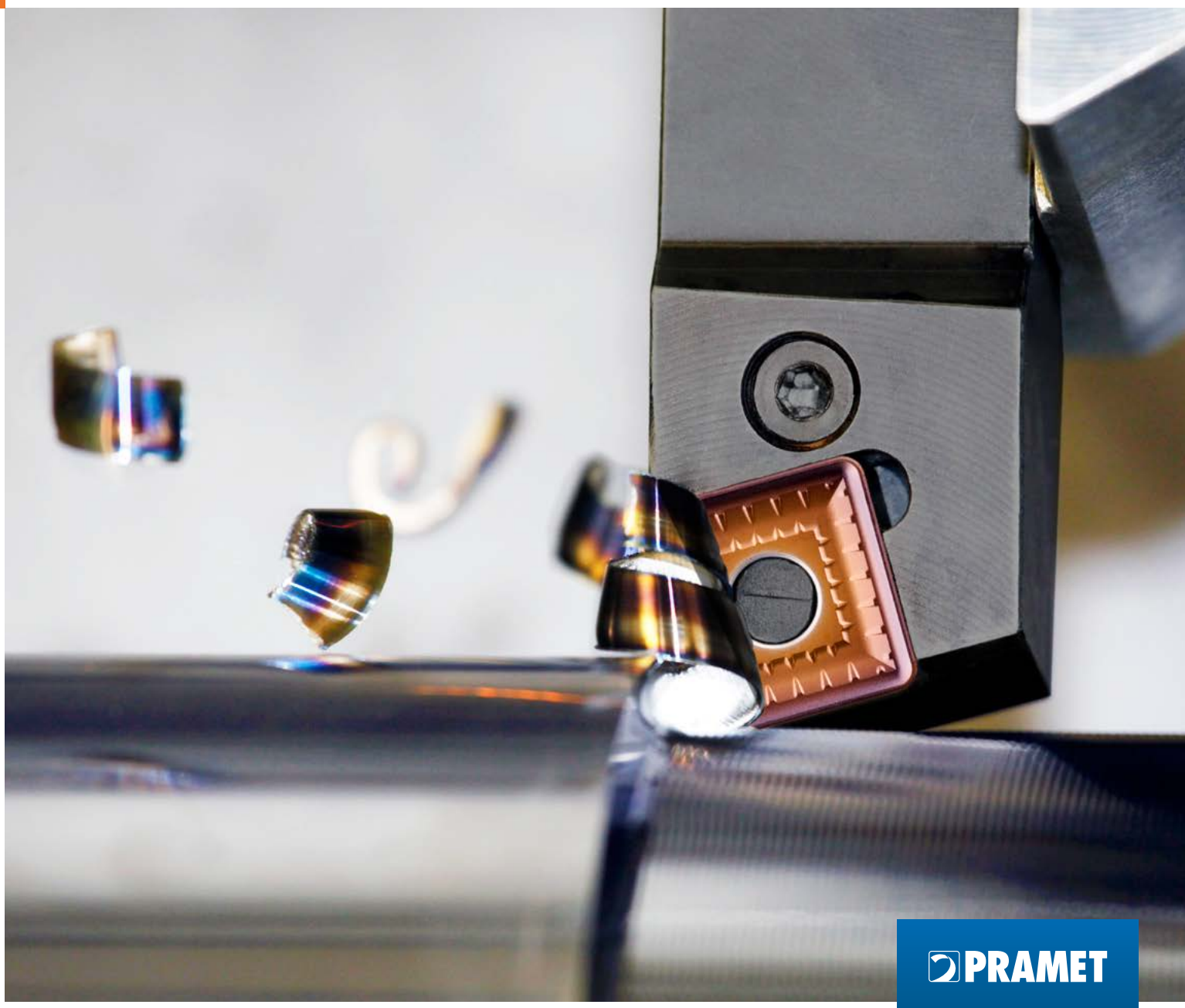
DORMER PRAMET

车削

2021 – 2022



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DORMER PRAMET

快速搜索

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工件材料分组 (WMG)



关于DORMER PRAMET的工件材料分类

工件材料分组 (WMG) 用于支持简单和可靠地选择正确的切削刀具以及适合特定应用加工工况的初始值。
Dormer Pramet将工件材料分为六个不同的颜色组 ;

- 蓝色 : 钢和铸钢 (P组)
- 黄色 : 不锈钢 (M组)
- 红色 : 铸铁 (K组)
- 绿色 : 有色金属 (N组)
- 橙色 : 高温合金 (S组)
- 灰色 : 硬化材料 (H组)

上述各组再根据其结构和/或成分分为几个子组。例如 , P组钢和铸钢分成四个子组 , 即 :

- P1 – 易切削钢
- P2 – 普通碳钢
- P3 – 合金钢
- P4 – 工具钢

最后 , 根据材料属性 (例如硬度和极限抗拉强度) 进行进一步分类。通过这种分类方式 , 可以为我们的客户提供一套完整的刀具推荐方案 , 包括线速度和进给量等初始值。
下页的表格中包含对每个工件材料分组的描述 , 以及适用于该分组的常用名称示例。

ISO组					硬度 (HB或HRC)	极限抗拉强度(MPa)
P	P1	P1.1	易切削钢（可加工性较高的碳钢）	硫化	< 240 HB	≤ 830
		P1.2		硫化和磷化	< 180 HB	≤ 620
		P1.3		硫化/磷化和含铅	< 180 HB	≤ 620
	P2	P2.1	普通碳钢（主要由铁和碳组成的钢）	含<0.25%C	< 180 HB	≤ 620
		P2.2		含<0.55%C	< 240 HB	≤ 830
		P2.3		含>0.55%C	< 300 HB	≤ 1030
	P3	P3.1	合金钢（碳钢，合金含量≤10%）	退火	< 180 HB	≤ 620
		P3.2		硬化与回火	180 – 260 HB	> 620 ≤ 900
		P3.3			260 – 360 HB	> 900 ≤ 1240
	P4	P4.1	工具钢（特种合金钢，用于刀具、模具）	退火	< 26 HRC	≤ 900
		P4.2		硬化与回火	26 – 39 HRC	> 900 ≤ 1240
		P4.3			39 – 45 HRC	> 1240 ≤ 1450
M	M1	M1.1	铁素体不锈钢（直铬非硬化合金）		< 160 HB	≤ 520
		M1.2			160 – 220 HB	> 520 ≤ 700
	M2	M2.1	马氏体不锈钢（直铬可硬化合金）	退火	< 200 HB	≤ 670
		M2.2		淬火加回火	200 – 280 HB	> 670 ≤ 950
		M2.3		沉淀硬化	280 – 380 HB	> 950 ≤ 1300
	M3	M3.1	奥氏体不锈钢（铬镍和铬镍锰合金）		< 200 HB	≤ 750
		M3.2			200 – 260 HB	> 750 ≤ 870
		M3.3			260 – 300 HB	> 870 ≤ 1040
	M4	M4.1	奥氏体-铁素体（双相）或 高级奥氏体不锈钢		< 300 HB	≤ 990
		M4.2	沉淀硬化奥氏体不锈钢		300 – 380 HB	≤ 1320
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
		K1.2		铁素体-珠光体或珠光体	180 – 240 HB	> 190 ≤ 310
		K1.3		珠光体	240 – 280 HB	> 310 ≤ 390
	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
		K2.2		铁素体或珠光体	160 – 200 HB	> 400 ≤ 550
		K2.3		珠光体	200 – 240 HB	> 550 ≤ 660
	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
		K3.2		铁素体或珠光体	180 – 220 HB	> 560 ≤ 680
		K3.3		珠光体	220 – 260 HB	> 680 ≤ 800
	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
		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
		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
		K4.4			280 – 320 HB	> 980 ≤ 1130
		K4.5			320 – 360 HB	> 1130 ≤ 1280
	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
		K5.2		铁素体-珠光体	180 – 220 HB	> 400 ≤ 450
		K5.3		珠光体	220 – 260 HB	> 450 ≤ 500
N	N1	N1.1	工业纯锻铝		< 60 HB	≤ 240
		N1.2	锻铝合金	中硬质回火	60 – 100 HB	> 240 ≤ 400
		N1.3		全硬质回火	100 – 150 HB	> 400 ≤ 590
	N2	N2.1	铸铝合金		< 75 HB	≤ 240
		N2.2			75 – 90 HB	> 240 ≤ 270
		N2.3			90 – 140 HB	> 270 ≤ 440
	N3	N3.1	易切削铜合金材料，具有出色机械加工性能		–	–
		N3.2	短切屑铜合金，具有良好至中等的机械加工性能		–	–
		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		–	–
	N4	N4.1	热塑性聚合物		–	–
		N4.2	热固性聚合物		–	–
		N4.3	增强型聚合物或复合材料		–	–
	N5	N5.1	石墨		–	–
S	S1	S1.1	钛或钛合金		< 200 HB	≤ 660
		S1.2			200 – 280 HB	> 660 ≤ 950
		S1.3			280 – 360 HB	> 950 ≤ 1200
	S2	S2.1	铁基高温合金		< 200 HB	≤ 690
		S2.2			200 – 280 HB	> 690 ≤ 970
	S3	S3.1	镍基高温合金		< 280 HB	≤ 940
		S3.2			280 – 360 HB	> 940 ≤ 1200
	S4	S4.1	钴基高温合金		< 240 HB	≤ 800
		S4.2			240 – 320 HB	> 800 ≤ 1070
H	H1	H1.1	冷硬铸铁		< 440 HB	–
	H2	H2.1	硬化铸铁		< 55 HRC	–
		H2.2			> 55 HRC	–
	H3	H3.1	硬化钢 < 55 HRC		< 51 HRC	–
		H3.2			51 – 55 HRC	–
	H4	H4.1	硬化钢 > 55 HRC		55 – 59 HRC	–
		H4.2			> 59 HRC	–

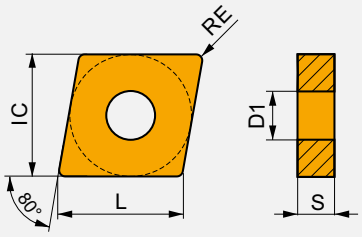
加工材料示例 – 参见通用技术信息章节（页码539）。

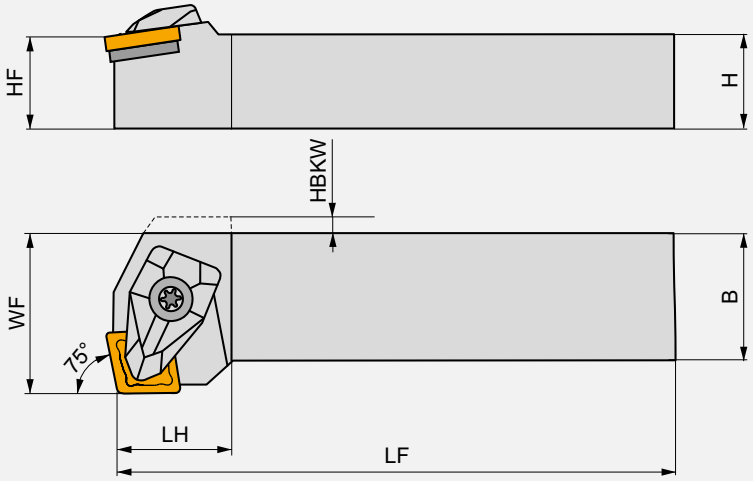
ISO 13399标准切削刀具参数

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！





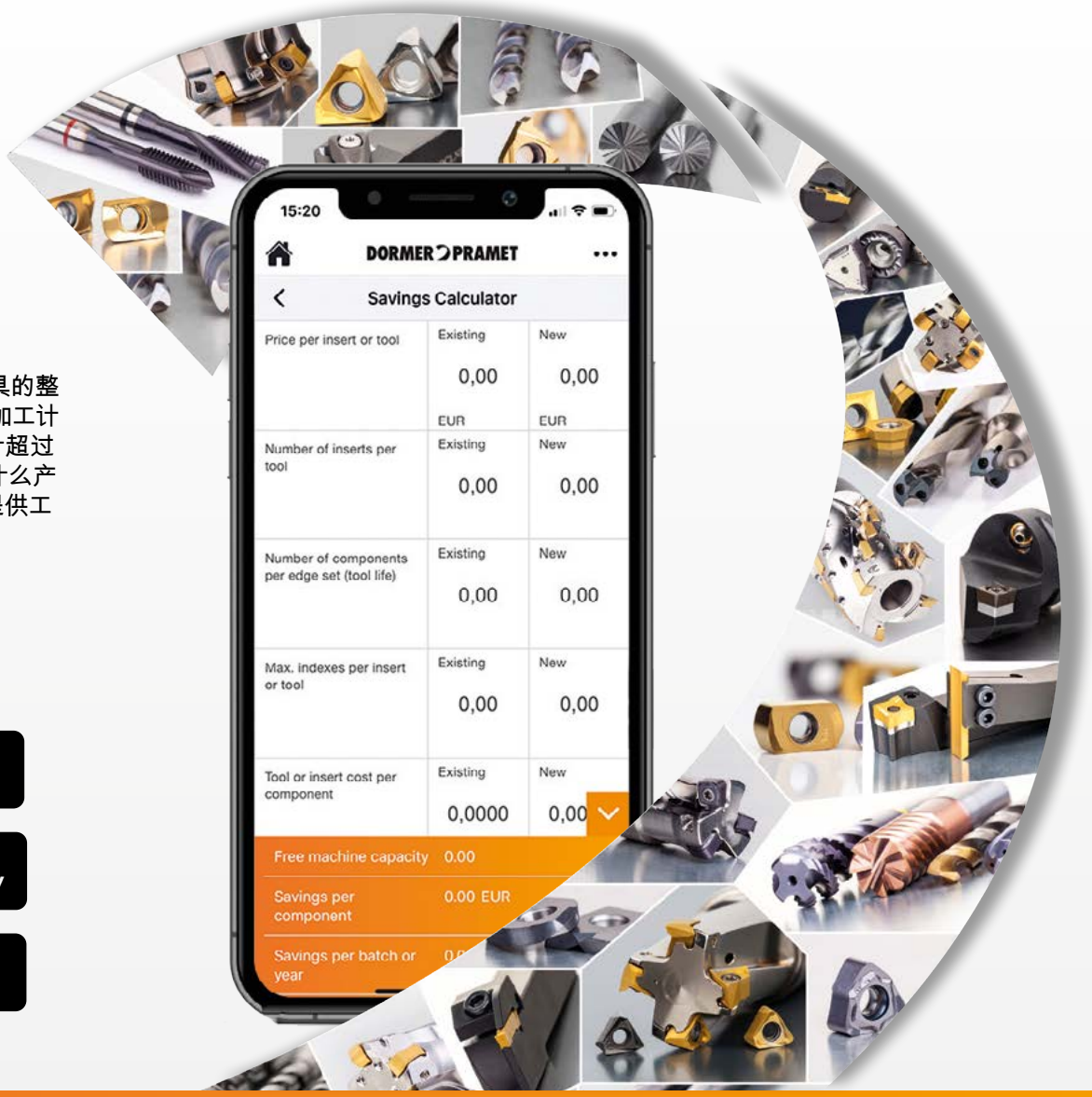
ISO 13399	描述
APMX	最大切削深度
B	刀柄宽度
BD	刀体直径
BLRAD	刀片加强刀尖半径
BW	刀片主体宽度
CDX	最大切削深度
CND	冷却剂入口直径
CUTDIA	工件最大切断直径
CW	切削宽度
CWTOLL	切削宽度下公差
CWTOLU	切削宽度上公差
D1	固定孔直径
DAXIN	轴向槽最小内径
DAXN	轴向槽最小外径
DAXX	轴向槽最大外径
DCON MS	接头直径
DMIN	最小孔径
DMINP	最小垂直孔径
GAMO	正交前角
GAMP	轴向前角
H	刀柄高度
HBH	刀头底部偏移高度
HBKW	刀头底部偏移宽度
HF	功能高度
IC	内切圆直径
INSD	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

DORMER PRAMET

所有刀具汇总

圆刃刀具和可转位刀具的整个产品组合包含在机加工计算器应用程序中。总计超过40,000种！无论加工什么产品，我们都能够为您提供工具支持。
简单可靠。



Download on the App Store

GET IT ON Google Play

Download on AppGallery

ISO车削

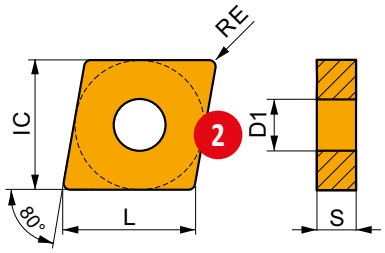


📖 6		WMG & ISO 13399
📖 10	ISO车削	说明
📖 18		导航工具
📖 57		正前角刀片
📖 219		负前角刀片
📖 386		切槽和切断
📖 482		螺纹车削
📖 526		内孔插槽
📖 533		技术信息

1 CNMM

PRAMET

	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



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。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]
4	5		6																	
10 DR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
CNMM 160612E-DR	T9315	1.2	225	0.45	6.0	–	–	–	210	0.45	6.0	–	–	–	–	–	–	–	–	–
7	8	9	200	0.45	6.0	120	0.41	6.0	190	11	6.0	–	–	–	–	–	–	–	–	–
			170	0.45	6.0	100	0.41	6.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190608E-DR	T9315	0.8	215	0.40	8.0	–	–	–	200	0.40	8.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	190	0.40	8.0	110	0.36	8.0	180	0.40	8.0	–	–	–	–	–	–	–	–	–
CNMM 190612E-DR	T9315	1.2	220	0.45	8.0	–	–	–	205	0.45	8.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	195	0.45	8.0	115	0.41	8.0	185	0.45	8.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	170	0.45	8.0	100	0.41	8.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190616E-DR	T9325	1.6	195	0.50	9.0	115	0.45	9.0	185	0.50	9.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	170	0.50	9.0	100	0.45	9.0	–	–	–	–	–	–	–	–	–	–	–	–
P HR断屑槽，适用于粗加工至重载粗加工，连续切削至间断切削。																				
CNMM 190616E-HR	6640	1.6	75	0.60	10.0	45	0.54	10.0	70	0.60	10.0	–	–	–	–	–	–	–	–	–
	T8345	1.6	55	0.60	10.0	30	0.54	10.0	50	0.60	10.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	105	0.60	10.0	60	0.54	10.0	95	0.60	10.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	80	0.60	10.0	45	0.54	10.0	–	–	–	–	–	–	–	–	–	–	–	–

CNMM190616E-HR:T8345 订购时请使用完整的刀片规格代码！

- 涂层
- 包括冒号
- ISO刀片代码

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
8	涂层
9	刀尖半径 (mm)
10	槽型说明
11	刀片应用领域

1 **DDUN(RL) INT**

P M K N S I 2

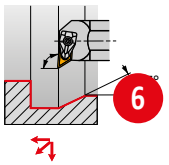
PRAMET 3 D

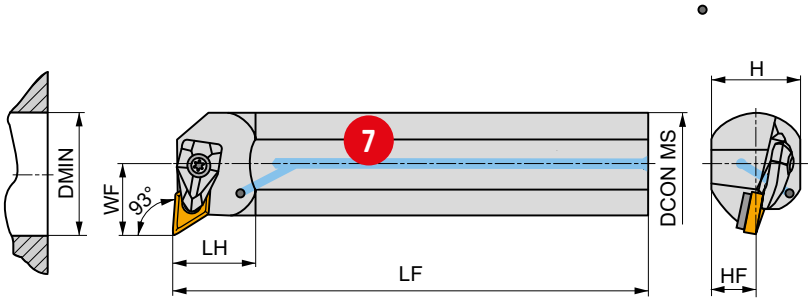

4

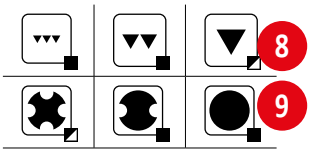
内孔用双重夹紧镗杆，使用DN..刀片，主偏角为93°。

内孔用左/右手双重夹紧钳镗杆，有内冷通道，主偏角为93°，使用DN..11和15刀片。内孔最小加工直径为Ø32mm。广泛的应用于内孔车削，仿形车削角度最大为27°。可提供Ø25至Ø50mm的刀柄。刀杆经过处理，使用寿命更长。

5


6




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	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNR 11	32	40	22	30	15	300	30	-10	-6	✓	1.68	GI046	DD11	–
	A40T-DDUNR 15	40	50	27	37	18.5	300	36	-11	-6					
	A50U-DDUNR 15	50	63	35	47	23.5	350	39	-8	-6					
L	**A25T-DDUNL 11**	25	32	17	23	11.5	300	28	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNL 11	32	40	22	30	15	300	30	-10	-6	✓	1.69	GI046	DD11	–
	A40T-DDUNL 15	40	50	27	37	18.5	300	36	-11	-6	✓	2.59	GI044	DD154	AT002
	A50U-DDUNL 15	50	63	35	47	23.5	350	39	-8	-6	✓	5.25	GI044	DD154	AT002

11 12 13 14 15 16 17 18

19

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

20

		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

21

AT002a	DN.. 1504..	–	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。

车削刀杆 – 页面概览

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.

车削刀杆 – 图标概览

通用图标

■	主要使用
◩	可以使用

▼▼▼	精加工 – 极佳的表面质量
▼▼	中等精度加工 – 良好的表面质量
▼	粗加工 – 无限制的表面粗糙度

●	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
	适用于短切屑材料
	适用于韧性材料（长切屑）
	重载作业条件
HFC	快进给切削
HSC	高速切削

W	具有修光刃槽型的刀片
	大悬伸
	火车轮加工
	薄壁和细长工件
U	应用广泛的多用途选项

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

车削操作

	锥体车削 – 外圆加工
	锥体车削 – 内圆加工
	仿形车削（多向加工）
	端面仿形车削
	孔内表面仿形车削
	带肩端面车削
	不带肩端面车削

	倒角（开坡口）
	背面倒角（开坡口）
	孔内倒角（开坡口）
	带肩轴向车削 – 外圆加工
	带肩轴向车削 – 内圆加工
	不带肩轴向车削 – 外圆加工
	不带肩轴向车削 – 内圆加工

	加工尾部端面（背车）
	多向仿形车削 – 外圆加工
	多向仿形车削 – 内圆加工
	单向仿形车削 – 外圆加工
	单向仿形车削 – 内圆加工
	径向车削浅槽

车削刀杆 – 图标概览

技术页面

FF	超精加工
F	精加工
M	中等加工
R	粗加工
HR	重载粗加工
X.V	线速度校正因子
a_p	切削深度 [mm]

f	进给 [mm/rev]
	寿命 [min]
	材质
(MT)CVD PVD	涂层
V	线速度
	切削刃形状
	冷却液

	极高线速度, 出色的系统刚性(稳定的工况)
	高线速度, 高系统刚性(稳定的工况)
	高线速度, 系统刚性有限(变切深)
	中等线速度,系统刚性有限(轻微断续切削)
	低线速度, 低系统刚性(断续切削)
	非常低的线速度, 系统刚性极其有限(极不稳定的工况)

其它

Nm	螺钉的夹紧力矩[Nm]
	重载粗车刀头
	内冷供应

CCGT

60

CCMT

62

CCMW

68

CCGW CBN

69

DCGT

86

DCMT

87

DCMW

92

DCGW CBN

92

DCMW PCD

93

ECGT

104

ECMT

105

ECMW

106

EPGX

110

EPMT

110

RCGT

118

RCMT

118

RCMW

120

RCMX

121

RCGX CER

123

SCGT

134

SCMT

135

SCMW

138

SPMR

146

SPUN

146

SPGN CER

147

TCGT

149

TCMT

150

TCMW

154

TCGW CBN

154

TPGX



162

TPMR



163

TPUN



164

TPGN CER



164

VBMT



168

VBGW CBN



171

VCGT



186

VCGW



189

VCGX



189

VCMT



190

VCMW



191

VCMW PCD



192

WCGT



212

WCGX



213

WCMT



213

CNGG



222

CNMA



222

CNMG



223

CNMM



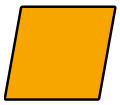
234

CNGA CER



238

CNGN CER



238

CNGA CBN



239

DNMA



260

DNMG



260

DNMM



270

DNGA CER



271

DNGN CER



271

DNGA CBN



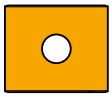
272

KNUX



284

LNUX 40, LN.X 50



289

RNMG



294

RNGN CER



294

SNMA



300

SNMG



301

SNMM



307

SNMX



311

SNGA CER



311

SNGN CER



312

TNMA



334

TNMG



335

TNMM



342

TNGA CER



343

TNGN CER



344

TNGA CBN



344

VNMG



356

VNGA CER



359

VNGA CBN



359

WNMA



366

WNMG



366

WNMM



375

WNGA CBN



376

P

非常不稳定工况

不稳定工况

稳定工况

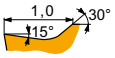
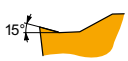
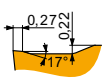
薄壁和细长工件

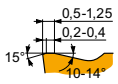
首选

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

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

M

非常不稳定工况

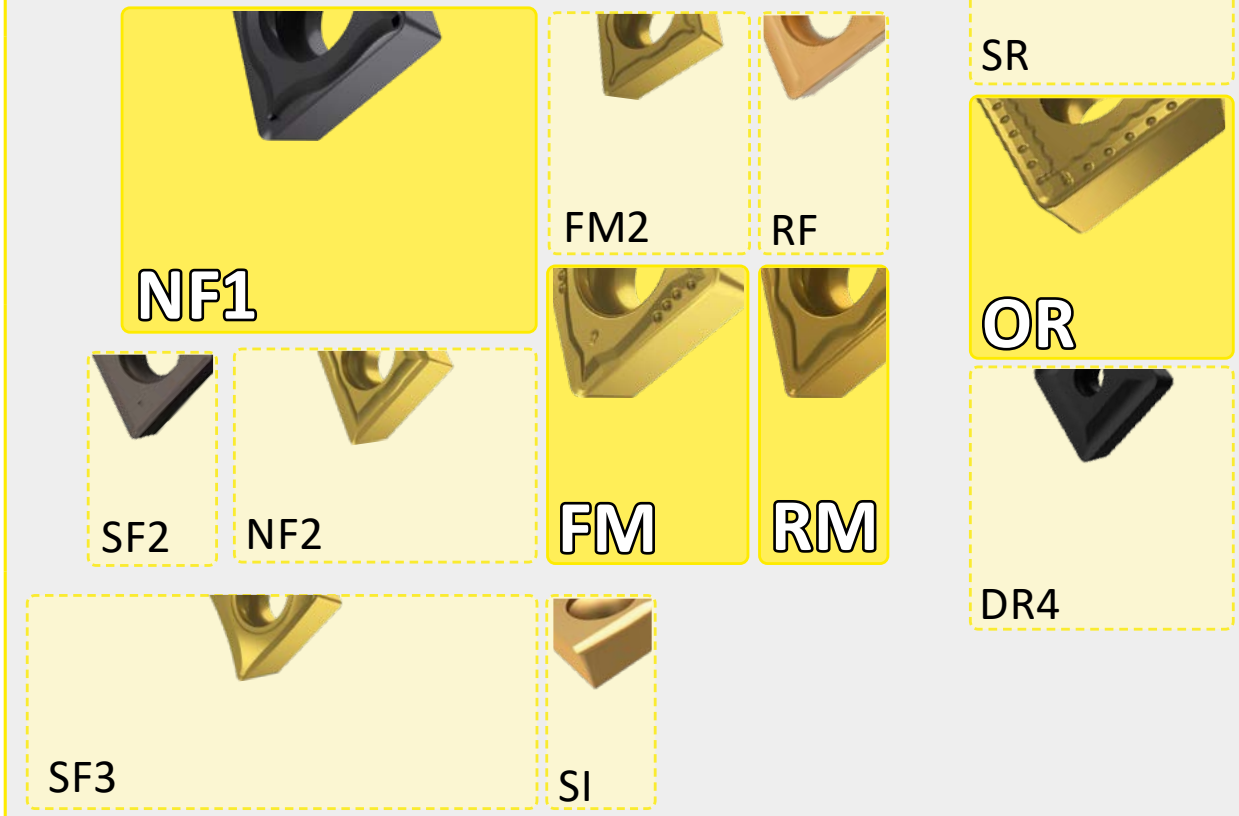
不稳定工况

稳定工况

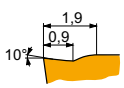
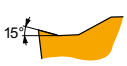
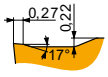
薄壁和细长工件

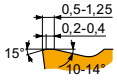
首选

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

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
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

K

非常不稳定工况

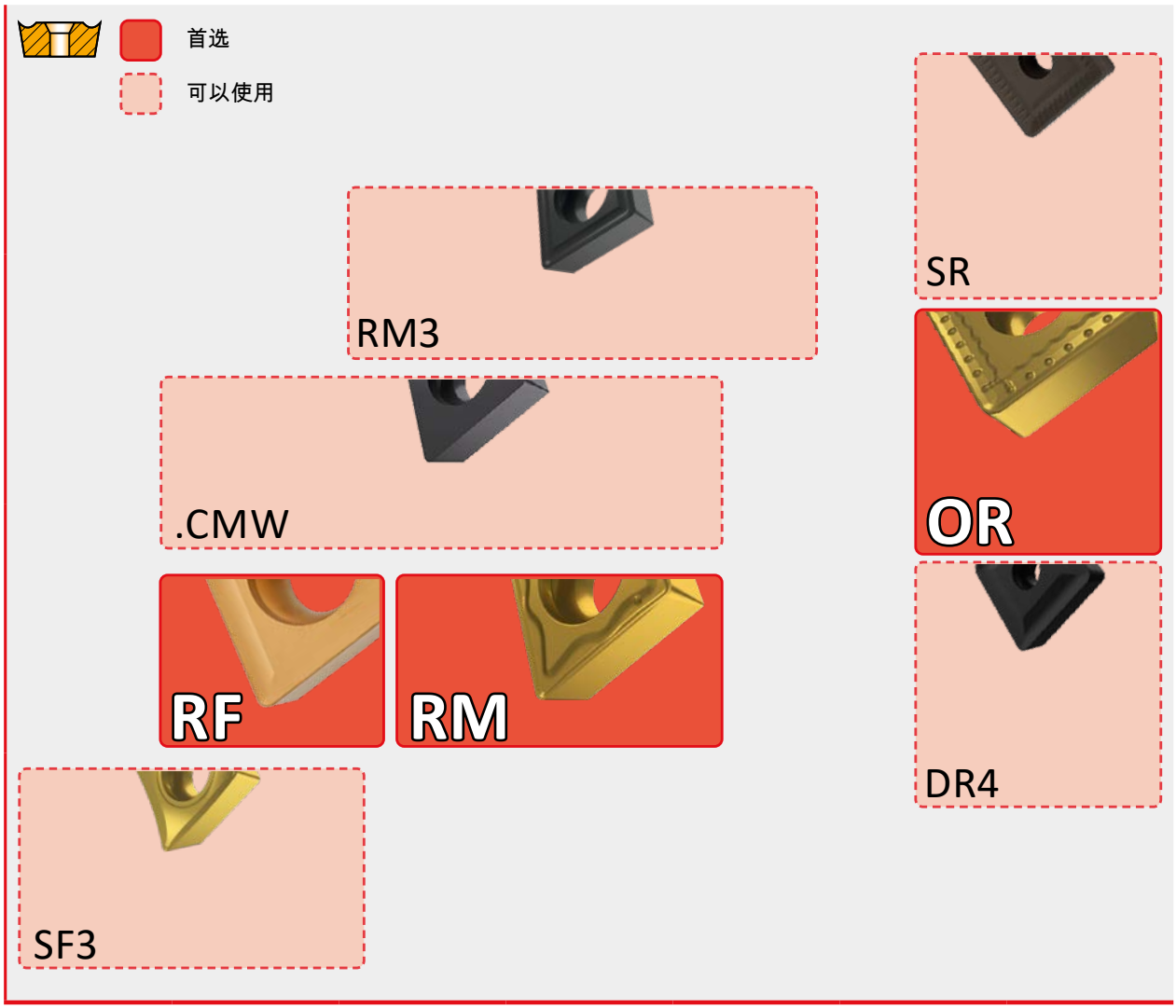
不稳定工况

稳定工况

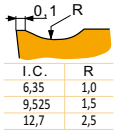
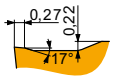
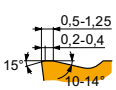
薄壁和细长工件

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

RF		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

首选

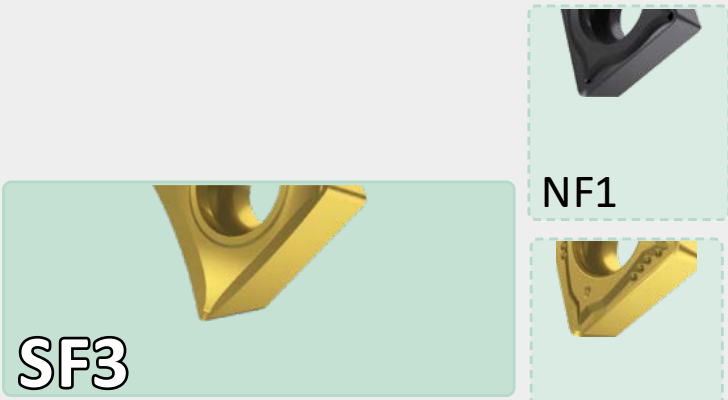
可以使用

非常不稳定工况

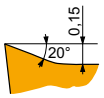
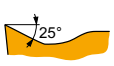
不稳定工况

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
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

S

首选

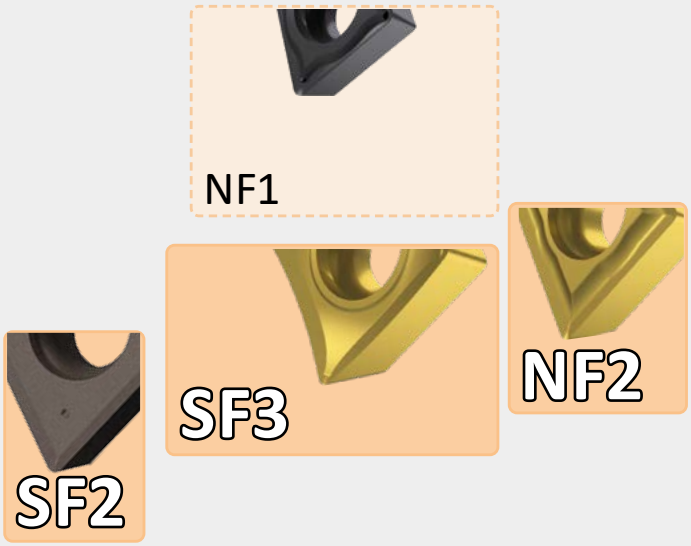
可以使用

非常不稳定工况

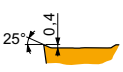
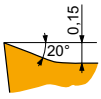
不稳定工况

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

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

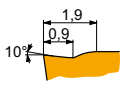


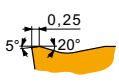






	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

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

P

非常不稳定工况

不稳定工况

稳定工况

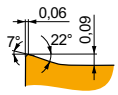
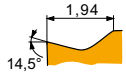
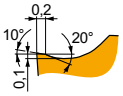
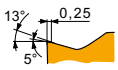
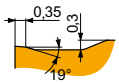
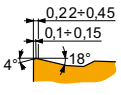
薄壁和细长工件

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

FF		大正前角槽型，设计用于不锈钢和钢，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
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

