x20至32x32mm的刀柄。刀杆经过处理，使用寿命更长。





Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R											
MTJNR 2020 K 16	20	20	20	25	125	34.0	-6	-6	0.42	GI024	MT16
MTJNR 2525 M 16	25	25	25	32	150	34.0	-6	-6	0.76	GI024	MT16
MTJNR 3232 P 22	32	32	32	40	175	42.0	-6	-6	1.37	GI025	MT22
L											
MTJNL 2020 K 16	20	20	20	25	125	34.0	-6	-6	0.43	GI024	MT16
MTJNL 2525 M 16	25	25	25	32	150	34.0	-6	-6	0.75	GI024	MT16
MTJNL 3232 P 22	32	32	32	40	175	42.0	-6	-6	1.37	GI025	MT22

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm				
MT16	UE 16	3.0	MTN 160312	UC 52	HS 93	HXK 5
MT22	UE 22	5.0	MTN 220612	UC 61	HS 94	HXK 5

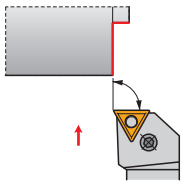
PTFN(RL) EXT

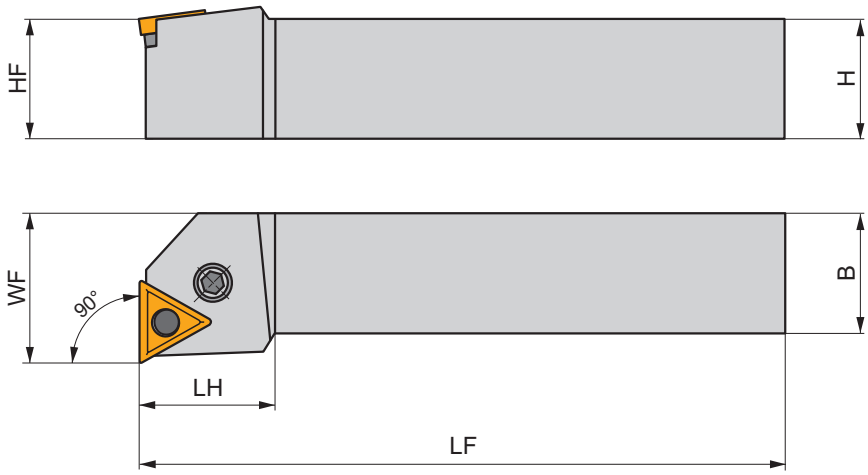
P M K N S H

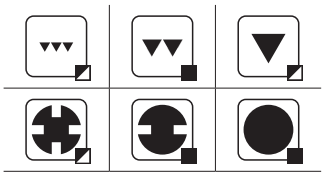
PRAMET

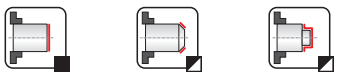
P

外圆杠杆锁车削刀杆，使用TN..刀片，主偏角为90°（端面车削）。
外圆用左/右手杠杆夹紧式刀具刀杆，主偏角为90°。使用TN..16、22或27尺寸的负前角刀片。适用于有阶梯外圆的端面车削和倒角车削。可提供16x16至40x40mm的刀柄。刀杆经过处理，使用寿命更长。









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PTFNR 2020 K 16**	20	20	20	25	125	22.0	-6	-6	0.41	GI024	PT01
	PTFNR 2525 M 16	25	25	25	32	150	28.0	-6	-6	0.75	GI024	PT01
	PTFNR 3225 P 22	32	25	32	32	170	36.0	-6	-6	1.05	GI025	PT02
	PTFNR 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.22	GI077	PT03
L	**PTFNL 2525 M 22**	25	25	25	32	150	28.0	-6	-6	0.70	GI025	PT02
	PTFNL 3225 P 22	32	25	32	32	170	36.0	-6	-6	1.14	GI025	PT02
	PTFNL 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.16	GI077	PT03

GI024	TN.. 1604..
GI025	TN.. 2204..
GI077	TN.. 2706..

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PT03	PTS 427	CL 015	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3

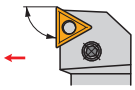
PTGN(RL) EXT

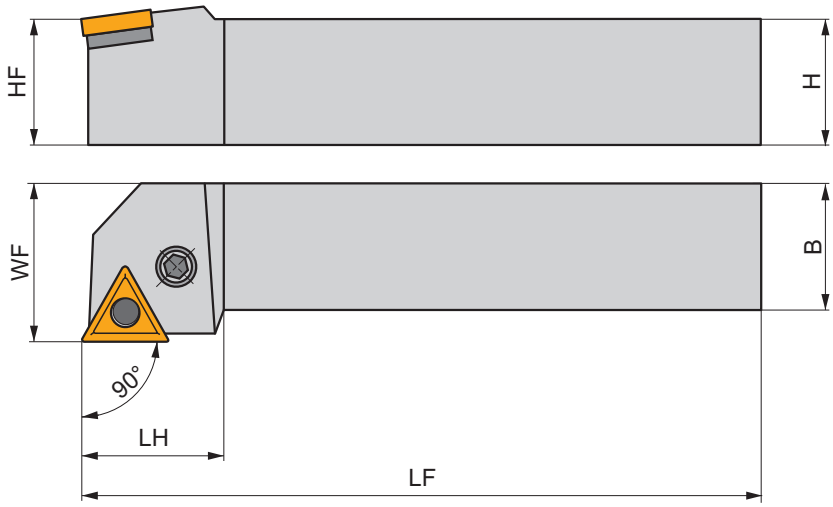
P M K N S H

PRAMET

P

外圆杠杆夹紧车刀杆，使用TN..刀片，主偏角为90°。
外圆用左/右手杠杆夹紧式刀具刀杆，主偏角为90°。使用TN..16、22或27尺寸的负前角刀片。适用于有阶梯外圆的轴向车削，锥面和倒角车削。可提供16x16至40x40mm的刀柄。刀杆经过处理，使用寿命更长。





Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R											
PTGNR 1616 H 16	16	16	16	20	100	22.0	-6	-6	0.20	GI024	PT01
PTGNR 2020 K 16	20	20	20	25	125	22.0	-6	-6	0.40	GI024	PT01
PTGNR 2525 M 16	25	25	25	32	150	28.0	-6	-6	0.73	GI024	PT01
PTGNR 2525 M 22	25	25	25	32	150	28.0	-6	-6	0.76	GI025	PT02
PTGNR 3232 P 22	32	32	32	40	170	28.0	-6	-6	1.35	GI025	PT02
PTGNR 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.15	GI077	PT03
L											
PTGNL 1616 H 16	16	16	16	20	100	22.0	-6	-6	0.21	GI024	PT01
PTGNL 2020 K 16	20	20	20	25	125	22.0	-6	-6	0.40	GI024	PT01
PTGNL 2525 M 16	25	25	25	32	150	28.0	-6	-6	0.76	GI024	PT01
PTGNL 2525 M 22	25	25	25	32	150	28.0	-6	-6	0.76	GI025	PT02
PTGNL 3232 P 22	32	32	32	40	170	28.0	-6	-6	1.34	GI025	PT02
PTGNL 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.14	GI077	PT03

GI024	TN.. 1604..
GI025	TN.. 2204..
GI077	TN.. 2706..

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PT03	PTS 427	CL 015	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3

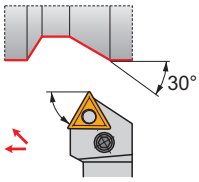
PTTN(RL) EXT

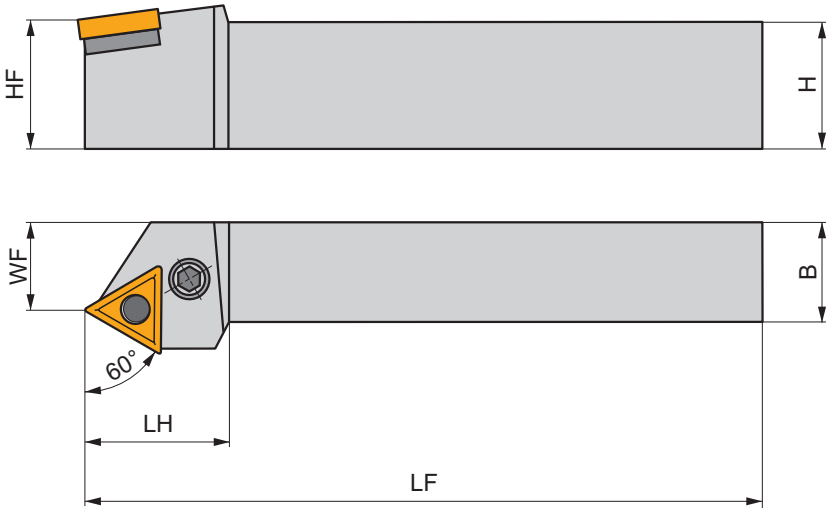
P M K N S H

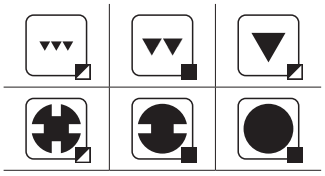
PRAMET

P

外圆杠杆夹紧车刀杆，使用TN..刀片，主偏角为60°。
外圆用左/右手杠杆夹紧式刀具刀杆，主偏角为60°。使用TN..16和22尺寸的负前角刀片。适用于有阶梯外圆的轴向车削，锥面，仿形车削角度最大为30°，和倒角车削。可提供20x20至32x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PTTNR 2020 K 16**	20	20	20	17	125	28.0	-6	-6	0.43	GI024	PT01
R	**PTTNR 2525 M 16**	25	25	25	22	150	28.0	-6	-6	0.63	GI024	PT01
R	**PTTNR 2525 M 22**	25	25	25	22	150	34.0	-6	-6	0.73	GI025	PT02
R	**PTTNR 3225 P 22**	32	25	32	22	170	34.0	-6	-6	1.07	GI025	PT02
L	**PTTNL 2020 K 16**	20	20	20	17	125	28.0	-6	-6	0.38	GI024	PT01
L	**PTTNL 3225 P 22**	32	25	32	22	170	34.0	-6	-6	1.04	GI025	PT02

GI024	TN.. 1604..
GI025	TN.. 2204..

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3

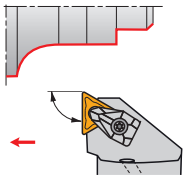
C.-DTJN(RL) EXT

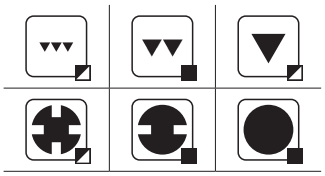
P M K N S H

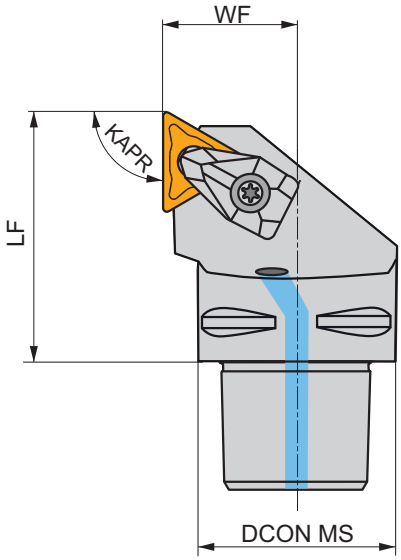
PRAMET

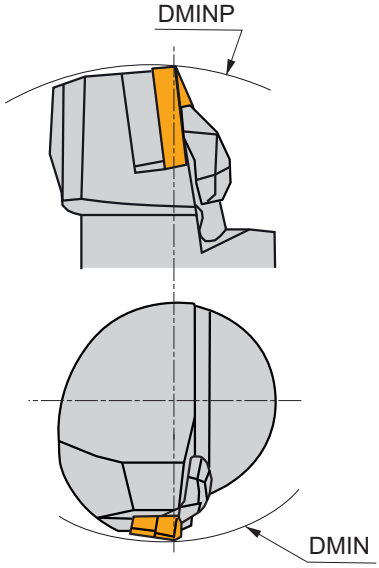
D

外圆用PSC快速更换式刀柄，双重夹紧，使用TN..刀片，主偏角为93°。
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为93°。使用TN..16尺寸的负前角刀片。适用于有阶梯外圆的轴向车削，锥面和倒角车削。可提供C4和C5刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DTJNR-27050-16	40	110	140	27	50	93	-6	-6	✓	0.43	GI024	C-DT16
R	C5-DTJNR-35060-16	50	110	165	35	60	93	-6	-6	✓	0.79	GI024	C-DT16
L	C4-DTJNL-27050-16	40	110	140	27	50	93	-6	-6	✓	0.43	GI024	C-DT16
L	C5-DTJNL-35060-16	50	110	165	35	60	93	-6	-6	✓	0.79	GI024	C-DT16

GI024	TN.. 1604..

C-DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P	CN 045-01

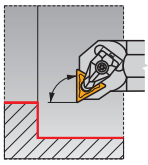
DTFN(RL) INT

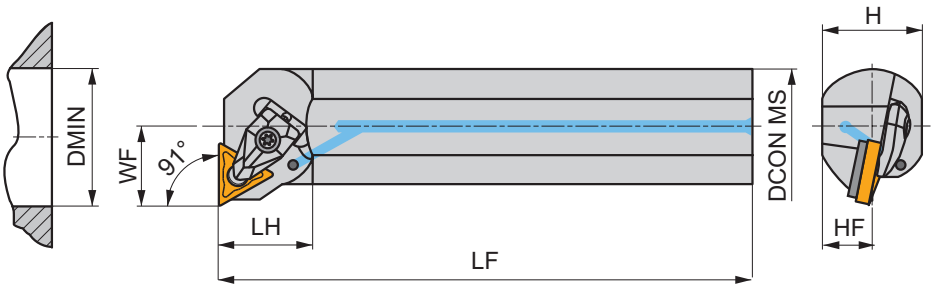
P M K N S H

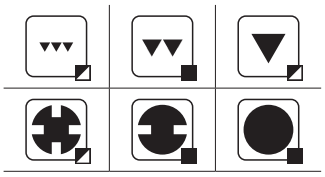
PRAMET

D

内孔双重刚性夹紧车刀杆，使用TN..刀片，主偏角为91°。
内孔左/右手双重刚性夹紧镗杆，有内冷通道，主偏角为91°，使用TN..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	**A25T-DTFNR 16**	25	32	17	23	11.5	300	32.0	-12	-6	✓	0.96	GI024	DTI16
	A32T-DTFNR 16	32	40	22	30	15	300	33.0	-10	-6	✓	1.67	GI024	DTI16
	A40T-DTFNR 22	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.58	GI025	DT22
L	**A25T-DTFNL 16**	25	32	17	23	11.5	300	32.0	-12	-6	✓	0.96	GI024	DTI16
	A32T-DTFNL 16	32	40	22	30	15	300	33.0	-10	-6	✓	1.67	GI024	DTI16
	A40T-DTFNL 22	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.58	GI025	DT22

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm			
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5
DTI16	DCS 09	1.7	DTS 316-01	US 2004-T09P	FLAG T09P

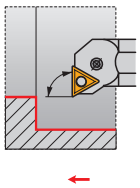
PTFN(RL) INT

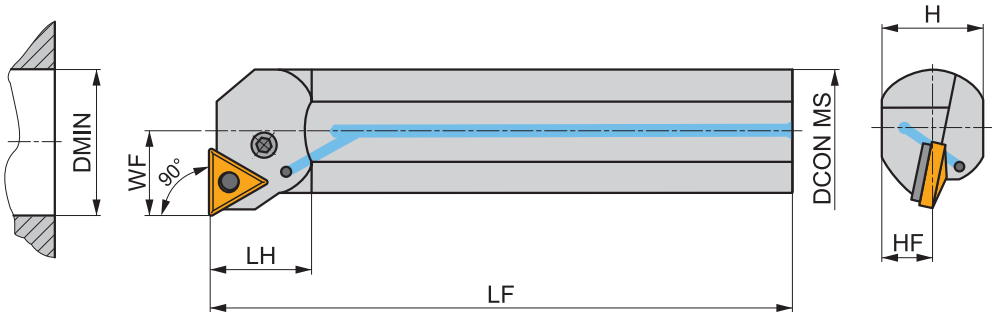
P M K N S H

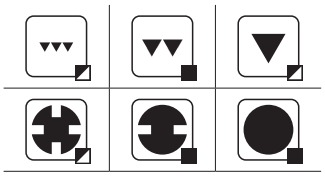
PRAMET

P

外圆杠杆夹紧车刀杆，使用TN..刀片，主偏角为90°。
内孔左/右手杠杆夹紧镗杆，有内冷通道，主偏角为90°，TN..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A25R-PTFNR 16**	25	31	17	23	–	200	-13	-6	–	0.71	GI024	PT04
	A32S-PTFNR 16	32	39	22	30	–	250	-12	-6	✓	1.45	GI024	PT01
L	**A25R-PTFNL 16**	25	31	17	23	–	200	-13	-6	–	0.71	GI024	PT04

GI024	TN.. 1604..

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT04	–	CL 216	CS 605	1.4	M 5x1	12	–	–	HXK 2

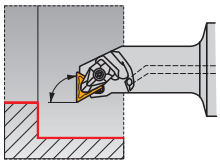
C.-DTFN(RL) INT

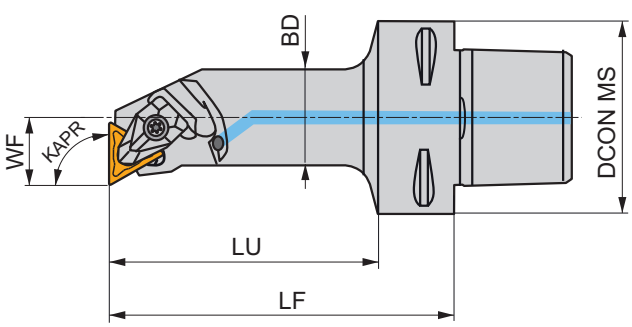
P M K N S H

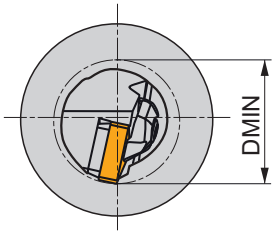
PRAMET

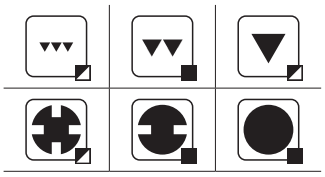
D

内孔PSC快换刀柄，双重刚性夹紧，使用TN..刀片，主偏角为91°。
内孔左/右手双重刚性夹紧刀具，有内冷通道，主偏角为91°。使用TN..16刀片。广泛的应用于内孔车削。
可提供C4的PSC刀柄，车削长度为68mm。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DTFNR-17090-16	40	32	17	90	68	25	91	-12	-6	✓	0.51	GI024	DTI16

GI024	TN.. 1604..

DTI16	DCS 09	1.7	DTS 316-01	US 2004-T09P	FLAG T09P

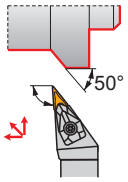
DVJN(RL) EXT

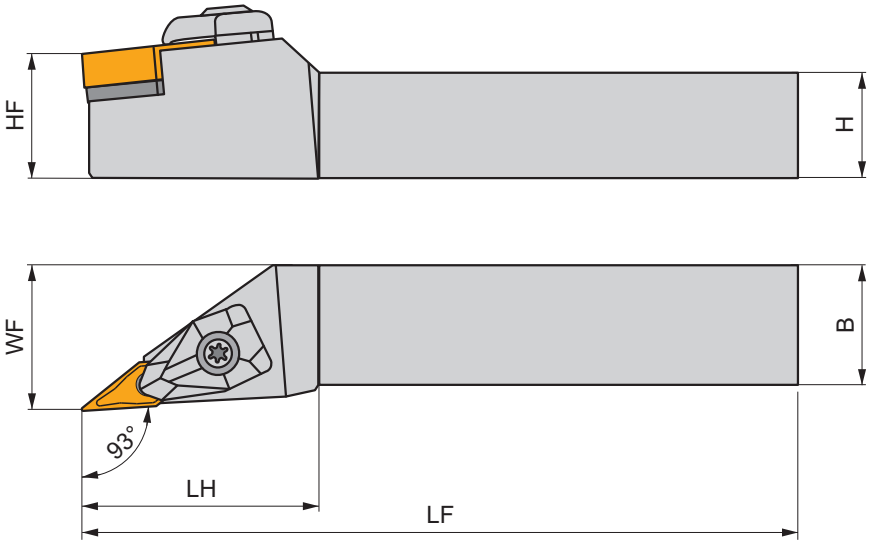
P M K N S H

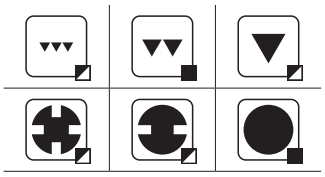
PRAMET

D

外圆用双重夹紧车刀杆，使用VN..刀片，主偏角为93°。
外圆用左/右手双重夹紧车刀杆，主偏角为93°。使用VN16尺寸的负前角刀片。适用于有阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供20x20至32x32mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**DVJNR 2020 K 16**	20	20	20	25	125	46.4	-13	-4	0.43	GI048	DV16
	DVJNR 2525 M 16	25	25	25	32	150	46.4	-13	-4	0.74	GI048	DV16
	DVJNR 3225 P 16	32	25	32	32	170	46.4	-13	-4	1.05	GI048	DV16
L	**DVJNL 2020 K 16**	20	20	20	25	125	46.4	-13	-4	0.43	GI048	DV16
	DVJNL 2525 M 16	25	25	25	32	150	46.4	-13	-4	0.75	GI048	DV16
	DVJNL 3225 P 16	32	25	32	32	170	46.4	-13	-4	1.06	GI048	DV16

GI048	VN.. 1604..

DV16	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

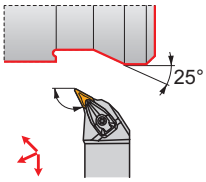
DVPN(RL) EXT

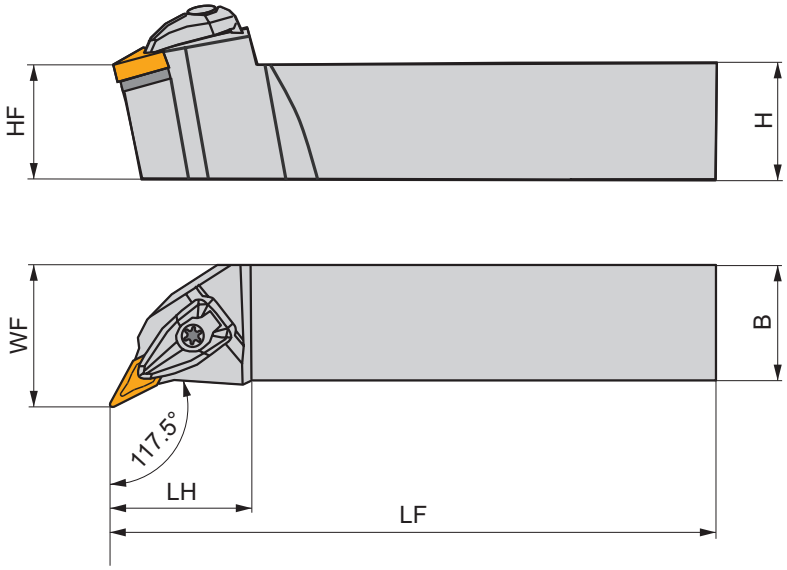
P M K N S H

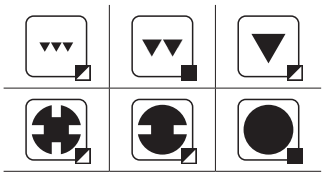
PRAMET

D

外圆用双重夹紧车刀杆，使用VN..刀片，切削角为117.5°。
外圆用左/右手双重夹紧车刀杆，主偏角为117.5°。使用VN..16尺寸的负前角刀片。适用于轴向和端面车削，有阶梯外圆，仿形和锥面车削。可提供25x25和32x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**DVPNR 2525 M 16**	25	25	25	32	150	39.2	-13	-4	0.75	GI048	DV16
L	**DVPNL 2525 M 16**	25	25	25	32	150	39.2	-13	-4	0.74	GI048	DV16

GI048	VN.. 1604..

DV16	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

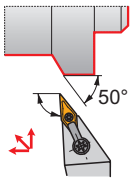
MVJN(RL) EXT

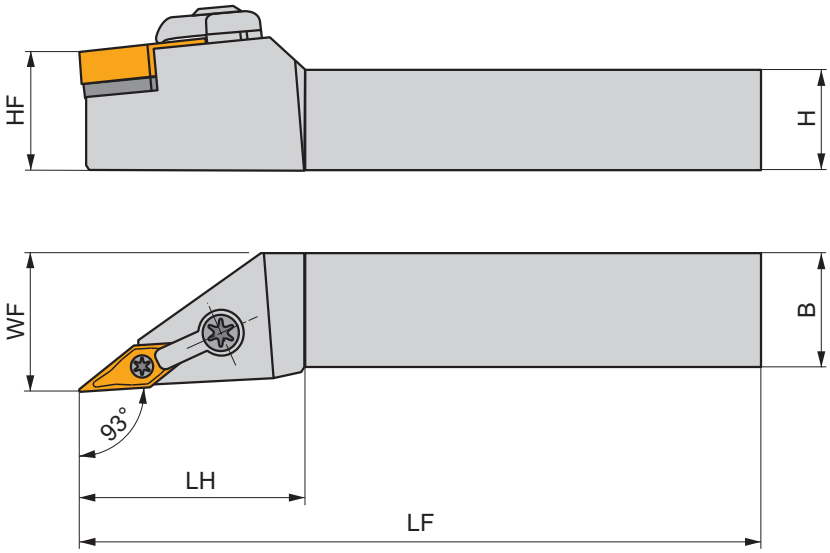
P M K N S H

PRAMET

M

外圆用多重锁紧车刀杆，使用VN..刀片，主偏角为93°。
外圆用左/右手多重锁紧车刀杆，主偏角为93°。使用VN..16的负前角刀片。适用于有阶梯外圆的轴向车削，仿形车削角度最大为50°，锥面和倒角车削。可提供20x20至32x25mm的刀柄。刀杆经过处理，使用寿命更长。





Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R											
MVJNR 2020 K 16-A	20	20	20	25	125	41.0	-4.5	-13.5	0.40	GI048	MV2
MVJNR 2525 M 16-A	25	25	25	32	150	41.0	-4.5	-13.5	0.70	GI048	MV2
MVJNR 3225 P 16-A	32	25	32	32	170	41.0	-4.5	-13.5	0.98	GI048	MV2
L											
MVJNL 2020 K 16-A	20	20	20	25	125	41.0	-4.5	-13.5	0.40	GI048	MV2
MVJNL 2525 M 16-A	25	25	25	32	150	41.0	-4.5	-13.5	0.70	GI048	MV2
MVJNL 3225 P 16-A	32	25	32	32	170	41.0	-4.5	-13.5	0.99	GI048	MV2

GI048	VN.. 1604..

MV2	UPC 22	MVN 160316	UP 0909-T09P	2.0 Nm	PS 6026-T09P	2.0 Nm	FLAG T09P

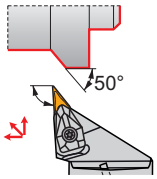
C.-DVJN(RL) EXT

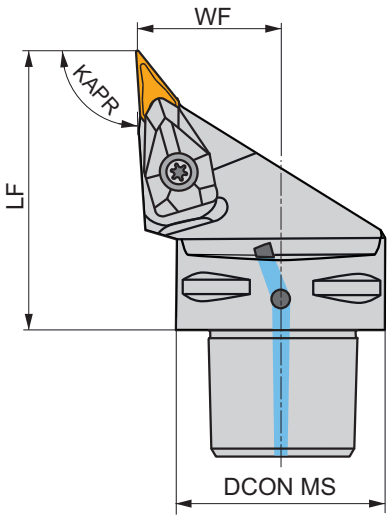
P M K N S H

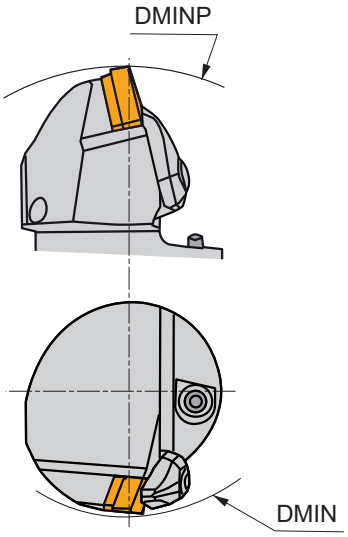
PRAMET

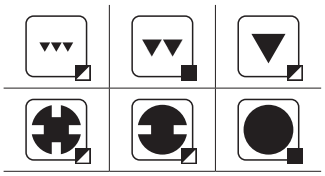
D

外圆用PSC快速更换式刀柄，双重夹紧，使用VN..刀片，主偏角为93°。
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为93°。使用VN..16尺寸的负前角刀片。适用于有阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供C4至C6刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DVJNR-27062-16	40	60	152	27	62	93	-13	-4	✓	0.45	GI048	C-DV16-1
	C5-DVJNR-35065-16	50	65	170	35	65	93	-13	-4	✓	0.47	GI048	C-DV16-2
	C6-DVJNR-45065-16	63	81	190	45	65	93	-13	-4	✓	1.13	GI048	C-DV16-2
L	C4-DVJNL-27062-16	40	60	152	27	62	93	-13	-4	✓	0.45	GI048	C-DV16-1
	C5-DVJNL-35065-16	50	65	170	35	65	93	-13	-4	✓	0.71	GI048	C-DV16-2
	C6-DVJNL-45065-16	63	81	190	45	65	93	-13	-4	✓	1.13	GI048	C-DV16-2

GI048	VN.. 1604..

		Nm				
C-DV16-1	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5	CN 034-01
C-DV16-2	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5	CN 034-02

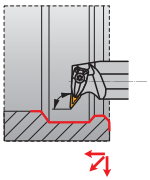
DVUN(RL) INT

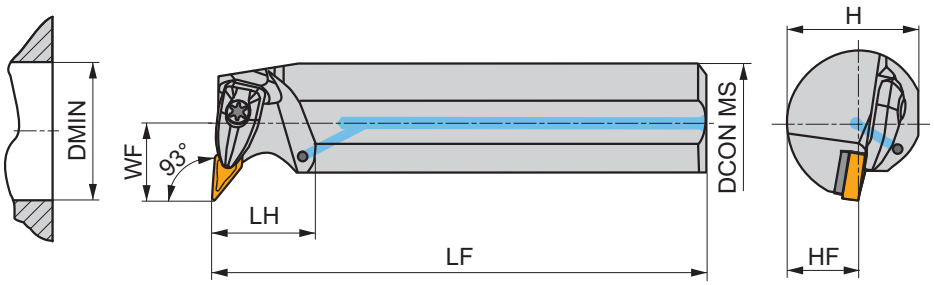
P M K N S H

PRAMET

D

内孔双重刚性夹紧镗杆，使用VN..刀片，主偏角为93°。
内孔左/右手双重刚性夹紧镗杆，有内冷通道，主偏角为93°，使用VN..刀片。适用于内孔锥面，有阶梯孔的轴向车削，仿形和倒角车削。刀杆经过处理，使用寿命更长。





Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R A40T-DVUNR 16	40	50	27	37	18.5	300	36.0	-9	-6	✓	2.59	GI048	DV16
L A40T-DVUNL 16	40	50	27	37	18.5	300	36.0	-9	-6	✓	2.58	GI048	DV16

GI048	VN.. 1604..

DV16	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

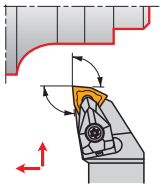
DWLN(RL) EXT

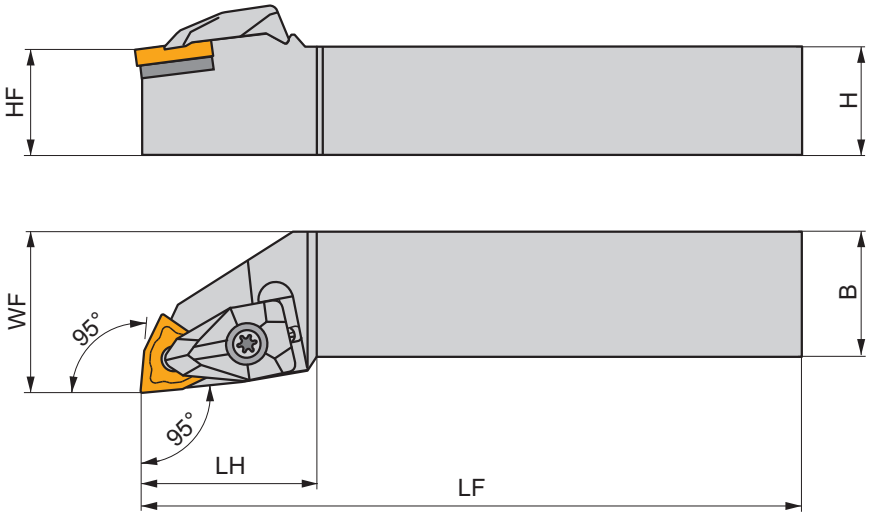
P M K N S H

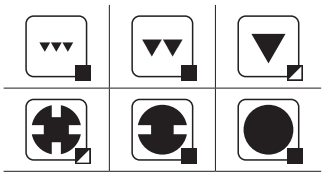
PRAMET

D

外圆用双重夹紧车刀杆，使用WN..刀片，主偏角为95°。
外圆用左/右手双重夹紧具车刀杆，主偏角为95°。使用WN..06至13负前角刀片。适用于有阶梯外圆的轴向车削，端面，锥面和倒角车削。可提供可提供16x16至40x40mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg			
R	**DWLNR 1616 H 06**	16	16	16	20	100	26.4	-6	-6	0.22	GI028	DW06	–
	DWLNR 2020 K 06	20	20	20	25	125	27.1	-6	-6	0.41	GI028	DW06	–
	DWLNR 2525 M 06	25	25	25	32	150	27.1	-6	-6	0.75	GI028	DW06	–
	DWLNR 2020 K 08	20	20	20	25	125	34.3	-6	-6	0.43	GI072	DW08	AT004
	DWLNR 2525 M 08	25	25	25	32	150	35.0	-6	-6	0.75	GI072	DW08	AT004
	DWLNR 3225 P 08	32	25	32	32	170	35.0	-6	-6	1.01	GI072	DW08	AT004
	DWLNR 3225 P 10	32	25	32	32	170	38.0	-6	-6	1.06	GI166	DW10	–
	DWLNR 3232 P 13	32	32	32	40	170	40.0	-6	-6	1.40	GI167	DW13	–
	DWLNR 4040 S 13	40	40	40	50	250	41.0	-6	-6	3.19	GI167	DW13	–
L	**DWLNL 1616 H 06**	16	16	16	20	100	26.4	-6	-6	0.22	GI028	DW06	–
	DWLNL 2020 K 06	20	20	20	25	125	27.1	-6	-6	0.41	GI028	DW06	–
	DWLNL 2525 M 06	25	25	25	32	150	27.1	-6	-6	0.76	GI028	DW06	–
	DWLNL 2020 K 08	20	20	20	25	125	34.3	-6	-6	0.43	GI072	DW08	AT004
	DWLNL 2525 M 08	25	25	25	32	150	35.0	-6	-6	0.74	GI072	DW08	AT004
	DWLNL 3225 P 08	32	25	32	32	170	35.0	-6	-6	1.10	GI072	DW08	AT004
	DWLNL 3225 P 10	32	25	32	32	170	38.0	-6	-6	1.14	GI166	DW10	–
	DWLNL 3232 P 13	32	32	32	40	170	40.0	-6	-6	1.43	GI167	DW13	–
	DWLNL 4040 S 13	40	40	40	50	250	41.0	-6	-6	3.17	GI167	DW13	–

GI028	WN.. 0604..
GI072	WN.. 0804..
GI166	WN.. 1006..
GI167	WN.. 1306..

DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P	–
DW08	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	–
DW10	DCS 16	6.4	DWN 100612	US 5018-T20P	–	LK T20P
DW13	DCS 19	6.4	DWN 130612	US 6013-T20P	–	LK T20P

AT004a	CER WN.N 0804..	DCS 12C4
AT004b	CER WN.A 0804..	DCS 12C2

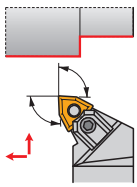
MWLN(RL) EXT

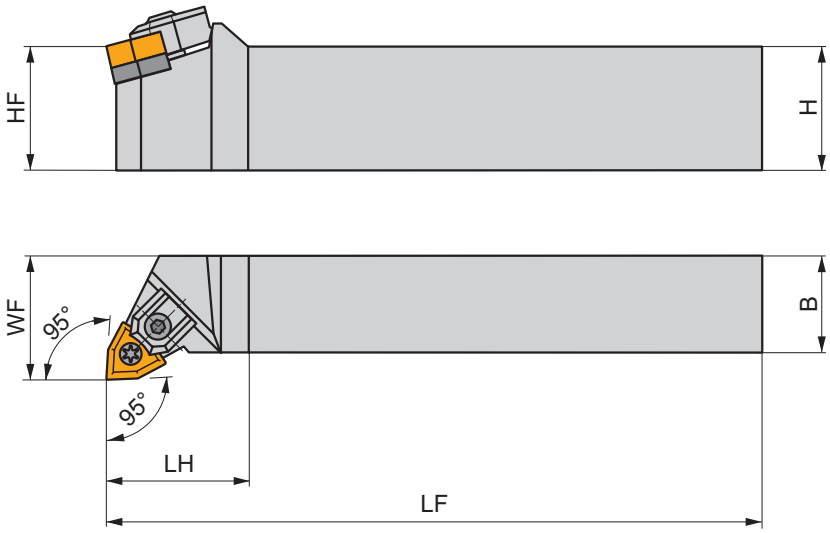
P M K N S H

PRAMET

M

外圆用多重锁紧车刀杆，使用WN..刀片，主偏角为95°。
外圆用左/右手多重锁紧车刀杆，主偏角95°。使用WN..08的负前角刀片。适用于有阶梯外圆的轴向车削，端面，锥面和倒角车削。可提供25x25至40x40mm的刀柄。刀杆经过处理，使用寿命更长。





Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R											
MWLNR 2525 M 08	25	25	25	32	150	34.0	-6	-6	0.73	GI072	MW02
MWLNR 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.09	GI072	MW02
MWLNR 4040 S 08	40	40	40	50	250	45.0	-6	-6	3.14	GI072	MW02
L											
MWLNL 2525 M 08	25	25	25	32	150	34.0	-6	-6	0.78	GI072	MW02
MWLNL 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.02	GI072	MW02
MWLNL 4040 S 08	40	40	40	50	250	45.0	-6	-6	3.14	GI072	MW02

GI072	WN.. 0804..

MW02	UE 11	4.0 Nm	MWS 433	UC 61	HS 94	HXK 5

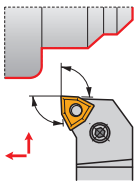
PWLN(RL) EXT

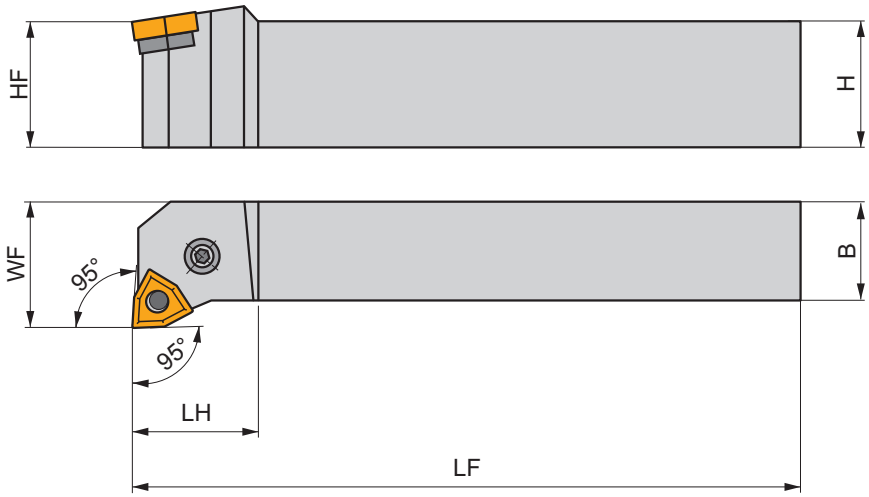
P M K N S H

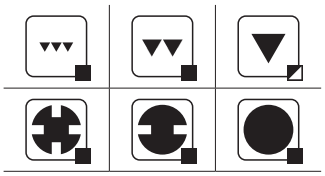
PRAMET

P

外圆用杠杆夹紧式车刀杆，使用WN..刀片，主偏角为95°。
外圆用左/右手杠杆夹紧式车削刀杆，主偏角为95°。使用WN..06和08负前角刀片。适用于有阶梯外圆的轴向车削，端面，锥面和倒角车削。可提供16x16至32x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PWLNR 1616 H 0604**	16	16	16	20	100	22.0	-6	-6	0.22	GI028	PW01
	PWLNR 2020 K 0604	20	20	20	25	125	22.0	-6	-6	0.40	GI028	PW01
	PWLNR 2525 M 0604	25	25	25	32	150	25.0	-6	-6	0.75	GI028	PW01
	PWLNR 2020 K 08	20	20	20	25	125	28.0	-6	-6	0.41	GI072	PW02
	PWLNR 2525 M 08	25	25	25	32	150	28.0	-6	-6	0.76	GI072	PW02
	PWLNR 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.05	GI072	PW02
L	**PWLNL 1616 H 0604**	16	16	16	20	100	22.0	-6	-6	0.21	GI028	PW01
	PWLNL 2020 K 0604	20	20	20	25	125	22.0	-6	-6	0.41	GI028	PW01
	PWLNL 2525 M 0604	25	25	25	32	150	25.0	-6	-6	0.75	GI028	PW01
	PWLNL 2020 K 08	20	20	20	25	125	28.0	-6	-6	0.40	GI072	PW02
	PWLNL 2525 M 08	25	25	25	32	150	28.0	-6	-6	0.74	GI072	PW02
	PWLNL 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.05	GI072	PW02

GI028	WN.. 0604..
GI072	WN.. 0804..

				Nm					
PW01	PWS 007	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PW02	PWS 008	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3

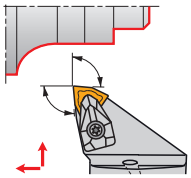
C.-DWLN(RL) EXT

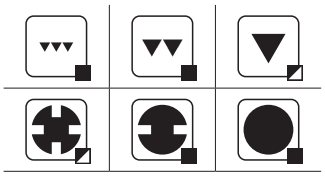
P M K N S H

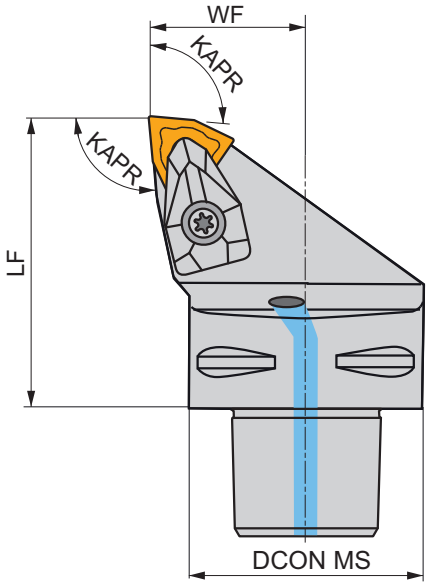
PRAMET

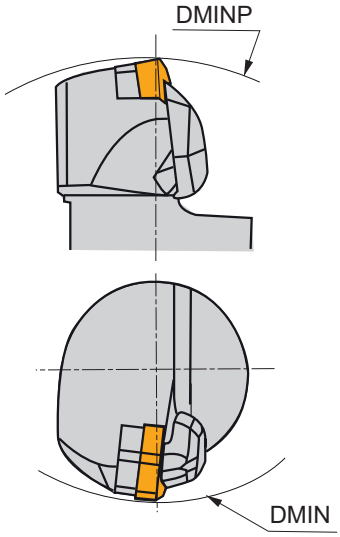
D

外圆用PSC快速更换式刀柄，双重夹紧，使用WN..刀片，主偏角为95°。
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为95°。使用WN..06和08负前角刀片。适用于端面，有阶梯外圆的轴向车削，锥面和倒角。可提供C4至C6刀柄。刀杆经过处理，使用寿命更长。









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	**C4-DWLNR-27050-06**	40	60	140	27	50	95	-6	-6	✓	0.42	GI028	C-DW06	–
	C4-DWLNR-27050-08	40	110	140	27	50	95	-6	-6	✓	0.42	GI072	C-DW08-1	AT004
	C5-DWLNR-35060-08	50	110	165	35	60	95	-6	-6	✓	0.74	GI072	C-DW08-2	AT004
	C6-DWLNR-45065-08	63	110	190	45	65	95	-6	-6	✓	1.34	GI072	C-DW08-2	AT004
L	**C4-DWLNL-27050-06**	40	60	140	27	50	95	-6	-6	✓	0.43	GI028	C-DW06	–
	C4-DWLNL-27050-08	40	110	140	27	50	95	-6	-6	✓	0.42	GI072	C-DW08-1	AT004
	C5-DWLNL-35060-08	50	110	165	35	60	95	-6	-6	✓	0.76	GI072	C-DW08-2	AT004
	C6-DWLNL-45065-08	63	110	190	45	65	95	-6	-6	✓	1.34	GI072	C-DW08-2	AT004

GI028	WN.. 0604..
GI072	WN.. 0804..

		Nm				
C-DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P	CN 034-01
C-DW08-1	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DW08-2	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	CN 045-01

AT004a	CER WN.N 0804..	DCS 12C4
AT004b	CER WN.A 0804..	DCS 12C2

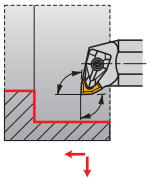
DWLN(RL) INT

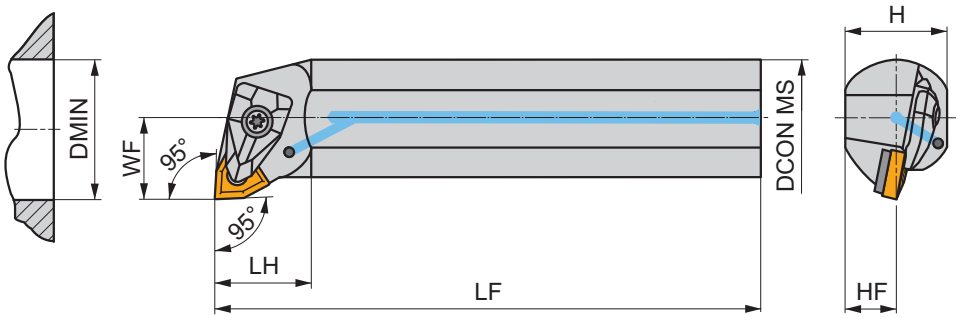
P M K N S H

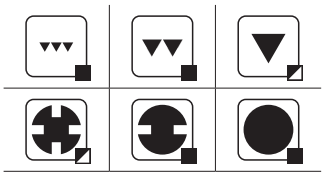
PRAMET

D

内孔双重刚性夹紧镗杆，使用WN..刀片，主偏角为95°。
内孔左/右手双重刚性夹紧镗杆，有内冷通道，主偏角为95°，使用负前角WN..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	**A25T-DWLNR 06**	25	32	17	23	11.5	300	31.0	-14	-6	✓	0.97	GI028	DW06
	A25T-DWLNR 08	25	33	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI072	DWI08
	A32T-DWLNR 08	32	40	22	30	15	300	33.0	-10	-6	✓	1.70	GI072	DWI08
	A40T-DWLNR 08	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.59	GI072	DW08
	A50U-DWLNR 08	50	63	35	47	23.5	350	39.0	-11	-6	✓	5.24	GI072	DW08
L	**A25T-DWLNL 06**	25	32	17	23	11.5	300	31.0	-14	-6	✓	0.97	GI028	DW06
	A25T-DWLNL 08	25	33	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI072	DWI08
	A32T-DWLNL 08	32	40	22	30	15	300	33.0	-10	-6	✓	1.70	GI072	DWI08
	A40T-DWLNL 08	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.59	GI072	DW08
	A50U-DWLNL 08	50	63	35	47	23.5	350	39.0	-11	-6	✓	5.25	GI072	DW08

GI028	WN.. 0604..
GI072	WN.. 0804..

		Nm			
DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P
DW08	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5
DWI08	DCS 12	3.9	DWS 328-02	US 2002-T15P	FLAG T15P/3,5

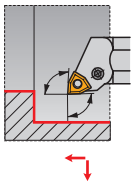
PWLN(RL) INT

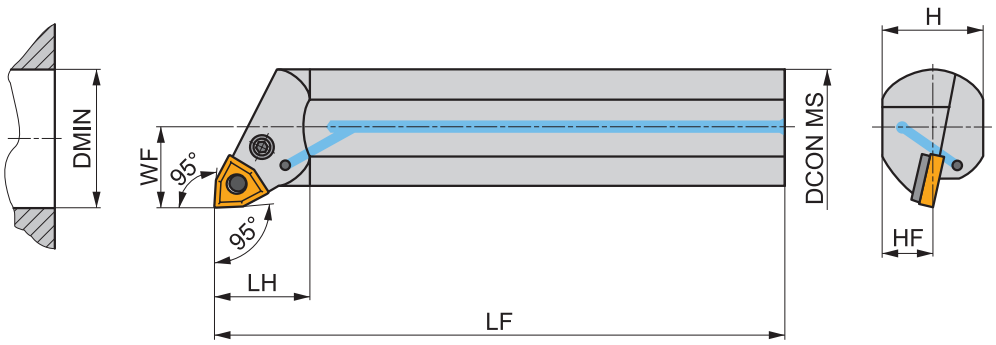
P M K N S H

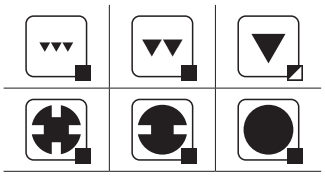
PRAMET

P

外圆杠杆夹紧镗杆，使用WN..刀片，主偏角为95°。
内孔左/右手杠杆夹紧镗杆，有内冷通道，主偏角为95°，使用WN..刀片。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A16M-PWLNR 0604**	16	20	11	15	–	150	-18	-4	✓	0.24	GI028	PT04
	A20Q-PWLNR 0604	20	27	13	18	–	180	-18	-4	✓	0.36	GI028	PT04
	A25R-PWLNR 0604	25	31	17	23	–	200	-14	-4	✓	0.72	GI028	PW01
	A32S-PWLNR 0604	32	39	22	30	–	250	-12	-4	✓	1.30	GI028	PW01
	A25R-PWLNR 08	25	31	17	23	–	200	-14	-4	✓	0.66	GI072	PC06
	A32S-PWLNR 08	32	39	22	30	–	250	-12	-4	✓	1.46	GI072	PW02
	A40T-PWLNR 08	40	48	27	37	–	300	-12	-4	✓	2.40	GI072	PW02
	A50U-PWLNR 08	50	61	35	47	–	350	-12	-4	✓	4.88	GI072	PW02
	A60V-PWLNR 08	60	80	43	57	–	400	-12	-4	–	8.10	GI072	PW02
L	**A16M-PWLNL 0604**	16	20	11	15	–	150	-18	-4	✓	0.22	GI028	PT04
	A20Q-PWLNL 0604	20	27	13	18	–	180	-18	-4	✓	0.36	GI028	PT04
	A25R-PWLNL 0604	25	31	17	23	–	200	-14	-4	✓	0.71	GI028	PW01
	A25R-PWLNL 08	25	31	17	23	–	200	-14	-4	✓	0.71	GI072	PC06
	A32S-PWLNL 08	32	39	22	30	–	250	-12	-4	✓	1.43	GI072	PW02
	A40T-PWLNL 08	40	48	27	37	–	300	-12	-4	–	2.70	GI072	PW02
	A50U-PWLNL 08	50	61	35	47	–	350	-12	-4	✓	4.88	GI072	PW02

GI028	WN.. 0604..
GI072	WN.. 0804..

				Nm					
PW01	PWS 007	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PW02	PWS 008	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PT04	–	CL 216	CS 605	1.4	M 5x1	12	–	–	HXK 2
PC06	–	CL 212	CS 626	2.0	M 6x1	13.4	–	–	HXK 2.5

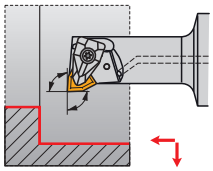
C.-DWLN(RL) INT

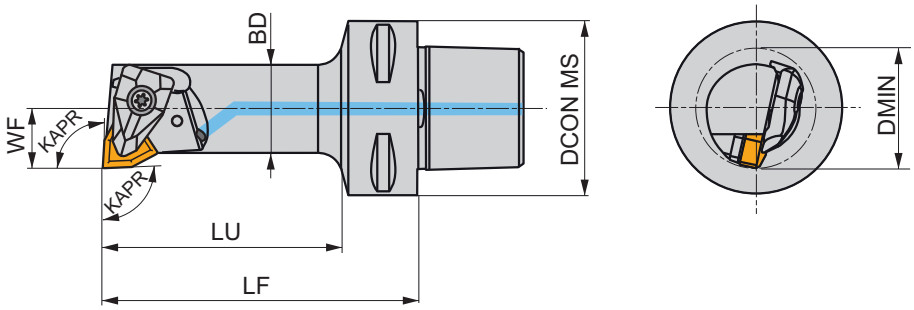
P M K N S H

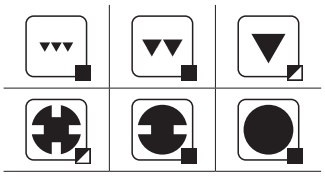
PRAMET

D

内孔PSC快换刀柄，双重刚性夹紧，使用WN..刀片，主偏角为95°。
内孔左/右手双重刚性夹紧镗杆，有内冷通道，主偏角为95°。使用WN..06和08刀片。适用于内孔锥面，和有阶梯孔的轴向车削，和倒角车削。可提供C4的PSC刀柄。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	**C4-DWLNR-13075-06**	40	27	13	75	52	20	95	-17	-6	✓	0.42	GI028	DW06
R	**C4-DWLNR-17090-08**	40	33	17	90	68	25	95	-12	-6	✓	0.53	GI072	DWI08
L	**C4-DWLNL-13075-06**	40	27	13	75	52	20	95	-17	-6	✓	0.42	GI028	DW06
L	**C4-DWLNL-17090-08**	40	33	17	90	68	25	95	-12	-6	✓	0.53	GI072	DWI08

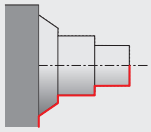
GI028	WN.. 0604..
GI072	WN.. 0804..

		Nm			
DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P
DWI08	DCS 12	3.9	DWS 328-02	US 2002-T15P	FLAG T15P/3,5

P 夹紧类型

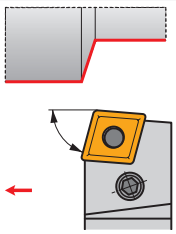
ISO 外圆车削

短型和稳定工件 (负角刀片)



PCBN(RL) EXT 75°

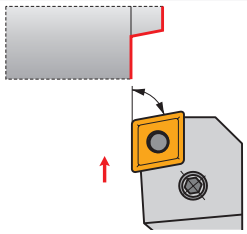
CN..



251

PCKN(RL) EXT 75°

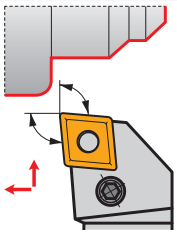
CN..



252

PCLN(RL) EXT 95°

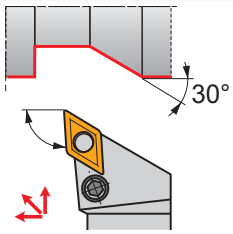
CN..



253

PDJN(RL) EXT 93°

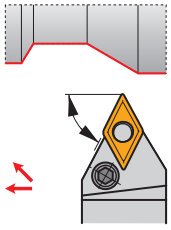
DN..



264

PDNN(RL) EXT 62°30´

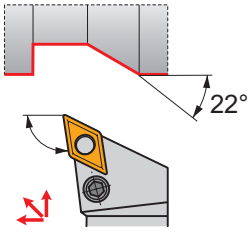
DN..



265

PDXN(RL) EXT 98°

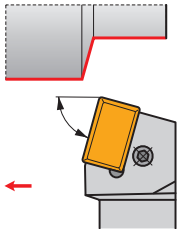
DN..



266

PLBN(RL) EXT 75°

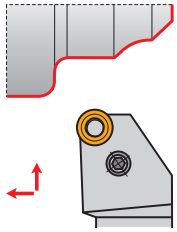
LN..



274

PRSN(RL) EXT

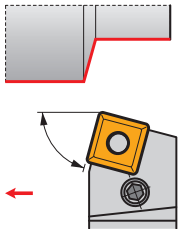
RN..



278

PSBN(RL) EXT 75°

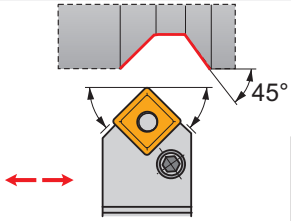
SN..



285

PSDNN EXT 45°

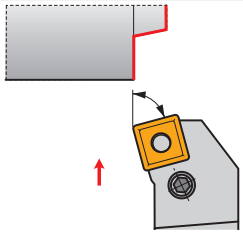
SN..



287

PSKN(RL) EXT 75°

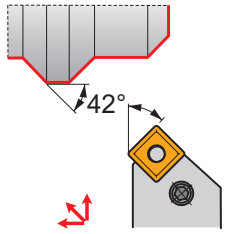
SN..



288

PSSN(RL) EXT 45°

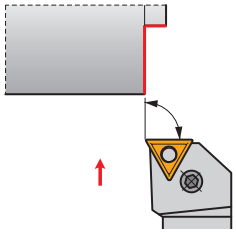
SN..



290

PTFN(RL) EXT 90°

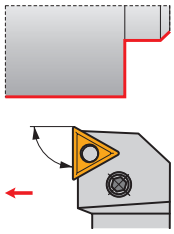
TN..