非常不稳定工况

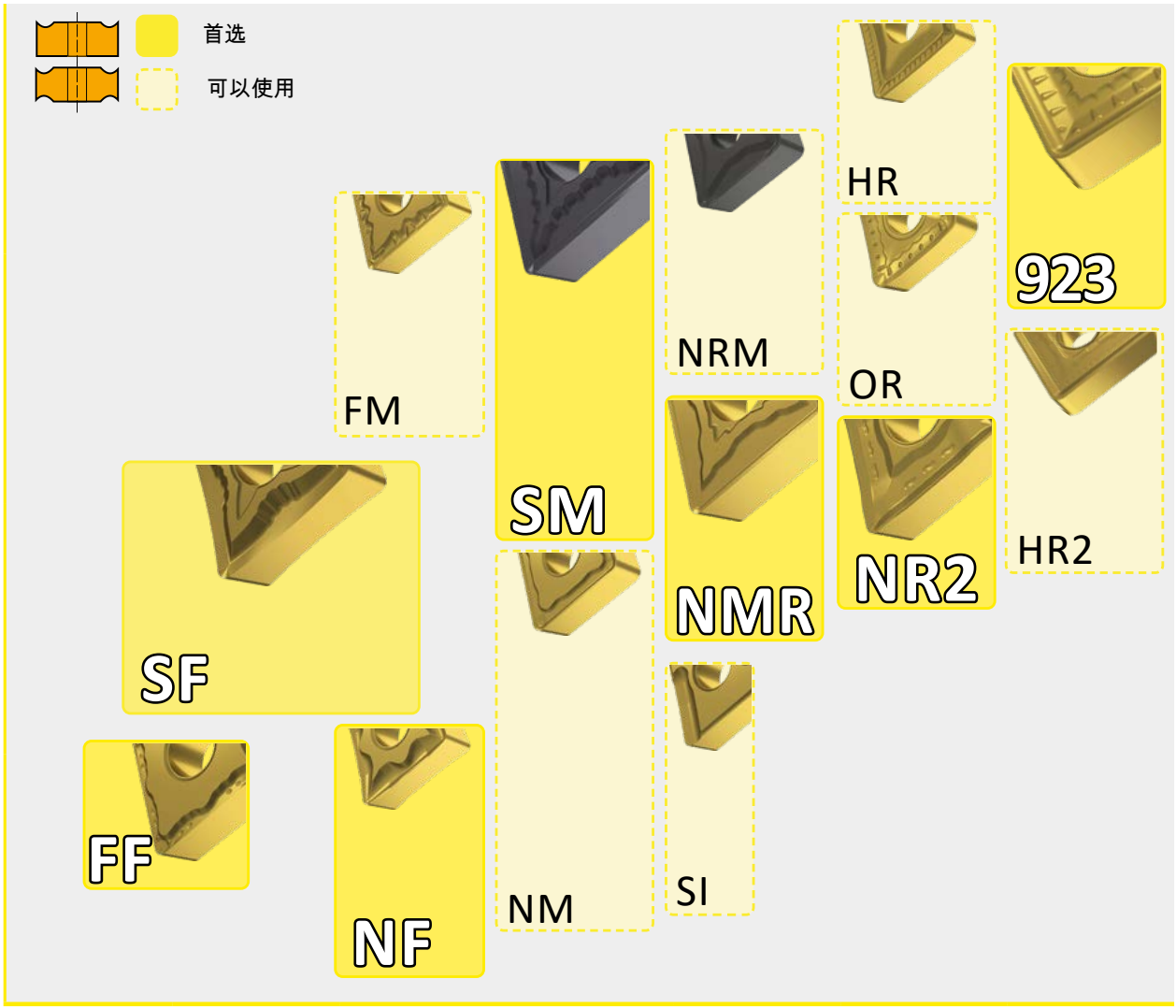
不稳定工况

稳定工况

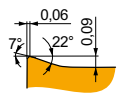
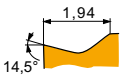
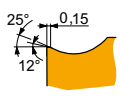
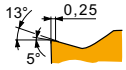
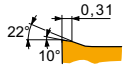
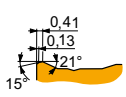
薄壁和细长工件

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

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

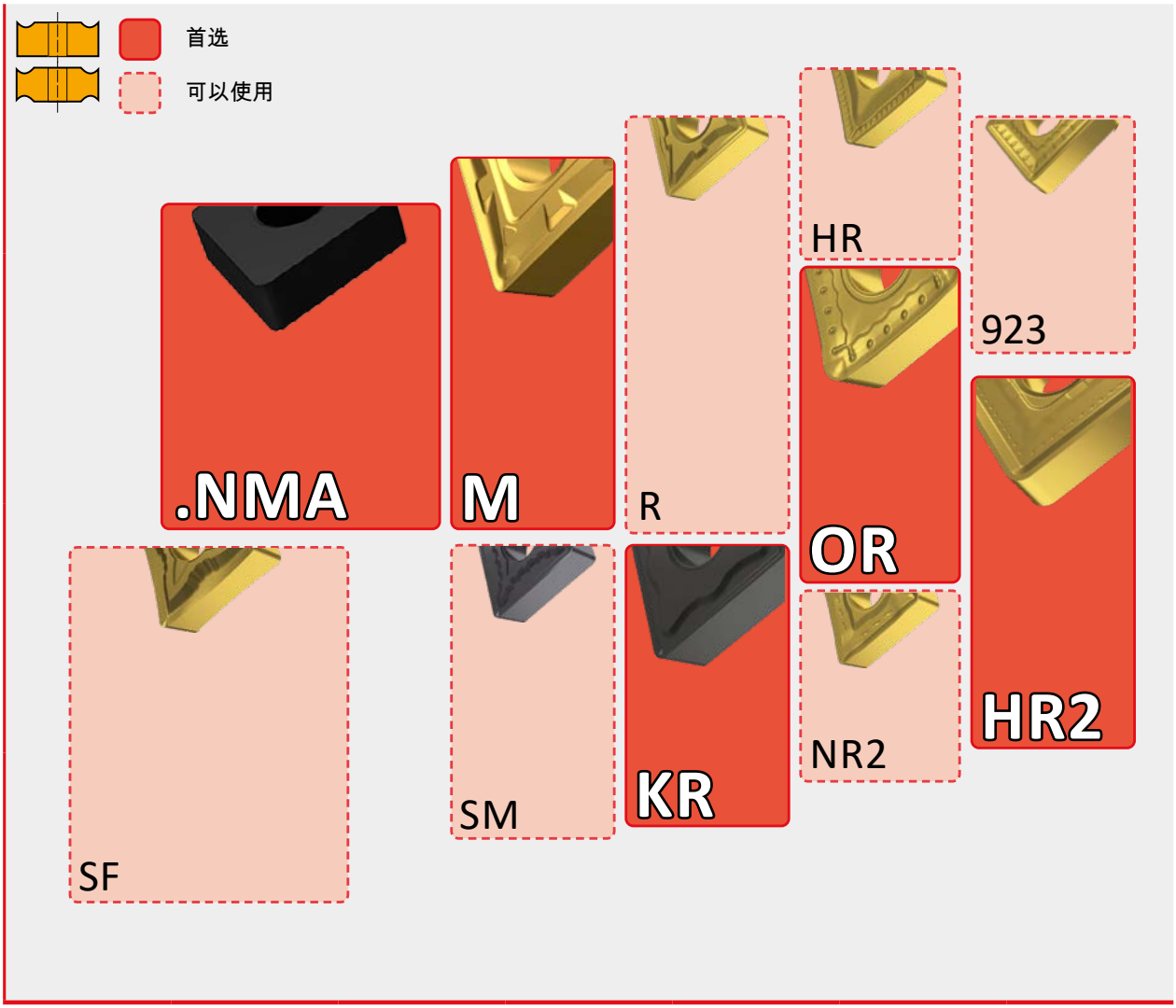
K

非常不稳定工况

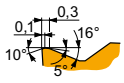
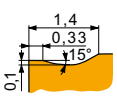
不稳定工况

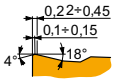
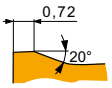
稳定工况

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

.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

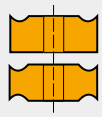
N

非常不稳定工况

不稳定工况

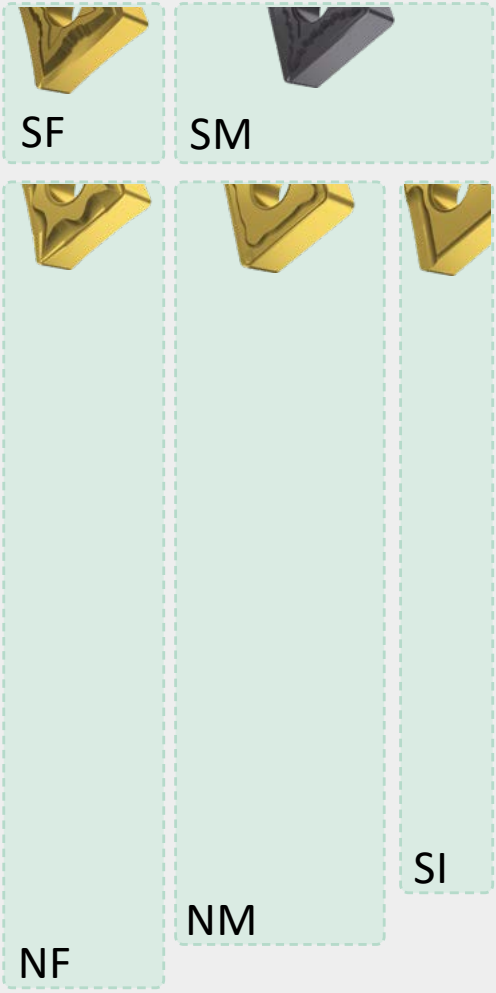
稳定工况

薄壁和细长工件

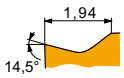
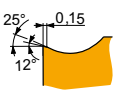
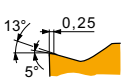


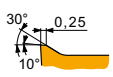
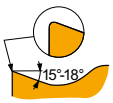
首选

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

S

首选

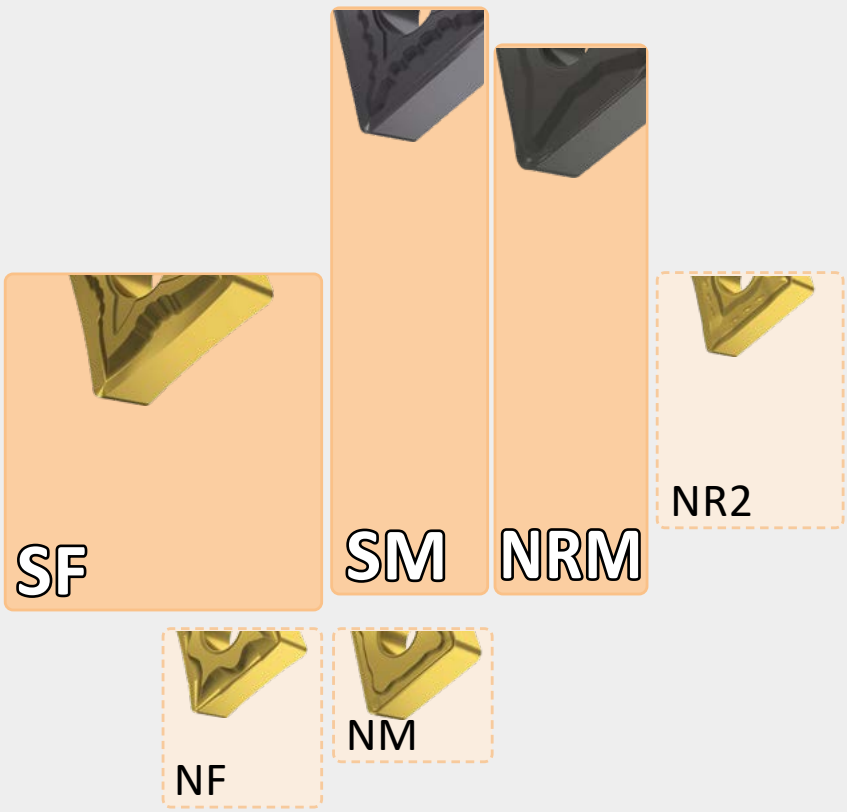
可以使用

非常不稳定工况

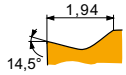
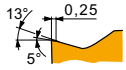
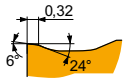
不稳定工况

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

H

非常不稳定工况

不稳定工况

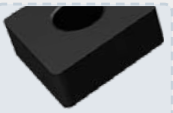
稳定工况

薄壁和细长工件

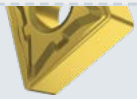
首选

可以使用





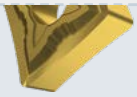
.NMA



R

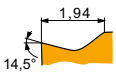
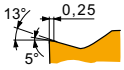


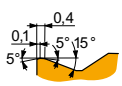
SM

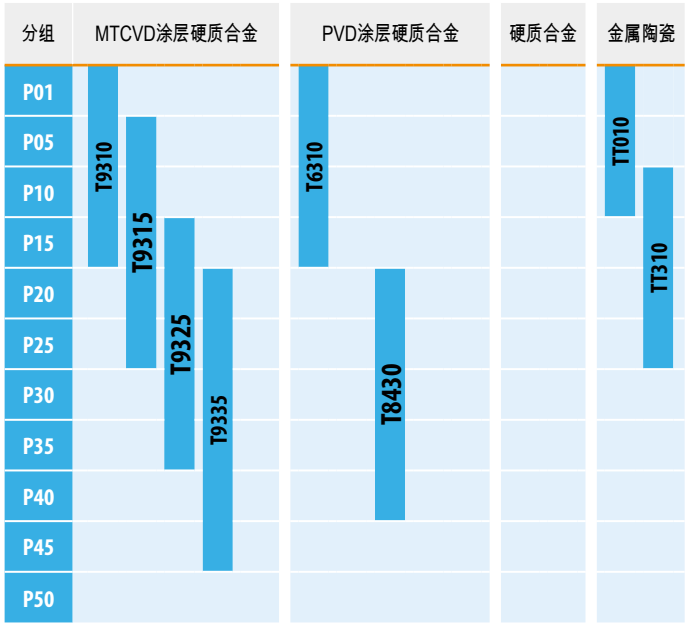


SF

	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

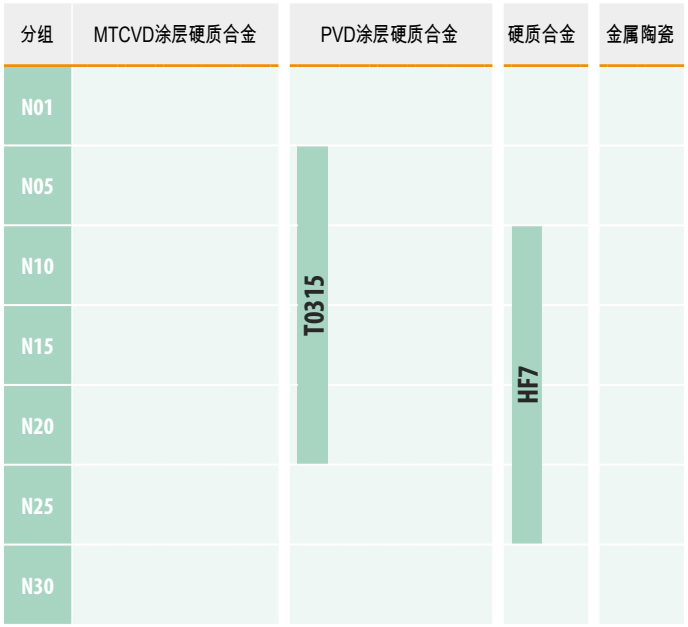
SF		通用正前角槽型，设计用于超精加工，钢、不锈钢、铸铁和高温合金，以及硬质材料，部分有色金属材料，并且用于加工薄壁，连续切削
SM		正前角槽型，设计用于中等精度加工，不锈钢、高温合金、钢和铸铁，部分有色金属和硬质材料，并且用于加工薄壁，连续切削和断续切削
.NMA		设计用于超精加工至半粗加工，铸铁，部分硬质材料，连续切削及轻断续切削

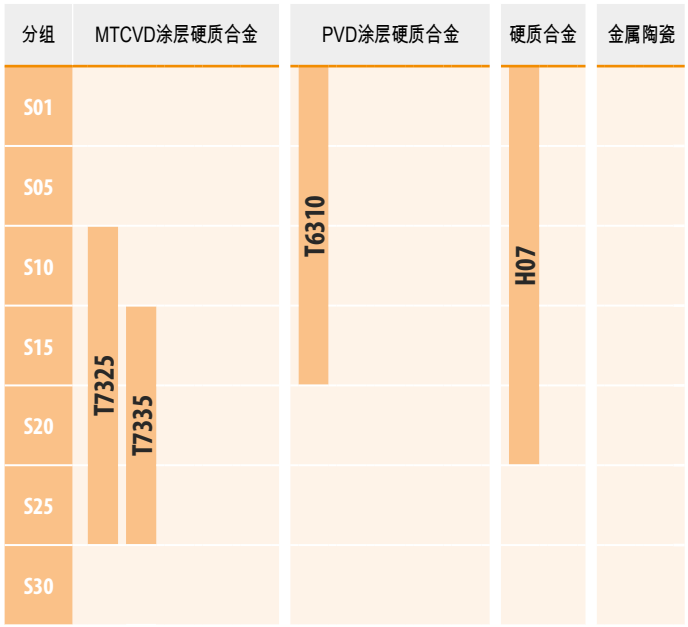
R		设计用于半粗加工和粗加工，铸铁，部分钢和硬质材料，连续切削及断续切削

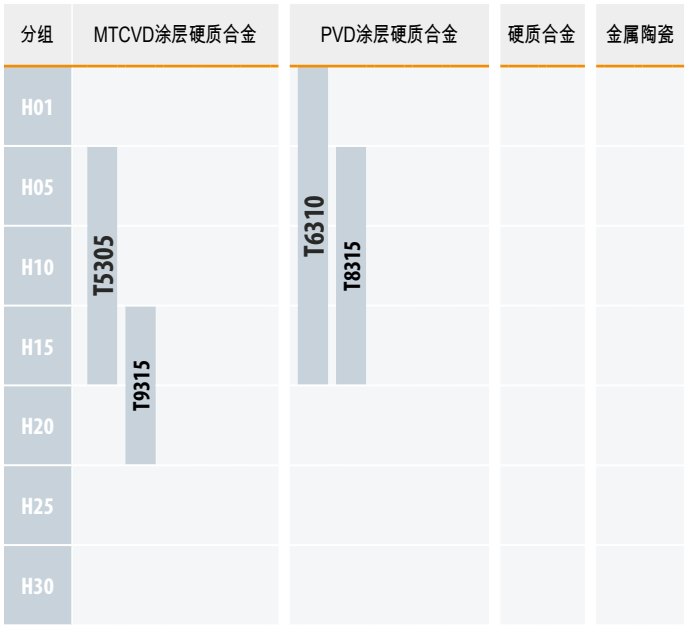

分组
MTCVD涂层硬质合金
PVD涂层硬质合金
硬质合金
金属陶瓷
P01
P05
P10
P15
P20
P25
P30
P35
P40
P45
P50
T9310
T9315
T9325
T9335
T6310
T8430
TT010
TT310


分组
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
T9325
T6310
T8315
T8430


分组
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
T8430
HF7


分组
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


分组
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
H07


分组
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
T9315
T6310
T8315

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
T9310	P01 - P15 K05 - K20 H10 - H20	■ ◪ ◪				MT-CVD		FGM	++	高耐磨材质，可用于轻微断续切削。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。
T9315	P05 - P25 K05 - K25 H10 - H20	■ ◪ ◪				MT-CVD		FGM	++	通用材质，即使在高强度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。得益于出色的平衡属性，该材质是许多车削操作的首选。不适合低线速度操作。
T9325	P15 - P35 M10 - M30 K15 - K35 S10 - S20	■ ■ ◪ ◪				MT-CVD		FGM	++	从技术角度来看，这是一种通用性极高的材质，在不利切削工况下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。
T9335	P20 - P45 M15 - M40 S15 - S25	■ ■ ◪				MT-CVD		FGM	+++	最坚韧的材质之一，尤其适用于中-高进给及中等线速度下的不利切削工况。M15 – M40比前代产品更坚韧，但也更耐磨，适合在高强度切削工况下使用。
T7325	P15 - P35 M10 - M25 S10 - S25	◪ ■ ■				MT-CVD		FGM	+++	应用最广泛的车削材质之一。专门设计用于加工不锈钢。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。
T7335	P20 - P40 M20 - M40 S15 - S25	◪ ■ ■				MT-CVD		FGM	+++	带功能梯度型基体的材质，具有极高的加工可靠性和出色的耐磨性。最适合切削韧性极强的M20 – M40材料。
T5305	P05 - P15 K01 - K15 H05 - H15	◪ ■ ◪				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。得益于出色的耐磨性，其也适用于对硬化和经过处理的K01 – K15材料进行生产加工。
T5315	P10 - P25 K10 - K25 H15 - H25	◪ ■ ◪				MT-CVD		H	+	该材质主要用于生产加工，具有高耐磨性和良好的加工可靠性。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。
6640	P20 - P40 M20 - M35 K25 - K40	■ ■ ■				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。

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
T8315	P05 - P20 M05 - M20 K05 - K25 N05 - N25 S05 - S15 H05 - H15	◪ ■ ■ ■ ◪ ■				PVD		submicron H	++	该材质具有出色的耐磨性，以及高于平均水平的加工可靠性，适合以中高线速度加工短切屑硬质材料。
T8430 NEW	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， 因此适合中低线速度切削加工。
T8330	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25 H15 - H25	■ ■ ■ ◪ ◪ ◪				PVD		submicron H	+++	通用切削材料，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，主要用于严苛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，建议将其用于低线速度切削。
T6310	P01 - P15 M01 - M15 K05 - K20 N05 - N20 S01 - S15 H01 - H15	■ ■ ■ ■ ■ ■				PVD		ultra submicron H	+++	高耐磨性车削材质，带PVD表面涂层。适用于非常重视切削刃锋利度和高后刀面耐磨损性的精加工操作及应用。
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，兼具优良的耐磨性与韧性。其独特涂层具有良好的摩擦特性。
HF7	M10 - M20 K10 - K25 N10 - N25	◪ ■ ■				×		submicron H	++	无涂层材质，主要用于加工有色金属；也可用于其他加工材料（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。其优点是切削刃强度高，耐磨性良好。
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。

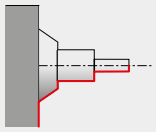
材质识别	应用范围	应用	进给	线速度	耐受不利工况	涂层	颜色	基材	冷却优势	材质说明
TT010	P01 - P10 M01 - M10	■ ◪	▰▱▱▱▱	▰▱▱▱▱	▰▱▱▱▱	×		cermet	+/–	不带涂层的金属陶瓷，适用于对所有类型的钢（包括不锈钢）进行极低进给精加工。其主要优点是切削刃半径保持在最小，并具有出色的抗物理和化学磨损特性。
TC100	K01 - K15	■	▰▰▱▱▱	▰▱▱▱▱	▰▱▱▱▱	×		ceramics	– -	用于铸铁加工的陶瓷材质。适合稳定条件下的高线速度加工。
TB310	K01 - K10 S05 - S10 H01 - H10	■ ◪ ◪	▰▰▱▱▱	▰▱▱▱▱	▰▱▱▱▱	×		CBN	– -	用于加工硬化材料的CBN材质。适合在稳定工况下进行高线速度、小进给量加工。
PD1	N05 - N25	■	▰▰▱▱▱	▰▱▱▱▱	▰▱▱▱▱	×		PCD	-	用于车削有色金属材料的PKD材质。稳定工况下进行高线速度、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

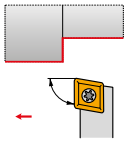
切削液的优点	
+ + +	必须使用冷却剂
+ +	强烈建议使用冷却剂
+	建议使用冷却剂
+/–	选择使用冷却剂
– -	不使用冷却剂
–	不建议使用冷却剂

ISO 外圆车削
长形和不稳定工件 (正角刀片)



SCAC(RL) EXT
90°

CC..
06
09

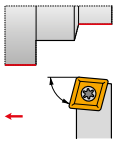


08×08
16×16

70
60 – 69

SCBC(RL) EXT
75°

CC..
09
12

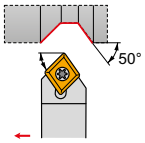


12×12
25×25

71
60 – 69

SCDCR EXT
45°

CC..
06

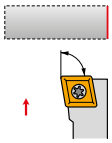


10×10

72
60 – 69

SCFC(RL) EXT
90°

CC..
06
09

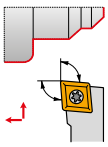


08×08
16×16

73
60 – 69

SCLC(RL) EXT
95°

CC..
06
08
09
12

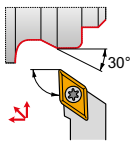


08×08
25×25

74
60 – 69

SDJC(RL) EXT
93°

DC..
07
11
15

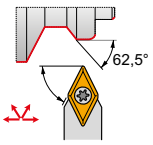


08×08
25×25

94
86 – 93

SDNCN EXT
62°30´

DC..
7
11

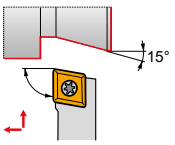


08×08
25×25

95
86 – 93

SEGC(RL) EXT
90°

EC..
08

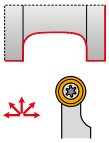


12×12
16×16

107
104 – 106

SRDC(RL) EXT

RC..
08

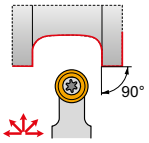


20×20
32×25

126
118 – 123

SRDCN EXT

RC..
06
08
10
12
16

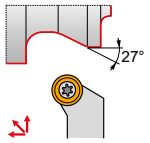


12×12
32×25

127
118 – 123

SRSC(RL) EXT

RC..
06
08
10
12
16

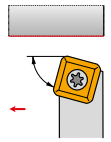


12×12
32×25

128
118 – 123

SSBC(RL) EXT
75°

SC..
09
12
25
38

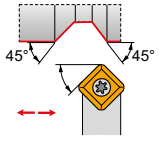


12×12
60×60

139
134 – 138

SSDCN EXT
45°

SC..
09
12

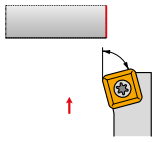


12×12
25×25

140
134 – 138

SSKC(RL) EXT
75°

SC..
09
12

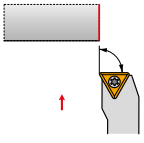


12×12
25×25

141
134 – 138

STFC(RL) EXT
90°

TC..
11
16

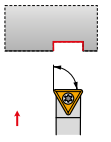


16×16
25×25

155
149 – 154

STFC(RL)-A EXT
90°

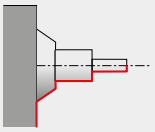
TC..
11



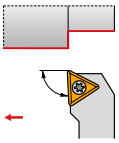
20×20

156
149 – 154

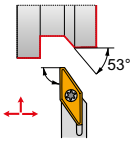
ISO 外圆车削
长形和不稳定工件 (正角刀片)



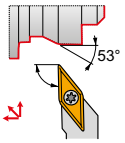
STJC(RL) EXT

93°	TC..
	11 16
16×16 25×25	
157	149 – 154

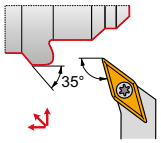
SVAC(RL)-DC EXT

90°	VC..
	13
10×10 25×25	
193	186 – 192

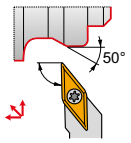
SVGC(RL) EXT

90°	VC..
	07
08×08 16×16	
194	186 – 192

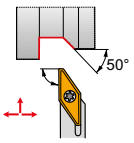
SVHB(C)(RL) EXT

107°30´	VB, VC..
	11 16
16×16 25×25	
172, 195	168 – 171 186 – 192

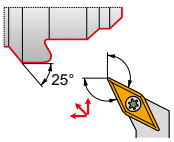
SVJB(C)(RL) EXT

93°	VB, VC..
	11 13 16
12×12 32×25	
173, 196	168 – 171 186 – 192

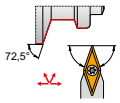
SVJC(RL)-DC EXT

93°	VC..
	13
10×10 25×25	
197	186 – 192

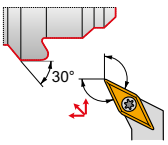
SVPB(C)(RL) EXT

117°30´	VB, VC..
	11 16
16×16 32×25	
174, 198	168 – 171 186 – 192

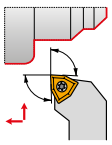
SVVB(C)N EXT

72°30´	VB, VC..
	11 13 16
12×12 32×25	
175, 199	168 – 171 186 – 192

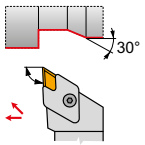
SVXB(C)(RL) EXT

98°	VB, VC..
	11 13 16
12×12 32×25	
176, 200	168 – 171 186 – 192

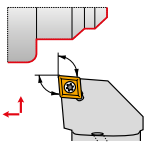
SWLC(RL) EXT

95°	WC..
	06 08
16×16 25×25	
215	212 – 214

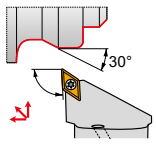
CKJN(RL) EXT

93°	KN..
	16
20×20 32×25	
287	284 – 286

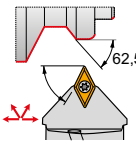
C.-SCLC(RL) EXT NEW

95°	CC..
	09 12
20 32	
75	60 – 69

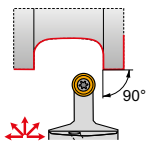
C.-SDJC(RL) EXT NEW

93°	DC..
	11
C3 C5	
96	86 – 93

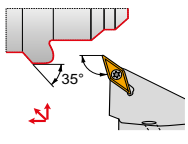
C.-SDNCN EXT NEW

62°30´	DC..
	11
C4 C5	
97	86 – 93

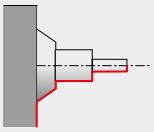
C.-SRDCN EXT NEW

	RC..
	10 12
C4 C5	
130	118 – 123

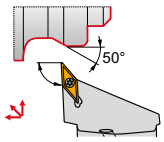
C.-SVHB(RL) EXT NEW

107°30´	VB, VC..
	16
C4 C6	
177, 201	168 – 171 186 – 192

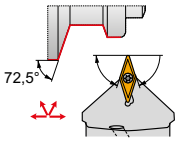
ISO 外圆车削
长形和不稳定工件 (正角刀片)



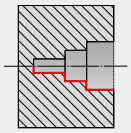
C.-SVJB(RL) EXT NEW

93°	VB, VC..
	11 16
C3 / C6	
178, 202	168 – 171 186 – 192

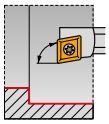
C.-SVVBN EXT NEW

72°30´	VB, VC..
	16
C4 / C6	
179, 203	168 – 171 186 – 192

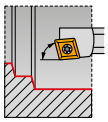
ISO 内孔车削
长形和不稳定工件 (正角刀片)



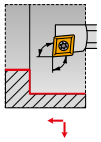
SCFC(RL) INT

90°	CC..
	06
ØDmin 13/16	
76	60 – 69

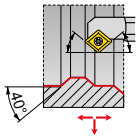
SCKC(RL) INT

75°	CC..
	06 09 12
ØDmin 11/40	
77	60 – 69

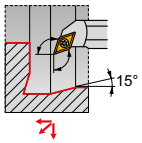
SCLC(RL) INT

95°	CC..
	06 09 12
ØDmin 11/40	
78	60 – 69

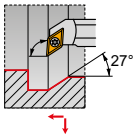
SCXC(RL) INT

40°	CC..
	06
ØDmin 13/20	
80	60 – 69

SDQC(RL) INT

107°30´	DC..
	07 11
ØDmin 13/40	
98	86 – 93

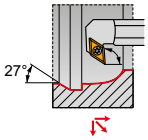
SDUC(RL) INT

93°	DC..
	07 11
ØDmin 13/40	
99	86 – 93

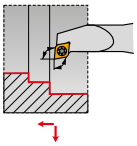
SDUC(RL)-E INT

93°	DC..
	07 11
ØDmin 13/40	
100	86 – 93

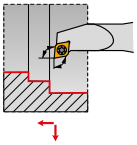
SDZC(RL) INT

93°	DC..
	07 11
ØDmin 27/65	
101	86 – 93

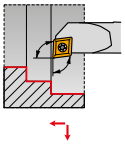
SELP(RL) INT

95°	EP..
	05
ØDmin 8/16	
111	110

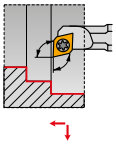
SELP(RL)-E INT

95°	EP..
	05
ØDmin 8/16	
112	110

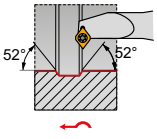
SEUC(RL) INT

93°	EC..
	06 08
ØDmin 11/32	
108	104 – 106

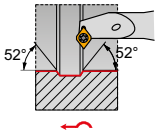
SEUP(RL) INT

93°	EP..
	05
ØDmin 8.3	
113	110

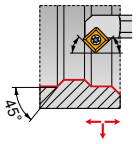
SEXP(RL) INT

52°30´	EP..
	05
ØDmin 9.5/16	
114	110

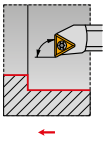
SEXP(RL)-E INT

52°30´	EP..
	05
ØDmin 9.5/16	
115	110

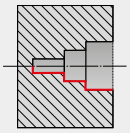
SSSC(RL) INT

45°	SC..
	09
ØDmin 25/32	
144	134 – 138

STFC(RL) INT

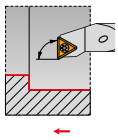
90°	TC..
	06 09 11 16
ØDmin 8.5/40	
158	149 – 154

ISO 内孔车削
长形和不稳定工件 (正角刀片)



STFC(RL)-E INT

90°



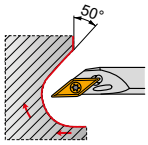
ØDmin 8.5 / 20

TC..
06
09
11

160 | 149 – 154

SVJB(RL) INT

93°



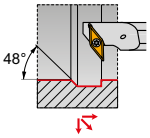
ØDmin 25 / 32

VB, VC..
11

180, 204 | 168 – 171, 186 – 192

SVLC(RL) INT

95°



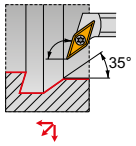
ØDmin 27 / 43

VC..
13

205 | 186 – 192

SVQB(C)(RL) INT

107°30´



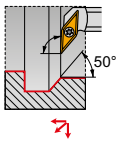
ØDmin 20 / 50

VB, VC..
11
13
16

181, 206 | 168 – 171, 186 – 192

SVUB(C)(RL) INT

93°



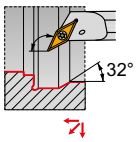
ØDmin 20 / 50

VB, VC..
11
13
16

182, 207 | 168 – 171, 186 – 192

SVXC(RL) INT

113°



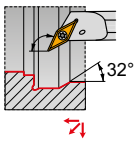
ØDmin 12.5 / 17.5

VC..
07

208 | 186 – 192

SVXC(RL)-E INT

113°



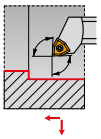
ØDmin 12.5 / 17.5

VC..
07

209 | 186 – 192

SWLC(RL) INT

95°



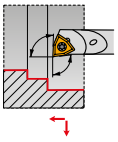
ØDmin 25 / 40

WC..
06
08

216 | 212 – 214

SWUC(RL) INT

93°



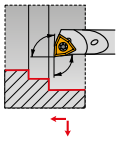
ØDmin 5.8 / 7.8

WC..
02

217 | 212 – 214

SWUC(RL)-E INT

93°



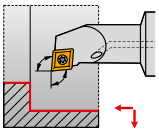
ØDmin 5.8 / 7.8

WC..
02

218 | 212 – 214

C.-SCLC(RL) INT NEW

95°



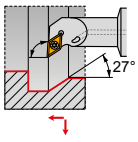
ØDmin C3 / C5

CC..
09

81 | 60 – 69

C.-SDUC(RL) INT NEW

93°



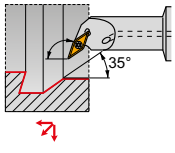
ØDmin 20 / 32

DC..
07
11

102 | 86 – 93

C.-SVQB(C)(RL) INT NEW

108°

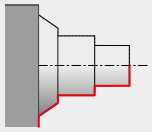


ØDmin 33

VB, VC..
16

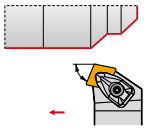
183, 210 | 168 – 171, 186 – 192

ISO 外圆车削
短型和稳定工件 (负角刀片)



DCBN(RL) EXT

75°



CN..

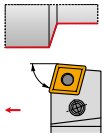
12
16
19

20×20
40×40

240 | 222 – 239

PCBN(RL) EXT

75°



CN..

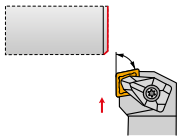
12
16
19
25

20×20
50×50

245 | 222 – 239

DCKN(RL) EXT

75°



CN..

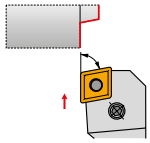
12
16

20×20
32X32

242 | 222 – 239

PCKN(RL) EXT

75°



CN..

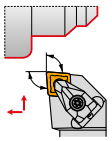
12
16
19

20×20
40×40

246 | 222 – 239

DCLN(RL) EXT

95°



CN..

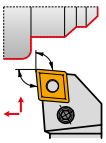
09
12
16
19

16×16
40×40

243 | 222 – 239

PCLN(RL) EXT

95°



CN..

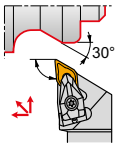
12
16
19
25

20×20
50×50

247 | 222 – 239

DDJN(RL) EXT

93°



DN..

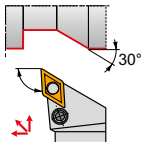
11
15

20×20
32×32

273 | 260 – 272

PDJN(RL) EXT

93°



DN..

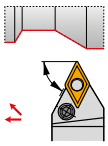
11
15

20×20
32×32

274 | 260 – 272

PDNN(RL) EXT

62°30´



DN..

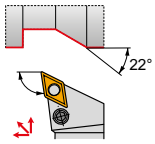
11
15

20×20
32×25

275 | 260 – 272

PDXN(RL) EXT

98°



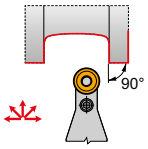
DN..

15

20×20
32×25

276 | 260 – 272

PRDCN EXT



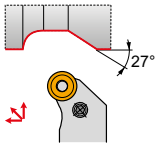
RC..