302

PTGN(RL) EXT 90°

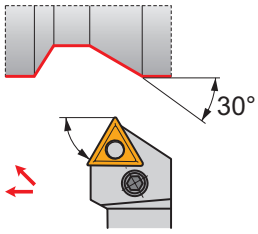
TN..



303

PTTN(RL) EXT 60°

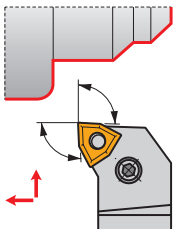
TN..



304

PWLN(RL) EXT 95°

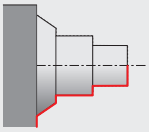
WN..



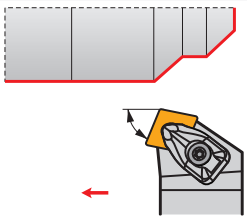
317

D 夹紧类型

ISO 外圆车削
短型和稳定工件 (负角刀片)

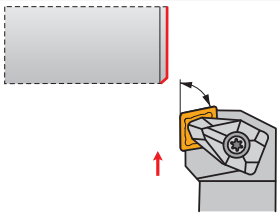


DCBN(RL) EXT 75°
CN..



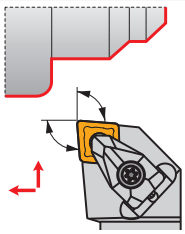
246

DCKN(RL) EXT 75°
CN..



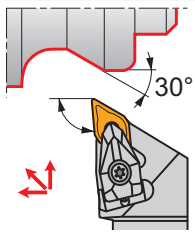
248

DCLN(RL) EXT 95°
CN..



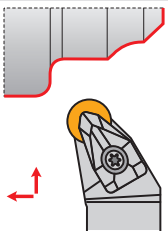
249

DDJN(RL) EXT 93°
DN..



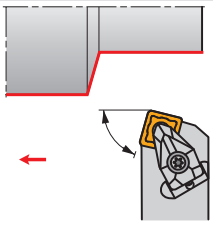
263

DRSN(RL) EXT
RN..



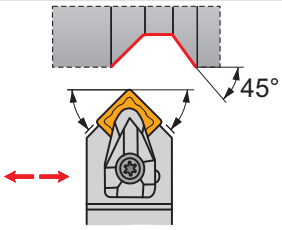
277

DSBN(RL) EXT 45°
SN..



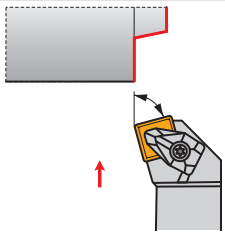
280

DSDNN EXT 45°
SN..



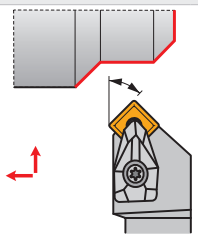
281

DSKN(RL) EXT 75°
SN..



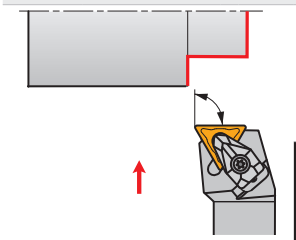
282

DSSN(RL) EXT 45°
SN..



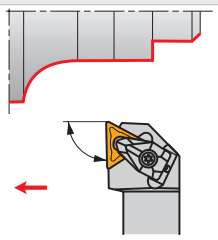
283

DTFN(RL) EXT 90°
TN..



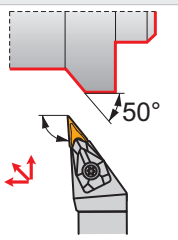
299

DTGN(RL) EXT 90°
TN..



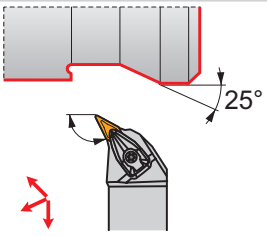
300

DVJN(RL) EXT 93°
VN..



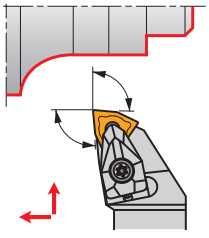
309

DVPN(RL) EXT 62°30´
VN..



310

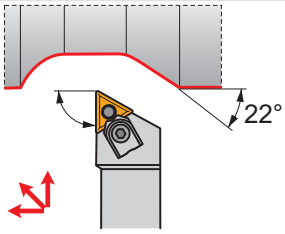
DWLN(RL) EXT 95°
WN..



314

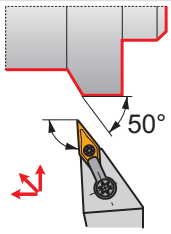
M 夹紧类型

MTJN(RL) EXT 93°
TN..



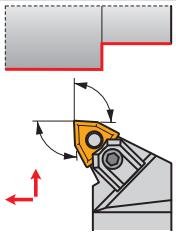
301

MVJN(RL) EXT 93°
VN..



311

MWLN(RL) EXT 95°
WN..

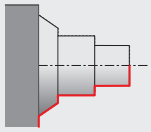


316

KHP / DKH 夹紧类型

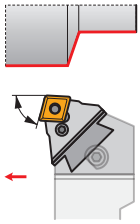
ISO 外圆重载车削

可换刀头(KH)



KHP-CBNR 75°

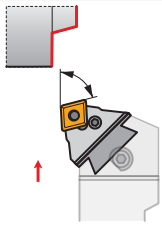
CN..



256

KHP-CBNL 75°

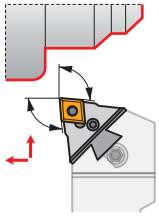
CN..



256

KHP-CLNR/L 95°

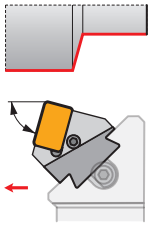
CN..



257

KHP-LBNR 75°

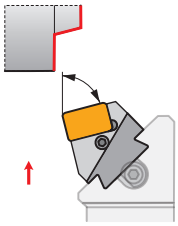
LN..



275

KHP-LBNL 75°

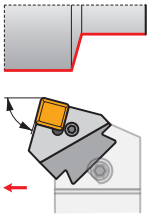
LN..



275

KHP-SBNR 75°

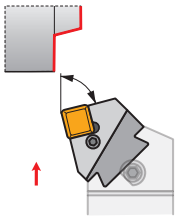
SN..



295

KHP-SBNL 75°

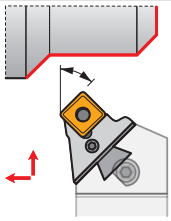
SN..



295

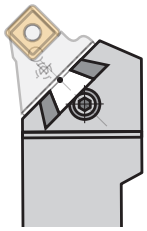
KHP-SSNR/L 45°

SN..



296

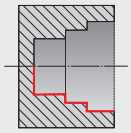
DKH(RL)



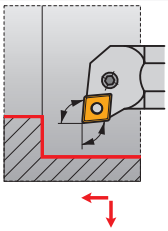
258, 276, 297

P 夹紧类型

ISO 内孔车削
短型和稳定工件 (负角刀片)

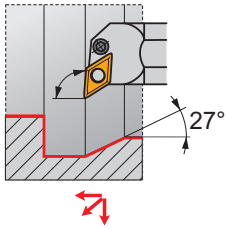


PCLN(RL) INT 95°
CN..



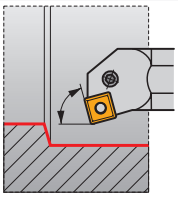
260

PDUN(RL) INT 93°
DN..



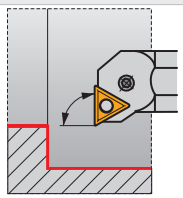
271

PSKN(RL) INT 93°
SN..



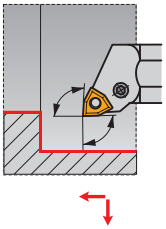
298

PTFN(RL) INT 90°
TN..



307

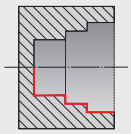
PWLN(RL) INT 95°
WN..



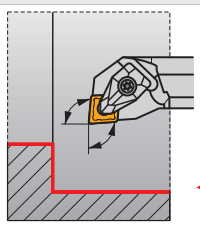
320

D 夹紧类型

ISO 内孔车削
短型和稳定工件 (负角刀片)

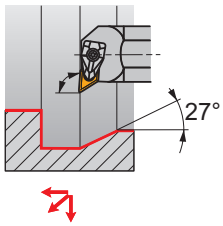


DCLN(RL) INT 95°
CN..



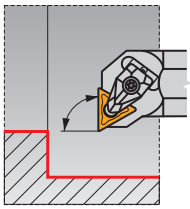
259

DDUN(RL) INT 93°
DN..



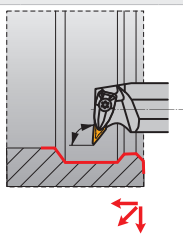
270

DTFN(RL) INT 90°
TN..



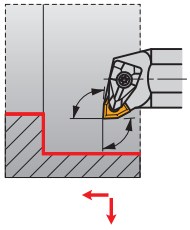
306

DVUN(RL) INT
VN..



313

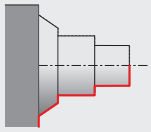
DWLN(RL) INT 95°
WN..



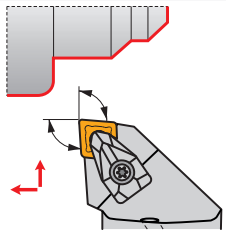
319

D 夹紧类型

ISO 外圆车削 PSC
短型和稳定工件 (负角刀片)

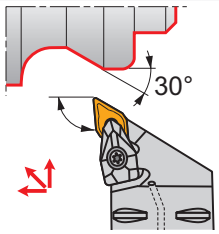


C.-DCLN(RL) EXT 95°
CN..



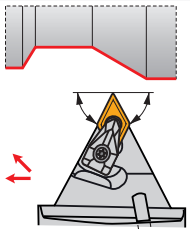
254

C.-DDJN(RL) EXT 93°
DN..



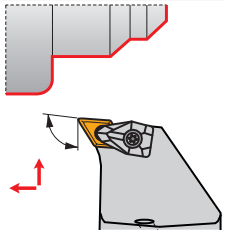
267

C.-DDNNN EXT 62.5°
DN..



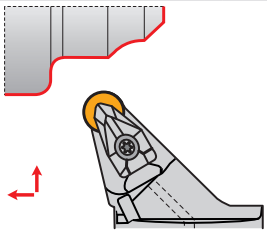
268

C.-DDUN(RL) EXT 93°
DN..



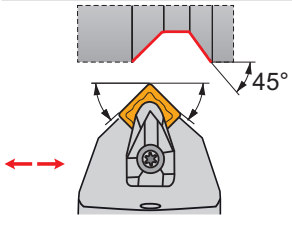
269

C.-DRSN(RL) EXT
RN..



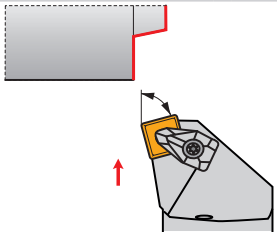
279

C.-DSDNN EXT 45°
SN..



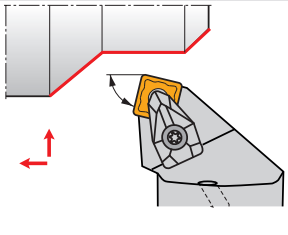
291

C.-DSKN(RL) EXT 75°
SN..



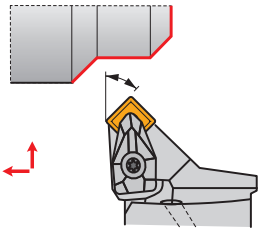
292

C.-DSRN(RL) EXT 75°
SN..



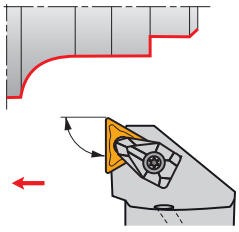
293

C.-DSSN(RL) EXT 45°
SN..



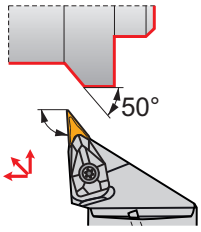
294

C.-DTJN(RL) EXT 93°
TN..



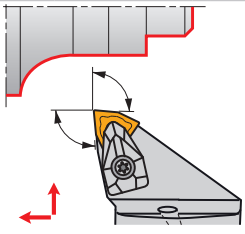
305

C.-DVJN(RL) EXT 93°
VN..



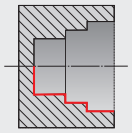
312

C.-DWLN(RL) EXT 95°
WN..

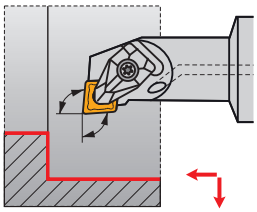


318

ISO 内孔车削 PSC
短型和稳定工件 (负角刀片)

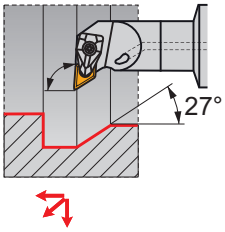


C.-DCLN(RL) INT 95°
CN..



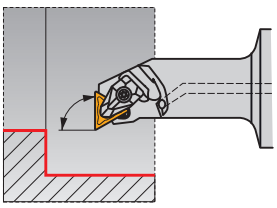
262

C.-DDUN(RL) INT 93°
DN..



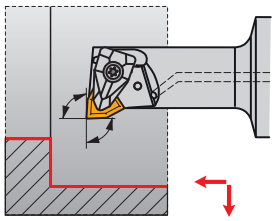
272

C.-DTFN(RL) INT 91°
TN..



308

C.-DWLN(RL) INT 95°
WN..



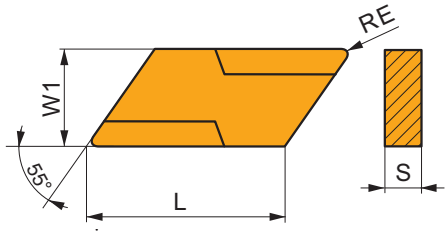
321

其他硬质合金和金属陶瓷刀片

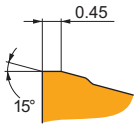
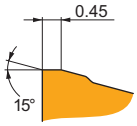
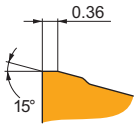
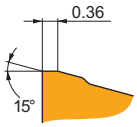
KNUX

PRAMET

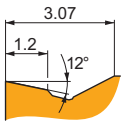
	W1 (mm)	L (mm)	S (mm)
1604	9.525	19.50	4.76



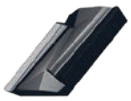
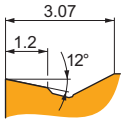
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
																				
L-22 屑槽，左手设计，适用于精加工至中粗加工，连续切削。																				
KNUX 160405L-22:T5315	●	0.5	◪	190	0.25	2.7		–	–	–	◪	180	0.25	2.7		–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T7325	●	0.5	◪	130	0.25	2.7	◪	100	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T7335	●	0.5	◪	125	0.25	2.7	◪	95	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T9325	●	0.5	■	155	0.25	2.7	◪	90	0.25	2.7	◪	145	0.25	2.7		–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T9335	●	0.5	■	135	0.25	2.7	◪	80	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160410L-22:T9335	⬌	1.0	■	155	0.32	2.7	◪	90	0.29	2.7		–	–	–		–	–	–	–	–	–	–	–	–
																				
R-22 屑槽，右手设计，适用于精加工至中粗加工，连续切削。																				
KNUX 160405R-22:T5315	●	0.5	◪	190	0.25	2.7		–	–	–	◪	180	0.25	2.7		–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T7325	●	0.5	◪	130	0.25	2.7	◪	100	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T7335	●	0.5	◪	125	0.25	2.7	◪	95	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T9325	●	0.5	■	155	0.25	2.7	◪	90	0.25	2.7	◪	145	0.25	2.7		–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T9335	●	0.5	■	135	0.25	2.7	◪	80	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160410R-22:T9335	⬌	1.0	■	155	0.32	2.7	◪	90	0.29	2.7		–	–	–		–	–	–	–	–	–	–	–	–
																				
L-32 屑槽，左手设计，适用于精加工至中粗加工，连续切削。																				
KNUX 160405L-32:T5315	●	0.5	◪	190	0.25	2.7		–	–	–	◪	180	0.25	2.7		–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T7325	●	0.5	◪	130	0.25	2.7	◪	100	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T7335	●	0.5	◪	125	0.25	2.7	◪	95	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T9325	●	0.5	■	155	0.25	2.7	◪	90	0.25	2.7	◪	145	0.25	2.7		–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T9335	●	0.5	■	135	0.25	2.7	◪	80	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160410L-32:T9325	●	1.0	■	175	0.32	2.7	◪	105	0.29	2.7	◪	165	0.32	2.7		–	–	–	–	–	–	–	–	–
KNUX 160410L-32:T9335	●	1.0	■	155	0.32	2.7	◪	90	0.29	2.7		–	–	–		–	–	–	–	–	–	–	–	–
																				
R-32 型，右手设计，适用于精加工至中粗加工，连续切削。																				
KNUX 160405R-32:T5315	●	0.5	◪	190	0.25	2.7		–	–	–	◪	180	0.25	2.7		–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T7325	●	0.5	◪	130	0.25	2.7	◪	100	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T7335	●	0.5	◪	125	0.25	2.7	◪	95	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T9325	●	0.5	■	155	0.25	2.7	◪	90	0.25	2.7	◪	145	0.25	2.7		–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T9335	●	0.5	■	135	0.25	2.7	◪	80	0.25	2.7		–	–	–		–	–	–	–	–	–	–	–	–
KNUX 160410R-32:T9325	●	1.0	■	175	0.32	2.7	◪	105	0.29	2.7	◪	165	0.32	2.7		–	–	–	–	–	–	–	–	–
KNUX 160410R-32:T9335	●	1.0	■	155	0.32	2.7	◪	90	0.29	2.7		–	–	–		–	–	–	–	–	–	–	–	–

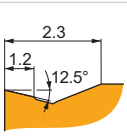
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
																				
KNUX 160405ER-72:T5315	●	0.5	◪	250	0.20	2.0	–	–	–	■	235	0.20	2.0	–	–	–	–	–	–	–	–	–
KNUX 160405ER-72:T9325	●	0.5	■	215	0.20	2.0	◪	125	0.18	2.0	◪	200	0.20	2.0	–	–	–	◪	45	0.16	1.6	–	–	–
KNUX 160405ER-72:T9335	●	0.5	■	185	0.20	2.0	◪	110	0.18	2.0	–	–	–	–	–	–	–	◪	40	0.16	1.6	–	–	–

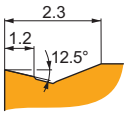
ER-72 屑槽，右手设计，适用于精细的精加工，连续切削。

Product		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)
 																				
KNUX 160405EL-72:T5315	●	0.5	◪	250	0.20	2.0	–	–	–	■	235	0.20	2.0	–	–	–	–	–	–	–	–	–
KNUX 160405EL-72:T9325	●	0.5	■	215	0.20	2.0	◪	125	0.18	2.0	◪	200	0.20	2.0	–	–	–	◪	45	0.16	1.6	–	–	–
KNUX 160405EL-72:T9335	●	0.5	■	185	0.20	2.0	◪	110	0.18	2.0	–	–	–	–	–	–	–	◪	40	0.16	1.6	–	–	–

EL-72 屑槽，左手设计，适用于精细的精加工，连续切削。

Product		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)
																				
KNUX 160405SR-73:6640	●	0.5	■	150	0.25	3.0	◪	90	0.23	3.0	■	140	0.25	3.0	–	–	–	–	–	–	–	–	–
KNUX 160410SR-73:6640	⬌	1.0	■	150	0.40	3.0	◪	90	0.36	3.0	■	140	0.40	3.0	–	–	–	–	–	–	–	–	–
KNUX 160410SR-73:T5315	●	1.0	◪	235	0.40	3.0	–	–	–	■	220	0.40	3.0	–	–	–	–	–	–	–	–	–

ER-73 型，右手设计，适用于精加工至中粗加工，连续切削。

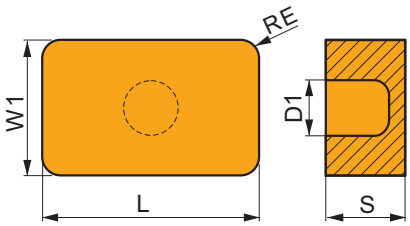
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
KNUX 160405SL-73:6640	●	0.5	■	150	0.25	3.0	◪	90	0.23	3.0	■	140	0.25	3.0	–	–	–	–	–	–	–	–	–
KNUX 160410SL-73:6640	⬌	1.0	■	150	0.40	3.0	◪	90	0.36	3.0	■	140	0.40	3.0	–	–	–	–	–	–	–	–	–

EL-73 屑槽，左手设计，适用于精加工至中粗加工，连续切削。

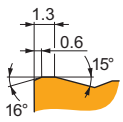
LNUX 40, LN.X 50

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
40-1	25.200	9.30	40.00	14.00
50-1	25.400	9.30	50.80	14.00
5014	25.400	6.35	50.80	14.00

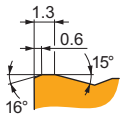
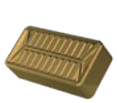
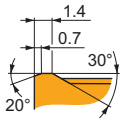


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
																				
LNUX 40-1129003:6630	⬌	3.2	■	45	1.35	25.0	–	–	–	◪	40	1.35	25.0	–	–	–	–	–	–	–	–	–
LNUX 40-1129003:T9325	⬌	3.2	■	55	1.35	25.0	–	–	–	◪	50	1.35	25.0	–	–	–	–	–	–	–	–	–
LNUX 40-1129003:T9335	⬌	3.2	■	40	1.35	25.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

LN.X 适用于重载粗加工，连续至断续切削。

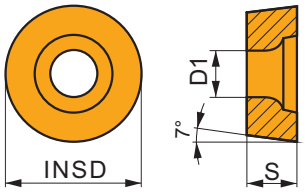
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	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)
 LN.X 适用于重载粗加工，连续至断续切削。																			
LNUX 50-1275000:6630	3.2	45	1.35	25.0	–	–	–	40	1.35	25.0	–	–	–	–	–	–	–	–	–
LNUX 50-1275000:T9325	3.2	55	1.35	25.0	–	–	–	50	1.35	25.0	–	–	–	–	–	–	–	–	–
  LN.X 设计用于重载粗加工，连续至重载断续切削。																			
LNMX 501432E:T9335	3.2	45	1.50	25.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

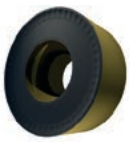
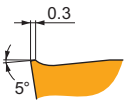
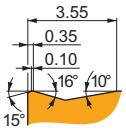
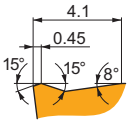
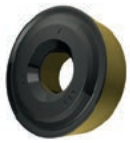
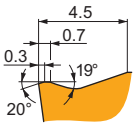
RCMT

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1606	16.000	5.50	6.35
2006	20.000	6.50	6.35
2507	25.000	8.60	7.94
3009	30.000	10.00	9.53



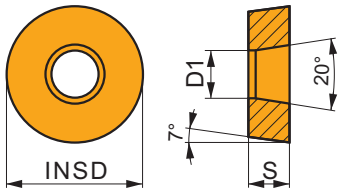
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	RE (mm)	P vc (m/min)	P f (mm/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)
  37 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。																			
RCMT 1606MOS-37:T9325	–	145	0.60	3.0	–	–	–	135	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMT 1606MOS-37:T9415	–	200	0.60	3.0	–	–	–	190	0.60	3.0	–	–	–	–	–	–	–	–	–
 371 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。																			
RCMT 2006MOS-371:T9325	–	125	0.80	3.0	–	–	–	115	0.80	3.0	–	–	–	–	–	–	–	–	–
RCMT 2006MOS-371:T9415	–	185	0.80	3.0	–	–	–	175	0.80	3.0	–	–	–	–	–	–	–	–	–
 372 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。																			
RCMT 2507MOS-372:T9325	–	90	0.80	3.0	–	–	–	85	0.80	3.0	–	–	–	–	–	–	–	–	–
  RR4 几何形状适用于重型粗加工和连续到重型断续切削。																			
RCMT 3009MO-RR4:T9310	–	90	1.10	4.0	–	–	–	85	1.10	4.0	–	–	–	–	–	–	–	–	–
RCMT 3009MO-RR4:T9315	–	85	1.10	4.0	–	–	–	80	1.10	4.0	–	–	–	–	–	–	–	–	–
RCMT 3009MO-RR4:T9415	–	95	1.10	4.0	–	–	–	90	1.10	4.0	–	–	–	–	–	–	–	–	–

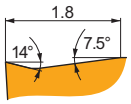
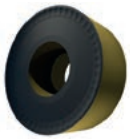
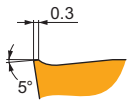
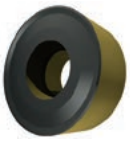
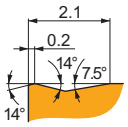
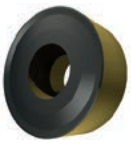
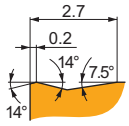
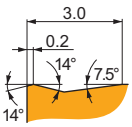
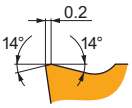
RCMX

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.60	3.18
1204	12.000	4.20	4.76
1606	16.000	5.20	6.35
2006	20.000	6.50	6.35
2507	25.000	7.20	7.94
3209	32.000	9.50	9.53



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/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)
																				
RCMX 1003MOS-31:T9325		–	165	0.50	2.0	95	0.45	2.0	155	0.50	2.0	–	–	–	–	–	–	–	–	–
 																				
RCMX 1606MOS-37:T9325		–	145	0.60	3.0	–	–	–	135	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-37:T9415		–	200	0.60	3.0	–	–	–	190	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMX 2006MOS-37:6630		–	135	0.60	3.0	–	–	–	125	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMX 2507MOS-37:6630		–	90	0.60	3.0	–	–	–	85	0.60	3.0	–	–	–	–	–	–	–	–	–
 																				
RCMX 1204MOS-321:T9325		–	120	1.00	3.0	–	–	–	110	1.00	3.0	–	–	–	–	–	–	–	–	–
RCMX 1204MOS-321:T9415		–	170	1.00	3.0	–	–	–	160	1.00	3.0	–	–	–	–	–	–	–	–	–
 																				
RCMX 1606MOS-331:6630		–	100	1.20	3.5	–	–	–	95	1.20	3.5	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-331:T9325		–	105	1.20	3.5	–	–	–	95	1.20	3.5	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-331:T9335		–	110	0.80	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-331:T9415		–	155	1.20	3.5	–	–	–	145	1.20	3.5	–	–	–	–	–	–	–	–	–
																				
RCMX 2006MOS-341:6630		–	105	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006MOS-341:6640		–	90	1.00	3.5	–	–	–	85	1.00	3.5	–	–	–	–	–	–	–	–	–
																				
RCMX 2507MOS-351:6630		–	70	1.00	3.5	–	–	–	65	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507MOS-351:6640		–	60	1.00	3.5	–	–	–	55	1.00	3.5	–	–	–	–	–	–	–	–	–

31 断屑槽适用于精加工至中粗加工，连续至断续切削。

37 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。

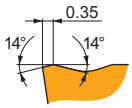
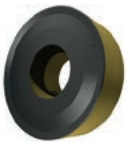
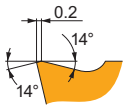
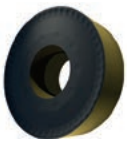
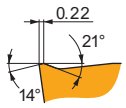
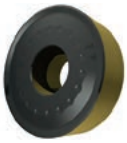
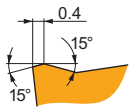
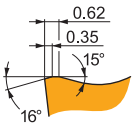
321 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。

331 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。

341 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。

351 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。

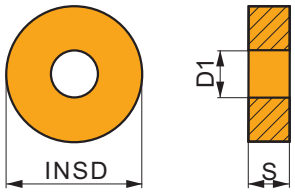
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
 HFC S	361 断屑槽适用于粗加工至重载粗加工，连续切削至重载切削的连续切削。																			
RCMX 3209M0S-361:6640		–	50	1.40	4.5	–	–	–	45	1.40	4.5	–	–	–	–	–	–	–	–	–
  HFC S	RF1 屑槽，适用于精加工至中粗加工，连续至断续切削。																			
RCMX 2006M0-RF1:T5305		–	105	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9310		–	105	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9315		–	100	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9325		–	90	0.80	3.5	–	–	–	85	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9335		–	110	0.80	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9415		–	105	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T8345		–	45	1.00	3.5	–	–	–	40	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9310		–	95	1.00	3.5	–	–	–	90	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9325		–	80	1.00	3.5	–	–	–	75	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9335		–	65	1.00	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9415		–	100	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
  HFC S	RM1 屑槽，适用于粗加工至粗加工，连续至断续切削。																			
RCMX 2006M0-RM1:T9310		–	95	1.00	3.5	–	–	–	90	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9315		–	90	1.00	3.5	–	–	–	85	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9325		–	80	1.00	3.5	–	–	–	75	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9335		–	125	0.60	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9415		–	100	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9310		–	95	1.00	3.5	–	–	–	90	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9315		–	90	1.00	3.5	–	–	–	85	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9325		–	80	1.00	3.5	–	–	–	75	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9335		–	80	0.60	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9415		–	100	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
  HFC S	RM2 屑槽，适用于中粗加工至粗加工，连续至断续切削。																			
RCMX 2507M0-RM2:T9310		–	90	1.10	3.5	–	–	–	85	1.10	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM2:T9325		–	75	1.10	3.5	–	–	–	70	1.10	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM2:T9415		–	95	1.10	3.5	–	–	–	90	1.10	3.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T5315		–	95	1.00	4.5	–	–	–	90	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9310		–	90	1.00	4.5	–	–	–	85	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9315		–	85	1.00	4.5	–	–	–	80	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9325		–	75	1.00	4.5	–	–	–	70	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9335		–	55	1.40	4.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9415		–	95	1.00	4.5	–	–	–	90	1.00	4.5	–	–	–	–	–	–	–	–	–
 HFC P	RR2 屑槽，适用于于重载粗加工，连续至断续切削。																			
RCMX 3209M0-RR2:T9315		–	60	1.40	4.5	–	–	–	55	1.40	4.5	–	–	–	–	–	–	10	0.70	2.0
RCMX 3209M0-RR2:T9415		–	70	1.40	4.5	–	–	–	65	1.40	4.5	–	–	–	–	–	–	10	0.70	2.0

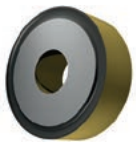
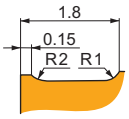
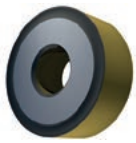
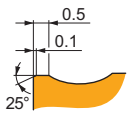
RNMG

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1204	12.700	5.16	4.76
1506	15.875	6.35	6.35
1906	19.050	7.94	6.35
2509	25.400	9.12	9.53



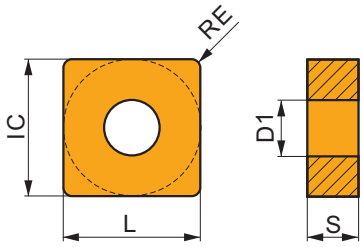
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
  HFC S 08 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。																				
RNMG 120400E-08:T5305	●	–	195	0.70	3.0	–	–	–	185	0.70	3.0	–	–	–	–	–	–	35	0.35	0.8
RNMG 120400E-08:T9325	●	–	135	0.70	3.0	–	–	–	125	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 120400E-08:T9415	●	–	190	0.70	3.0	–	–	–	180	0.70	3.0	–	–	–	–	–	–	35	0.35	0.8
RNMG 150600E-08:T5305	●	–	195	0.70	3.0	–	–	–	185	0.70	3.0	–	–	–	–	–	–	35	0.35	1.0
RNMG 150600E-08:T9325	✱	–	205	0.70	3.0	–	–	–	190	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 150600E-08:T9415	●	–	190	0.70	3.0	–	–	–	180	0.70	3.0	–	–	–	–	–	–	35	0.35	1.0
RNMG 190600E-08:T9325	●	–	135	0.70	3.0	–	–	–	125	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 190600E-08:T9415	●	–	190	0.70	3.0	–	–	–	180	0.70	3.0	–	–	–	–	–	–	35	0.35	1.3
  HFC P 081 断屑槽适用于粗加工至重载粗加工，连续切削至间断切削。																				
RNMG 250900E-081:T9325	✱	–	130	0.90	5.0	–	–	–	120	0.90	5.0	–	–	–	–	–	–	–	–	–
RNMG 250900E-081:T9415	●	–	100	0.90	5.0	–	–	–	95	0.90	5.0	–	–	–	–	–	–	20	0.45	1.7

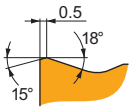
SNMM

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



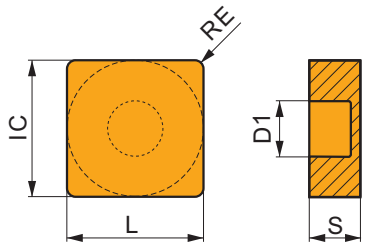
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	Interrupted/ Continuous cut	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)
 P SR 屑槽，适用于粗加工至重载粗加工，连续至断续切削。																				
SNMM 250724S-SR:T9325	✱	2.4	80	1.00	12.0	45	0.90	12.0	75	1.00	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924S-SR:6630	✱	2.4	65	1.00	14.0	35	0.90	14.0	60	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMM 250924S-SR:T9335	✱	2.4	65	1.00	14.0	35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–

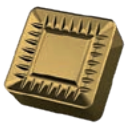
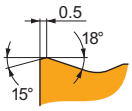
SNMX

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2512	25.400	9.17	25.40	12.00



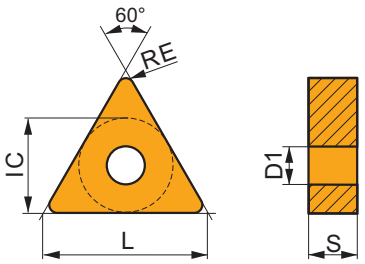
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
 																				
SR 屑槽，适用于粗加工至重载粗加工，连续至断续切削。																				
SNMX 251224S-SR:6630		2.4	65	1.00	14.0	35	0.90	14.0	60	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMX 251224S-SR:T8345		2.4	45	1.00	14.0	25	0.90	14.0	40	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMX 251224S-SR:T9325		2.4	80	1.00	14.0	45	0.90	14.0	75	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMX 251224S-SR:T9335		2.4	65	1.00	14.0	35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–

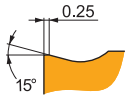
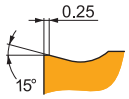
TNMM

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2204	12.700	5.16	22.00	4.76



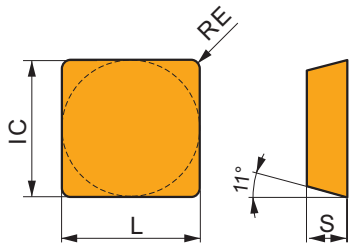
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
																				
ER 屑槽，右手设计，适用于中等至中粗加工，连续切削。																				
TNMM 220412ER:T9335	●	1.2	190	0.35	2.1	110	0.32	2.1	–	–	–	–	–	–	40	0.25	1.7	–	–	–
																				
EL 屑槽，左手设计，适用于中等至中粗加工，连续切削。																				
TNMM 220412EL:T9335	●	1.2	190	0.35	2.1	110	0.32	2.1	–	–	–	–	–	–	40	0.25	1.7	–	–	–

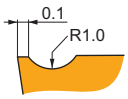
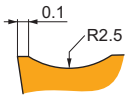
SPMR

PRAMET

	IC (mm)	L (mm)	S (mm)
0903	9.525	9.53	3.18
1203	12.700	12.70	3.18



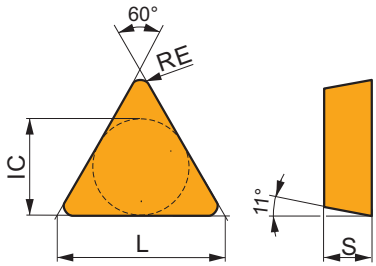
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	● ⇕ ✱	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)
																				
46 断屑槽适用于精细的精加工，连续切削至间断切削。																				
SPMR 090304E-46:T9325	●	0.4	215	0.15	1.0	125	0.15	1.0	200	0.15	1.0	–	–	–	–	–	–	–	–	–
SPMR 090308E-46:T9325	●	0.8	255	0.15	1.0	150	0.15	1.0	240	0.15	1.0	–	–	–	–	–	–	–	–	–
																				
48 断屑槽适用于精加工至中粗加工，连续至断续切削。																				
SPMR 120304E-48:T9325	●	0.4	170	0.22	2.2	100	0.22	2.2	160	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120304E-48:T9335	●	0.4	145	0.22	2.2	85	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
SPMR 120308E-48:6640	⇕	0.8	160	0.22	2.2	95	0.22	2.2	150	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120308E-48:T9325	⇕	0.8	205	0.22	2.2	120	0.22	2.2	190	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120308E-48:T9335	⇕	0.8	175	0.22	2.2	105	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
SPMR 120312E-48:T9325	⇕	1.2	215	0.22	2.2	125	0.22	2.2	200	0.22	2.2	–	–	–	–	–	–	–	–	–

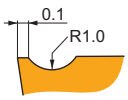
TPMR

PRAMET

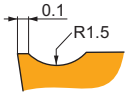
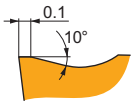
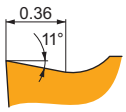
	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



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。

Product	● ⇕ ✱	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)
																				
46 断屑槽适用于精细的精加工，连续切削至间断切削。																				
TPMR 110304E-46:6640	●	0.4	140	0.15	1.0	80	0.14	1.0	130	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110304E-46:T9325	●	0.4	175	0.15	1.0	105	0.15	1.0	165	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110304E-46:T9335	●	0.4	150	0.15	1.0	90	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 110308E-46:6640	●	0.8	170	0.15	1.0	100	0.14	1.0	160	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110308E-46:T9325	●	0.8	205	0.15	1.0	120	0.15	1.0	190	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110308E-46:T9335	●	0.8	180	0.15	1.0	105	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–

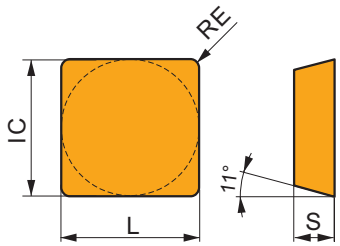
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	RE (mm)	P vc (m/min)	P f (mm/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)
	47 断屑槽适用于精加工至中粗加工，连续至断续切削。																			
TPMR 160304E-47:6640	●	0.4	120	0.20	1.5	70	0.18	1.5	110	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160304E-47:T9325	●	0.4	150	0.20	1.5	90	0.18	1.5	140	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160304E-47:T9335	●	0.4	125	0.20	1.5	75	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 160308E-47:6640	●	0.8	140	0.20	1.5	80	0.18	1.5	130	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160308E-47:T9325	●	0.8	175	0.20	1.5	105	0.18	1.5	165	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160308E-47:T9335	●	0.8	150	0.20	1.5	90	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 160312E-47:T9325	●	1.2	185	0.20	1.5	110	0.18	1.5	175	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160312E-47:T9335	●	1.2	160	0.20	1.5	95	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
	61 断屑槽适用于中等进给和切削深度的精加工，连续至断续切削。																			
TPMR 160308E-61:T9325	●	0.8	135	0.35	1.8	80	0.32	1.8	125	0.35	1.8	–	–	–	–	–	–	–	–	–
TPMR 160308E-61:T9335	●	0.8	120	0.35	1.8	70	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–
	PF2 屑槽，适用于精细的精加工，连续切削。																			
TPMR 110304-PF2:TT010	●	0.4	255	0.10	0.5	150	0.10	0.5	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 160304-PF2:TT010	●	0.4	255	0.10	0.5	150	0.10	0.5	–	–	–	–	–	–	–	–	–	–	–	–

SPUN-IT

PRAMET

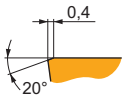
	IC (mm)	L (mm)	M (mm)	S (mm)
1203	12.700	12.70	2.3	3.18
1504	15.875	15.88	2.8	4.76
1904	19.050	19.05	3.5	4.76
2506	25.400	25.40	4.4	6.35



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/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)
	SPUN 适用于超精加工至中粗加工，连续至轻微断续切削。																			
SPUN 120308:6640	●	0.8	180	0.15	4.0	–	–	–	170	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 120312:6640	●	1.2	190	0.15	4.0	–	–	–	180	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 150408:6640	●	0.8	155	0.20	5.0	–	–	–	145	0.20	5.0	–	–	–	–	–	–	–	–	–

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/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)
SPUN 150412:6640		1.2	165	0.20	5.0	–	–	–	155	0.20	5.0	–	–	–	–	–	–	–	–	–
SPUN 190408:6640		0.8	150	0.20	6.0	–	–	–	140	0.20	6.0	–	–	–	–	–	–	–	–	–
SPUN 190412:6640		1.2	160	0.20	6.0	–	–	–	150	0.20	6.0	–	–	–	–	–	–	–	–	–
SPUN 190416:6640		1.6	165	0.20	6.0	–	–	–	155	0.20	6.0	–	–	–	–	–	–	–	–	–
																				
SPUN 250620S:6640		2.0	80	0.40	12.0	–	–	–	75	0.40	12.0	–	–	–	–	–	–	–	–	–

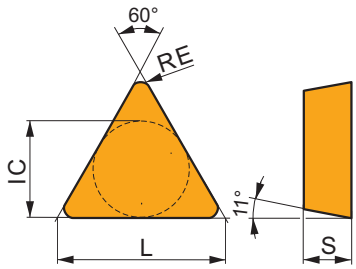
SPUN 适用于超精加工至中粗加工，连续至轻微断续切削。

SPUN..S 适用于超精加工至中粗加工，连续至轻微断续切削。

TPUN-IT

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
2706	15.875	27.50	6.35
3306	19.050	33.00	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/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)
TPUN 110304:6640		0.4	135	0.10	1.2	–	–	–	125	0.10	1.2	–	–	–	–	–	–	–	–	–
TPUN 110308:6640		0.8	125	0.18	1.2	–	–	–	115	0.18	1.2	–	–	–	–	–	–	–	–	–
TPUN 160304:6640		0.4	135	0.10	1.5	–	–	–	125	0.10	1.5	–	–	–	–	–	–	–	–	–
TPUN 160308:6640		0.8	125	0.18	1.5	–	–	–	115	0.18	1.5	–	–	–	–	–	–	–	–	–
TPUN 160312:6640		1.2	125	0.20	1.5	–	–	–	115	0.20	1.5	–	–	–	–	–	–	–	–	–
TPUN 220408:6640		0.8	120	0.18	2.0	–	–	–	110	0.18	2.0	–	–	–	–	–	–	–	–	–
TPUN 220412:6640		1.2	120	0.20	2.0	–	–	–	110	0.20	2.0	–	–	–	–	–	–	–	–	–
TPUN 270616S:6640		1.6	65	0.30	5.0	–	–	–	60	0.30	5.0	–	–	–	–	–	–	–	–	–
TPUN 330620S:6640		2.0	65	0.30	5.0	–	–	–	60	0.30	5.0	–	–	–	–	–	–	–	–	–

TPUN 适用于超精加工至中粗加工，连续至轻微断续切削。

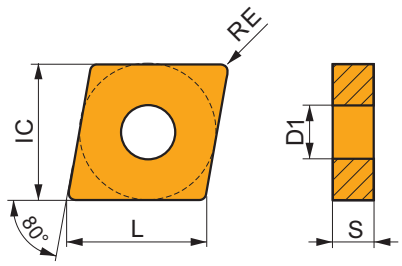
TPUN..S 适用于超精加工至中粗加工，连续至轻微断续切削。

先进材料刀片

CNGA CER

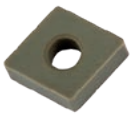
PRAMET

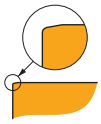
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



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。

Product		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)
CNGA 120404 T02020:TC100	●	0.4	–	–	–	–	–	–	590	0.10	2.0	–	–	–	–	–	–	–	–	–
CNGA 120408 T01020:TC100	●	0.8	–	–	–	–	–	–	550	0.20	2.0	–	–	–	–	–	–	–	–	–
CNGA 120412 T01020:TC100	●	1.2	–	–	–	–	–	–	540	0.25	2.0	–	–	–	–	–	–	–	–	–





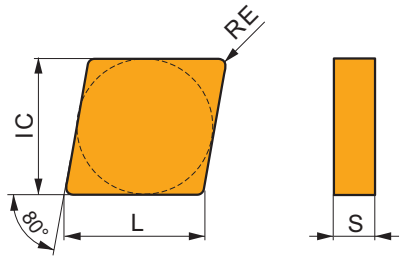
HSC T

CER 适用于高线速度连续切削。

CNGN CER

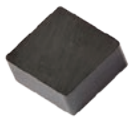
PRAMET

	IC (mm)	L (mm)	S (mm)
1204	12.700	12.90	4.76
1207	12.700	12.90	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/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)
CNGN 120408 T01020:TC100	●	0.8	–	–	–	–	–	–	550	0.20	2.0	–	–	–	–	–	–	–	–	–
CNGN 120708 T01020:TC100	●	0.8	–	–	–	–	–	–	550	0.20	2.0	–	–	–	–	–	–	–	–	–
CNGN 120712 T01020:TC100	●	1.2	–	–	–	–	–	–	540	0.25	2.0	–	–	–	–	–	–	–	–	–



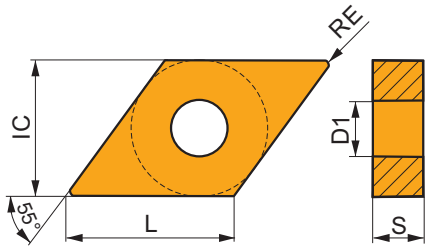
HSC T

CER 适用于高线速度连续切削。

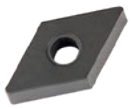
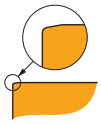
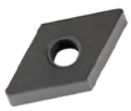
DNGA CER

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1504	12.700	5.16	15.50	4.76



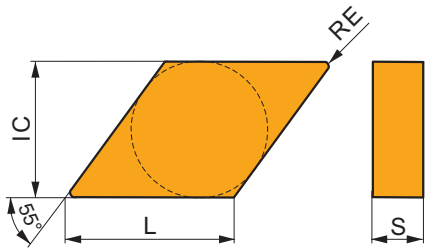
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
 	HSC S	CER 适用于高线速度连续切削。																		
DNGA 150408 S02020:TC100	●	0.8	–	–	–	–	–	–	■ 450	0.20	1.5	–	–	–	–	–	–	–	–	–
	HSC T	CER 适用于高线速度连续切削。																		
DNGA 150404 T01020:TC100	●	0.4	–	–	–	–	–	–	■ 475	0.10	1.5	–	–	–	–	–	–	–	–	–
DNGA 150408 T00520:TC100	●	0.8	–	–	–	–	–	–	■ 450	0.20	1.5	–	–	–	–	–	–	–	–	–

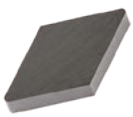
DNGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
1504	12.700	15.50	4.76



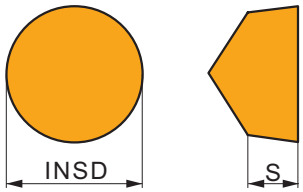
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
	HSC T	CER 适用于高线速度连续切削。																		
DNGN 150408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 450	0.20	1.5	–	–	–	–	–	–	–	–	–

RCGX CER

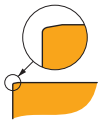
PRAMET

	INSD (mm)	S (mm)
0606	6.350	6.35
0907	9.525	7.94
1207	12.700	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/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)
RCGX 060600 K15015:TC100	●	–	–	–	–	–	–	–	365	0.30	0.8	–	–	–	–	–	–	–	–	–
RCGX 090700 K15015:TC100	●	–	–	–	–	–	–	–	410	0.20	1.2	–	–	–	–	–	–	–	–	–
RCGX 120700 K15015:TC100	●	–	–	–	–	–	–	–	405	0.20	1.5	–	–	–	–	–	–	–	–	–



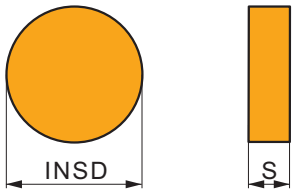
HSC K

CER 适用于高线速度连续切削。

RNGN CER

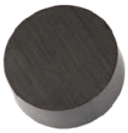
PRAMET

	INSD (mm)	S (mm)
0903	9.525	3.18
1204	12.700	4.76
1207	12.700	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/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)
RNGN 090300 T01020:TC100	●	–	–	–	–	–	–	–	460	0.20	1.2	–	–	–	–	–	–	–	–	–
RNGN 120400 T01020:TC100	●	–	–	–	–	–	–	–	455	0.20	1.5	–	–	–	–	–	–	–	–	–
RNGN 120700 T01020:TC100	●	–	–	–	–	–	–	–	455	0.20	1.5	–	–	–	–	–	–	–	–	–
RNGN 120700 T15015:TC100	●	–	–	–	–	–	–	–	455	0.20	1.5	–	–	–	–	–	–	–	–	–



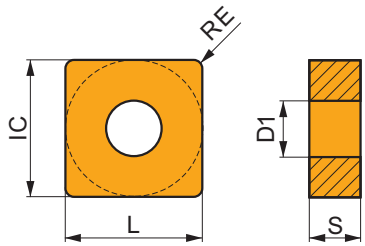
HSC T

CER 适用于高线速度连续切削。

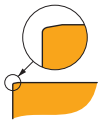
SNGA CER

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



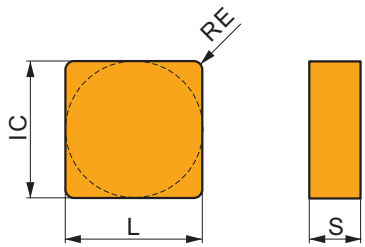
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
 HSC T CER 适用于高线速度连续切削。																				
SNGA 120408 T01025:TC100	●	0.8	–	–	–	–	–	–	575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGA 120412 T01020:TC100	●	1.2	–	–	–	–	–	–	565	0.25	2.0	–	–	–	–	–	–	–	–	–

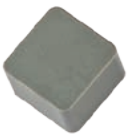
SNGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
0903	9.525	9.53	3.18
1204	12.700	12.70	4.76
1207	12.700	12.70	7.94



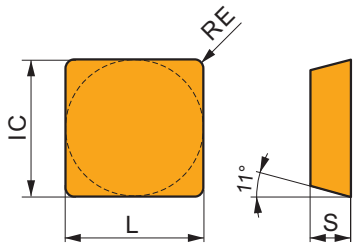
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
 HSC T CER 适用于高线速度连续切削。																				
SNGN 090308 T01020:TC100	●	0.8	–	–	–	–	–	–	580	0.20	1.8	–	–	–	–	–	–	–	–	–
SNGN 090312 T01020:TC100	●	1.2	–	–	–	–	–	–	565	0.25	1.8	–	–	–	–	–	–	–	–	–
SNGN 120404 T01020:TC100	●	0.4	–	–	–	–	–	–	620	0.10	2.0	–	–	–	–	–	–	–	–	–
SNGN 120408 T01020:TC100	●	0.8	–	–	–	–	–	–	575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGN 120708 T01020:TC100	●	0.8	–	–	–	–	–	–	575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGN 120712 T01020:TC100	●	1.2	–	–	–	–	–	–	565	0.25	2.0	–	–	–	–	–	–	–	–	–

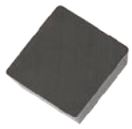
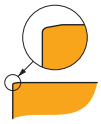
SPGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
1203	12.700	12.70	3.18



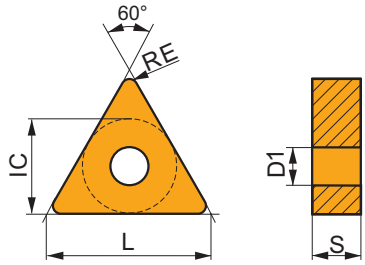
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
  HSC T CER 适用于高线速度连续切削。																				
SPGN 120308 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 530	0.20	1.5	–	–	–	–	–	–	–	–	–

TNGA CER

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76



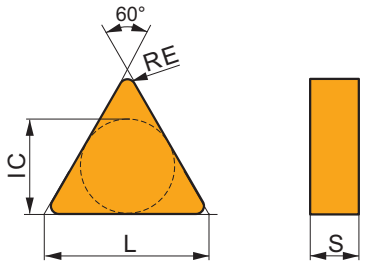
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
HSC T CER 适用于高线速度连续切削。																				
TNGA 160408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 475	0.20	1.5	–	–	–	–	–	–	–	–	–
TNGA 160412 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 500	0.20	1.5	–	–	–	–	–	–	–	–	–

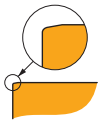
TNGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
1604	9.525	16.50	4.76
1607	9.525	16.50	7.94



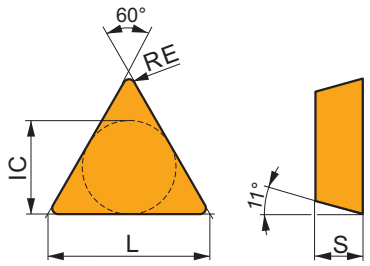
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
 HSC T CER 适用于高线速度连续切削。																				
TNGN 160408 T01020:TC100	●	0.8	–	–	–	–	–	–	475	0.20	1.5	–	–	–	–	–	–	–	–	–
TNGN 160412 T01020:TC100	●	1.2	–	–	–	–	–	–	500	0.20	1.5	–	–	–	–	–	–	–	–	–
TNGN 160708 T02020:TC100	●	0.8	–	–	–	–	–	–	475	0.20	1.5	–	–	–	–	–	–	–	–	–

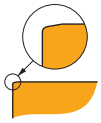
TPGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



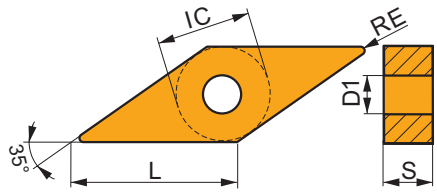
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
 HSC T CER 适用于高线速度连续切削。																				
TPGN 110304 T01020:TC100	●	0.4	–	–	–	–	–	–	460	0.10	1.5	–	–	–	–	–	–	–	–	–
TPGN 110308 T01020:TC100	●	0.8	–	–	–	–	–	–	425	0.20	1.5	–	–	–	–	–	–	–	–	–
TPGN 160304 T01020:TC100	●	0.4	–	–	–	–	–	–	460	0.10	1.5	–	–	–	–	–	–	–	–	–
TPGN 160308 T01020:TC100	●	0.8	–	–	–	–	–	–	425	0.20	1.5	–	–	–	–	–	–	–	–	–
TPGN 160312 T01020:TC100	●	1.2	–	–	–	–	–	–	450	0.20	1.5	–	–	–	–	–	–	–	–	–

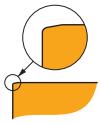
VNGA CER

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



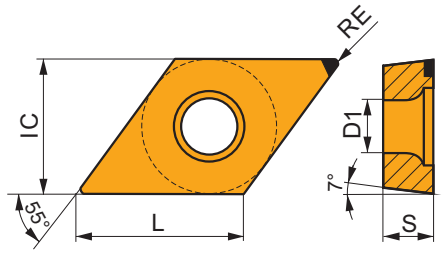
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
 HSC T CER 适用于高线速度连续切削。																				
VNGA 160404 T01020:TC100	●	0.4	–	–	–	–	–	–	■ 425	0.10	1.0	–	–	–	–	–	–	–	–	–
VNGA 160408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 395	0.20	1.0	–	–	–	–	–	–	–	–	–

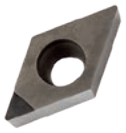
DCMW PCD

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97



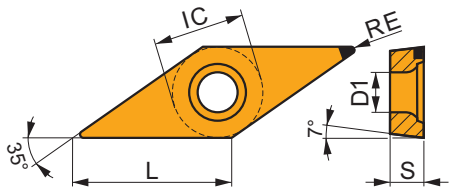
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
 HSC F PCD 适用于精加工，高线速度和稳定的切削条件。																				
DCMW 11T304FN:PD1	●	0.4	–	–	–	–	–	–	–	–	–	■ 1035	0.12	0.5	–	–	–	–	–	–
DCMW 11T308FN:PD1	●	0.8	–	–	–	–	–	–	–	–	–	■ 1200	0.12	1.0	–	–	–	–	–	–

VCMW PCD

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76



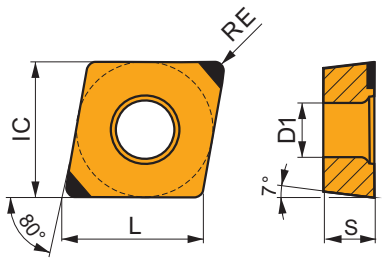
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
HSC F PCD 焊尖，适用于于精加工至中粗加工，高线速度和稳定的切削条件。																				
VCMW 160404FN:PD1	●	0.4	–	–	–	–	–	–	–	–	–	■ 900	0.12	0.5	–	–	–	–	–	–
VCMW 160408FN:PD1	●	0.8	–	–	–	–	–	–	–	–	–	■ 1050	0.12	1.0	–	–	–	–	–	–

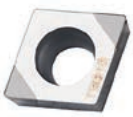
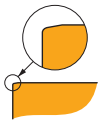
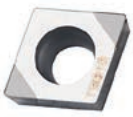
CCGW CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
09T3	9.525	4.50	9.70	3.97



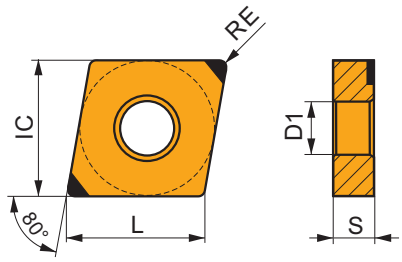
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
  HSC E CBN 适用于精加工。																				
CCGW 060204E-B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3
CCGW 09T304E-B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3
 HSC S CBN 适用于精加工。																				
CCGW 060204S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3
CCGW 09T304S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3

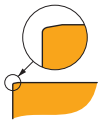
CNGA CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