16
20
25
32

32×25
50×50

124 | 118 – 123

PRSC(RL) EXT



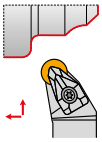
RC..

16
20
25

32×25
40×40

125 | 118 – 123

DRSN(RL) EXT



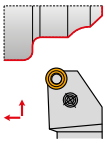
RN..

12

25×25

295 | 294

PRSN(RL) EXT



RN..

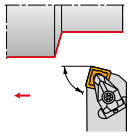
12
15
19

25×25
40×40

296 | 294

DSBN(RL) EXT

75°



SN..

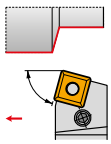
12
15
19

20×20
40×40

313 | 300 – 312

PSBN(RL) EXT

75°



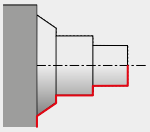
SN..

12
15
19
25

20×20
50×50

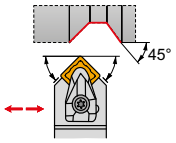
318 | 300 – 312

ISO 外圆车削
短型和稳定工件 (负角刀片)



DSDNN EXT

45°



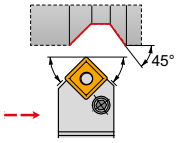
SN..
12
15
19
25

20×20
40×40

315
300 – 312

PSDNN EXT

45°



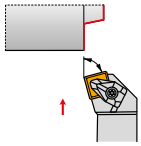
SN..
12
15
19
25

20×20
50×50

320
300 – 312

DSKN(RL) EXT

75°



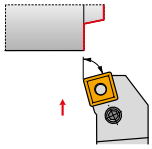
SN..
12
19

25×25
32×32

316
300 – 312

PSKN(RL) EXT

75°



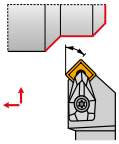
SN..
12
15
19
25

20×20
50×50

321
300 – 312

DSSN(RL) EXT

45°



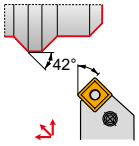
SN..
12
15
19

20×20
40×40

317
300 – 312

PSSN(RL) EXT

45°



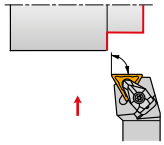
SN..
12
15
19
25

20×20
50×50

323
300 – 312

DTFN(RL) EXT

90°



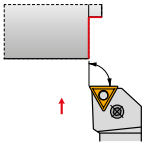
TN..
16
22

20×20
25×25

345
334 – 344

PTFN(RL) EXT

90°



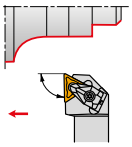
TN..
16
22
27

16×16
40×40

348
334 – 344

DTGN(RL) EXT

90°



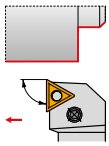
TN..
16
22

20×20
32×25

346
334 – 344

PTGN(RL) EXT

90°



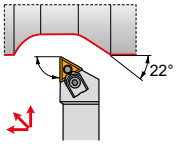
TN..
16
22
27

16×16
40×40

349
334 – 344

MTJN(RL) EXT

93°



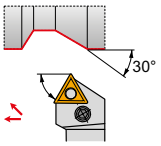
TN..
16
22

16×16
32×32

347
334 – 344

PTTN(RL) EXT

60°



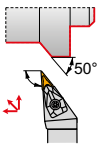
TN..
16
22

20×20
32×25

350
334 – 344

DVJN(RL) EXT

93°



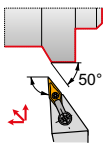
VN..
16

20×20
32×25

360
356 – 376

MVJN(RL) EXT

93°



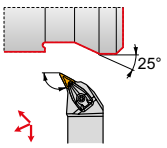
VN..
16

20×20
32×25

362
356 – 376

DVPN(RL) EXT

62°30′



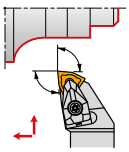
VN..
16

20×20
32×25

361
356 – 376

DWLN(RL) EXT

95°

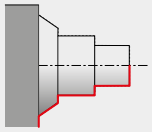


WN..
06
08
10
13

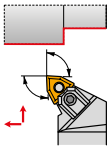
16×16
40×40

377
366 – 376

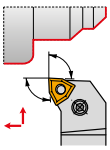
ISO 外圆车削
短型和稳定工件 (负角刀片)



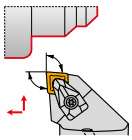
MWLN(RL) EXT

95°	WN..
	08
25×25 40×40	
379	366 – 376

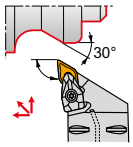
PWLN(RL) EXT

95°	WN..
	06 08
16×16 32×25	
380	366 – 376

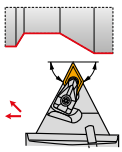
C.-DCLN(RL) EXT NEW

95°	CN..
	12 16 19
C3 C8	
249	222 – 239

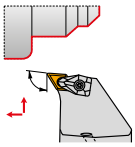
C.-DDJN(RL) EXT NEW

93°	DN..
	11 15
C4 C6	
277	260 – 272

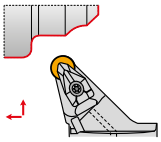
C.-DDNNN EXT NEW

62.5°	DN..
	15
C5 C6	
278	260 – 272

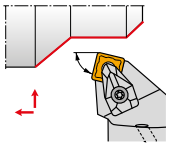
C.-DDUN(RL) EXT NEW

93°	DN..
	15
C5 C6	
279	260 – 272

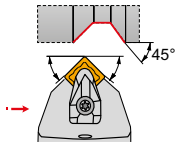
C.-DRSN(RL) EXT NEW

	RN..
	12
C6	
297	294

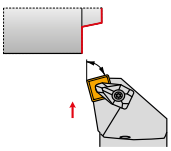
C.-DSRN(RL) EXT NEW

75°	SN..
	12 19
C4 C6	
326	300 – 312

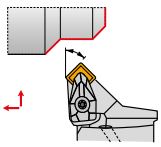
C.-DSDNN EXT NEW

45°	SN..
	12 19
C4 C6	
324	300 – 312

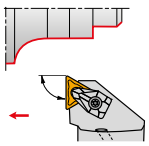
C.-DSKN(RL) EXT NEW

75°	SN..
	12
C4	
325	300 – 312

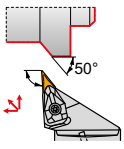
C.-DSSN(RL) EXT NEW

45°	SN..
	12
C4 C5	
327	300 – 312

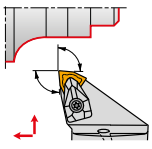
C.-DTJN(RL) EXT NEW

93°	TN..
	16
C4 C5	
351	334 – 344

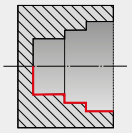
C.-DVJN(RL) EXT NEW

93°	VN..
	16
C4 C6	
363	356 – 376

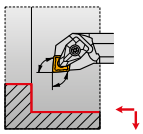
C.-DWLN(RL) EXT NEW

95°	WN..
	06 08
C4 C6	
381	366 – 376

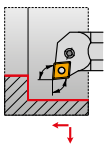
ISO 内孔车削
短型和稳定工件 (负角刀片)



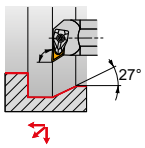
DCLN(RL) INT

95°	CN..
	09 12
ØDmin 32 / 50	
254	222 – 239

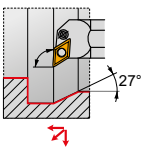
PCLN(RL) INT

95°	CN..
	09 12 16 19
ØDmin 20 / 80	
255	222 – 239

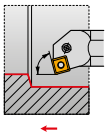
DDUN(RL) INT

93°	DN..
	11 15
ØDmin 25 / 50	
280	260 – 272

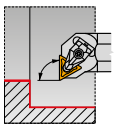
PDUN(RL) INT

93°	DN..
	11 15
ØDmin 25 / 60	
281	260 – 272

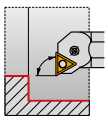
PSKN(RL) INT

93°	SN..
	11 15
ØDmin 32 / 80	
331	300 – 312

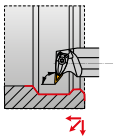
DTFN(RL) INT

90°	TN..
	16 22
ØDmin 32 / 50	
352	334 – 344

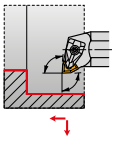
PTFN(RL) INT

90°	TN..
	16 22
ØDmin 32 / 50	
353	334 – 344

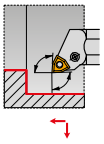
DVUN(RL) INT

	VN..
	16
ØDmin 50	
364	356 – 376

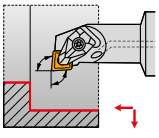
DWLN(RL) INT

95°	WN..
	06 08
ØDmin 32 / 63	
382	366 – 376

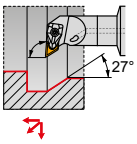
PWLN(RL) INT

95°	WN..
	06 08
ØDmin 20 / 80	
383	366 – 376

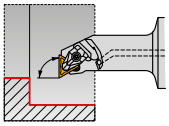
C.-DCLN(RL) INT NEW

95°	CN..
	09 12 16
ØDmin 25 / 50	
257	222 – 239

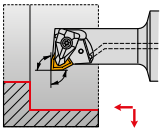
C.-DDUN(RL) INT NEW

93°	DN..
	11
ØDmin 12	
282	260 – 272

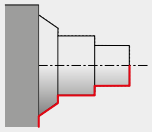
C.-DTFN(RL) INT NEW

91°	TN..
	16
ØDmin 32	
354	334 – 344

C.-DWLN(RL) INT NEW

95°	WN..
	06 08
ØDmin 27 / 33	
385	366 – 376

ISO 外圆重载车削
固定刀杆

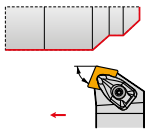


DCBN(RL) EXT

75°

CN..

19



40×40

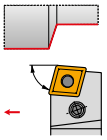
240 | 222 – 239

PCBN(RL) EXT

75°

CN..

19
25



40×40
50×50

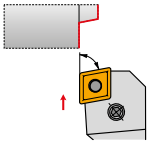
245 | 222 – 239

PCKN(RL) EXT

75°

CN..

19



40×40

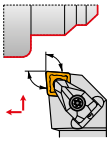
246 | 222 – 239

DCLN(RL) EXT

95°

CN..

19



40×40

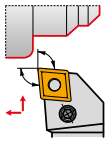
243 | 222 – 239

PCLN(RL) EXT

95°

CN..

19
25



40×40
50×50

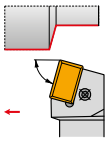
247 | 222 – 239

PLBN(RL) EXT

75°

LN..

40
50



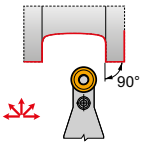
60×60

290 | 289

PRDCN EXT

RC..

20
25
32



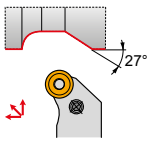
40×40
50×50

124 | 118 – 123

PRSC(RL) EXT

RC..

16
25



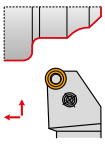
40×40

125 | 118 – 123

PRSN(RL) EXT

RN..

19



40×40

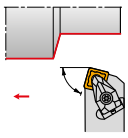
296 | 294

DSBN(RL) EXT

75°

SN..

19



40×40

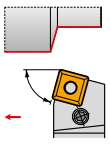
313 | 300 – 312

PSBN(RL) EXT

75°

SN..

19
25



40×40
50×50

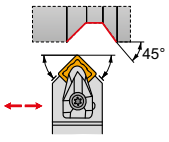
318 | 300 – 312

DSDNN EXT

45°

SN..

19
25



40×40

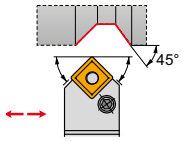
315 | 300 – 312

PSDNN EXT

45°

SN..

19
25



40×40
50×50

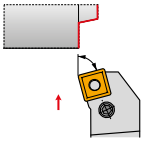
320 | 300 – 312

PSKN(RL) EXT

75°

SN..

19
25



40×40
50×50

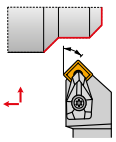
321 | 300 – 312

DSSN(RL) EXT

45°

SN..

19



40×40

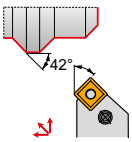
317 | 300 – 312

PSSN(RL) EXT

45°

SN..

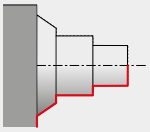
19
25



40×40
50×50

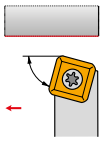
323 | 300 – 312

ISO 外圆重载车削
固定刀杆



SSBC(RL) EXT

75°



SC..



25
38

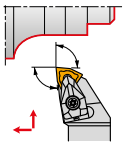
40×40
60×60

139

134 – 138

DWLN(RL) EXT

95°



WN..



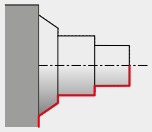
13

40×40

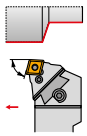
377

366 – 376

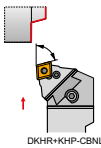
ISO 外圆重载车削
可换刀头(KH)



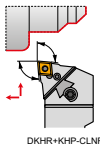
KHP-CBNR + DKH(RL)

75°	CN..
 DKHR+KHP-CBNR	25
40×50 60×80	
251, 253	222 – 239

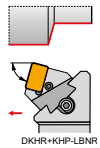
KHP-CBNL + DKH(RL)

75°	CN..
 DKHR+KHP-CBNL	25
40×50 60×80	
251, 253	222 – 239

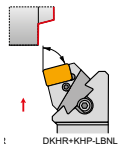
KHP-CLNR/L + DKH(RL)

95°	CN..
 DKHR+KHP-CLNR	19 25
40×50 60×80	
252, 253	222 – 239

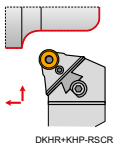
KHP-LBNR + DKH(RL)

75°	LN..
 DKHR+KHP-LBNR	40
40×50 60×80	
291, 292	289

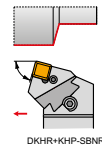
KHP-LBNL + DKH(RL)

75°	LN..
 DKHR+KHP-LBNL	40
40×50 60×80	
291, 292	289

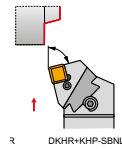
KHP-RSCR/L + DKH(RL)

	RC..
 DKHR+KHP-RSCR	20 25 32
40×50 60×80	
131, 132	118 – 123

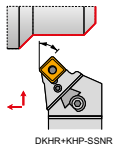
KHP-SBNR + DKH(RL)

75°	SN..
 DKHR+KHP-SBNR	25
40×50 60×80	
328, 330	300 – 312

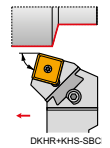
KHP-SBNL + DKH(RL)

75°	SN..
 DKHR+KHP-SBNL	25
40×50 60×80	
328, 330	300 – 312

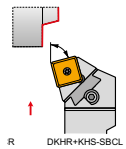
KHP-SSNR/L + DKH(RL)

45°	SN..
 DKHR+KHP-SSNR	19 25
40×50 60×80	
329, 330	300 – 312

KHS-SBCR + DKH(RL)

75°	SC..
 DKHR+KHS-SBC	25 38
40×50 60×80	
142, 143	134 – 138

KHS-SBCL + DKH(RL)

75°	SC..
 DKHR+KHS-SBCL	25 38
40×50 60×80	
142, 143	134 – 138

DORMER PRAMET

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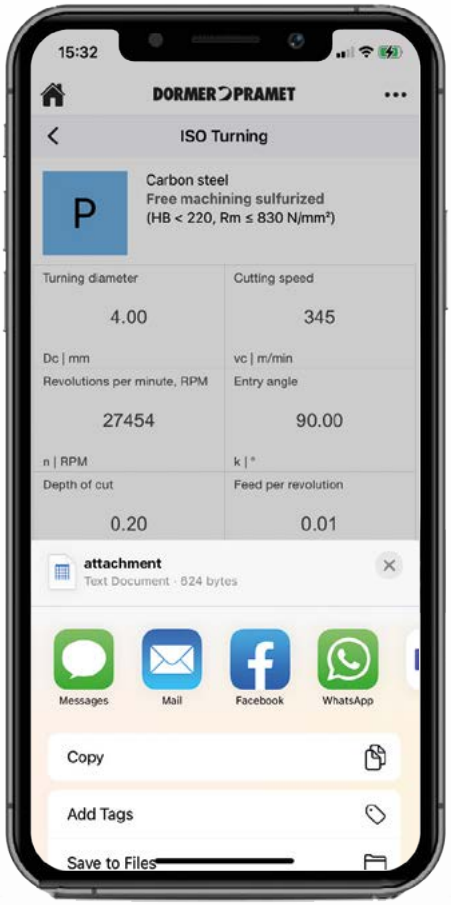

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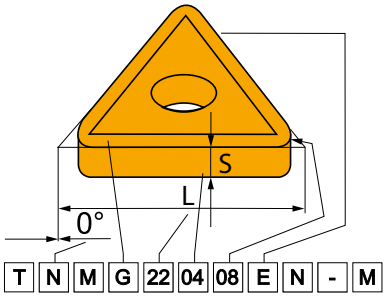


	1	2	3	4
ISO	T T	N N	U M	N G
ANSI	T T	N N	U M	 G

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

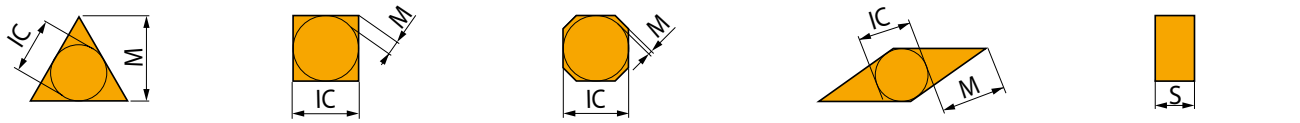
A 3°		B 5°	
C 7°		D 15°	
E 20°		F 25°	
G 30°		N 0°	
P 11°		O	非标

4 刀片类型

N	
R	
F	
A	
M	
G	
W	40° – 60°
T	
Q	
U	
B	70° – 90°
H	
C	
J	
X	非标

3 公差

	(mm)			(")		
	M (±)	S (±)	IC (±)	M (±)	S (±)	IC (±)
A	0.005	0.025	0.025	.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"

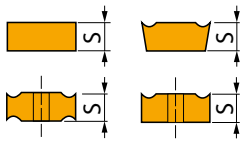


5	6	7	8	9		10
22	04	08			-	
22	04	08	E	N		M
5	6	7	8	9		10
4	3	2			-	
4	3	2	E	N		M

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"



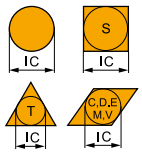
圆刀片

d=I.C. (")	00
d=I.C. (mm)	M0



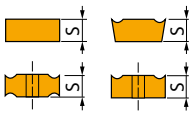
ANSI

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

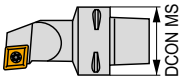
R	进给 ←	N	进给 ← → 进给
L	→ 进给		

10 断屑槽类型

外圆车削刀具 – ISO代码名称

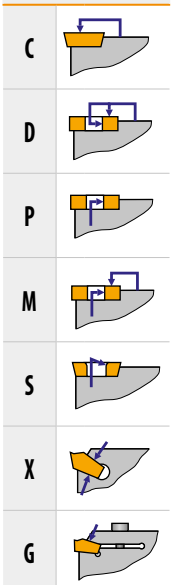
		1	2	3	4	5	6		7	8	9	10	11	12	13
刀柄 刀具	ISO		P	C	L	N	R	–	32	25			L	12	– M
件数	ISO	C4	– D	C	L	N	R	–	27	050			–	12	
刀柄 刀具	ANSI		2 D	3 C	4 L	5 N	6 R	–	7 & 8 16				12 4		11 D

1 耦合尺寸

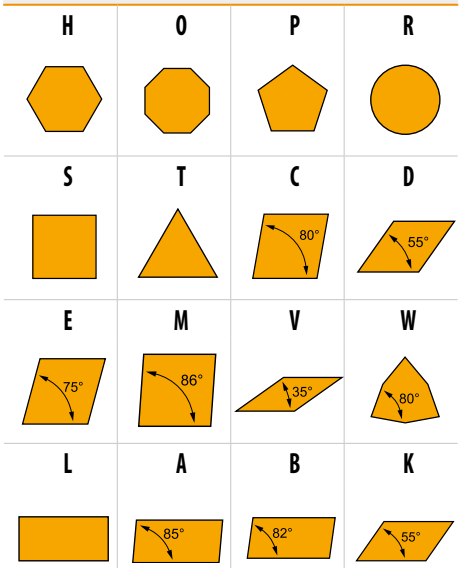


C	DCON MS
C3	32
C4	40
C5	50
C6	63
C8	80

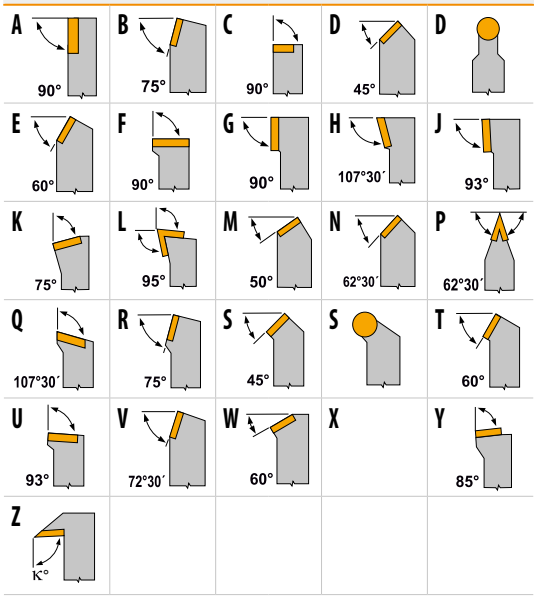
2 夹紧类型



3 ISO代码 - 刀片



4 刀杆类型 - 主偏角

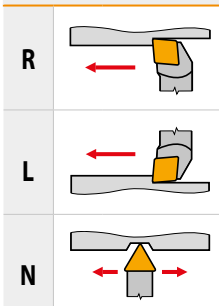


5 刀片后角

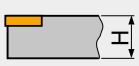


N	B	C	P
0°	5°	7°	11°

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)



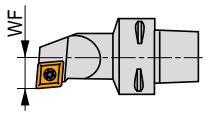
08	10	12	16	20	25
32	38	40	45	50	60

7 & 8 刀杆宽度 & 高度 (")

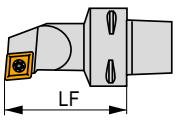
Symbol	B (")	H (")
05	5/16"	5/16"
06	3/8"	3/8"
08	1/2"	1/2"
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"
24	1 1/2"	1 1/2"
32	2"	2"

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

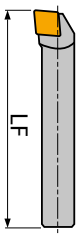
9 功能宽度[mm]



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

	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.		H	O	P	S	T	C	D	E	M	V	W	R	K
(mm)	(")													
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
. .	

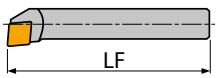
15 / 15 刀杆

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

刀夹

1	2		3	4	5	6	7
KH	P	–	C	L	N	R	25

刀杆

8	6	9	10	11
DKH	R	50	60	W

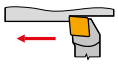
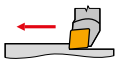
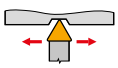
1 刀夹

5 刀片后角

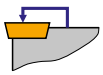
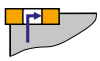
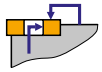
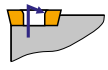
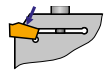


N	C	P
0°	7°	11°

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

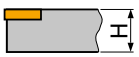
A 90°	B 75°	C 90°	D 45°	D
E 60°	F 90°	G 90°	H 107°30′	J 93°
K 75°	L 95°	M 50°	N 62°30′	P 62°30′
Q 107°30′	R 75°	S 45°	S	T 60°
U 93°	V 72°30′	W 60°	X Special	Y 85°
Z K°				

7 刀片切削刃长度(刀片尺寸)

d=I.C.		H	O	P	S	T	C	D	E	M	V	W	R	K
(mm)	(")													
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												

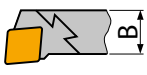
8 刀杆

9 刀杆高度 (mm)



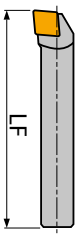
08	10	12	16	20	25
32	40	50	60	70	80

10 刀杆宽度 (mm)

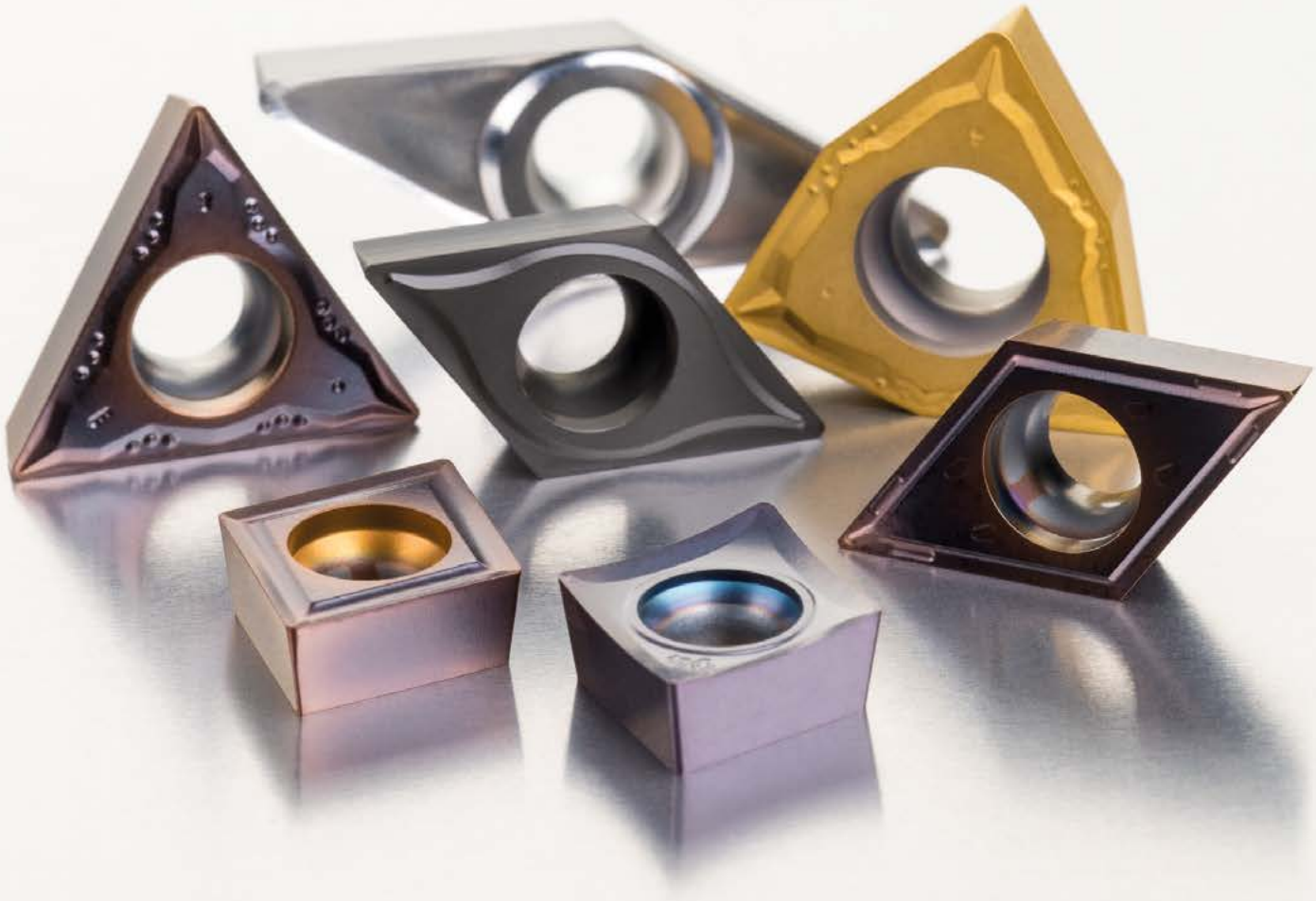


08	10	12	16	20	25
32	40	50	60	70	80

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



正前角刀片

CC

06 / 08 / 09 / 12

硬质合金刀片

CCGT



60

CCMT



62

CCMW



68

CBN刀片

CCGW CBN



69

匹配正确的尺寸（示例）

刀片	刀杆
CCMT 120404E-UR	S32U-SCKCR 12-A

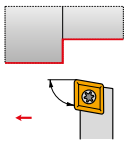
ISO 外圆车削

SCAC(RL) EXT

90°

CC..

06
09



08×08
16×16

70

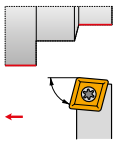
60 – 69

SCBC(RL) EXT

75°

CC..

09
12



12×12
25×25

71

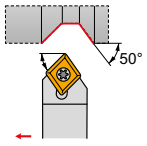
60 – 69

SCDCR EXT

45°

CC..

06



10×10

72

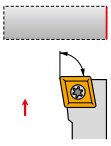
60 – 69

SCFC(RL) EXT

90°

CC..

06
09



08×08
16×16

73

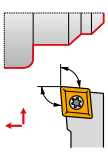
60 – 69

SCLC(RL) EXT

95°

CC..

06
08
09
12



08×08
25×25

74

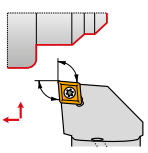
60 – 69

C.-SCLC(RL) EXT NEW

95°

CC..

09
12



C3
C5

75

60 – 69

CC

06 / 08 / 09 / 12

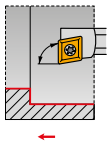
ISO内孔车削

SCFC(RL) INT

90°

CC..

06



ØDmin 13/16

76

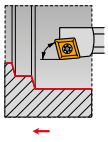
60 – 69

SCKC(RL) INT

75°

CC..

06
09
12



ØDmin 11/40

77

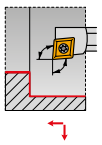
60 – 69

SCLC(RL) INT

95°

CC..

06
09
12



ØDmin 11/40

78

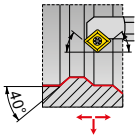
60 – 69

SCXC(RL) INT

40°

CC..

06



ØDmin 13/20

80

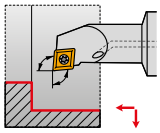
60 – 69

C.-SCLC(RL) INT NEW

95°

CC..

09



ØDmin 20/32

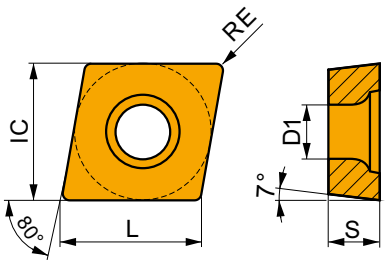
81

60 – 69

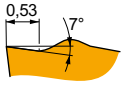
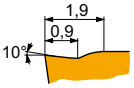
CCGT

PRAMET

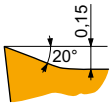
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0602-SF3	6.350	2.80	6.40	2.58
0803-AL	7.940	3.40	8.10	3.43
0803-SF3	7.940	3.40	8.10	3.43
09T3	9.525	4.40	9.70	3.97
09T3-SF3	9.525	4.40	9.70	4.22
1204	12.700	5.50	12.90	4.76
1204-SF3	12.700	5.50	12.90	5.01



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

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
AL断屑槽，具有大正前角设计，适用于精加工至粗加工，连续切削至轻微断续切削。																				
CCGT 060202F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	450	0.12	1.0	–	–	–	–	–	–
	T0315	0.2	–	–	–	–	–	–	–	–	–	645	0.12	1.0	–	–	–	–	–	–
CCGT 060204F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	360	0.24	1.0	–	–	–	–	–	–
	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	–	–	–	–	–	–
	T0315	0.4	–	–	–	–	–	–	–	–	–	525	0.24	1.0	–	–	–	–	–	–
CCGT 09T302F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	450	0.12	1.0	–	–	–	–	–	–
	T0315	0.2	–	–	–	–	–	–	–	–	–	645	0.12	1.0	–	–	–	–	–	–
CCGT 09T304F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	345	0.24	1.5	–	–	–	–	–	–
	T0315	0.4	–	–	–	–	–	–	–	–	–	495	0.24	1.5	–	–	–	–	–	–
CCGT 09T308F-AL	**HF7**	0.8	–	–	–	–	–	–	–	–	–	315	0.48	1.5	–	–	–	–	–	–
	T0315	0.8	–	–	–	–	–	–	–	–	–	450	0.48	1.5	–	–	–	–	–	–
CCGT 120404F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	330	0.24	2.4	–	–	–	–	–	–
	T0315	0.4	–	–	–	–	–	–	–	–	–	480	0.24	2.4	–	–	–	–	–	–
CCGT 120408F-AL	**HF7**	0.8	–	–	–	–	–	–	–	–	–	300	0.48	2.4	–	–	–	–	–	–
	T0315	0.8	–	–	–	–	–	–	–	–	–	435	0.48	2.4	–	–	–	–	–	–
																				
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
CCGT 09T302E-FF2	**T7325**	0.2	235	0.05	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.2	345	0.05	1.0	–	–	–	325	0.05	1.0	–	–	–	–	–	–	–	–	–
																				
NF1断屑槽，具有正前角设计，适用于超精加工至中度加工，连续切削。																				
CCGT 060204E-NF1	**H07**	0.4	–	–	–	95	0.09	0.8	–	–	–	485	0.12	0.8	45	0.07	0.6	–	–	–
	T6310	0.4	180	0.10	0.8	125	0.09	0.8	–	–	–	540	0.12	0.8	50	0.07	0.6	35	0.15	1.0
	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	0.15	1.0
	T7325	0.8	235	0.12	0.8	180	0.11	0.8	–	–	–	–	–	–	75	0.11	0.6	–	–	–
CCGT 09T304E-NF1	**H07**	0.4	–	–	–	90	0.09	1.2	–	–	–	470	0.12	1.2	45	0.07	1.0	–	–	–
	T6310	0.4	175	0.10	1.2	125	0.09	1.2	–	–	–	525	0.12	1.2	50	0.07	1.0	35	0.15	1.0
	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	0.15	1.0
	T7325	0.8	215	0.14	1.2	165	0.13	1.2	–	–	–	–	–	–	65	0.13	1.0	–	–	–

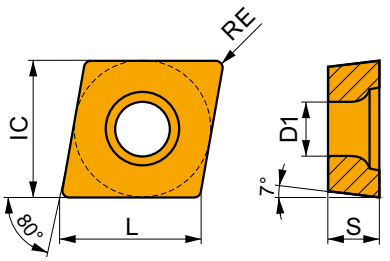
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
SF3断屑槽，具有大正前角设计，适用于精细的精加工，连续切削。																				
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	0.15	1.0
CCGT 060202E-SF3	H07	0.2	–	–	–	120	0.05	0.8	190	0.05	0.8	605	0.06	0.8	60	0.04	0.6	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	0.15	1.0
	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	0.15	1.0
CCGT 080304E-SF3	H07	0.4	–	–	–	95	0.09	1.0	150	0.10	1.0	485	0.12	1.0	45	0.07	0.8	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	0.15	1.0
CCGT 09T302E-SF3	H07	0.2	–	–	–	120	0.05	0.8	190	0.05	0.8	605	0.06	0.8	60	0.04	0.6	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
																				
ER-SI断屑槽，具有正前角设计，右手设计，适用于超精加工，连续切削。																				
CCGT 060202ER-SI	T8330	0.2	215	0.10	0.8	125	0.09	0.8	200	0.10	0.8	–	–	–	50	0.08	0.6	–	–	–
	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	–	–	–
	T8330	0.4	215	0.12	0.8	125	0.11	0.8	200	0.12	0.8	–	–	–	50	0.10	0.6	–	–	–
	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	–	–	–
	T8330	0.4	195	0.17	0.8	115	0.15	0.8	185	0.17	0.8	–	–	–	45	0.15	0.6	–	–	–
	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	T8330	0.8	205	0.23	1.0	120	0.21	1.0	190	0.23	1.0	–	–	–	50	0.21	0.8	–	–	–
	T8430	0.8	230	0.24	1.0	125	0.22	1.0	185	0.24	1.0	–	–	–	45	0.22	0.8	–	–	–
																				
EL-SI断屑槽，具有正前角，左手设计，适用于超精加工，连续切削。																				
CCGT 060202EL-SI	T8330	0.2	215	0.10	0.8	125	0.09	0.8	200	0.10	0.8	–	–	–	50	0.08	0.6	–	–	–
	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	–	–	–
	T8330	0.4	215	0.12	0.8	125	0.11	0.8	200	0.12	0.8	–	–	–	50	0.10	0.6	–	–	–
	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	–	–	–
	T8330	0.4	195	0.17	0.8	115	0.15	0.8	185	0.17	0.8	–	–	–	45	0.15	0.6	–	–	–
	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	T8330	0.8	205	0.23	1.0	120	0.21	1.0	190	0.23	1.0	–	–	–	50	0.21	0.8	–	–	–
	T8430	0.8	230	0.24	1.0	125	0.22	1.0	185	0.24	1.0	–	–	–	45	0.22	0.8	–	–	–