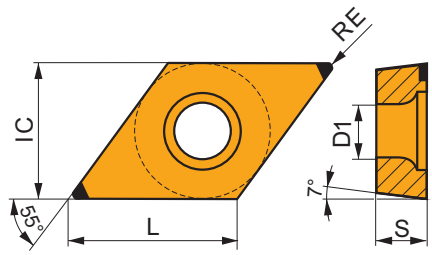
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
			HSC S																	
CBN 适用于精加工，连续切削。																				
CNGA 120404S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 510	0.10	0.4	–	–	–	◪ 135	0.07	0.3	■ 105	0.07	0.3
CNGA 120408S01020B:TB310	●	0.8	–	–	–	–	–	–	◪ 530	0.15	0.6	–	–	–	◪ 140	0.11	0.5	■ 110	0.08	0.7

DCGW CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.50	11.60	3.97



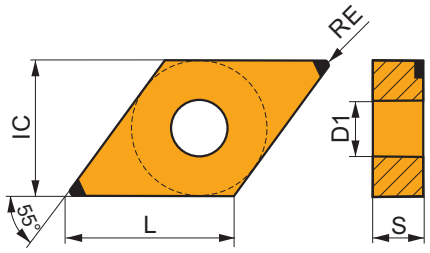
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
			HSC S																	
CBN 适用于精加工。																				
DCGW 11T304S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 370	0.10	0.4	–	–	–	◪ 95	0.07	0.3	■ 75	0.07	0.3
DCGW 11T308S01020B:TB310	●	0.8	–	–	–	–	–	–	◪ 380	0.15	0.6	–	–	–	◪ 100	0.11	0.5	■ 80	0.08	0.7

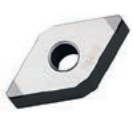
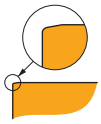
DNGA CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



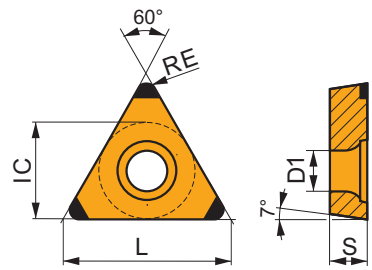
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
  HSC S CBN 适用于精加工，连续切削。																				
DNGA 150608S01020B:TB310	●	0.8	–	–	–	–	–	–	◪ 420	0.15	0.6	–	–	–	◪ 110	0.11	0.5	■ 85	0.08	0.7

TCGW CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.90	11.00	2.38



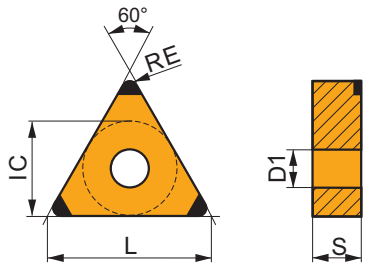
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		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)
HSC E CBN 适用于精加工，连续切削。																				
TCGW 110204E-C:TB310	●	0.4	–	–	–	–	–	–	◪ 390	0.10	0.4	–	–	–	◪ 100	0.07	0.3	■ 80	0.07	0.3
HSC S CBN 适用于精加工，连续切削。																				
TCGW 110204S01020C:TB310	●	0.4	–	–	–	–	–	–	◪ 390	0.10	0.4	–	–	–	◪ 100	0.07	0.3	■ 80	0.07	0.3
TCGW 110208S01020C:TB310	●	0.8	–	–	–	–	–	–	◪ 400	0.15	0.6	–	–	–	◪ 105	0.11	0.5	■ 85	0.08	0.7

TNGA CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	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/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)
TNGA 160408S01020C:TB310	●	0.8	–	–	–	–	–	–	450	0.15	0.6	–	–	–	115	0.11	0.5	95	0.08	0.7

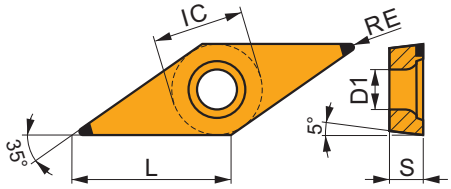
HSC S

CBN 适用于精加工，连续切削。

VBGW CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.50	16.00	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。

Product		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)
VBGW 160404S01020B:TB310	●	0.4	–	–	–	–	–	–	340	0.10	0.4	–	–	–	90	0.07	0.3	70	0.07	0.3
VBGW 160408S01020B:TB310	●	0.8	–	–	–	–	–	–	350	0.15	0.6	–	–	–	90	0.11	0.5	70	0.08	0.7

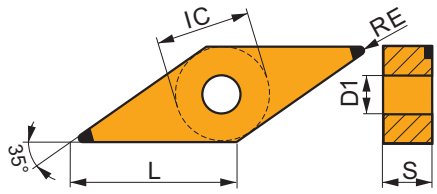
HSC S

CBN 适用于精加工，连续切削。

VNGA CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.00	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。

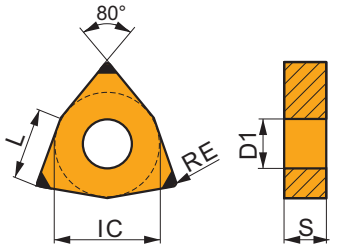
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
	HSC S																			
VNGA 160404S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 360	0.10	0.4	–	–	–	◪ 95	0.07	0.3	■ 75	0.07	0.3
VNGA 160408S01020B:TB310	●	0.8	–	–	–	–	–	–	◪ 370	0.15	0.6	–	–	–	◪ 95	0.11	0.5	■ 75	0.08	0.7

CBN 适用于精加工，连续切削。

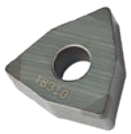
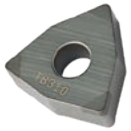
WNGA CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	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/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)
	HSC S																			
WNGA 080408S01020C:TB310	●	0.8	–	–	–	–	–	–	◪ 530	0.15	0.6	–	–	–	◪ 140	0.11	0.5	■ 110	0.08	0.7
	W HSC S																			
WNGA080408S01020WC:TB310	–	0.8	–	–	–	–	–	–	◪ 530	0.15	0.6	–	–	–	◪ 140	0.11	0.5	■ 110	0.08	0.7

CBN 适用于精加工，连续切削。

切断和切槽

GL – 外冷刀具导航工具

刀片座	GL1	GL2	GL3	GL4	GL5	GL6
NEW GLAF(RL)EXT 20×20 / 25×25		CDX 20 mm	CDX 20 – 40 mm	CDX 20 – 32 mm	CDX 24 – 32 mm	CDX 24 – 32 mm
NEW GLAF(RL)EXT-S 12×12 / 16×16		CDX 12 – 16 mm	CDX 12 – 16 mm	CDX 16 mm		
GLSF(RL)EXT 20×20 / 25×25	CDX 16 mm NEW	CDX 20 – 24 mm	CDX 20 – 32 mm	CDX 20 – 32 mm	CDX 20 – 32 mm	CDX 20 – 32 mm
GLSF(RL)EXT-S 12×12 / 16×16	CDX 12 – 16 mm NEW	CDX 12 – 16 mm	CDX 12 – 16 mm	CDX 16 mm		
GLSF(RL)EXT-G 20×20 / 32×32 NEW		CDX 10 mm	CDX 10 – 20 mm	CDX 12 – 24 mm	CDX 12 – 32 mm	CDX 12 – 32 mm

切削宽度(mm) CW	1.5	2	3 (2.5)	4	5	6	8
NEW 深切断加工(单面刀片)			单面刀片 PM 1 PR	单面刀片 PM 1 PR			
切断(管件/完整棒材)	NEW PM	PM 1 PR	CW = 2.5 / 3 PM 1 PR	PM 1 PR	PM 1 PR	PM 1 PR	
切槽(深/浅)		PR GM	PR GM	PR GM	PR GM	GM	NEW GM
车削(轴向)		GM	GM	GM	GM	GM	NEW GM
仿形(多轴)		MM	MM	MM	MM	MM	

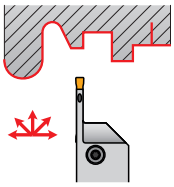
GLAF(RL) EXT

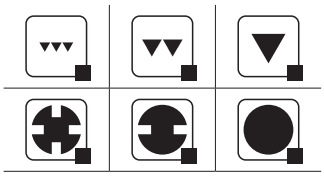
P M K N S H

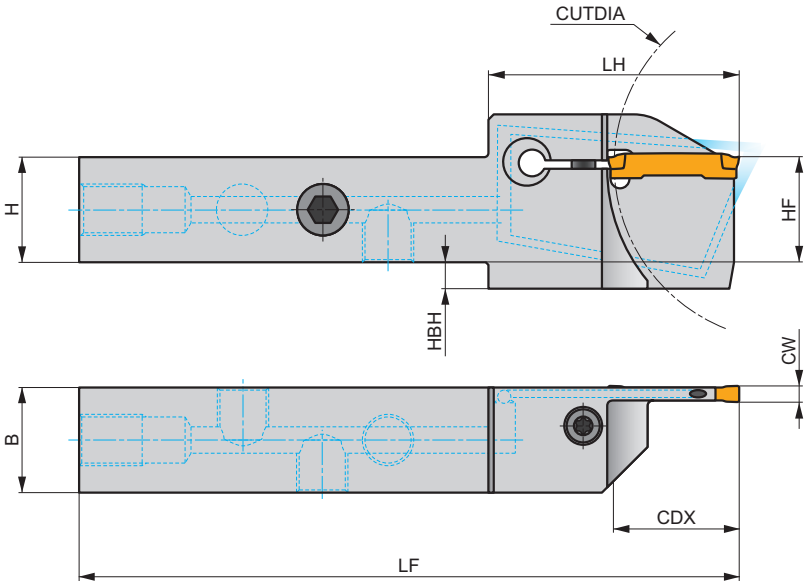
PRAMET

G

带内冷通道的切槽和切断加工刀具，用于GL刀片
带内冷通道的外部右旋/左旋刀柄，用于GL刀片。适用于径向切槽、切断加工、车削和仿形铣应用。加强刀体设计延长了刀具使用寿命，并且减少了振动。刀体经过处理，使用寿命更长。







	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		kg			
R	GL2-A2020KFR-20-80	20	5	20	20	125	43.5	2.00	20	80	✓	0.33	GI334	GL11	CC01
	GL2-A2525MFR-20-80	25	–	25	25	150	43.5	2.00	20	80	✓	0.65	GI334	GL11	CC01
	GL3-A2020KFR-20-80	20	5	20	20	125	43.5	3.00	20	80	✓	0.33	GI335	GL11	CC01
	GL3-A2020KFR-24-80	20	5	20	20	125	47.5	3.00	24	80	✓	0.32	GI335	GL11	CC01
	GL3-A2525MFR-20-80	25	–	25	25	150	43.5	3.00	20	80	✓	0.66	GI335	GL11	CC01
	GL3-A2525PFR-32-80	25	5	25	25	170	55.5	3.00	32	80	✓	0.73	GI335	GL11	CC01
	GL3-A2525PFR-40-100	25	7	25	25	170	63.5	3.00	40	100	✓	0.70	GI335	GL11	CC01
	GL4-A2020KFR-20-80	20	5	20	20	125	43.6	4.00	20	80	✓	0.38	GI336	GL11	CC01
	GL4-A2020KFR-24-80	20	5	20	20	125	47.6	4.00	24	80	✓	0.37	GI336	GL11	CC01
	GL4-A2525MFR-20-80	25	–	25	25	150	43.6	4.00	20	80	✓	0.58	GI336	GL11	CC01
	GL4-A2525PFR-32-80	25	5	25	25	170	55.6	4.00	32	80	✓	0.67	GI336	GL11	CC01
	GL5-A2020KFR-24-80	20	5	20	20	125	47.6	5.00	24	80	✓	0.32	GI337	GL11	CC01
	GL5-A2525PFR-32-100	25	5	25	25	170	55.6	5.00	32	100	✓	0.67	GI337	GL11	CC01
	GL6-A2020KFR-24-80	20	5	20	20	125	47.6	6.00	24	80	✓	0.37	GI338	GL11	CC01
	GL6-A2525PFR-32-100	25	5	25	25	170	55.6	6.00	32	100	✓	0.68	GI338	GL11	CC01
L	GL2-A2020KFL-20-80	20	5	20	20	125	43.5	2.00	20	80	✓	0.33	GI334	GL11	CC01
	GL2-A2525MFL-20-80	25	–	25	25	150	43.5	2.00	20	80	✓	0.66	GI334	GL11	CC01
	GL3-A2020KFL-20-80	20	5	20	20	125	43.5	3.00	20	80	✓	0.33	GI335	GL11	CC01
	GL3-A2020KFL-24-80	20	5	20	20	125	47.5	3.00	24	80	✓	0.36	GI335	GL11	CC01
	GL3-A2525MFL-20-80	25	–	25	25	150	43.5	3.00	20	80	✓	0.65	GI335	GL11	CC01
	GL3-A2525PFL-32-80	25	5	25	25	170	55.5	3.00	32	80	✓	0.67	GI335	GL11	CC01
	GL3-A2525PFL-40-100	25	7	25	25	170	63.5	3.00	40	100	✓	0.70	GI335	GL11	CC01
	GL4-A2020KFL-20-80	20	5	20	20	125	43.6	4.00	20	80	✓	0.33	GI336	GL11	CC01
	GL4-A2020KFL-24-80	20	5	20	20	125	47.6	4.00	24	80	✓	0.37	GI336	GL11	CC01
	GL4-A2525MFL-20-80	25	–	25	25	150	43.6	4.00	20	80	✓	0.65	GI336	GL11	CC01
	GL4-A2525PFL-32-80	25	5	25	25	170	55.6	4.00	32	80	✓	0.73	GI336	GL11	CC01
	GL5-A2020KFL-24-80	20	5	20	20	125	47.6	5.00	24	80	✓	0.32	GI337	GL11	CC01

	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		kg			
L	**GL5-A2525PFL-32-100**	25	5	25	25	170	55.6	5.00	32	100	✓	0.67	GI337	GL11	CC01
	GL6-A2020KFL-24-80	20	5	20	20	125	47.6	6.00	24	80	✓	0.33	GI338	GL11	CC01
	GL6-A2525PFL-32-100	25	5	25	25	170	55.6	6.00	32	100	✓	0.68	GI338	GL11	CC01

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

沿加工直径的切削深度请参见第364页。

GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P

CC01	CHP-P1/8	G1/8″	HXK 4

冷却液附件请参见第366页。

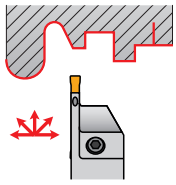
GLAF(RL) EXT-S

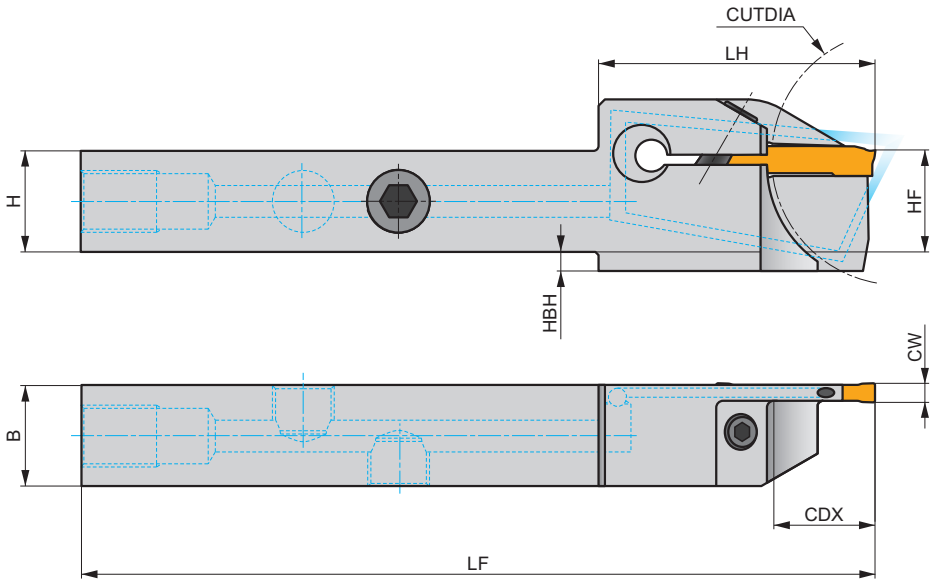
P M K N S H

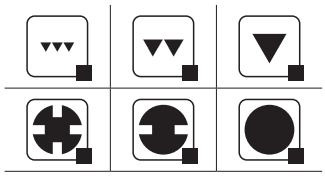
PRAMET

G

带内冷通道的切槽刀具，用于GL刀片、纵切机床
带内冷通道的外部右旋/左旋刀柄，用于GL刀片，设计用于纵切机床，且易于接触刀片夹紧机构。适用于径向切槽、切断加工、车削和仿形铣应用。刀体经过处理，使用寿命更长。







	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		kg			
R	GL2-A1212HFR-12-40	12	3	12	12	100	33.0	2.00	12	40	✓	0.12	GI334	GL13	CC02
	GL2-A1616KFR-16-45	16	3	16	16	125	43.5	2.00	16	45	✓	0.21	GI334	GL12	CC01
	GL3-A1212HFR-12-40	12	3	12	12	100	33.0	3.00	12	40	✓	0.12	GI335	GL13	CC02
	GL3-A1616KFR-16-45	16	3	16	16	125	43.5	3.00	16	45	✓	0.21	GI335	GL12	CC01
	GL4-A1616KFR-16-45	16	4	16	16	125	43.6	4.00	16	45	✓	0.21	GI336	GL12	CC01
L	GL2-A1212HFL-12-40	12	3	12	12	100	33.0	2.00	12	40	✓	0.11	GI334	GL13	CC02
	GL2-A1616KFL-16-45	16	3	16	16	125	43.5	2.00	16	45	✓	0.27	GI334	GL12	CC01
	GL3-A1212HFL-12-40	12	3	12	12	100	33.0	3.00	12	40	✓	0.12	GI335	GL13	CC02
	GL3-A1616KFL-16-45	16	3	16	16	125	43.5	3.00	16	45	✓	0.25	GI335	GL12	CC01
	GL4-A1616KFL-16-45	16	4	16	16	125	43.6	4.00	16	45	✓	0.21	GI336	GL12	CC01

GI334	GL2..
GI335	GL3..
GI336	GL4..

沿加工直径的切削深度请参见第364页。

		Nm			
GL12	HS 0516	5.0	M 5	16	HXK 4
GL13	HS 0412	5.0	M 4	12	HXK 3

CC01	CHP-P1/8	–	G1/8″	HXK 4	–	–
CC02	–	CHP-P6	M6	HXK 3	CHP-G06	CHP-R1/8-6

冷却液附件请参见第366页。

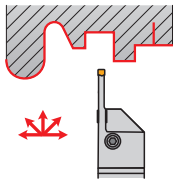
GLSF(RL) EXT

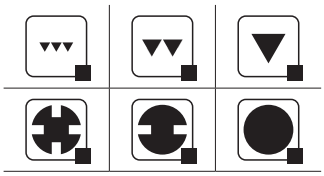
P M K N S H

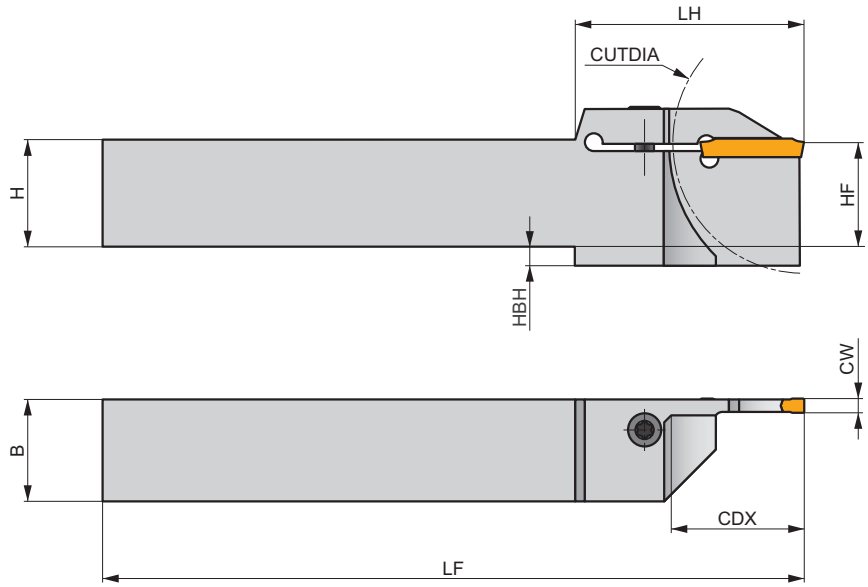
PRAMET

G

切槽和切断加工刀具，用于GL刀片
外部右旋/左旋刀柄，用于GL刀片。适用于径向切槽、切断加工、车削和仿形铣应用。加强刀体设计延长了刀具使用寿命，并且减少了振动。刀体经过处理，使用寿命更长。







	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	GL1-S2020KFR-16-60	20	–	20	20	125	34.2	1.50	16	60	0.35	GI333	GL11
	GL2-S2020KFR-20-80	20	–	20	20	125	43.5	2.00	20	80	0.38	GI334	GL11
	GL2-S2020KFR-24-80	20	5	20	20	125	48.5	2.00	24	80	0.38	GI334	GL11
	GL2-S2525MFR-20-80	25	–	25	25	150	43.5	2.00	20	80	0.70	GI334	GL11
	GL2-S2525MFR-24-80	25	–	25	25	150	47.5	2.00	24	80	0.68	GI334	GL11
	GL3-S2020KFR-20-80	20	–	20	20	125	43.5	3.00	20	80	0.38	GI335	GL11
	GL3-S2020KFR-24-80	20	5	20	20	125	47.5	3.00	24	80	0.36	GI335	GL11
	GL3-S2525MFR-20-80	25	–	25	25	150	43.5	3.00	20	80	0.70	GI335	GL11
	GL3-S2525MFR-24-80	25	–	25	25	150	47.5	3.00	24	80	0.65	GI335	GL11
	GL3-S2525PFR-32-80	25	5	25	25	170	55.5	3.00	32	80	0.78	GI335	GL11
	GL4-S2020KFR-20-80	20	–	20	20	125	43.5	4.00	20	80	0.38	GI336	GL11
	GL4-S2020KFR-24-80	20	5	20	20	125	47.5	4.00	24	80	0.37	GI336	GL11
	GL4-S2525MFR-20-80	25	–	25	25	150	43.5	4.00	20	80	0.68	GI336	GL11
	GL4-S2525MFR-24-80	25	–	25	25	150	47.5	4.00	24	80	0.69	GI336	GL11
	GL4-S2525PFR-32-80	25	5	25	25	170	55.5	4.00	32	80	0.78	GI336	GL11
	GL5-S2020KFR-20-80	20	–	20	20	125	43.5	5.00	20	80	0.38	GI337	GL11
	GL5-S2525MFR-20-80	25	–	25	25	150	43.5	5.00	20	80	0.68	GI337	GL11
	GL5-S2525PFR-32-100	25	5	25	25	170	55.5	5.00	32	100	0.78	GI337	GL11
	GL6-S2020KFR-20-80	20	–	20	20	125	43.5	6.00	20	80	0.39	GI338-1	GL11
	GL6-S2525MFR-20-80	25	–	25	25	150	43.5	6.00	20	80	0.68	GI338-1	GL11
	GL6-S2525PFR-32-100	25	5	25	25	170	55.5	6.00	32	100	0.75	GI338	GL11
L	GL1-S2020KFL-16-60	20	–	20	20	125	34.2	1.50	16	60	0.35	GI333	GL11
	GL2-S2020KFL-20-80	20	–	20	20	125	43.5	2.00	20	80	0.38	GI334	GL11
	GL2-S2020KFL-24-80	20	5	20	20	125	47.5	2.00	24	80	0.39	GI334	GL11
	GL2-S2525MFL-20-80	25	–	25	25	150	43.5	2.00	20	80	0.70	GI334	GL11
	GL2-S2525MFL-24-80	25	–	25	25	150	47.5	2.00	24	80	0.64	GI334	GL11
	GL3-S2020KFL-20-80	20	–	20	20	125	43.5	3.00	20	80	0.38	GI335	GL11

	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
L	**GL3-S2020KFL-24-80**	20	5	20	20	125	47.5	3.00	24	80	0.39	GI335	GL11
	GL3-S2525MFL-20-80	25	–	25	25	150	43.5	3.00	20	80	0.68	GI335	GL11
	GL3-S2525MFL-24-80	25	–	25	25	150	47.5	3.00	24	80	0.68	GI335	GL11
	GL3-S2525PFL-32-80	25	5	25	25	170	55.5	3.00	32	80	0.78	GI335	GL11
	GL4-S2020KFL-20-80	20	–	20	20	125	43.5	4.00	20	80	0.38	GI336	GL11
	GL4-S2020KFL-24-80	20	5	20	20	125	47.5	4.00	24	80	0.39	GI336	GL11
	GL4-S2525MFL-20-80	25	–	25	25	150	43.5	4.00	20	80	0.68	GI336	GL11
	GL4-S2525MFL-24-80	25	–	25	25	150	47.5	4.00	24	80	0.65	GI336	GL11
	GL4-S2525PFL-32-80	25	5	25	25	170	55.5	4.00	32	80	0.78	GI336	GL11
	GL5-S2020KFL-20-80	20	–	20	20	125	43.5	5.00	20	80	0.38	GI337	GL11
	GL5-S2525MFL-20-80	25	–	25	25	150	43.5	5.00	20	80	0.71	GI337	GL11
	GL5-S2525PFL-32-100	25	5	25	25	170	55.5	5.00	32	100	0.78	GI337	GL11
	GL6-S2020KFL-20-80	20	–	20	20	125	43.5	6.00	20	80	0.39	GI338-1	GL11
	GL6-S2525MFL-20-80	25	–	25	25	150	43.5	6.00	20	80	0.71	GI338-1	GL11
	GL6-S2525PFL-32-100	25	5	25	25	170	55.5	6.00	32	100	0.75	GI338	GL11

GI333	GL1..	–
GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..
GI338-1	GL6-D600..	–

沿加工直径的切削深度请参见第364页。

		Nm			
GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P

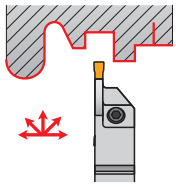
GLSF(RL) EXT-S

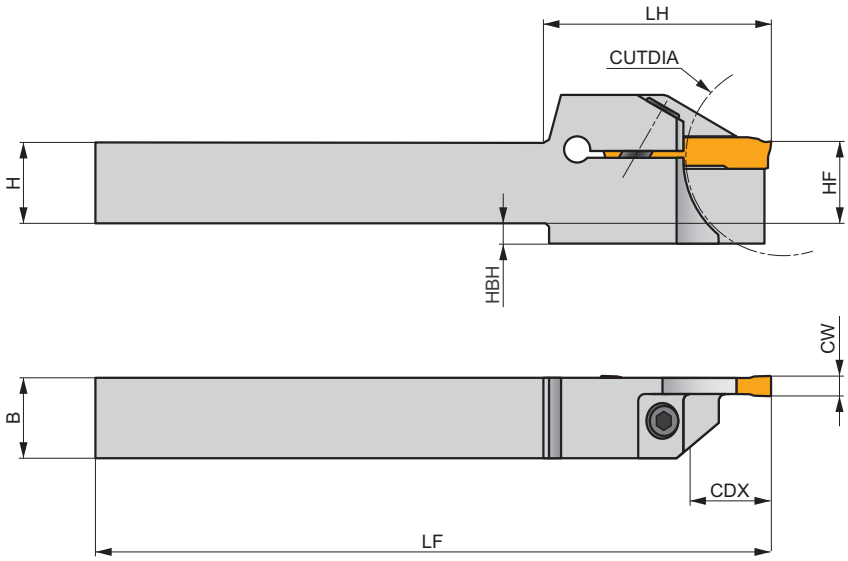
P M K N S H

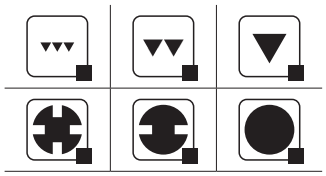
PRAMET

G

切槽和切断加工刀具，用于GL刀片、纵切机床。
外部右旋/左旋刀柄，用于GL刀片，设计用于纵切机床，且易于接触刀片夹紧机构。适用于径向切槽、切断加工、车削和仿形铣应用。刀体经过处理，使用寿命更长。







	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	**GL1-S1212HFR-12-40**	12	–	12	12	100	30.2	1.50	12	40	0.10	GI333	GL13
	GL1-S1616KFR-16-45	16	–	16	16	125	34.2	1.50	16	45	0.23	GI333	GL12
	GL2-S1212HFR-12-40	12	3	12	12	100	33.0	2.00	12	40	0.14	GI334	GL13
	GL2-S1616KFR-16-45	16	3	16	16	125	39.5	2.00	16	45	0.23	GI334	GL12
	GL3-S1212HFR-12-40	12	3	12	12	100	33.0	3.00	12	40	0.11	GI335	GL13
	GL3-S1616KFR-16-45	16	3	16	16	125	39.5	3.00	16	45	0.23	GI335	GL12
	GL4-S1616KFR-16-45	16	4	16	16	125	39.5	4.00	16	45	0.28	GI336	GL12
L	**GL1-S1212HFL-12-40**	12	–	12	12	100	30.2	1.50	12	40	0.10	GI333	GL13
	GL1-S1616KFL-16-45	16	–	16	16	125	34.2	1.50	16	45	0.23	GI333	GL12
	GL2-S1212HFL-12-40	12	3	12	12	100	33.0	2.00	12	40	0.11	GI334	GL13
	GL2-S1616KFL-16-45	16	3	16	16	125	39.5	2.00	16	45	0.23	GI334	GL12
	GL3-S1212HFL-12-40	12	3	12	12	100	33.0	3.00	12	40	0.11	GI335	GL13
	GL3-S1616KFL-16-45	16	3	16	16	125	39.5	3.00	16	45	0.23	GI335	GL12
	GL4-S1616KFL-16-45	16	4	16	16	125	39.5	4.00	16	45	0.24	GI336	GL12

GI333	GL1..
GI334	GL2..
GI335	GL3..
GI336	GL4..

沿加工直径的切削深度请参见第364页。

		Nm			
GL12	HS 0516	5.0	M 5	16	HXK 4
GL13	HS 0412	5.0	M 4	12	HXK 3

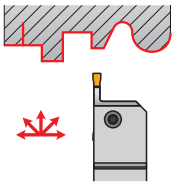
GLSF(RL) EXT-G

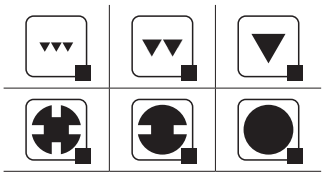
P M K N S H

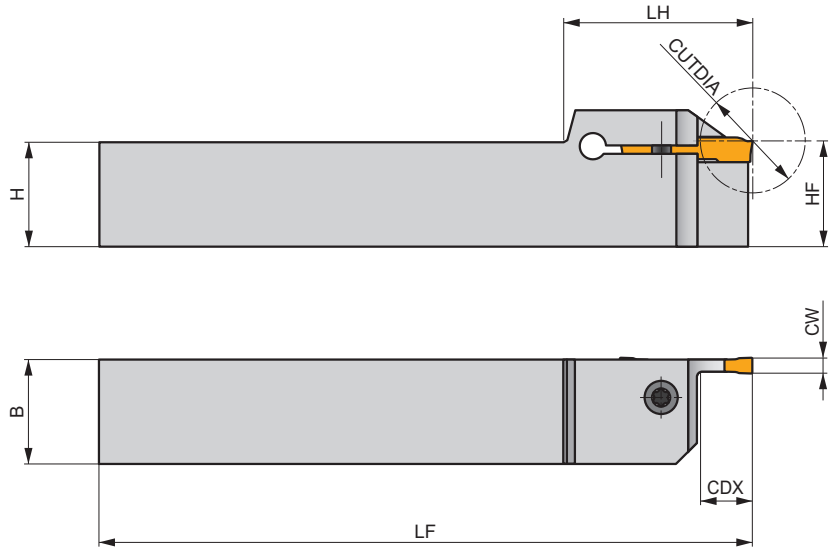
PRAMET

G

切槽和车削刀具，用于GL刀片
外部右旋/左旋刀柄，用于GL刀片。最适合轴向车削和仿形铣应用，也可用于切槽加工和切断加工。刀体经过处理，使用寿命更长。







	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	GL2-S2020KFR-10	20	20	20	125	36.0	2.00	10	20	0.38	GI334	GL11
	GL2-S2525MFR-10	25	25	25	150	36.0	2.00	10	20	0.69	GI334	GL11
	GL3-S2020KFR-10	20	20	20	125	36.0	3.00	10	20	0.39	GI335	GL11
	GL3-S2525MFR-10	25	25	25	150	36.0	3.00	10	20	0.73	GI335	GL11
	GL3-S3232MFR-20	32	32	32	150	46.0	3.00	20	40	1.12	GI335	GL15
	GL4-S2020KFR-12	20	20	20	125	36.0	4.00	12	24	0.37	GI336	GL11
	GL4-S2525MFR-12	25	25	25	150	36.0	4.00	12	24	0.69	GI336	GL11
	GL4-S3232MFR-24	32	32	32	150	50.0	4.00	24	48	1.04	GI336	GL15
	GL5-S2020KFR-12	20	20	20	125	36.0	5.00	12	24	0.36	GI337	GL11
	GL5-S2525MFR-12	25	25	25	150	36.0	5.00	12	24	0.72	GI337	GL11
	GL5-S3232PFR-32	32	32	32	170	58.0	5.00	32	64	1.21	GI337	GL15
	GL6-S2020KFR-12	20	20	20	125	36.0	6.00	12	24	0.36	GI338-1	GL11
	GL6-S2525MFR-12	25	25	25	150	36.0	6.00	12	24	0.68	GI338-1	GL11
	GL6-S3232PFR-32	32	32	32	170	58.0	6.00	32	64	1.22	GI338	GL15
L	GL2-S2020KFL-10	20	20	20	125	36.0	2.00	10	20	0.37	GI334	GL11
	GL2-S2525MFL-10	25	25	25	150	36.0	2.00	10	20	0.70	GI334	GL11
	GL3-S2020KFL-10	20	20	20	125	36.0	3.00	10	20	0.36	GI335	GL11
	GL3-S2525MFL-10	25	25	25	150	36.0	3.00	10	20	0.70	GI335	GL11
	GL3-S3232MFL-20	32	32	32	150	46.0	3.00	20	40	1.12	GI335	GL15
	GL4-S2020KFL-12	20	20	20	125	36.0	4.00	12	24	0.37	GI336	GL11
	GL4-S2525MFL-12	25	25	25	150	36.0	4.00	12	24	0.69	GI336	GL11
	GL4-S3232MFL-24	32	32	32	150	50.0	4.00	24	48	1.04	GI336	GL15
	GL5-S2020KFL-12	20	20	20	125	36.0	5.00	12	24	0.36	GI337	GL11
	GL5-S2525MFL-12	25	25	25	150	36.0	5.00	12	24	0.72	GI337	GL11
	GL5-S3232PFL-32	32	32	32	170	58.0	5.00	32	64	1.15	GI337	GL15
	GL6-S2020KFL-12	20	20	20	125	36.0	6.00	12	24	0.36	GI338-1	GL11
	GL6-S2525MFL-12	25	25	25	150	36.0	6.00	12	24	0.72	GI338-1	GL11

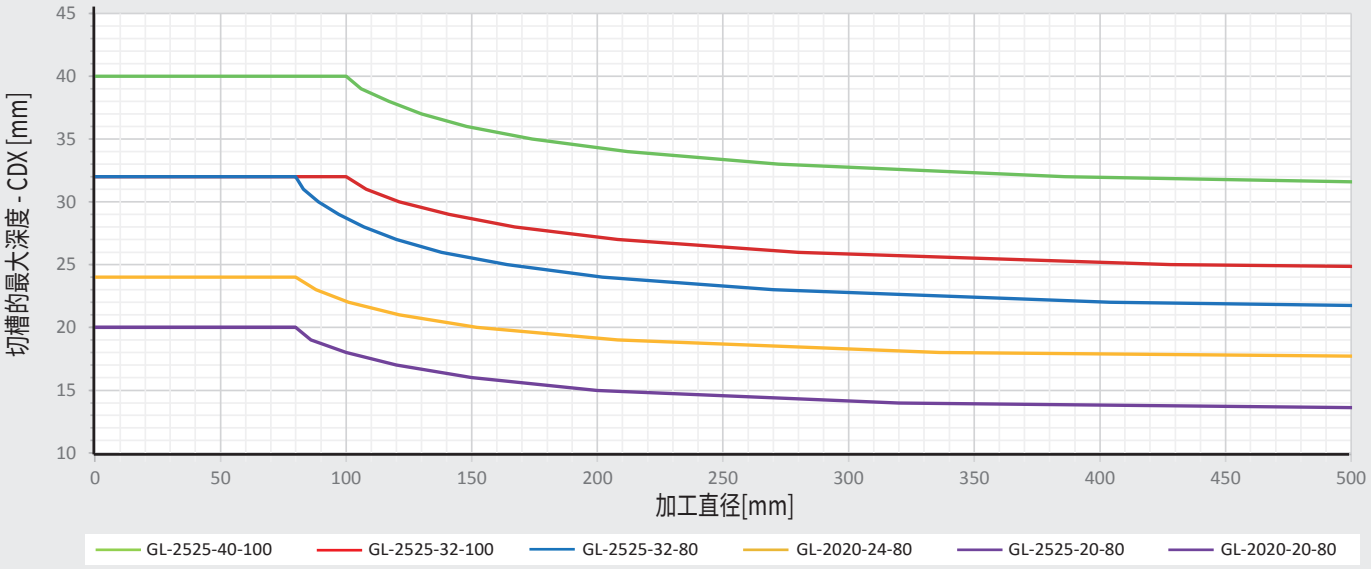
	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
L	**GL6-S3232PFL-32**	32	32	32	170	58.0	6.00	32	64	1.15	GI338	GL15

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..
GI338-1	GL6-D600..	–

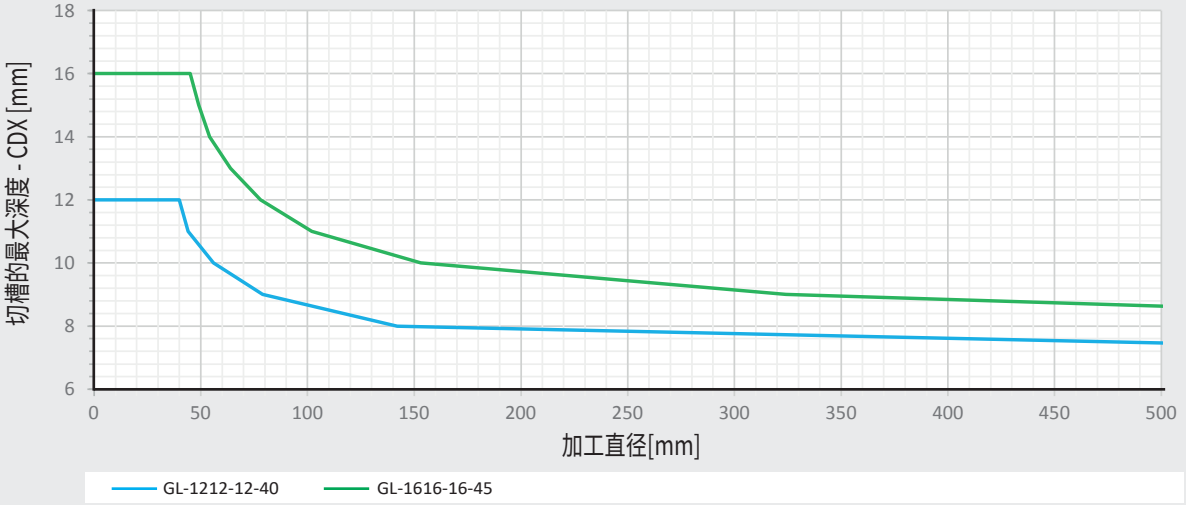
		Nm			
GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P
GL15	SR 88026-T30P	5.0	M8	26	LK T30P

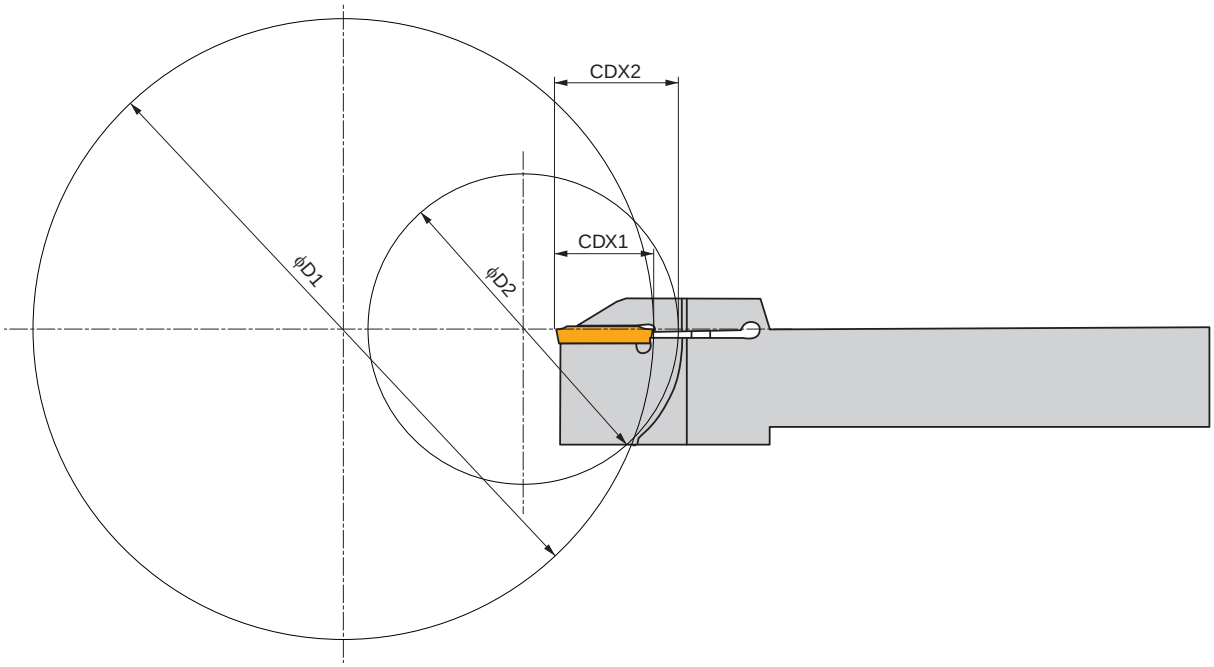
切削深度随加工直径变化

GLAF(RL) EXT



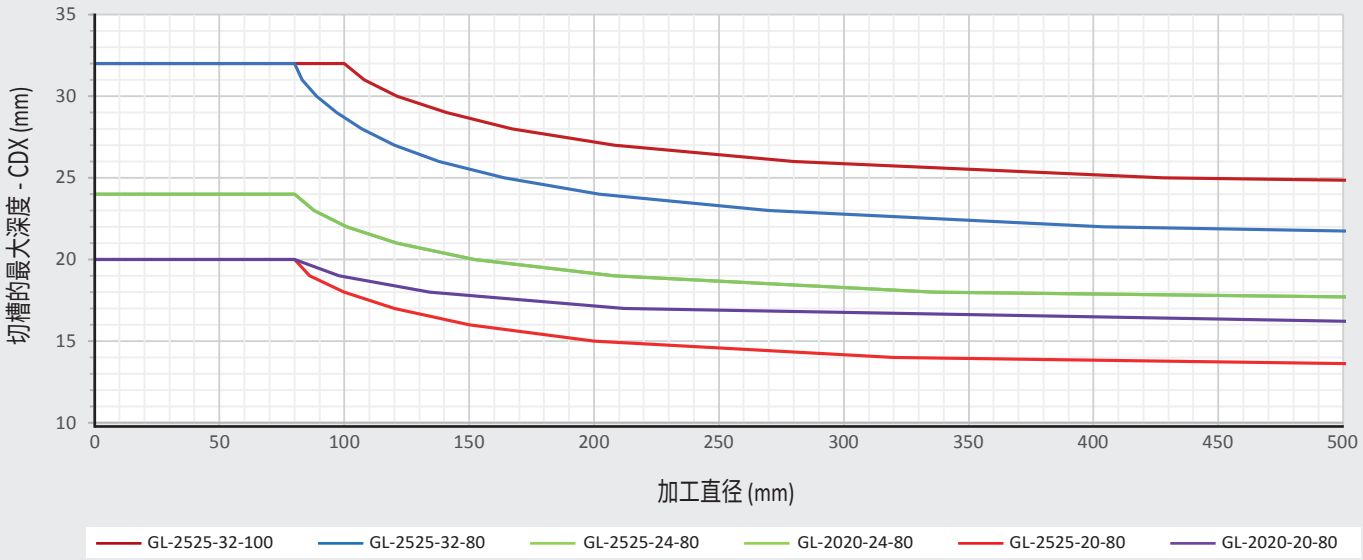
GLAF(RL) EXT-S



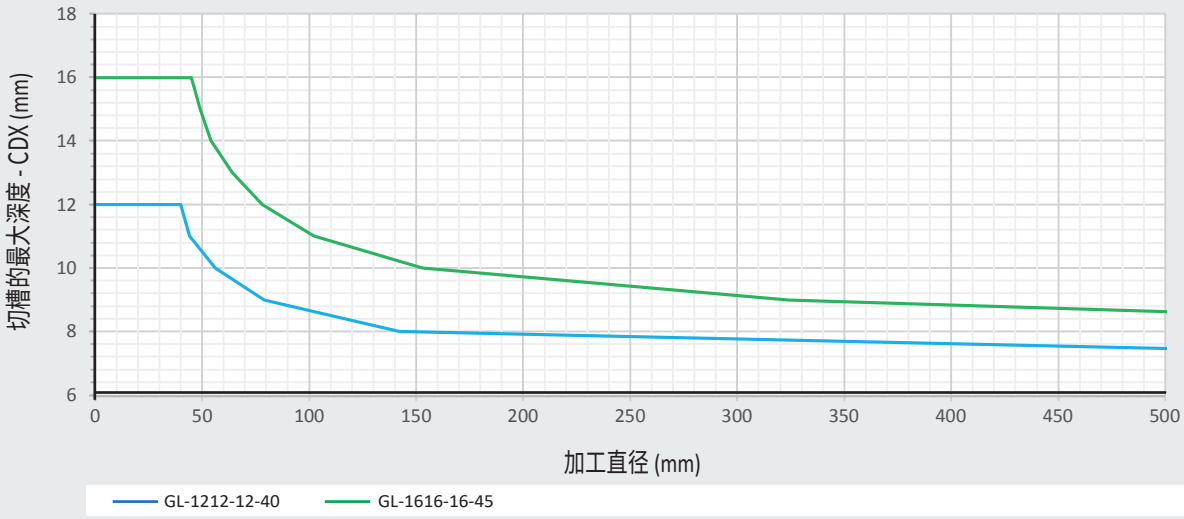


切削深度随加工直径变化

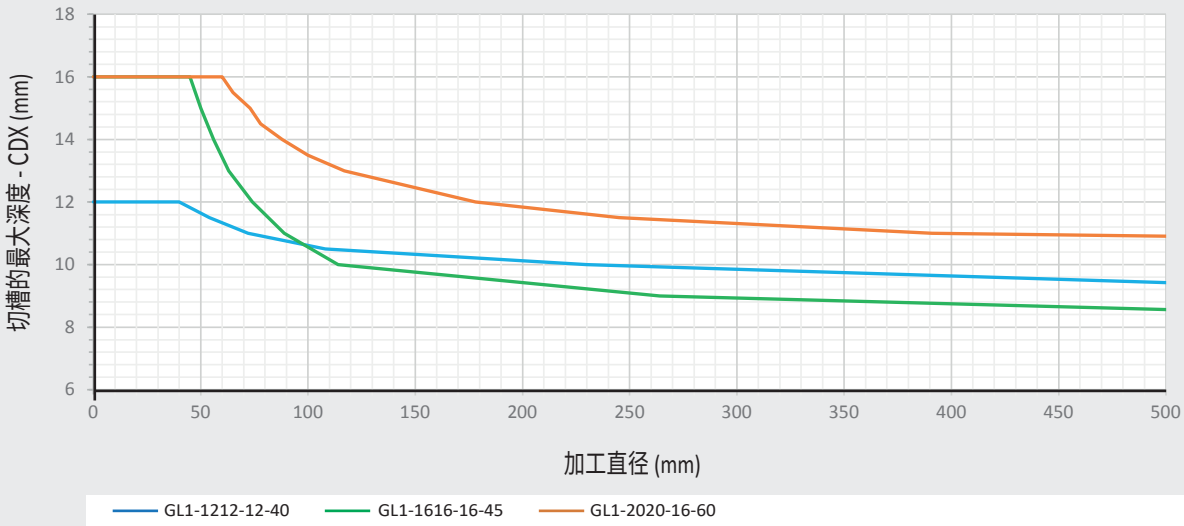
GLSF (RL) EXT



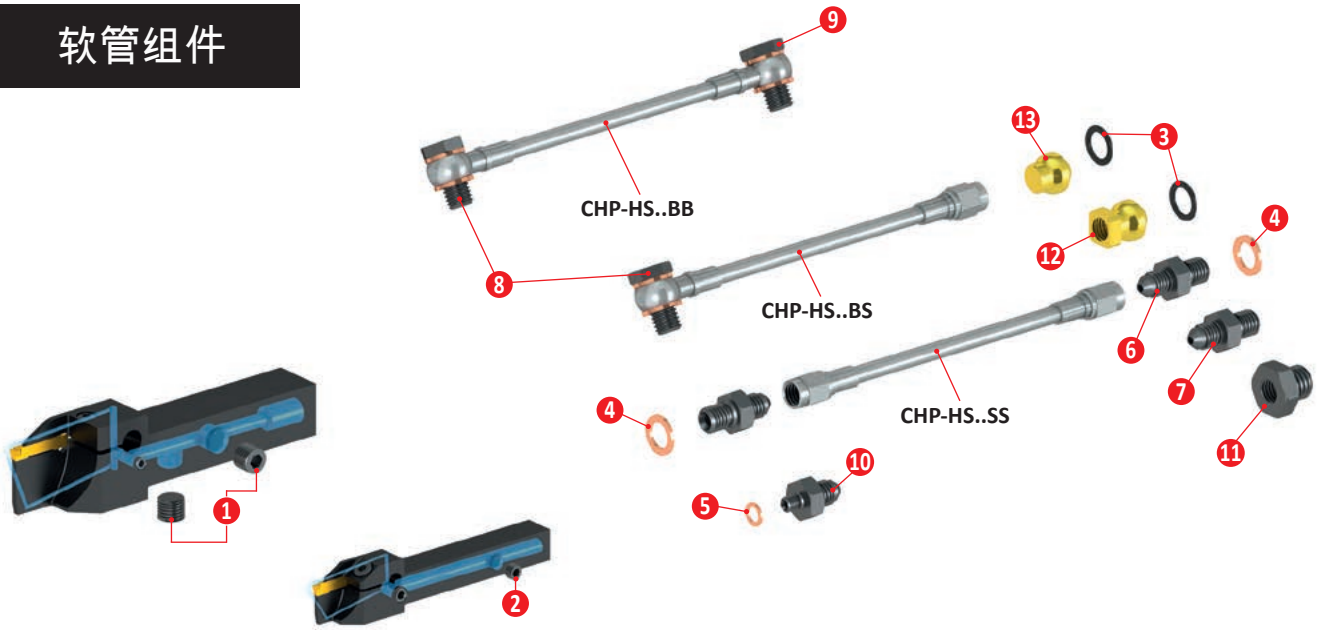
GLSF (RL) EXT-S

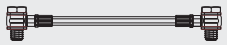


GL1



软管组件



			长度			
			150 mm	CHP-HS150 SS	CHP-HS150 BS	CHP-HS150 BB
		名称	250 mm	CHP-HS250 SS	CHP-HS250 BS	CHP-HS250 BB
			300 mm	CHP-HS300 SS	CHP-HS300 BS	CHP-HS300 BB
1		堵头螺丝G1/8“	CHP-P1/8	1 x	1 x	1 x
2		堵头螺丝6*	CHP-P6	–	–	–
3		O形环	CHP-010×1	2 x	2 x	2 x
4		铜垫片	CHP-G10	2 x	3 x	4 x
5		铜垫片*	CHP-G06	–	–	–
6		管接头G1/8“	CHP-CS1/8	2 x	1 x	–
7		管接头M10	CHP-CS10	1 x	–	–
8		空心接头螺栓G1/8“	CHP-CB1/8	–	1 x	2 x
9		空心接头螺栓M10	CHP-CB10	–	1 x	1 x
10		变径套G1/8“至M6*	CHP-R1/8-6	–	–	–
11		变径套G1/4"至G1/8“	CHP-R1/4-1/8	–	1 x	1 x
12		冷却液喷嘴G1/8“	CHP-PV1/8-12	1 x	1 x	1 x
13		冷却液喷嘴塞	CHP-PV14	1 x	1 x	1 x

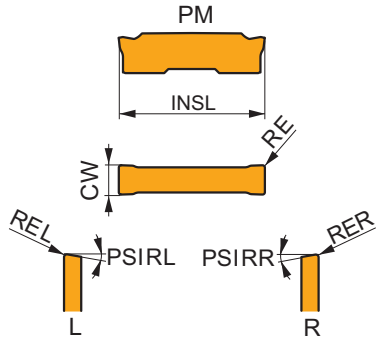
* 交付时包含12×12刀柄

更多信息请参见包装说明书

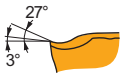
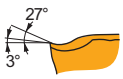
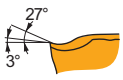
GL. D - PM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
150	1.50	-0.04	0.04	16.5
200	2.00	-0.05	0.05	25.0
250	2.55	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



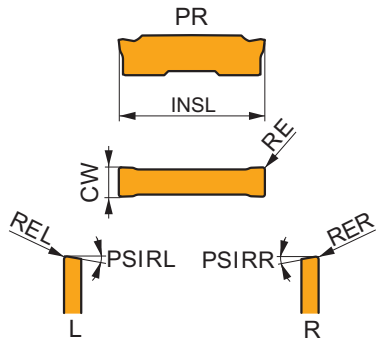
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
PM 具有大正前角的型，是切断和切槽加工以及连续切削至轻微断续切削的首选。																
GL1-D150M015-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	–	–
GL2-D200M02-PM:G8330	⬌	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	–	–
GL2-D200M02-PM:T7325	●	0.2	150	0.08	115	0.07	140	0.08	–	–	45	0.06	–	–	–	–
GL3-D250G02-PM:G8330	⬌	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL3-D300M02-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL3-D300M02-PM:T7325	●	0.2	150	0.10	115	0.09	140	0.10	–	–	45	0.07	–	–	–	–
GL4-D400M02-PM:G8330	⬌	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	–
GL4-D400M02-PM:T7325	●	0.2	150	0.12	115	0.11	140	0.12	–	–	45	0.10	–	–	–	–
GL5-D500M03-PM:G8330	⬌	0.3	130	0.15	75	0.14	120	0.15	390	0.18	30	0.12	–	–	–	–
GL6-D600M03-PM:G8330	⬌	0.3	130	0.15	75	0.14	120	0.15	390	0.18	30	0.12	–	–	–	–
																
R-PM 具有大正前角的旋槽型，是切断加工和连续切削的首选。																
GL1-D150G015R06-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	6	–
GL1-D150G015R12-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	12	–
GL2-D200G02R06-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	6	–
GL2-D200G02R06-PM:T7325	●	0.2	150	0.08	115	0.07	140	0.08	–	–	45	0.06	–	–	6	–
GL2-D200G02R12-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	12	–
GL3-D300G02R06-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	6	–
GL3-D300G02R06-PM:T7325	●	0.2	150	0.10	115	0.09	140	0.10	–	–	45	0.07	–	–	6	–
GL3-D300G02R12-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	12	–
GL4-D400G02R06-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	6	–
GL4-D400G02R06-PM:T7325	●	0.2	150	0.12	115	0.11	140	0.12	–	–	45	0.10	–	–	6	–
GL4-D400G02R12-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	12	–
																
L-PM 具有大正前角的旋槽型，是切断加工和连续切削的首选。																
GL1-D150G015L06-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	–	6
GL1-D150G015L12-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	–	12
GL2-D200G02L06-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	–	6
GL2-D200G02L06-PM:T7325	●	0.2	150	0.08	115	0.07	140	0.08	–	–	45	0.06	–	–	–	6
GL2-D200G02L12-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	–	12
GL3-D300G02L06-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	6
GL3-D300G02L06-PM:T7325	●	0.2	150	0.10	115	0.09	140	0.10	–	–	45	0.07	–	–	–	6
GL3-D300G02L12-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	12
GL4-D400G02L06-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	6
GL4-D400G02L06-PM:T7325	●	0.2	150	0.12	115	0.11	140	0.12	–	–	45	0.10	–	–	–	6
GL4-D400G02L12-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	12

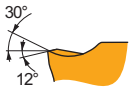
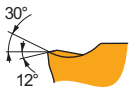
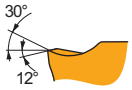
GL. D - PR

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



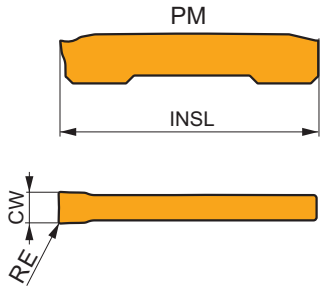
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
PR 带负T-型倒棱的型，是不利工况下切槽加工和切断加工以及连续切削至间断切削的首选。																
GL2-D200M02-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
GL2-D200M02-PR:T7325		0.2	150	0.10	115	0.09	140	0.10	–	–	–	–	–	–	–	–
GL3-D300M02-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL3-D300M02-PR:T7325		0.2	150	0.12	115	0.11	140	0.12	–	–	–	–	–	–	–	–
GL4-D400M02-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
GL4-D400M02-PR:T7325		0.2	150	0.15	115	0.14	140	0.15	–	–	–	–	–	–	–	–
GL5-D500M04-PR:G8330		0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
GL6-D600M04-PR:G8330		0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
																
R-PR 带负T-型倒棱的旋槽型，是不利工况下棒料切断加工以及连续切削至间断切削的首选。																
GL2-D200G02R06-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	6	–
GL2-D200G02R12-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	12	–
GL3-D300G02R06-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	6	–
GL3-D300G02R12-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	12	–
GL4-D400G02R06-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	6	–
GL4-D400G02R12-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	12	–
																
L-PR 带负T-型倒棱的旋槽型，是高难度棒料切断加工以及连续切削至间断切削的首选。																
GL2-D200G02L06-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	6
GL2-D200G02L12-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	12
GL3-D300G02L06-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	6
GL3-D300G02L12-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	12
GL4-D400G02L06-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	6
GL4-D400G02L12-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	12

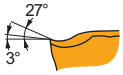
GL. S - PM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



线速度(vc)和进给量(f)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。

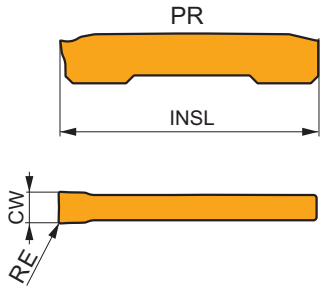
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
GL3-S300M02-PM:G8330		0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL4-S400M02-PM:G8330		0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	–

PM 单刃刀片具有大正前角的型，是深度切断加工以及连续切削至轻微断续切削的首选。

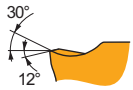
GL. S - PR

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



线速度(vc)和进给量(f)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。

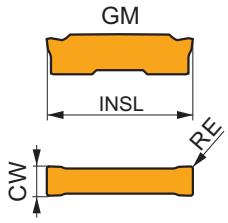
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
GL3-S300M02-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL4-S400M02-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

PR 单刃刀片上带负T-型倒棱的屑槽，是不利工况下深槽加工和切断加工以及连续切削至断续切削的首选。

GL. D - GM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



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/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)
GL2-D200M02-GM:G8330	⇕	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	●	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330	⇕	0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	●	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330	⇕	0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	●	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330	⇕	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	●	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330	⇕	0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	●	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330	⇕	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330	⇕	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]	⇕	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–

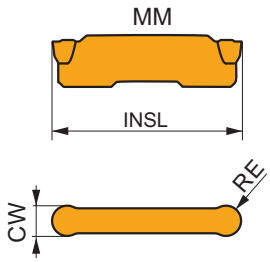
[1] Usable only in holders with CDX ≥ 24.

GM 用途断屑槽，适用于切槽和轴向车削，以及连续至断续切削。

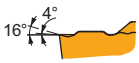
GL. D - MM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0

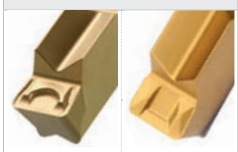


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
																				
GL2-D200MM0-MM:G8330	⇕	1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	⇕	1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330	⇕	1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	⇕	1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330	⇕	2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	⇕	2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330	⇕	2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	⇕	2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330	⇕	3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	⇕	3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–

MM 屑槽，球头外形，适用于仿形加工和轴向车削，连续至断续切削。

LCM. – 外冷刀具导航工具

刀片座	0316	0416	0516	0616	0830
GFI(RL) EXT 16×16 / 32×25					
GFM(RL) EXT 20×20 / 32×25					
切削宽度(mm) CW	3	4	5	6	8
深切断加工(单面刀片)	LCMR CM	LCMR CM			
切断(管件/完整棒材)	CM F	CM F	CM F	CM F	F
切槽(深/浅)	F M	F M	F M	F M	F
车削(轴向)	F M	F M	F M	 F M	F
仿形(多轴)	MP	MP	MP	MP	MP

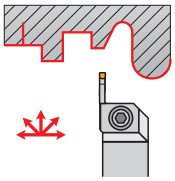
GFI(RL) EXT

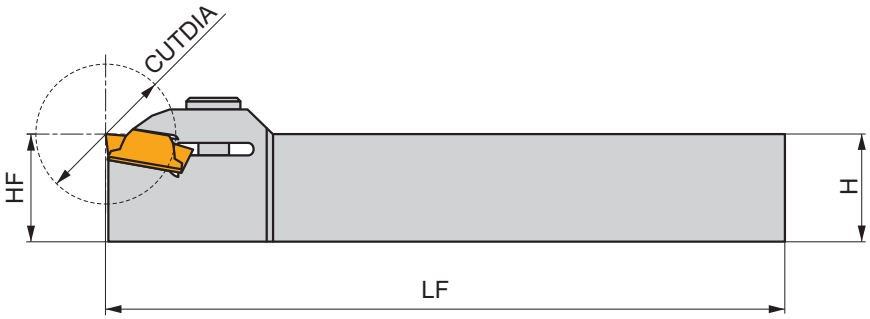
P M K N S H

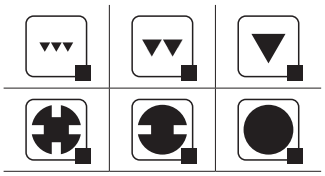
PRAMET

G

外圆用开槽和车削加工刀具，V-型刀片槽，顶部夹紧，使用LCM..刀片。
外圆用左/右手车刀杆，开槽加工,使用LCM. 刀片。适用于开槽，仿形和轴向车削应用。刀杆经过处理，使用寿命更长。







	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CUTDIA (mm)	kg		
R	GFIR 1616 H 03	16	16	16	100	3.00	18	0.22	GI136	GL03
	GFIR 2020 K 03	20	20	20	125	3.00	18	0.40	GI136	GL04
	GFIR 2525 M 03	25	25	25	150	3.00	18	0.73	GI136	GL05
	GFIR 1616 H 04	16	16	16	100	4.00	24	0.21	GI137	GL03
	GFIR 2020 K 04	20	20	20	125	4.00	24	0.39	GI137	GL04
	GFIR 2525 M 04	25	25	25	150	4.00	24	0.71	GI137	GL05
	GFIR 2020 K 05	20	20	20	125	5.00	28	0.38	GI138	GL04
	GFIR 2525 M 05	25	25	25	150	5.00	28	0.70	GI138	GL05
	GFIR 2020 K 06	20	20	20	125	6.00	28	0.38	GI139	GL04
	GFIR 2525 M 06	25	25	25	150	6.00	28	0.70	GI139	GL05
	GFIR 2525 M 08	25	25	25	150	8.00	48	0.74	GI193	GL09
	GFIR 3225 P 08	32	32	25	170	8.00	48	1.01	GI193	GL09
L	GFIL 1616 H 03	16	16	16	100	3.00	18	0.22	GI136	GL03
	GFIL 2020 K 03	20	20	20	125	3.00	18	0.39	GI136	GL04
	GFIL 2525 M 03	25	25	25	150	3.00	18	0.73	GI136	GL05
	GFIL 1616 H 04	16	16	16	100	4.00	24	0.20	GI137	GL03
	GFIL 2020 K 04	20	20	20	125	4.00	24	0.38	GI137	GL04
	GFIL 2525 M 04	25	25	25	150	4.00	24	0.71	GI137	GL05
	GFIL 2020 K 05	20	20	20	125	5.00	28	0.38	GI138	GL04
	GFIL 2525 M 05	25	25	25	150	5.00	28	0.71	GI138	GL05
	GFIL 2020 K 06	20	20	20	125	6.00	28	0.40	GI139	GL04
	GFIL 2525 M 06	25	25	25	150	6.00	28	0.70	GI139	GL05
	GFIL 2525 M 08	25	25	25	150	8.00	48	0.74	GI193	GL09
	GFIL 3225 P 08	32	32	25	170	8.00	48	1.02	GI193	GL09

GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..
GI193	LCM. 0830..

		Nm			
GL03	HS 0616C	6.0	M 6	16	HXK 5
GL04	HS 0620C	6.0	M 6	20	HXK 5
GL05	HS 0625C	6.0	M 6	25	HXK 5
GL09	HSI 1020	8.0	M 10	20	HXK 8

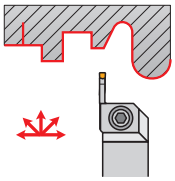
GFM(RL) EXT

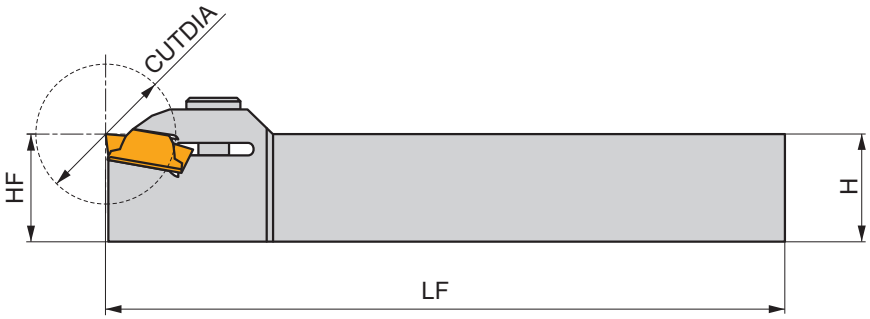
P M K N S H

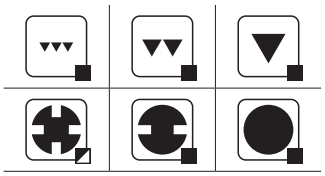
PRAMET

G

外圆用开槽和车削加工刀具，V-型刀片槽，顶部夹紧，使用LCM刀片。
外圆用左/右手车刀杆，开槽加工。使用LCM.刀片。适用于切断，开槽，仿形和轴向车削应用。刀杆经过处理，使用寿命更长。







	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CUTDIA (mm)	kg		
R	GFMR 2020 K 0316	20	20	20	125	3.00	30	0.37	GI136	GL04
	GFMR 2525 M 0316	25	25	25	150	3.00	30	0.68	GI136	GL04
	GFMR 2020 K 0416	20	20	20	125	4.00	40	0.37	GI137	GL04
	GFMR 2525 M 0416	25	25	25	150	4.00	40	0.67	GI137	GL04
	GFMR 2525 M 0516	25	25	25	150	5.00	50	0.65	GI138	GL04
	GFMR 3225 P 0516	32	32	25	170	5.00	50	0.96	GI138	GL04
	GFMR 2525 M 0616	25	25	25	150	6.00	60	0.66	GI139	GL04
	GFMR 3225 P 0616	32	32	25	170	6.00	60	0.95	GI139	GL04
	GFMR 3225 P 0830	32	32	25	170	8.00	80	0.97	GI193	GL10
L	GFML 2020 K 0316	20	20	20	125	3.00	30	0.36	GI136	GL04
	GFML 2525 M 0316	25	25	25	150	3.00	30	0.69	GI136	GL04
	GFML 2020 K 0416	20	20	20	125	4.00	40	0.37	GI137	GL04
	GFML 2525 M 0416	25	25	25	150	4.00	40	0.67	GI137	GL04
	GFML 2525 M 0516	25	25	25	150	5.00	50	0.66	GI138	GL04
	GFML 3225 P 0516	32	32	25	170	5.00	50	0.96	GI138	GL04
	GFML 2525 M 0616	25	25	25	150	6.00	60	0.64	GI139	GL04
	GFML 3225 P 0616	32	32	25	170	6.00	60	0.95	GI139	GL04
	GFML 3225 P 0830	32	32	25	170	8.00	80	0.97	GI193	GL10

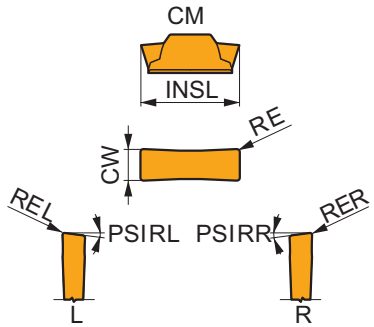
GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..
GI193	LCM. 0830..

		Nm			
GL04	HS 0620C	6.0	M 6	20	HXK 5
GL10	HSI 1020	8.0	M 10	20	HXK 8

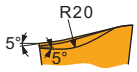
LCMF 16 - CM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



线速度(vc)和进给量(f)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。

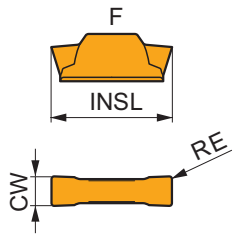
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
CM 屑槽，是切断和开槽的首选，连续切削至轻微断续切削。																
LCMF 031602-CM:T8330	⚙	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 031604-CM:T8330	⚙	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 041602-CM:T8330	⚙	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 041604-CM:T8330	⚙	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 051604-CM:T8330	⚙	0.4	130	0.11	75	0.11	120	0.11	–	–	–	–	–	–	–	–
LCMF 061604-CM:T8330	⚙	0.4	130	0.11	75	0.11	120	0.11	–	–	–	–	–	–	–	–
R-CM 屑槽，惯用右手设计，是切断，连续切削至轻微断续切削的首选。																
LCMF 031602R15-CM:T8330[1]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	15	–
LCMF 031602R6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	6	–
LCMF 041602R15-CM:T8330[1]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	15	–
LCMF 041602R6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	6	–
L-CM 屑槽，左手设计，是切断，连续切削至轻微断续切削的首选。																
LCMF 031602L15-CM:T8330[1]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	15
LCMF 031602L6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	6
LCMF 041602L15-CM:T8330[1]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	15
LCMF 041602L6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	6

[1] Toolholders have to be modified.

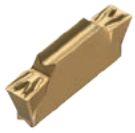
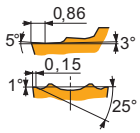
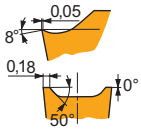
LCMF 16, LCMF 30 - F

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4
0830	8.00	-0.05	0.05	30.0



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/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)
																				
LCMF 031602-F:T8330		0.2	195	0.10	0.3	115	0.09	0.3	185	0.10	0.3	–	–	–	–	–	–	–	–	–
LCMF 031604-F:T8330		0.4	200	0.10	0.5	120	0.09	0.5	190	0.10	0.5	–	–	–	–	–	–	–	–	–
LCMF 041604-F:T8330		0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMF 041604-F:T9325		0.4	275	0.13	0.5	165	0.12	0.5	260	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMF 041608-F:T8330		0.8	205	0.13	1.0	120	0.12	1.0	190	0.13	1.0	–	–	–	–	–	–	–	–	–
LCMF 041608-F:T9325		0.8	305	0.13	1.0	180	0.12	1.0	285	0.13	1.0	–	–	–	–	–	–	–	–	–
LCMF 051608-F:T8330		0.8	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	–	–	–	–	–	–	–	–	–
LCMF 051608-F:T9325		0.8	285	0.15	1.0	170	0.14	1.0	270	0.15	1.0	–	–	–	–	–	–	–	–	–
LCMF 061608-F:T8330		0.8	190	0.17	1.0	110	0.15	1.0	180	0.17	1.0	–	–	–	–	–	–	–	–	–
LCMF 061608-F:T9325		0.8	270	0.17	1.0	160	0.15	1.0	255	0.17	1.0	–	–	–	–	–	–	–	–	–
																				
LCMF 083008-F:T8330		0.8	175	0.25	1.0	105	0.23	1.0	165	0.25	1.0	–	–	–	–	–	–	–	–	–
LCMF 083012-F:T8330		1.2	170	0.25	1.5	100	0.23	1.5	160	0.25	1.5	–	–	–	–	–	–	–	–	–

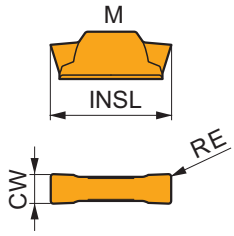
F 屑槽，适用于切断，开槽和轴向车削，超精加工和精加工，连续切削至轻微断续切削。

F 屑槽，适用于切断，开槽和轴向车削，超精加工和精加工，连续切削至轻微断续切削。

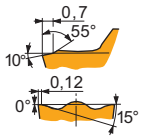
LCMF 16 - M

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



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。



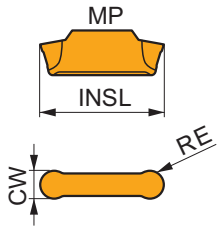
M 屑槽，适用于开槽和轴向车削，连续至断续切削。

Product	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)
LCMF 031602-M:T8330	0.2	160	0.13	1.0	95	0.12	1.0	150	0.13	1.0	–	–	–	–	–	–	30	0.10	0.7
LCMF 031604-M:T8330	0.4	170	0.13	1.0	100	0.12	1.0	160	0.13	1.0	–	–	–	–	–	–	30	0.10	0.7
LCMF 041604-M:T8330	0.4	155	0.18	1.0	90	0.16	1.0	145	0.18	1.0	–	–	–	–	–	–	30	0.12	0.8
LCMF 041604-M:T9325	0.4	225	0.18	1.0	135	0.16	1.0	210	0.18	1.0	–	–	–	–	–	–	–	–	–
LCMF 041608-M:T8330	0.8	185	0.18	1.0	110	0.16	1.0	175	0.18	1.0	–	–	–	–	–	–	35	0.12	0.8
LCMF 041608-M:T9325	0.8	265	0.18	1.0	155	0.16	1.0	250	0.18	1.0	–	–	–	–	–	–	–	–	–
LCMF 051608-M:T8330	0.8	180	0.20	1.0	105	0.18	1.0	170	0.20	1.0	–	–	–	–	–	–	35	0.13	1.0
LCMF 051608-M:T9325	0.8	255	0.20	1.0	150	0.18	1.0	240	0.20	1.0	–	–	–	–	–	–	–	–	–
LCMF 061608-M:T8330	0.8	175	0.25	1.0	105	0.23	1.0	165	0.25	1.0	–	–	–	–	–	–	35	0.13	1.0
LCMF 061608-M:T9325	0.8	230	0.25	1.0	135	0.23	1.0	215	0.25	1.0	–	–	–	–	–	–	–	–	–

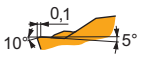
LCMF 16, LCMF 30 - MP

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	17.5
0416	4.00	-0.05	0.05	17.6
0516	5.00	-0.05	0.05	18.3
0616	6.00	-0.05	0.05	18.5
0830	8.00	-0.05	0.05	30.9



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。



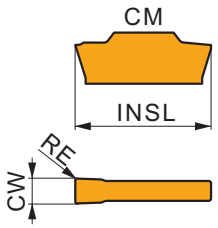
MP 屑槽，适用于轴向车削和仿形加工，连续切削至间断切削。

Product	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)
LCMF 0316M0-MP:T8330	1.5	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMF 0416M0-MP:T8330	2.0	175	0.40	1.0	105	0.36	1.0	165	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMF 0416M0-MP:T9325	2.0	220	0.40	1.0	130	0.36	1.0	205	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMF 0516M0-MP:T8330	2.5	170	0.45	1.0	100	0.41	1.0	160	0.45	1.0	–	–	–	–	–	–	–	–	–
LCMF 0516M0-MP:T9325	2.5	205	0.45	1.0	120	0.41	1.0	190	0.45	1.0	–	–	–	–	–	–	–	–	–
LCMF 0616M0-MP:T8330	3.0	165	0.50	1.0	95	0.45	1.0	155	0.50	1.0	–	–	–	–	–	–	–	–	–
LCMF 0616M0-MP:T9325	3.0	200	0.50	1.0	120	0.45	1.0	190	0.50	1.0	–	–	–	–	–	–	–	–	–
LCMF 0830M0-MP:T8330	4.0	150	0.60	1.2	90	0.54	1.2	140	0.60	1.2	–	–	–	–	–	–	–	–	–

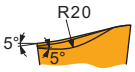
LCMR 16 - CM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4



线速度(vc)和进给量(f)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。

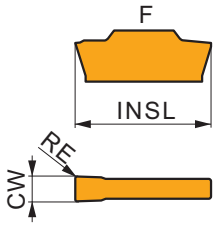
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
															
LCMR 031602-CM:T8330	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMR 041604-CM:T8330	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–

CM 屑槽，是切断和开槽的首选，连续切削至轻微断续切削。

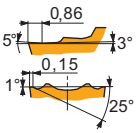
LCMR 16, LCMR 30 - F

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



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。

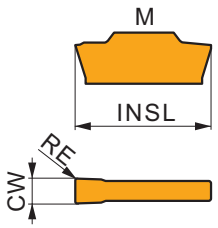
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																			
LCMR 031604-F:T8330	0.4	200	0.10	0.5	120	0.09	0.5	190	0.10	0.5	–	–	–	–	–	–	–	–	–
LCMR 041604-F:T8330	0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMR 051604-F:T8330	0.4	180	0.15	0.5	105	0.14	0.5	170	0.15	0.5	–	–	–	–	–	–	–	–	–
LCMR 061608-F:T8330	0.8	190	0.17	1.0	110	0.15	1.0	180	0.17	1.0	–	–	–	–	–	–	–	–	–

F 屑槽，适用于切断，开槽和轴向车削，超精加工和精加工，连续切削至轻微断续切削。

LCMR 16 - M

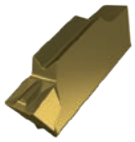
PRAMET

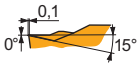
	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



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/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)
LCMR 031604-M:T8330	0.4	170	0.13	1.0	100	0.12	1.0	160	0.13	1.0	–	–	–	–	–	–	30	0.10	0.7
LCMR 041604-M:T8330	0.4	155	0.18	1.0	90	0.16	1.0	145	0.18	1.0	–	–	–	–	–	–	30	0.12	0.8
LCMR 051604-M:T8330	0.4	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	–	–	–	30	0.13	1.0
LCMR 061608-M:T8330	0.8	175	0.25	1.0	105	0.23	1.0	165	0.25	1.0	–	–	–	–	–	–	35	0.13	1.0





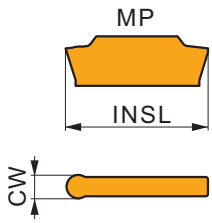
E

M 屑槽，适用于开槽和轴向车削，连续至断续切削。

LCMR 16 - MP

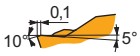
PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	17.4
0416	4.00	-0.05	0.05	17.5
0516	5.00	-0.05	0.05	18.1
0616	6.00	-0.05	0.05	18.3



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/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)
LCMR 0316MO-MP:T8330	1.5	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMR 0416MO-MP:T8330	2.0	175	0.40	1.0	105	0.36	1.0	165	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMR 0516MO-MP:T8330	2.5	170	0.45	1.0	100	0.41	1.0	160	0.45	1.0	–	–	–	–	–	–	–	–	–
LCMR 0616MO-MP:T8330	3.0	165	0.50	1.0	95	0.45	1.0	155	0.50	1.0	–	–	–	–	–	–	–	–	–

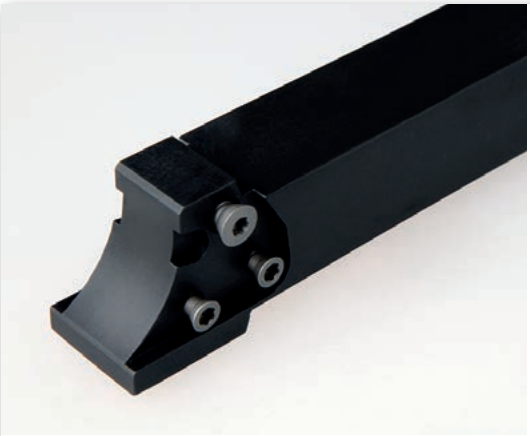


U S

MP 屑槽，适用于轴向车削和仿形加工，连续切削至间断切削。

GL – 刀片和附件导航工具

刀片座	GL1	GL2	GL3	GL4	GL5	GL6	
刀片 H = 26; 32 mm	NEW CDX 16 mm	CDX 35–50 mm	CDX 35–50 mm	CDX 50 mm	CDX 60 mm	CDX 60 mm	
NEW MS刀片		CDX 24 mm	CDX 24 mm	CDX 24 mm	CDX 24 mm	CDX 24 mm	
切削宽度 (mm) CW	1.5	2	3 (2.5)	4	5	6	8
NEW 深切断加工 (单面刀片)			单面刀片 PM 1 PR	单面刀片 PM 1 PR			
切断 (管件/完整棒材)	NEW PM	PM 1 PR	CW = 2.5 / 3 PM 1 PR	PM 1 PR	PM 1 PR	PM 1 PR	
切槽 (深/浅)		PR GM	PR GM	PR GM	PR GM	PR GM	NEW GM



MS-EN

模块化刀架
刀柄尺寸:
20 × 20 mm、25 × 25 mm、32 × 32 mm

DU, D

刀架座
刀柄尺寸:
20 × 20 mm、25 × 23 mm、25 × 32 mm、32 × 29 mm、25 × 30 mm

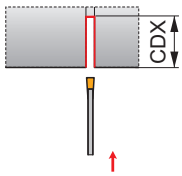
GLS B

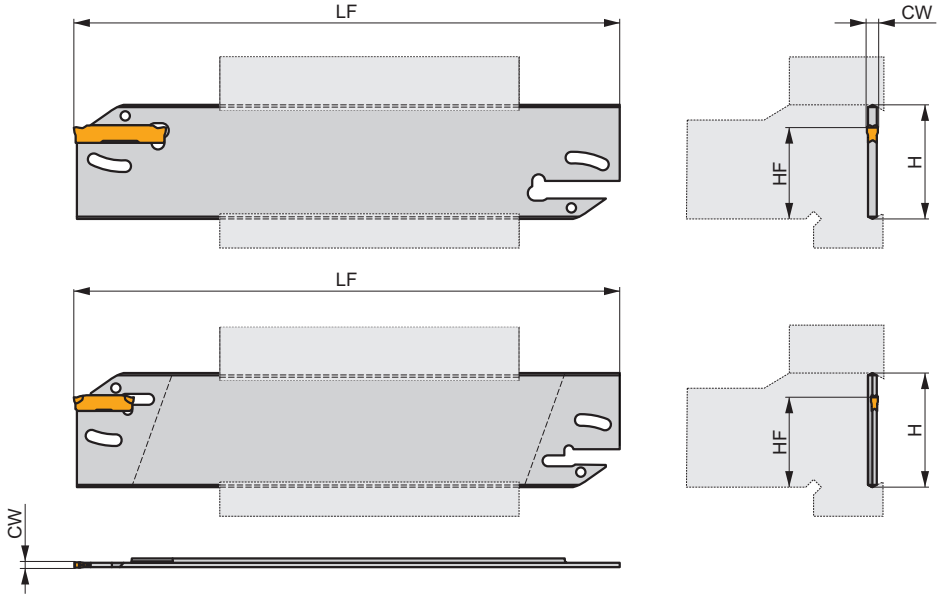
P M K N S H

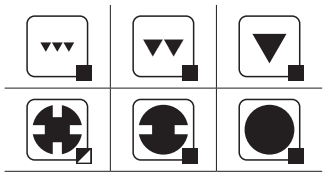
PRAMET

X

双刃切断和切槽刀板，用于GL刀片
用于GL刀片的刀板，适用于切断和切槽加工切断和切槽加工应用。通过使用专用扳手（包含在组件中）轻松更换刀片。可以安装至DU、D刀柄。刀体经过处理，使用寿命更长。







	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
R	GL1-S26KBR-16	21.4	26	125	1.50	16	0.05	GI333	KV2
	GL1-S32MBR-16	32	32	150	1.50	16	0.07	GI333	KV2
L	GL1-S26KBL-16	21.4	26	125	1.50	16	0.05	GI333	KV2
	GL1-S32MBL-16	32	32	150	1.50	16	0.07	GI333	KV2
N	GL2-S26KB	21.4	26	125	2.00	35	0.13	GI334	KV2
	GL2-S32MB	25	32	150	2.00	50	0.15	GI334	KV2
	GL3-S26KB	21.4	26	125	3.00	35	0.15	GI335	KV2
	GL3-S32MB	25	32	150	3.00	50	0.15	GI335	KV2
	GL4-S32MB	25	32	150	4.00	50	0.19	GI336	KV2
	GL5-S32MB	25	32	150	5.00	60	0.22	GI337	KV2
	GL6-S32MB	25	32	150	6.00	60	0.25	GI338	KV2

GI333	GL1..	–
GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

KV2	KV 15x150

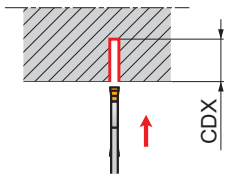
GLS BS

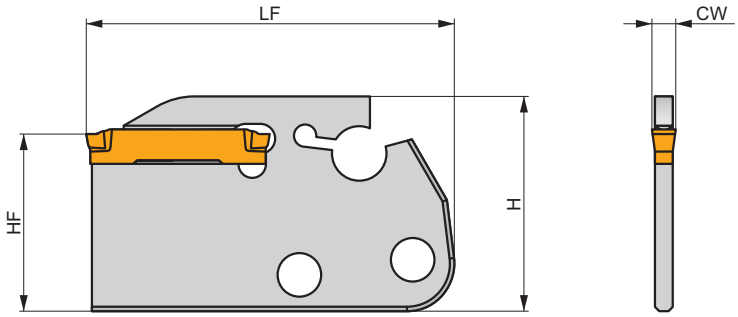
P M K N S H

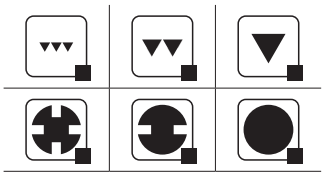
PRAMET

G

切槽和切断加工刀板，用于GL刀片、MS-EN刀柄
用于模块化刀柄MS-EN的刀板，设计用于GL刀片。适用于切槽和切断加工应用。刀片经过处理，确保了更长的刀具寿命。







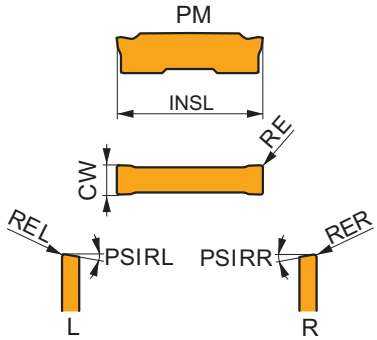
Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg	
GL2-S29CBS	24	29	50	2.00	24	0.01	GI334
GL3-S29CBS	24	29	50	3.00	24	0.02	GI335
GL4-S29CBS	24	29	50	4.00	24	0.02	GI336
GL5-S29CBS	24	29	50	5.00	24	0.03	GI337
GL6-S29CBS	24	29	50	6.00	24	0.04	GI338

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

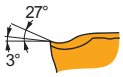
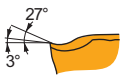
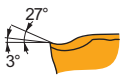
GL. D - PM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
150	1.50	-0.04	0.04	16.5
200	2.00	-0.05	0.05	25.0
250	2.55	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



线速度(vc)和进给量(f)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/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
GL1-D150M015-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	–	–
GL2-D200M02-PM:G8330	⬌	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	–	–
GL2-D200M02-PM:T7325	●	0.2	150	0.08	115	0.07	140	0.08	–	–	45	0.06	–	–	–	–
GL3-D250G02-PM:G8330	⬌	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL3-D300M02-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL3-D300M02-PM:T7325	●	0.2	150	0.10	115	0.09	140	0.10	–	–	45	0.07	–	–	–	–
GL4-D400M02-PM:G8330	⬌	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	–
GL4-D400M02-PM:T7325	●	0.2	150	0.12	115	0.11	140	0.12	–	–	45	0.10	–	–	–	–
GL5-D500M03-PM:G8330	⬌	0.3	130	0.15	75	0.14	120	0.15	390	0.18	30	0.12	–	–	–	–
GL6-D600M03-PM:G8330	⬌	0.3	130	0.15	75	0.14	120	0.15	390	0.18	30	0.12	–	–	–	–
																
GL1-D150G015R06-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	6	–
GL1-D150G015R12-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	12	–
GL2-D200G02R06-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	6	–
GL2-D200G02R06-PM:T7325	●	0.2	150	0.08	115	0.07	140	0.08	–	–	45	0.06	–	–	6	–
GL2-D200G02R12-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	12	–
GL3-D300G02R06-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	6	–
GL3-D300G02R06-PM:T7325	●	0.2	150	0.10	115	0.09	140	0.10	–	–	45	0.07	–	–	6	–
GL3-D300G02R12-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	12	–
GL4-D400G02R06-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	6	–
GL4-D400G02R06-PM:T7325	●	0.2	150	0.12	115	0.11	140	0.12	–	–	45	0.10	–	–	6	–
GL4-D400G02R12-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	12	–
																
GL1-D150G015L06-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	–	6
GL1-D150G015L12-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	–	12
GL2-D200G02L06-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	–	6
GL2-D200G02L06-PM:T7325	●	0.2	150	0.08	115	0.07	140	0.08	–	–	45	0.06	–	–	–	6
GL2-D200G02L12-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	–	12
GL3-D300G02L06-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	6
GL3-D300G02L06-PM:T7325	●	0.2	150	0.10	115	0.09	140	0.10	–	–	45	0.07	–	–	–	6
GL3-D300G02L12-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	12
GL4-D400G02L06-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	6
GL4-D400G02L06-PM:T7325	●	0.2	150	0.12	115	0.11	140	0.12	–	–	45	0.10	–	–	–	6
GL4-D400G02L12-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	12

PM 具有大正前角的型，是切断和切槽加工以及连续切削至轻微断续切削的首选。

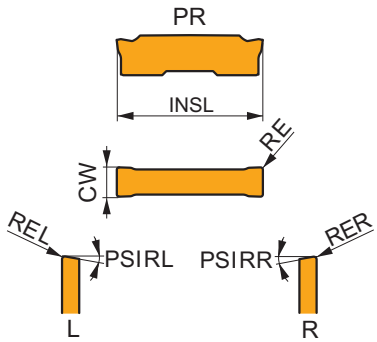
R-PM 具有大正前角的旋槽型，是切断加工和连续切削的首选。

L-PM 具有大正前角的旋槽型，是切断加工和连续切削的首选。

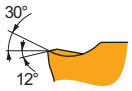
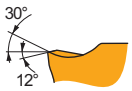
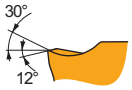
GL. D - PR

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



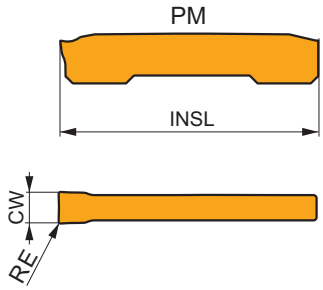
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
PR 带负T-型倒棱的型，是不利工况下切槽加工和切断加工以及连续切削至间断切削的首选。																
GL2-D200M02-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
GL2-D200M02-PR:T7325		0.2	150	0.10	115	0.09	140	0.10	–	–	–	–	–	–	–	–
GL3-D300M02-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL3-D300M02-PR:T7325		0.2	150	0.12	115	0.11	140	0.12	–	–	–	–	–	–	–	–
GL4-D400M02-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
GL4-D400M02-PR:T7325		0.2	150	0.15	115	0.14	140	0.15	–	–	–	–	–	–	–	–
GL5-D500M04-PR:G8330		0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
GL6-D600M04-PR:G8330		0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
																
R-PR 带负T-型倒棱的旋槽型，是不利工况下棒料切断加工以及连续切削至间断切削的首选。																
GL2-D200G02R06-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	6	–
GL2-D200G02R12-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	12	–
GL3-D300G02R06-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	6	–
GL3-D300G02R12-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	12	–
GL4-D400G02R06-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	6	–
GL4-D400G02R12-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	12	–
																
L-PR 带负T-型倒棱的旋槽型，是高难度棒料切断加工以及连续切削至间断切削的首选。																
GL2-D200G02L06-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	6
GL2-D200G02L12-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	12
GL3-D300G02L06-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	6
GL3-D300G02L12-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	12
GL4-D400G02L06-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	6
GL4-D400G02L12-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	12

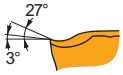
GL. S - PM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



线速度(vc)和进给量(f)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。

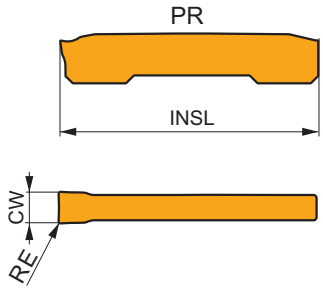
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
GL3-S300M02-PM:G8330		0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL4-S400M02-PM:G8330		0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	–

PM 单刃刀片具有大正前角的型，是深度切断加工以及连续切削至轻微断续切削的首选。

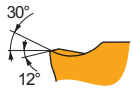
GL. S - PR

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



线速度(vc)和进给量(f)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。

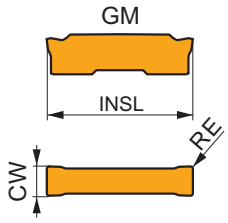
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
GL3-S300M02-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL4-S400M02-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

PR 单刃刀片上带负T-型倒棱的屑槽，是不利工况下深槽加工和切断加工以及连续切削至断续切削的首选。

GL. D - GM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



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/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)
GL2-D200M02-GM:G8330	⁝	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	●	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330	⁝	0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	●	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330	⁝	0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	●	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330	⁝	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	●	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330	⁝	0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	●	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330	⁝	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330	⁝	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]	⁝	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–

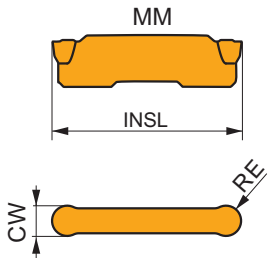
[1] Usable only in holders with CDX ≥ 24.

GM 用途断屑槽，适用于切槽和轴向车削，以及连续至断续切削。

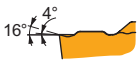
GL. D - MM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0

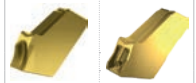
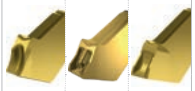
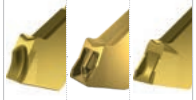
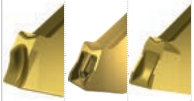
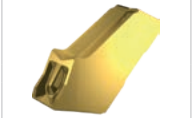
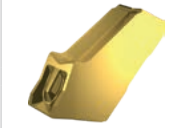


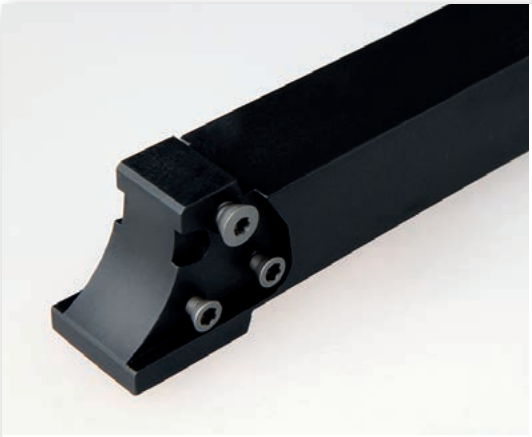
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
																				
GL2-D200MM0-MM:G8330	⁝	1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	⁝	1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330	⁝	1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	⁝	1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330	⁝	2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	⁝	2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330	⁝	2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	⁝	2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330	⁝	3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	⁝	3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–

MM 屑槽，球头外形，适用于仿形加工和轴向车削，连续至断续切削。

LFMX – 刀片和附件导航工具

刀片座	1.60	2.00	3.00	4.00	5.00	6.35
XLCFN B 刀片 H = 26 mm H = 32; 45 mm						
XLCF(NRL) BS MS刀片						
切削宽度 (mm) CW	1.5 / 1.6	2.0 / 2.2	3.1	4.1	5.1	6.35
切断刀片 (锋利/带 T 倒棱)	 F1 F2	 F1 F2 M2	 F1 F2 M2	 F1 F2 M2	 F2	 F2



MS-EN

模块化刀架
刀柄尺寸：
20 × 20 mm、25 × 25 mm、32 × 32 mm

DU, D

刀架座
刀柄尺寸：
20 × 20 mm、25 × 23 mm、25 × 32 mm、32 × 29 mm、25 × 30 mm

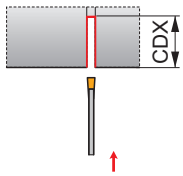
XLCFN B

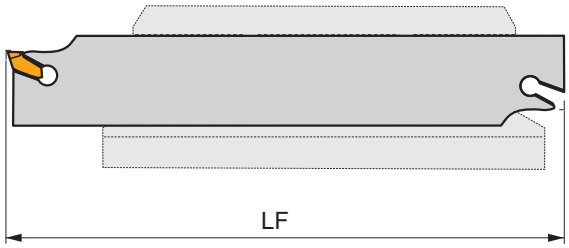
P M K N S H

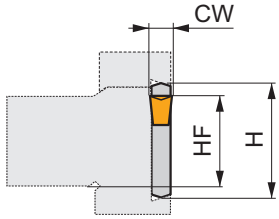
PRAMET

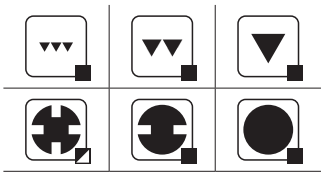
X

使用LFMX刀片，双头切断刀片
刀片用于切断应用，适用于单面LFMX刀片。可以安装在DU普拉米特基础刀杆上。刀体经过处理，使用寿命更长。









	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
N	**XLCFN 2601 J 1.60**	21.4	26	110	1.50	15	0.06	GI132	KV
	XLCFN 2601 J 2.00	21.4	26	110	2.00	25	0.07	GI061	KV
	XLCFN 2602 J 3.00	21.4	26	110	3.10	37.5	0.08	GI001	KV
	XLCFN 2603 J 4.00	21.4	26	110	4.10	40	0.10	GI002	KV
	XLCFN 3201 M 1.60	25	32	150	1.50	15	0.11	GI132	KV
	XLCFN 3201 M 2.00	25	32	150	2.00	25	0.11	GI061	KV
	XLCFN 3202 M 3.00	25	32	150	3.10	50	0.08	GI001	KV
	XLCFN 3203 M 4.00	25	32	150	4.10	50	0.14	GI002	KV
	XLCFN 3204 M 5.00	25	32	150	5.10	60	0.18	GI004	KV
	XLCFN 3205 M 6.35	25	32	150	6.35	60	0.21	GI005	KV
	XLCFN 4502 S 3.00	32	45	250	3.10	80	0.25	GI001	KV
	XLCFN 4503 S 4.00	32	45	250	4.10	80	0.33	GI002	KV
	XLCFN 4504 S 5.00	32	45	250	5.10	80	0.41	GI004	KV
	XLCFN 4505 S 6.35	32	45	250	6.35	80	0.48	GI005	KV

GI001	LFMX 3.1-.	–
GI002	LFMX 4.1-.	–
GI004	LFMX 5.1-.	–
GI005	LFMX 6.35-.	–
GI061	LFMX 2.0-.	LFMX 2.2-.
GI132	LFMX 1.5-.	LFMX 1.6-.

KV	KV 5x70

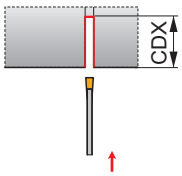
XLCF(NRL) BS

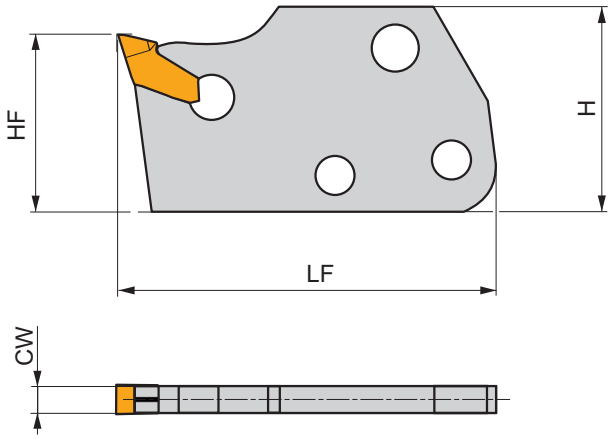
P M K N S H

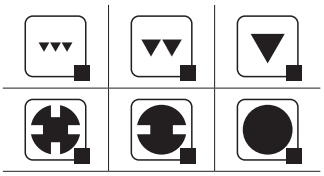
PRAMET

X

模块化MS-EN槽刀杆的径向开槽刀板，使用LFMX刀片，
模块化开槽刀板，开槽加工，使用单面LFMX刀片。适用于开槽或切断（最大25mm的切削深度）应用。刀板经过处理，使用寿命更长。







	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
R	XLCFR 160115-1.60	12	25	35	1.50	15	0.03	GI132	KV
	XLCFR 160115-2.00	12	25	35	2.00	15	0.01	GI061	KV
	XLCFR 250115-1.60	24	29	40	1.50	15	0.01	GI132	KV
	XLCFR 250115-2.00	24	29	40	2.00	15	0.05	GI061	KV
L	XLCFL 160115-1.60	12	25	35	1.50	15	0.03	GI132	KV
	XLCFL 160115-2.00	12	25	35	2.00	15	0.04	GI061	KV
	XLCFL 250115-1.60	24	29	40	1.50	15	0.04	GI132	KV
	XLCFL 250115-2.00	24	29	40	2.00	15	0.05	GI061	KV
N	XLCFN 160215-3.00	12	25	35	3.10	15	0.01	GI001	KV
	XLCFN 160220-3.00	12	25	40	3.10	20	0.04	GI001	KV
	XLCFN 250215-3.00	24	29	40	3.10	15	0.04	GI001	KV
	XLCFN 250225-3.00	24	29	50	3.10	25	0.02	GI001	KV
	XLCFN 250315-4.00	24	29	40	4.10	15	0.04	GI002	KV
	XLCFN 250325-4.00	24	29	50	4.10	25	0.04	GI002	KV
	XLCFN 250425-5.00	24	29	50	5.10	25	0.04	GI004	KV
	XLCFN 250525-6.35	24	29	50	6.35	25	0.07	GI005	KV

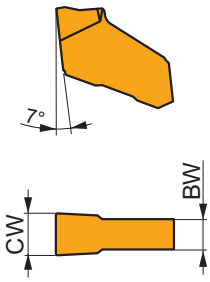
GI001	LFMX 3.1-.	–
GI002	LFMX 4.1-.	–
GI004	LFMX 5.1-.	–
GI005	LFMX 6.35-.	–
GI061	LFMX 2.0-.	LFMX 2.2-.
GI132	LFMX 1.5-.	LFMX 1.6-.

KV	KV 5x70

LFMX - F1

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	BW (mm)
1.5	1.50	-0.03	0.03	1.30
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60



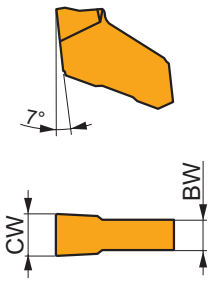
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
F1 eN-屑槽，适用于切断和开槽加工，连续切削。																
LFMX 1.5-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 1.6-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 2.0-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 3.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–

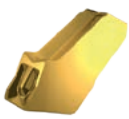
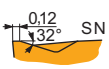
LFMX - F2

PRAMET

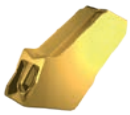
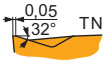
	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	BW (mm)
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



线速度(vc)和进给量(f)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/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
  SN-F2 屑槽，适用于切断和开槽加工，连续切削。																
LFMX 1.6-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNF2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

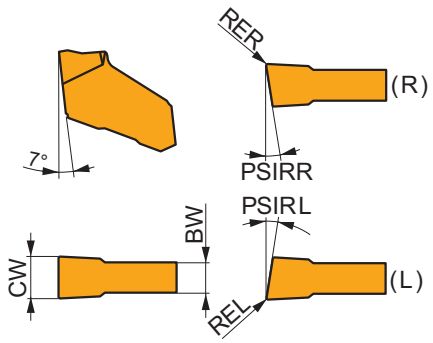
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
 																
TN-F2 屑槽，适用于切断和开槽加工，连续切削。																
LFMX 3.1-.20TNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–

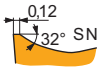
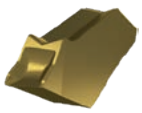
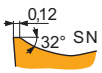
LFMX - M2

PRAMET

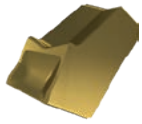
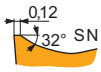
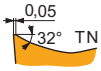
	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	BW (mm)
2.0	2.00	-0.03	0.03	1.60
2.2	2.20	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



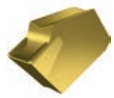
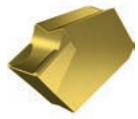
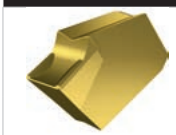
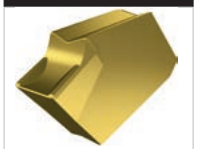
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
SN-M2 屑槽，适用于切断和开槽加工，连续至轻微断续切削。																
LFMX 2.0-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:6640	⬌	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:T8330	⬌	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:6640	⬌	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:T8330	⬌	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:6640	⬌	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:T8330	⬌	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:6640	⬌	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:T8330	⬌	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
 																
SR-M2 屑槽，右手设计，适用于切断，连续切削至轻微断续切削。																
LFMX 2.0-.16SR12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	12	–
LFMX 2.0-.16SR6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	6	–
LFMX 3.1-.20SR8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	8	–
LFMX 4.1-.20SR8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	8	–

线速度(vc)和进给量(f)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/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
  SL-M2 屑槽，左手设计，适用于切断加工，连续切削至轻微断续切削。																
LFMX 2.0-.16SL12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	12
LFMX 2.0-.16SL6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	6
LFMX 3.1-.20SL8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	8
LFMX 4.1-.20SL8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	8
 TN-M2 屑槽，适用于切开和开槽加工，连续至轻微断续切削。																
LFMX 3.1-.20TNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

LFUX – 刀片和附件导航工具

刀片座	03	04	05	06		
XLCFN B LFUX 刀片 H = 26 mm H = 32; 47 mm						
切削宽度 (mm) CW	3	4	5			
切断刀片	 LFUX	 LFUX	 LFUX	 LFUX		

DU, D

- 刀架座
- 刀柄尺寸：
20 × 20 mm、25 × 23 mm、25 × 32 mm、32 × 29 mm、25 × 30 mm

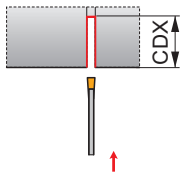
XLCFN B LFUX

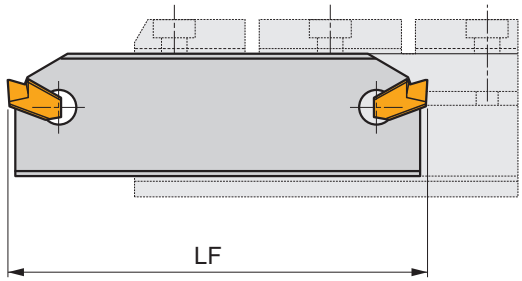
P M K N S H

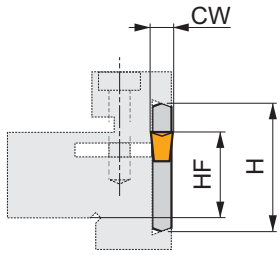
PRAMET

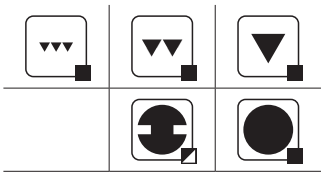
X

使用LFUX刀片，双头切断刀片
刀片用于切断应用，适用于单面LFUX刀片。高度为26、32或47mm。可安装在DU,D普拉米特基础刀杆上。刀体经过处理，使用寿命更长。









	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
N	**XLCFN 2603 J 03**	21.4	26	110	3.10	37.5	0.06	GI018	KV
	XLCFN 3202 M 03	25	32	150	3.10	50	0.11	GI018	KV
	XLCFN 3203 M 04	25	32	150	4.10	50	0.15	GI019	KV
	XLCFN 3204 M 05	25	32	150	5.10	60	0.17	GI020	KV
	XLCFN 4704 S 05	38	47	270	5.10	100	0.46	GI020	KV
	XLCFN 4705 S 06	38	47	270	6.10	100	0.50	GI021	KV

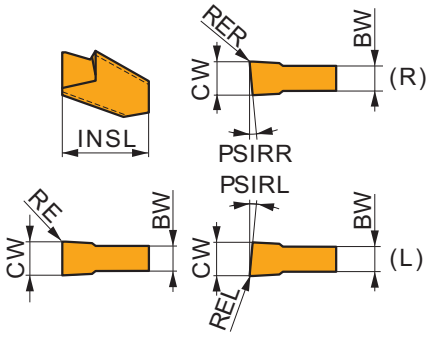
GI018	LFUX 0308..
GI019	LFUX 0408..
GI020	LFUX 0508..
GI021	LFUX 0608..