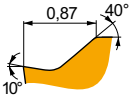
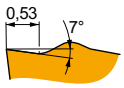
CCMT

PRAMET

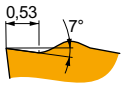
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



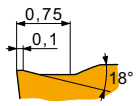
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
FF断屑槽，具有正前角设计，适用于超精加工，连续切削或轻微断续切削。																				
CCMT 060202E-FF	**T8315**	0.2	◪ 195	0.10	1.0	◪ 115	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.2	■ 185	0.10	1.0	◪ 110	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8430	0.2	■ 230	0.10	1.0	◪ 125	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.2	■ 315	0.10	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF	**T8315**	0.4	◪ 195	0.12	1.0	◪ 115	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 185	0.12	1.0	◪ 110	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 225	0.12	1.0	◪ 120	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 310	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF	**T8315**	0.4	◪ 190	0.12	1.2	◪ 110	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 185	0.12	1.2	◪ 110	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 225	0.12	1.2	◪ 120	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 300	0.12	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
CCMT 060202E-FF2	**T7325**	0.2	◪ 240	0.05	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.2	■ 205	0.05	0.8	–	–	–	■ 190	0.05	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.2	■ 280	0.05	0.8	–	–	–	◪ 230	0.05	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.2	■ 390	0.05	0.8	–	–	–	◪ 370	0.05	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	■ 350	0.05	0.8	–	–	–	◪ 330	0.05	0.8	–	–	–	–	–	–	–	–	–
	TT010	0.2	■ 345	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2	**T7325**	0.4	◪ 190	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 165	0.12	1.0	–	–	–	■ 155	0.12	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 205	0.12	1.0	–	–	–	◪ 170	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 280	0.12	1.0	–	–	–	◪ 265	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 255	0.12	1.0	–	–	–	◪ 240	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 215	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	TT010	0.4	■ 280	0.12	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080302E-FF2	**T7325**	0.2	◪ 240	0.05	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.2	■ 205	0.05	0.8	–	–	–	■ 190	0.05	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.2	■ 280	0.05	0.8	–	–	–	◪ 230	0.05	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	■ 350	0.05	0.8	–	–	–	◪ 330	0.05	0.8	–	–	–	–	–	–	–	–	–
	TT010	0.2	■ 345	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2	**T7325**	0.4	◪ 190	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 165	0.12	1.0	–	–	–	■ 155	0.12	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 205	0.12	1.0	–	–	–	◪ 170	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 255	0.12	1.0	–	–	–	◪ 240	0.12	1.0	–	–	–	–	–	–	–	–	–
	TT010	0.4	■ 350	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

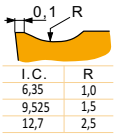
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
CCMT 080308E-FF2	**T7325**	0.8	205	0.17	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	180	0.17	1.0	–	–	–	170	0.17	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	210	0.17	1.0	–	–	–	175	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	260	0.17	1.0	–	–	–	245	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2	**T7325**	0.4	190	0.12	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	165	0.12	1.2	–	–	–	155	0.12	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.4	200	0.12	1.2	–	–	–	165	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.4	275	0.12	1.2	–	–	–	260	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	250	0.12	1.2	–	–	–	235	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9335	0.4	215	0.12	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	TT010	0.4	350	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2	**T7325**	0.8	205	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	175	0.17	1.2	–	–	–	165	0.17	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.8	205	0.17	1.2	–	–	–	170	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.8	285	0.17	1.2	–	–	–	270	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	255	0.17	1.2	–	–	–	240	0.17	1.2	–	–	–	–	–	–	–	–	–
	TT010	0.8	350	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
CCMT 060202E-FM	**T7325**	0.2	210	0.10	1.0	160	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.2	210	0.10	1.0	160	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.2	195	0.10	1.0	115	0.09	1.0	185	0.10	1.0	585	0.12	1.0	–	–	–	–	–	–
	T8330	0.2	185	0.10	1.0	110	0.09	1.0	175	0.10	1.0	555	0.12	1.0	–	–	–	–	–	–
	T8430	0.2	230	0.10	1.0	125	0.09	1.0	185	0.10	1.0	630	0.12	1.0	–	–	–	–	–	–
	T9315	0.2	315	0.10	1.0	–	–	–	295	0.10	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.2	285	0.10	1.0	170	0.09	1.0	270	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM	**T7325**	0.4	200	0.15	1.0	155	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	195	0.15	1.0	150	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	185	0.15	1.0	110	0.14	1.0	175	0.15	1.0	555	0.18	1.0	–	–	–	–	–	–
	T8330	0.4	170	0.15	1.0	100	0.14	1.0	160	0.15	1.0	510	0.18	1.0	–	–	–	–	–	–
	T8430	0.4	205	0.15	1.0	110	0.14	1.0	170	0.15	1.0	570	0.18	1.0	–	–	–	–	–	–
	T9315	0.4	285	0.15	1.0	–	–	–	270	0.15	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.4	250	0.15	1.0	150	0.15	1.0	235	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-FM	**T7325**	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	190	0.20	1.0	110	0.18	1.0	180	0.20	1.0	570	0.24	1.0	–	–	–	–	–	–
	T8430	0.8	220	0.20	1.0	120	0.18	1.0	180	0.20	1.0	600	0.24	1.0	–	–	–	–	–	–
	T9315	0.8	300	0.20	1.0	–	–	–	285	0.20	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	265	0.20	1.0	155	0.18	1.0	250	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-FM	**T7325**	0.2	205	0.10	1.2	155	0.09	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.2	205	0.10	1.2	155	0.09	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.2	190	0.10	1.2	110	0.09	1.2	180	0.10	1.2	570	0.12	1.2	–	–	–	–	–	–
	T8330	0.2	180	0.10	1.2	105	0.09	1.2	170	0.10	1.2	540	0.12	1.2	–	–	–	–	–	–
	T8430	0.2	225	0.10	1.2	120	0.09	1.2	185	0.10	1.2	615	0.12	1.2	–	–	–	–	–	–
	T9315	0.2	310	0.10	1.2	–	–	–	290	0.10	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.2	275	0.10	1.2	165	0.09	1.2	260	0.10	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM	**T7325**	0.4	195	0.15	1.2	150	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	190	0.15	1.2	145	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	180	0.15	1.2	105	0.14	1.2	170	0.15	1.2	540	0.18	1.2	–	–	–	–	–	–
	T8330	0.4	170	0.15	1.2	100	0.14	1.2	160	0.15	1.2	510	0.18	1.2	–	–	–	–	–	–
	T8430	0.4	200	0.15	1.2	110	0.14	1.2	165	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–
	T9315	0.4	275	0.15	1.2	–	–	–	260	0.15	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	245	0.15	1.2	145	0.15	1.2	230	0.15	1.2	–	–	–	–	–	–	–	–	–

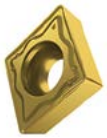
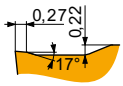
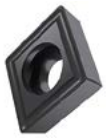
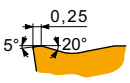
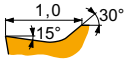
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
			FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																	
CCMT 09T308E-FM	T7325	0.8	215	0.20	1.2	165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	205	0.20	1.2	155	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	195	0.20	1.2	115	0.18	1.2	185	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–
	T8330	0.8	185	0.20	1.2	110	0.18	1.2	175	0.20	1.2	555	0.24	1.2	–	–	–	–	–	–
	T8430	0.8	210	0.20	1.2	115	0.18	1.2	175	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–
	T9315	0.8	290	0.20	1.2	–	–	–	275	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	260	0.20	1.2	155	0.18	1.2	245	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 120404E-FM	T7325	0.4	190	0.15	1.7	145	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	185	0.15	1.7	140	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	170	0.15	1.7	100	0.14	1.7	160	0.15	1.7	510	0.18	1.7	–	–	–	–	–	–
	T8330	0.4	165	0.15	1.7	95	0.14	1.7	155	0.15	1.7	495	0.18	1.7	–	–	–	–	–	–
	T8430	0.4	195	0.15	1.7	105	0.14	1.7	160	0.15	1.7	540	0.18	1.7	–	–	–	–	–	–
	T9315	0.4	265	0.15	1.7	–	–	–	250	0.15	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	240	0.15	1.7	140	0.15	1.7	225	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM	T7325	0.8	205	0.20	1.7	155	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	200	0.20	1.7	155	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–
	T8330	0.8	180	0.20	1.7	105	0.18	1.7	170	0.20	1.7	540	0.24	1.7	–	–	–	–	–	–
	T8430	0.8	205	0.20	1.7	110	0.18	1.7	170	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–
	T9315	0.8	280	0.20	1.7	–	–	–	265	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	250	0.20	1.7	150	0.18	1.7	235	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-FM	T8330	1.2	175	0.27	1.7	105	0.24	1.7	165	0.27	1.7	525	0.32	1.7	–	–	–	–	–	–
	T8430	1.2	190	0.27	1.7	105	0.24	1.7	155	0.27	1.7	525	0.32	1.7	–	–	–	–	–	–
	T9325	1.2	235	0.27	1.7	140	0.24	1.7	220	0.27	1.7	–	–	–	–	–	–	–	–	–
																				
			FM2断屑槽，适用于精加工至中等加工，连续至断续切削。																	
CCMT 080304E-FM2	T8330	0.4	165	0.12	1.0	95	0.11	1.0	155	0.12	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.4	205	0.12	1.0	110	0.11	1.0	170	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.4	280	0.12	1.0	–	–	–	265	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9335	0.4	215	0.12	1.0	125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2	T8330	0.8	180	0.17	1.0	105	0.15	1.0	170	0.17	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	210	0.17	1.0	115	0.15	1.0	175	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T8330	0.4	165	0.12	1.0	95	0.11	1.0	155	0.12	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.4	205	0.12	1.0	110	0.11	1.0	170	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.4	280	0.12	1.0	–	–	–	265	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.4	255	0.12	1.0	150	0.11	1.0	240	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	–	–	–	–	–	–	–	–	–
	T7325	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	180	0.17	1.0	105	0.15	1.0	170	0.17	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	210	0.17	1.0	115	0.15	1.0	175	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	290	0.17	1.0	–	–	–	275	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	225	0.17	1.0	135	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2	T7325	0.8	190	0.20	1.5	145	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	165	0.20	1.5	95	0.18	1.5	155	0.20	1.5	–	–	–	–	–	–	–	–	–
	T8430	0.8	190	0.20	1.5	105	0.18	1.5	155	0.20	1.5	–	–	–	–	–	–	–	–	–
	T9325	0.8	235	0.20	1.5	140	0.18	1.5	220	0.20	1.5	–	–	–	–	–	–	–	–	–
	T9335	0.8	200	0.20	1.5	120	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

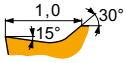
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
NF2断屑槽，具有正前角设计，适用于超精加工至中粗加工，连续切削。																				
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	–	–	–
	T7325	0.2	195	0.10	0.8	150	0.09	0.8	–	–	–	–	–	–	60	0.08	0.6	–	–	–
	T8330	0.2	170	0.10	0.8	100	0.09	0.8	160	0.10	0.8	510	0.12	0.8	40	0.08	0.6	–	–	–
	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	–	–	–
	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	**H07**	0.4	–	–	–	85	0.11	0.8	140	0.12	0.8	445	0.14	0.8	45	0.11	0.6	–	–	–
	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	–	–	–
	T7325	0.4	200	0.12	0.8	155	0.11	0.8	–	–	–	–	–	–	65	0.11	0.6	–	–	–
	T8330	0.4	170	0.12	0.8	100	0.11	0.8	160	0.12	0.8	510	0.14	0.8	40	0.11	0.6	–	–	–
	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	–	–	–
	T9315	0.4	290	0.12	0.8	–	–	–	275	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	255	0.12	0.8	150	0.11	0.8	240	0.12	0.8	–	–	–	55	0.11	0.6	–	–	–
	T9335	0.4	220	0.12	0.8	130	0.11	0.8	–	–	–	–	–	–	45	0.11	0.6	–	–	–
CCMT 080304E-NF2	**T5315**	0.4	280	0.12	1.0	–	–	–	265	0.12	1.0	–	–	–	–	–	–	–	–	–
	T7325	0.4	190	0.12	1.0	145	0.11	1.0	–	–	–	–	–	–	60	0.11	0.8	–	–	–
	T7335	0.4	190	0.12	1.0	145	0.11	1.0	–	–	–	–	–	–	60	0.11	0.8	–	–	–
	T9315	0.4	280	0.12	1.0	–	–	–	265	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	55	0.11	0.8	–	–	–
	T9335	0.4	215	0.12	1.2	125	0.11	1.2	–	–	–	–	–	–	45	0.11	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	–	–	–
	T5315	0.8	295	0.17	1.0	–	–	–	280	0.17	1.0	–	–	–	–	–	–	–	–	–
	T7325	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.14	0.8	–	–	–
	T7335	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.14	0.8	–	–	–
	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	–	–	–
	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	–	–	–
	T7325	0.4	190	0.12	1.2	145	0.11	1.2	–	–	–	–	–	–	60	0.11	1.0	–	–	–
	T8330	0.4	165	0.12	1.2	95	0.11	1.2	155	0.12	1.2	495	0.14	1.2	40	0.11	1.0	–	–	–
	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	–	–	–
	T9315	0.4	275	0.12	1.2	–	–	–	260	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	250	0.12	1.2	150	0.11	1.2	235	0.12	1.2	–	–	–	55	0.11	1.0	–	–	–
	T9335	0.4	215	0.12	1.2	125	0.11	1.2	–	–	–	–	–	–	45	0.11	1.0	–	–	–
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	–	–	–
	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	–	–	–
	T7325	0.8	215	0.14	1.2	165	0.13	1.2	–	–	–	–	–	–	65	0.13	1.0	–	–	–
	T8330	0.8	190	0.14	1.2	110	0.13	1.2	180	0.14	1.2	570	0.17	1.2	45	0.13	1.0	–	–	–
	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	–	–	–
	T9315	0.8	310	0.14	1.2	–	–	–	290	0.14	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	275	0.14	1.2	165	0.13	1.2	260	0.14	1.2	–	–	–	60	0.13	1.0	–	–	–
	T9335	0.8	235	0.14	1.2	140	0.13	1.2	–	–	–	–	–	–	50	0.13	1.0	–	–	–
	 I.C. R 6,35 1,0 9,525 1,5 12,7 2,5																			
RF断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
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	0.15	1.0
	T7335	0.4	160	0.15	1.0	120	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–	–	–	–
	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	0.15	1.0
	T7335	0.8	165	0.20	1.5	125	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
	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	0.15	1.0
	T7335	0.8	150	0.22	2.2	115	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	195	0.22	2.2	115	0.22	2.2	185	0.22	2.2	–	–	–	–	–	–	–	–	–

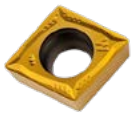
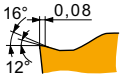
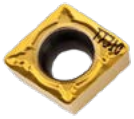
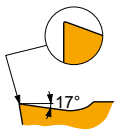
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
CCMT 09T304E-RM	**T5305**	0.4	260	0.27	2.2	–	–	–	245	0.27	2.2	–	–	–	–	–	–	50	0.15	1.0
	T5315	0.4	230	0.27	2.2	–	–	–	215	0.27	2.2	–	–	–	–	–	–	45	0.15	1.0
	T7335	0.4	155	0.27	2.2	120	0.24	2.2	–	–	–	–	–	–	50	0.19	1.8	–	–	–
	T8330	0.4	140	0.27	2.2	80	0.24	2.2	130	0.27	2.2	–	–	–	35	0.19	1.8	25	0.15	1.0
	T8430	0.4	150	0.27	2.2	80	0.24	2.2	125	0.27	2.2	–	–	–	30	0.19	1.8	25	0.15	1.0
	T9315	0.4	215	0.27	2.2	–	–	–	200	0.27	2.2	–	–	–	–	–	–	40	0.15	1.0
	T9325	0.4	190	0.27	2.2	110	0.24	2.2	180	0.27	2.2	–	–	–	40	0.19	1.8	–	–	–
CCMT 09T308E-RM	**T5305**	0.8	290	0.30	2.2	–	–	–	275	0.30	2.2	–	–	–	–	–	–	55	0.15	1.0
	T5315	0.8	265	0.30	2.2	–	–	–	250	0.30	2.2	–	–	–	–	–	–	50	0.15	1.0
	T7335	0.8	175	0.30	2.2	135	0.27	2.2	–	–	–	–	–	–	55	0.24	1.8	–	–	–
	T8330	0.8	165	0.30	2.2	95	0.27	2.2	155	0.30	2.2	–	–	–	40	0.24	1.8	30	0.15	1.0
	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	1.0
	T9315	0.8	240	0.30	2.2	–	–	–	225	0.30	2.2	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.8	215	0.30	2.2	125	0.27	2.2	200	0.30	2.2	–	–	–	45	0.24	1.8	–	–	–
CCMT 120408E-RM	**T5305**	0.8	290	0.30	2.7	–	–	–	275	0.30	2.7	–	–	–	–	–	–	55	0.15	1.0
	T5315	0.8	260	0.30	2.7	–	–	–	245	0.30	2.7	–	–	–	–	–	–	50	0.15	1.0
	T7335	0.8	175	0.30	2.7	135	0.27	2.7	–	–	–	–	–	–	55	0.24	2.2	–	–	–
	T8330	0.8	160	0.30	2.7	95	0.27	2.7	150	0.30	2.7	–	–	–	40	0.24	2.2	30	0.15	1.0
	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	1.0
	T9315	0.8	235	0.30	2.7	–	–	–	220	0.30	2.7	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.8	210	0.30	2.7	125	0.27	2.7	195	0.30	2.7	–	–	–	45	0.24	2.2	–	–	–
CCMT 120412E-RM	**T8330**	1.2	165	0.33	2.7	95	0.30	2.7	155	0.33	2.7	–	–	–	40	0.23	2.2	30	0.15	1.0
	T8430	1.2	180	0.33	2.7	95	0.30	2.7	145	0.33	2.7	–	–	–	35	0.23	2.2	30	0.15	1.0
	T9315	1.2	235	0.33	2.7	–	–	–	220	0.33	2.7	–	–	–	–	–	–	45	0.15	1.0
	T9325	1.2	215	0.33	2.7	125	0.30	2.7	200	0.33	2.7	–	–	–	45	0.23	2.2	–	–	–
																				
RM3断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
CCMT 120404E-RM3	**T7325**	0.4	140	0.25	2.5	105	0.25	2.5	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.4	190	0.25	2.5	–	–	–	180	0.25	2.5	–	–	–	–	–	–	35	0.15	1.0
	T9325	0.4	165	0.25	2.5	95	0.25	2.5	155	0.25	2.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-RM3	**T6310**	0.8	145	0.27	2.5	100	0.27	2.5	115	0.27	2.5	–	–	–	–	–	–	25	0.15	1.0
	T7325	0.8	165	0.27	2.5	125	0.27	2.5	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.8	215	0.27	2.5	–	–	–	200	0.27	2.5	–	–	–	–	–	–	40	0.15	1.0
	T9325	0.8	195	0.27	2.5	115	0.27	2.5	185	0.27	2.5	–	–	–	–	–	–	–	–	–
CCMT 120412E-RM3	**T7325**	1.2	170	0.30	2.5	130	0.27	2.5	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	1.2	220	0.30	2.5	–	–	–	205	0.30	2.5	–	–	–	–	–	–	40	0.15	1.0
																				
UR断屑槽，适用于精细的精加工，连续切削或轻微断续切削。																				
CCMT 060202E-UR	**T7325**	0.2	185	0.10	0.8	140	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.2	185	0.10	0.8	140	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.2	170	0.10	0.8	100	0.09	0.8	160	0.10	0.8	–	–	–	–	–	–	–	–	–
	T8330	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.2	200	0.10	0.8	110	0.09	0.8	165	0.10	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.2	275	0.10	0.8	–	–	–	260	0.10	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	250	0.10	0.8	150	0.09	0.8	235	0.10	0.8	–	–	–	–	–	–	–	–	–
	TT310	0.2	275	0.10	0.5	165	0.09	0.5	–	–	–	–	–	–	–	–	–	–	–	–

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

产品型号		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)
																				
	UR断屑槽，适用于精细的精加工，连续切削或轻微断续切削。																			
CCMT 060204E-UR	**T5315**	0.4	◪	245	0.15	1.0		–	–	–	■	230	0.15	1.0	–	–	–	–	–	–	–	–	–
	T7325	0.4	◪	170	0.15	1.0	◪	130	0.15	1.0		–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	◪	170	0.15	1.0	◪	130	0.15	1.0		–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	◪	160	0.15	1.0	◪	95	0.14	1.0	■	150	0.15	1.0	–	–	–	–	–	–	–	–	–
	T8330	0.4	■	150	0.15	1.0	◪	90	0.14	1.0	■	140	0.15	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.4	■	175	0.15	1.0	◪	95	0.14	1.0	◪	140	0.15	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.4	■	245	0.15	1.0		–	–	–	◪	230	0.15	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.4	■	215	0.15	1.0	◪	125	0.15	1.0	◪	200	0.15	1.0	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪	190	0.20	1.0	◪	145	0.18	1.0		–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■	165	0.20	1.0	◪	95	0.18	1.0	■	155	0.20	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	■	185	0.20	1.0	◪	100	0.18	1.0	◪	150	0.20	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	■	255	0.20	1.0		–	–	–	◪	240	0.20	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■	230	0.20	1.0	◪	135	0.18	1.0	◪	215	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	–	–	–	–	–	–	–	–	–
	T8430	0.2	■	195	0.10	1.0	◪	105	0.09	1.0	◪	160	0.10	1.0	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.4	◪	170	0.15	1.2	◪	130	0.15	1.2		–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	◪	165	0.15	1.2	◪	125	0.15	1.2		–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	◪	155	0.15	1.2	◪	90	0.14	1.2	■	145	0.15	1.2	–	–	–	–	–	–	–	–	–
	T8330	0.4	■	150	0.15	1.2	◪	90	0.14	1.2	■	140	0.15	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.4	■	175	0.15	1.2	◪	95	0.14	1.2	◪	140	0.15	1.2	–	–	–	–	–	–	–	–	–
	T9310	0.4	■	265	0.15	1.2		–	–	–	◪	250	0.15	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.4	■	235	0.15	1.2		–	–	–	◪	220	0.15	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■	215	0.15	1.2	◪	125	0.15	1.2	◪	200	0.15	1.2	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪	185	0.20	1.2	◪	140	0.18	1.2		–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪	175	0.20	1.2	◪	135	0.18	1.2		–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	◪	170	0.20	1.2	◪	100	0.18	1.2	■	160	0.20	1.2	–	–	–	–	–	–	–	–	–
	T8330	0.8	■	160	0.20	1.2	◪	95	0.18	1.2	■	150	0.20	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.8	■	185	0.20	1.2	◪	100	0.18	1.2	◪	150	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9310	0.8	■	280	0.20	1.2		–	–	–	◪	265	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.8	■	250	0.20	1.2		–	–	–	◪	235	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■	225	0.20	1.2	◪	135	0.18	1.2	◪	210	0.20	1.2	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.4	◪	160	0.15	1.7	◪	120	0.15	1.7		–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■	140	0.15	1.7	◪	80	0.14	1.7	■	130	0.15	1.7	–	–	–	–	–	–	–	–	–
	T8430	0.4	■	170	0.15	1.7	◪	90	0.14	1.7	◪	135	0.15	1.7	–	–	–	–	–	–	–	–	–
	T9315	0.4	■	230	0.15	1.7		–	–	–	◪	215	0.15	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	■	205	0.15	1.7	◪	120	0.15	1.7	◪	190	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR	**T5315**	0.8	◪	255	0.20	1.7		–	–	–	■	240	0.20	1.7	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪	175	0.20	1.7	◪	135	0.18	1.7		–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪	170	0.20	1.7	◪	130	0.18	1.7		–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■	155	0.20	1.7	◪	90	0.18	1.7	■	145	0.20	1.7	–	–	–	–	–	–	–	–	–
	T8430	0.8	■	180	0.20	1.7	◪	95	0.18	1.7	◪	145	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9315	0.8	■	240	0.20	1.7		–	–	–	◪	225	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	■	215	0.20	1.7	◪	125	0.18	1.7	◪	200	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR	**T5315**	1.2	◪	240	0.27	1.7		–	–	–	■	225	0.27	1.7	–	–	–	–	–	–	–	–	–
	T7325	1.2	◪	170	0.27	1.7	◪	130	0.24	1.7		–	–	–	–	–	–	–	–	–	–	–	–
	T8430	1.2	■	165	0.27	1.7	◪	90	0.24	1.7	◪	135	0.27	1.7	–	–	–	–	–	–	–	–	–
	T9315	1.2	■	225	0.27	1.7		–	–	–	◪	210	0.27	1.7	–	–	–	–	–	–	–	–	–
	T9325	1.2	■	205	0.27	1.7	◪	120	0.24	1.7	◪	190	0.27	1.7	–	–	–	–	–	–	–	–	–

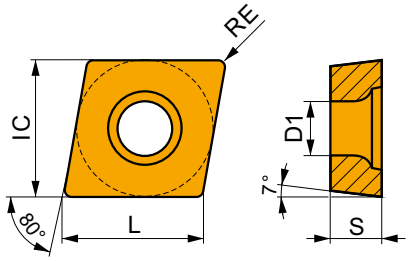
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
			W S																	
			W-FM修光刃断屑槽，可以提高进给量并改善表面光洁度，从而完成精细的精加工。																	
CCMT 060204W-FM	**T7325**	0.4	165	0.30	0.8	125	0.27	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8430	0.4	165	0.30	0.8	90	0.27	0.8	135	0.30	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	215	0.30	0.8	–	–	–	200	0.30	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM	**T7325**	0.4	165	0.30	0.8	125	0.27	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	145	0.30	0.8	85	0.27	0.8	135	0.30	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	165	0.30	0.8	90	0.27	0.8	135	0.30	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	215	0.30	0.8	–	–	–	200	0.30	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T308W-FM	**T8330**	0.8	155	0.40	1.0	90	0.36	1.0	145	0.40	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	170	0.40	1.0	90	0.36	1.0	135	0.40	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	220	0.40	1.0	–	–	–	205	0.40	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	200	0.40	1.0	120	0.36	1.0	190	0.40	1.0	–	–	–	–	–	–	–	–	–
			W E																	
			W-UR修光刃断屑槽，适用于精细的精加工，提供更高的进给量并改善了表面光洁度。																	
CCMT 060204W-UR	**TT310**	0.4	255	0.15	0.5	150	0.14	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308W-UR	**TT310**	0.8	255	0.20	1.2	150	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–

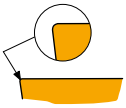
CCMW

PRAMET

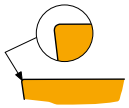
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



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

产品型号		RE	P			M			K			N			S			H		
			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)
			E																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
CCMW 060202	**T5305**	0.2	–	–	–	–	–	–	230	0.08	2.0	–	–	–	–	–	–	45	0.15	1.0
	T6310	0.2	–	–	–	–	–	–	100	0.08	2.0	–	–	–	–	–	–	25	0.15	1.0
CCMW 060204	**T5305**	0.4	–	–	–	–	–	–	230	0.10	2.0	–	–	–	–	–	–	45	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	195	0.10	2.0	–	–	–	–	–	–	40	0.15	1.0
	T6310	0.4	–	–	–	–	–	–	95	0.10	2.0	–	–	–	–	–	–	20	0.15	1.0
CCMW 09T304	**T5305**	0.4	–	–	–	–	–	–	215	0.10	3.0	–	–	–	–	–	–	45	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	190	0.10	3.0	–	–	–	–	–	–	40	0.15	1.0
	T6310	0.4	–	–	–	–	–	–	95	0.10	3.0	–	–	–	–	–	–	20	0.15	1.0
CCMW 09T308	**T5305**	0.8	–	–	–	–	–	–	200	0.20	3.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	180	0.20	3.0	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	90	0.20	3.0	–	–	–	–	–	–	20	0.15	1.0

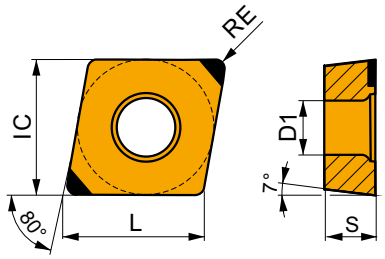
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
CCMW 120404	T5305	0.4	–	–	–	–	–	–	210	0.10	4.0	–	–	–	–	–	–	45	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	185	0.10	4.0	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.4	–	–	–	–	–	–	90	0.10	4.0	–	–	–	–	–	–	20	0.15	1.0
CCMW 120408	T5305	0.8	–	–	–	–	–	–	195	0.20	4.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	175	0.20	4.0	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	90	0.20	4.0	–	–	–	–	–	–	20	0.15	1.0

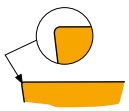
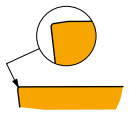
CCGW CBN

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。

产品型号		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)
																				
			适用于精加工。																	
CCGW 060204E-B	TB310	0.4	–	–	–	–	–	–	460	0.10	0.4	–	–	–	120	0.07	0.3	95	0.15	1.0
CCGW 09T304E-B	TB310	0.4	–	–	–	–	–	–	460	0.10	0.4	–	–	–	120	0.07	0.3	95	0.15	1.0
																				
			适用于精加工。																	
CCGW 060204S01020B	TB310	0.4	–	–	–	–	–	–	460	0.10	0.4	–	–	–	120	0.07	0.3	95	0.15	1.0
CCGW 09T304S01020B	TB310	0.4	–	–	–	–	–	–	460	0.10	0.4	–	–	–	120	0.07	0.3	95	0.15	1.0

SCAC(RL) EXT

P M K N S H

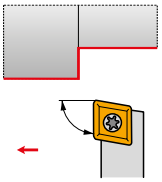
PRAMET

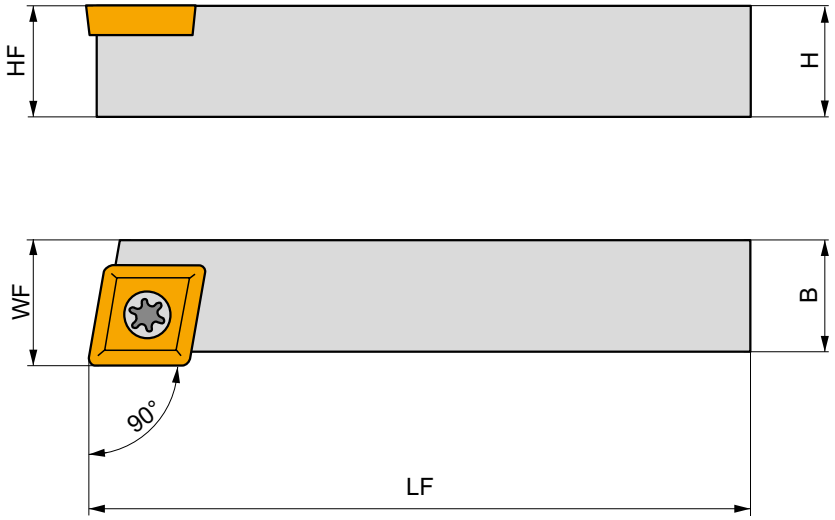
S

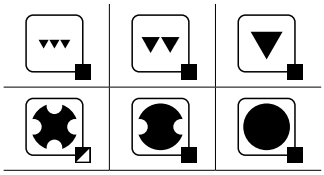


外圆用螺钉夹紧式车刀杆，使用CC..刀片，主偏角为90°。

外圆用左/右手持式车刀杆，主偏角为90°，螺钉锁紧式。使用CC..06或09正前角刀片。适用于外圆用轴向，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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
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	0.09	GI045	S07
	SCACR 1212 F 09	12	12	12	12.5	80	0	0	0.12	GI041	S04
	SCACR 1616 H 09	16	16	16	16.5	100	0	0	0.22	GI041	S04
L	SCACL 0808 D 06	8	8	8	8.5	60	0	0	0.07	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 1616 H 09	16	16	16	16.5	100	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

SCBC(RL) EXT

P M K N S H

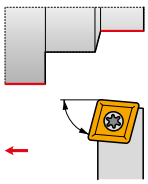
PRAMET

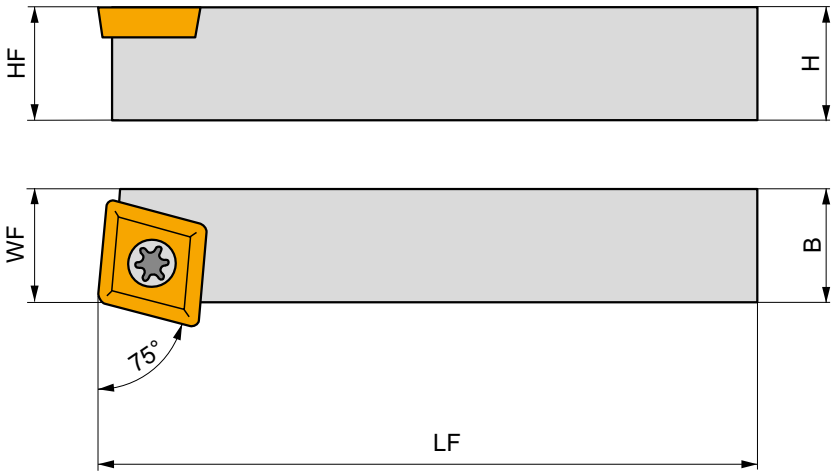
S

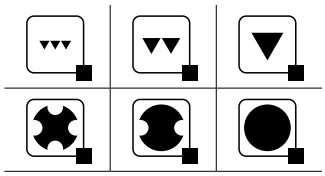


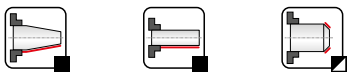
外圆用螺钉夹紧式车刀杆，使用CC..刀片，主偏角为75°。

外圆用左/右手持式车刀杆，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。









	产品型号	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

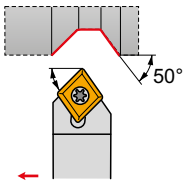
PRAMET

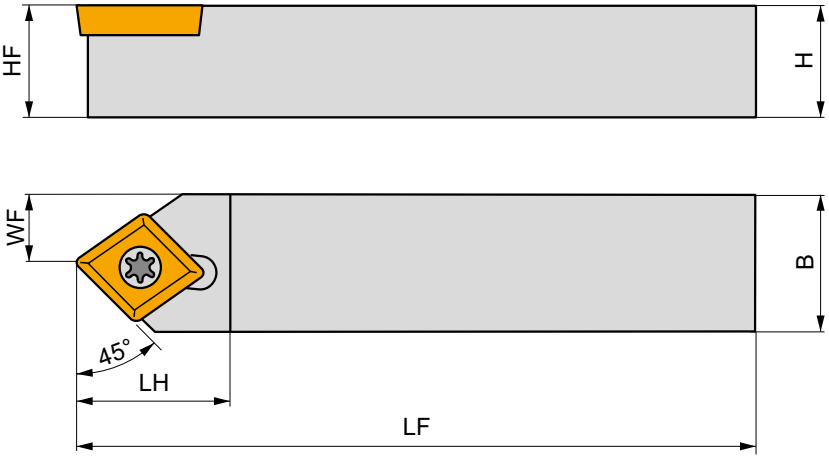
S

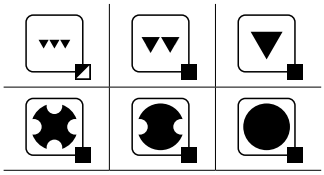


外圆用螺钉夹紧式车刀杆，使用CC..刀片，主偏角度为45°

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。









	产品型号	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	0.06	GI045	SC21

GI045	CC.. 0602..