KV	KV 5x70

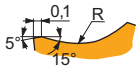
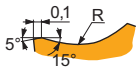
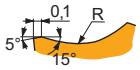
LFUX

PRAMET

	CW (mm)	BW (mm)	INSL (mm)
0308	3.00	2.51	11.5
0408	4.00	3.44	11.5
0508	5.00	4.30	11.5
0608	6.00	5.30	11.5



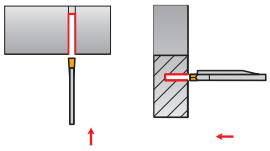
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

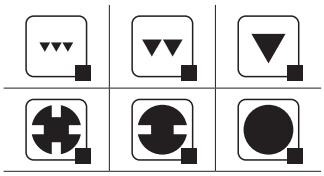
Product	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
TN 屑槽，适用于切断和开槽加工，连续至轻微断续切削。																
LFUX 030802TN:6640	⬌	0.2	150	0.10	–	–	140	0.10	–	–	–	–	–	–	–	–
LFUX 030802TN:T8330	⬌	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	–	–
LFUX 040802TN:6640	⬌	0.2	150	0.12	–	–	140	0.12	–	–	–	–	–	–	–	–
LFUX 040802TN:T8330	⬌	0.2	130	0.12	–	–	120	0.12	–	–	–	–	–	–	–	–
LFUX 050802TN:6640	⬌	0.2	150	0.15	–	–	140	0.15	–	–	–	–	–	–	–	–
LFUX 050802TN:T8330	⬌	0.2	130	0.15	–	–	120	0.15	–	–	–	–	–	–	–	–
LFUX 060802TN:6640	⬌	0.2	150	0.20	–	–	140	0.20	–	–	–	–	–	–	–	–
LFUX 060802TN:T8330	⬌	0.2	130	0.20	–	–	120	0.20	–	–	–	–	–	–	–	–
																
TR 屑槽，右手，适用于切断加工，连续切削至轻微断续切削。																
LFUX 030800TR:6640	●	0.2	150	0.10	–	–	140	0.10	–	–	–	–	–	–	5	–
LFUX 030800TR:T8330	●	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	5	–
LFUX 040800TR:6640	●	0.2	150	0.12	–	–	140	0.12	–	–	–	–	–	–	5	–
LFUX 040800TR:T8330	●	0.2	130	0.12	–	–	120	0.12	–	–	–	–	–	–	5	–
																
TL 屑槽，左手设计，适用于切断加工，连续切削至轻微断续切削。																
LFUX 030800TL:6640	●	0.2	150	0.10	–	–	140	0.10	–	–	–	–	–	–	–	5
LFUX 030800TL:T8330	●	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	–	5

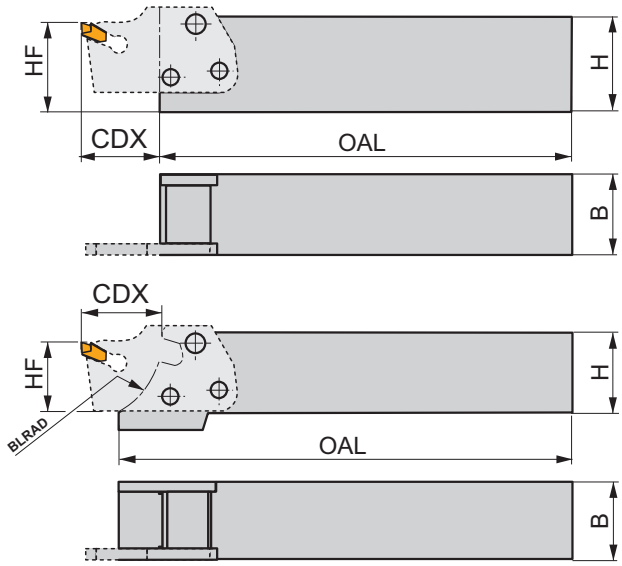
MS-EN

PRAMET

模块化刀柄，用于切槽和切断加工刀板
用于BS型切槽和切断加工刀板的模块化设计,刀体经过处理，使用寿命更长。







Product	HF (mm)	H (mm)	B (mm)	OAL (mm)	BLRAD (mm)	kg		
MS-EN-1212 F	12	12	12	75	–	0.12	GI006	ND4
MS-EN-1616 H	16	16	16	90	–	0.21	GI006	ND4
MS-EN-2020 K	20	20	20	115	–	0.23	GI003	ND5
MS-EN-2020 KS	20	20	20	129	25	0.42	GI060	ND5
MS-EN-2525 M	25	25	25	140	–	0.65	GI003	ND5
MS-EN-2525 MS	25	25	25	153	25	0.73	GI060	ND5
MS-EN-3225 P	32	32	25	160	–	0.95	GI003	ND5
MS-EN-3225 PS	32	32	25	174	25	1.00	GI060	ND5

GI003	XLC.. 25..15...	XLC.. 25..25…	GL.BS	XLXFL 25…
GI006	XLCF. 16..15…	XLCF. 16..20…	–	–
GI060	XLC.. 25..15…	XLC.. 25..25…	GL.BS	–

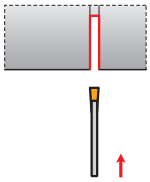
		Nm				Nm			
ND4	US 4011-T15P	3.5	M 4	10.6	–	–	–	–	FLAG T15P
ND5	US 45013-T20P	5.0	M 5	13	US 46017-T20P	5.0	M6	17	FLAG T20P

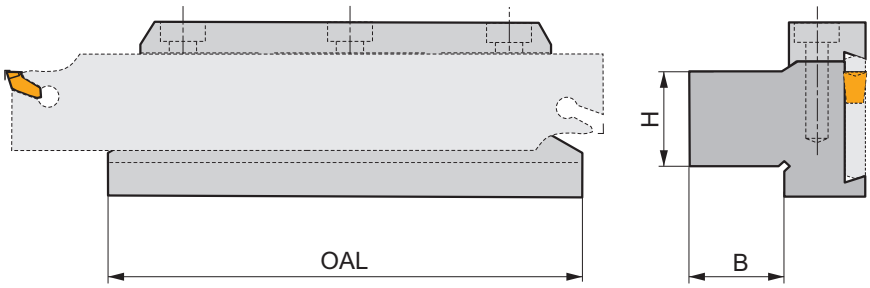
ND4 =3 x US 4011-T15P; ND5=2 x US 45013-T20P

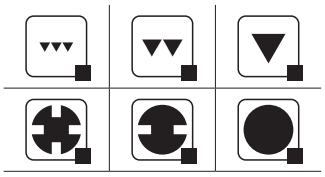
DU, D

PRAMET

用于切槽和切断加工刀板的刀柄
可以安装GL或XLC刀片，用于切断加工的刀板。刀体经过处理，使用寿命更长。







Product	H (mm)	B (mm)	OAL (mm)	kg		
26-DU 2020	20	20	90	0.76	GI007	ND2
26-D 2020	20	20	100	0.82	GI007	ND2
32-DU 2523	25	23	110	1.06	GI008	ND2
32-DU 2532	25	32	110	1.24	GI008	ND2
32-D 2530	25	30	115	1.28	GI008	ND2
32-DU 3229	32	29	110	1.25	GI008	ND2
45-DU 3229	32	29	110	1.50	GI009	ND7
45-DU 4036	40	36	110	2.05	GI009	ND7
47-D 4040	40	40	150	3.84	GI091	ND3

GI007	XLC.N 26..	GL.-S26.B.
GI008	XLC.N 32..	GL.-S32.B.
GI009	XLC.N 45..	–
GI091	XLC.N 47..	–

		Nm			
ND2	HS 0625	6.0	M 6	25	HXK 5
ND3	HS 1030	8.0	M 10	30	HXK 8
ND7	HS 0630	6.0	M 6	30	HXK 5

刀片座	LNMX 3.00	GL3	GL4	GL5	GL6
NEW 端面轴向，右手 20×20 / 32×32		CDX 12 mm	CDX 20 – 25 mm	CDX 25 mm	CDX 25 – 32 mm
NEW 端面轴向，左手 25×25 / 32×32		CDX 12 mm	CDX 20 – 25 mm	CDX 25 mm	CDX 25 – 32 mm
NEW 端面90°，右手 25×25		CDX 15 mm	CDX 20 – 25 mm		
MS刀片					

切削宽度(mm) CW	3.1	3	4	5	6	8
端面切槽	LFMX	GM	GM	GM	GM	GM
端面车削 端面仿形		GM, MM	GM, MM	GM, MM	GM, MM	GM

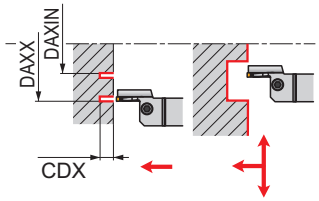
GLSF L-R AXIAL

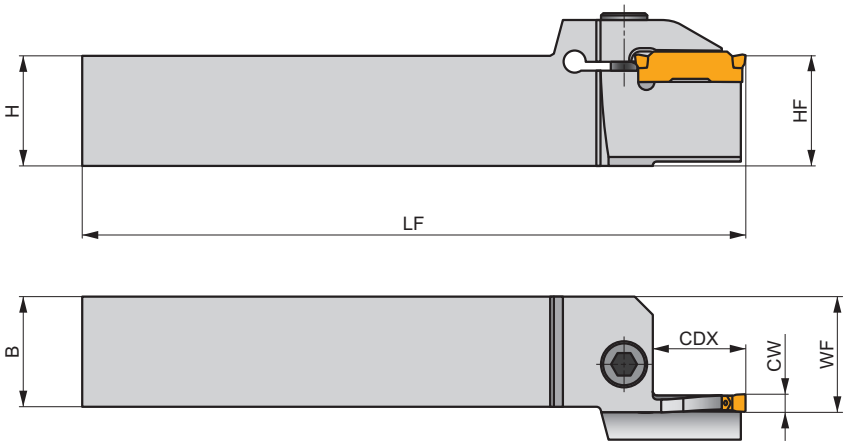
P M K N S H

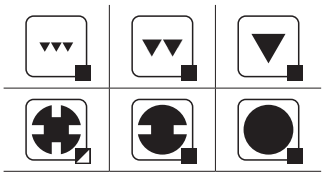
PRAMET

G

轴面切槽加工刀具，用于GL刀片
右旋轴面切槽加工刀柄，用于GL刀片。适用于表面切槽加工、车削和仿形铣应用。刀体经过处理，使用寿命更长。







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg		
L	GL3-S2525MFL-12-R035027	25	25	25	26	150	3.00	12	35	27	0.69	GI361	GL16
	GL3-S2525MFL-15-R044033	25	25	25	26	150	3.00	15	44	33	0.68	GI361	GL16
	GL3-S2525MFL-15-R055040	25	25	25	26	150	3.00	15	55	40	0.68	GI361	GL16
	GL3-S2525MFL-20-R080051	25	25	25	26	150	3.00	20	80	51	0.65	GI361	GL16
	GL3-S2525MFL-25-R110076	25	25	25	26	150	3.00	25	110	76	0.63	GI361	GL16
	GL4-S2525MFL-20-R065050	25	25	25	26	150	4.00	20	65	50	0.71	GI362	GL16
	GL4-S2525MFL-20-R095060	25	25	25	26	150	4.00	20	95	60	0.65	GI362	GL16
	GL4-S2525MFL-25-R160090	25	25	25	26	150	4.00	25	160	90	0.63	GI362	GL16
	GL4-S2525MFL-25-R400150	25	25	25	25.7	150	4.00	25	400	150	0.63	GI362	GL16
	GL4-S2525MFL-25-R950380	25	25	25	25.7	150	4.00	25	950	380	0.63	GI362	GL16
	GL5-S2525MFL-25-R095060	25	25	25	25.3	150	5.00	25	95	60	0.63	GI363	GL16
	GL5-S2525MFL-25-R200090	25	25	25	25.3	150	5.00	25	200	90	0.63	GI363	GL16
	GL5-S2525MFL-25-R950180	25	25	25	25.3	150	5.00	25	950	180	0.63	GI363	GL16
	GL6-S2525MFL-25-R095060	25	25	25	25.4	150	6.00	25	95	60	0.69	GI364	GL16
	GL6-S2525MFL-25-R200090	25	25	25	25.4	150	6.00	25	200	90	0.64	GI364	GL16
	GL6-S2525MFL-25-R950180	25	25	25	25.4	150	6.00	25	950	180	0.64	GI364	GL16
	GL6-S3232PFL-32-R200090	32	32	32	32.4	170	6.00	32	200	90	1.20	GI364	GL17
	GL6-S3232PFL-32-R950180	32	32	32	32.4	170	6.00	32	950	180	1.20	GI364	GL17

GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM
GI363	GL5-GM	GL5-MM
GI364	GL6-GM	GL6-MM

		Nm			
GL16	HS 0620	6.0	M6	20	HXK 5
GL17	HS 0825	8.0	M8	25	HXK 6

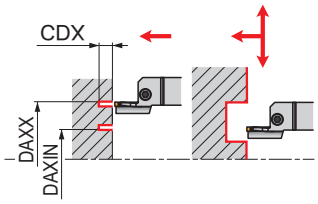
GLSF R-L AXIAL

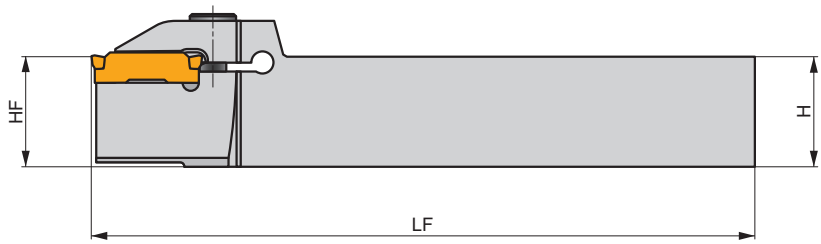
P M K N S H

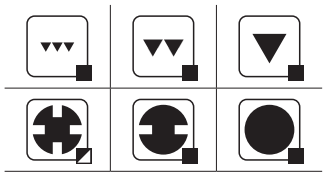
PRAMET

G

轴面切槽加工刀具，用于GL刀片
左旋轴面切槽加工刀柄，用于GL刀片。适用于表面切槽加工、车削和仿形铣应用。刀体经过处理，使用寿命更长。







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg		
R	GL3-S2020KFR-12-L035027	20	20	20	20.5	125	3.00	12	35	27	0.40	GI361	GL16
	GL3-S2020KFR-15-L044033	20	20	20	20.5	125	3.00	15	44	33	0.39	GI361	GL16
	GL3-S2020KFR-15-L055040	20	20	20	20.5	125	3.00	15	55	40	0.39	GI361	GL16
	GL3-S2020KFR-20-L080051	20	20	20	20.5	125	3.00	20	80	51	0.38	GI361	GL16
	GL3-S2525MFR-12-L035027	25	25	25	26	150	3.00	12	35	27	0.69	GI361	GL16
	GL3-S2525MFR-15-L044033	25	25	25	26	150	3.00	15	44	33	0.68	GI361	GL16
	GL3-S2525MFR-15-L055040	25	25	25	26	150	3.00	15	55	40	0.68	GI361	GL16
	GL3-S2525MFR-20-L080051	25	25	25	26	150	3.00	20	80	51	0.65	GI361	GL16
	GL3-S2525MFR-25-L110076	25	25	25	26	150	3.00	25	110	76	0.63	GI361	GL16
	GL4-S2525MFR-20-L065050	25	25	25	26	150	4.00	20	65	50	0.66	GI362	GL16
	GL4-S2525MFR-20-L095060	25	25	25	26	150	4.00	20	95	60	0.65	GI362	GL16
	GL4-S2525MFR-25-L160090	25	25	25	26	150	4.00	25	160	90	0.63	GI362	GL16
	GL4-S2525MFR-25-L400150	25	25	25	25.7	150	4.00	25	400	150	0.63	GI362	GL16
	GL4-S2525MFR-25-L950380	25	25	25	25.7	150	4.00	25	950	380	0.63	GI362	GL16
	GL5-S2525MFR-25-L095060	25	25	25	25.3	150	5.00	25	95	60	0.63	GI363	GL16
	GL5-S2525MFR-25-L200090	25	25	25	25.3	150	5.00	25	200	90	0.63	GI363	GL16
	GL5-S2525MFR-25-L950180	25	25	25	25.3	150	5.00	25	950	180	0.63	GI363	GL16
	GL6-S2525MFR-25-L095060	25	25	25	25.4	150	6.00	25	95	60	0.64	GI364	GL16
	GL6-S2525MFR-25-L200090	25	25	25	25.4	150	6.00	25	200	90	0.64	GI364	GL16
	GL6-S2525MFR-25-L950180	25	25	25	25.4	150	6.00	25	950	180	0.64	GI364	GL16
	GL6-S3232PFR-32-L200090	32	32	32	32.4	170	6.00	32	200	90	1.20	GI364	GL17
	GL6-S3232PFR-32-L950180	32	32	32	32.4	170	6.00	32	950	180	1.21	GI364	GL17

GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM
GI363	GL5-GM	GL5-MM
GI364	GL6-GM	GL6-MM

GL16	HS 0620	6.0	M6	20	HXK 5
GL17	HS 0825	8.0	M8	25	HXK 6

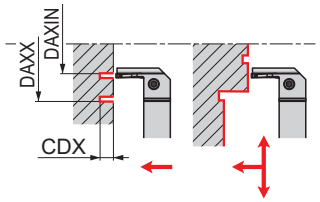
GLSG R-R AXIAL

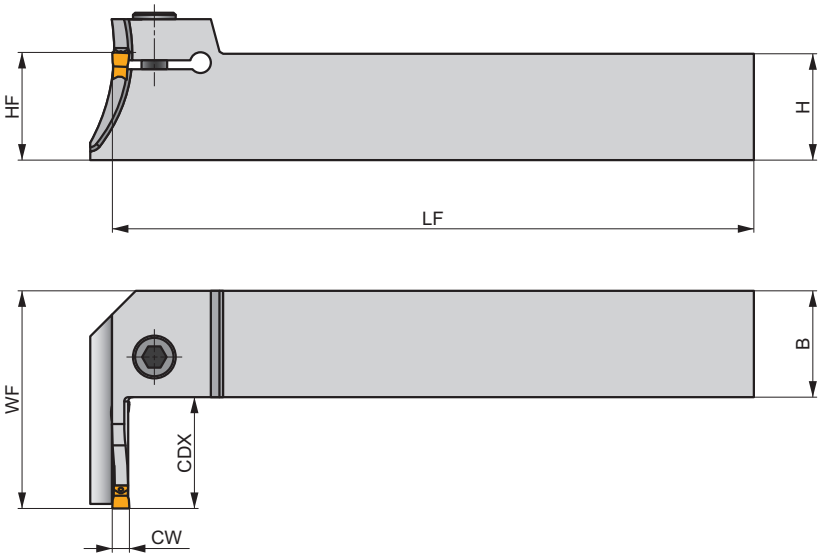
P M K N S H

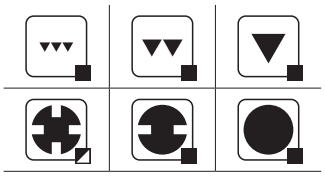
PRAMET

G

径面切槽加工刀具，用于GL刀片
左旋径面切槽加工刀柄，用于GL刀片。适用于表面切槽加工、车削和仿形铣应用。刀体经过处理，使用寿命更长。







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg		
R	GL3-S2525MGR-15-R044033	25	25	25	40.9	150	3.00	15	44	33	0.75	GI361	GL16
	GL3-S2525MGR-15-R055040	25	25	25	40.9	150	3.00	15	55	40	0.75	GI361	GL16
	GL3-S2525MGR-20-R080051	25	25	25	45.9	150	3.00	20	80	51	0.75	GI361	GL16
	GL3-S2525MGR-25-R110076	25	25	25	50.9	150	3.00	25	110	76	0.75	GI361	GL16
	GL4-S2525MGR-20-R065050	25	25	25	46	150	4.00	20	65	50	0.77	GI362	GL16
	GL4-S2525MGR-25-R095060	25	25	25	51	150	4.00	25	95	60	0.76	GI362	GL16
	GL4-S2525MGR-25-R160090	25	25	25	51	150	4.00	25	160	90	0.76	GI362	GL16
	GL4-S2525MGR-25-R400150	25	25	25	51	150	4.00	25	400	150	0.75	GI362	GL16

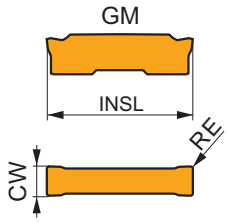
GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM

GL16	HS 0620	6.0	M6	20	HXK 5

GL. D - GM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



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/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)
GL2-D200M02-GM:G8330	⇕	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	●	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330	⇕	0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	●	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330	⇕	0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	●	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330	⇕	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	●	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330	⇕	0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	●	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330	⇕	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330	⇕	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]	⇕	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–

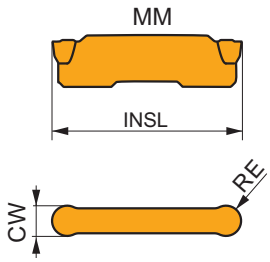
[1] Usable only in holders with CDX ≥ 24.

GM 用途断屑槽，适用于切槽和轴向车削，以及连续至断续切削。

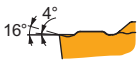
GL. D - MM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0



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/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)
																				
GL2-D200MM0-MM:G8330	⇕	1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	⇕	1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330	⇕	1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	⇕	1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330	⇕	2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	⇕	2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330	⇕	2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	⇕	2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330	⇕	3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	⇕	3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–

MM 屑槽，球头外形，适用于仿形加工和轴向车削，连续至断续切削。

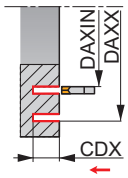
XLXFL BS AXIAL

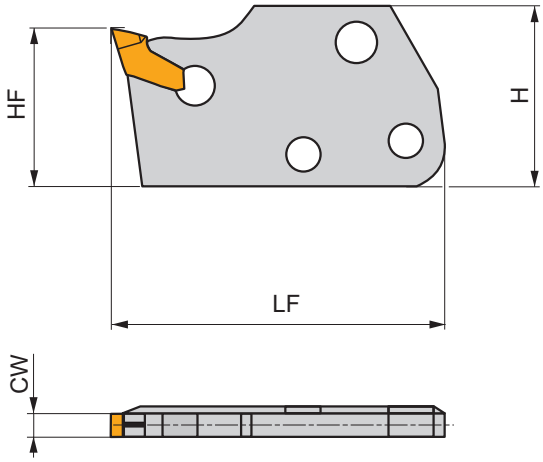
P M K N S H

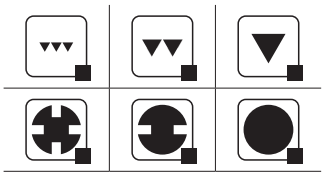
PRAMET

X

模块化MS-EN槽刀杆的端面开槽刀板，使用LFMX刀片。
模块化切槽刀板，切槽加工，使用单面LFMX3.1刀片。适用于端面开槽（最大切削深度为20mm）应用。
可以安装在MS-EN车刀杆上。刀板经过处理，使用寿命更长。







	Product	H (mm)	HF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
L	**XLXFL 250220-3.00-60**	29	24	46	3.10	20	60	85	0.05	GI001	KV
	XLXFL 250220-3.00-80	29	24	46	3.10	20	80	105	0.05	GI001	KV
	XLXFL 250220-3.00-100	29	24	46	3.10	20	100	155	0.03	GI001	KV
	XLXFL 250220-3.00-150	29	24	46	3.10	20	150	280	0.03	GI001	KV

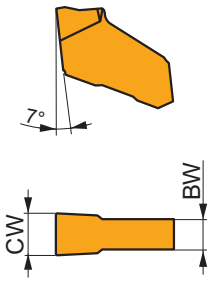
GI001	LFMX 3.1-.

KV	KV 5x70

LFMX - F1

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	BW (mm)
1.5	1.50	-0.03	0.03	1.30
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60



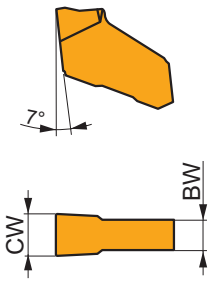
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
F1 eN-屑槽，适用于切断和开槽加工，连续切削。																
LFMX 1.5-.16ENF1:T8330	⬌	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 1.6-.16ENF1:T8330	⬌	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 2.0-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 3.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–

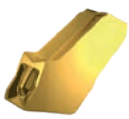
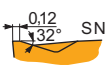
LFMX - F2

PRAMET

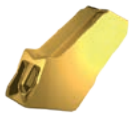
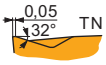
	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	BW (mm)
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



线速度(vc)和进给量(f)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/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
  SN-F2 屑槽，适用于切断和开槽加工，连续切削。																
LFMX 1.6-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNF2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

线速度(vc)和进给量(f)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。

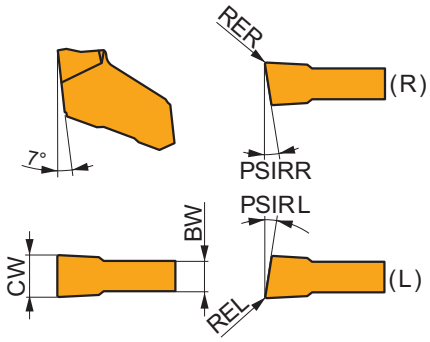
Product	●	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
 																
LFMX 3.1-.20TNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–

TN-F2 屑槽，适用于切断和开槽加工，连续切削。

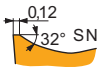
LFMX - M2

PRAMET

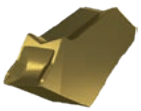
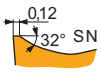
	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	BW (mm)
2.0	2.00	-0.03	0.03	1.60
2.2	2.20	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



线速度(vc)和进给量(f)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。

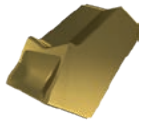
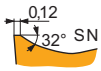
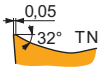
Product	●	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
LFMX 2.0-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:6640	●	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:T8330	●	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:6640	●	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:T8330	●	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–

SN-M2 屑槽，适用于切断和开槽加工，连续至轻微断续切削。

 																
LFMX 2.0-.16SR12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	12	–
LFMX 2.0-.16SR6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	6	–
LFMX 3.1-.20SR8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	8	–
LFMX 4.1-.20SR8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	8	–

SR-M2 屑槽，右手设计，适用于切断，连续切削至轻微断续切削。

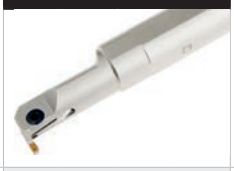
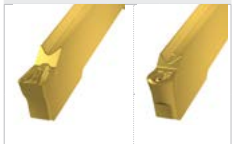
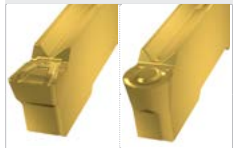
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
 																
LFMX 2.0-.16SL12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	12
LFMX 2.0-.16SL6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	6
LFMX 3.1-.20SL8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	8
LFMX 4.1-.20SL8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	8
																
LFMX 3.1-.20TNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

SL-M2 屑槽，左手设计，适用于切断加工，连续切削至轻微断续切削。

TN-M2 屑槽，适用于切开和开槽加工，连续至轻微断续切削。

切槽镗杆

刀片座	0313	0413	GL2	GL3	GL4
GG.(RL) INT					
GLAG (RL)INT DCON MS = 25 – 40 mm DMIN = 32 mm			CDX 6 – 10 mm	CDX 6 – 12 mm	CDX 6 – 20 mm
切削宽度(mm) CW	3	4	2	3	4
切槽(内冷)	CM F	CM F	GM	GM	GM
车削/仿形(内冷)	F MP	F MP	 GM MM	GM MM	 GM MM

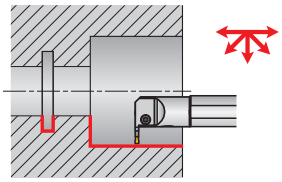
GLAG (RL) INT

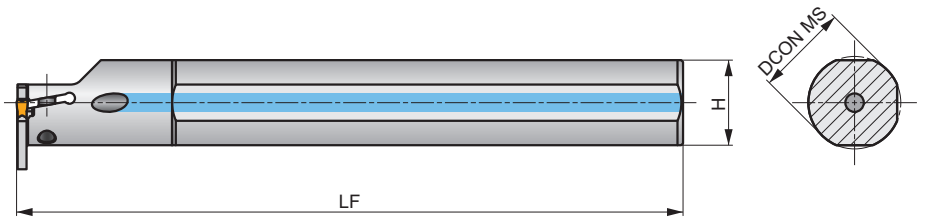
P M K N S H

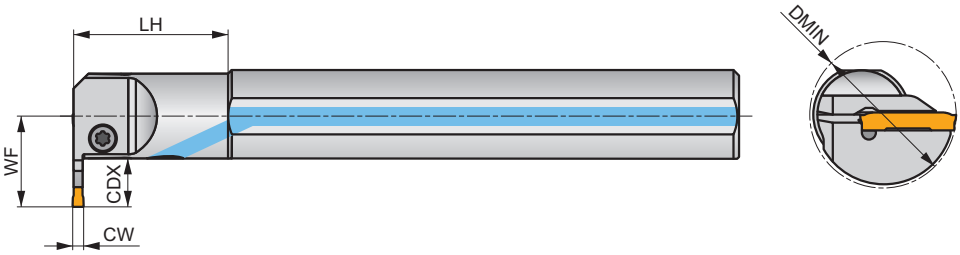
PRAMET

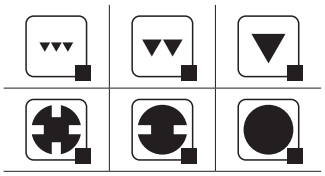
G

内部切槽加工刀具，用于GL刀片
带内冷通道的内部右旋/左旋刀柄，用于GL刀片，设计带有加固的刀座和刀板，以确保安全。适用于内部切槽加工、车削和仿形铣应用。刀体经过处理，使用寿命更长。









	Product	DCON MS (mm)	H (mm)	WF (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		kg		
R	GL2-A25QGR-06-32	25	23	18.5	180	41.2	2.00	6	32	✓	0.57	GI360	GL14
	GL2-A25QGR-10-38	25	23	22.5	180	41.2	2.00	10	38	✓	0.57	GI360	GL14
	GL3-A25QGR-06-32	25	23	18.5	180	42.0	3.00	6	32	✓	0.57	GI361	GL14
	GL3-A25QGR-12-38	25	23	24.5	180	42.0	3.00	12	38	✓	0.58	GI361	GL14
	GL4-A25QGR-06-40	25	23	18.6	180	43.0	4.00	6	40	✓	0.58	GI362	GL14
	GL4-A25QGR-12-40 [1)]	25	23	24.6	180	43.0	4.00	12	40	✓	0.58	GI365	GL14
	GL2-A32SGR-06-40	32	30	22	250	51.2	2.00	6	40	✓	1.38	GI360	GL14
	GL2-A32SGR-10-45	32	30	26	250	51.2	2.00	10	45	✓	1.30	GI360	GL14
	GL3-A32SGR-06-40	32	30	22	250	52.0	3.00	6	40	✓	1.38	GI361	GL14
	GL3-A32SGR-12-45	32	30	28	250	52.0	3.00	12	45	✓	1.30	GI361	GL14
	GL4-A32SGR-06-40	32	30	22.1	250	53.0	4.00	6	40	✓	1.39	GI362	GL14
	GL4-A32SGR-12-45 [1)]	32	30	28.1	250	53.0	4.00	12	45	✓	1.39	GI365	GL14
	GL3-A40TGR-12-54	40	38	32	300	52.0	3.00	12	54	✓	2.69	GI361	GL14
	GL4-A40TGR-12-56 [1)]	40	38	32.1	300	53.0	4.00	12	56	✓	2.60	GI365	GL14
	GL4-A40TGR-20-62 [1)]	40	38	40.1	300	53.0	4.00	20	62	✓	2.70	GI365	GL14
L	GL2-A25QGL-06-32	25	23	18.5	180	41.2	2.00	6	32	✓	0.57	GI360	GL14
	GL2-A25QGL-10-38	25	23	22.5	180	41.2	2.00	10	38	✓	0.57	GI360	GL14
	GL3-A25QGL-06-32	25	23	18.5	180	42.0	3.00	6	32	✓	0.57	GI361	GL14
	GL3-A25QGL-12-38	25	23	24.5	180	42.0	3.00	12	38	✓	0.58	GI361	GL14
	GL4-A25QGL-06-40	25	23	18.6	180	43.0	4.00	6	40	✓	0.58	GI362	GL14
	GL4-A25QGL-12-40 [1)]	25	23	24.6	180	43.0	4.00	12	40	✓	0.58	GI365	GL14
	GL2-A32SGL-06-40	32	30	22	250	51.2	2.00	6	40	✓	1.38	GI360	GL14
	GL2-A32SGL-10-45	32	30	26	250	51.2	2.00	10	45	✓	1.38	GI360	GL14
	GL3-A32SGL-06-40	32	30	22	250	52.0	3.00	6	40	✓	1.30	GI361	GL14
	GL3-A32SGL-12-45	32	30	28	250	52.0	3.00	12	45	✓	1.38	GI361	GL14
	GL4-A32SGL-06-40	32	30	22.1	250	53.0	4.00	6	40	✓	1.39	GI362	GL14
	GL4-A32SGL-12-45 [1)]	32	30	28.1	250	53.0	4.00	12	45	✓	1.30	GI365	GL14

	Product	DCON MS (mm)	H (mm)	WF (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		kg		
L	**GL3-A40TGL-12-54**	40	38	32	300	52.0	3.00	12	54	✓	2.60	GI361	GL14
	GL4-A40TGL-12-56 [1]	40	38	32.1	300	53.0	4.00	12	56	✓	2.70	GI365	GL14
	GL4-A40TGL-20-62 [1]	40	38	40.1	300	53.0	4.00	20	62	✓	2.70	GI365	GL14

[1] 只有当 DMIN >= 68 毫米时，才适用 MM 几何尺寸。

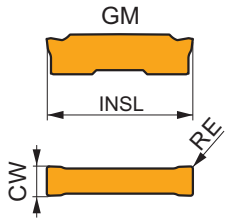
GI360	GL2-GM	GL2-MM
GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM

		Nm			
GL14	US 5015-T20P	5.0	M 5	15	LK T20P

GL. D - GM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



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/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)
GL2-D200M02-GM:G8330	⇕	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	●	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330	⇕	0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	●	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330	⇕	0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	●	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330	⇕	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	●	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330	⇕	0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	●	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330	⇕	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330	⇕	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	●	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]	⇕	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–

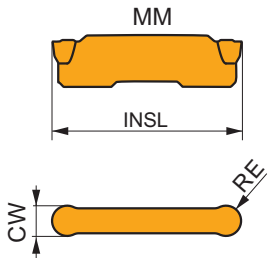
[1] Usable only in holders with CDX ≥ 24.

GM 用途断屑槽，适用于切槽和轴向车削，以及连续至断续切削。

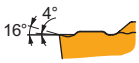
GL. D - MM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0



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/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)
																				
GL2-D200MM0-MM:G8330	⇕	1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	⇕	1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330	⇕	1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	⇕	1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330	⇕	2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	⇕	2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330	⇕	2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	⇕	2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330	⇕	3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	⇕	3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–

MM 屑槽，球头外形，适用于仿形加工和轴向车削，连续至断续切削。

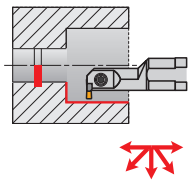
GG.(RL) INT

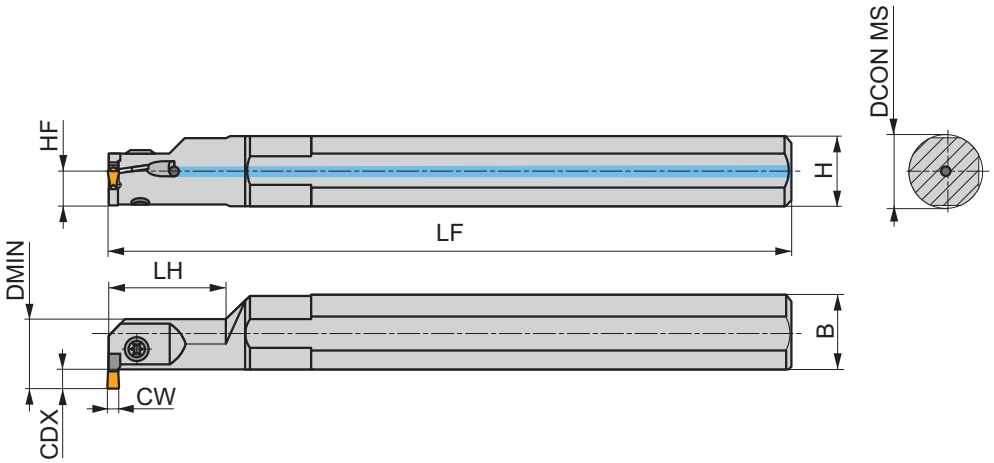
P M K N S H

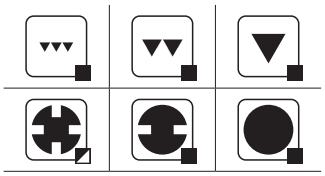
PRAMET

G

内孔开槽镗杆，使用LCM..刀片。
内孔左/右手切槽镗杆，切槽加工，使用用LCM.刀片。适用于内孔切槽和仿形车削。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		kg		
R	A16Q-GGER 0313	16	7.5	15	15.5	180	25.0	3.00	3	16	✓	0.26	GI143	GL06
	A20R-GGFR 0313	20	9	18	19	200	30.0	3.00	4.5	20	✓	0.38	GI143	GL06
	A25S-GGHR 0313	25	11.5	23	24	250	40.0	3.00	6.5	25	✓	0.78	GI143	GL06
	A25S-GGFR 0413	25	11.5	23	24	250	40.0	4.00	6.5	25	✓	0.78	GI170	GL06
L	A16Q-GGEL 0313	16	7.5	15	15.5	180	25.0	3.00	3	16	✓	0.27	GI143	GL06
	A20R-GGFL 0313	20	9	18	19	200	30.0	3.00	4.5	20	✓	0.38	GI143	GL06
	A25S-GGHL 0313	25	11.5	23	24	250	40.0	3.00	6.5	25	✓	0.78	GI143	GL06

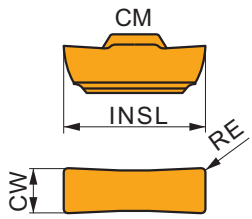
GI143	LCM. 0313..
GI170	LCM. 0413..

GL06	SR 85011-T15P	5.0	M 5	9	FLAG T15P

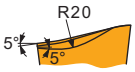
LCMF 13 - CM

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



线速度(vc)和进给量(f)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。

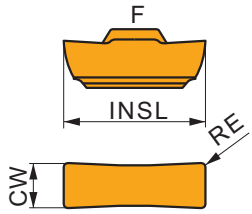
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
															
LCMF 031304-CM:T8330	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 041304-CM:T8330	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–

CM 屑槽，开槽的首选。

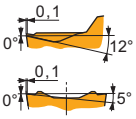
LCMF 13 - F

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



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。

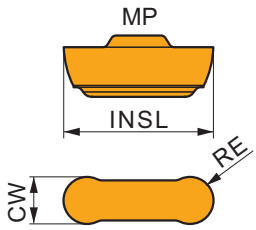
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																			
LCMF 031302-F:T8330	0.2	195	0.10	0.3	115	0.09	0.3	185	0.10	0.3	–	–	–	–	–	–	–	–	–
LCMF 031304-F:T8330	0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMF 041304-F:T8330	0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–

F 屑槽，车削的首选。

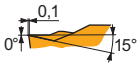
LCMF 13 - MP

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6

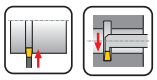
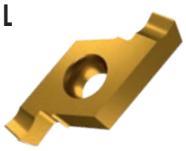
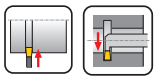


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	P f (mm/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)
																				
LCMF 0313M0-MP:T8330		1.5	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMF 0413M0-MP:T8330		2.0	175	0.40	1.0	105	0.36	1.0	165	0.40	1.0	–	–	–	–	–	–	–	–	–

MP 屑槽，适用于轴向车削和仿形，超精加工和精加工，连续至断续切削。

O 形圈和卡环开槽

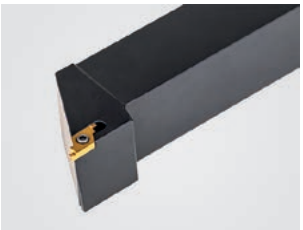
	外部冷却		内部冷却			
P61(RL) EXT 16x16 20x20 25x25	R	L				
P61(RL) INT DCON MS = 12 – 32 mm DMIN = 16 – 40 mm			R	L		
P61S(RL)-1 INT DCON MS = 10 – 12 mm DMIN = 12.5 mm					R	L
为卡簧开槽 	R **X61** CW = 0,85 – 3,2	L **X61** CW = 0,85 – 3,2	L  **X61** CW=0,85 – 3,2	R **X61** CW =0,85 – 3,2	L **X61-1** CW=0,85 – 2,2	R **X61-1** CW=0,85 – 2,2
O 形圈开槽 	R **X61 R** RE = 1 – 1.5	L **X61 R** RE = 1 – 1.5	L **X61 R** RE = 1 – 1.5	R **X61 R** RE = 1 – 1.5	L **X61 R-1** RE = 0.5 – 1	R **X61 R-1** RE = 0.5–1

P61(RL) EXT

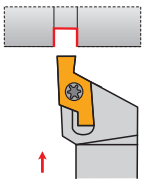
P M K N S

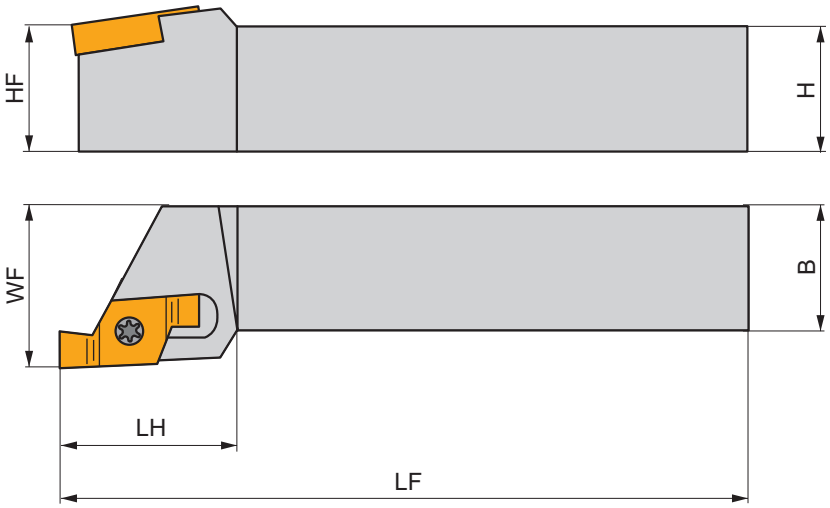
PRAMET

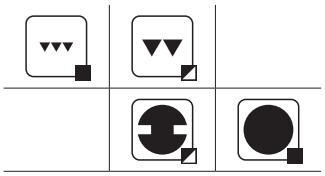
S



外圆用开槽车刀杆,使用X61卡簧槽和O型圈刀片
外圆用左/右手径向车刀杆，开槽加工。使用X61双面卡簧槽或O形圈刀片进行开槽。可提供高公差尺寸的平滑切削动作。可提供16x16至25x25mm的刀柄。刀杆经过处理，使用寿命更长。







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	kg		
R	**P61.SFR-1616H-06**	16	16	16	20	100	21.0	0.23	GI332_1	SV11
	P61.SFR-2020K-06	20	20	20	25	125	25.0	0.40	GI332_1	SV11
	P61.SFR-2525M-06	25	25	25	32	150	32.0	0.72	GI332_1	SV11
L	**P61.SFL-1616H-06**	16	16	16	20	100	21.0	0.22	GI332_2	SV11
	P61.SFL-2020K-06	20	20	20	25	125	25.0	0.41	GI332_2	SV11
	P61.SFL-2525M-06	25	25	25	32	150	32.0	0.73	GI332_2	SV11

GI332_1	X61 0602.. R

		Nm			
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

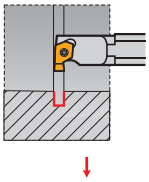
P61(RL) INT

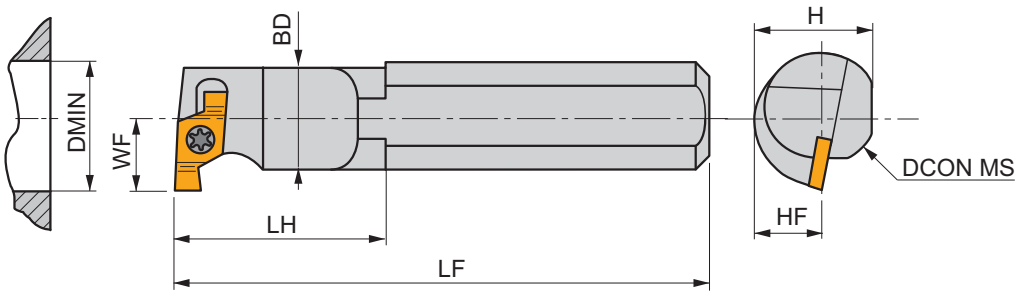
P M K N S

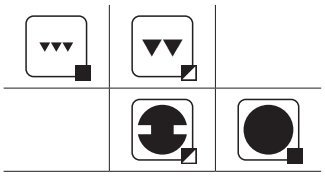
PRAMET

S

内孔卡簧槽刀杆,使用X61刀片。
内孔用左/右手切槽镗杆，切槽加工，使用X61双面刀片。适用于内孔卡簧槽或O-形圈槽。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	KAPR (°)		kg		
R	**P61.SGR-0012M-06**	12	16	11.5	9	11	150	22.0	0	–	0.16	GI332_2	SV11
	P61.SGR-A-0016M-06	16	20	15	11	15	150	29.0	0	✓	0.23	GI332_2	SV11
	P61.SGR-A-0020P-06	20	25	19	13	18	170	29.0	0	✓	0.38	GI332_2	SV11
	P61.SGR-A-0025R-06	25	32	24	17	23	200	31.0	0	✓	0.70	GI332_2	SV11
	P61.SGR-A-0032T-06	32	40	31	22	30	300	49.0	0	✓	1.72	GI332_2	SV11
L	**P61.SGL-0012M-06**	12	16	11.5	9	11	150	22.0	0	–	0.16	GI332_1	SV11
	P61.SGL-A-0016M-06	16	20	15	11	15	150	29.0	0	✓	0.23	GI332_1	SV11
	P61.SGL-A-0020P-06	20	25	19	13	18	170	29.0	0	✓	0.39	GI332_1	SV11
	P61.SGL-A-0025R-06	25	32	24	17	23	200	31.0	0	✓	0.71	GI332_1	SV11
	P61.SGL-A-0032T-06	32	40	31	22	30	300	49.0	0	✓	1.72	GI332_1	SV11

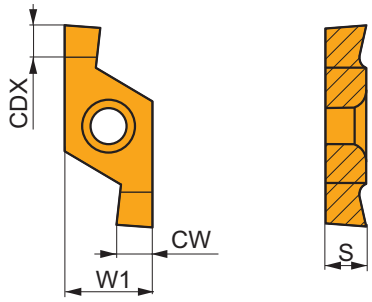
		Nm			
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

左手刀片安装到右手镗杆

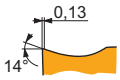
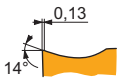
X 61

PRAMET

	W1	CWTOLL	CWTOLU	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33

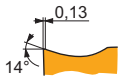


线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE	P		M		K		N		S		H		CW	CDX
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)
																
X61-R 外圆和内孔，右手断屑槽，适用于O形圈和卡簧槽加工，可连续切削。																
X61 0602-080 R:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-080 R:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 R:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-090 R:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-100 R:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-100 R:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-110 R:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-110 R:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 R:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-130 R:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-150 R:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-150 R:G8330	●	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-160 R:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-160 R:G8330	●	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 R:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-185 R:G8330	●	–	120	0.09	70	0.08	110	0.09	–	–	–	–	–	–	1.90	2
X61 0602-200 R:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.05	2.2
X61 0602-215 R:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-215 R:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-250 R:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.55	2.6
X61 0602-265 R:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-265 R:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-300 R:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.05	3
X61 0602-300 R:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.05	3
X61 0602-315 R:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.20	3
X61 0602-315 R:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.20	3
																
X61-L 外圆和内孔，左手断屑槽，适用于O形圈和卡簧槽加工，可连续切削。																
X61 0602-080 L:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-080 L:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 L:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-090 L:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-100 L:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-100 L:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-110 L:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-110 L:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 L:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-130 L:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.35	1.4

线速度(vc)和进给量(f)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/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CDX (mm)
X61 0602-150 L:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-150 L:G8330	●	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-160 L:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-160 L:G8330	●	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 L:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-185 L:G8330	●	–	120	0.09	70	0.08	110	0.09	–	–	–	–	–	–	1.90	2
X61 0602-200 L:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.05	2.2
X61 0602-215 L:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-215 L:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-250 L:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.55	2.6
X61 0602-265 L:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-265 L:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-300 L:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.05	3
X61 0602-300 L:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.05	3
X61 0602-315 L:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.20	3
X61 0602-315 L:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.20	3

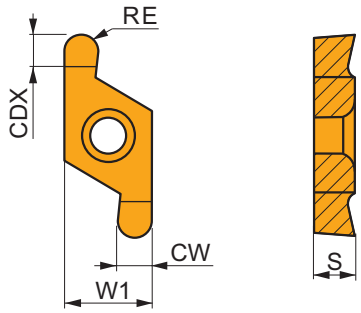


X61-L 外圆和内孔，左手断屑槽，适用于O形圈和卡簧槽加工，可连续切削。

X 61 R

PRAMET

	W1 (mm)	CWTOLL (mm)	CWTOLU (mm)	S (mm)
0602	6.350	-0.03	0.03	2.33



线速度(vc)和进给量(f)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/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CDX (mm)
X61 0602-R100 R:6640	●	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R100 R:G8330	●	1.0	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R150 R:6640	●	1.5	175	0.06	105	0.05	165	0.06	–	–	–	–	–	–	3.09	3
X61 0602-R150 R:G8330	●	1.5	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	3.09	3

X61R-R 外圆和内孔，右手断屑槽，适用于O形圈和卡簧槽加工，可连续切削。

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CDX (mm)
X61 0602-R100 L:6640	●	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R100 L:G8330	●	1.0	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R150 L:6640	●	1.5	175	0.06	105	0.05	165	0.06	–	–	–	–	–	–	3.09	3
X61 0602-R150 L:G8330	●	1.5	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	3.09	3

X61R-L 外圆和内孔，左手断屑槽，适用于O形圈和卡簧槽加工，可连续切削。

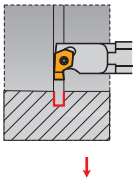
P61S(RL)-1 INT

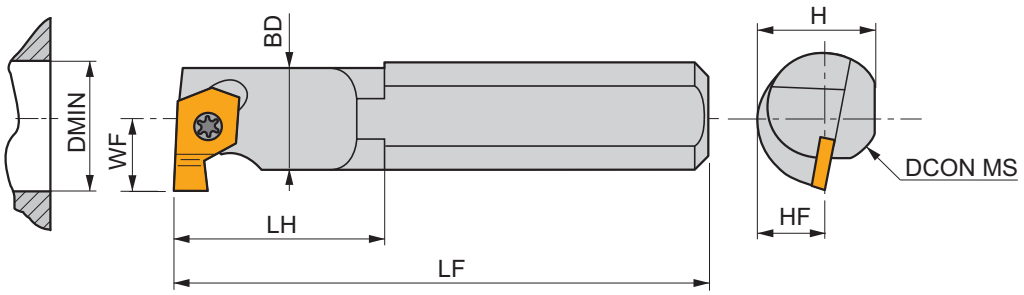
P M K N S

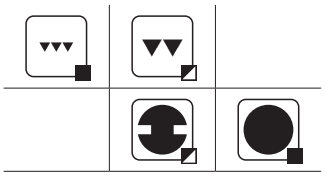
PRAMET

S

内孔卡簧槽刀杆,使用X61-1刀片。
内孔左/右手切槽镗杆，切槽加工，使用单面X61-1刀片。适用于内孔卡簧槽或O-形圈槽。刀杆经过处理，使用寿命更长。







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	KAPR (°)	kg		
R	**P61.SGR-0010M-06/1**	10	12.5	10	7.5	9	150	19.0	0	0.12	GI333_2	SV11
R	**P61.SGR-0012M-06/1**	12	12.5	10	7.5	11	150	19.0	0	0.16	GI333_2	SV11
L	**P61.SGL-0010M-06/1**	10	12.5	10	7.5	9	150	19.0	0	0.12	GI333_1	SV11
L	**P61.SGL-0012M-06/1**	12	12.5	10	7.5	11	150	19.0	0	0.16	GI333_1	SV11

GI333_1	X61 0602..-1 R

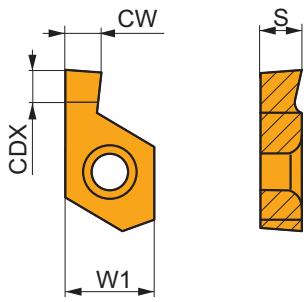
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

左手刀片安装到右手镗杆

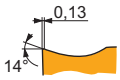
X 61-1

PRAMET

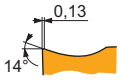
	W1	CWTOLL	CWTOLU	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33



线速度(vc)和进给量(f)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	P		M		K		N		S		H		CW	CDX
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)
																
X61 0602-080 R1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 R1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-110 R1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 R1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-160 R1:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 R1:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-215 R1:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.2

X61-1-R 内孔，右手设计，具有一个用于O形圈和卡簧槽加工的切削刃，可连续切削。

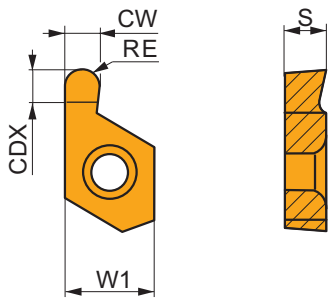
																
X61 0602-080 L1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 L1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-110 L1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 L1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-160 L1:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 L1:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-215 L1:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.2

X61-1-L 内孔，左手设计，具有一个用于O形圈和卡簧槽加工的切削刃，可连续切削。

X 61 R-1

PRAMET

	W1 (mm)	CWTOLL (mm)	CWTOLU (mm)	S (mm)
0602	6.350	-0.03	0.03	2.33



线速度(vc)和进给量(f)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/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CDX (mm)
X61 0602-R050 R1:6640	●	0.5	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.09	1.3
X61 0602-R100 R1:6640	●	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	2.8

X61R-1-R 内孔，右手设计，具有一个用于O形圈和卡簧槽加工的切削刃，可连续切削。

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CDX (mm)
X61 0602-R050 L1:6640	●	0.5	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.09	1.3
X61 0602-R100 L1:6640	●	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	2.8

X61R-1-L 内孔，左手设计，具有一个用于O形圈和卡簧槽加工的切削刃，可连续切削。

螺纹车削

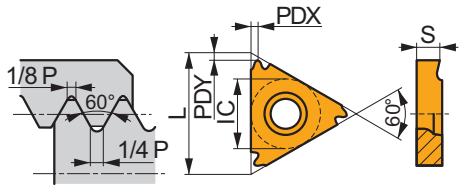
	全牙型				非全牙型			
	外圆		内孔		外圆		内孔	
经济型 -P1 (压制刀片)	M	60°	M	60°	60°-PP	60°	60°-PP	60°
	UN	60°	UN	60°	55°-PP	55°	55°-PP	55°
	W	55°	W	55°				
	NPT	60°	NPT	60°				
精密型 (磨制刀片)	M	60°	M	60°	60°-PP	60°	60°-PP	60°
	M-AL	60°	M-AL	60°				
	UN	60°	UN	60°				
	W	55°	W	55°	55°-PP	55°	55°-PP	55°
	TR-S	30°	TR-S	30°	M-S PP	60°	M-S PP	60°

	FULL PROFILE							
	外圆		内孔		外圆		内孔	
精密型 (磨制刀片)	TR	30°	TR	30°	ACME	29°	ACME	29°
							STACME	29°
	BSPT	55°	BSPT	55°	NPT	60°	NPT	60°
	RD	30°	RD	30°	API RD	60°	API RD	60°

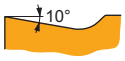
TN M EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



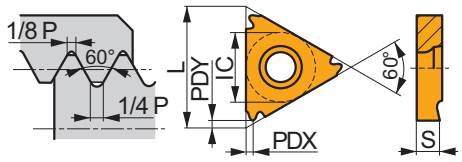
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN M-P1 ER 压制型外螺纹刀片，右手设计，适用于加工ISO公制螺纹，连续切削。												
TN 16ER100M-P1:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16ER125M-P1:T8030	●	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16ER150M-P1:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16ER175M-P1:T8030	●	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16ER200M-P1:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16ER250M-P1:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16ER300M-P1:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2

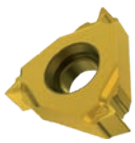
TN M INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



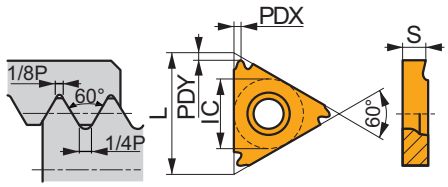
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN M-P1 NR压制型内螺纹刀片，右手设计，适用于加工ISO公制螺纹，连续切削。												
TN 11NR100M-P1:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 11NR150M-P1:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 11NR200M-P1:T8030	●	–	160	95	150	480	40	–	2.00	–	–	–
TN 16NR100M-P1:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16NR150M-P1:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16NR200M-P1:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16NR250M-P1:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16NR300M-P1:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2

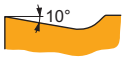
TN UN EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



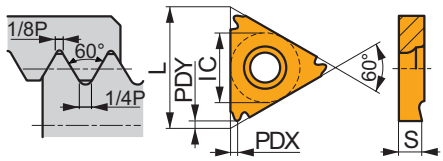
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
									TN UN-P1 ER压制型外螺纹刀片，右手设计，适用于加工美标螺纹，连续切削。			
TN 16ER200UN-P1:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16ER180UN-P1:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16ER160UN-P1:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16ER140UN-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER120UN-P1:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2

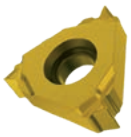
TN UN INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



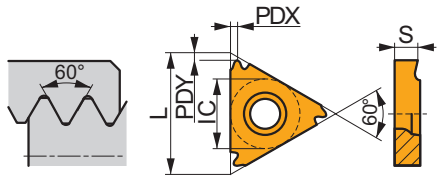
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
									TN UN-P1 NR压制型内螺纹刀片，右手设计，适用于加工美标螺纹，连续切削。			
TN 16NR200UN-P1:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16NR180UN-P1:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16NR160UN-P1:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16NR140UN-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR120UN-P1:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2

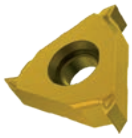
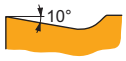
TN 60° PP EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



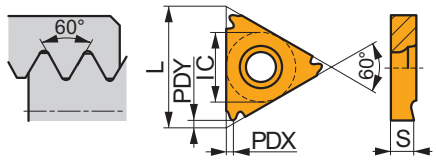
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
 														
TN M60-P1 PP ER 按下外圆，右手设计，适用于加工公制和美标螺纹，连续切削。														
TN 16ERA60-P1:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16ERAG60-P1:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERG60-P1:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.2

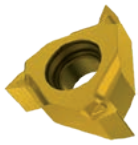
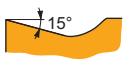
TN 60° PP INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



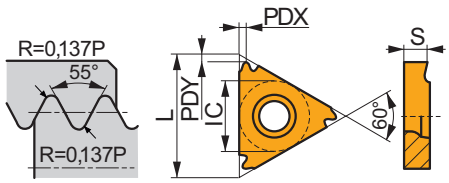
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
 														
TN M60-P1 PP NR 按下内孔，右手设计，适用于加工公制和美标螺纹，连续切削。														
TN 11NRA60-P1:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.7
TN 16NRAG60-P1:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRG60-P1:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.2

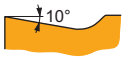
TN W EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



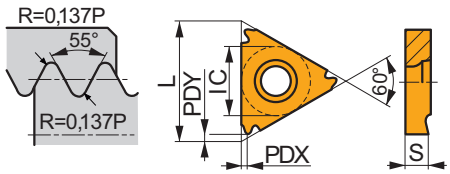
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
									TN W-P1 ER压制外圆，右手设计，适用于加工惠氏螺纹，连续切削。			
TN 16ER190W-P1:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16ER140W-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER110W-P1:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

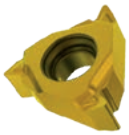
TN W INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



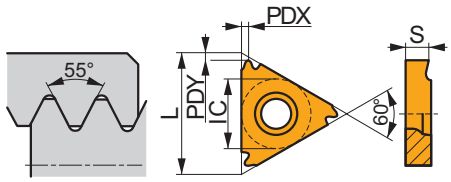
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
									TN W-P1 NR压制内孔，右手设计，适用于加工惠氏螺纹，连续切削。			
TN 11NR190W-P1:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 11NR140W-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	0.9	0.7
TN 16NR140W-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR110W-P1:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

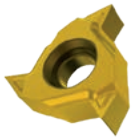
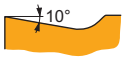
TN 55° PP EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



线速度(vc)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。

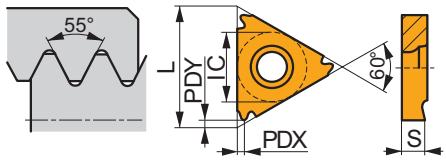
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
TN 16ERAG55-P1:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	–	–
TN 16ERG55-P1:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	–	–

TN W55-P1 PP ER 按下 外圆，右手设计，适用于加工惠氏螺纹，连续切削。

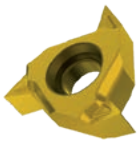
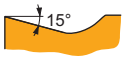
TN 55° PP INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



线速度(vc)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。

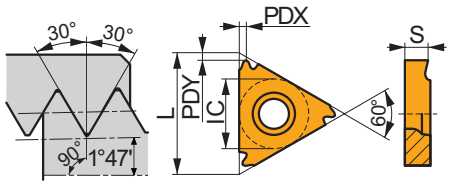
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
TN 16NRAG55-P1:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	–	–

TN W55-P1 PP NR 按下内孔，右手设计，适用于加工惠氏螺纹，连续切削。

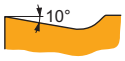
TN NPT EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



线速度(vc)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。

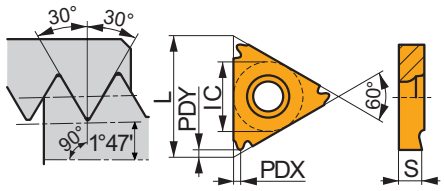
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 16ER115NPT-P1:T8030	●	–	160	95	150	480	40	–	–	11.5	–	–

TN NPT-P1 ER 按下 外圆，右手设计，适用于加工NPT螺纹，连续切削。

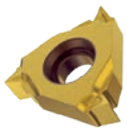
TN NPT INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



线速度(vc)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。

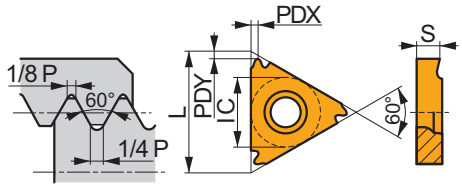
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 16NR115NPT-P1:T8030	●	–	160	95	150	480	40	–	–	11.5	–	–

TN NPT-P1 NR 按下 内孔，右手设计，适用于加工NPT螺纹，连续切削。

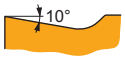
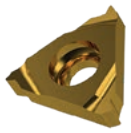
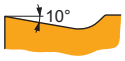
TN M EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



线速度(vc)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。

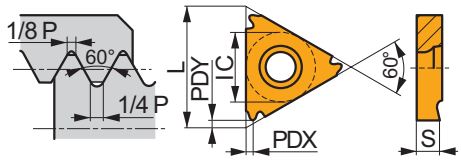
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
			TN M ER外圆，右手设计，适用于加工ISO公制螺纹，连续切削。									
TN 16ER050M:T8010	●	–	175	105	165	–	40	–	0.50	–	0.8	0.8
TN 16ER050M:T8030	●	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 16ER075M:T8010	●	–	175	105	165	–	40	–	0.75	–	0.8	0.8
TN 16ER075M:T8030	●	–	160	95	150	480	40	–	0.75	–	0.8	0.8
TN 16ER080M:T8030	●	–	160	95	150	480	40	–	0.80	–	0.6	0.8
TN 16ER100M:T8010	●	–	175	105	165	–	40	–	1.00	–	0.8	0.8
TN 16ER100M:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16ER125M:T8010	●	–	175	105	165	–	40	–	1.25	–	0.8	0.8
TN 16ER125M:T8030	●	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16ER150M:T8010	●	–	175	105	165	–	40	–	1.50	–	0.8	0.8
TN 16ER150M:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16ER175M:T8010	●	–	175	105	165	–	40	–	1.75	–	1.5	1.2
TN 16ER175M:T8030	●	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16ER200M:T8010	●	–	175	105	165	–	40	–	2.00	–	1.5	1.2
TN 16ER200M:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16ER250M:T8010	●	–	175	105	165	–	40	–	2.50	–	1.5	1.2
TN 16ER250M:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16ER300M:T8010	●	–	175	105	165	–	40	–	3.00	–	1.5	1.2
TN 16ER300M:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2
TN 16ER350M:T8030[1]	●	–	160	95	150	480	40	–	3.50	–	1.7	1.2
TN 22ER350M:T8030	●	–	160	95	150	480	40	–	3.50	–	2.5	1.8
TN 22ER400M:T8010	●	–	175	105	165	–	40	–	4.00	–	2.5	1.8
TN 22ER400M:T8030	●	–	160	95	150	480	40	–	4.00	–	2.5	1.8
TN 22ER450M:T8030	●	–	160	95	150	480	40	–	4.50	–	2.5	1.8
TN 22ER500M:T8030	●	–	160	95	150	480	40	–	5.00	–	2.5	1.8
			TN M EL外圆，左手设计，适用于加工ISO公制螺纹，连续切削。									
TN 16EL050M:T8030	●	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 16EL075M:T8030	●	–	160	95	150	480	40	–	0.75	–	0.8	0.8
TN 16EL080M:T8030	●	–	160	95	150	480	40	–	0.80	–	0.6	0.8
TN 16EL100M:T8010	●	–	175	105	165	–	40	–	1.00	–	0.8	0.8
TN 16EL100M:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16EL125M:T8030	●	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16EL150M:T8010	●	–	175	105	165	–	40	–	1.50	–	0.8	0.8
TN 16EL150M:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16EL175M:T8030	●	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16EL200M:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16EL250M:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16EL300M:T8010	●	–	175	105	165	–	40	–	3.00	–	1.5	1.2
TN 16EL300M:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2
TN 22EL350M:T8030	●	–	160	95	150	480	40	–	3.50	–	2.5	1.8
TN 22EL400M:T8030	●	–	160	95	150	480	40	–	4.00	–	2.5	1.8
TN 22EL450M:T8030	●	–	160	95	150	480	40	–	4.50	–	2.5	1.8

[1] Toolholders have to be modified.