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

SCFC(RL) EXT

P M K N S H

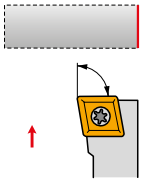
PRAMET

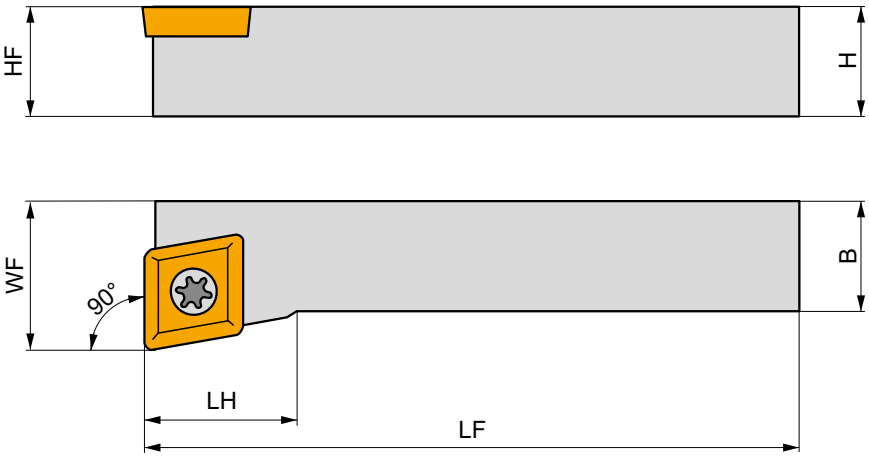
S

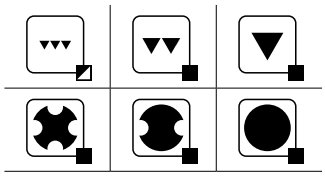


外圆用螺钉夹紧式车刀杆，使用CC..刀片，主偏角为90°。

外圆用左/右手持式车刀杆，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。









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

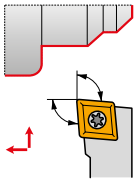
PRAMET

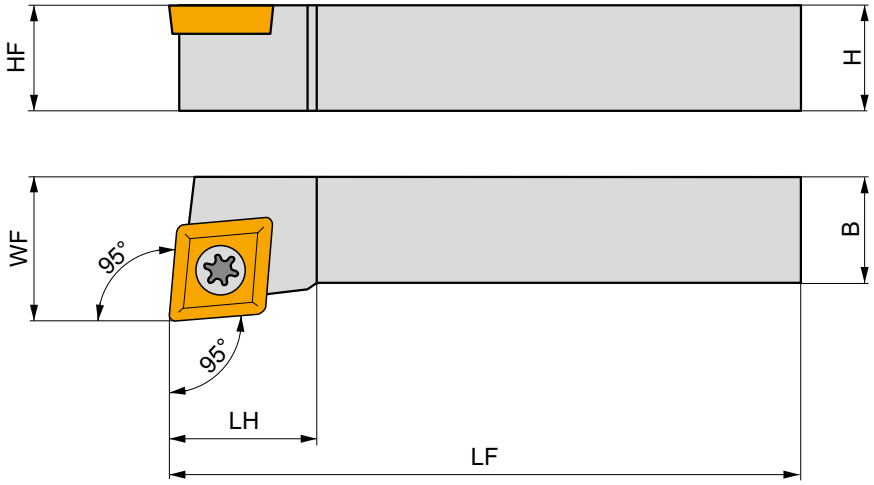
S

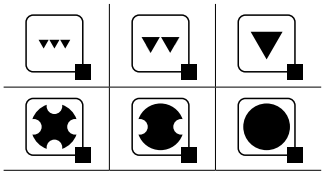


外圆用螺钉夹紧式车刀杆，使用CC..刀片，主偏角为95°。

有95°主偏角的外圆用左/右手持式车刀杆，螺钉锁紧式。使用CC..06、08、09或12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25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SCLCR 0808 D 06	8	8	8	10	60	8	0	0	0.06	GI045	S01
	SCLCR 1010 E 06	10	10	10	12	70	8	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	0.02	GI232	SC22
	SCLCR 1616 H 08	16	16	16	20	100	15.2	0	0	0.22	GI232	SC22
	SCLCR 1212 F 09	12	12	12	16	80	16	0	0	0.12	GI041	S08
	SCLCR 1616 H 09	16	16	16	20	100	16	0	0	0.22	GI041	S08
	SCLCR 2020 K 12-M-A	20	20	20	25	125	20	0	0	0.44	GI011	SC20
	SCLCR 2525 M 12-M-A	20	25	20	32	150	20	0	0	0.68	GI011	SC20
L	SCLCL 0808 D 06	8	8	8	10	60	8	0	0	0.06	GI045	S01
	SCLCL 1010 E 06	10	10	10	12	70	8	0	0	0.06	GI045	S01
	SCLCL 1212 F 08	12	12	12	16	80	13.4	0	0	0.03	GI232	SC22
	SCLCL 1616 H 08	16	16	16	20	100	15.2	0	0	0.23	GI232	SC22
	SCLCL 1212 F 09	12	12	12	16	80	16	0	0	0.10	GI041	S08
	SCLCL 1616 H 09	16	16	16	20	100	16	0	0	0.22	GI041	S08
	SCLCL 2020 K 12-M-A	20	20	20	25	125	20	0	0	0.40	GI011	SC20
	SCLCL 2525 M 12-M-A	25	25	25	32	150	20	0	0	0.78	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	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

NEW

C.-SCLC(RL) EXT

P M K N S H

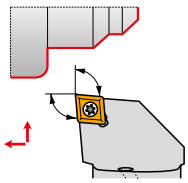
PRAMET

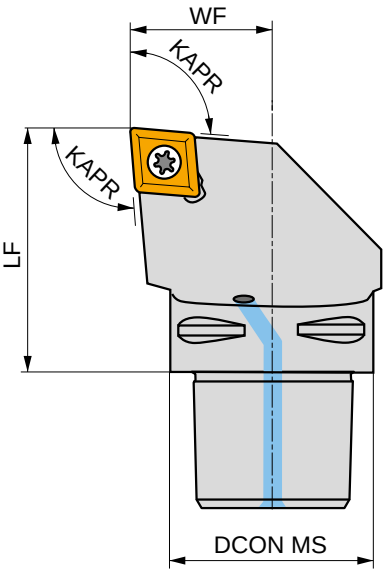
S

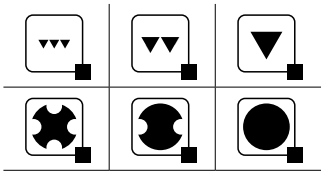


外圆用PSC快速更换式刀柄，螺钉夹紧式，使用CC..刀片，主偏角为95°。

外圆用左/右手动刀具，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。









	产品型号	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

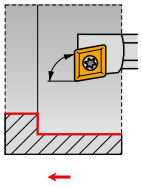
PRAMET

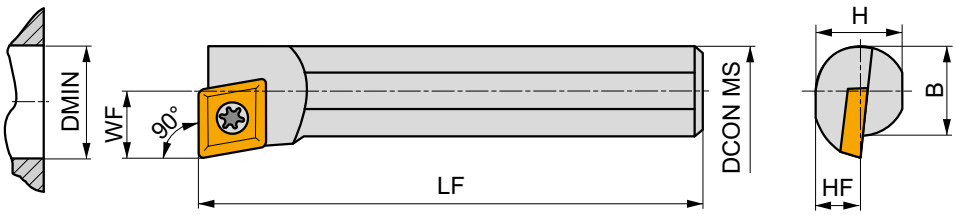
S

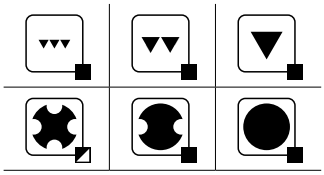


内孔用螺钉夹紧式镗杆，使用CC..刀片，主偏角为90°。

内孔用左/右手镗杆，主偏角为90°。螺钉锁紧式。使用CC..06型螺。内孔最小加工直径为Ø13mm的刀柄。适用于内孔表面和阶梯孔的轴向车削，锥面和倒角车削。可提供Ø10和Ø12mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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
	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	0.10	GI045	S06
	S12K-SCFCL 06	12	16	9	11	11.5	125	-7	0	0.14	GI045	S06

GI045	CC.. 0602..

		Nm			
S06	US 2505-T07P	0.9	M 2.5	5.2	FLAG T07P

SCKC(RL) INT

P M K N S H

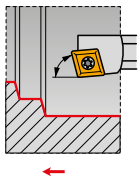
PRAMET

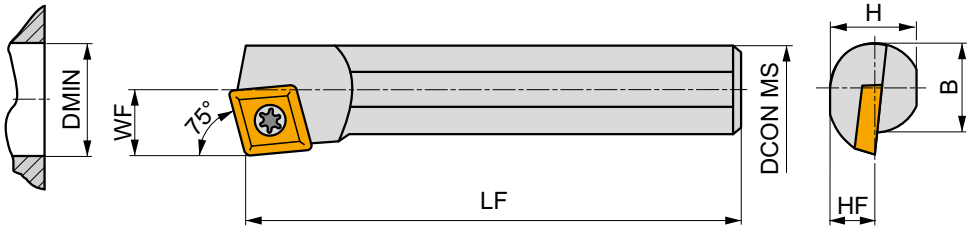
S

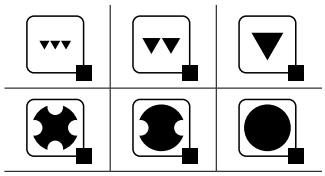


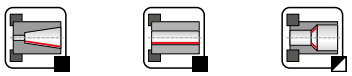
内孔用螺钉夹紧式镗杆，使用CC..刀片，主偏角度为75°。

内孔用左/右手镗杆，主偏角75°。螺钉锁紧式。使用CC..06、09或12刀片。内孔最小加工直径为Ø11mm的刀柄。适用于内孔无阶梯孔的轴向车削，锥面倒角车削。可提供Ø8至Ø32mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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
	S12K-SCKCR 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S02
	S16M-SCKCR 09-A	16	20	11	14.5	15	150	-8	0	0.25	GI041	S05
	S20S-SCKCR 09	20	25	13	18.5	18.5	250	-5	0	0.60	GI041	S08
	S25T-SCKCR 09	25	32	17	23	23	300	-3	0	1.15	GI041	S08
	S32U-SCKCR 12-A	32	40	22	30	30	350	-10	0	2.10	GI011	SC20
L	**S08F-SCKCL 06**	8	11	6	7.2	7.6	80	-12	0	0.03	GI045	S02
	S12K-SCKCL 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S02
	S16M-SCKCL 09-A	16	20	11	14.5	15	150	-8	0	0.24	GI041	S05
	S20S-SCKCL 09	20	25	13	18.5	18.5	250	-5	0	0.60	GI041	S08
	S25T-SCKCL 09	25	32	17	23	23	300	-3	0	1.15	GI041	S08
	S32U-SCKCL 12-A	32	40	22	30	30	350	-10	0	2.10	GI011	SC20

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

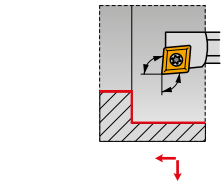
PRAMET

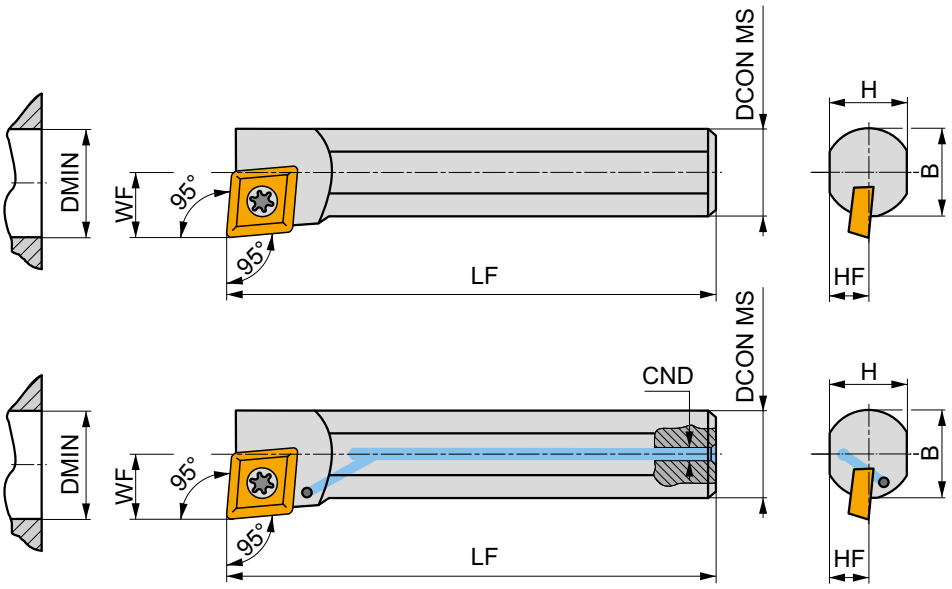
S

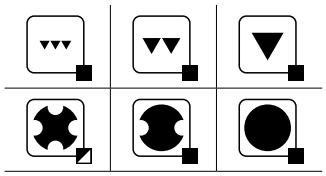


内孔用螺钉夹紧式镗杆，使用CC..刀片，主偏角为95°

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为95°，使用CC..06、08、09或12刀片。内孔最小加工直径为Ø11mm。适用于有阶梯孔的轴向车削，锥面和倒角车削。可提供Ø8至Ø32mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	✓	0.06	GI045	S02
	S08F-SCLCR 06	8	11	6	7.2	7.6	80	–	-13	0	–	0.06	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	–	0.08	GI045	S02
	A12K-SCLCR 06	12	16	9	11	–	125	5	-8	0	✓	0.11	GI045	S01
	S12K-SCLCR 06	12	16	9	11	11.5	125	–	-8	0	–	0.13	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	✓	0.38	GI041	S08
	S20S-SCLCR 09	20	25	13	18	18.5	250	–	-5	0	–	0.62	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	–	1.10	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	✓	0.06	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	–	0.26	GI045	S01
	A10K-SCLCL 08	10	12	6	9	9.5	125	4	-14	0	✓	0.02	GI232	SC22
	A12M-SCLCL 08	12	16	9	11	11.5	150	5	-5	0	✓	0.14	GI232	SC22

	产品型号	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	✓	0.40	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	–	1.15	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	–	2.10	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

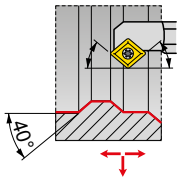
PRAMET

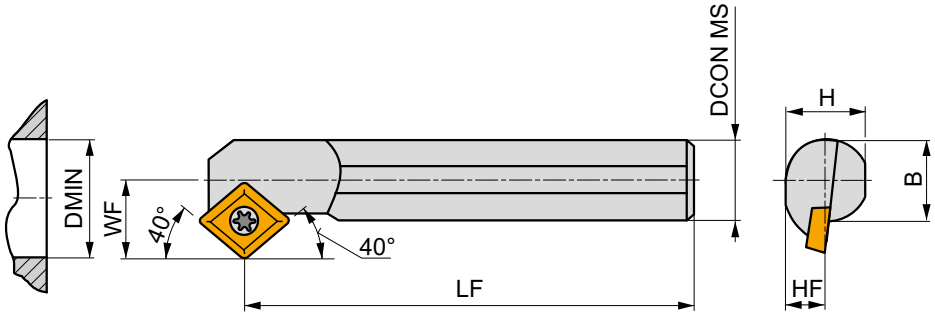
S

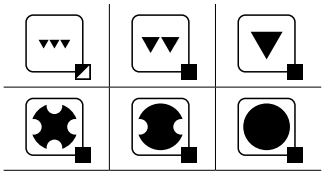


内孔用螺钉夹紧式镗杆，使用CC..刀片，主偏角为40°。

内孔用左/右手镗杆，螺钉锁紧式。主偏角为40°，使用CC..06刀片。内孔最小加工直径为Ø13mm的刀柄。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。可提供Ø10至Ø16mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	0.31	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

NEW

C.-SCLC(RL) INT

P M K N S H

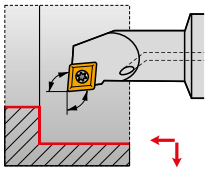
PRAMET

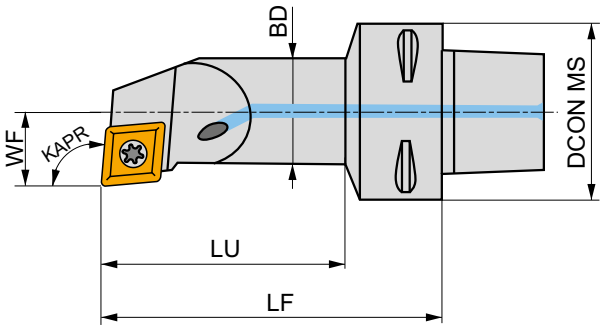
S

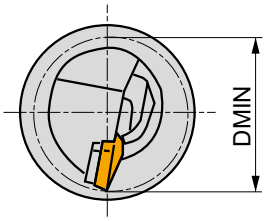


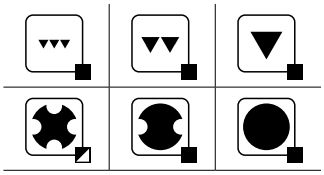
内孔用PSC快速更换式刀柄，螺钉夹紧式，使用CC..刀片，主偏角为95°。

内孔用左/右手动刀具，有内冷通道，螺钉锁紧式。主偏角为95°，使用CC..09刀片。内孔最小加工直径为Ø20mm。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。











	产品型号	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SCLCR-11065-09	32	20	11	65	48	16	95	-8.4	0	✓	0.21	GI041	SC09M
	C3-SCLCR-13075-09	32	25	13	75	58	20	95	-5.8	0	✓	0.26	GI041	SC09M
	C4-SCLCR-11070-09	40	20	11	70	47	16	95	-8.4	0	✓	0.36	GI041	SC09M
	C4-SCLCR-13080-09	40	25	13	80	57	20	95	-5.8	0	✓	0.41	GI041	SC09M
	C4-SCLCR-17090-09	40	32	17	90	68	25	95	-3.4	0	✓	0.50	GI041	SC09M
	C5-SCLCR-11070-09	50	20	11	70	46	16	95	-8.4	0	✓	0.55	GI041	SC09M
	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
	C4-SCLCL-13080-09	40	25	13	80	57	20	95	-5.8	0	✓	0.62	GI041	SC09M
	C5-SCLCL-11070-09	50	20	11	70	46	16	95	-8.4	0	✓	0.55	GI041	SC09M
	C5-SCLCL-13080-09	50	25	13	80	56	20	95	-5.8	0	✓	0.60	GI041	SC09M

GI041	CC.. 09T3..

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

CP 05

硬质合金刀片

CPGX

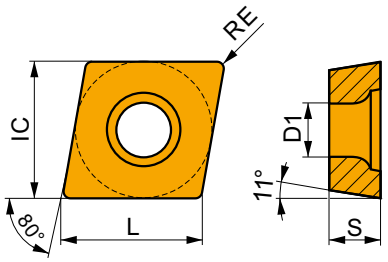


83

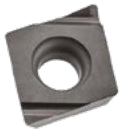
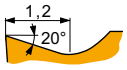
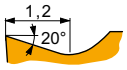
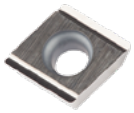
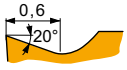
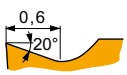
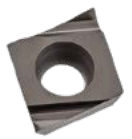
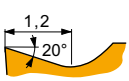
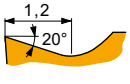
CPGX

PRAMET

	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



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

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
			 																	
			FR-JQ断屑槽，具有正前角，右手设计，适用于超精加工，连续切削。																	
CPGX 080304FR-JQ	**TT010**	0.4	■ 350	0.06	0.5	◪ 210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
			 																	
			FL-JQ断屑槽，具有正前角，左手设计，适用于超精加工，连续切削。																	
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	–	–	–	–	–	–	–	–	–	–	–	–
			 																	
			FR-JR断屑槽，具有正前角，右手设计，适用于超精加工，连续切削。																	
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	–	–	–	–	–	–	–	–	–	–	–	–
			 																	
			FL-JR断屑槽，具有正前角，左手设计，适用于超精加工，连续切削。																	
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	–	–	–	–	–	–	–	–	–	–	–	–
			 																	
			FR-JZ断屑槽，具有正前角，右手设计，适用于超精加工，连续切削。																	
CPGX 060202FR-JZ	**TT010**	0.2	■ 330	0.06	0.5	◪ 195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
			 																	
			FL-JZ断屑槽，具有正前角，左手设计，适用于超精加工，连续切削。																	
CPGX 060202FL-JZ	**TT010**	0.2	■ 330	0.06	0.5	◪ 195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

DC

07 / 11 / 15

硬质合金刀片

DCGT



86

DCMT



87

DCMW



92

CBN和PCD刀片

DCGW CBN



92

DCMW PCD



93

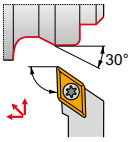
匹配正确的尺寸（示例）

刀片	刀杆
DCMT 070204E-UR	SDJCR 0808 D 07

ISO 外圆车削

SDJC(RL) EXT

93°



DC..

07
11
15

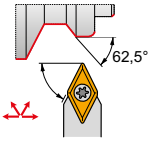
08×08
25×25

94

86 – 93

SDNCN EXT

62°30´



DC..

7
11

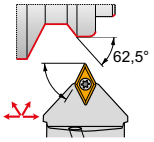
08×08
25×25

95

86 – 93

C.-SDNCN EXT NEW

62°30´



DC..

11

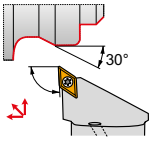
C4
C5

97

86 – 93

C.-SDJC(RL) EXT NEW

93°



DC..

11

C3
C5

96

86 – 93

DC

07 / 11 / 15

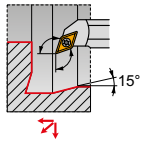
ISO内孔车削

SDQC(RL) INT

107°30´

DC..

07
11



ØDmin 13 / 40

98

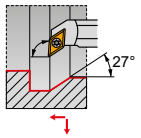
86 – 93

SDUC(RL) INT

93°

DC..

07
11



ØDmin 13 / 40

99

86 – 93

SDUC(RL)-E INT

93°

DC..

07
11



ØDmin 13 / 40

100

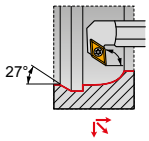
86 – 93

SDZC(RL) INT

93°

DC..

07
11



ØDmin 27 / 65

101

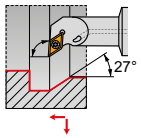
86 – 93

C.-SDUC(RL) INT NEW

93°

DC..

07
11



ØDmin 20 / 32

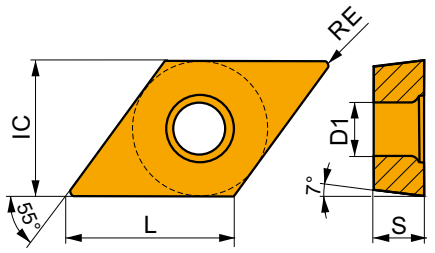
102

86 – 93

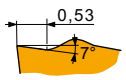
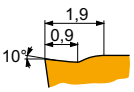
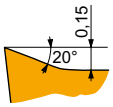
DCGT

PRAMET

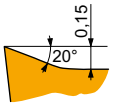
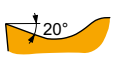
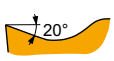
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
0702-SF3	6.350	2.80	7.80	2.58
11T3	9.525	4.40	11.60	3.97
11T3-SF3	9.525	4.40	11.60	4.22



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

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
			F																	
AL断屑槽，具有大正前角设计，适用于精加工至粗加工，连续切削至轻微断续切削。																				
DCGT 070202F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	360	0.12	1.0	–	–	–	–	–	–
	T0315	0.2	–	–	–	–	–	–	–	–	–	510	0.12	1.0	–	–	–	–	–	–
DCGT 070204F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	285	0.24	1.0	–	–	–	–	–	–
	T0315	0.4	–	–	–	–	–	–	–	–	–	420	0.24	1.0	–	–	–	–	–	–
DCGT 11T302F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	345	0.12	1.5	–	–	–	–	–	–
	T0315	0.2	–	–	–	–	–	–	–	–	–	495	0.12	1.5	–	–	–	–	–	–
DCGT 11T304F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	270	0.24	1.5	–	–	–	–	–	–
	T0315	0.4	–	–	–	–	–	–	–	–	–	390	0.24	1.5	–	–	–	–	–	–
DCGT 11T308F-AL	**HF7**	0.8	–	–	–	–	–	–	–	–	–	255	0.48	1.5	–	–	–	–	–	–
	T0315	0.8	–	–	–	–	–	–	–	–	–	360	0.48	1.5	–	–	–	–	–	–
			E																	
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
DCGT 11T302E-FF2	**T7325**	0.2	190	0.05	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.2	165	0.05	0.8	–	–	–	155	0.05	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.2	225	0.05	0.8	–	–	–	185	0.05	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	280	0.05	0.8	–	–	–	265	0.05	0.8	–	–	–	–	–	–	–	–	–
	TT010	0.2	275	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
			E																	
NF1断屑槽，具有正前角设计，适用于超精加工至中度加工，连续切削。																				
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	0.15	1.0
	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	0.15	1.0
	T7325	0.8	180	0.14	0.8	140	0.13	0.8	–	–	–	–	–	–	55	0.13	0.6	–	–	–
			E																	
SF3断屑槽，具有大正前角设计，适用于精细的精加工，连续切削。																				
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	0.15	1.0
DCGT 070202E-SF3	**H07**	0.2	–	–	–	95	0.05	0.8	150	0.05	0.8	485	0.06	0.8	45	0.04	0.6	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	0.15	1.0

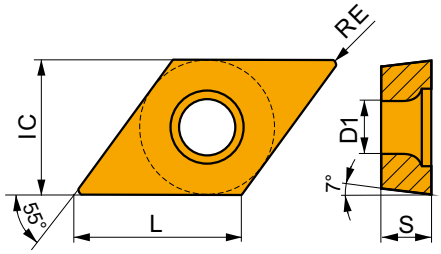
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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，具有大正前角设计，适用于精细的精加工，连续切削。																	
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	–	–	–
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
																				
			ER-SI断屑槽，具有正前角设计，右手设计，适用于超精加工，连续切削。																	
DCGT 11T304ER-SI	**T8330**	0.4	170	0.12	0.8	100	0.11	0.8	160	0.12	0.8	–	–	–	40	0.10	0.6	–	–	–
	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	**T8330**	0.8	170	0.22	1.0	100	0.20	1.0	160	0.22	1.0	–	–	–	40	0.18	0.8	–	–	–
	T8430	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	–	–	–	40	0.18	0.8	–	–	–
																				
			EL-SI断屑槽，具有正前角，左手设计，适用于超精加工，连续切削。																	
DCGT 11T304EL-SI	**T8330**	0.4	170	0.12	0.8	100	0.11	0.8	160	0.12	0.8	–	–	–	40	0.10	0.6	–	–	–
	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	–	–	–

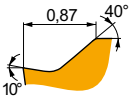
DCMT

PRAMET

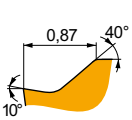
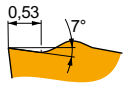
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



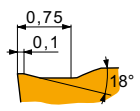
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
			FF断屑槽，具有正前角设计，适用于超精加工，连续切削或轻微断续切削。																	
DCMT 11T302E-FF	**T8315**	0.2	160	0.10	0.8	95	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.2	150	0.10	0.8	90	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8430	0.2	185	0.10	0.8	100	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.2	255	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

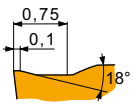
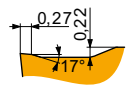
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
FF断屑槽，具有正前角设计，适用于超精加工，连续切削或轻微断续切削。																				
DCMT 11T304E-FF	**T8315**	0.4	◪ 160	0.12	0.8	◪ 95	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 150	0.12	0.8	◪ 90	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 185	0.12	0.8	◪ 100	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 255	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF	**T8315**	0.8	◪ 180	0.15	0.8	◪ 105	0.14	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 170	0.15	0.8	◪ 100	0.14	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 200	0.15	0.8	◪ 110	0.14	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 270	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
DCMT 070202E-FF2	**T7325**	0.2	◪ 190	0.05	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.2	■ 165	0.05	0.8	–	–	–	■ 155	0.05	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.2	■ 225	0.05	0.8	–	–	–	◪ 185	0.05	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	■ 280	0.05	0.8	–	–	–	◪ 265	0.05	0.8	–	–	–	–	–	–	–	–	–
	TT010	0.2	■ 275	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2	**T7325**	0.4	◪ 160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 135	0.12	0.8	–	–	–	■ 125	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 170	0.12	0.8	–	–	–	◪ 135	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 230	0.12	0.8	–	–	–	◪ 215	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 205	0.12	0.8	–	–	–	◪ 190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2	**T7325**	0.8	◪ 170	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 150	0.17	0.8	–	–	–	■ 140	0.17	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 175	0.17	0.8	–	–	–	◪ 140	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 235	0.17	0.8	–	–	–	◪ 220	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 215	0.17	0.8	–	–	–	◪ 200	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2	**T7325**	0.4	◪ 160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 135	0.12	0.8	–	–	–	■ 125	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 170	0.12	0.8	–	–	–	◪ 135	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 230	0.12	0.8	–	–	–	◪ 215	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 205	0.12	0.8	–	–	–	◪ 190	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 175	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	TT010	0.4	■ 280	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2	**T7325**	0.8	◪ 170	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 150	0.17	0.8	–	–	–	■ 140	0.17	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 175	0.17	0.8	–	–	–	◪ 140	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 235	0.17	0.8	–	–	–	◪ 220	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 215	0.17	0.8	–	–	–	◪ 200	0.17	0.8	–	–	–	–	–	–	–	–	–
	TT010	0.8	■ 280	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
DCMT 070202E-FM	**T7325**	0.2	◪ 175	0.10	0.8	■ 135	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.2	◪ 160	0.10	0.8	■ 95	0.09	0.8	◪ 150	0.10	0.8	◪ 480	0.12	0.8	–	–	–	–	–	–
	T8330	0.2	■ 150	0.10	0.8	■ 90	0.09	0.8	◪ 140	0.10	0.8	◪ 450	0.12	0.8	–	–	–	–	–	–
	T8430	0.2	■ 185	0.10	0.8	■ 100	0.09	0.8	◪ 150	0.10	0.8	◪ 510	0.12	0.8	–	–	–	–	–	–
	T9315	0.2	■ 255	0.10	0.8	–	–	–	◪ 240	0.10	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	■ 230	0.10	0.8	■ 135	0.09	0.8	◪ 215	0.10	0.8	–	–	–	–	–	–	–	–	–

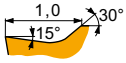
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
DCMT 070204E-FM	**T7325**	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
	T8330	0.4	150	0.12	0.8	90	0.11	0.8	140	0.12	0.8	450	0.14	0.8	–	–	–	–	–	–
	T8430	0.4	185	0.12	0.8	100	0.11	0.8	150	0.12	0.8	510	0.14	0.8	–	–	–	–	–	–
	T9315	0.4	255	0.12	0.8	–	–	–	240	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM	**T7325**	0.2	175	0.10	0.8	135	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	480	0.12	0.8	–	–	–	–	–	–
	T8330	0.2	150	0.10	0.8	90	0.09	0.8	140	0.10	0.8	450	0.12	0.8	–	–	–	–	–	–
	T8430	0.2	185	0.10	0.8	100	0.09	0.8	150	0.10	0.8	510	0.12	0.8	–	–	–	–	–	–
	T9315	0.2	255	0.10	0.8	–	–	–	240	0.10	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	230	0.10	0.8	135	0.09	0.8	215	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM	**T7325**	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
	T8330	0.4	135	0.17	0.8	80	0.15	0.8	125	0.17	0.8	405	0.20	0.8	–	–	–	–	–	–
	T8430	0.4	155	0.17	0.8	85	0.15	0.8	130	0.17	0.8	435	0.20	0.8	–	–	–	–	–	–
	T9310	0.4	285	0.12	0.8	–	–	–	270	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	255	0.12	0.8	–	–	–	240	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM	**T7325**	0.8	185	0.17	0.8	140	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	180	0.17	0.8	140	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	170	0.17	0.8	100	0.15	0.8	160	0.17	0.8	510	0.20	0.8	–	–	–	–	–	–
	T8330	0.8	165	0.17	0.8	95	0.15	0.8	155	0.17	0.8	495	0.20	0.8	–	–	–	–	–	–
	T8430	0.8	190	0.17	0.8	105	0.15	0.8	155	0.17	0.8	525	0.20	0.8	–	–	–	–	–	–
	T9310	0.8	285	0.17	0.8	–	–	–	270	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.8	260	0.17	0.8	–	–	–	245	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	235	0.17	0.8	140	0.15	0.8	220	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM	**T8330**	1.2	150	0.22	1.2	90	0.22	1.2	140	0.22	1.2	450	0.26	1.2	–	–	–	–	–	–
	T8430	1.2	175	0.22	1.2	95	0.22	1.2	140	0.22	1.2	480	0.26	1.2	–	–	–	–	–	–
	T9315	1.2	235	0.22	1.2	–	–	–	220	0.22	1.2	–	–	–	–	–	–	–	–	–
	T9325	1.2	210	0.22	1.2	125	0.22	1.2	195	0.22	1.2	–	–	–	–	–	–	–	–	–
																				
FM2断屑槽，适用于精加工至中等加工，连续至断续切削。																				
DCMT 070204E-FM2	**T6310**	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	–	–	–	–	–	–	–	–	–
	T7325	0.4	160	0.12	0.8	120	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	230	0.12	0.8	–	–	–	215	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	205	0.12	0.8	120	0.11	0.8	190	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	–	–	–	–	–	–	–	–	–
	T7325	0.4	160	0.12	0.8	120	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	230	0.12	0.8	–	–	–	215	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9335	0.4	175	0.12	0.8	105	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–

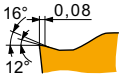
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
FM2断屑槽，适用于精加工至中等加工，连续至断续切削。																				
DCMT 11T308E-FM2	**T6310**	0.8	■ 150	0.17	0.8	◪ 105	0.15	0.8	■ 120	0.17	0.8	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪ 170	0.17	0.8	◪ 130	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 150	0.17	0.8	◪ 90	0.15	0.8	■ 140	0.17	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 175	0.17	0.8	◪ 95	0.15	0.8	◪ 140	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 235	0.17	0.8	–	–	–	◪ 220	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 215	0.17	0.8	◪ 125	0.15	0.8	◪ 200	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 180	0.17	0.8	◪ 105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM2	**T8430**	1.2	■ 155	0.22	1.2	◪ 85	0.20	1.2	◪ 130	0.22	1.2	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 190	0.22	1.2	◪ 110	0.20	1.2	◪ 180	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 150408E-FM2	**T9315**	0.8	■ 205	0.20	1.5	–	–	–	◪ 190	0.20	1.5	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 185	0.20	1.5	◪ 110	0.18	1.5	◪ 175	0.20	1.5	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 160	0.20	1.5	◪ 95	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
RF断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
DCMT 11T304E-RF	**T5315**	0.4	◪ 175	0.20	0.8	–	–	–	■ 165	0.20	0.8	–	–	–	–	–	–	◪ 35	0.15	1.0
	T7335	0.4	◪ 115	0.20	0.8	◪ 85	0.18	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	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	0.15	1.0
	T7335	0.8	◪ 140	0.20	0.8	◪ 105	0.18	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 175	0.20	0.8	◪ 105	0.18	0.8	◪ 165	0.20	0.8	–	–	–	–	–	–	–	–	–
																				
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
DCMT 11T304E-RM	**T5305**	0.4	◪ 225	0.27	0.8	–	–	–	■ 210	0.27	0.8	–	–	–	–	–	–	◪ 45	0.15	1.0
	T5315	0.4	◪ 205	0.27	0.8	–	–	–	■ 190	0.27	0.8	–	–	–	–	–	–	◪ 40	0.15	1.0
	T7335	0.4	◪ 135	0.27	0.8	■ 105	0.24	0.8	–	–	–	–	–	–	◪ 40	0.19	0.6	–	–	–
	T8330	0.4	■ 125	0.27	0.8	■ 75	0.24	0.8	■ 115	0.27	0.8	–	–	–	◪ 30	0.19	0.6	◪ 25	0.15	1.0
	T8430	0.4	■ 135	0.27	0.8	■ 75	0.24	0.8	◪ 110	0.27	0.8	–	–	–	◪ 25	0.19	0.6	◪ 20	0.15	1.0
	T9315	0.4	■ 185	0.27	0.8	–	–	–	◪ 175	0.27	0.8	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	0.4	■ 165	0.27	0.8	■ 95	0.24	0.8	◪ 155	0.27	0.8	–	–	–	◪ 35	0.19	0.6	–	–	–
DCMT 11T308E-RM	**T5305**	0.8	◪ 270	0.27	0.8	–	–	–	■ 255	0.27	0.8	–	–	–	–	–	–	◪ 50	0.15	1.0
	T5315	0.8	◪ 240	0.27	0.8	–	–	–	■ 225	0.27	0.8	–	–	–	–	–	–	◪ 45	0.15	1.0
	T7335	0.8	◪ 165	0.27	0.8	■ 125	0.24	0.8	–	–	–	–	–	–	◪ 50	0.19	0.6	–	–	–
	T8330	0.8	■ 150	0.27	0.8	■ 90	0.24	0.8	■ 140	0.27	0.8	–	–	–	◪ 35	0.19	0.6	◪ 30	0.15	1.0
	T8430	0.8	■ 165	0.27	0.8	■ 90	0.24	0.8	◪ 135	0.27	0.8	–	–	–	◪ 35	0.19	0.6	◪ 25	0.15	1.0
	T9315	0.8	■ 220	0.27	0.8	–	–	–	◪ 205	0.27	0.8	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	0.8	■ 200	0.27	0.8	■ 120	0.24	0.8	◪ 190	0.27	0.8	–	–	–	◪ 45	0.19	0.6	–	–	–
DCMT 11T312E-RM	**T7335**	1.2	◪ 165	0.27	1.2	■ 125	0.24	1.2	–	–	–	–	–	–	◪ 50	0.19	1.2	–	–	–
	T8330	1.2	■ 150	0.27	1.2	■ 90	0.24	1.2	■ 140	0.27	1.2	–	–	–	◪ 35	0.19	1.2	◪ 30	0.15	1.0
	T8430	1.2	■ 170	0.27	1.2	■ 90	0.24	1.2	◪ 135	0.27	1.2	–	–	–	◪ 35	0.19	1.2	◪ 25	0.15	1.0
	T9315	1.2	■ 225	0.27	1.2	–	–	–	◪ 210	0.27	1.2	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	1.2	■ 200	0.27	1.2	■ 120	0.24	1.2	◪ 190	0.27	1.2	–	–	–	◪ 45	0.19	1.2	–	–	–
DCMT 150408E-RM	**T8330**	0.8	■ 135	0.27	1.9	■ 80	0.24	1.9	■ 125	0.27	1.9	–	–	–	◪ 30	0.22	1.5	◪ 25	0.15	1.0
	T8430	0.8	■ 150	0.27	1.9	■ 80	0.24	1.9	◪ 125	0.27	1.9	–	–	–	◪ 30	0.22	1.5	◪ 25	0.15	1.0
	T9315	0.8	■ 200	0.27	1.9	–	–	–	◪ 190	0.27	1.9	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	0.8	■ 180	0.27	1.9	■ 105	0.24	1.9	◪ 170	0.27	1.9	–	–	–	◪ 40	0.22	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。