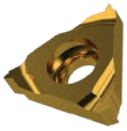
TN M INT

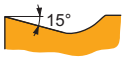
PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



线速度(vc)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。

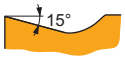




TN M NR内孔，右手设计，适用于加工ISO公制螺纹，连续切削。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
TN 11NR050M:T8030	●	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 11NR075M:T8010	●	–	175	105	165	–	40	–	0.75	–	0.8	0.8
TN 11NR075M:T8030	●	–	160	95	150	480	40	–	0.75	–	0.8	0.8
TN 11NR100M:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 11NR125M:T8030	●	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 11NR150M:T8010	●	–	175	105	165	–	40	–	1.50	–	0.8	0.8
TN 11NR150M:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 11NR200M:T8010	●	–	175	105	165	–	40	–	2.00	–	0.9	0.8
TN 11NR200M:T8030	●	–	160	95	150	480	40	–	2.00	–	0.9	0.8
TN 16NR050M:T8030	●	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 16NR075M:T8030	●	–	160	95	150	480	40	–	0.75	–	0.8	0.8
TN 16NR100M:T8010	●	–	175	105	165	–	40	–	1.00	–	0.8	0.8
TN 16NR100M:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16NR125M:T8030	●	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16NR150M:T8010	●	–	175	105	165	–	40	–	1.50	–	0.8	0.8
TN 16NR150M:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16NR175M:T8030	●	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16NR200M:T8010	●	–	175	105	165	–	40	–	2.00	–	1.5	1.2
TN 16NR200M:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16NR250M:T8010	●	–	175	105	165	–	40	–	2.50	–	1.5	1.2
TN 16NR250M:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16NR300M:T8010	●	–	175	105	165	–	40	–	3.00	–	1.5	1.2
TN 16NR300M:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2
TN 16NR350M:T8030[1)]	●	–	160	95	150	480	40	–	3.50	–	1.6	1.2
TN 22NR350M:T8030	●	–	160	95	150	480	40	–	3.50	–	2.5	1.8
TN 22NR400M:T8010	●	–	175	105	165	–	40	–	4.00	–	2.5	1.8
TN 22NR400M:T8030	●	–	160	95	150	480	40	–	4.00	–	2.5	1.8
TN 22NR450M:T8010	●	–	175	105	165	–	40	–	4.50	–	2.5	1.8
TN 22NR450M:T8030	●	–	160	95	150	480	40	–	4.50	–	2.5	1.8
TN 22NR500M:T8010	●	–	175	105	165	–	40	–	5.00	–	2.5	1.8
TN 22NR500M:T8030	●	–	160	95	150	480	40	–	5.00	–	2.5	1.8

线速度(vc)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。



TN M NL内孔，左手设计，适用于加工ISO公制螺纹，连续切削。

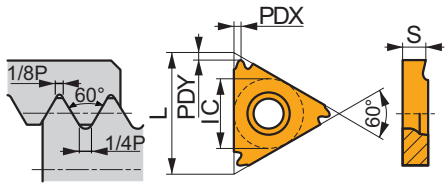
Product	●	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
TN 11NL050M:T8030	●	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 11NL100M:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 11NL150M:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 11NL200M:T8030	●	–	160	95	150	480	40	–	2.00	–	0.9	0.8
TN 16NL100M:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16NL125M:T8030	●	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16NL150M:T8010	●	–	175	105	165	–	40	–	1.50	–	0.8	0.8
TN 16NL150M:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16NL175M:T8030	●	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16NL200M:T8010	●	–	175	105	165	–	40	–	2.00	–	1.5	1.2
TN 16NL200M:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16NL250M:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16NL300M:T8010	●	–	175	105	165	–	40	–	3.00	–	1.5	1.2
TN 16NL300M:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2
TN 22NL350M:T8030	●	–	160	95	150	480	40	–	3.50	–	2.5	1.8
TN 22NL400M:T8030	●	–	160	95	150	480	40	–	4.00	–	2.5	1.8

[1] Toolholders have to be modified.

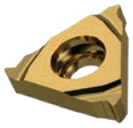
TN UN EXT

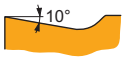
PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



线速度(vc)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。

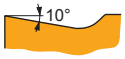




TN UN ER外圆，右手设计，适用于加工美标螺纹，连续切削。

Product	●	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
TN 16ER320UN:T8030	●	–	160	95	150	480	40	–	–	32.0	0.8	0.8
TN 16ER280UN:T8030	●	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16ER240UN:T8030	●	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16ER200UN:T8010	●	–	175	105	165	–	40	–	–	20.0	0.8	0.8
TN 16ER200UN:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16ER180UN:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16ER160UN:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16ER140UN:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER130UN:T8030	●	–	160	95	150	480	40	–	–	13.0	1.5	1.2
TN 16ER120UN:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16ER110UN:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16ER100UN:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16ER090UN:T8030	●	–	160	95	150	480	40	–	–	9.0	1.5	1.2
TN 16ER080UN:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22ER070UN:T8030	●	–	160	95	150	480	40	–	–	7.0	2.5	1.8
TN 22ER060UN:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8

线速度(vc)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。



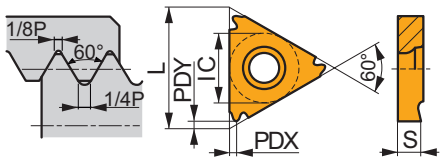
TN UN EL外圆，左手设计，适用于加工美标螺纹，连续切削。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
TN 16EL200UN:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16EL120UN:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16EL100UN:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2

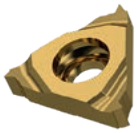
TN UN INT

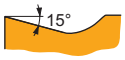
PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



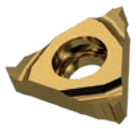
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。





TN UN NR内孔，右手设计，适用于加工美标螺纹，连续切削。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
TN 16NR200UN:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16NR180UN:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16NR160UN:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16NR140UN:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR120UN:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NR110UN:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16NR100UN:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NR080UN:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22NR050UN:T8030	●	–	160	95	150	480	40	–	–	5.0	2.5	1.8



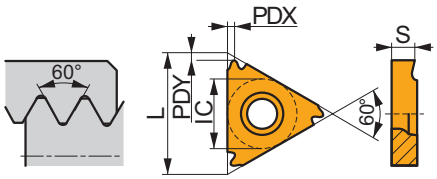
TN UN NL内孔，左手设计，适用于加工美标螺纹，连续切削。

TN 16NL120UN:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NL080UN:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

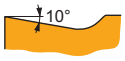
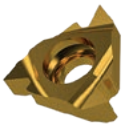
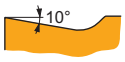
TN 60° PP EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



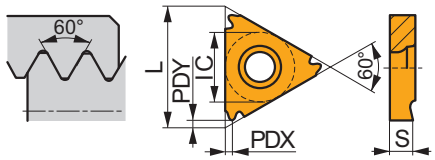
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
TN M60 PP ER外圆，右手设计，适用于加工公制和美标螺纹，连续切削。														
TN 16ERA60:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16ERAG60:T8010	●	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERAG60:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERG60:T8010	●	–	175	105	165	–	40	–	1.75	3.00	8	14	1.5	1.1
TN 16ERG60:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22ERN60:T8010	●	–	175	105	165	–	40	–	3.50	5.00	5	7	2.5	1.8
TN 22ERN60:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8
														
TN M60 PP EL外圆，左手设计，适用于加工公制和美标螺纹，连续切削。														
TN 16ELA60:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16ELAG60:T8010	●	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ELAG60:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ELG60:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22ELN60:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8

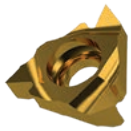
TN 60° PP INT

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



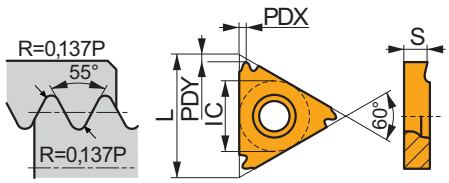
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
								TN M60 PP NR内孔，右手设计，适用于加工公制和美标螺纹，连续切削。						
TN 11NRA60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	1.50	16	48	0.8	0.7
TN 16NRA60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	1.50	16	48	0.8	0.7
TN 16NRAG60:T8010	●	–	■ 175	◪ 105	■ 165	–	◪ 40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRAG60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRG60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	1.75	3.00	8	14	1.5	1.1
TN 22NRN60:T8010	●	–	■ 175	◪ 105	■ 165	–	◪ 40	–	3.50	5.00	5	7	2.5	1.8
TN 22NRN60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	3.50	5.00	5	7	2.5	1.8
								TN M60 PP NL左手内孔设计，适用于加工公制和美标螺纹，连续切削。						
TN 11NLA60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	1.50	16	48	0.8	0.7
TN 16NLAG60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	3.00	8	48	1.5	1.1
TN 22NLN60:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	3.50	5.00	5	7	2.5	1.8

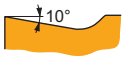
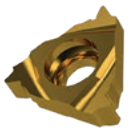
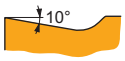
TN W EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



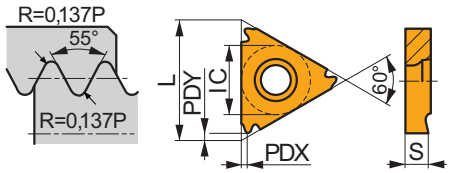
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	● ⬌ ✱	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
			TN W ER外圆，右手设计，适用于加工惠氏螺纹，连续切削。									
TN 16ER280W:T8030	●	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16ER240W:T8030	●	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16ER200W:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16ER190W:T8010	●	–	175	105	165	–	40	–	–	19.0	0.8	0.8
TN 16ER190W:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16ER180W:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16ER160W:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16ER140W:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER120W:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16ER110W:T8010	●	–	175	105	165	–	40	–	–	11.0	1.5	1.2
TN 16ER110W:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16ER100W:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16ER080W:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22ER070W:T8030	●	–	160	95	150	480	40	–	–	7.0	2.5	1.8
TN 22ER060W:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8
TN 22ER050W:T8030	●	–	160	95	150	480	40	–	–	5.0	2.5	1.7
			TN W EL外圆，左手设计，适用于加工惠氏螺纹，连续切削。									
TN 16EL190W:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16EL140W:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16EL120W:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16EL110W:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16EL100W:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16EL080W:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

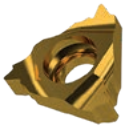
TN W INT

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



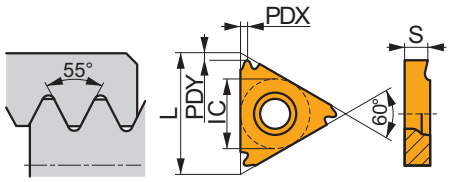
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN W NR内孔，右手设计，适用于加工惠氏螺纹，连续切削。												
TN 11NR190W:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 11NR140W:T8010	●	–	175	105	165	–	40	–	–	14.0	0.9	0.7
TN 11NR140W:T8030	●	–	160	95	150	480	40	–	–	14.0	0.9	0.7
TN 16NR280W:T8030	●	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16NR190W:T8010	●	–	175	105	165	–	40	–	–	19.0	0.8	0.8
TN 16NR190W:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16NR160W:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16NR140W:T8010	●	–	175	105	165	–	40	–	–	14.0	1.5	1.2
TN 16NR140W:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR120W:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NR110W:T8010	●	–	175	105	165	–	40	–	–	11.0	1.5	1.2
TN 16NR110W:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16NR100W:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NR090W:T8030	●	–	160	95	150	480	40	–	–	9.0	1.5	1.2
TN 16NR080W:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22NR060W:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8
TN 22NR050W:T8030	●	–	160	95	150	480	40	–	–	5.0	2.5	1.7
TN W NL内孔，左手设计，适用于加工惠氏螺纹，连续切削。												
TN 16NL140W:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NL120W:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NL110W:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16NL100W:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NL080W:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

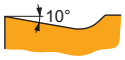
TN 55° PP EXT

PRAMET

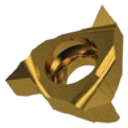
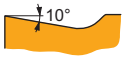
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



线速度(vc)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)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
TN 16ERA55:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16ERAG55:T8010	●	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERAG55:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERG55:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22ERN55:T8010	●	–	175	105	165	–	40	–	3.50	5.00	5	7	2.5	1.8
TN 22ERN55:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8

TN W55 PP ER外圆，右手设计，适用于加工惠氏螺纹，连续切削。

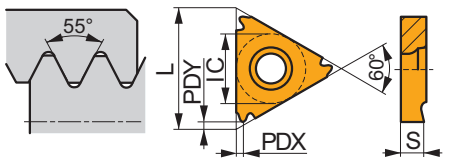
														
TN 16ELAG55:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ELG55:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22ELN55:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8

TN W55 PP EL外圆，左手设计，适用于加工惠氏螺纹，连续切削。

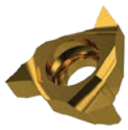
TN 55° PP INT

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



线速度(vc)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)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
TN 11NRA55:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NRA55:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NRAG55:T8010	●	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRAG55:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRG55:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22NRN55:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8

TN W55 PP NR内孔，右手设计，适用于加工惠氏螺纹，连续切削。

线速度(vc)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。

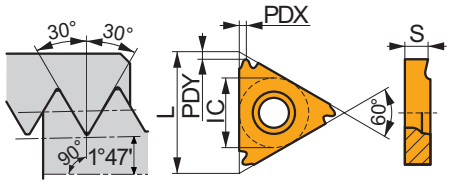
TN W55 PP NL内孔，左手设计，适用于加工惠氏螺纹，连续切削。

Product	●	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
TN 11NLA55:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NLA55:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NLAG55:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NLG55:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1

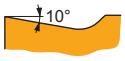
TN NPT EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



线速度(vc)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。



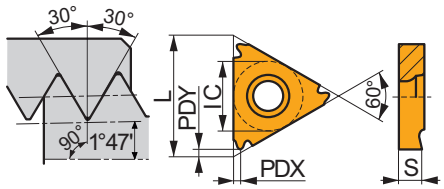
TN NPT ER外圆，右手设计，适用于加工NPT螺纹，连续切削。

Product	●	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
TN 16ER270NPT:T8030	●	–	160	95	150	480	40	–	–	27.0	0.8	0.7
TN 16ER180NPT:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.7
TN 16ER140NPT:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.1
TN 16ER115NPT:T8030	●	–	160	95	150	480	40	–	–	11.5	1.5	1.1
TN 16ER080NPT:T8030	●	–	160	95	150	480	40	–	–	8.0	1.6	1.1

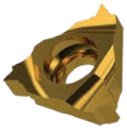
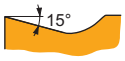
TN NPT INT

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



线速度(vc)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。

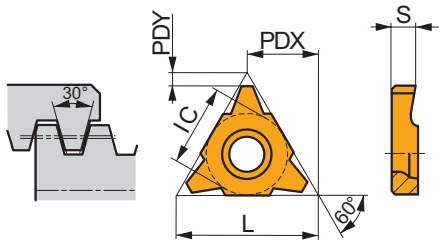
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 11NR180NPT:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.7
TN 11NR140NPT:T8030	●	–	160	95	150	480	40	–	–	14.0	1.0	0.7
TN 16NR140NPT:T8010	●	–	175	105	165	–	40	–	–	14.0	1.5	1.1
TN 16NR140NPT:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.1
TN 16NR115NPT:T8010	●	–	175	105	165	–	40	–	–	11.5	1.5	1.1
TN 16NR115NPT:T8030	●	–	160	95	150	480	40	–	–	11.5	1.5	1.1
TN 16NR080NPT:T8030	●	–	160	95	150	480	40	–	–	8.0	1.6	1.1

TN NPT NR内孔，右手设计，适用于加工NPT螺纹，连续切削。

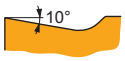
TN TR-S EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



线速度(vc)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。

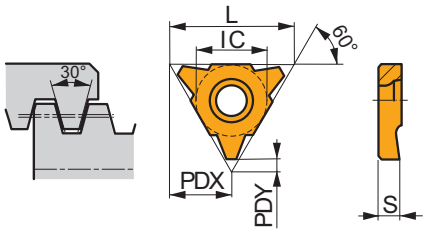
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 22EN600TR:T8030	●	–	160	95	150	480	40	–	6.00	–	11.0	1.9
TN 22EN700TR:T8030	●	–	160	95	150	480	40	–	7.00	–	11.0	2.3

TN TR-S PP EN外圆，左手和右手设计，适用于加工梯形螺纹，连续切削。

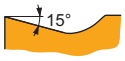
TN TR-S INT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



线速度(vc)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。

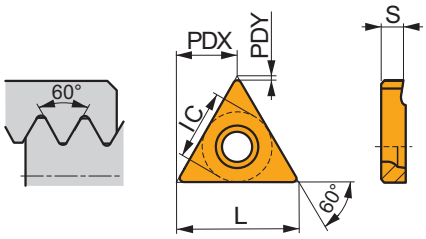
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 22NN600TR:T8030	●	–	160	95	150	480	40	–	6.00	–	11.0	1.9
TN 22NN700TR:T8030	●	–	160	95	150	480	40	–	7.00	–	11.0	2.3

TN M60-S PP NN内孔，左手和右手设计，适用于加工公制和美标螺纹，连续切削。

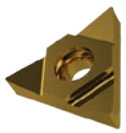
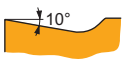
TN 60°-S PP EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



线速度(vc)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。

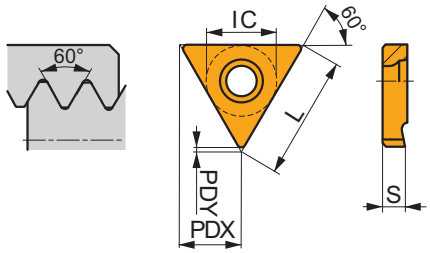
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
TN 22EN350-500M:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	11.0	0.5
TN 22EN550-800M:T8030	●	–	160	95	150	480	40	–	5.50	8.00	3	4.5	11.0	0.8

TN M60-S PP EN外圆，左手和右手设计，适用于加工公制和美标螺纹，连续切削。

TN 60°-S PP INT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



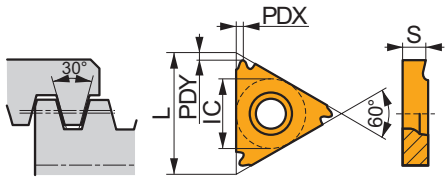
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
TN M60-S PP NN内孔，左手和右手设计，适用于加工公制和美标螺纹，连续切削。														
TN 22NN350-500M:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	11.0	0.2
TN 22NN550-800M:T8030	●	–	160	95	150	480	40	–	5.50	8.00	3	4.5	11.0	0.5

TN TR EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



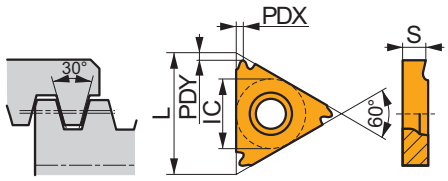
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
TN TR ER外圆，右手设计，适用于加工梯形螺纹，连续切削。												
TN 16ER150TR:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.9
TN 16ER200TR:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.3
TN 16ER300TR:T8030	●	–	160	95	150	480	40	–	3.00	–	1.6	1.3
TN 22ER400TR:T8030	●	–	160	95	150	480	40	–	4.00	–	2.2	1.8
TN 22ER500TR:T8030	●	–	160	95	150	480	40	–	5.00	–	2.2	1.8
TN TR EL外圆，左手设计，适用于加工梯形螺纹，连续切削。												
TN 16EL300TR:T8030	●	–	160	95	150	480	40	–	3.00	–	1.6	1.3
TN 22EL400TR:T8030	●	–	160	95	150	480	40	–	4.00	–	2.2	1.8
TN 22EL500TR:T8030	●	–	160	95	150	480	40	–	5.00	–	2.2	1.8

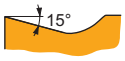
TN TR INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



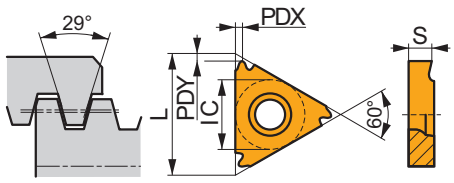
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN TR NR内孔，右手设计，适用于加工梯形螺纹，连续切削。												
TN 16NR150TR:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.9
TN 16NR200TR:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.3
TN 16NR300TR:T8030	●	–	160	95	150	480	40	–	3.00	–	1.6	1.3
TN 22NR400TR:T8030	●	–	160	95	150	480	40	–	4.00	–	2.2	1.8
TN 22NR500TR:T8030	●	–	160	95	150	480	40	–	5.00	–	2.2	1.8
TN TR NL内孔，左手设计，适用于加工梯形螺纹，连续切削。												
TN 16NL300TR:T8030	●	–	160	95	150	480	40	–	3.00	–	1.6	1.3

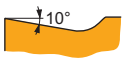
TN ACME EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



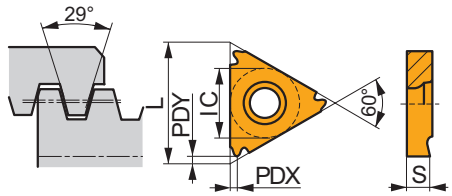
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN ACME ER外圆，右手设计，适用于加工ACME螺纹，连续切削。												
TN 16ER080ACME:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.3
TN 22ER060ACME:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	2.0
TN 22ER050ACME:T8030	●	–	160	95	150	480	40	–	–	5.0	2.3	2.0

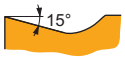
TN ACME INT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.71



线速度(vc)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。

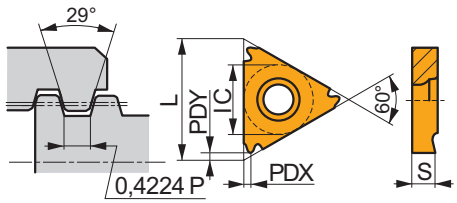
Product	●	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 22NR060ACME:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	2.0

TN ACME NR内孔，右手设计，适用于加工ACME螺纹，连续切削。

TN STACME INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



线速度(vc)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)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
TN 16NR060STACME:T8030[1]	●	–	160	95	150	480	40	–	–	6.0	1.3	1.3

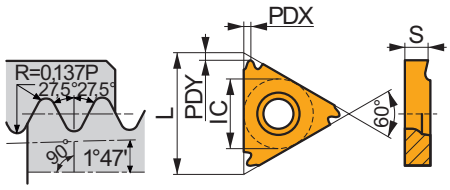
TN STACME NR内孔，右手设计，适用于加工Stub ACMEE螺纹，连续切削。

[1] Toolholders have to be modified.

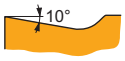
TN BSPT EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



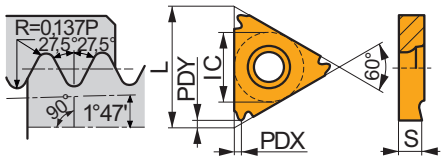
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN BSPT ER外圆，右手设计，适用于加工BSPT螺纹，连续切削。												
TN 16ER190BSPT:T8030	●	–	160	95	150	480	40	–	–	19.0	1.5	1.2
TN 16ER140BSPT:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER110BSPT:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

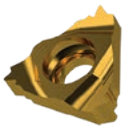
TN BSPT INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



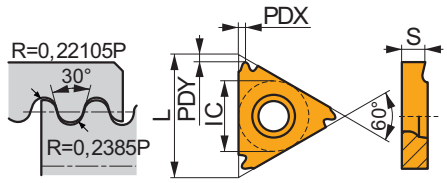
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	●	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN BSPT NR内孔，右手设计，适用于加工BSPT螺纹，连续切削。												
TN 16NR140BSPT:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR110BSPT:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

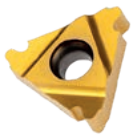
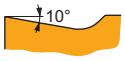
TN RD EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



线速度(vc)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)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
												
TN 16ER080RD:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 16ER060RD:T8030[1]	●	–	160	95	150	480	40	–	–	6.0	1.5	1.2
TN 22ER060RD:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8

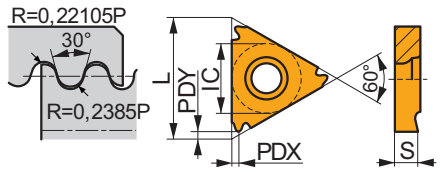
TN RD ER外圆，右手设计，适用于加工公制圆螺纹，连续切削。

[1] Toolholders have to be modified.

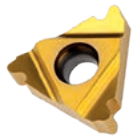
TN RD INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



线速度(vc)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)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 16NR080RD:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 16NR060RD:T8030[1]	●	–	160	95	150	480	40	–	–	6.0	1.5	1.2
TN 22NR060RD:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8

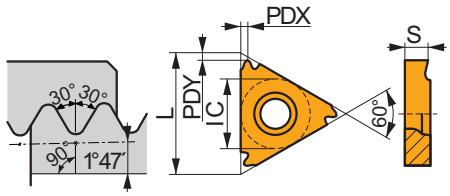
TN RD NR内孔，右手设计，适用于加工公制圆螺纹，连续切削。

[1] Toolholders have to be modified.

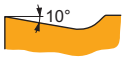
TN API RD EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



线速度(vc)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。

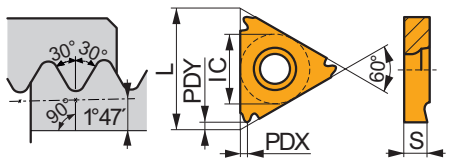
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN 16ER100API-RD01:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16ER080API-RD01:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

TN API ER外圆，右手设计，适用于加工API螺纹，连续切削。

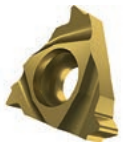
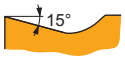
TN API RD INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



线速度(vc)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。

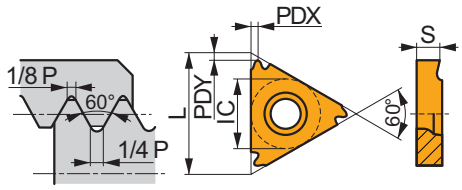
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
 												
TN 16NR100API-RD01:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NR080API-RD01:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

TN API NR内孔，右手设计，适用于加工API螺纹，连续切削。

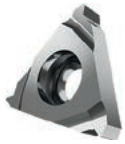
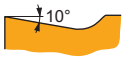
TN M EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



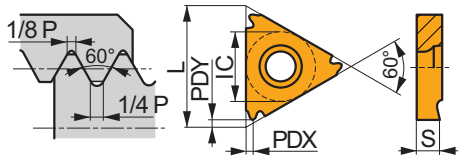
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
  TN M-AL ER外圆，右手设计，适用于加工ISO公制螺纹，连续切削。												
TN 16ER100M-AL:HF7	●	–	–	95	–	480	–	–	1.00	–	0.8	0.8
TN 16ER125M-AL:HF7	●	–	–	95	–	480	–	–	1.25	–	0.8	0.8
TN 16ER150M-AL:HF7	●	–	–	95	–	480	–	–	1.50	–	0.8	0.8
TN 16ER200M-AL:HF7	●	–	–	95	–	480	–	–	2.00	–	1.5	1.2

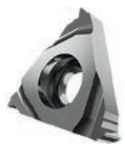
TN M INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



线速度(vc)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)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
 TN M-AL NR内孔，右手设计，适用于加工ISO公制螺纹，连续切削。												
TN 16NR150M-AL:HF7	●	–	–	95	–	480	–	–	1.50	–	0.8	0.8
TN 16NR200M-AL:HF7	●	–	–	95	–	480	–	–	2.00	–	1.5	1.2

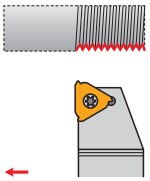
SE(RL)

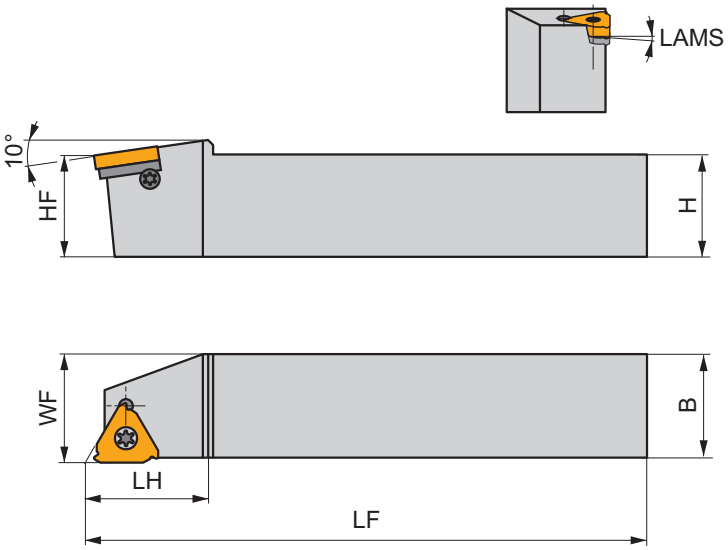
P M K N S H

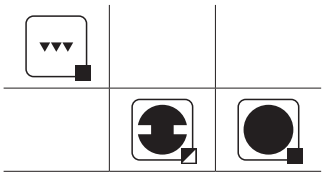
PRAMET

S

外圆螺纹车刀杆，使用螺钉夹紧的TN 16,22刀片
左/右手螺钉夹紧刀杆，外螺纹加工，使用TN 16、22或27 ER/EL刀片。适用于公制或英制螺纹。TN 16和22也适用于浅槽加工。刀杆经过处理，延长了使用寿命。







	Product	H	HF	B	WF	LF	LH	LAMS		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)		
R	**SER 2020 K 16**	20	20	20	20	125	22.5	–	GI068	Z12
	SER 2525 M 16	25	25	25	25	150	24.0	–	GI068	Z12
	SER 3225 P 16	32	32	25	25	170	24.5	–	GI068	Z12
	SER 2525 M 22-A	25	25	25	25	150	25.5	–	GI071	Z13
	SER 3225 P 22-A	32	32	25	25	170	25.5	–	GI071	Z13
L	**SEL 2020 K 16**	20	20	20	20	125	22.5	–	GI068	Z12
	SEL 2525 M 16	25	25	25	25	150	24.0	–	GI068	Z12
	SEL 2525 M 22-A	25	25	25	25	150	25.5	–	GI071	Z13

GI068	TN 16ER..	TN 16EL..
GI071	TN 22ER..	TN 22EL..

		Nm							
Z12	US 3512A-T15P	3.0	M 3.5	12.7	–	HS 0304	FLAG T15P	HXK 2.5	Page xx
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	–	FLAG T20	–	Page xx

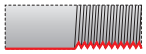
SE(RL)-S

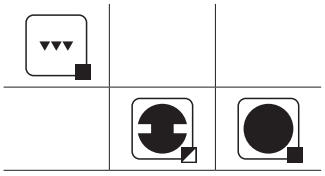
P M K N S H

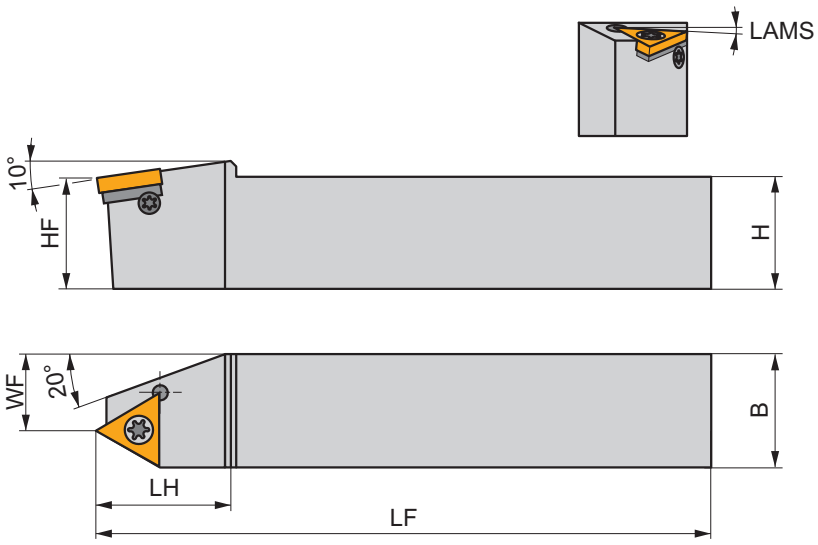
PRAMET

S

外圆螺纹车刀杆，使用螺钉夹紧的TN 22 EN刀片
右/左手螺钉夹紧车刀杆，大直径外螺纹加工，使用TN 22和27 EN中置刀片。适用于公制或英制螺纹。刀杆经过处理，延长了使用寿命。







	Product	H	HF	B	WF	LF	LH	LAMS		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)		
R	**SER-S 2525 M 22-A**	25	25	25	14	150	30.0	–	GI086	Z15
	SER-S 3225 P 22-A	32	32	25	14	170	30.0	–	GI086	Z15
L	**SEL-S 2525 M 22-A**	25	25	25	14	150	30.0	–	GI086	Z15

GI086	TN 22EN..

Z15	US 4514A-T20	5.0	M 4.5	14	SP 0405	FLAG T20	Page xx

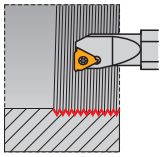
SI(RL)

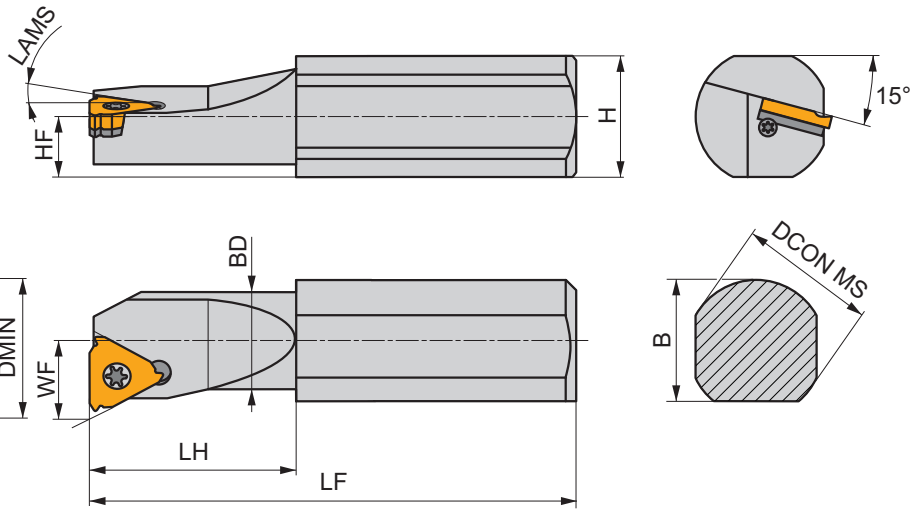
P M K N S H

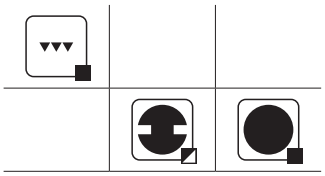
PRAMET

S

内孔螺纹车刀杆，使用螺钉夹紧的TN 11 ,16,22刀片
右/左手螺钉夹紧镗杆，内螺纹加工，使用TN 11、16、22或27 NR/NL刀片。适用于公制或英制螺纹。最小内径13mm。可提供直径从16mm到50mm的刀柄。刀杆经过处理，延长了刀具寿命。







	Product	B	DCON MS	DMIN	BD	WF	H	HF	LF	LH	LAMS			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)			
R	SIR 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25.0	0	–	GI085	Z11
	SIR 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25.0	1	–	GI085	Z11
	SIR 0013 M 11-0	14.5	16	16	13	9	14	7	150	32.0	0	–	GI085	Z11
	SIR 0013 M 11-1	14.5	16	16	13	9	14	7	150	32.0	1	–	GI085	Z11
	SIR 1416 N 16-0	14	16	22	17	11.4	14.5	7.25	160	–	0	–	GI022	Z9
	SIR 1416 N 16-1	14	16	22	17	11.4	14.5	7.25	160	–	1	–	GI022	Z9
	SIR 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.25	160	40.0	2	✓	GI022	Z10
	SIR 1820 P 16	18.5	20	27	21	13.85	18	9	170	–	–	–	GI022	Z12
	SIR 2325 Q 16	23.5	25	29	26	16.55	23	11.5	180	–	–	–	GI022	Z12
	SIR 2532 S 16	30	32	36	32	19.75	25	12.5	250	–	–	–	GI022	Z12
	SIR 2532 S 22-2	30	32	25	25	16.65	25	12.5	250	80.0	2	✓	GI076	Z14
	SIR 2532 S 22-A	30	32	36	32	21.65	25	12.5	250	–	–	–	GI076	Z13
	SIR 3240 T 22-A	38	40	48	40	25.85	32	16	300	–	–	–	GI076	Z13
L	SIL 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25.0	0	–	GI085	Z11
	SIL 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25.0	1	–	GI085	Z11
	SIL 0013 M 11-1	14.5	16	16	13	9	14	7	150	32.0	1	–	GI085	Z11
	SIL 1416 N 16-0	14	16	22	17	11.4	14.5	7.25	160	–	0	–	GI022	Z9
	SIL 1416 N 16-1	14	16	22	17	11.4	14.5	7.25	160	–	1	–	GI022	Z9
	SIL 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.25	160	40.0	2	✓	GI022	Z10
	SIL 1820 P 16	18.5	20	24	21	13.85	18	9	170	–	–	–	GI022	Z12
	SIL 2325 Q 16	23.5	25	29	26	16.55	23	11.5	180	–	–	–	GI022	Z12
	SIL 2532 S 16	30	32	36	32	19.75	25	12.5	250	–	–	–	GI022	Z12
	SIL 2532 S 22-2	30	32	25	25	16.65	25	12.5	250	80.0	2	✓	GI076	Z14

GI022	TN 16NR..	TN 16NL..

GI076	TN 22NR..	TN 22NL..
GI085	TN 11NR..	TN 11NL..

		Nm							
Z10	US 3510A-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	–
Z11	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–	–
Z12	US 3512A-T15P	3.0	M 3.5	12.7	–	HS 0304	FLAG T15P	HXK 2.5	Page xx
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	–	FLAG T20	–	Page xx
Z14	US 4514A-T20	5.0	M 4.5	14	–	–	FLAG T20	–	–
Z9	US 3510A-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	P-16

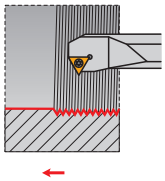
SI(RL)-S

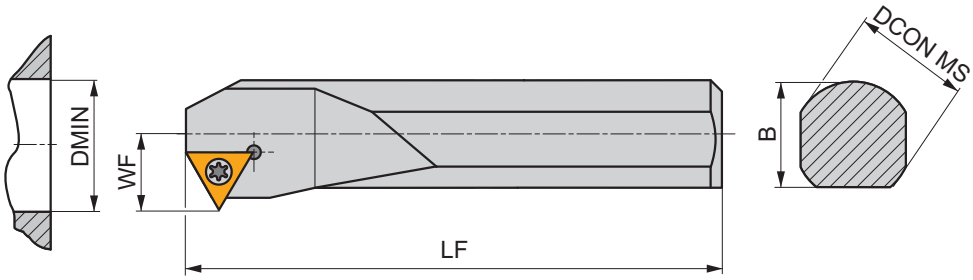
P M K N S H

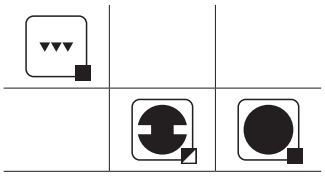
PRAMET

S

内孔螺纹车刀杆，使用螺钉夹紧的TN 22刀片
右/左手螺钉夹紧式镗杆，内螺纹加工，使用TN 22或TN 27 NN刀片。适用于公制或英制螺纹。最小内径39mm。可提供直径从32mm到50mm的刀柄。刀杆经过处理，延长了使用寿命。



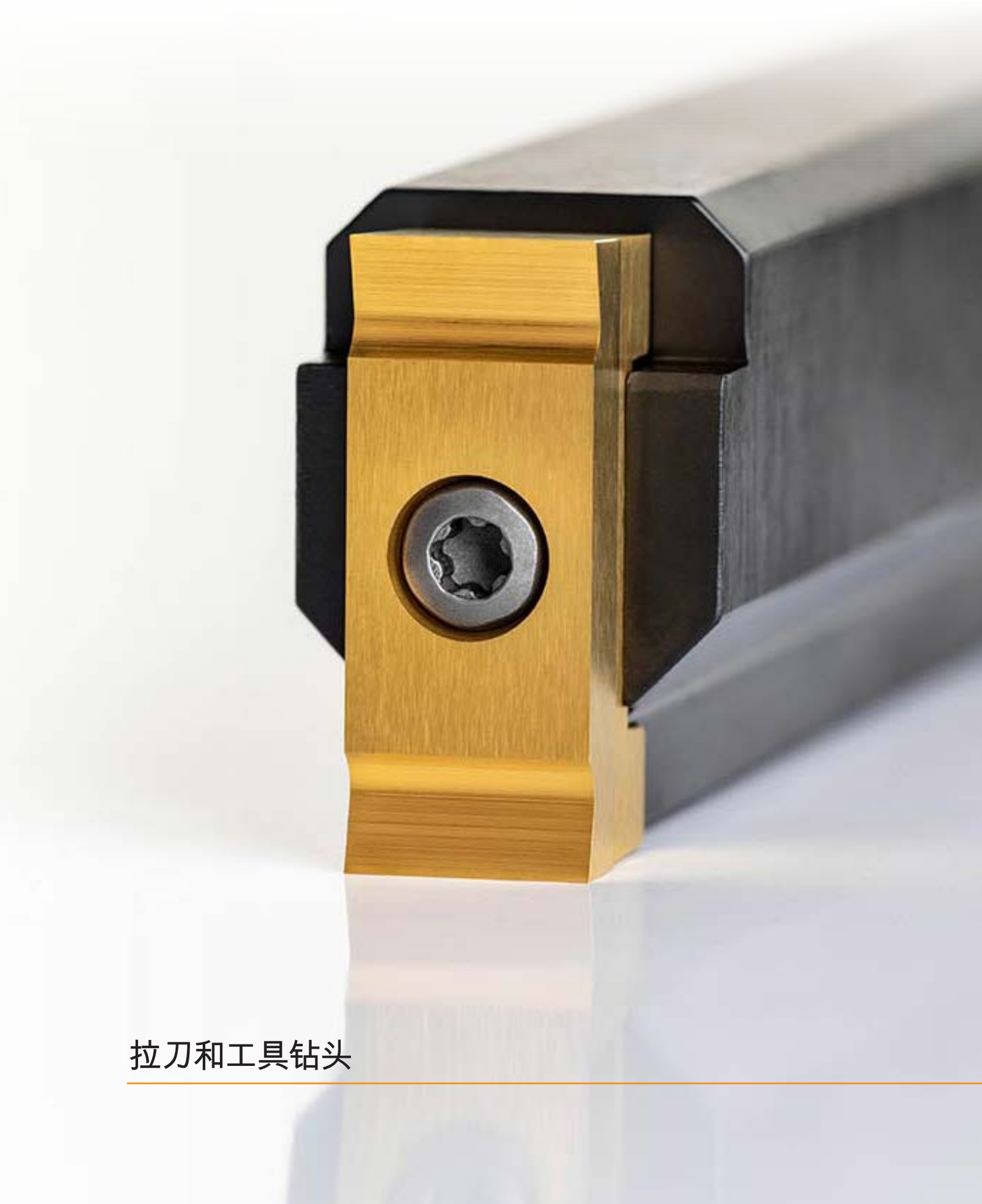




	Product	B	DCON MS	DMIN	WF	H	HF	LF	LAMS		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)		
R	**SIR-S 2532 S 22-A**	30	32	39	22.3	25	12.5	250	–	GI107	Z15
	SIR-S 3240 T 22-A	38	40	48	27	32	16	300	–	GI107	Z15

GI107	TN 22NN..

Z15	US 4514A-T20	5.0	M 4.5	14	SP 0405	FLAG T20	Page xx



拉刀和工具钻头

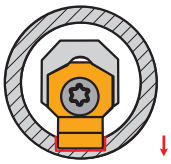
PHZ

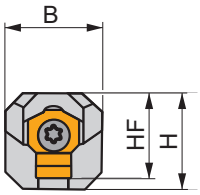
P M K N S H

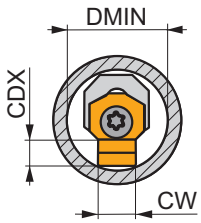
PRAMET

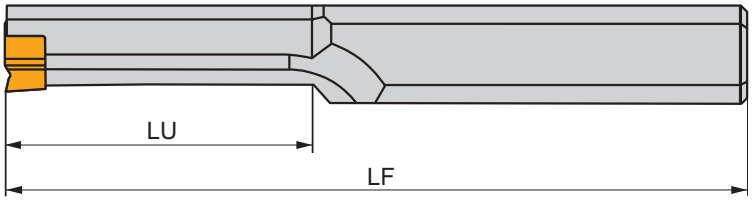
S

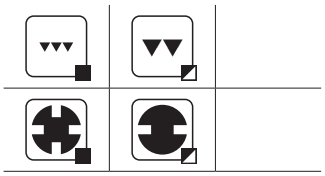
小直径内孔用插槽刀杆，使用单面HZ刀片。
内孔刀杆可插削最大12mm的宽度。刀杆经过处理，使用寿命更长。











	Product	H (mm)	HF (mm)	B (mm)	OAL (mm)	LU (mm)	CW (mm)	DMIN (mm)	CDX (mm)	kg		
N	**PHZ 90 1104-06**	11.3	9	8.5	160	35	3.00	9.5	1.6	0.14	GI239	SH21
	PHZ 90 1107-06	11.3	10	7	200	60	–	–	–	0.19	GI240	SH21
	PHZ 90 1111-06	11.3	12	–	200	60	–	–	–	0.21	GI240	SH21
	PHZ 1512-10	15.5	16.2	–	220	–	–	–	–	0.33	GI224	SH22
	PHZ 2014-13	20.6	21.5	–	250	–	–	–	–	0.58	GI225	SH23

GI224	HZ 1006-60	HZ 1006-80
GI225	HZ 1309-100	HZ 1309-120
GI239	HZ90 0604-30	–
GI240	HZ90 0604-40	HZ90 0604-50

		Nm			
SH21	DVF 3593	0.8	M 2.5	10	TX207PLUS
SH22	DVF 2260	3.6	M 4	15	TX215PLUS
SH23	5513 020-14	8.5	M 6	18	TX225PLUS

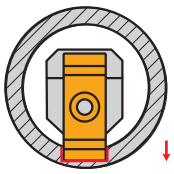
PHZ-2

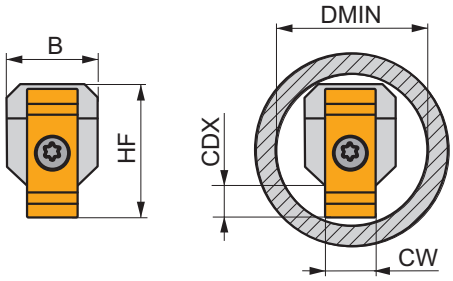
P M K N S H

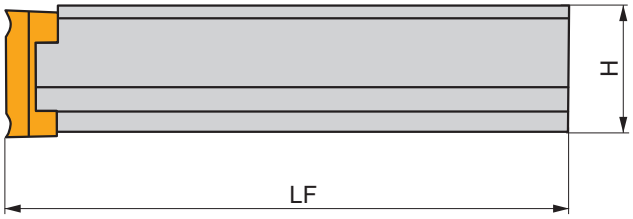
PRAMET

S

大直径内孔用插槽刀杆，使用双面HZ刀片。
内孔刀杆，可插削最大20mm的宽度。刀杆经过处理，使用寿命更长。







Product	H (mm)	HF (mm)	B (mm)	OAL (mm)	CW (mm)	DMIN (mm)	CDX (mm)	kg		
N **PHZ/2 3625-14**	36	37.5	25	300	–	44	–	1.84	GI235	SH23
PHZ/2 4832-18	48	50	32	400	–	58	–	2.00	GI241	SH24

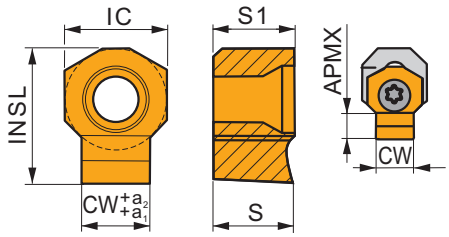
GI235	HZ/2 14-14	HZ/2 16-16
GI241	HZ/2 18-18	HZ/2 20-20

		Nm			
SH23	5513 020-14	8.5	M 6	18	TX225PLUS
SH24	5513 021-03	13.0	M 8	22	DMN 3124

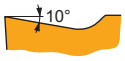
HZ

PRAMET

	CW (mm)	INSL (mm)	APMX (mm)	S (mm)	S1 (mm)
0604-30	3.00	7.5	1.60	4.66	4.76
0604-40	4.00	8.0	2.50	4.66	4.76
0604-50	5.00	8.0	3.00	4.66	4.76
1006-60	6.00	13.5	4.20	6.25	6.35
1006-80	8.00	13.5	5.20	6.25	6.35
1309-100	10.00	18.5	6.20	9.40	9.53
1309-120	12.00	18.5	7.20	9.40	9.53



线速度(vc)和进给量(fz)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。

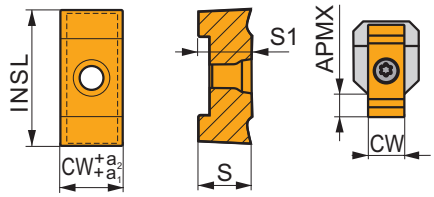
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CWTOLL (mm)	CWTOLU (mm)
																	
HZ 1006-60 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	6.00	0.07	0.14
HZ 1006-60 D10:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	6.00	0.03	0.08
HZ 1006-60 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	6.00	0.00	0.01
HZ 1006-60 P9:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	6.00	-0.04	-0.01
HZ 1006-80 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	8.00	0.08	0.17
HZ 1006-80 D10:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	8.00	0.04	0.10
HZ 1006-80 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	8.00	0.00	0.01
HZ 1006-80 P9:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	8.00	-0.05	-0.01
HZ 1309-100 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	10.00	0.08	0.17
HZ 1309-100 D10:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	10.00	0.04	0.10
HZ 1309-100 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	10.00	0.00	0.01
HZ 1309-100 P9:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	10.00	-0.05	-0.01
HZ 1309-120 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	12.00	0.10	0.20
HZ 1309-120 D10:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	12.00	0.05	0.12
HZ 1309-120 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	12.00	0.00	0.02
HZ 1309-120 P9:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	12.00	-0.06	-0.02
HZ90 0604-30 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	3.00	0.06	0.12
HZ90 0604-30 D10:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	3.00	0.02	0.06
HZ90 0604-30 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	3.00	0.00	0.01
HZ90 0604-30 P9:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	3.00	-0.03	-0.01
HZ90 0604-40 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	4.00	0.07	0.14
HZ90 0604-40 D10:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	4.00	0.03	0.08
HZ90 0604-40 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	4.00	0.00	0.01
HZ90 0604-40 P9:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	4.00	-0.04	-0.01
HZ90 0604-50 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	5.00	0.07	0.14
HZ90 0604-50 D10:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	5.00	0.03	0.08
HZ90 0604-50 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	5.00	0.00	0.01
HZ90 0604-50 P9:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	5.00	-0.04	-0.01

HZ 用于拉削的正前角断屑槽（一个切削刃）。

HZ-2

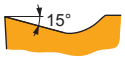
PRAMET

	INSL (mm)	APMX (mm)	S (mm)	S1 (mm)	CW (mm)
14-14	36.0	8.00	13.90	14.00	14.00
16-16	36.0	9.00	13.90	14.00	16.00
18-18	45.0	12.00	15.90	16.00	18.00
20-20	45.0	13.00	15.90	16.00	20.00



线速度(vc)和进给量(fz)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。

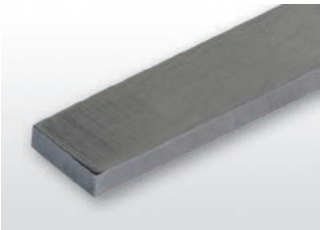
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CWTOLL (mm)	CWTOLU (mm)
HZ/2 14-14 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	14.00	0.10	0.20
HZ/2 14-14 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	14.00	0.00	0.02
HZ/2 14-14 P9:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	14.00	-0.06	-0.02
HZ/2 16-16 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	16.00	0.10	0.20
HZ/2 16-16 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	16.00	0.00	0.02
HZ/2 16-16 P9:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	16.00	-0.06	-0.02
HZ/2 18-18 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	18.00	0.10	0.20
HZ/2 18-18 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	18.00	0.00	0.02
HZ/2 18-18 P9:333TN	✱	–	50	0.10	30	0.10	45	0.10	–	–	–	–	–	–	18.00	-0.06	-0.02
HZ/2 20-20 C11:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	20.00	0.11	0.24
HZ/2 20-20 H7:333TN	✱	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	20.00	0.00	0.02
HZ/2 20-20 P9:333TN	✱	–	50	0.10	30	0.10	45	0.10	–	–	–	–	–	–	20.00	-0.07	-0.02



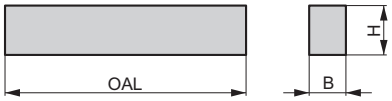
HZ-2 用于拉削的正前角断屑槽（两个切削刃）。

TOOL BITS F

DORMER



HSS-E 矩形白钢条
根据 DIN 4964 D 标准磨削的矩形白钢条。T2000S HSS-E 银亮钢，含 10%钴，硬度为 65-67 HRC。



HSS-E	DIN 4964D	Bright
h13		

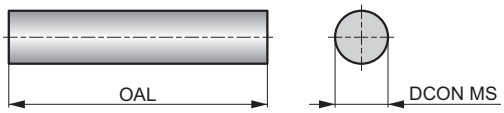
Product	H (mm)	B (mm)	OAL (mm)
8X6X200:T2000S	8	6	200.0
10X2X200:T2000S	10	2	200.0
10X3X200:T2000S	10	3	200.0
10X4X200:T2000S	10	4	200.0
10X5X200:T2000S	10	5	200.0
10X6X200:T2000S	10	6	200.0
10X8X200:T2000S	10	8	200.0
12X3X200:T2000S	12	3	200.0
12X4X200:T2000S	12	4	200.0
12X6X200:T2000S	12	6	200.0
12X8X200:T2000S	12	8	200.0
15X3X200:T2000S	15	3	200.0
15X4X200:T2000S	15	4	200.0
15X5X200:T2000S	15	5	200.0
15X6X200:T2000S	15	6	200.0
15X8X200:T2000S	15	8	200.0
15X10X200:T2000S	15	10	200.0
16X8X200:T2000S	16	8	200.0
16X10X200:T2000S	16	10	200.0