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		
																				
																				

UR断屑槽，适用于精细的精加工，连续切削或轻微断续切削。

DCMT 070202E-UR	**T7325**	0.2	◪	150	0.10	0.8	◪	115	0.09	0.8		–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.2	◪	135	0.10	0.8	◪	80	0.09	0.8	■	125	0.10	0.8	–	–	–	–	–	–	–	–	–
	T8330	0.2	■	130	0.10	0.8	◪	75	0.09	0.8	■	120	0.10	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.2	■	155	0.10	0.8	◪	85	0.09	0.8	◪	130	0.10	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.2	■	220	0.10	0.8		–	–	–	◪	205	0.10	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	■	200	0.10	0.8	◪	120	0.09	0.8	◪	190	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR	**T7325**	0.4	◪	135	0.17	0.8	◪	105	0.15	0.8		–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	◪	135	0.12	0.8	◪	80	0.11	0.8	■	125	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8330	0.4	■	130	0.12	0.8	◪	75	0.11	0.8	■	120	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	■	155	0.12	0.8	◪	85	0.11	0.8	◪	130	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	■	220	0.12	0.8		–	–	–	◪	205	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■	165	0.18	0.8	◪	95	0.16	0.8	◪	155	0.18	0.8	–	–	–	–	–	–	–	–	–
	TT310	0.4	■	210	0.12	0.8	◪	125	0.11	0.8		–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR	**T7325**	0.2	◪	150	0.10	0.8	◪	115	0.09	0.8		–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.2	■	130	0.10	0.8	◪	75	0.09	0.8	■	120	0.10	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.2	■	155	0.10	0.8	◪	85	0.09	0.8	◪	130	0.10	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.2	■	220	0.10	0.8		–	–	–	◪	205	0.10	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	■	200	0.10	0.8	◪	120	0.09	0.8	◪	190	0.10	0.8	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.4	◪	135	0.17	0.8	◪	105	0.15	0.8		–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	◪	130	0.17	0.8	◪	100	0.15	0.8		–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	◪	135	0.12	0.8	◪	80	0.11	0.8	■	125	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8330	0.4	■	130	0.12	0.8	◪	75	0.11	0.8	■	120	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	■	155	0.12	0.8	◪	85	0.11	0.8	◪	130	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	■	220	0.12	0.8		–	–	–	◪	205	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■	165	0.18	0.8	◪	95	0.16	0.8	◪	155	0.18	0.8	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪	160	0.17	0.8	◪	120	0.15	0.8		–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪	155	0.17	0.8	◪	120	0.15	0.8		–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	◪	145	0.17	0.8	◪	85	0.15	0.8	■	135	0.17	0.8	–	–	–	–	–	–	–	–	–
	T8330	0.8	■	140	0.17	0.8	◪	80	0.15	0.8	■	130	0.17	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.8	■	165	0.17	0.8	◪	90	0.15	0.8	◪	135	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.8	■	225	0.17	0.8		–	–	–	◪	210	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	■	200	0.17	0.8	◪	120	0.15	0.8	◪	190	0.17	0.8	–	–	–	–	–	–	–	–	–
	TT310	0.8	■	225	0.17	0.8	◪	135	0.15	0.8		–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T312E-UR	**T9315**	1.2	■	205	0.22	1.2		–	–	–	◪	190	0.22	1.2	–	–	–	–	–	–	–	–	–
	T9325	1.2	■	180	0.22	1.2	◪	105	0.20	1.2	◪	170	0.22	1.2	–	–	–	–	–	–	–	–	–
																							
																							

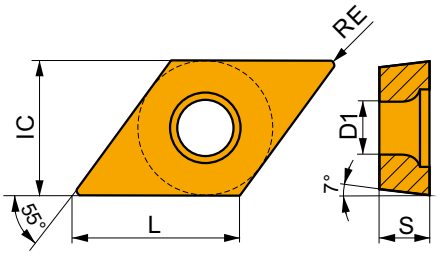
W-FM修光刃断屑槽，可以提高进给量并改善表面光洁度，从而完成精细的精加工。

DCMX 11T304W-FM	**T7325**	0.4	◪	130	0.30	0.8	■	100	0.27	0.8		–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■	115	0.30	0.8	■	65	0.27	0.8	■	105	0.30	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	■	130	0.30	0.8	■	70	0.27	0.8	◪	105	0.30	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	■	170	0.30	0.8		–	–	–	◪	160	0.30	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■	155	0.30	0.8	■	90	0.27	0.8	◪	145	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T308W-FM	**T7325**	0.8	◪	140	0.40	1.0	■	105	0.36	1.0		–	–	–	–	–	–	–	–	–	–	–	–
	T8430	0.8	■	130	0.40	1.0	■	70	0.36	1.0	◪	105	0.40	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	■	175	0.40	1.0		–	–	–	◪	165	0.40	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■	160	0.40	1.0	■	95	0.36	1.0	◪	150	0.40	1.0	–	–	–	–	–	–	–	–	–

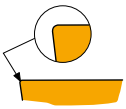
DCMW

PRAMET

	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



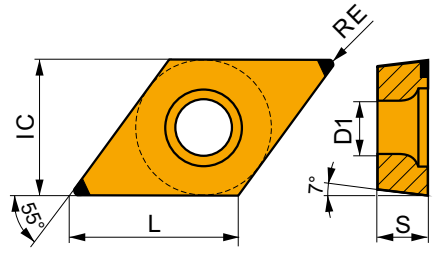
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
			E																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
DCMW 070202	**T5305**	0.2	–	–	–	–	–	–	200	0.08	0.8	–	–	–	–	–	–	40	0.15	1.0
	T6310	0.2	–	–	–	–	–	–	80	0.08	0.8	–	–	–	–	–	–	20	0.15	1.0
DCMW 070204	**T5305**	0.4	–	–	–	–	–	–	195	0.10	0.8	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	175	0.10	0.8	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.4	–	–	–	–	–	–	85	0.10	0.8	–	–	–	–	–	–	20	0.15	1.0
DCMW 11T304	**T5305**	0.4	–	–	–	–	–	–	190	0.10	1.2	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	165	0.10	1.2	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.4	–	–	–	–	–	–	80	0.10	1.2	–	–	–	–	–	–	20	0.15	1.0
DCMW 11T308	**T5305**	0.8	–	–	–	–	–	–	185	0.18	1.2	–	–	–	–	–	–	35	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	160	0.18	1.2	–	–	–	–	–	–	30	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	80	0.18	1.2	–	–	–	–	–	–	20	0.15	1.0

DCGW CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.50	11.60	3.97



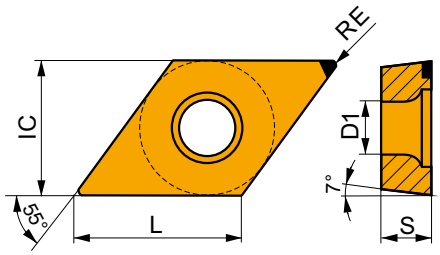
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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															
			适用于精加工。																	
DCGW 11T304S01020B	**TB310**	0.4	–	–	–	–	–	–	370	0.10	0.4	–	–	–	95	0.07	0.3	75	0.15	1.0
DCGW 11T308S01020B	**TB310**	0.8	–	–	–	–	–	–	380	0.15	0.6	–	–	–	100	0.11	0.5	80	0.15	1.0

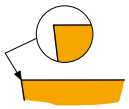
DCMW PCD

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。

产品型号		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 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	–	–	–	–	–	–

SDJC(RL) EXT

P M K N S H

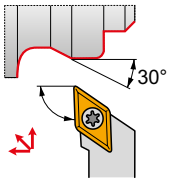
PRAMET

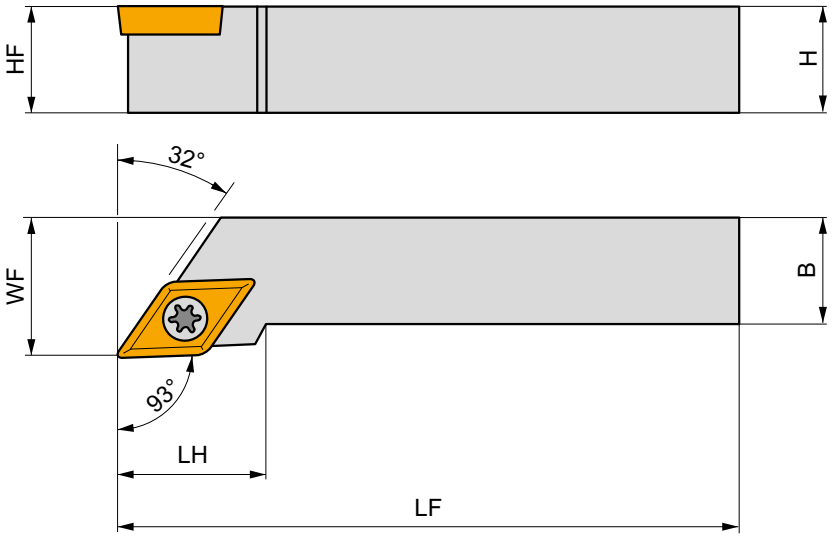
S

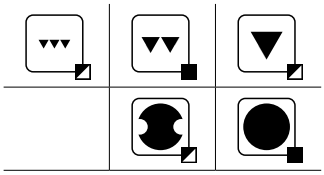


外圆用螺钉夹紧式车刀杆，使用DC..刀片，主偏角为93°。

外圆用左/右手持车刀杆，主偏角为93°。螺钉锁紧式。使用DC..07、11或15正前角刀片。适用于阶梯外圆，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。









	产品型号	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	0.06	GI052	S01
	SDJCR 1010 E 07	10	10	10	12	70	14	0	0	0.06	GI052	S01
	SDJCR 1212 F 07	12	12	12	16	80	14	0	0	0.11	GI052	S01
	SDJCR 1212 F 11	12	12	12	16	80	20	0	0	0.10	GI012	S08
	SDJCR 1616 H 11	16	16	16	20	100	20	0	0	0.22	GI012	S08
	SDJCR 2020 K 11-M-A	20	20	20	25	125	20	0	0	0.40	GI012	SD10
	SDJCR 2525 M 11-M-A	25	25	25	32	150	20	0	0	0.74	GI012	SD10
	SDJCR 2525 M 15	25	25	25	32	150	28	0	0	0.75	GI243	SD11
L	SDJCL 0808 D 07	8	8	8	10	60	14	0	0	0.04	GI052	S01
	SDJCL 1010 E 07	10	10	10	12	70	14	0	0	0.08	GI052	S01
	SDJCL 1212 F 07	12	12	12	16	80	14	0	0	0.12	GI052	S01
	SDJCL 1212 F 11	12	12	12	16	80	20	0	0	0.12	GI012	S08
	SDJCL 1616 H 11	16	16	16	20	100	20	0	0	0.20	GI012	S08
	SDJCL 2020 K 11-M-A	20	20	20	25	125	20	0	0	0.41	GI012	SD10
	SDJCL 2525 M 11-M-A	25	25	25	32	150	20	0	0	0.74	GI012	SD10
	SDJCL 2525 M 15	25	25	25	32	150	28	0	0	0.07	GI243	SD11

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

		Nm						
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

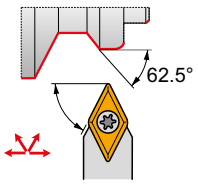
PRAMET

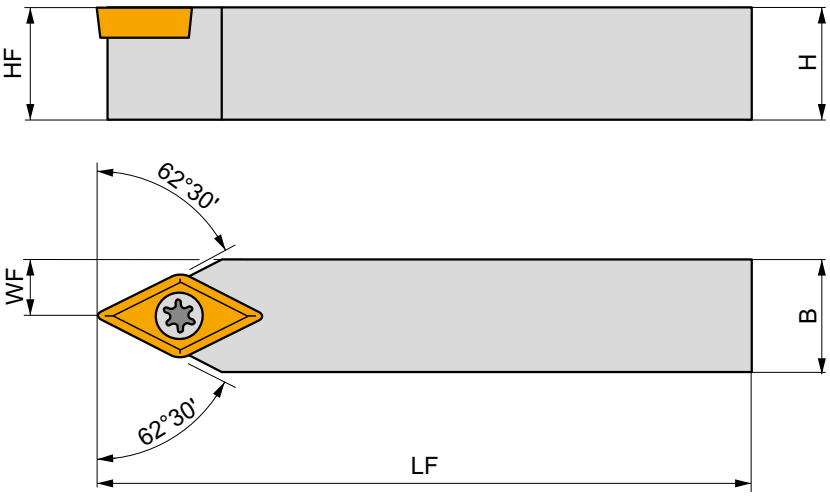
S

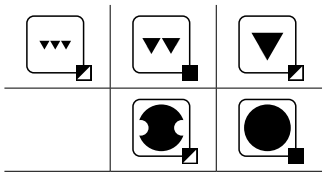


外圆用螺钉夹紧式车刀杆，使用DC..刀片，主偏角为62.5°。

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。









	产品型号	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	0.06	GI052	S01
	SDNCN 1010 E 07	10	10	10	5	70	0	0	0.08	GI052	S01
	SDNCN 1212 F 07	12	12	12	6	80	0	0	0.12	GI052	S01
	SDNCN 1212 F 11	12	12	12	6	80	0	0	0.12	GI012	S08
	SDNCN 1616 H 11	16	16	16	8	100	0	0	0.18	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	–

NEW

C.-SDJC(RL) EXT

P M K N S H

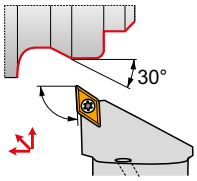
PRAMET

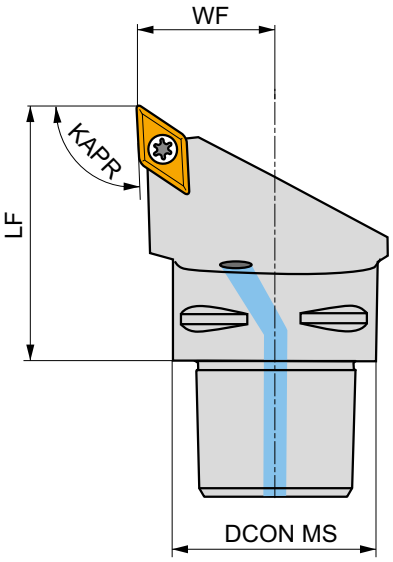
S

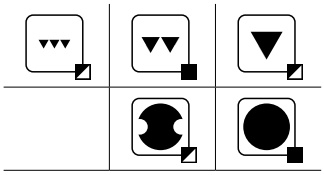


外圆用PSC快速更换式刀柄，螺钉夹紧式，DC..刀片，主偏角为93°。

外圆用左/右手动刀具，有内冷通道，主偏角为93°。螺钉锁紧式。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。









	产品型号	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SDJCR-22040-11	32	22	40	93	0	0	✓	0.21	GI012	C-SD11V-1
R	C4-SDJCR-27050-11	40	27	50	93	0	0	✓	0.38	GI012	C-SD11V-1
R	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	✓	0.21	GI012	C-SD11V-1
L	C4-SDJCL-27050-11	40	27	50	93	0	0	✓	0.38	GI012	C-SD11V-1
L	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

NEW

C.-SDNCN EXT

P M K N S H

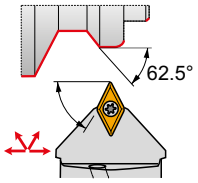
PRAMET

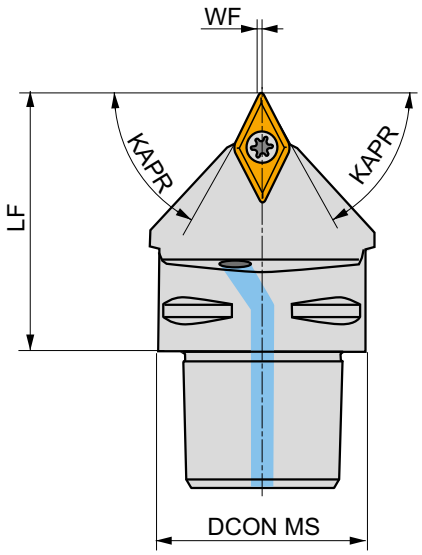
S

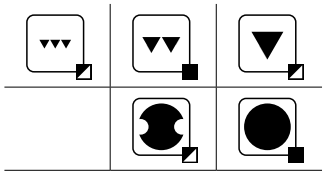


外圆用PSC快速更换式刀柄，螺钉夹紧式，DC..刀片，主偏角为62.5°。

外圆用左/右手动刀具，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。









	产品型号	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

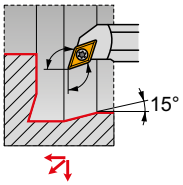
PRAMET

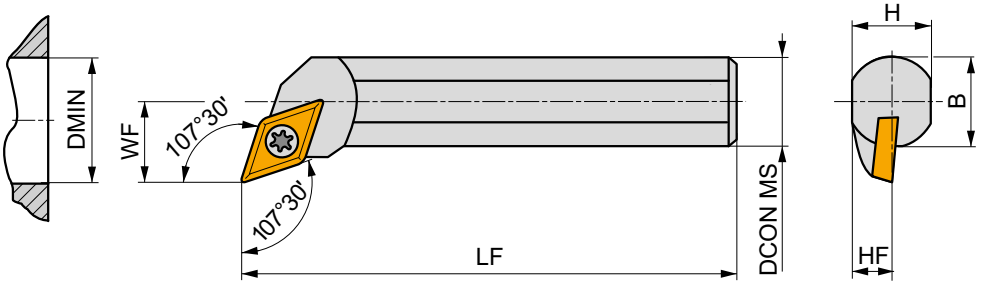
S

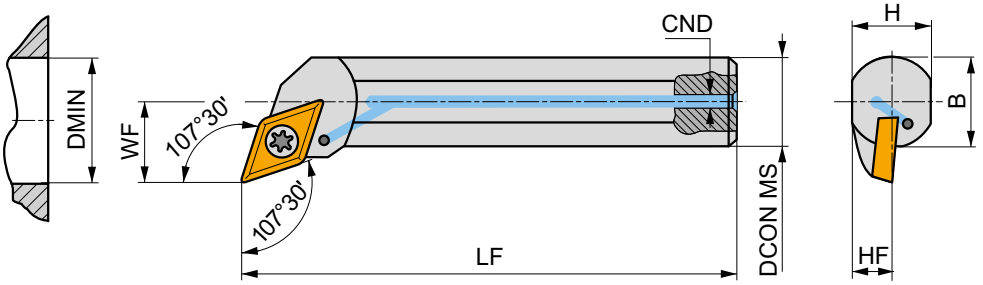


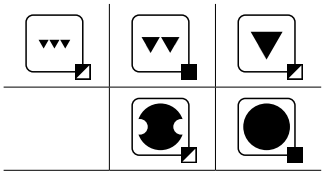
内孔用螺钉夹紧式镗杆，使用DC..刀片，主偏角为107.5°。

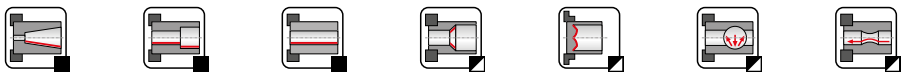
内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为107.5°。使用DC..07或11刀片。内孔最小加工直径为Ø13mm。适用于有阶梯孔的轴向车削，锥面，仿形和倒角车削。可提供Ø10至Ø32mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	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	✓	0.24	GI052	S01
	A20Q-SDQCR 11	20	25	13	18	–	180	8	-5	0	✓	0.40	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	✓	0.67	GI012	S08
	S25T-SDQCR 11	25	32	17	23	23	300	–	-3	0	–	1.09	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	✓	0.24	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	✓	1.33	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

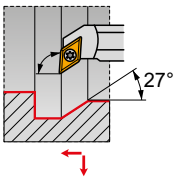
PRAMET

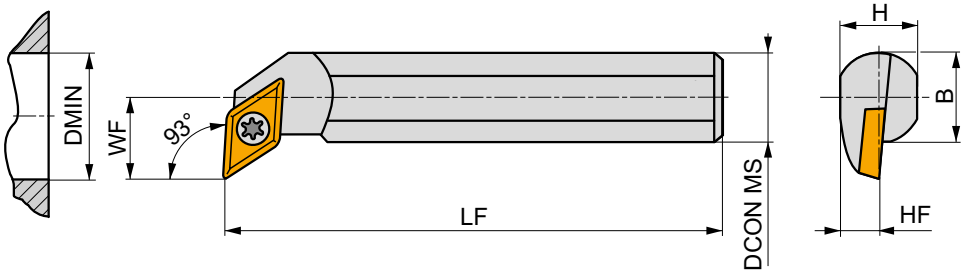
S

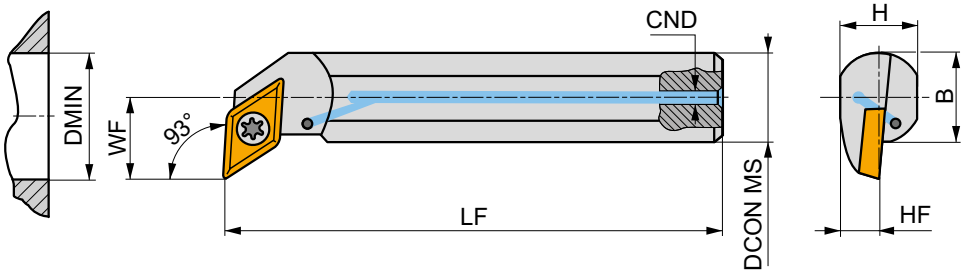


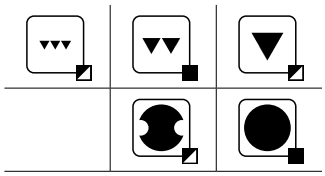
内孔用螺钉夹紧式镗杆，使用DC..刀片，主偏角为93°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为93°，使用DC..07或11刀片。内孔最小加工直径为Ø13mm。适用于有阶梯孔的轴向车削，锥面，仿形和倒角车削。可提供Ø10至Ø32mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	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	✓	0.05	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	✓	0.38	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	–	1.15	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	✓	0.06	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	✓	0.21	GI052	S01
	A20Q-SDUCL 11	20	25	13	18	–	180	8	-3	0	✓	0.38	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	✓	0.67	GI012	S08
	S25T-SDUCL 11	25	32	17	23	23	300	–	-3	0	–	1.15	GI012	S08
	A32S-SDUCL 11-A	32	40	22	30	30	250	8	-10	0	✓	1.35	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

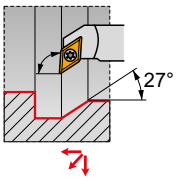
PRAMET

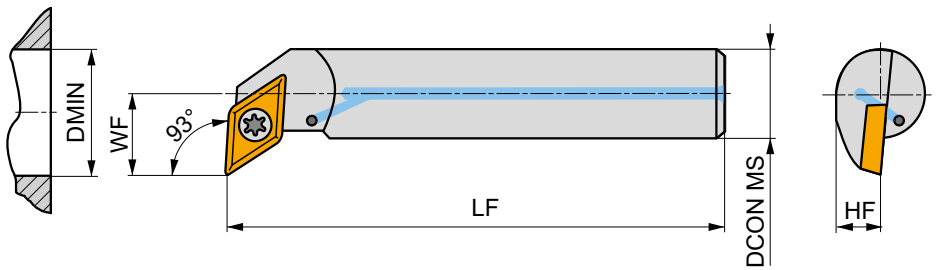
S

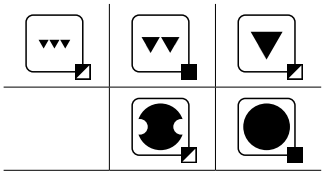


内孔用螺钉夹紧式硬质合金镗杆，使用DC..刀片，主偏角为93°。

内孔用左/右手硬质合金镗杆，有内冷通道，螺钉锁紧式。主偏角为93°，使用DC..07正前角刀片。内孔最小加工直径为Ø15mm。适用于有阶梯孔的轴向车削，锥面，仿形和倒角车削。可提供Ø10至Ø16mm的刀柄。刀具悬伸>3xD。









	产品型号	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..

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

SDZC(RL) INT

P M K N S H

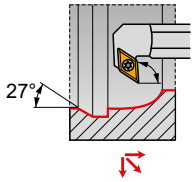
PRAMET

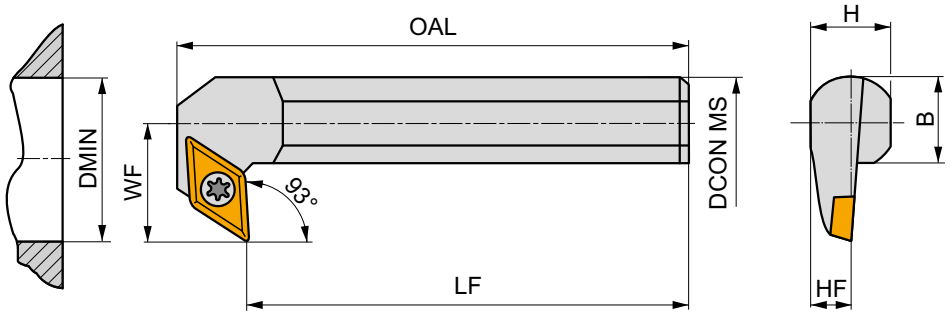
S

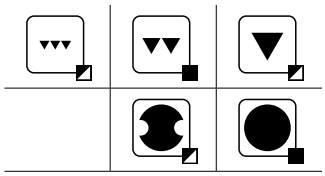


内孔用螺钉夹紧式镗杆，使用DC..刀片，主偏角为93°。

内孔用左/右手镗杆，主偏角为93°。螺钉锁紧式。使用DC..07或11刀片。内孔最小加工直径为Ø27mm的刀柄。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。可提供Ø16至Ø40mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	0.50	GI012	S08
	S25R-SDZCR 11-93	25	42	27	23	23	200	218	-3	0	0.83	GI012	S08
	S32S-SDZCR 11-93-A	32	53	35	30	30	250	268	-6	0	1.64	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	0.60	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	–

NEW

C.-SDUC(RL) INT

P M K N S H

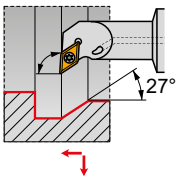
PRAMET

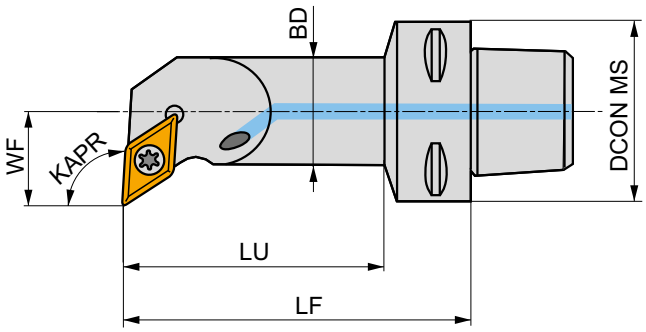
S

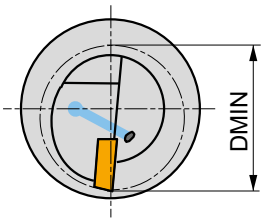


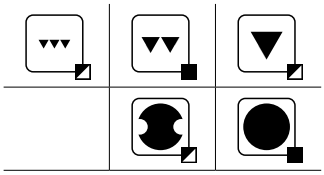
内孔用PSC快速更换式刀柄，螺钉夹紧式，使用DC..刀片，主偏角为93°。

内孔用左/右手动刀具，有内冷通道，螺钉锁紧式。主偏角为93°，使用DC..07或11刀片。内孔最小加工直径为Ø20mm。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。











	产品型号	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

EC

06 / 08

硬质合金刀片

ECGT



104

ECMT



105

ECMW



106

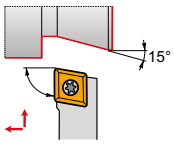
匹配正确的尺寸（示例）

刀片	刀杆
ECMT 060204E-FM2	S08K-SEUCR 06

ISO 外圆车削

SEGC(RL) EXT

90°



12×12
16×16

107

EC..



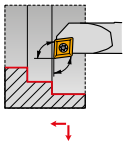
08

104 – 106

ISO内孔车削

SEUC(RL) INT

93°





11
32

108

EC..



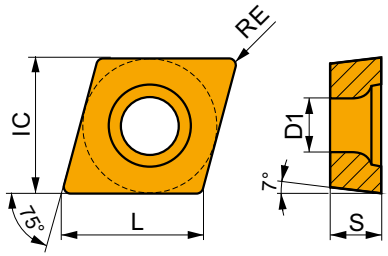
06
08

104 – 106

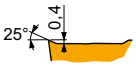
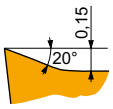
ECGT

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0602-SF3	6.350	2.80	6.50	2.58
0803	7.940	3.40	8.20	3.18
0803-SF3	7.940	3.40	8.20	3.43



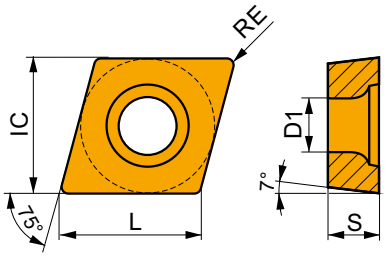
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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断屑槽，具有大正前角设计，适用于精细的精加工，连续切削。																	
ECGT 060202E-SF2	**H07**	0.2	–	–	–	105	0.05	1.0	–	–	–	525	0.06	1.0	50	0.04	0.8	–	–	–
	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	–	–	–
	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	–	–	–
	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	–	–	–
	T6310	0.4	160	0.10	1.0	115	0.09	1.0	–	–	–	480	0.12	1.0	45	0.07	0.8	–	–	–
																				
			SF3断屑槽，具有大正前角设计，适用于精细的精加工，连续切削。																	
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	–	–	–
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0

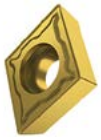
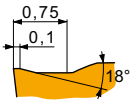
ECMT

PRAMET

	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



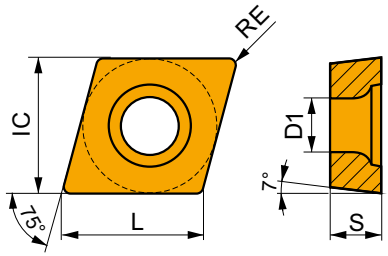
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
			U S																	
			FM2断屑槽，适用于精加工至中等加工，连续至断续切削。																	
ECMT 060204E-FM2	**T7325**	0.4	◪ 180	0.12	0.8	◪ 140	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 155	0.12	0.8	◪ 90	0.11	0.8	■ 145	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 205	0.12	0.8	◪ 110	0.11	0.8	◪ 170	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 290	0.12	0.8	–	–	–	◪ 275	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 255	0.12	0.8	◪ 150	0.11	0.8	◪ 240	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 220	0.12	0.8	◪ 130	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2	**T5315**	0.4	◪ 280	0.12	1.0	–	–	–	■ 265	0.12	1.0	–	–	–	–	–	–	–	–	–
	T7325	0.4	◪ 170	0.12	1.0	◪ 130	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 150	0.12	1.0	◪ 90	0.11	1.0	■ 140	0.12	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 205	0.12	1.0	◪ 110	0.11	1.0	◪ 170	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 280	0.12	1.0	–	–	–	◪ 265	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 255	0.12	1.0	◪ 150	0.11	1.0	◪ 240	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 215	0.12	1.0	◪ 125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2	**T7325**	0.8	◪ 185	0.17	1.0	◪ 140	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 165	0.17	1.0	◪ 95	0.15	1.0	■ 155	0.17	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 210	0.17	1.0	◪ 115	0.15	1.0	◪ 175	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 290	0.17	1.0	–	–	–	◪ 275	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 260	0.17	1.0	◪ 155	0.15	1.0	◪ 245	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 225	0.17	1.0	◪ 135	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–

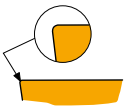
ECMW

PRAMET

	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



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

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
			E																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
ECMW 060204	**H07**	0.4	–	–	–	–	–	–	■ 100	0.10	2.0	–	–	–	–	–	–	–	–	–
ECMW 080304	**H07**	0.4	–	–	–	–	–	–	■ 100	0.10	2.5	–	–	–	–	–	–	–	–	–
ECMW 080308	**H07**	0.8	–	–	–	–	–	–	■ 95	0.18	2.5	–	–	–	–	–	–	–	–	–

SEGC(RL) EXT

P M K N S H

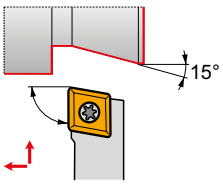
PRAMET

S

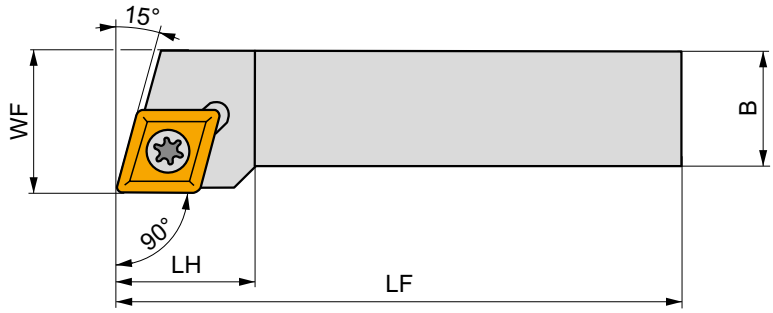


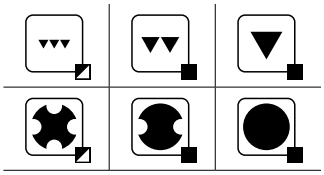
外螺纹锁车刀杆，使用EC..刀片，主偏角为90°。

外圆用左/右手持式车刀杆，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。











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

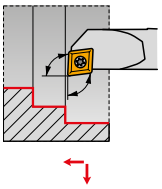
PRAMET

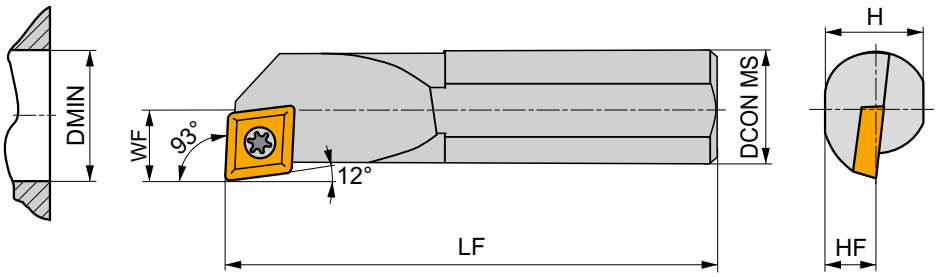
S

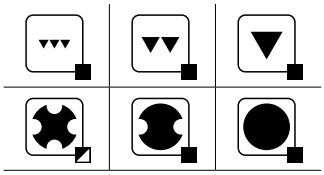


内孔用螺钉夹紧式镗杆，使用EC..刀片，主偏角为93°

内孔用左/右手镗杆，主偏角为93°。螺钉锁紧式。使用EC..06和08刀片。内孔最小加工直径为Ø11mm的刀柄。适用于内孔锥面，有阶梯孔的轴向车削，倒角车削。可提供Ø8至Ø25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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

EP 05

硬质合金刀片

EPGX



110

EPMT



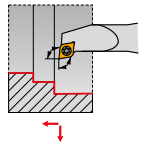
110

匹配正确的尺寸（示例）

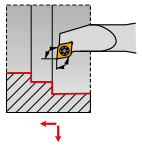
刀片	刀杆
EPGX **05**0202FR-JZ	S0608H-SELPR **05**

ISO内孔车削

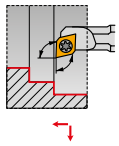
SELP(RL) INT

95°	EP..
	05
ØDmin 8 / 16	
111	110

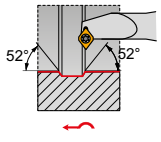
SELP(RL)-E INT

95°	EP..
	05
ØDmin 8 / 16	
112	110

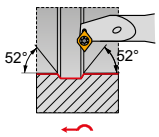
SEUP(RL) INT

93°	EP..
	05
ØDmin 8,3	
113	110

SEXP(RL) INT

52°30´	EP..
	05
ØDmin 9,5 / 16	
114	110

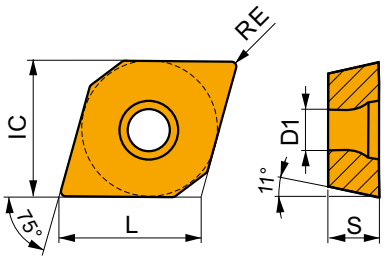
SEXP(RL)-E INT

52°30´	EP..
	05
ØDmin 9,5 / 16	
115	110

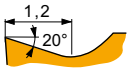
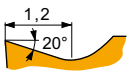
EPGX

PRAMET

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



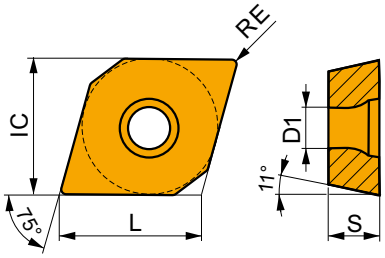
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			FR-JZ断屑槽，具有正前角，右手设计，适用于超精加工，连续切削。																	
EPGX 050202FR-JZ	**TT010**	0.2	■ 295	0.06	0.5	◪ 175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
			FL-JZ断屑槽，具有正前角，左手设计，适用于超精加工，连续切削。																	
EPGX 050202FL-JZ	**TT010**	0.2	■ 295	0.06	0.5	◪ 175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

EPMT

PRAMET

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



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

产品型号		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)
																				
			NF2断屑槽，具有正前角设计，适用于超精加工至中粗加工，连续切削。																	
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	–	–	–
	T7325	0.2	◪ 215	0.07	0.8	■ 165	0.06	0.8	–	–	–	–	–	–	■ 65	0.06	0.6	–	–	–
	T7335	0.2	◪ 220	0.07	0.8	■ 170	0.06	0.8	–	–	–	–	–	–	■ 70	0.06	0.6	–	–	–
	T9315	0.2	◪ 390	0.05	0.8	–	–	–	◪ 370	0.05	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	◪ 305	0.07	0.8	■ 180	0.06	0.8	◪ 285	0.07	0.8	–	–	–	◪ 65	0.06	0.6	–	–	–
	T9335	0.2	◪ 200	0.10	0.8	■ 120	0.09	0.8	–	–	–	–	–	–	◪ 45	0.07	0.6	–	–	–
	TT010	0.2	◪ 345	0.05	0.5	◪ 205	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

SELP(RL) INT

P M K N S H

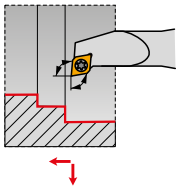
PRAMET

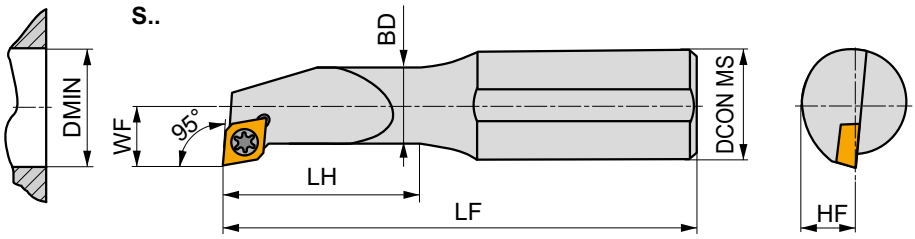
S

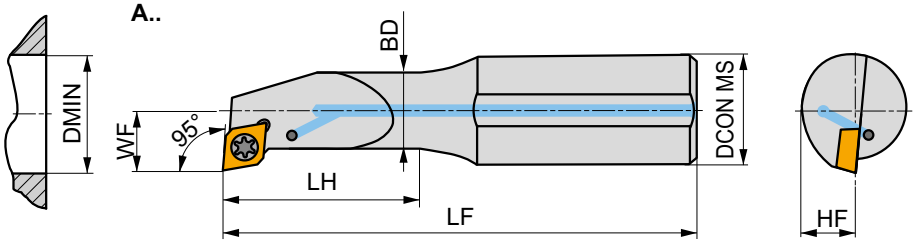


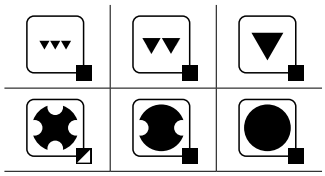
内孔用螺钉夹紧式镗杆，使用EP..刀片，主偏角为95°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为95°。使用EP..0502刀片。内孔最小加工直径为Ø8mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø8至Ø16mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	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	-10	0	–	0.04	GI212	SE21
	S0810J-SELPR 05	10	11	8	6	110	26	-5	0	–	0.06	GI212	SE22
	S1012K-SELPR 05	12	13	10	7	125	32	-5	0	–	0.11	GI212	SE22
	A1216M-SELPR 05	16	16	12	9	150	40	-2	0	✓	0.18	GI212	SE22
	S1216M-SELPR 05	16	16	12	9	150	40	-2	0	–	0.21	GI212	SE22
L	S0608H-SELPL 05	8	8	6	4.5	100	20	-10	0	–	0.04	GI212	SE21
	S0810J-SELPL 05	10	11	8	6	110	26	-5	0	–	0.06	GI212	SE22
	S1012K-SELPL 05	12	13	10	7	125	32	-5	0	–	0.11	GI212	SE22
	S1216M-SELPL 05	16	16	12	9	150	40	-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

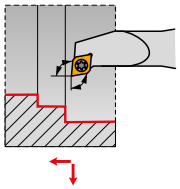
PRAMET

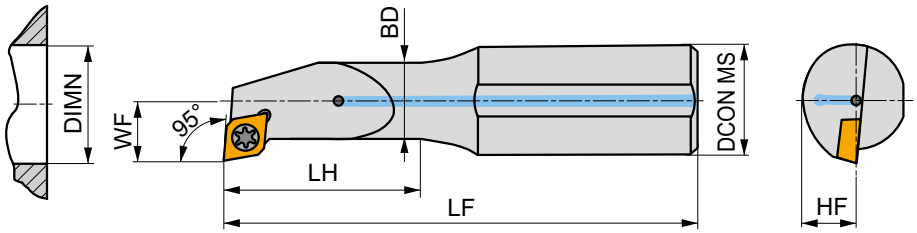
S

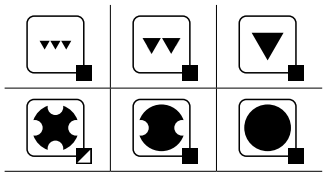


内孔用螺钉夹紧式硬质合金镗杆，使用EP..刀片，主偏角为95°。

内孔用左/右手硬质合金镗杆，有内冷通道，螺钉锁紧式。主偏角为95°使用EP刀片..0502刀片。内孔最小加工直径为Ø8mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø8至Ø16mm。刀具悬伸>3xD。









	产品型号	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	-10	0	✓	0.06	GI212	SE22
	E0810J-SELPR 05	10	11	8	6	110	36	-5	0	✓	0.10	GI212	SE22
	E1012K-SELPR 05	12	13	10	7	125	44	-5	0	✓	0.18	GI212	SE22
L	E0608H-SELPL 05	8	8	6	4.5	100	28	-10	0	✓	0.06	GI212	SE22
	E0810J-SELPL 05	10	11	8	6	110	36	-5	0	✓	0.10	GI212	SE22
	E1216M-SELPL 05	16	16	12	9	150	55	-2	0	✓	0.33	GI212	SE22

GI212	EP.. 0502..

		Nm			
SE22	28588	0.8	M 2.2	5.6	MA2-8304

SEUP(RL) INT

P M K N S H

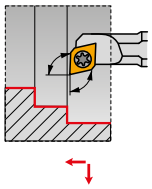
PRAMET

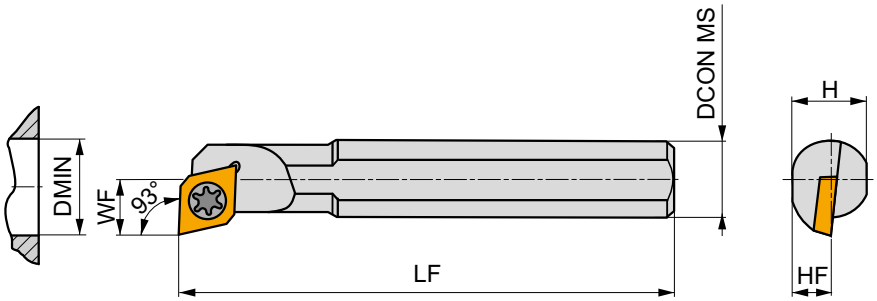
S

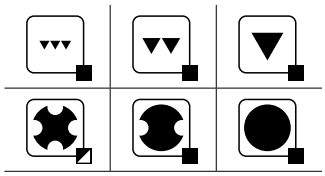


内孔用螺钉夹紧式镗杆，使用EP..刀片，主偏角为93°。

内孔用左/右手镗杆，主偏角为93°。螺钉锁紧式。使用EP..0502刀片。内孔最小加工直径为Ø8.3mm的刀柄。适用于有用内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø6mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	0.03	GI212	SE21
L	S06H-SEUPL 05	6	8.3	5	5.4	2.7	100	-7	0	0.03	GI212	SE21

GI212	EP.. 0502..

SE21	28992	0.8 Nm	M 2.2	4.2	MA2-8304

SEXP(RL) INT

P M K N S H

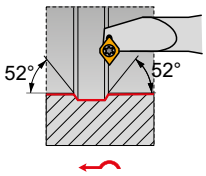
PRAMET

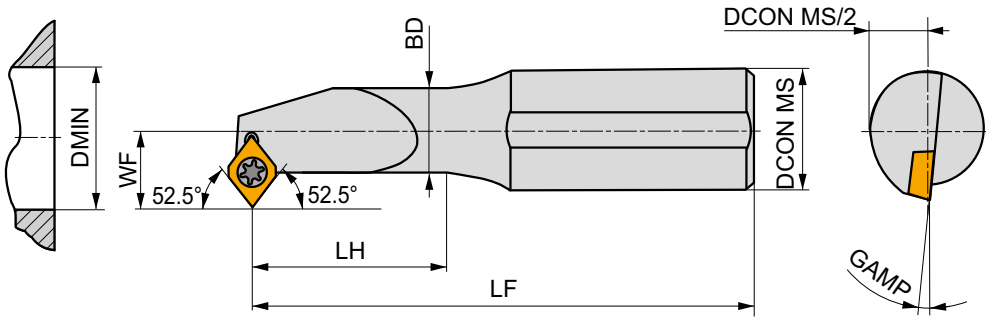
S

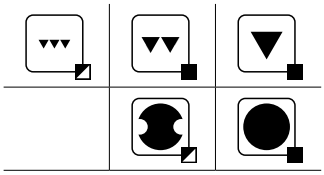


内孔用螺钉夹紧式镗杆，使用EP..刀片，主偏角为52.5°。

内孔用左/右手镗杆，螺钉锁紧式。使用EP刀片的主偏角为52.5°。0502刀片。内孔最小加工直径为Ø9.5mm。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。可提供Ø8至Ø16mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	-7	0.04	GI212	SE21
	S0810J-SEXPR 05	10	11	8	6	110	26	-5	0.06	GI212	SE22
	S1012K-SEXPR 05	12	13	10	7	125	32	-5	0.11	GI212	SE22
	S1216M-SEXPR 05	16	16	12	9	150	40	-2	0.21	GI212	SE22
L	**S0608H-SEXPL 05**	8	9.5	6	5.5	100	20	-7	0.04	GI212	SE21
	S0810J-SEXPL 05	10	11	8	6	110	26	-5	0.07	GI212	SE22
	S1012K-SEXPL 05	12	13	10	7	125	32	-5	0.11	GI212	SE22
	S1216M-SEXPL 05	16	16	12	9	150	40	-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

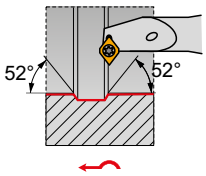
PRAMET

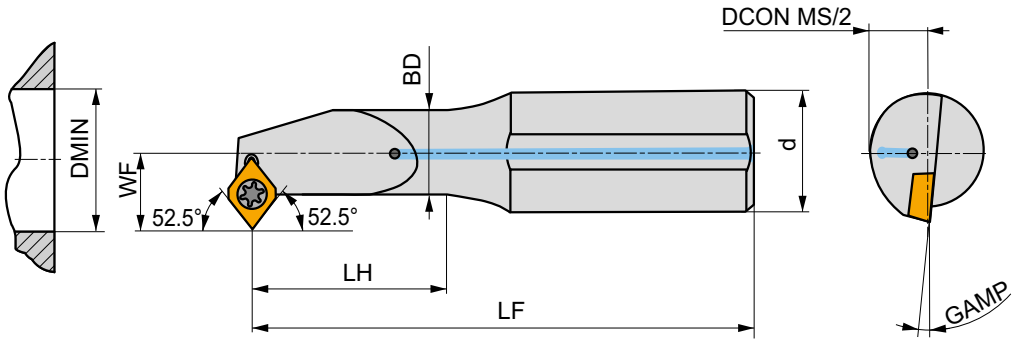
S

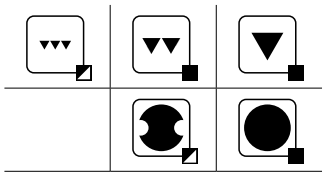


内孔用螺钉夹紧式硬质合金镗杆，使用EP..刀片，主偏角为52.5°。

内孔用左/右手硬质合金镗杆，有内冷通道，主偏角为52.5°，使用EP..0502刀片。内孔最小加工直径为Ø9.5mm。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。可提供Ø8至Ø16mm的刀柄。刀具悬伸>3xD。









	产品型号	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	-7	✓	0.07	GI212	SE21
	E0810J-SEXPR 05	10	11	8	6	110	36	-5	✓	0.11	GI212	SE22
	E1012K-SEXPR 05	12	13	10	7	125	44	-5	✓	0.16	GI212	SE22
	E1216M-SEXPR 05	16	16	12	9	150	55	-2	✓	0.32	GI212	SE22
L	**E0608H-SEXPL 05**	8	9.5	6	5.5	100	28	-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

RC

06/ 08/ 12/ 16/ 20/ 25/ 32

硬质合金刀片

RCGT



118

RCMT



118

RCMW



120

RCMX



121

CER刀片

RCGX CER



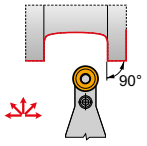
123

匹配正确的尺寸（示例）

刀片	刀杆
RCMT 1204MOE-RM3	SRDCN 3225 P 12-M

ISO 外圆车削

PRDCN EXT



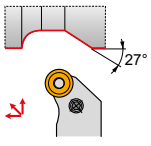
RC..

20
25
32

40×40
50×50

124 | 118 – 123

PRSC(RL) EXT



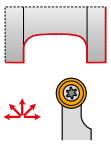
RC..

16
25

40×40

125 | 118 – 123

SRDC(RL) EXT



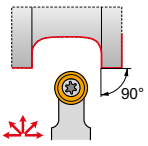
RC..

08

20×20
32×25

126 | 118 – 123

SRDCN EXT



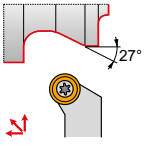
RC..

06
08
10
12
16

12×12
32×25

127 | 118 – 123

SRSC(RL) EXT



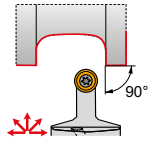
RC..

06
08
10
12
16

12×12
32×25

128 | 118 – 123

C.-SRDCN EXT *NEW*



RC..

10
12

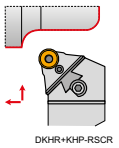
C4
C5

130 | 118 – 123

RC 06/ 08/ 12/ 16/ 20/ 25/ 32

ISO外圆重载车削

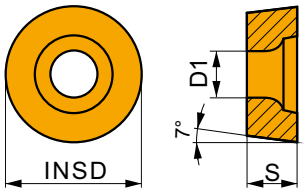
KHP-RSCR/L + DKH(RL)

	RC..
 DKHR+KHP-RSCR	20 25 32
■ 40×50 60×80	
131, 132	118 – 123

RCGT

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
0803	8.0	3.40	3.18
1003	10.0	4.40	3.18



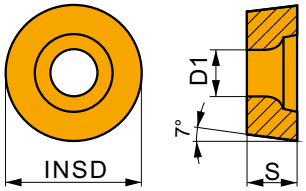
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			AL断屑槽，具有大正前角设计，适用于精加工至粗加工，连续切削至轻微断续切削。																	
RCGT 0803MOF-AL	**HF7**	–	–	–	–	–	–	–	–	–	–	285	1.20	1.0	–	–	–	–	–	–
	T0315	–	–	–	–	–	–	–	–	–	–	420	1.20	1.0	–	–	–	–	–	–
RCGT 1003MOF-AL	**HF7**	–	–	–	–	–	–	–	–	–	–	255	1.50	1.0	–	–	–	–	–	–
	T0315	–	–	–	–	–	–	–	–	–	–	390	1.50	1.0	–	–	–	–	–	–

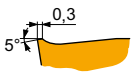
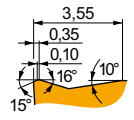
RCMT

PRAMET

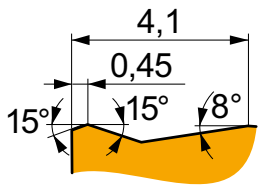
	INSD (mm)	D1 (mm)	S (mm)
0602	6.0	2.80	2.38
0803	8.0	3.40	3.18
10T3	10.0	4.40	3.97
1204	12.0	4.40	4.76
1606	16.0	5.50	6.35
2006	20.0	6.50	6.35
2507	25.0	8.60	7.94



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

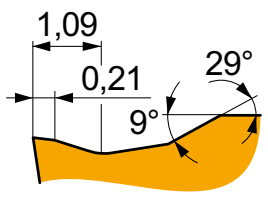
产品型号		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
			断屑槽37，适用于中粗加工至重载粗加工，连续至断续切削。																	
RCMT 1606MOS-37	**T9315**	–	165	0.60	3.0	–	–	–	155	0.60	3.0	–	–	–	–	–	–	–	–	–
	T9325	–	145	0.60	3.0	–	–	–	135	0.60	3.0	–	–	–	–	–	–	–	–	–
																				
			断屑槽371，适用于中粗加工至重载粗加工，连续至断续切削。																	
RCMT 2006MOS-371	**T9315**	–	145	0.80	3.0	–	–	–	135	0.80	3.0	–	–	–	–	–	–	–	–	–
	T9325	–	125	0.80	3.0	–	–	–	115	0.80	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。

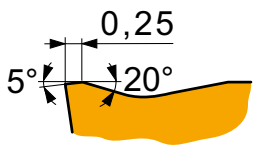
断屑槽372，适用于中粗加工至重载粗加工，连续至断续切削。

产品型号		RE (mm)	P	vc (m/min)	f (mm/rev)	ap (mm)	M	vc (m/min)	f (mm/rev)	ap (mm)	K	vc (m/min)	f (mm/rev)	ap (mm)	N	vc (m/min)	f (mm/rev)	ap (mm)	S	vc (m/min)	f (mm/rev)	ap (mm)	H	vc (m/min)	f (mm/rev)	ap (mm)
RCMT 2507MOS-372	T9325	–	■	90	0.80	3.0		–	–	–	◩	85	0.80	3.0		–	–	–		–	–	–		–	–	–

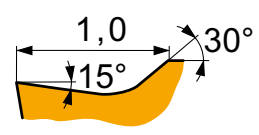
FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。

产品型号		RE (mm)	P	vc (m/min)	f (mm/rev)	ap (mm)	M	vc (m/min)	f (mm/rev)	ap (mm)	K	vc (m/min)	f (mm/rev)	ap (mm)	N	vc (m/min)	f (mm/rev)	ap (mm)	S	vc (m/min)	f (mm/rev)	ap (mm)	H	vc (m/min)	f (mm/rev)	ap (mm)
RCMT 0602MOE-FM	T7325	–	◩	215	0.45	1.2	■	165	0.41	1.2		–	–	–		–	–	–		–	–	–		–	–	–
	T8330	–	■	190	0.45	1.2	■	110	0.41	1.2	◩	180	0.45	1.2	◩	570	0.54	1.2		–	–	–		–	–	–
	T8430	–	■	200	0.45	1.2	■	110	0.41	1.2	◩	165	0.45	1.2	◩	555	0.54	1.2		–	–	–		–	–	–
	T9315	–	■	260	0.45	1.2		–	–	–	◩	245	0.45	1.2		–	–	–		–	–	–		–	–	–
	T9325	–	■	235	0.45	1.2	■	140	0.41	1.2	◩	220	0.45	1.2		–	–	–		–	–	–		–	–	–
RCMT 0803MOE-FM	T7325	–	◩	190	0.60	1.6	■	145	0.54	1.6		–	–	–		–	–	–		–	–	–		–	–	–
	T8330	–	■	170	0.60	1.6	■	100	0.54	1.6	◩	160	0.60	1.6	◩	510	0.72	1.6		–	–	–		–	–	–
	T8430	–	■	175	0.60	1.6	■	95	0.54	1.6	◩	140	0.60	1.6	◩	480	0.72	1.6		–	–	–		–	–	–
	T9315	–	■	225	0.60	1.6		–	–	–	◩	210	0.60	1.6		–	–	–		–	–	–		–	–	–
	T9325	–	■	200	0.60	1.6	■	120	0.54	1.6	◩	190	0.60	1.6		–	–	–		–	–	–		–	–	–
RCMT 10T3MOE-FM	T7325	–	◩	185	0.65	1.7	■	140	0.59	1.7		–	–	–		–	–	–		–	–	–		–	–	–
	T8330	–	■	165	0.65	1.7	■	95	0.59	1.7	◩	155	0.65	1.7	◩	495	0.78	1.7		–	–	–		–	–	–
	T8430	–	■	170	0.65	1.7	■	90	0.59	1.7	◩	135	0.65	1.7	◩	465	0.78	1.7		–	–	–		–	–	–
	T9315	–	■	220	0.65	1.7		–	–	–	◩	205	0.65	1.7		–	–	–		–	–	–		–	–	–
	T9325	–	■	195	0.65	1.7	■	115	0.59	1.7	◩	185	0.65	1.7		–	–	–		–	–	–		–	–	–
RCMT 1204MOE-FM	T7325	–	◩	175	0.70	1.8	■	135	0.63	1.8		–	–	–		–	–	–		–	–	–		–	–	–
	T8330	–	■	160	0.70	1.8	■	95	0.63	1.8	◩	150	0.70	1.8	◩	480	0.84	1.8		–	–	–		–	–	–
	T8430	–	■	155	0.70	1.8	■	85	0.63	1.8	◩	130	0.70	1.8	◩	435	0.84	1.8		–	–	–		–	–	–
	T9315	–	■	205	0.70	1.8		–	–	–	◩	190	0.70	1.8		–	–	–		–	–	–		–	–	–
	T9325	–	■	190	0.70	1.8	■	110	0.63	1.8	◩	180	0.70	1.8		–	–	–		–	–	–		–	–	–

RM3断屑槽，适用于中粗加工至粗加工，连续至断续切削。

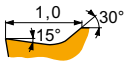
产品型号		RE (mm)	P	vc (m/min)	f (mm/rev)	ap (mm)	M	vc (m/min)	f (mm/rev)	ap (mm)	K	vc (m/min)	f (mm/rev)	ap (mm)	N	vc (m/min)	f (mm/rev)	ap (mm)	S	vc (m/min)	f (mm/rev)	ap (mm)	H	vc (m/min)	f (mm/rev)	ap (mm)
RCMT 0803MOE-RM3	T7325	–	◩	185	0.50	1.3	◩	140	0.45	1.3		–	–	–		–	–	–		–	–	–		–	–	–
	T9315	–	■	225	0.50	1.3		–	–	–	◩	210	0.50	1.3		–	–	–		–	–	–	◩	45	0.15	1.0
RCMT 1204MOE-RM3	H07	–		–	–	–	◩	65	0.54	1.8	■	105	0.60	1.8		–	–	–		–	–	–		–	–	–
	T7325	–	◩	165	0.60	1.8	◩	125	0.54	1.8		–	–	–		–	–	–		–	–	–		–	–	–
	T8330	–	■	150	0.60	1.8	◩	90	0.54	1.8	■	140	0.60	1.8		–	–	–		–	–	–	◩	30	0.15	1.0
	T8430	–	■	150	0.60	1.8	◩	80	0.54	1.8	◩	125	0.60	1.8		–	–	–		–	–	–	◩	25	0.15	1.0
	T9315	–	■	205	0.60	1.8		–	–	–	◩	190	0.60	1.8		–	–	–		–	–	–	◩	40	0.15	1.0
RCMT 1606MOE-RM3	T7325	–	◩	160	0.65	2.0	◩	120	0.59	2.0		–	–	–		–	–	–		–	–	–		–	–	–
	T8330	–	■	145	0.65	2.0	◩	85	0.59	2.0	■	135	0.65	2.0		–	–	–		–	–	–	◩	25	0.15	1.0
	T8430	–	■	145	0.65	2.0	◩	80	0.59	2.0	◩	120	0.65	2.0		–	–	–		–	–	–	◩	25	0.15	1.0
	T9315	–	■	195	0.65	2.0		–	–	–	◩	185	0.65	2.0		–	–	–		–	–	–	◩	35	0.15	1.0
RCMT 2507MOE-RM3	H07	–		–	–	–	◩	60	0.54	3.0	■	95	0.60	3.0		–	–	–		–	–	–		–	–	–

UR断屑槽，适用于精细的精加工，连续切削或轻微断续切削。

产品型号		RE (mm)	P	vc (m/min)	f (mm/rev)	ap (mm)	M	vc (m/min)	f (mm/rev)	ap (mm)	K	vc (m/min)	f (mm/rev)	ap (mm)	N	vc (m/min)	f (mm/rev)	ap (mm)	S	vc (m/min)	f (mm/rev)	ap (mm)	H	vc (m/min)	f (mm/rev)	ap (mm)
RCMT 0602MOE-UR	T6310	–	■	170	0.40	1.2	◩	120	0.36	1.2	■	135	0.40	1.2		–	–	–		–	–	–		–	–	–
	T7325	–	◩	190	0.40	1.2	◩	145	0.36	1.2		–	–	–		–	–	–		–	–	–		–	–	–
	T8330	–	■	170	0.40	1.2	◩	100	0.36	1.2	■	160	0.40	1.2		–	–	–		–	–	–		–	–	–
	T8430	–	■	180	0.40	1.2	◩	95	0.36	1.2	◩	145	0.40	1.2		–	–	–		–	–	–		–	–	–
	T9315	–	■	240	0.40	1.2		–	–	–	◩	225	0.40	1.2		–	–	–		–	–	–		–	–	–
	T9325	–	■	215	0.40	1.2	◩	125	0.36	1.2	◩	200	0.40	1.2		–	–	–		–	–	–		–	–	–

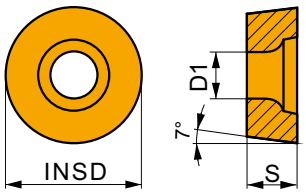
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 E																	
			UR断屑槽，适用于精细的精加工，连续切削或轻微断续切削。																	
RCMT 0803M0E-UR	**T6310**	–	■ 160	0.45	1.6	◪ 115	0.41	1.6	■ 125	0.45	1.6	–	–	–	–	–	–	–	–	–
	T7325	–	◪ 180	0.45	1.6	◪ 140	0.41	1.6	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	–	■ 160	0.45	1.6	◪ 95	0.41	1.6	■ 150	0.45	1.6	–	–	–	–	–	–	–	–	–
	T8430	–	■ 170	0.45	1.6	◪ 90	0.41	1.6	◪ 135	0.45	1.6	–	–	–	–	–	–	–	–	–
	T9315	–	■ 220	0.45	1.6	–	–	–	◪ 205	0.45	1.6	–	–	–	–	–	–	–	–	–
	T9325	–	■ 200	0.45	1.6	◪ 120	0.41	1.6	◪ 190	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 10T3M0E-UR	**T6310**	–	■ 160	0.50	1.4	◪ 115	0.45	1.4	■ 125	0.50	1.4	–	–	–	–	–	–	–	–	–
	T7325	–	◪ 175	0.50	1.4	◪ 135	0.45	1.4	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	–	■ 160	0.50	1.4	◪ 95	0.45	1.4	■ 150	0.50	1.4	–	–	–	–	–	–	–	–	–
	T8430	–	■ 165	0.50	1.4	◪ 90	0.45	1.4	◪ 135	0.50	1.4	–	–	–	–	–	–	–	–	–
	T9315	–	■ 215	0.50	1.4	–	–	–	◪ 200	0.50	1.4	–	–	–	–	–	–	–	–	–
	T9325	–	■ 190	0.50	1.4	◪ 110	0.45	1.4	◪ 180	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-UR	**T6310**	–	■ 150	0.55	1.8	◪ 105	0.50	1.8	■ 120	0.55	1.8	–	–	–	–	–	–	–	–	–
	T7325	–	◪ 165	0.55	1.8	◪ 125	0.50	1.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	–	■ 150	0.55	1.8	◪ 90	0.50	1.8	■ 140	0.55	1.8	–	–	–	–	–	–	–	–	–
	T8430	–	■ 145	0.55	1.8	◪ 80	0.50	1.8	◪ 120	0.55	1.8	–	–	–	–	–	–	–	–	–
	T9315	–	■ 200	0.55	1.8	–	–	–	◪ 190	0.55	1.8	–	–	–	–	–	–	–	–	–
	T9325	–	■ 180	0.55	1.8	◪ 105	0.50	1.8	◪ 170	0.55	1.8	–	–	–	–	–	–	–	–	–

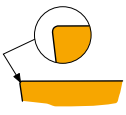
RCMW

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
0602	6.0	2.80	2.38
0803	8.0	3.40	3.18
10T3	10.0	4.40	3.97
1204	12.0	4.40	4.76



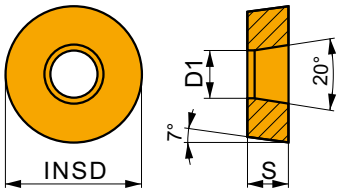
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 E																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
RCMW 0602M0	**T5305**	–	–	–	–	–	–	–	■ 280	0.25	0.6	–	–	–	–	–	–	◪ 55	0.15	1.0
	T5315	–	–	–	–	–	–	–	■ 250	0.25	0.6	–	–	–	–	–	–	◪ 50	0.15	1.0
RCMW 0803M0	**T5305**	–	–	–	–	–	–	–	■ 255	0.30	0.8	–	–	–	–	–	–	◪ 50	0.15	1.0
	T5315	–	–	–	–	–	–	–	■ 230	0.30	0.8	–	–	–	–	–	–	◪ 45	0.15	1.0
RCMW 10T3M0	**T5305**	–	–	–	–	–	–	–	■ 225	0.40	1.0	–	–	–	–	–	–	◪ 45	0.15	1.0
	T5315	–	–	–	–	–	–	–	■ 200	0.40	1.0	–	–	–	–	–	–	◪ 40	0.15	1.0
RCMW 1204M0	**T5305**	–	–	–	–	–	–	–	■ 205	0.45	1.2	–	–	–	–	–	–	◪ 40	0.15	1.0
	T5315	–	–	–	–	–	–	–	■ 190	0.45	1.2	–	–	–	–	–	–	◪ 40	0.15	1.0

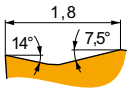
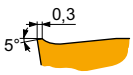
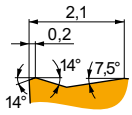
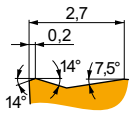
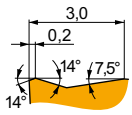
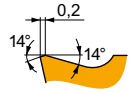
RCMX

PRAMET

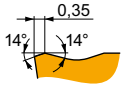
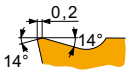
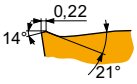
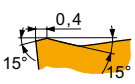
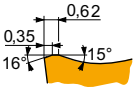
	INSD (mm)	D1 (mm)	S (mm)
1003	10.0	3.60	3.18
1204	12.0	4.20	4.76
1606	16.0	5.20	6.35
2006	20.0	6.50	6.35
2507	25.0	7.20	7.94
3209	32.0	9.50	9.53



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。

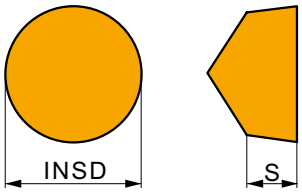
产品型号		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			HFC E																	
			断屑槽31，适用于精加工至中粗加工，连续至断续切削。																	
RCMX 1003M0S-31	T9325	–	165	0.50	2.0	95	0.45	2.0	155	0.50	2.0	–	–	–	–	–	–	–	–	–
	T9335	–	140	0.50	2.0	80	0.45	2.0	–	–	–	–	–	–	–	–	–	–	–	–
			HFC S																	
			断屑槽37，适用于中粗加工至重载粗加工，连续至断续切削。																	
RCMX 1606M0S-37	T9315	–	165	0.60	3.0	–	–	–	155	0.60	3.0	–	–	–	–	–	–	–	–	–
	T9325	–	145	0.60	3.0	–	–	–	135	0.60	3.0	–	–	–	–	–	–	–	–	–
			HFC S																	
			断屑槽321，适用于中粗加工至重载粗加工，连续至断续切削。																	
RCMX 1204M0S-321	T9315	–	130	1.00	3.0	–	–	–	120	1.00	3.0	–	–	–	–	–	–	–	–	–
	T9325	–	120	1.00	3.0	–	–	–	110	1.00	3.0	–	–	–	–	–	–	–	–	–
	T9335	–	105	1.00	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
			HFC S																	
			断屑槽331，适用于中粗加工至重载粗加工，连续至断续切削。																	
RCMX 1606M0S-331	T9315	–	120	1.20	3.5	–	–	–	110	1.20	3.5	–	–	–	–	–	–	–	–	–
	T9325	–	105	1.20	3.5	–	–	–	95	1.20	3.5	–	–	–	–	–	–	–	–	–
	T9335	–	110	0.80	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
			HFC S																	
			断屑槽341，适用于中粗加工至重载粗加工，连续至断续切削。																	
RCMX 2006M0S-341	6640	–	90	1.00	3.5	–	–	–	85	1.00	3.5	–	–	–	–	–	–	–	–	–
			HFC S																	
			断屑槽351，适用于中粗加工至重载粗加工，连续至断续切削。																	
RCMX 2507M0S-351	6640	–	60	1.00	3.5	–	–	–	55	1.00	3.5	–	–	–	–	–	–	–	–	–

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

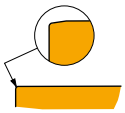
产品型号		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
			HFC S																	
断屑槽361，适用于粗加工至重载粗加工，连续切削至重载切削的连续切削。																				
RCMX 3209M0S-361	**6640**	–	■ 50	1.40	4.5	–	–	–	■ 45	1.40	4.5	–	–	–	–	–	–	–	–	–
			HFC S																	
RF1断屑槽，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	–	–	–	–	–	–	–	–	–
	T9310	–	■ 105	0.80	3.5	–	–	–	◪ 95	0.80	3.5	–	–	–	–	–	–	–	–	–
	T9315	–	■ 100	0.80	3.5	–	–	–	◪ 95	0.80	3.5	–	–	–	–	–	–	–	–	–
	T9325	–	■ 90	0.80	3.5	–	–	–	◪ 85	0.80	3.5	–	–	–	–	–	–	–	–	–
	T9335	–	■ 110	0.80	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1	**T8345**	–	■ 45	1.00	3.5	–	–	–	◪ 40	1.00	3.5	–	–	–	–	–	–	–	–	–
	T9310	–	■ 95	1.00	3.5	–	–	–	◪ 90	1.00	3.5	–	–	–	–	–	–	–	–	–
	T9315	–	■ 90	1.00	3.5	–	–	–	◪ 85	1.00	3.5	–	–	–	–	–	–	–	–	–
	T9325	–	■ 80	1.00	3.5	–	–	–	◪ 75	1.00	3.5	–	–	–	–	–	–	–	–	–
	T9335	–	■ 65	1.00	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
			HFC S																	
RM1断屑槽，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	–	–	–	–	–	–	–	–	–
	T9315	–	■ 90	1.00	3.5	–	–	–	◪ 85	1.00	3.5	–	–	–	–	–	–	–	–	–
	T9325	–	■ 80	1.00	3.5	–	–	–	◪ 75	1.00	3.5	–	–	–	–	–	–	–	–	–
	T9335	–	■ 125	0.60	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1	**T9310**	–	■ 95	1.00	3.5	–	–	–	◪ 90	1.00	3.5	–	–	–	–	–	–	–	–	–
	T9315	–	■ 90	1.00	3.5	–	–	–	◪ 85	1.00	3.5	–	–	–	–	–	–	–	–	–
	T9325	–	■ 80	1.00	3.5	–	–	–	◪ 75	1.00	3.5	–	–	–	–	–	–	–	–	–
	T9335	–	■ 80	0.60	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
			HFC S																	
RM2断屑槽，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	–	–	–	–	–	–	–	–	–
	T9315	–	■ 85	1.10	3.5	–	–	–	◪ 80	1.10	3.5	–	–	–	–	–	–	–	–	–
	T9325	–	■ 75	1.10	3.5	–	–	–	◪ 70	1.10	3.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2	**T5315**	–	◪ 95	1.00	4.5	–	–	–	◪ 90	1.00	4.5	–	–	–	–	–	–	–	–	–
	T9310	–	■ 90	1.00	4.5	–	–	–	◪ 85	1.00	4.5	–	–	–	–	–	–	–	–	–
	T9315	–	■ 85	1.00	4.5	–	–	–	◪ 80	1.00	4.5	–	–	–	–	–	–	–	–	–
	T9325	–	■ 75	1.00	4.5	–	–	–	◪ 70	1.00	4.5	–	–	–	–	–	–	–	–	–
	T9335	–	■ 55	1.40	4.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
			HFC P																	
RR2断屑槽，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	0.15	1.0
	T9316	–	■ 60	1.40	4.5	–	–	–	◪ 55	1.40	4.5	–	–	–	–	–	–	–	–	–