Product	H (mm)	B (mm)	OAL (mm)
16X12X200:T2000S	16	12	200.0
20X3X200:T2000S	20	3	200.0
20X4X200:T2000S	20	4	200.0
20X5X200:T2000S	20	5	200.0
20X6X200:T2000S	20	6	200.0
20X8X200:T2000S	20	8	200.0
20X10X200:T2000S	20	10	200.0
20X12X200:T2000S	20	12	200.0
20X15X200:T2000S	20	15	200.0
25X5X200:T2000S	25	5	200.0
25X6X200:T2000S	25	6	200.0
25X10X200:T2000S	25	10	200.0
25X12X200:T2000S	25	12	200.0
30X4X200:T2000S	30	4	200.0
30X5X200:T2000S	30	5	200.0
30X10X200:T2000S	30	10	200.0
30X15X200:T2000S	30	15	200.0
30X20X200:T2000S	30	20	200.0

TOOL BITS R

DORMER

HSS-E 圆形白钢条
根据 DIN 4964 A 标准磨削的圆形白钢条。T2000S HSS-E 银亮钢，含 10%钴，硬度为 65-67 HRC。



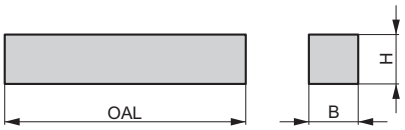
HSS-E	DIN 4964A	Bright
h9		

Product	DCON MS (mm)	OAL (mm)
3X200 T:T2000S	3.00	200.0
4X200 T:T2000S	4.00	200.0
5X200 T:T2000S	5.00	200.0
6X200 T:T2000S	6.00	200.0
7X200 T:T2000S	7.00	200.0
8X200 T:T2000S	8.00	200.0
10X200 T:T2000S	10.00	200.0
12X200 T:T2000S	12.00	200.0
14X200 T:T2000S	14.00	200.0
16X200 T:T2000S	16.00	200.0
20X200 T:T2000S	20.00	200.0

TOOL BITS S

DORMER

HSS-E 方形白钢条
根据 DIN 4964 B 标准磨削的方形白钢条。T2000S HSS-E 银亮钢，含 10%钴，硬度为 65-67 HRC。

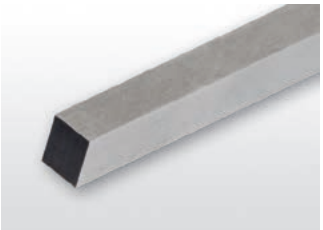


HSS-E	DIN 4964B	Bright
+0 -0.1		

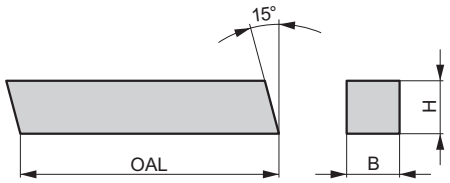
Product	H (mm)	B (mm)	OAL (mm)
4X4X200:T2000S	4	4	200.0
6X6X200:T2000S	6	6	200.0
8X8X200:T2000S	8	8	200.0
10X10X200:T2000S	10	10	200.0
12X12X200:T2000S	12	12	200.0
14X14X200:T2000S	14	14	200.0
15X15X200:T2000S	15	15	200.0
16X16X200:T2000S	16	16	200.0
20X20X200:T2000S	20	20	200.0
25X25X200:T2000S	25	25	200.0

TOOL BITS SA

DORMER



带斜面的 HSS-E 方形白钢条
根据 DIN 4964 B 标准磨削的方形白钢条，两端带斜面。T2000S HSS-E 银亮钢，含 10%钴，硬度为 65-67 HRC。

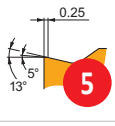


HSS-E	DIN 4964B	Bright
h13		

Product	H (mm)	B (mm)	OAL (mm)	H (inch)	B (inch)	OAL (inch)
4X4X200A:T2000S	4	4	200.0	–	–	–
6X6X100A:T2000S	6	6	100.0	–	–	–
6X6X200A:T2000S	6	6	200.0	–	–	–
8X8X100A:T2000S	8	8	100.0	–	–	–
8X8X160A:T2000S	8	8	160.0	–	–	–
8X8X200A:T2000S	8	8	200.0	–	–	–
10X10X100A:T2000S	10	10	100.0	–	–	–
10X10X160A:T2000S	10	10	160.0	–	–	–
10X10X200A:T2000S	10	10	200.0	–	–	–
12X12X100A:T2000S	12	12	100.0	–	–	–
12X12X200A:T2000S	12	12	200.0	–	–	–
14X14X200A:T2000S	14	14	200.0	–	–	–
15X15X200A:T2000S	15	15	200.0	–	–	–
16X16X200A:T2000S	16	16	200.0	–	–	–
20X20X200A:T2000S	20	20	200.0	–	–	–
25X25X200A:T2000S	25	25	200.0	–	–	–
3/16X3/16X2.1/2A:T2000S	–	–	–	3/16	3/16	2.500
1/4X1/4X2.1/2A:T2000S	–	–	–	1/4	1/4	2.500
1/4X1/4X4A:T2000S	–	–	–	1/4	1/4	4.000
5/16X5/16X2.1/2A:T2000S	–	–	–	5/16	5/16	2.500
5/16X5/16X4A:T2000S	–	–	–	5/16	5/16	4.000
3/8X3/8X3A:T2000S	–	–	–	3/8	3/8	3.000
3/8X3/8X4A:T2000S	–	–	–	3/8	3/8	4.000
3/8X3/8X6A:T2000S	–	–	–	3/8	3/8	6.000
1/2X1/2X4A:T2000S	–	–	–	1/2	1/2	4.000
1/2X1/2X6A:T2000S	–	–	–	1/2	1/2	6.000
5/8X5/8X6A:T2000S	–	–	–	5/8	5/8	6.000

说明

SM



SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。 10

PRAMET

1

CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35

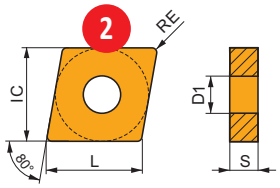
3

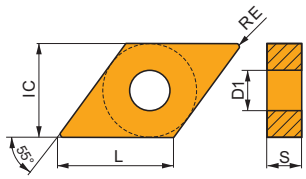
DNMG

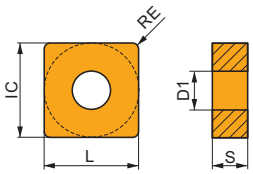
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	4.76

SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1906	19.050	7.94	19.05	6.35







TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76

VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

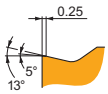
WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	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/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)
CNMG 120404E-SM:T6310	●	0.4	155	0.20	2.0	110	0.18	2.0	125	0.20	2.0	465	0.24	2.0	45	0.18	1.6	30	0.13	0.3
CNMG 120404E-SM:T7325			180	0.20	2.0	140	0.18	2.0	–	–	–	–	–	–	55	0.18	1.6	–	–	–
CNMG 120404E-SM:T7335			175	0.20	2.0	135	0.18	2.0	–	–	–	–	–	–	55	0.18	1.6	–	–	–
CNMG 120404E-SM:T8415	●	0.4	200	0.20	2.0	105	0.18	2.0	185	0.20	2.0	510	0.24	2.0	45	0.18	1.6	35	0.13	0.3
CNMG 120404E-SM:T8430	●	0.4	180	0.20	2.0	95	0.18	2.0	145	0.20	2.0	495	0.24	2.0	35	0.18	1.6	30	0.13	0.3

4



SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。

7 8 9 11

图号	描述
1	刀片规格
2	刀片示意图
3	刀片尺寸表 (mm)
4	典型刀片的图片
5	主切削刃廓形
6	图标 - 具体特点和切削刃类型

图号	描述
7	ISO刀片代码: 涂层
8	工况
9	刀尖半径 (mm)
10	槽型说明
11	刀片应用领域

本页仅用于刀片信息的介绍 - 具体产品信息会有不同。

1 DDUN(RL) INT

P M K N S H 2

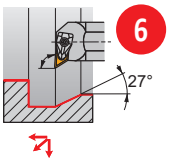
PRAMET

D 3

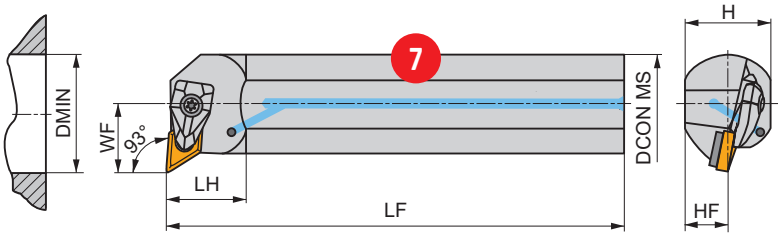
内孔双重刚性夹紧镗杆，使用DN..刀片，主偏角为93°。

内孔左/右手双重刚性夹紧镗杆，有内冷通道，主偏角为93°，使用DN..刀片。广泛的应用于内孔车削，仿形车削角度最大为27°。刀杆经过处理，使用寿命更长。 5

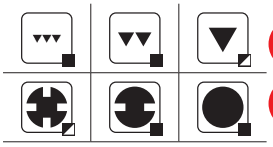
4



6



7


8 9

10

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg			
R	A25T-DDUNR 11	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
R	A32T-DDUNR 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI046	DD11	–
R	A40T-DDUNR 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.58	GI044	DD154	AT002
R	A50U-DDUNR 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	[illegible]	GI044	DD154	AT002
L	A25T-DDUNL 11	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
L	A32T-DDUNL 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.69	GI046	DD11	–
L	A40T-DDUNL 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.59	GI044	DD154	AT002
L	A50U-DDUNL 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.25	GI044	DD154	AT002

11 12 13 14 15 16 17 18

GI044	19 [illegible]06..
GI046	DN.. 1104..

		Nm			
DD11	DCS 09	1.7	20 [illegible]67-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

AT002a	DN.. 1504..	21 [illegible]	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

所示为带车削刀架的典型页面 - 具体页面详情可能有所不同。

图号	描述
1	车削刀杆的
2	推荐的材料组
3	刀片夹紧系统
4	示例图片 [1]
5	刀具说明
6	工件轮廓
7	刀具示意图
8	表面质量
9	切削属性/工况
10	产品应用
11	刀具设计

图号	描述
12	刀架的ISO代码
13	刀杆的尺寸[mm]和角度[2] [°]
14	内冷式
15	重量 [kg]
16	兼容刀片组 [3]
17	备件组[3]、[4]
18	附件组[3]，[4]
19	兼容刀片
20	备件
21	专用附件

1) 车刀杆以右手刀显示 (R)
2) GAMO = 前角 (查看技术部分)
LAMS = 主切削刃倾斜角(查看技术部分)
3) 刀片组, 备件和附件代码仅用于此样册. 不能用于订货.
4) 备件和附件图标仅是用来理解样本信息. 他们不包含在图标列表里, 某些情况下, 附带扭矩 Nm,螺钉长度和螺纹尺寸.

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

车削作业

	不带肩轴向车削–外圆加工
	带肩轴向车削–外圆加工
	锥体车削–外圆加工
	倒角(开坡口)
	不带肩端面车削
	带肩端面车削
	单向仿形车削–外圆加工
	多向仿形车削–外圆加工
	端面仿形车削
	加工外圆浅槽
	用于 O 形圈的浅槽
	外圆车槽(可扩槽加工)

	不带肩轴向车削–内圆加工
	带肩轴向车削–内圆加工
	锥体车削–内圆加工
	孔内倒角(开坡口)
	背面倒角(开坡口)
	加工尾部端面(背车)
	单向仿形车削–内圆加工
	多向仿形车削–内圆加工
	孔内表面仿形车削
	内孔沟槽
	用于 O 形圈的内部凹槽
	内孔沟槽(可扩槽加工)

	加工外圆深槽
	切断加工
	管壁切断
	加工端面浅槽
	加工端面浅槽及车槽(可扩槽加工)
	加工端面深槽
	加工端面深槽及车槽(可扩槽加工)
	仿形车削(多向加工)
	端面仿形车削
	螺纹车削
	螺纹车削
	成形加工

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

特点

1	首选
U	应用广泛的多用途选项
	适用于短切屑材料
	适用于韧性材料(长切屑)
	薄壁和细长工件

	大悬伸
	重载作业条件
W	具有修光刃槽型的刀片
HSC	高速切削
HFC	快进给切削

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
K	刃口两次倒棱
P	刃口两次S型倒棱

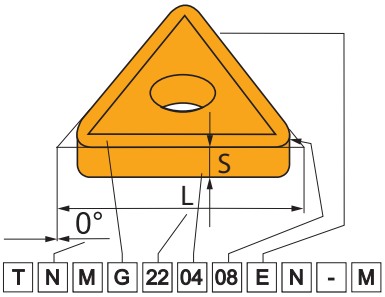
技术参数

FF	超精加工
F	精加工
M	中等加工
R	粗加工
HR	重载粗加工

V	线速度
f	进给 [mm/rev]
a_p	切削深度 [mm]
X.V	线速度校正因子
	寿命 [min]

Nm	螺钉的夹紧力矩[Nm]
	重载粗车刀
	内冷供应

ISO代码 - 刀片



	1	2	3	4
ISO	T	N	U	N
	T	N	M	G
ANSI	T	N	U	
	T	N	M	G

1 ISO代码 - 刀片

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 刀片后角

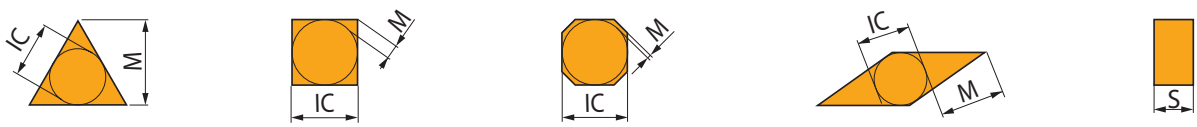
A	3°	B	5°
C	7°	D	15°
E	20°	F	25°
G	30°	N	0°
P	11°	O	非标

4 刀片类型

N	
R	
F	
A	
M	
G	
W	40° – 60°
T	40° – 60°
Q	40° – 60°
U	40° – 60°
B	70° – 90°
H	70° – 90°
C	70° – 90°
J	70° – 90°
X	非标

3 公差

	(mm)			(")		
	M (±)	S (±)	IC (±)	M (±)	S (±)	IC (±)
A	0.005	0.025	0.025	.0002"	.001"	.0010"
F	0.005	0.025	0.013	.0002"	.001"	.0005"
C	0.013	0.025	0.025	.0005"	.001"	.0010"
H	0.013	0.025	0.013	.0005"	.001"	.0005"
E	0.025	0.025	0.025	.0010"	.001"	.0010"
G	0.025	0.130	0.025	.0010"	.005"	.0010"
J	0.005	0.025	0.05 – 0.13	.0002"	.001"	.002 – 0.005"
K	0.013	0.025	0.05 – 0.13	.0005"	.001"	.002 – 0.005"
L	0.025	0.025	0.05 – 0.13	.0010"	.001"	.002 – 0.005"
M	0.08 – 0.18	0.130	0.05 – 0.13	.003 – 0.007"	.005"	.002 – 0.005"
N	0.08 – 0.18	0.025	0.05 – 0.13	.003 – 0.007"	.001"	.002 – 0.005"
U	0.05 – 0.38	0.130	0.05 – 0.13	.005 – 0.015"	.005"	.003 – 0.010"



ISO代码 - 刀片

5	6	7	8	9		10
22	04	08				
22	04	08	E	N	-	M
5	6	7	8	9		10
4	3	2				
4	3	2	E	N	-	M

5 刀片切削刃长度(刀片尺寸)

d=IC (mm)	(in)	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	16
	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												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1″	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4″	10												

6 刀片厚度

	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 刀片刀尖圆角

	RE (mm)	RE (″)
00	0	0″
02	0.2	1/128″
04	0.4	1/64″
08	0.8	1/32″
12	1.2	3/64″
16	1.6	1/16″
24	2.4	3/32″
32	3.2	1/8″

圆刀片

d=I.C.	
(″)	00
(mm)	M0

ANSI

5 内切圆

Symbol	d=I.C. (mm)	d=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″

6 刀片厚度

Symbol	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″

7 刀片刀尖圆角

Symbol	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 刀片切削刃处理类型

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 进给方向

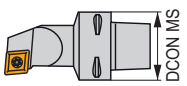
R		N	
L			

10 断屑槽类型

外圆车削刀具 – ISO代码名称

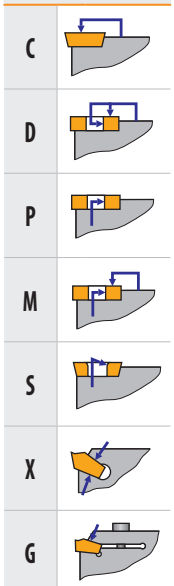
		1		2	3	4	5	6		7	8	11	12		13
刀柄刀具	ISO			P	C	L	N	R	–	32	25	L	12	–	M
件数	ISO	C4	–	D	C	L	N	R	–	27	050		– 12		
刀柄刀具	ANSI			D	C	L	N	R	–	16		4	D		

1 耦合尺寸

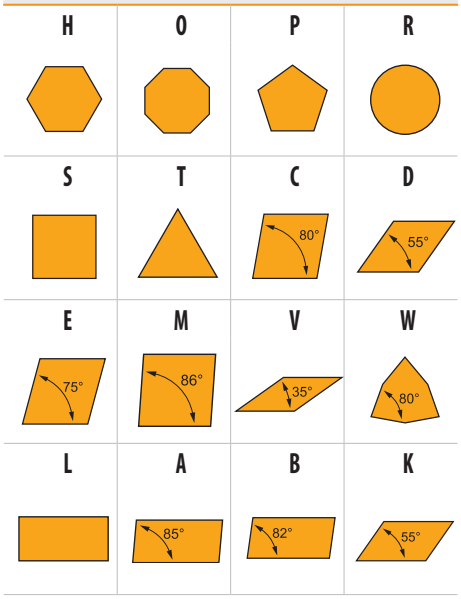


C	DCON MS
C3	32
C4	40
C5	50
C6	63
C8	80

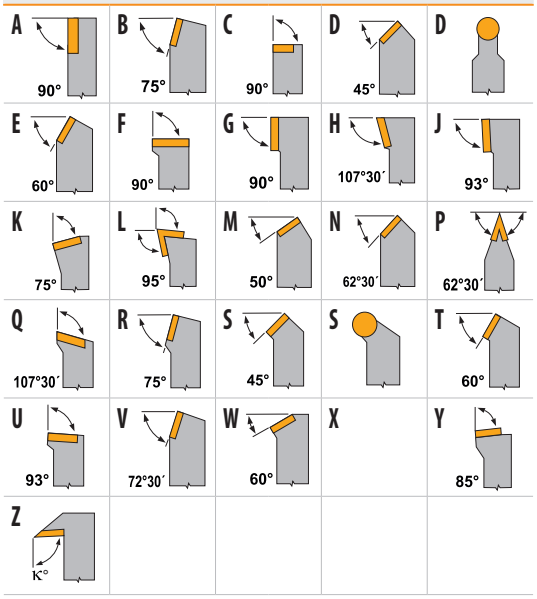
2 夹紧类型



3 ISO代码 - 刀片



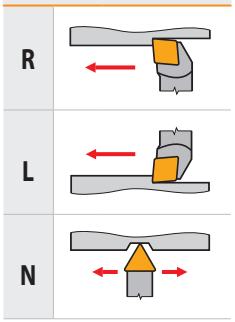
4 刀杆类型 - 主偏角



5 刀片后角

N	B	C	P
0°	5°	7°	11°

6 切削方向



7 刀杆高度 (mm)

08	10	12	16	20	25
32	38	40	45	50	60

8 刀杆宽度 (mm)

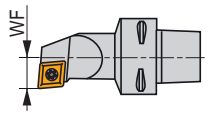
08	10	12	16	20	25
32	38	40	45	50	60

7 & 8 刀杆宽度 & 高度 (”)

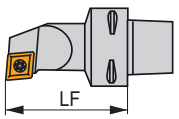
Symbol	B (”)	H (”)
05	5/16”	5/16”
06	3/8”	3/8”
08	1/2”	1/2”
10	5/8”	5/8”
12	3/4”	3/4”
16	1”	1”
85	1”	1 1/4”
86	1”	1 1/2”
20	1 1/4”	1 1/4”
24	1 1/2”	1 1/2”
32	2”	2”

对于方刀杆, 数字为宽度和高度的1/16, 对于矩形刀杆, 第一个数字是宽度的 1/8, 第二个数字是高度的1/4

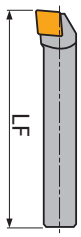
9 功能宽度[mm]



10 功能长度[mm]



11 刀杆总长



	LF (”)
A	4.000”
B	4.500”
C	5.000”
D	6.000”
E	7.000”
F	8.000”
M	4.000”
N	4.500”
R	6.000”
S	7.000”
T	8.000”

	LF [mm]
D	60
E	70
F	80
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	
Y	500

内圆车削刀具 – ISO代码名称

	15	16	17		2	3	4	5	6	12		14
ISO	A	25	T	–	P	C	L	N	L	12	–	X
ANSI	A	16	T	–	D	C	L	N	L	4		

12 / 12 刀片切削刃长度(刀片尺寸)

d = 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	16
	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												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1″	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4″	10												

13 制造类型

M	带垫片的夹紧系统”S”

14 制造类型

X	特殊规格刀柄类型
· ·	
93	Z类型刀杆主偏角
· ·	

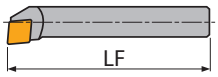
15 / 15 刀杆

S	钢制刀柄
A	带冷却孔钢制刀柄
E	带冷却液孔的硬质合金柄+钢制切削头

16 / 16 刀柄直径[mm]

DCON MS [mm]		DCON MS (″)	
08	8	03	.1875″
10	10	04	.250″
12	12	05	.3125″
16	16	06	.375″
20	20	08	.500″
25	25	10	.625″
32	32	12	.750″
40	40	16	1.000″
50	50	20	1.250″
60	60	24	1.500″
		32	2.000″

17 / 17 刀杆总长



	LF (″)
F	3.250″
H	4.000″
K	5.000″
M	6.000″
P	6.250″
Q	7.250″
R	8.000″
S	10.000″
T	12.000″
U	14.000″
V	15.750″
W	17.750″
Y	20.000″
X	专用

	LF [mm]
D	60
E	70
F	80
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	专用
Y	500

刀头 – ISO代码名称

1	2		3	4	5	6	7
KH	P	–	C	L	N	R	25

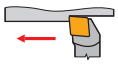
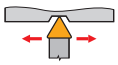
8	6	9	10	11
DKH	R	50	60	W

1 刀夹

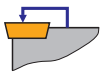
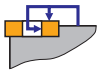
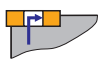
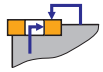
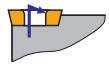
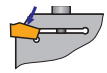
5 刀片后角

N	C	P
0°	7°	11°

6 切削方向

R	
L	
N	

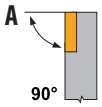
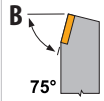
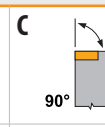
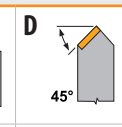
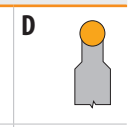
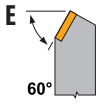
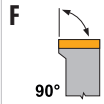
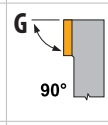
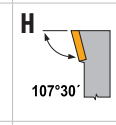
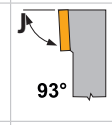
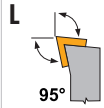
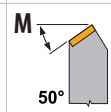
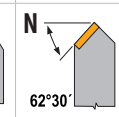
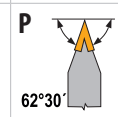
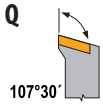
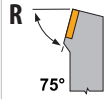
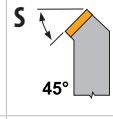
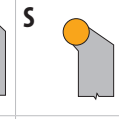
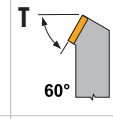
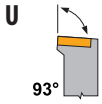
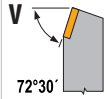
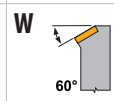
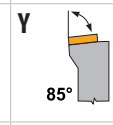
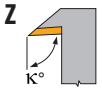
2 夹紧类型

C	
D	
P	
M	
S	
X	
G	

3 ISO代码 - 刀片

S		C	
T		D	
R		K	
W		V	
L		X	Special

4 刀杆类型 - 主偏角

A 	B 	C 	D 	D 
E 	F 	G 	H 	J 
K	L 	M 	N 	P 
Q 	R 	S 	S 	T 
U 	V 	W 	X Special	Y 
Z 				

7 刀片切削刃长度(刀片尺寸)

d=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	16
	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												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1"	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"	10												

8 刀杆

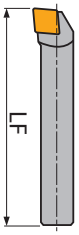
9 刀杆高度 (mm)

08	10	12	16	20	25
32	40	50	60	70	80

10 刀杆宽度 (mm)

08	10	12	16	20	25
32	40	50	60	70	80

11 刀杆总长



	LF (mm)
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	专用
Y	500

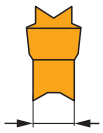
1	2		3	4	5	6	7		8
GL	3	–	D	300	G	02	L06	–	PM

1 刀具组

GL

2 腔尺寸

1, 2, 3, 4, 5, 6



3 切削刃数

S	单刃
D	双刃

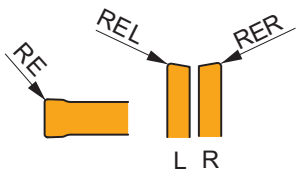
4 切削宽度 - CW

	CW
150	1.50
200	2.00
250	2.50
300	3.00
400	4.00
500	5.00
600	6.00
800	8.00

5 切削刃设计

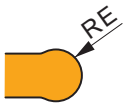
G	精磨刀片
M	压铸刀片

6 刀尖半径



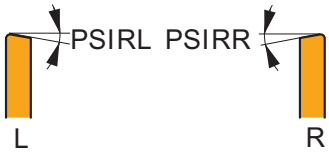
	RE, RER, REL (mm)
015	0.15
02	0.2
03	0.3
04	0.4
08	0.8

圆刃槽型



	RE (mm)
M0	RE = CW/2

7 主偏角



	(°)
06	6
12	12

8 断屑槽名称

PM
PR
GM
MM

切断和切槽刀杆（外圆车削）– GL – 代码名称

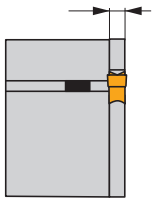
1	2		3	4	5	6	7		8		9	10	11
GL	3	–	S	2525	M	F	R	–	20	–	R	120	090

1 刀具组

GL

2 刀座尺寸

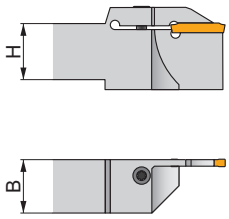
1, 2, 3, 4, 5, 6



3 刀柄类型

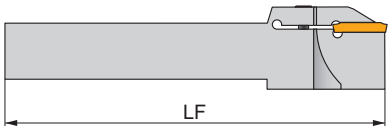
A	带内冷通道的钢制刀柄
S	钢制刀柄，无内冷通道

4 刀杆尺寸



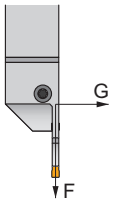
	H × B (mm)
1212 –	12 × 12
1616 –	16 × 16
2020 –	20 × 20
2525 –	25 × 25
3232 –	32 × 32

5 刀杆总长 - LF

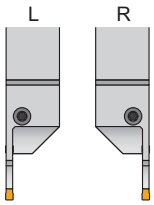


	LF (mm)
H	100
K	125
M	150
P	170

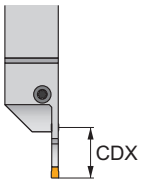
6 刀杆类型 - 主偏角



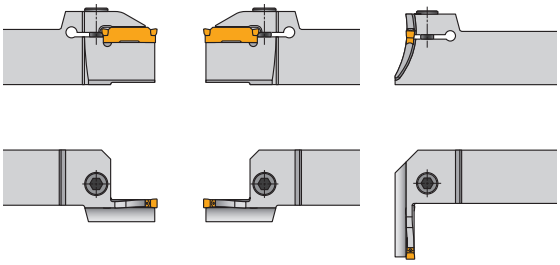
7 刀柄类别（右/左）



8 切削深度最大值 - CDX

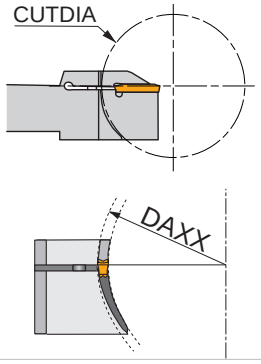


9 刀板曲率方向

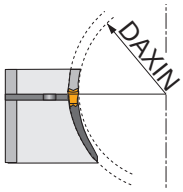


轴向车削的附加信息

10 最大直径



11 最小直径

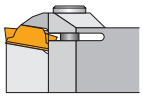


切断和切槽刀具（外圆车削）– ISO代码名称

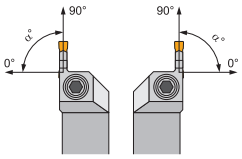
	1	2	3	4	5	6	7	8	9	10	11
ISO	G	F	I	L	25	25	M	0316	R	030	017
ANSI	G	F	I	L	16		D	0316	R	1.18	.670

1 夹紧类型

G



2 刀杆类型 - 主偏角

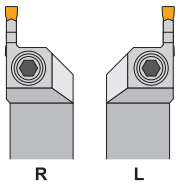


α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°

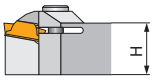
3 最大切削深度 – CDX

G = 2.0 × CW	N = 5.5 × CW
H = 2.5 × CW	O = 6.0 × CW
I = 3.0 × CW	P = 6.5 × CW
J = 3.5 × CW	Q = 7.0 × CW
K = 4.0 × CW	R = 7.5 × CW
L = 4.5 × CW	S = 8.0 × CW
M = 5.0 × CW	T = 8.5 × CW

4 刀柄类别（右/左）

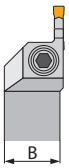


5 刀杆高度 (mm)



12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.

6 刀杆宽度 (mm)



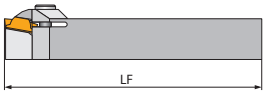
12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.

5 & 6

	B (″)	H (″)
05	5/16″	5/16″
06	3/8″	3/8″
08	1/2″	1/2″
10	5/8″	5/8″
12	3/4″	3/4″
16	1″	1″
85	1″	1 1/4″
86	1″	1 1/2″
20	1 1/4″	1 1/4″
24	1 1/2″	1 1/2″
32	2″	2″

对于方刀杆，数字为宽度和高度的1/16，对于矩形刀杆，第一个数字是宽度的1/8，第二个数字是高度的1/4

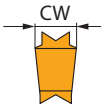
7 刀杆总长



	LF (mm)
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200

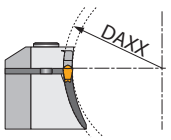
	LF (″)
A	4.000″
B	4.500″
C	5.000″
D	6.000″
E	7.000″
F	8.000″

8 刀片宽度



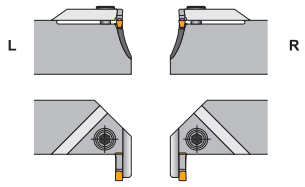
	CW (mm)	CW (″)
02	2.0	.079″
03, 0313, 0316	3.0	.118″
04, 0413, 0416	4.0	.157″
05, 0516	5.0	.197″
06, 0616	6.0	.236″
08, 0830	8.0	.315″

10 最大直径 - 端面槽加工



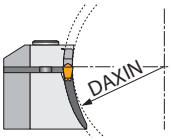
轴向车削的附加信息

9 刀板曲率方向



轴向车削的附加信息

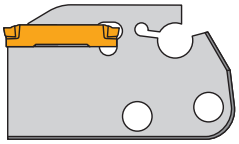
11 最小直径 - 端面槽加工



轴向车削的附加信息

切断和切槽刀片（外圆车削）– GL – 代码名称

1	2		3	4	5	6	7		8
GL	1	–	S	26	K	B	R	–	16

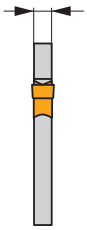


1 刀具组

GL

2 刀座尺寸

1, 2, 3, 4, 5, 6



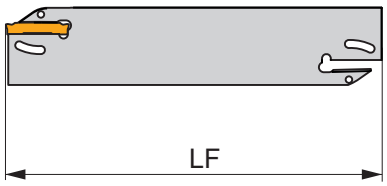
3 刀柄类型

A	带内冷通道的钢制刀柄
S	钢制刀柄，无内冷通道

4 刀杆尺寸

	H (mm)
26	26
29	29
32	32

5 刀板总长 - LF

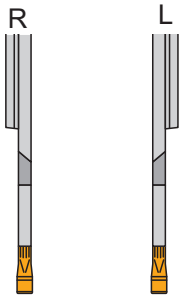


	LF (mm)
C	50
K	125
M	150

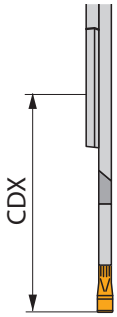
6 刀杆类型

B – 刀片
BS – 模块化刀片

7 刀柄类别（右/左）

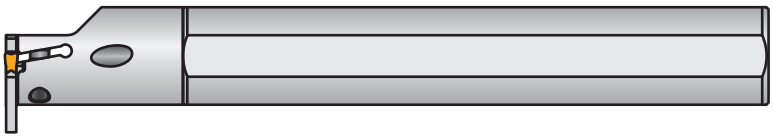


8 切削深度 最大值 - CDX



切断和切槽刀杆（外圆车削）– GL – 代码名称

1	2		3	4	5	6	7		8		9
GL	3	–	A	32	S	G	R	–	12	–	45

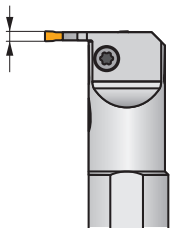


1 刀具组

GL

2 刀座尺寸

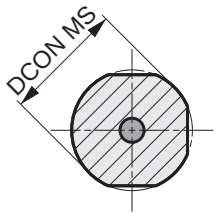
2, 3, 4



3 刀柄类型

A	带内冷通道的钢制刀柄
S	钢制刀柄，无内冷通道

4 刀杆尺寸

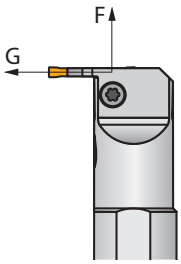


	DCON MS (mm)
25	25
32	32
40	40

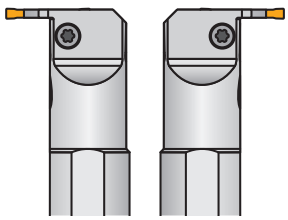
5 刀杆总长 - LF

	LF (mm)
Q	180
S	250
T	300

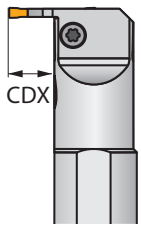
6 刀杆类型 - 主偏角



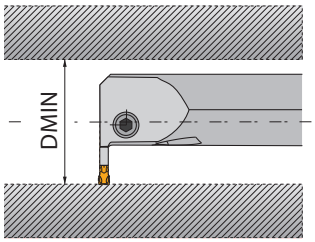
7 刀柄类别（右/左）

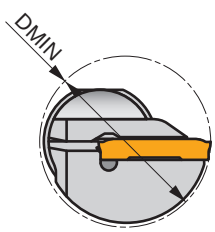


8 切削深度 最大值 - CDX



9 最小直径





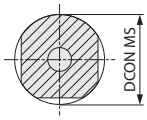
切断和切槽刀具 – 内圆车削 – ISO代码名称

	1	2	3		4	5	6	7	8
ISO	A	25	S	–	G	G	H	L	0313
ANSI	A	16	S	–	G	G	H	L	0313

1 刀杆

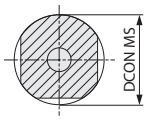
S	钢制刀柄
A	带冷却孔钢制刀柄

2 刀柄直径(公制)



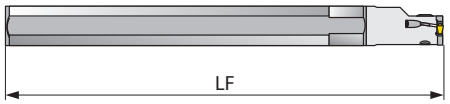
	DCON MS [mm]
12	12
16	16
20	20
25	25
32	32
40	40

2 刀柄直径(公制)



	DCON MS (")
08	.500"
10	.625"
12	.750"
16	1.000"
20	1.250"
24	1.500"

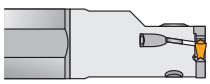
3 刀杆总长



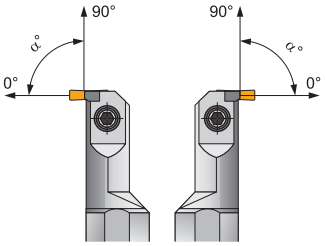
	LF [mm]	LF (")		LF [mm]	LF (")
M	150	6.000"	S	250	10.000"
P	170	6.250"	T	300	12.000"
Q	180	7.250"	U	350	14.000"
R	200	8.000"	V	400	15.750"

4 夹紧类型

G



5 刀杆类型 - 主偏角

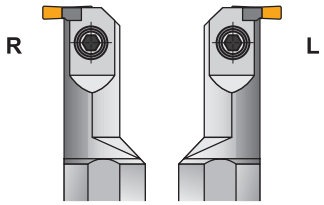


α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°

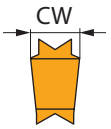
6 最大切削深度 – CDX

E = 1.0 × CW	J = 3.5 × CW
F = 1.5 × CW	K = 4.0 × CW
G = 2.0 × CW	L = 4.5 × CW
H = 2.5 × CW	M = 5.0 × CW
I = 3.0 × CW	N = 5.5 × CW
X = Special	

7 刀柄类别(右/左)



8 刀片宽度

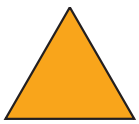


	CW [mm]
0313	3.0
0413	4.0

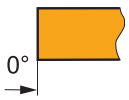
用于螺纹的可转位刀片 – ISO代码名称

	1	2	3	4	5	6	7		8
ISO	T	N	16	E	R	175	M	–	P1
ANSI	T	N	16	E	R	120	W	–	P1

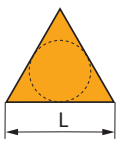
1 ISO代码 - 刀片

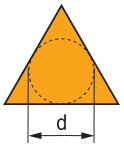
T	

2 刀片后角

N	

3 刀片切削刃长度(刀片尺寸)





L		d = IC	
(mm)	(")	(mm)	(")
11	.433"	**6,350**	1/4"
16	.650"	**9,525**	3/8"
22	.866"	**12,7**	1/2"

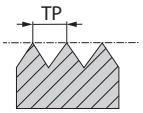
4 外圆 - 内孔

E	外圆
N	内孔

5 切削方向

R	右手
L	左手
N	Neutral

6 螺距



s × 100

螺距 **mm × 100**

6 螺纹数

英制螺纹数 × **10**

7 螺纹牙型

M	公制螺纹60°	TR	TR 30° ISO 2901/3–1977
MJ	SEA MA1370	UN	美制螺纹60° ISO 5864–1978
W	惠式螺纹55° ISO 228–1982	UNJ	SEA AS8879
RD	圆齿螺纹30°	ACME	ACME螺纹29° ANSI B1.5–1988
BSPT	ISO 228/1 35 21 1959 ISO 7/1	STACME	ASME/ANSI B1.8-1988
NPT	ANSI B1.1–1983	API RD	API

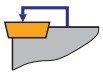
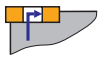
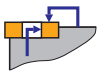
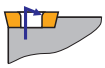
8 断屑槽类型

P1	压制
AL	用于有色金属

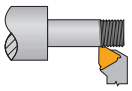
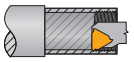
ISO代码名称 - 螺纹刀杆

	1	2	3		4	5	6	7		8
ISO	S	E	R	–	S	2525	M	16	–	
ANSI	S	E	R	–	S	16	D	16	–	

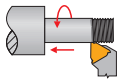
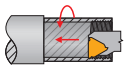
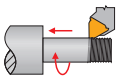
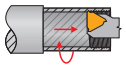
1 夹紧类型

C	
P	
M	
S	

2 加工方式

E	外圆	
I	内孔	

3 切削方向

R	右手	外圆	
		内孔	
L	左手	外圆	
		内孔	

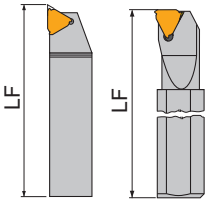
4 结构类型

–	标准
S	非标

5 尺寸 (mm)

外圆车削	2525	25 × 25 mm
内孔车削	1416	内孔车削 – 14 mm 刀杆高度 Ø – 16 mm

6 刀杆总长 (mm)

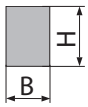


	LF (mm)
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300

7 刀片切削刃长度(刀片尺寸)

d = IC [mm]	d = IC (")	T
6.350	1/4"	11
9.525	3/8"	16
12.700	1/2"	22

5 尺寸 (")

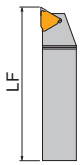


	B (")	H (")
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"

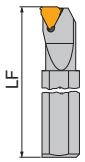
	DCON (")
08	.500"
10	.625"
12	.750"
16	1.000"
20	1.250"
24	1.500"

对于方刀杆, 数字为宽度和高度的1/16, 对于
矩形刀杆, 第一个数字是宽度的1/8, 第二个
数字是高度的1/4

6 刀杆总长 (")



	LF (")
C	5.000"
D	6.000"
E	7.000"
F	8.000"



	LF (")
K	5.000"
M	6.000"
P	6.250"
Q	7.250"
R	8.000"
S	10.000"
T	12.000"
U	14.000"

8 螺旋升角 λ

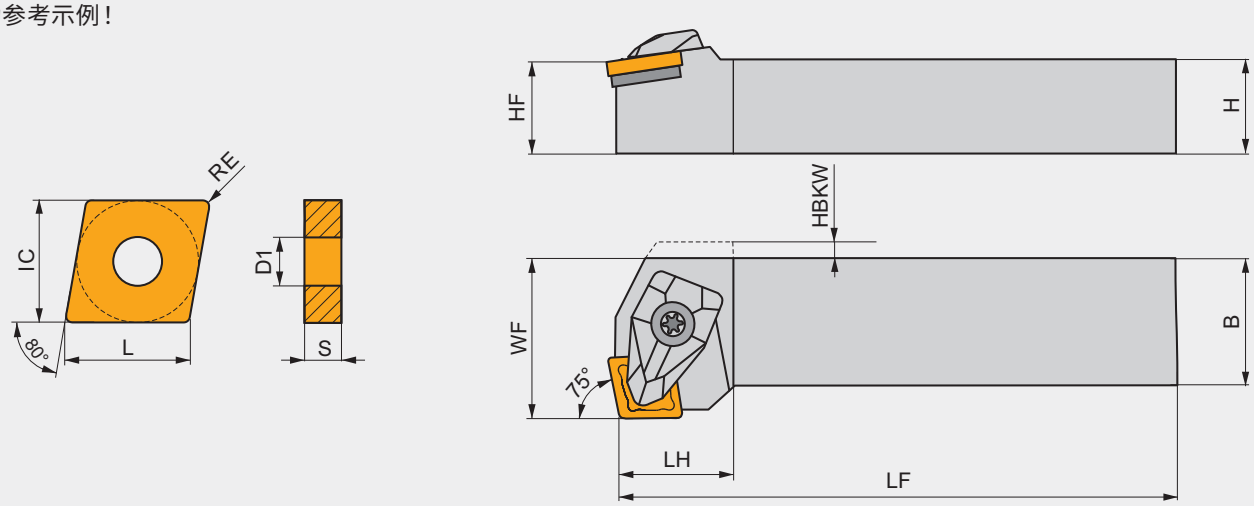
0	螺旋升角 λ = 0°
1	螺旋升角 λ = 1°
2	螺旋升角e λ = 2°

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。

仅作为参考示例！



ISO 13399	描述
APMX	最大切削深度
B	刀柄宽度
BD	刀体直径
BLRAD	刀片加强刀尖半径
BW	刀片主体宽度
CDX	最大切削深度
CND	冷却剂入口直径
CUTDIA	工件最大切断直径
CW	切削宽度
CWTOLL	切削宽度下公差
CWTOLU	切削宽度上公差
D1	固定孔直径
DAXIN	轴向槽最小内径
DAXN	轴向槽最小外径
DAXX	轴向槽最大外径
DCON MS	接头直径
DMIN	最小孔径
DMINP	最小垂直孔径
GAMO	正交前角
GAMP	轴向前角
H	刀柄高度
HBH	刀头底部偏移高度
HBKW	刀头底部偏移宽度
HF	功能高度
IC	内切圆直径
INSD	刀片直径
INSL	刀片长度

ISO 13399	描述
KAPR	刀具主偏角
L	切削刃长度
LAMS	倾斜角
LB	刀体长度
LF	功能长度
LFA	功能长度上的A尺寸
LFS	次要功能长度
LH	刀头长度
LU	有效长度
M	M-尺寸
OAL	总长度
PDX	轮廓距离X
PDY	轮廓距离Y
PSIRL	左侧刀具导程角
PSIRR	右手主切削刃角
RE	刀尖半径
S	刀片厚度
S1	刀片总厚度
TP	螺纹螺距
TPI	每英寸螺纹牙数
TPIN	每英寸最小螺纹牙数
TPIX	每英寸最大螺纹牙数
TPN	最小螺距
TPX	最大螺距
W1	刀片宽度
WF	工作宽度
WFS	次要工作宽度

T	9	4	1	5
运行	涂层 / 材质	升级序号	ISO	

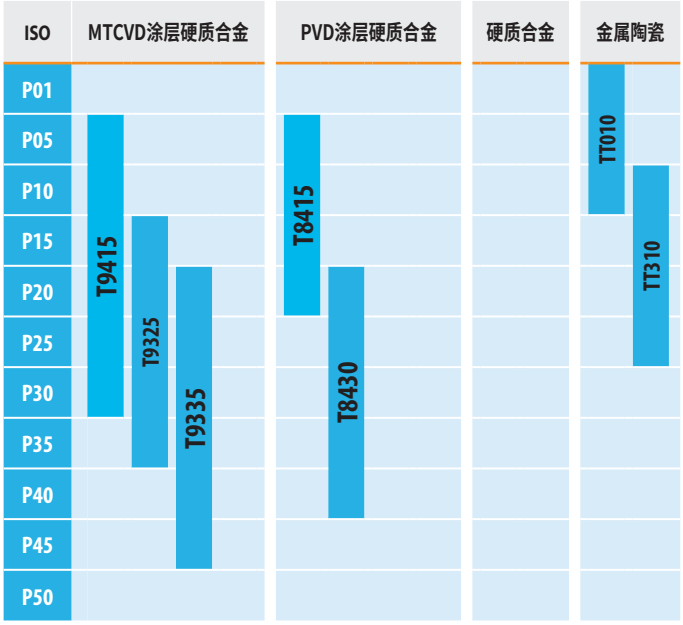
D	钻削
M	铣削
T	车削
G	切槽和切断

0 PVD 1 CVD	特殊应用
2 PVD 3 CVD	自由代码
4 PVD 5 CVD	难加工材料 K, H
6 PVD 7 CVD	难加工材料 M, S
8 PVD 9 CVD	通用
B	CBN
C	陶瓷
D	PCD
T	金属陶瓷

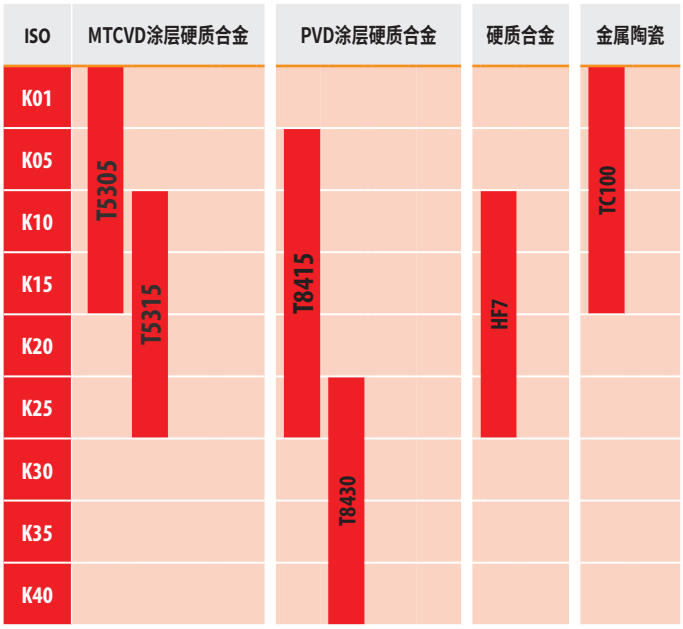
1 – 9

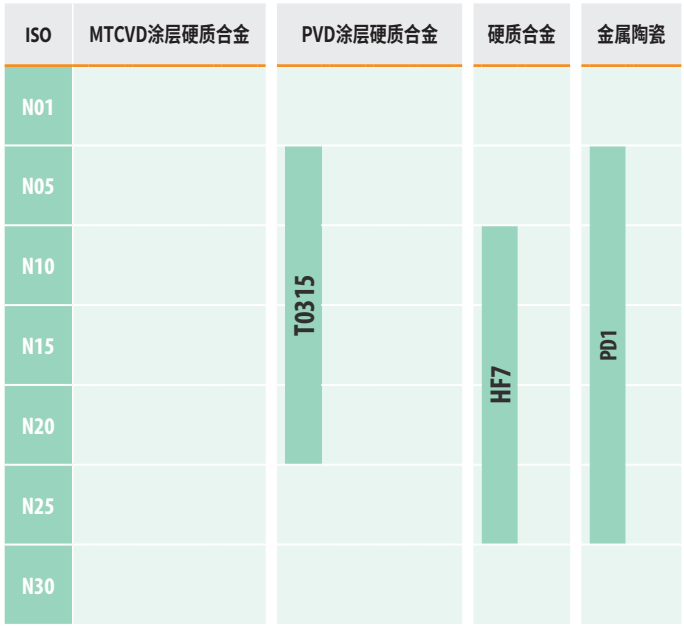
	01 – 50
	01 – 05
	05 – 10
	10 – 20
	20 – 30
	30 – 40
	40 – 50

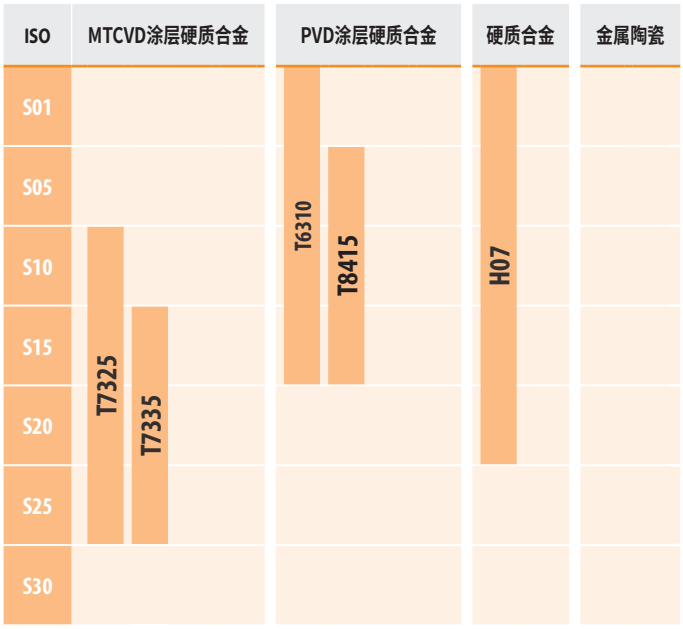
车削材质 – 导航工具

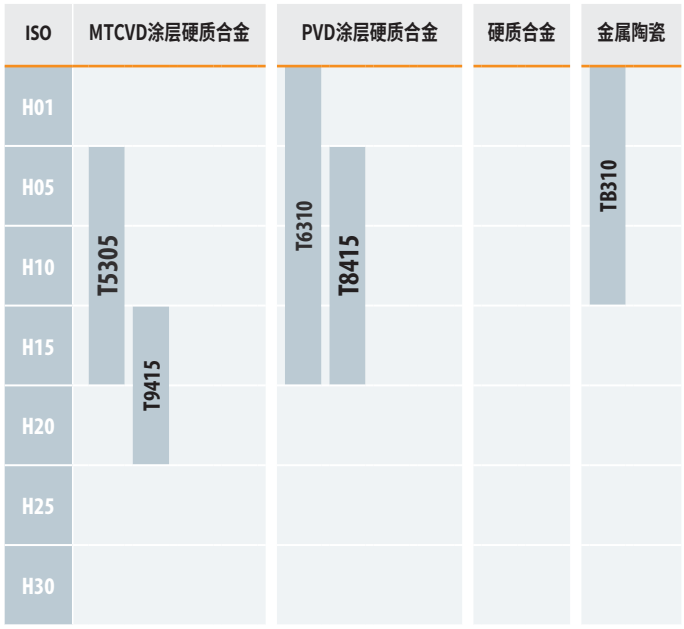

ISO
MTCVD涂层硬质合金
PVD涂层硬质合金
硬质合金
金属陶瓷
P01
P05
P10
P15
P20
P25
P30
P35
P40
P45
P50
T9415
T9325
T9335
T8415
T8430
TT010
TT310

ISO
MTCVD涂层硬质合金
PVD涂层硬质合金
硬质合金
金属陶瓷
M01
M05
M10
M15
M20
M25
M30
M35
M40
T7325
T7335
T8415
T8430


ISO
MTCVD涂层硬质合金
PVD涂层硬质合金
硬质合金
金属陶瓷
K01
K05
K10
K15
K20
K25
K30
K35
K40
T5305
T5315
T8415
T8430
HF7
TC100


ISO
MTCVD涂层硬质合金
PVD涂层硬质合金
硬质合金
金属陶瓷
N01
N05
N10
N15
N20
N25
N30
T0315
HF7
PD1


ISO
MTCVD涂层硬质合金
PVD涂层硬质合金
硬质合金
金属陶瓷
S01
S05
S10
S15
S20
S25
S30
T7325
T7335
T6310
T8415
H07


ISO
MTCVD涂层硬质合金
PVD涂层硬质合金
硬质合金
金属陶瓷
H01
H05
H10
H15
H20
H25
H30
T5305
T9415
T6310
T8415
TB310

CVD 车材质

材质识别	应用范围	应用	进给	线速度	耐受不利工况	涂层	颜色	基材	冷却优势	材质说明
T9415 NEW	P05 - P30	■				MT-CVD		FGM	+ +	材质极其耐磨，主要用于普通碳素钢和合金钢的精车。虽然它具有很高的耐磨性，但也适用于间断切削加工。我们建议大多数车削操作将这种材质作为首选，尤其是大批量的应用。
	K05 - K25	◪								
	H10 - H20	◪								
T9310	P01 - P15	■				MT-CVD		FGM	+ +	具有高耐磨性的材质，用于轻微断续切削。可进行精加工或半精加工操作。如果机床-刀具-工件系统结构具有足够的刚度，也可将该材料用于粗加工操作。
	K05 - K20	◪								
	H10 - H20	◪								
T9315	P05 - P25	■				MT-CVD		FGM	+ +	多用途材质，即使在苛刻切削工况下也具有出色的耐磨性能。也可以用于断续切削操作。
	K05 - K25	◪								
	H10 - H20	◪								
T9325	P15 - P35	■				MT-CVD		FGM	+ +	从技术角度来看，这是一种用途极为广泛的材质，在不利切削工况下也具有较高的抗机械损伤能力，并保持出色的耐磨性。该材料的正确应用要求高线速度。
	M10 - M30	■								
	K15 - K35	◪								
	S10 - S20	◪								
T9335	P20 - P45	■				MT-CVD		FGM	+ + +	最坚韧的材质之一，尤其适合采用中高进给以及中等线速度的不利切削工况。M15 – M40比前代产品更坚韧，也更耐磨，适合密集切削工况。
	M15 - M40	■								
	S15 - S25	◪								
T9226	P15 - P35	■				MT-CVD		FGM	+ + +	此材质设计用于重载粗加工，是抗机械损坏性能和耐磨性均很高的多用途材质。不适用线速度较低的情况。
	M10 - M30	■								
	K15 - K35	◪								
	S15 - S25	□								
T7325	P15 - P35	◪				MT-CVD		FGM	+ + +	用途最广泛的车削材质之一，专门设计用于不锈钢加工。耐磨性与性能可靠性之间实现了最佳平衡。广泛应用于各类车削作业。
	M10 - M25	■								
	S10 - S25	■								
T7335	P20 - P40	◪				MT-CVD		FGM	+ + +	带功能梯度型基体的材质，具有极高的工作可靠性和出色的耐磨性。最适合切削韧性极强的M20 – M40材料。
	M20 - M40	■								
	S15 - S25	■								
T5305	P05 - P15	◪				MT-CVD		H	+	具有极高耐化学磨损性质的材质；适用于高线速度下的精加工操作。由于耐磨性高，也适合对硬化材料及经过处理的材料进行K01 – K15生产加工。
	K01 - K15	■								
	H05 - H15	◪								
T5315	P10 - P25	◪				MT-CVD		H	+	此材质主要用于生产加工，具有高耐磨性和良好的工作可靠性。该材料因其特性而特别适合在良好或轻微不良切削条件下进行粗加工和精加工操作。
	K10 - K25	■								
	H15 - H25	◪								
6640	P20 - P40	■				MT-CVD		H	+ + +	最坚韧的车削材料之一，尤其适用于粗加工操作，或适用于不良切削条件下要求保证使用可靠性的情况，低线速度至中等线速度以及中-高进给率条件下的另一理想选择。
	M20 - M35	■								
	K25 - K40	■								

PVD 车削品级

材质识别	应用范围	应用	进给	线速度	耐受不利工况	涂层	颜色	基材	冷却优势	材质说明
T8415 NEW	P05 - P20 M05 - M20 K05 - K25 N05 - N25 S05 - S15 H05 - H15	■ ■ ■ ◪ ■ ■				PVD		submicron H	+ +	这是一种多功能、高性能的车削材质，主要用于钢材加工，但也非常适合不锈钢和耐热合金 (HRSA)，可能还适用于淬硬钢。它适合在较宽的线速度范围、轻载到中等的进给量和良好的切削条件下进行加工，最好使用冷却液。
T8315	P05 - P20 M05 - M20 K05 - K25 N05 - N25 S05 - S15 H05 - H15	◪ ■ ■ ■ ◪ ■				PVD		submicron H	+ +	此材质具有出色的耐磨性，同时保持高于平均水平的工作可靠性，适合以中高线速度加工短屑硬质材料。
T8430	P20 - P40 M20 - M35 K25 - K40 N15 - N30 S15 - S25 H15 - H25	■ ■ ◪ ◪ ◪ ◪				PVD		submicron H	+ + +	应用最广泛的切削材料，可用于加工所有类型的加工材料，适用于几乎所有类型的车削操作。其主要优点在于高水平的使用可靠性和极佳的摩擦特性，因此适合于中等和低速切削加工。
T8345	P30 - P50 M20 - M40 K30 - K40 S20 - S30	■ ◪ ◪ ◪			+	PVD		submicron H	+ + +	最坚韧的车削材质，主要适用于苛刻的切削工况以及对工作可靠性要求极高的应用。根据材料特性，建议将其用于低速切削。
T6310	P01 - P15 M01 - M15 K05 - K20 N05 - N20 S01 - S15 H01 - H15	■ ■ ■ ■ ■ ■				PVD		ultra submicron H	+ + +	具有高耐磨性的车削材质，带PVD外涂层。适用于非常重视切削刃锋利度和后刀面磨损性的精加工操作和应用
T0315	N05 - N20	■				PVD		submicron H	+ +	亚微细颗粒度材质，用于车削有色金属及其合金，兼具耐磨性与韧性。其独特涂层具有出色的摩擦特性。
G8330	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25	■ ■ ■ ◪ ◪				PVD		submicron H	+ + +	通用切削材质，用于切槽和切断操作。该材质的特点是具有卓越的可靠性和通用性。为适应大多数工件材料的加工工况而开发。
T8330	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25 H15 - H25	■ ■ ■ ◪ ◪ ◪				PVD		submicron H	+ + +	应用最广泛的切削材料，可用于加工所有类型的加工材料，适用于几乎所有类型的车削操作。其主要优点在于高水平的使用可靠性和极佳的摩擦特性，因此适合于中等和低速切削加工。
T8010	P05 - P15 M05 - M15 K10 - K20 S10 - S15	■ ■ ■ ◪				PVD		submicron H	+ + +	该材质适用于钢、不锈钢、铸铁、高温合金的连续高精度螺纹车削。提供出色的耐磨性，同时确保操作可靠性
T8030	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25	■ ■ ■ ◪ ◪				PVD		submicron H	+ + +	它无疑是最通用的材质，适合加工所有类型的材料，并且可以应用于几乎所有车削作业。其主要优点是高操作可靠性和出色的摩擦性能；因此适合中低线速度车削应用。

其他 车削品级 车

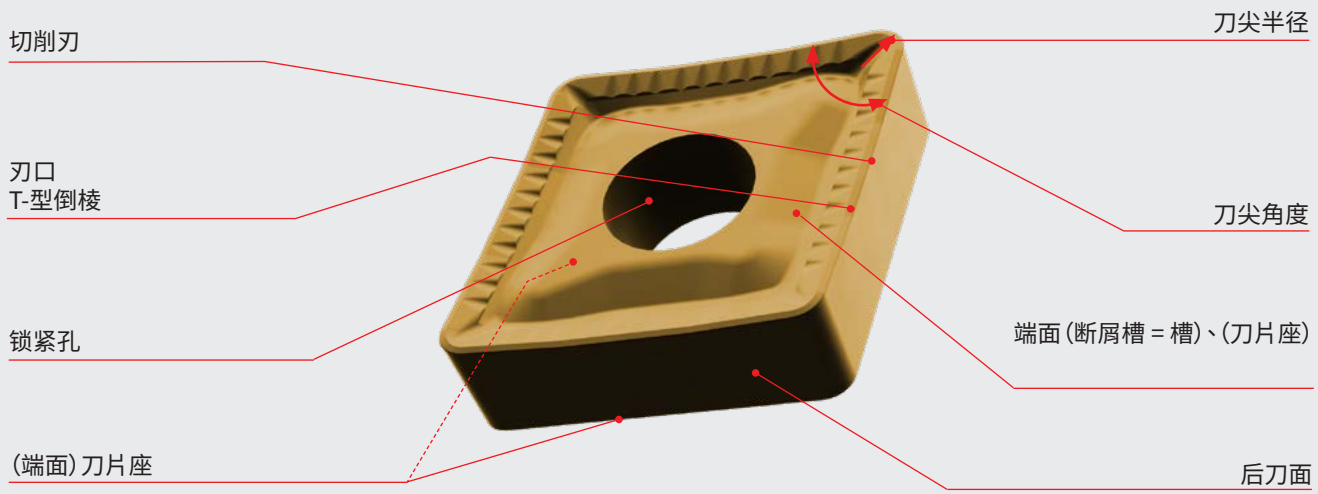
材质识别	应用范围	应用	进给	线速度	耐受不利工况	涂层	颜色	基材	冷却优势	材质说明
HF7	M10 - M20 K10 - K25 N10 - N25	◪ ■ ■				×		submicron H	+ +	无涂层材质，主要用于加工有色金属；也可用于加工其他材料（钢除外）。该材料可用于切削、铣削甚至钻孔。
H07	M05 - M15 K10 - K25 N10 - N30 S01 - S20	◪ ■ ■ ■				×		submicron H	+ +	无涂层车削材质，适用于抗氧化性不作为刀具寿命主要标准的加工应用。设计用于加工钛基合金，兼具高切削刃强度以及良好的耐磨性。
TT310	P10 - P25 M15 - M25	■ ◪				PVD		cermet	+ / -	带涂层的金属陶瓷，适用于对碳和合金钢（包括不锈钢）进行超精加工及精车操作。PVD涂层进一步提升了其出色的摩擦特性。
TT010	P01 - P10 M01 - M10	■ ◪				×		cermet	+ / -	不带涂层的金属陶瓷，适用于对所有类型的钢（包括不锈钢）以极低进给率进行精加工。其主要优点是切削刃半径最小，并具有出色的抗物理和化学磨损特性。
TC100	K01 - K15	■				×		ceramics	- -	用于铸铁加工的陶瓷材质。适合稳定条件下的高线速度加工。
TB310	K01 - K10 S05 - S10 H01 - H10	■ ◪ ◪				×		CBN	- -	用于加工硬化材料的CBN材质。适合稳定条件下的高线速度、小进给量加工。
PD1	N05 - N25	■				×		PCD	-	用于车削有色金属材料的PKD材质。稳定条件下进行高线速度、小进给量加工的理想之选。
333TN	P45 - P50 M35 - M40 K35 - K40	■ ◪ ◪				PVD		HSS	+ + +	由高速钢基体和薄而硬的PVD涂层组成的专用材质。是产品组合中最坚韧的切削材质。该材质的刀片是唯一用于键槽开槽的产品。

基体	
H	WC-Co基体
submicron H	WC-Co基体, 细颗粒度 (< 1 µm)
ultra submicron H	WC-Co基体,极细颗粒度 (< 0,5 µm)
FGM	功能梯度基体
Cermet	无WC金属陶瓷
ceramics	陶瓷
PCD	多晶金刚石
CBN	立方碳化硼
HSS	高速钢

涂层	
MT-CVD	中温CVD涂层
PVD	物理涂层
×	无涂层材质

切削液的优点	
+ + +	必须使用冷却剂
+ +	强烈建议使用冷却剂
+	建议使用冷却剂
+ / –	选择使用冷却剂
– -	不使用冷却剂
–	不建议使用冷却剂

刀片部分



刀尖圆角 – 在大多数情况下决定着建议的最小切削深度以及进给和可达到的粗糙度。
切削刃，端面与后刀面的相交线。其纵向粗糙度是评价刀片的首要标准之一。
刀尖角度对于可用切削刃长度、断续切削阻力、切削点散热等非常重要。
刃口T-型倒棱是位于切削刃后的区域。其宽度通常可变，并且其角度也有规律地变化。在大多数情况下，倒棱的宽度以及刀片工作点的调节角度限制着规定的最小进给量。
断屑槽 – 与倒棱一起确定应用区域（窄槽 – 精加工和短切屑材料；宽槽 – 主要用于粗加工操作和难加工材料）。
锁紧孔 – 如果没有孔，则刀片无疑为ISO C夹紧机构而设计。如果是圆柱形孔，则刀片是为ISO P、M、D + 夹紧机构而设计（在几乎所有情况下，刀片后角角度为0°。如果是喇叭形孔，并且后刀面角为正角，则为单面刀片，专为ISO S夹紧机构而设计。如果是圆锥形孔，并且刀片两侧相同，很有可能是切向刀片（双面刀片）。
刀片座 – 如果两个表面是相同的槽型，是双面刀片，如果槽型不同，则是单面刀片。必须根据预计载荷或切削类型对其进行评估。（半径和切削刃的尺寸和距离）。

刀架部分

车刀包括两个基本部件：

1）刀体，包含：
- 刀座表面
- 夹紧面
- 侧表面（可利用调节螺钉进一步提供）

注意：　对于外圆车削，刀杆体通常是方形横截面（方形或矩形）。对于内圆车削，刀杆体的横截面为圆形，对于更大的横截面，提供调节表面。但刀杆体也可能由特殊类型的刀柄形成，例如CAPTO（PSC）或HSK

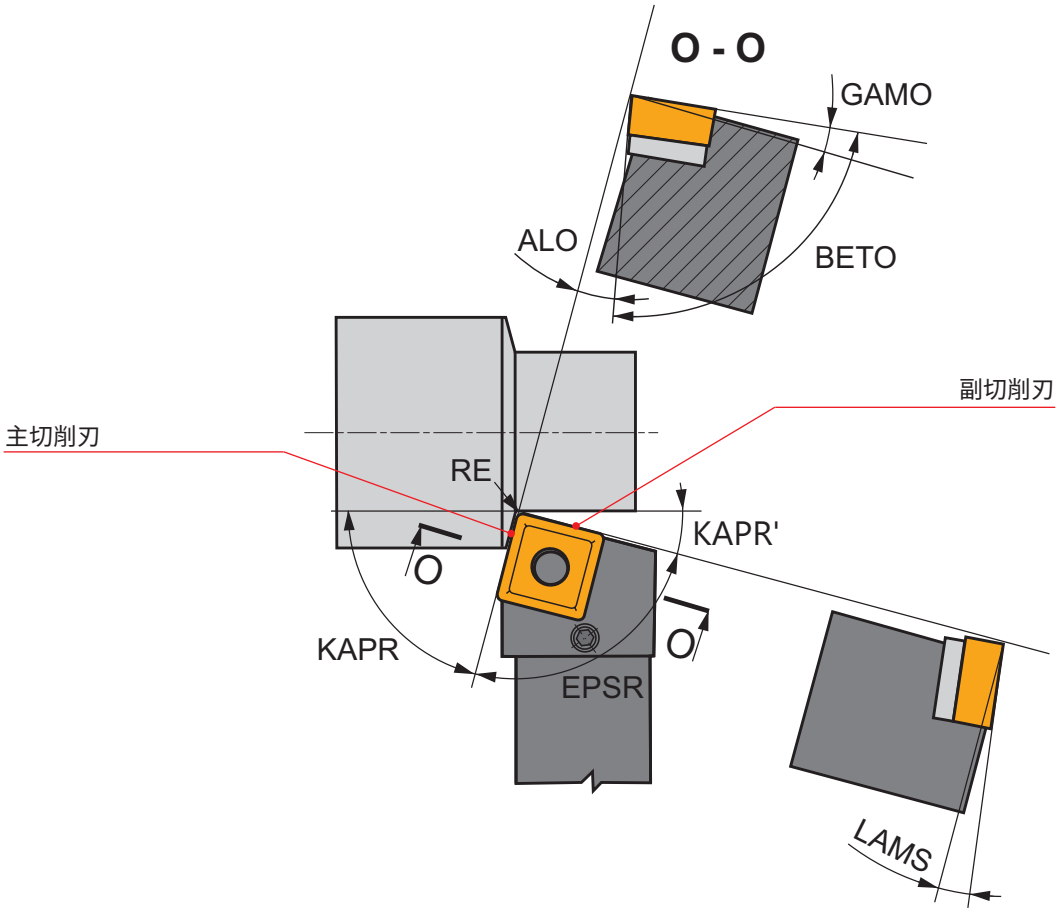
2）刀头，带有：
- 端面
- 后刀面

刀杆头也包含夹紧机构，刀片插入夹紧机构中。
可能从端面侧（径向刀片）或从后刀面侧（切向刀片）插入
备注：刀头类型包括：
- 直型 – 允许双向车削
- 侧型 – 左右设计不同
- 弯型 – 左右设计不同（当车削更复杂的表面时能够更好地接近工件）

车刀的工作角度和结构角度

切削刃相对于工件的位置和方向及其几何形状决定着切削角度的特性。
切削刃上的角度通过一个双坐标系统确定：
a）设计
b）工作

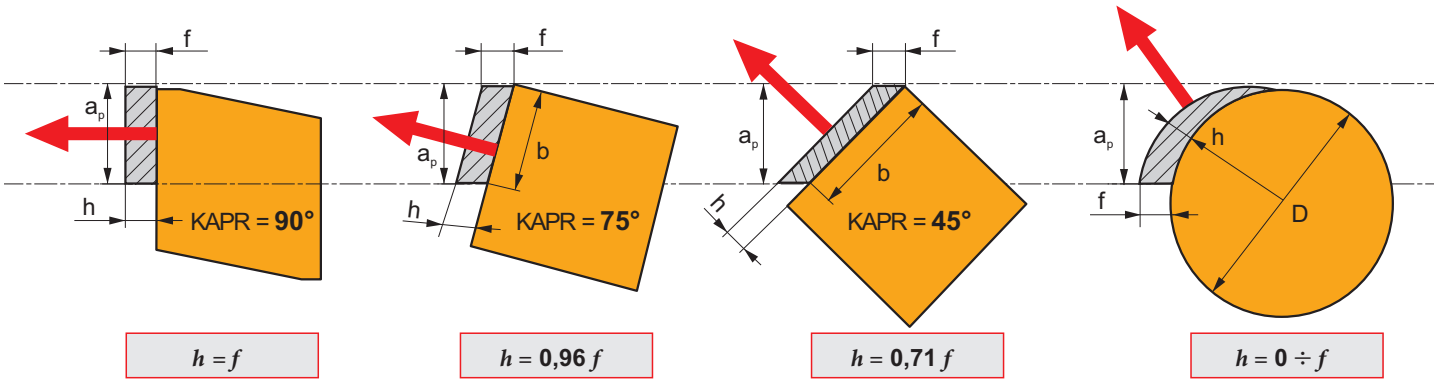
a）刀具坐标系统（固定），用于在设计、生产和检查时确定切削刃槽型。在此系统内定义的所有角度都称为刀具切削角度。按照刀片形状用ISO标准定义的所有角度均属于此分组。



b) 工作坐标系统，用于在加工过程中确定切削刃槽型。这些角度被称为工作角度，取决于刀片夹入刀杆的位置。例如，刀片SNUN ..... 有一个刀具隙角AN = 0°和一个前角*GAMP* = 0°，而刀片被夹紧在刀杆中会形成一个工作隙角ALO=6°和一个工作前角*GAMO*=-6°。工作角度影响着带有预成型断屑槽的刀具角度。但最重要的是切削过程中的工作角度。

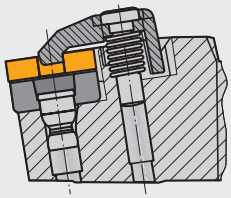
基本刀具角度在图中的刀具基础平面（与刀杆支承面相交）和刀具法平面（与切削刃 – 切削面O-O相交）中标示。
其中比较重要的角度有：
前角 *GAMO* – 对切削过程有重大影响。该角度的大小决定着切屑成形过程中塑性变形过程的进展和强度；还决定着切削力的大小和作用在切削刃上的热应力。前角的范围很大，对于带有可转位刀片的铣削和车削刀具，*GAMO*在+25°和-15°之间。正前角能够改善切屑形成条件，减小切削力，降低切削温度。负前角能够提高切削刃的强度，但会增加切屑形成时的塑性变形，因而也会使得切削力和温度相应升高。

隙角*ALO*影响着后刀面与加工面之间的摩擦值。加大隙角*ALO*可减少摩擦，并能因此减少后刀面磨损。
楔角 *BETO*为刀片夹角。加大角度BETO可提高切削刃的强度（抗冲击强度），但也会增加切削阻力。
主切削刃的倾斜角*LAMS* – 决定着切削刃和工件间的第一接触点，对于断续切削非常重要。如果*LAMS*为正，接触点靠近刀尖。如果*LAMS*为负，则第一接触点远离刀尖，因此会影响切削刃抵抗机械应力的能力。此外，LAMS还影响着排屑的方向。如果LAMS为负，排屑方向朝向已加工表面。而如果LAMS为正，排屑方向背向已加工表面。
主切削刃的主偏角 *KAPR*对切削力大小和切屑的截面形状有重要影响。在给定进给f和切削深度a_p下，减小角度KAPR可令切屑更薄。而如果*KAPR*为90°，切屑厚度$h = f$，且切屑宽度$b = a_p$更大。主偏角越小，倒棱工作宽度越大，并且刀片前角减小。
小切削刃的主偏角*KAPR´* 以及刀尖圆角RE决定着最终表面质量。



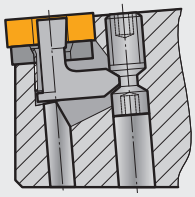
根据夹紧技术选择刀杆

PRAMET TOOLS提供的产品包括刀杆、可调节刀杆、转塔刀头，以及用于外圆或内圆纵向车削、端面车削、仿形车削的可调节刀杆。根据刀片夹紧机构，刀杆被分为六组，具体请见下文的示意图及简介。



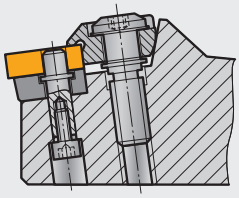
ISO D

这是用于夹紧带圆柱孔的负极刀片的最坚固的系统。刀片只通过一个特殊的夹具固定在刀槽中，夹具与刀片的孔配合，将刀片向下推，同时顶住刀槽的后端面。这种系统的缺点也是夹钳，可能会造成排屑问题。因此，这种夹头特别适用于刀具动态应力较大的外圆加工。



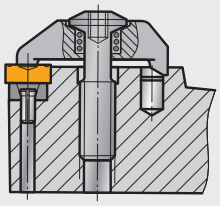
ISO P

此系统用于夹紧带圆柱形孔的负前角刀片，带容屑结构和/或不带容屑结构的刀片均适用。拧紧将刀片压入刀杆床的螺钉后，用一根角杆令刀片完全夹紧。带有这种刀片夹紧机构的刀杆可确保刀片被可靠、精确地夹紧。其性能非常出色，在外圆车削精加工和粗加工中最为常用。此类夹紧系统也可以用于大直径内孔车削刀杆。



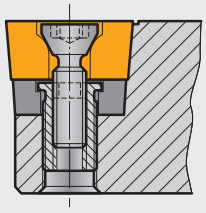
ISO M

此系统用于夹紧与ISO P系统类型相同的刀片。在这种情况下，刀片被固定在一个高强度销上，被一个夹钳压紧，该夹钳同时也固定住刀片顶部。这种夹紧机构主要适用于预计承受更强动态载荷的刀杆。这些刀杆几乎专门用于外圆车削。



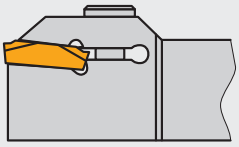
ISO C

此系统用于夹紧无孔的负前角刀片和正前角刀，即带有容屑机构（预压紧、研磨和侧压紧）和不带容屑机构的刀片。刀片通过一个螺钉固定的夹子固定在刀杆床上，某些类型的刀片下方还嵌有一个侧压容屑机构。带有此类夹紧机构的刀杆用于外表面和内表面加工。如今C型夹紧机构的重要性越来越低，尤其是在内圆车削刀具中，已被优点更多的S型夹紧机构所取代。



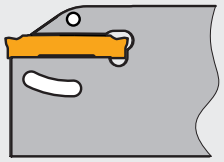
ISO S

这种夹紧机构主要用于针对外圆车削和内圆车削（钻孔）设计的小横截面刀具。在这种情况下，用一个贯穿刀片锥孔的专用螺钉进行夹紧。拧紧该螺钉，刀片将被固定在刀具床上。并且，切屑流不会受到阻碍，因此这种解决方案非常便捷。



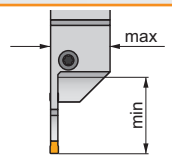
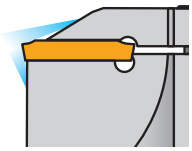
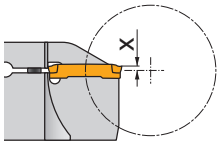
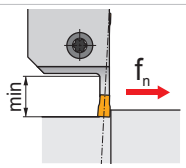
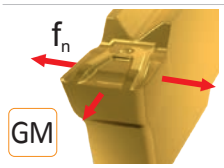
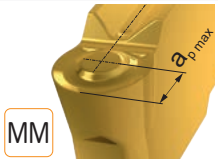
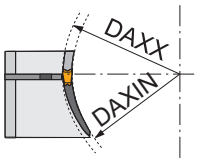
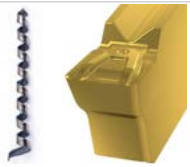
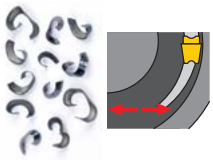
ISO G

此夹紧机构用于切槽刀具以及仿形车削刀具（CTP系统）。刀片通过夹紧机构从顶部推入刀杆床。通过用线速度进给部件阻止刀片移动，形成刀杆、夹紧装置和刀片上的接触表面。



ISO X

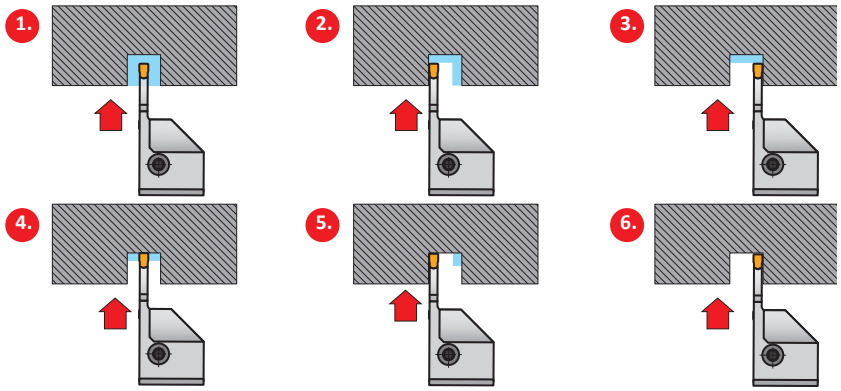
此标志代表采用专用夹紧机构的刀具（即各刀具制造商和供应商所提供的产品并不相同）。在我们提供的产品中，利用切削阻力将刀片夹紧至自锁床的刀杆均带有此标志。此夹紧机构用于切断和开槽刀具。

示例	建议
	选择具有最大允许截面、最小允许悬伸和CDX（最大切削深度）的刀架，以消除振动。
	将充足的冷却液直接应用至切削刃上可以降低切削刃和刀座的温度，从而延长刀具寿命。
	在进行切断或深切槽加工时，建议将切削刃设置得略高于工件轴线，以减少振动。
	对于切断或深切槽加工，使用PM或PR断屑槽，这两种断屑槽都能形成理想的螺旋形切屑。
	进行轴向车削时，建议使用CDX（最大切削深度）尽可能小的刀具，以减少刀具的振动和偏转。
	对于轴向车削加工，使用GM切屑槽，该切屑槽在切削刃的前部和两侧具有合适槽型。
	当使用MM断屑槽进行仿形车削时，最大切削深度为槽型直径的50%。
	对于内孔开槽加工，仅使用GM和MM断屑槽，以形成理想的短切屑。
	进行端面切槽时，必须选择直径范围与待加工的第一槽正确匹配的刀架。
	对于深端面切槽加工，仅使用GM断屑槽，以形成理想的长螺旋切屑，从而避免其卡在端面槽内。
	对于端面车削和仿形加工，仅使用GM和MM断屑槽，以形成理想的短切屑。

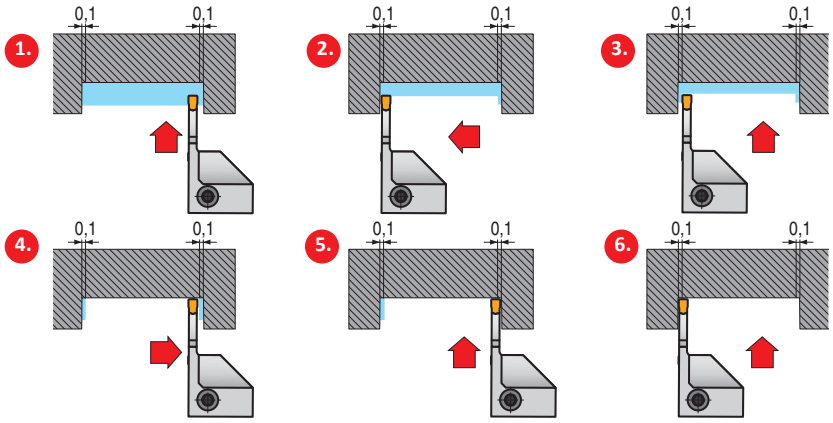
实际使用推荐：

车削凹槽的步骤（加深和加宽）如下图所示。

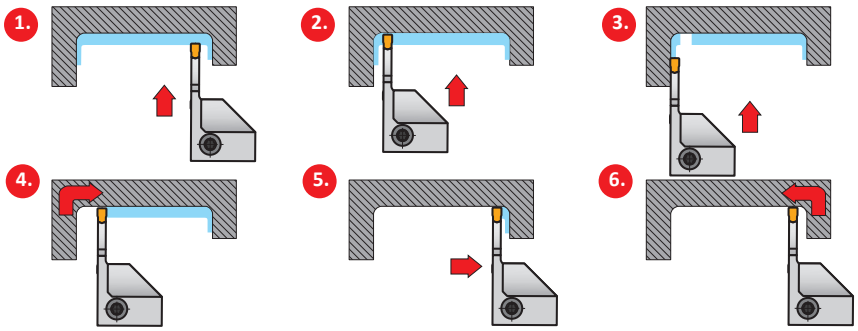
备注：使用GM或LCMF及F断屑槽的GL型刀片，可以实现一个平整的表面。外侧径向槽通道应与中心通道以刀片刀尖圆角的两倍重叠。



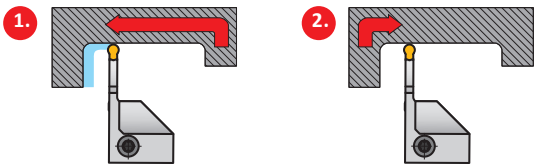
在加工宽槽时，按照下图所示步骤进行。



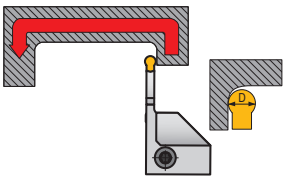
使用侧向车削扩大或加深轮廓时，按照下图所示步骤进行。



轮廓粗加工（带圆切削刃的刀片）

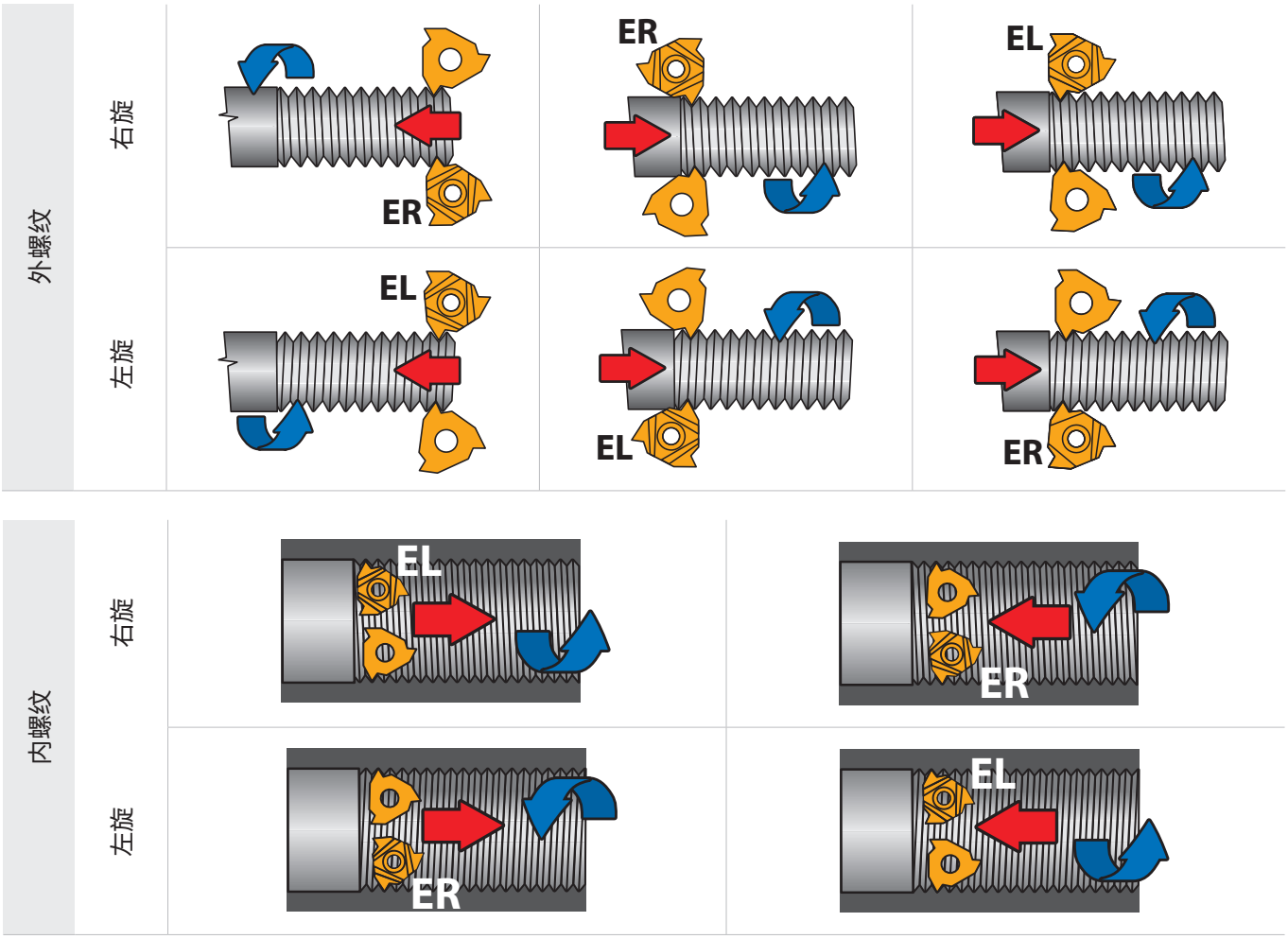


轮廓精加工（带圆切削刃的刀片）

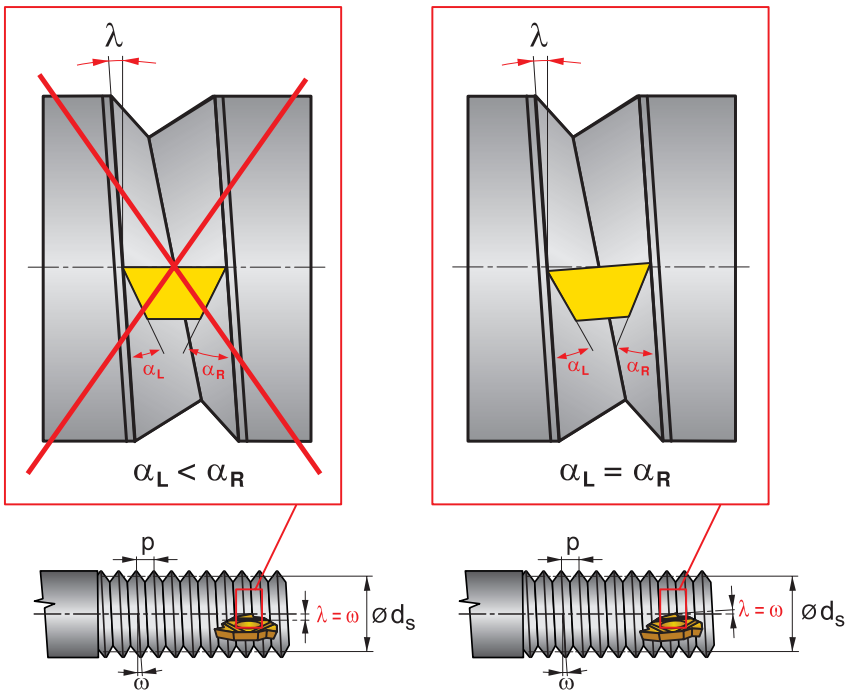


螺纹加工

基于下表 15 加工方式的选择受工件和机床刀具的影响。工件 – 是外或内螺纹，左或右手螺纹，刀具-是采用左或右手刀具。



螺旋角可以通过下面的公式来计算



$$tg\,\omega = \frac{p}{d_s \cdot \pi}$$

ω 螺旋角 [°]

p 螺距 [mm]

d_s 螺纹中径 [mm]

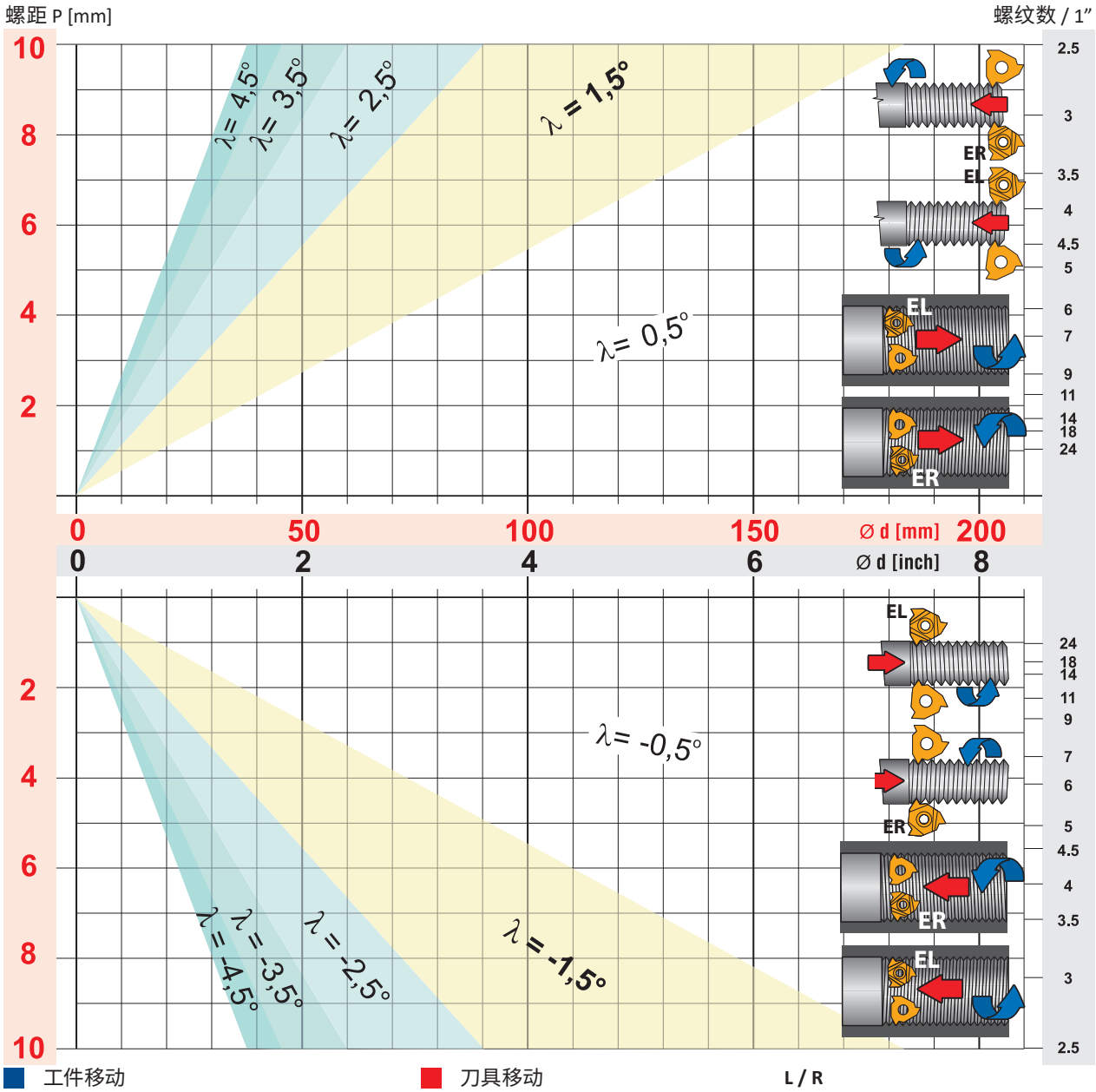
为加工出正确的螺纹牙型和确保刀片均匀磨损，切削刃螺旋角应该等于螺纹导程角。
通常，刀柄螺旋角 λ = 1.5°。可以通过更换刀垫选择不同的螺旋角。
使用下图或表选择正确的刀垫。表和图。

选择刀垫

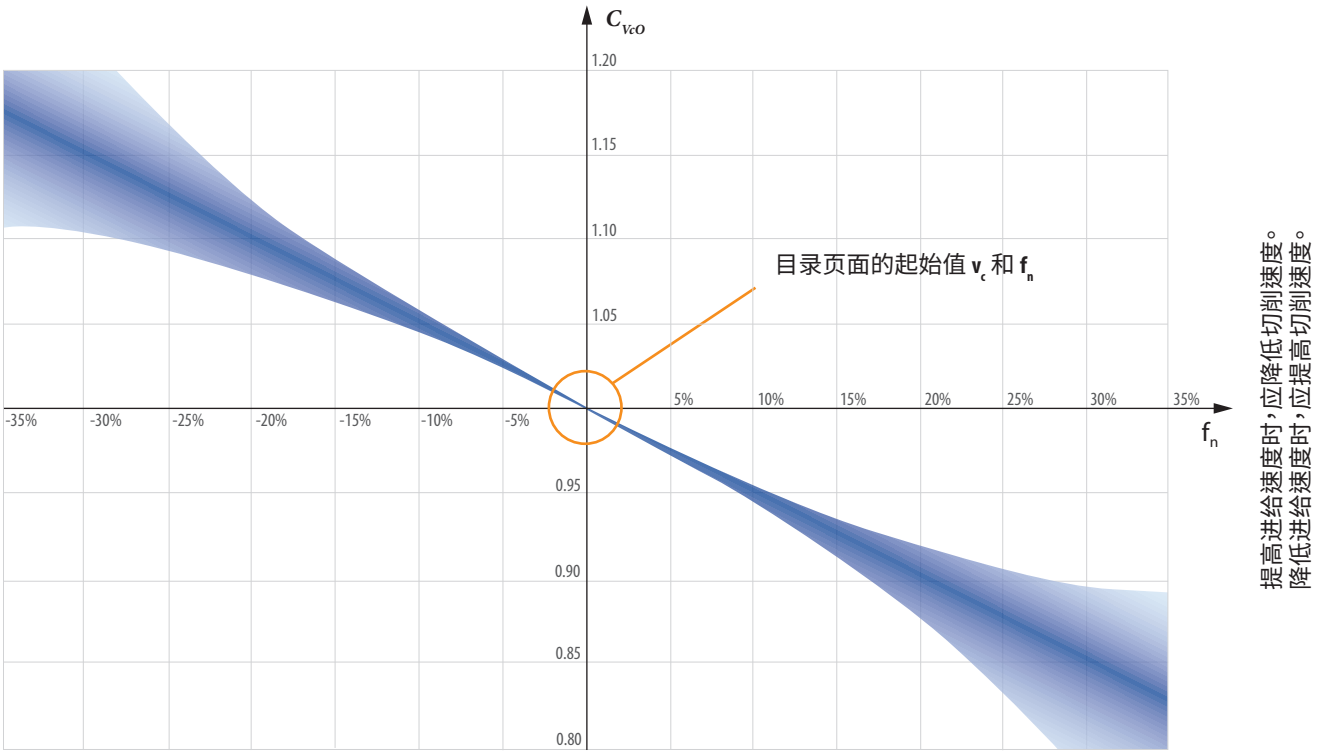
螺旋角 λ	正前角					负前角	
	4.5°	3.5°	2.5°	**1.5°**	0.5°	-0.5°	-1.5°
刀柄	**刀垫规格**						
SER .... .16; SIL .... .16	PE16+4.5	PE16+3.5	PE16+2.5	**PE16+1.5**	PE16+0.5	PE16-0.5	PE16-1.5
SEL .... .16; SIR .... .16	PI16+4.5	PI16+3.5	PI16+2.5	**PI16+1.5**	PI16+0.5	PI16-0.5	PI16-1.5
SER .... .22; SIL .... .22	PE22+4.5	PE22+3.5	PE22+2.5	**PE22+1.5**	PE22+0.5	PE22-0.5	PE22-1.5
SEL .... .22; SIR .... .22	PI22+4.5	PI22+3.5	PI22+2.5	**PI22+1.5**	PI22+0.5	PI22-0.5	PI22-1.5
SER-S .... .22; SIL-S .... .22	PE22S+4.5	PE22S+3.5	PE22S+2.5	**PE22S+1.5**	PE22S+0.5	PE22S-0.5	PE22S-1.5
SEL-S .... .22; SIR-S .... .22	PI22S+4.5	PI22S+3.5	PI22S+2.5	**PI22S+1.5**	PI22S+0.5	PI22S-0.5	PI22S-1.5

注意：通常，刀柄螺旋角 λ = 1.5°. 可以通过更换刀垫选择不同的螺旋角。
用于刀柄 SER-S ...., SIR-S .... 的刀垫标有 „S“.

刀垫选择



切削速度修正系数 C_{VcO} 与进给速度变化的函数关系：



达到要求耐久性的修正系数C_{VcT}

分钟	10	15	20	30	45	60
一般加工操作（从超精加工到粗加工）	1.13	1.00	0.93	0.84	0.76	0.71
重载加工操作（重载粗加工）	–	–	–	1.10	1.00	0.93

附加修正系数C_{VcA}

加工环境	C_{VcA}	C_{VcB}
加工材料的状况 （由于锻造或铸造形成的硬皮）	0.70	
内圆车削	0.75	
切断和径向切槽	0.88	
端面切槽	0.80	
断续切削		0.80
不稳定的加工工况		0.85
普通加工工况		1.00
稳定加工工况		1.20

计算校正线速度v_{cC}

$$v_{cC} = v_c \cdot k_{vG} \cdot C_{VcO} \cdot C_{VcT} \cdot C_{VcA} \cdot C_{VcB}$$

k_{vG} – 所用材料的系数
v_c – 从目录页中查询到的开始速度

切削参数计算公式

数量	公式	单位	注意
转速	$n = \frac{v_c \cdot 1000}{D \cdot \pi}$	(转/分钟)	n 转速 (转/分钟) D 直径 (刀具或工件) (mm) v_c 线速度 (m/分钟) f_{rev} 每转进给量 (mm/转) f_{min} 每分钟进给量 (进给速度) (mm/分钟)
线速度	$v_c = \frac{\pi \cdot D \cdot n}{1000}$	(m/分钟)	
每转进给量	$f_{rev} = \frac{f_{min}}{n}$	(mm/转)	
每分钟进给量 (进给速度)	$f_{min} = v_f = f_{rev} \cdot n$	(mm/分钟)	
轮廓高度最大值 R_{max}	$R_{max} = \frac{125 \cdot f_{rev}^{2}}{RE}$	(mm)	R_{max} 轮廓高度最大值 (mm) R_a 表面粗糙度 (mm) f_{rev} 每转进给量 (mm/转) RE 刀尖半径 (mm)
表面粗糙度 R_a	$R_a = \frac{43{,}9 \cdot f_{rev}^{1{,}88}}{RE^{0{,}97}}$	(mm)	
切屑横截面	$A = f_{rev} \cdot a_p$	(mm^2)	A 切屑横截面 (mm^2) f_{rev} 每转进给量 (mm/转) a_p 轴向切削深度 (mm) κ_r 主切削刃主偏角 (°) h 切屑厚度 (mm) v_c 线速度 (m/分钟) f_{min} 每分钟进给量 (进给速度) (mm/分钟) Q 每分钟材料去除率 (cm^3/分钟) $INSD$ 刀片直径 (mm)
切屑厚度 (用于平直切削刃刀片)	$h = f_{rev} \cdot \sin \kappa_r$	(mm)	
切屑厚度 (用于圆形刀片)	$h = f_{rev} \cdot \sqrt{\frac{a_p}{INSD}}$	(mm)	
金属去除率	$Q = a_p \cdot f_{rev} \cdot v_c$	(cm^3/分钟)	
功率需量	$P_c = \frac{a_p \cdot f_{rev}^{1-c} \cdot k_{c1} \cdot v_c \cdot k\kappa_r}{6 \cdot 10^4 \cdot \eta}$	(kW)	P_c 功率需量 (kW) a_p 切削深度 (mm) f_{rev} 进给量 (mm/转) c 常数 KTV (1) k_c 单位切削力 (MPa) k_{κ_r} 角度常数 (1) η 效率 (通常 η = 0.75) (1) x 加工材料常数 (1)
近似 功率需量	$P_c = \frac{a_p \cdot f_{rev} \cdot v_c}{x}$	(kW)	

材料	钢	铸铁	铝
系数 x	20	25	100

推荐螺钉扭矩

夹紧螺钉

螺钉名称	螺丝刀	扭矩 (Nm)*
28588	MA2-8304	0.8
28992	MA2-8304	0.8
416.1-832	PT-8002	3.6
5513 020-01	PT-8004	3.6
5513 020-03	PT-8001	0.8
5513 020-04	PT-8003	1.5
5513 020-05	PT-8001	0.8
5513 020-14	TX 225PLUS	8.5
5513 020-24	PT-8002	1.5
5513 020-27	PT-8000	0.6
5513 020-28	PT-8000	0.6
5513 021-03	DMN 3124	13
CS 8601-T09P	SDR T09P	1.7
CS 8601-T15P	SDR T15P	3.9
CS 8601-T20P	SDR T20P	6.4
CS 8601-T25P	SDR T25P	9.5
DVF 0573	PT-8002	1.5
DVF 2260	TX 215PLUS	3.6
DVF 3584	DMD 1650	0.6
DVF 3593	TX 207PLUS	0.8
HS 0408	HXK 3	5
HS 0412	HXK 3	5
HS 0516	HXK 4	5
HS 0520C	HXK 4	5
HS 0616C	HXK 5	8
HS 0620	HXK 5	6
HS 0620C	HXK 5	6
HS 0625	HXK 5	6
HS 0625C	HXK 5	6
HS 0630	HXK 5	6
HS 0825	HXK 6	10
HS 0830	HXK 6	10
HS 0835	HXK 6	10
HS 0840	HXK 8	11
HS 1030	HXK 8	8
HS 1060	HXK 6	10
HS 93	HXK 5	8
HS 94	HXK 5	8
HSI 1020	HXK 6	8
PS 0512	HXK 2	2
PS 0512-A	HXK 2	2
PS 0616	HXK 2,5	4
PS 12040	HXK 5	8

夹紧螺钉

螺钉名称	螺丝刀	扭矩 (Nm)*
PS 6026-709P	SRD T09P	2
PS 8290	HXK 2	2
SR 14	HXK 10	10
SR 85011-T15P	SDR T15P	5
SR 85017-T09P	SDR T09P	2
SR 85020-T15P	SDR T15P	3
SR 86025-T20P	SRD T20P	5
SR 88026-T30P	LKT30P	5
T20.037	DMD 1650	0.6
UP 0909-T09P	SRD T09P	2
UP 1515-T15P	SDR T15P	8
US 2505-T07P	SDR T07P	0.9
US 2506-T07P	SDR T07P	0.9
US 3007-T09P	SDR T09P	2
US 34	HXK 3	5
US 35	HXK 4	6
US 3508-T15P	SDR T15P	3
US 3510A-T15P	SDR T15P	3
US 3510-T15P	SDR T15P	3
US 3512A-T15P	SDR T15P	3
US 3512-T15P	SDR T15P	3
US 36	HXK 4	6
US 38	HXK 5	8
US 39	HXK 5	8
US 40	HXK 4	6
US 4008-T15P	SDR T15P	3.5
US 4011-T15P	SDR T15P	3.5
US 41	HXK 4	6
US 42	HXK 4	6
US 45013-T20P	SDR T20P	5
US 4512-T15P	SDR T15P	5
US 4514A-T20	SDR T20	5
US 46	HXK 3	5
US 46017-T20P	SDR T20P	5
US 47	HXK 5	8
US 5012-T15P	SDR T15P	5
US 5015-T20P	SDR T20P	5
US 5018-T20P	SDR T20P	5
US 6020-T25P	SDR T25P	6
US 64518-T15P	SDR T15P	5
US 8025-T30P	SDR T20P	13
US 83	HXK 4	6
US 95	HXK 4	10

扭矩螺丝刀

扭矩手柄	扭矩 (Nm)	夹紧螺钉螺纹
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

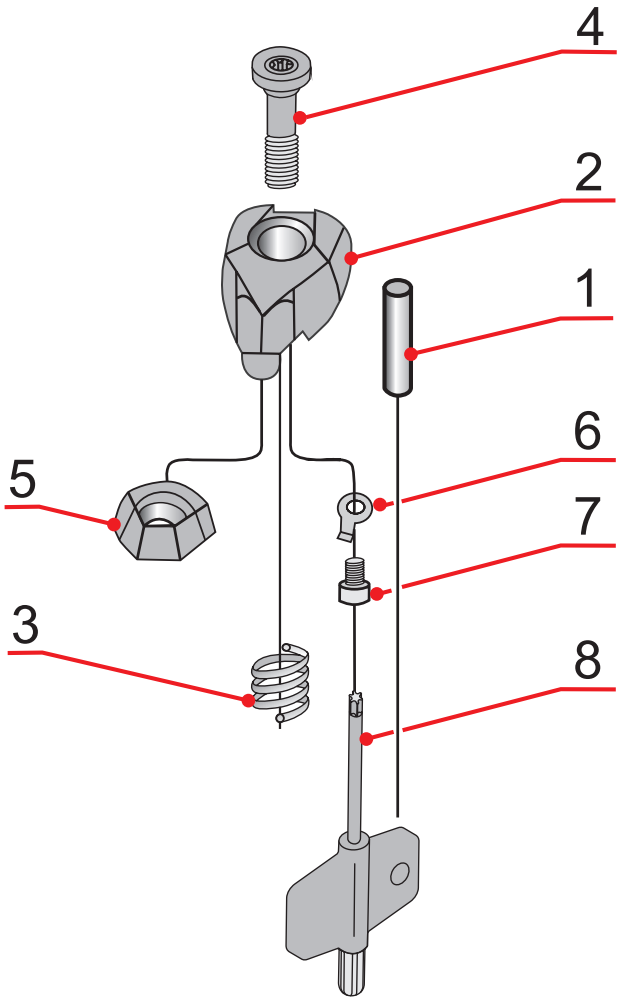
可替换的接杆

可替换的接杆

D-T6	D-T8	D-T15
D-T6P	D-T8P	D-T15P
D-T7	D-T9	D-T20
D-T7P	D-T9P	D-T20P

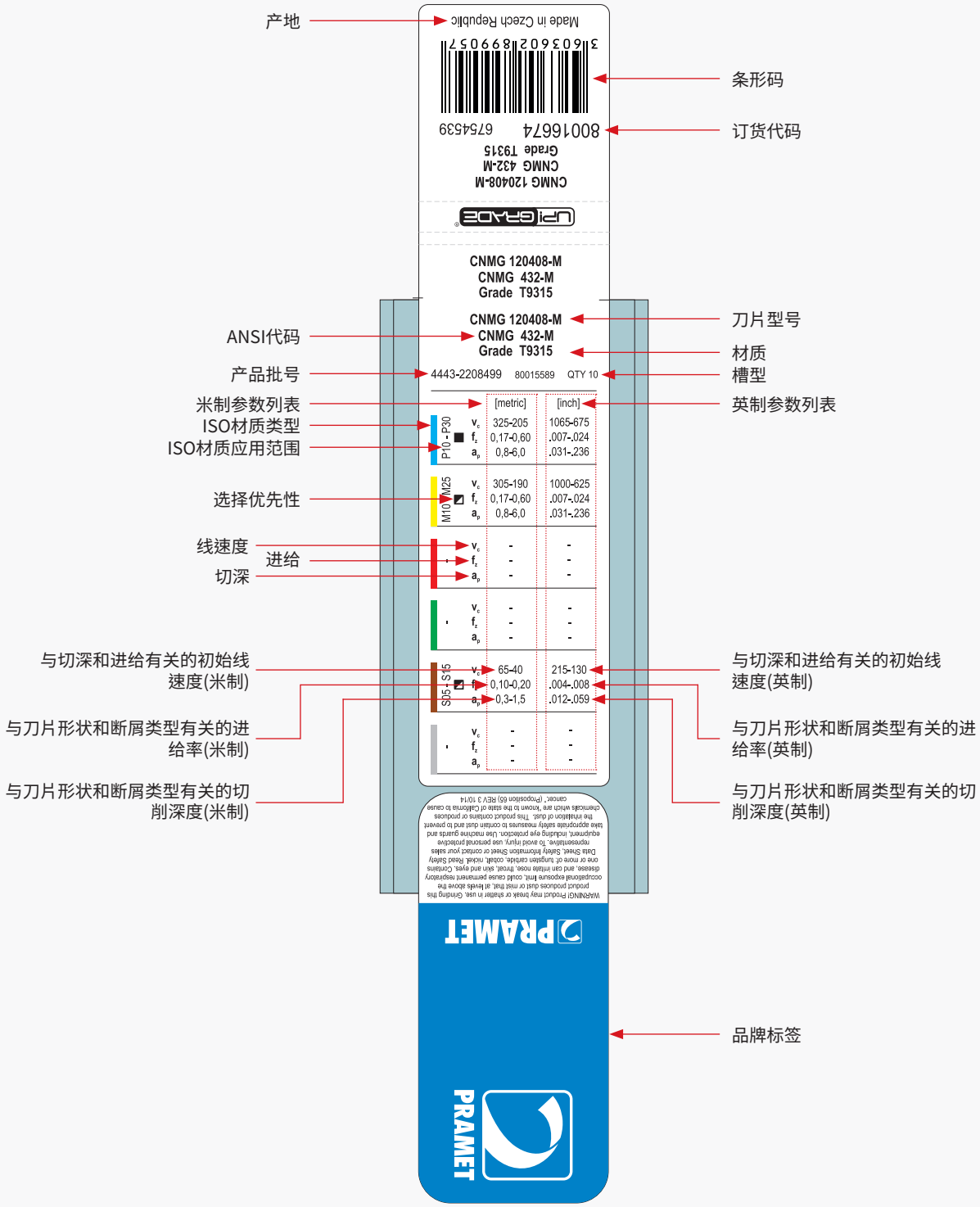
螺钉润滑

刀片夹紧螺钉受到高热应力。建议所有螺钉使用高品质润滑脂类似 二硫化钼润滑剂 1000 进行润滑。



	1	2	3	4		5	6	7	8
					Nm				
DCS 09	CP 2655	CD 09	PR 0157	CS 8601-T09P	1.7	–	–	–	–
DCS 12	CP 2607	CD 12	PR 0158	CS 8602-T15P	3.9	–	–	–	–
DCS 16	CP 2607	CD 16	PR 0159	CS 8603-T20P	6.4	–	–	–	–
DCS 19	CP 2607	CD 19	PR 0159	CS 8603-T20P	6.4	–	–	–	–
DCS 25	CP 2607	CD 25	PR 0101	CS 8604-T25P	9.5	–	–	–	–
DCS 16V	CP 2607	CD 16V	PR 0158	CS 8602-T15P	3.9	–	–	–	–
DCS 12C2	CP 2607	CD 12C2	PR 0158	CS 8602-T15P	3.9	PP 3002	H 1201	CS 9701-T07P	FLAG T07P
DCS 16C2	CP 2607	CD 16C2	PR 0159	CS 8603-T20P	6.4	PP 3003	H 1201	CS 9701-T07P	FLAG T07P
DCS 12C4	CP 2607	CD 12C4	PR 0158	CS 8602-T15P	3.9	PP 3002	H 1201	CS 9701-T07P	FLAG T07P
DCS 16C4	CP 2607	CD 16C4	PR 0159	CS 8603-T20P	6.4	PP 3003	H 1201	CS 9701-T07P	FLAG T07P

刀片盒的技术信息


产地
Made in Czech Republic
条形码
订货代码
8001667 4 6754539
CNMG 120408-M
CNMG 432-M
Grade T9315
刀片型号
材质
槽型
ANSI代码
产品批号
4443-2208499 80015589 QTY 10
米制参数列表
ISO材质类型
ISO材质应用范围
选择优先性
线速度
进给
切深
英制参数列表
[metric] [inch]
P10 - P30 v_c 325-205 1065-675 f_z 0,17-0,60 .007-.024 a_p 0,8-6,0 .031-.236
M10 - M25 v_c 305-190 1000-625 f_z 0,17-0,60 .007-.024 a_p 0,8-6,0 .031-.236
S05 - S15 v_c 65-40 215-130 f_z 0,10-0,20 .004-.008 a_p 0,3-1,5 .012-.059
与切深和进给有关的初始线速度(米制)
与刀片形状和断屑类型有关的进给率(米制)
与刀片形状和断屑类型有关的切削深度(米制)
与切深和进给有关的初始线速度(英制)
与刀片形状和断屑类型有关的进给率(英制)
与刀片形状和断屑类型有关的切削深度(英制)
PRAMET
品牌标签

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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