RCGX CER

	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。

产品型号		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		K															
适用于高线速度连续切削。																				
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	–	–	–	–	–	–	–	–	–

PRDCN EXT

P M K N S H

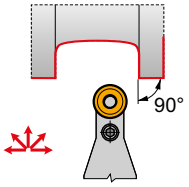
PRAMET

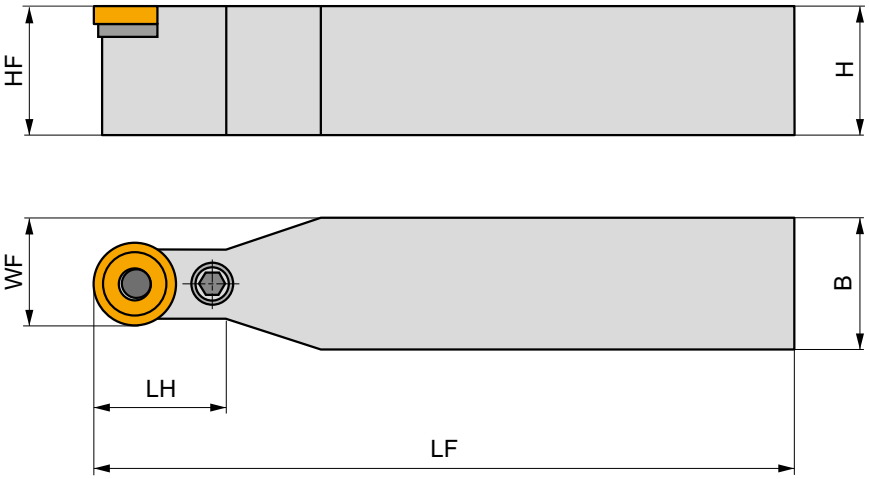
P

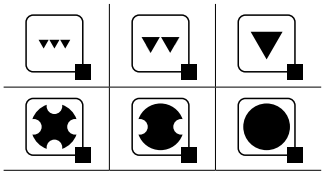


外圆用杠杆夹紧式车刀杆，使用圆形RC..刀片。

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。









	产品型号	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	32	0	0	0.80	GI090	PRP70
	PRDCN 3232 P 20	32	32	32	26	170	32	0	0	1.30	GI069	PRP90
	PRDCN 4040 S 20	40	40	40	30	250	40	0	0	3.10	GI069	PRP90
	PRDCN 4040 S 25	40	40	40	32.5	250	40	0	0	3.20	GI122	PRP80
	PRDCN 5050 S 32	50	50	50	41	250	50	0	0	3.50	GI096	PRP32
	PRDCN 5050 T 32	50	50	50	41	300	50	0	0	5.12	GI096	PRP32

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

				Nm					
PRP32	RCU 320600	PU 10	US 47	8.0	M 12x1	36	NT 08	MT 08	HXK 5
PRP70	RCU 160300	PU 07	US 36	6.0	M 8x1	26	NT 05	MT 05	HXK 4
PRP80	RCU 250600	PU 08	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5
PRP90	RCU 200400	PU 09	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4

PRSC(RL) EXT

P M K N S H

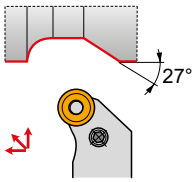
PRAMET

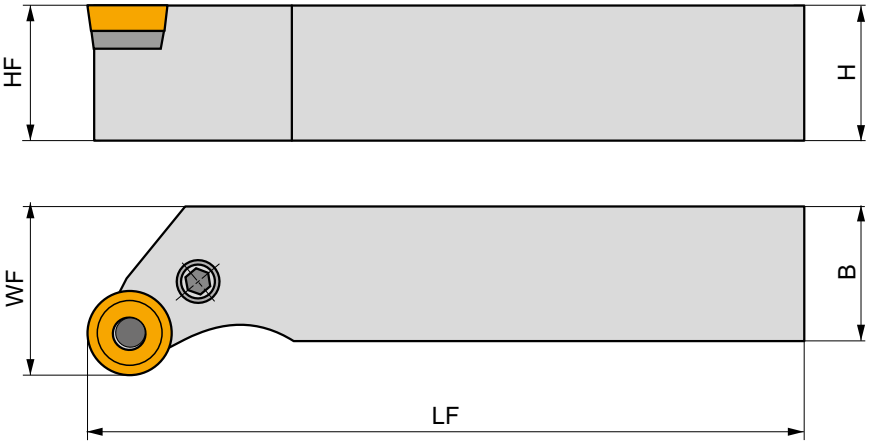
P

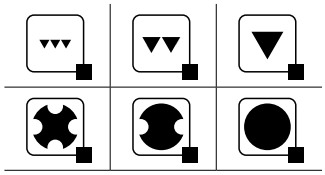


外圆用杠杆夹紧式车刀杆，使用圆形RC..刀片。

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。









	产品型号	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	0.90	GI090	PRP70
	PRSCR 4040 R 16	40	40	40	50	200	0	0	2.38	GI090	PRP70
	PRSCR 3232 P 20	32	32	32	40	170	0	0	1.40	GI069	PRP90
	PRSCR 4040 S 25	40	40	40	50	250	0	0	3.40	GI122	PRP80
L	**PRSCL 3225 P 16**	32	25	32	32	170	0	0	0.90	GI090	PRP70
	PRSCL 4040 R 16	40	40	40	50	200	0	0	2.38	GI090	PRP70
	PRSCL 3232 P 20	32	32	32	40	170	0	0	1.32	GI069	PRP90
	PRSCL 4040 S 25	40	40	40	50	250	0	0	3.40	GI122	PRP80

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

				Nm					
PRP70	RCU 160300	PU 07	US 36	6.0	M 8x1	26	NT 05	MT 05	HXK 4
PRP80	RCU 250600	PU 08	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5
PRP90	RCU 200400	PU 09	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4

SRDC(RL) EXT

P M K N S H

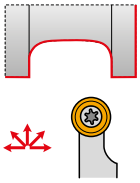
PRAMET

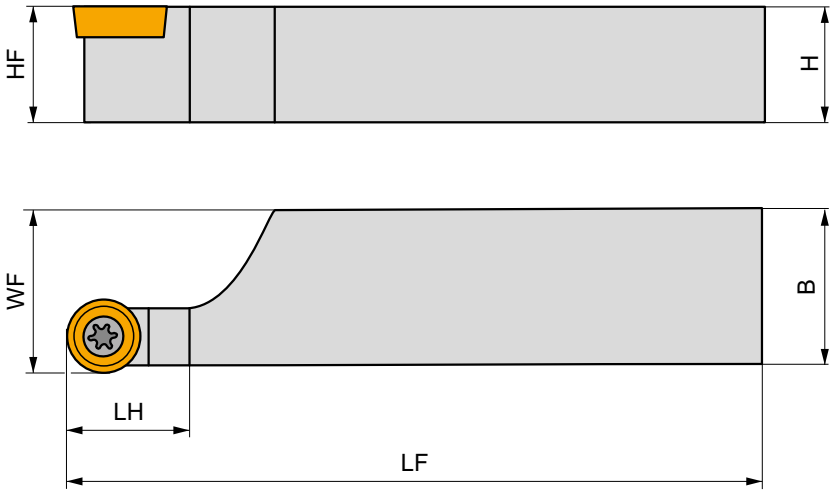
S

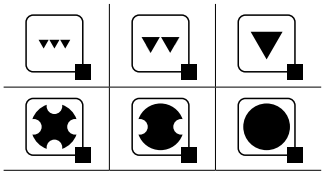


外圆用螺钉夹紧式车刀杆，使用圆形RC..刀片。

外圆用左/右手持式车刀杆，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。









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

GI051	RC.. 0803M0

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

SRDCN EXT

P M K N S H

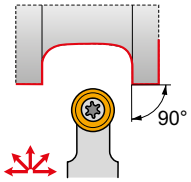
PRAMET

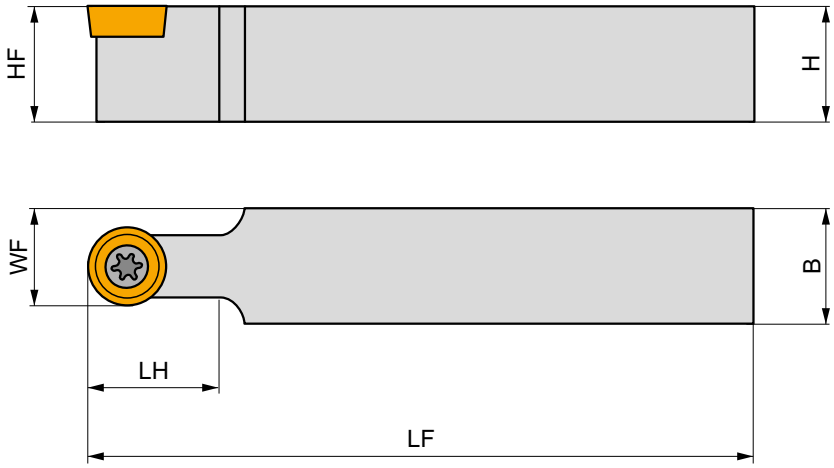
S

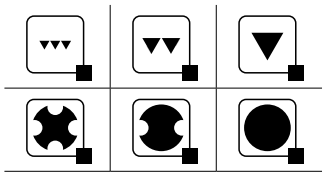


外圆用螺钉夹紧式车刀杆，使用圆形RC..刀片。

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。









	产品型号	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	0.10	GI054	S01
	SRDCN 1616 H 06	16	16	16	11	100	12	0	0	0.20	GI054	S01
	SRDCN 2020 K 08	20	20	20	14	125	20	0	0	0.38	GI051	S03
	SRDCN 2020 K 1003-M-A	20	20	20	15	125	25	0	0	0.40	GI064	SR10
	SRDCN 2020 K 10-M-A	20	20	20	15	125	25	0	0	0.40	GI013	SR10
	SRDCN 2525 M 10-M-A	25	25	25	17.5	150	25	0	0	0.68	GI013	SR10
	SRDCN 2525 M 12-M-A	25	25	25	18.5	150	30	0	0	0.68	GI014	SR12
	SRDCN 3225 P 10-M	32	25	32	17.5	170	25	0	0	0.90	GI013	SR10
	SRDCN 3225 P 12-M	32	25	32	18.5	170	30	0	0	0.90	GI014	SR12
	SRDCN 3225 P 16-M	32	25	32	20.5	170	32	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

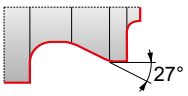
PRAMET

S



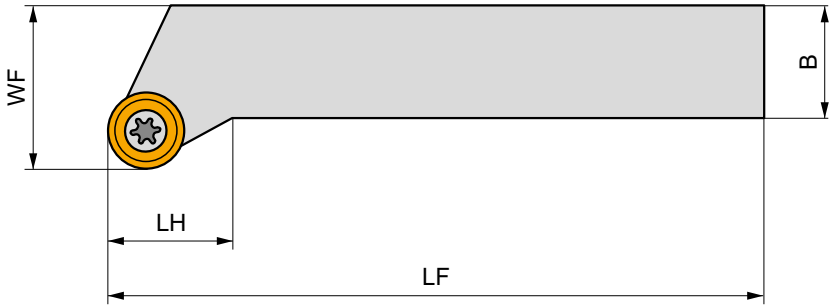
外圆用螺钉夹紧式车刀杆，使用圆形RC..刀片。

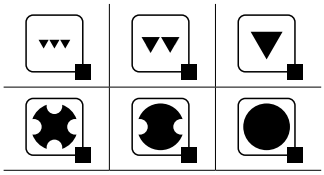
外圆用左/右手持式车刀杆，螺钉锁紧式。使用RC..06至16正前角刀片。适用于外圆表面，无阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供12x12至32x25mm的刀柄。刀杆经过处理，使用寿命更长。













	产品型号	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	0.09	GI054	S01
	SRSCR 1616 H 06	16	16	16	20	100	12	0	0	0.22	GI054	S01
	SRSCR 2020 K 08	20	20	20	25	125	20	0	0	0.45	GI051	S03
	SRSCR 2020 K 10-M-A	20	20	20	25	125	20	0	0	0.45	GI013	SR10
	SRSCR 2525 M 10-M-A	25	25	25	32	150	20	0	0	0.75	GI013	SR10
	SRSCR 3225 P 10-M	32	25	32	32	170	20	0	0	1.06	GI013	SR10
	SRSCR 2525 M 12-M-A	25	25	25	32	150	20	0	0	0.75	GI014	SR12
	SRSCR 3225 P 12-M	32	25	32	32	170	20	0	0	1.07	GI014	SR12
	SRSCR 3225 P 16-M	32	25	32	32	170	20	0	0	1.10	GI161	SR16
L	SRSCL 1212 F 06	12	12	12	16	80	12	0	0	0.10	GI054	S01
	SRSCL 1616 H 06	16	16	16	20	100	12	0	0	0.22	GI054	S01
	SRSCL 2020 K 08	20	20	20	25	125	20	0	0	0.45	GI051	S03
	SRSCL 2020 K 10-M-A	20	20	20	25	125	20	0	0	0.45	GI013	SR10
	SRSCL 2525 M 10-M-A	25	25	25	32	150	20	0	0	0.75	GI013	SR10
	SRSCL 3225 P 10-M	32	25	32	32	170	20	0	0	1.06	GI013	SR10
	SRSCL 2525 M 12-M-A	25	25	25	32	150	20	0	0	0.75	GI014	SR12
	SRSCL 3225 P 12-M	32	25	32	32	170	20	0	0	1.07	GI014	SR12
	SRSCL 3225 P 16-M	32	25	32	32	170	20	0	0	1.10	GI161	SR16

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

								
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

NEW

C.-SRDCN EXT

P M K N S H

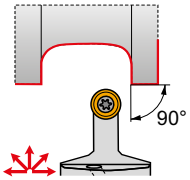
PRAMET

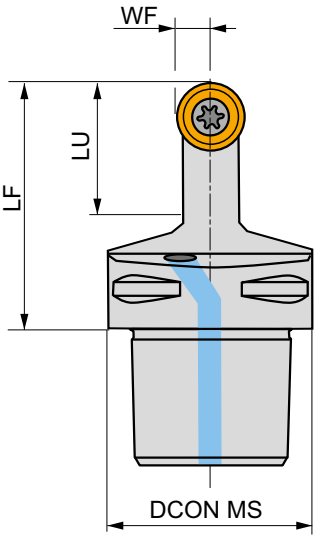
S

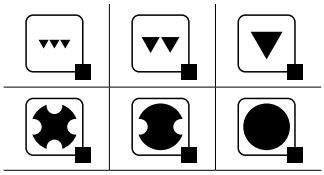


外圆用PSC快速更换式刀柄，使用RC..刀片，螺钉夹紧式。

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。









	产品型号	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

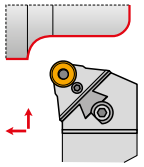
PRAMET

P

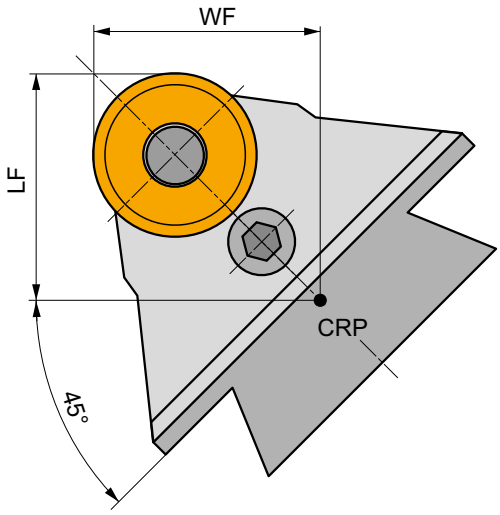


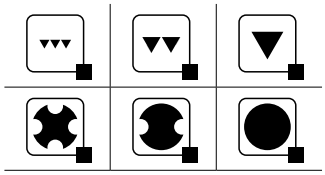
模块化KHP杠杆夹紧式车刀刀夹，使用RC..刀片。

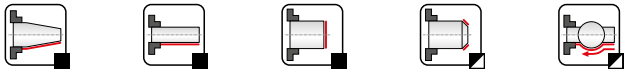
燕尾形左/右手杠杆夹紧式车刀夹，安装在DKH刀杆上。使用RC..20至32负前角正前角刀片。适用于无阶梯外圆的重载轴向车削，端面车削，锥面和倒角车削。车刀杆经过处理，使用寿命更长。



DKHR+KHP-RSCR







	产品型号	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-RSCR 20**	35	45	0	0	1.25	GI069	PRP90
	KHP-RSCR 25	35	45	0	0	1.30	GI122	PRP80
	KHP-RSCR 32	35	45	0	0	1.30	GI096	PRP32
	KHP-RSCL 20	35	45	0	0	1.30	GI069	PRP90
	KHP-RSCL 25	35	45	0	0	1.30	GI122	PRP80
	KHP-RSCL 32	35	45	0	0	1.30	GI096	PRP32

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

				Nm					
PRP32	RCU 320600	PU 10	US 47	8.0	M 12x1	36	NT 08	MT 08	HXK 5
PRP80	RCU 250600	PU 08	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5
PRP90	RCU 200400	PU 09	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4

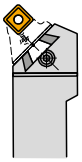
DKH(RL)

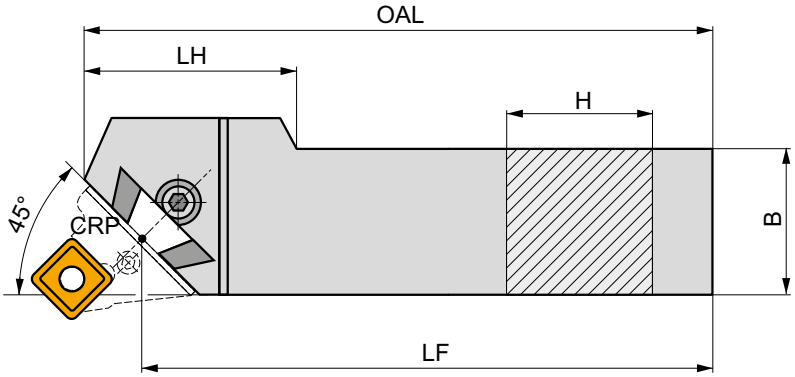
PRAMET

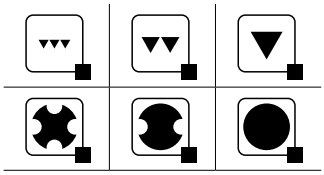


使用KHP/KHS重载车刀刀夹的外圆用刀柄

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。







	产品型号	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

SC

09/ 12/ 25/ 38

硬质合金刀片

SCGT	SCMT	SCMW
		
134	135	138

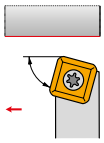
匹配正确的尺寸（示例）

刀片	刀杆
SCMT 120408E-RM	SSDCN 2020 K 12-M-A

ISO 外圆车削

SSBC(RL) EXT

75°



SC..

09
12
25
38

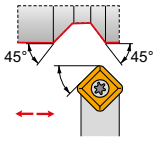
12×12
60×60

139

134 – 138

SSDCN EXT

45°



SC..

09
12

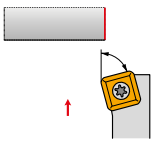
12×12
25×25

140

134 – 138

SSKC(RL) EXT

75°



SC..

09
12

12×12
25×25

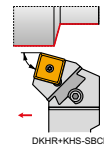
141

134 – 138

ISO外圆重载车削

KHS-SBCR + DKH(RL)

75°



SC..

25
38

40×50
60×80

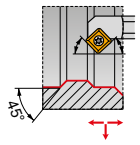
142, 143

134 – 138

ISO内孔车削

SSSC(RL) INT

45°



SC..

09



25
32

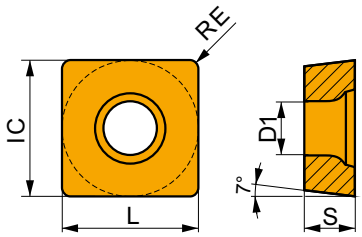
144

134 – 138

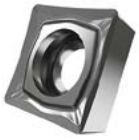
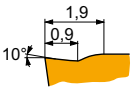
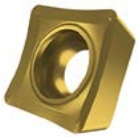
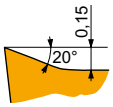
SCGT

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
09T3-SF3	9.525	4.40	9.53	4.22
1204	12.700	5.50	12.70	4.76



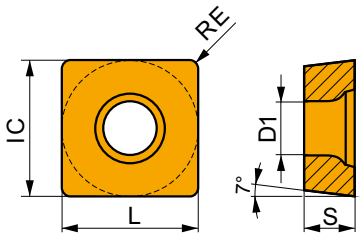
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
AL断屑槽，具有大正前角设计，适用于精加工至粗加工，连续切削至轻微断续切削。																				
SCGT 120408F-AL	**HF7**	0.8	–	–	–	–	–	–	–	–	–	■ 315	0.48	2.0	–	–	–	–	–	–
	T0315	0.8	–	–	–	–	–	–	–	–	–	■ 465	0.48	2.0	–	–	–	–	–	–
																				
NF1断屑槽，具有正前角设计，适用于超精加工至中度加工，连续切削。																				
SCGT 09T308E-NF1	**H07**	0.8	–	–	–	◪ 100	0.13	1.2	–	–	–	◪ 510	0.17	1.2	■ 50	0.13	1.0	–	–	–
	T6310	0.8	■ 200	0.14	1.2	■ 140	0.13	1.2	–	–	–	◪ 600	0.17	1.2	■ 60	0.13	1.0	◪ 40	0.15	1.0
	T7325	0.8	◪ 225	0.14	1.2	■ 175	0.13	1.2	–	–	–	–	–	–	■ 70	0.13	1.0	–	–	–
SCGT 120408E-NF1	**H07**	0.8	–	–	–	◪ 90	0.16	1.4	–	–	–	◪ 455	0.22	1.4	■ 45	0.16	1.1	–	–	–
	T6310	0.8	■ 180	0.18	1.4	■ 125	0.16	1.4	–	–	–	◪ 540	0.22	1.4	■ 50	0.16	1.1	◪ 35	0.15	1.0
	T7325	0.8	◪ 205	0.18	1.4	■ 155	0.16	1.4	–	–	–	–	–	–	■ 65	0.16	1.1	–	–	–
																				
SF3断屑槽，具有大正前角设计，适用于精细的精加工，连续切削。																				
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	0.15	1.0
	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	0.15	1.0

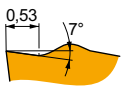
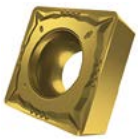
SCMT

PRAMET

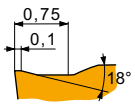
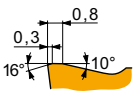
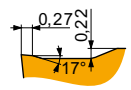
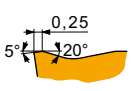
	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76
2509	25.400	8.70	25.40	9.53
3809	38.100	8.70	38.10	9.53



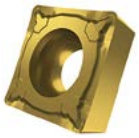
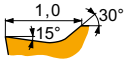
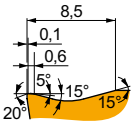
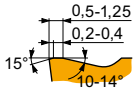
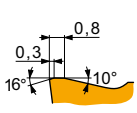
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
SCMT 09T304E-FF2	**T8430**	0.4	■ 210	0.12	1.2	–	–	–	◪ 175	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 260	0.12	1.2	–	–	–	◪ 245	0.12	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FF2	**T8330**	0.8	■ 185	0.17	1.2	–	–	–	■ 175	0.17	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 220	0.17	1.2	–	–	–	◪ 180	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 265	0.17	1.2	–	–	–	◪ 250	0.17	1.2	–	–	–	–	–	–	–	–	–
																				
FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
SCMT 09T304E-FM	**T7325**	0.4	◪ 205	0.15	1.2	■ 155	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	◪ 200	0.15	1.2	■ 155	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	◪ 190	0.15	1.2	■ 110	0.14	1.2	◪ 180	0.15	1.2	◪ 570	0.18	1.2	–	–	–	–	–	–
	T8330	0.4	■ 180	0.15	1.2	■ 105	0.14	1.2	◪ 170	0.15	1.2	◪ 540	0.18	1.2	–	–	–	–	–	–
	T8430	0.4	■ 210	0.15	1.2	■ 115	0.14	1.2	◪ 175	0.15	1.2	◪ 585	0.18	1.2	–	–	–	–	–	–
	T9315	0.4	■ 290	0.15	1.2	–	–	–	◪ 275	0.15	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 260	0.15	1.2	■ 155	0.15	1.2	◪ 245	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM	**T7325**	0.8	◪ 225	0.20	1.2	■ 175	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪ 215	0.20	1.2	■ 165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	◪ 205	0.20	1.2	■ 120	0.18	1.2	◪ 190	0.20	1.2	◪ 615	0.24	1.2	–	–	–	–	–	–
	T8330	0.8	■ 195	0.20	1.2	■ 115	0.18	1.2	◪ 185	0.20	1.2	◪ 585	0.24	1.2	–	–	–	–	–	–
	T8430	0.8	■ 225	0.20	1.2	■ 120	0.18	1.2	◪ 185	0.20	1.2	◪ 615	0.24	1.2	–	–	–	–	–	–
	T9315	0.8	■ 305	0.20	1.2	–	–	–	◪ 285	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 275	0.20	1.2	■ 165	0.18	1.2	◪ 260	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM	**T7325**	0.4	◪ 195	0.15	1.6	■ 150	0.15	1.6	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	◪ 185	0.15	1.6	■ 110	0.14	1.6	◪ 175	0.15	1.6	◪ 555	0.18	1.6	–	–	–	–	–	–
	T8330	0.4	■ 170	0.15	1.6	■ 100	0.14	1.6	◪ 160	0.15	1.6	◪ 510	0.18	1.6	–	–	–	–	–	–
	T8430	0.4	■ 205	0.15	1.6	■ 110	0.14	1.6	◪ 170	0.15	1.6	◪ 570	0.18	1.6	–	–	–	–	–	–
	T9315	0.4	■ 280	0.15	1.6	–	–	–	◪ 265	0.15	1.6	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 250	0.15	1.6	■ 150	0.15	1.6	◪ 235	0.15	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM	**T7325**	0.8	◪ 215	0.20	1.6	■ 165	0.18	1.6	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪ 210	0.20	1.6	■ 160	0.18	1.6	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	◪ 200	0.20	1.6	■ 120	0.18	1.6	◪ 190	0.20	1.6	◪ 600	0.24	1.6	–	–	–	–	–	–
	T8330	0.8	■ 190	0.20	1.6	■ 110	0.18	1.6	◪ 180	0.20	1.6	◪ 570	0.24	1.6	–	–	–	–	–	–
	T8430	0.8	■ 220	0.20	1.6	■ 120	0.18	1.6	◪ 180	0.20	1.6	◪ 600	0.24	1.6	–	–	–	–	–	–
	T9315	0.8	■ 300	0.20	1.6	–	–	–	◪ 285	0.20	1.6	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 265	0.20	1.6	■ 155	0.18	1.6	◪ 250	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-FM	**T7325**	1.2	◪ 210	0.27	1.6	■ 160	0.24	1.6	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	1.2	■ 185	0.27	1.6	■ 110	0.24	1.6	◪ 175	0.27	1.6	◪ 555	0.32	1.6	–	–	–	–	–	–
	T8430	1.2	■ 200	0.27	1.6	■ 110	0.24	1.6	◪ 165	0.27	1.6	◪ 555	0.32	1.6	–	–	–	–	–	–
	T9315	1.2	■ 275	0.27	1.6	–	–	–	◪ 260	0.27	1.6	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 245	0.27	1.6	■ 145	0.24	1.6	◪ 230	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。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
FM2断屑槽，适用于精加工至中等加工，连续至断续切削。																				
SCMT 09T304E-FM2	**T7325**	0.4	200	0.12	1.0	155	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8430	0.4	220	0.12	1.0	120	0.11	1.0	180	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.4	265	0.12	1.0	155	0.11	1.0	250	0.12	1.0	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM2	**T8330**	0.8	190	0.17	1.0	110	0.15	1.0	180	0.17	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	225	0.17	1.0	120	0.15	1.0	185	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	305	0.17	1.0	–	–	–	285	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	270	0.17	1.0	160	0.15	1.0	255	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	235	0.17	1.0	140	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
RF断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SCMT 09T308E-RF	**T5315**	0.8	255	0.20	1.5	–	–	–	240	0.20	1.5	–	–	–	–	–	–	50	0.15	1.0
	T7335	0.8	170	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
	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	0.15	1.0
	T7335	0.8	160	0.22	2.2	120	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	205	0.22	2.2	120	0.22	2.2	190	0.22	2.2	–	–	–	–	–	–	–	–	–
																				
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SCMT 09T308E-RM	**T5315**	0.8	275	0.30	2.0	–	–	–	260	0.30	2.0	–	–	–	–	–	–	55	0.15	1.0
	T7335	0.8	190	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	60	0.24	1.6	–	–	–
	T8330	0.8	175	0.30	2.0	105	0.27	2.0	165	0.30	2.0	–	–	–	40	0.24	1.6	35	0.15	1.0
	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	1.0
	T9315	0.8	255	0.30	2.0	–	–	–	240	0.30	2.0	–	–	–	–	–	–	50	0.15	1.0
	T9325	0.8	230	0.30	2.0	135	0.27	2.0	215	0.30	2.0	–	–	–	50	0.24	1.6	–	–	–
SCMT 120408E-RM	**T5305**	0.8	305	0.30	2.3	–	–	–	285	0.30	2.3	–	–	–	–	–	–	60	0.15	1.0
	T5315	0.8	275	0.30	2.3	–	–	–	260	0.30	2.3	–	–	–	–	–	–	55	0.15	1.0
	T7335	0.8	185	0.30	2.3	140	0.27	2.3	–	–	–	–	–	–	60	0.24	1.8	–	–	–
	T8330	0.8	175	0.30	2.3	105	0.27	2.3	165	0.30	2.3	–	–	–	40	0.24	1.8	35	0.15	1.0
	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	1.0
	T9315	0.8	250	0.30	2.3	–	–	–	235	0.30	2.3	–	–	–	–	–	–	50	0.15	1.0
	T9325	0.8	225	0.30	2.3	135	0.27	2.3	210	0.30	2.3	–	–	–	50	0.24	1.8	–	–	–
																				
RM3断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SCMT 120408E-RM3	**T6310**	0.8	155	0.27	2.3	110	0.27	2.3	125	0.27	2.3	–	–	–	–	–	–	30	0.15	1.0
	T8330	0.8	155	0.27	2.3	90	0.27	2.3	145	0.27	2.3	–	–	–	–	–	–	30	0.15	1.0
	T8430	0.8	170	0.27	2.3	90	0.27	2.3	135	0.27	2.3	–	–	–	–	–	–	25	0.15	1.0
	T9315	0.8	225	0.27	2.3	–	–	–	210	0.27	2.3	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.8	205	0.27	2.3	120	0.27	2.3	190	0.27	2.3	–	–	–	–	–	–	–	–	–
	T9335	0.8	175	0.27	2.3	105	0.27	2.3	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120412E-RM3	**T7325**	1.2	175	0.30	2.3	135	0.27	2.3	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.2	205	0.30	2.3	120	0.27	2.3	190	0.30	2.3	–	–	–	–	–	–	–	–	–

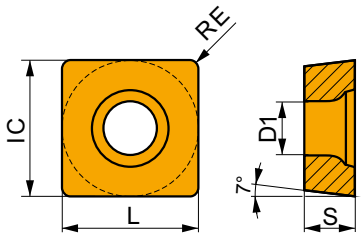
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
UR断屑槽，适用于精细的精加工，连续切削或轻微断续切削。																				
SCMT 09T304E-UR	**T7325**	0.4	◪ 175	0.15	1.2	◪ 135	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 155	0.15	1.2	◪ 90	0.14	1.2	■ 145	0.15	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 180	0.15	1.2	◪ 95	0.14	1.2	◪ 145	0.15	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 250	0.15	1.2	–	–	–	◪ 235	0.15	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 225	0.15	1.2	◪ 135	0.15	1.2	◪ 210	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR	**T5315**	0.8	◪ 280	0.20	1.2	–	–	–	■ 265	0.20	1.2	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪ 195	0.20	1.2	◪ 150	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 170	0.20	1.2	◪ 100	0.18	1.2	■ 160	0.20	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 190	0.20	1.2	◪ 105	0.18	1.2	◪ 155	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 260	0.20	1.2	–	–	–	◪ 245	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 235	0.20	1.2	◪ 140	0.18	1.2	◪ 220	0.20	1.2	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪ 185	0.20	1.6	◪ 140	0.18	1.6	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 165	0.20	1.6	◪ 95	0.18	1.6	■ 155	0.20	1.6	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 185	0.20	1.6	◪ 100	0.18	1.6	◪ 150	0.20	1.6	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 260	0.20	1.6	–	–	–	◪ 245	0.20	1.6	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 230	0.20	1.6	◪ 135	0.18	1.6	◪ 215	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-UR	**T8330**	1.2	■ 160	0.27	1.6	◪ 95	0.24	1.6	■ 150	0.27	1.6	–	–	–	–	–	–	–	–	–
	T8430	1.2	■ 175	0.27	1.6	◪ 95	0.24	1.6	◪ 140	0.27	1.6	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 215	0.27	1.6	◪ 125	0.24	1.6	◪ 200	0.27	1.6	–	–	–	–	–	–	–	–	–
																				
DR4断屑槽，适用于粗加工至重载粗加工，连续切削至断续切削。																				
SCMT 380932E-DR4	**T9335**	3.2	■ 50	1.33	16.0	◪ 30	1.20	16.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
OR断屑槽，适用于粗加工至重载加工，连续至断续切削。																				
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	–	–	–
	T9325	2.4	■ 90	1.00	10.0	■ 50	0.90	10.0	◪ 85	1.00	10.0	–	–	–	◪ 20	0.70	8.0	–	–	–
	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	–	–	–
	T9226	3.2	■ 65	1.20	18.0	■ 35	1.08	18.0	◪ 60	1.20	18.0	–	–	–	◪ 10	1.08	9.9	–	–	–
	T9315	3.2	■ 85	1.20	18.0	–	–	–	◪ 80	1.20	18.0	–	–	–	–	–	–	–	–	–
	T9325	3.2	■ 80	1.20	18.0	■ 45	1.08	18.0	◪ 75	1.20	18.0	–	–	–	◪ 15	1.08	9.9	–	–	–
	T9335	3.2	■ 60	1.20	18.0	■ 35	1.08	18.0	–	–	–	–	–	–	◪ 10	1.08	9.9	–	–	–
																				
SR断屑槽，适用于粗加工至重载粗加工，连续至断续切削。																				
SCMT 250924E-SR	**T9325**	2.4	■ 70	1.00	14.0	■ 40	0.90	14.0	◪ 65	1.00	14.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	■ 60	1.00	14.0	■ 35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 380932E-SR	**T9335**	3.2	■ 50	1.30	20.0	■ 30	1.30	20.0	–	–	–	–	–	–	–	–	–	–	–	–

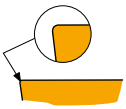
SCMW

PRAMET

	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



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

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
			E																	
适用于超精加工至中粗加工，连续至轻微断续切削。																				
SCMW 09T304	**T5305**	0.4	–	–	–	–	–	–	240	0.10	2.0	–	–	–	–	–	–	50	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	205	0.10	2.0	–	–	–	–	–	–	40	0.15	1.0
SCMW 09T308	**T5305**	0.8	–	–	–	–	–	–	220	0.20	2.0	–	–	–	–	–	–	45	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	190	0.20	2.0	–	–	–	–	–	–	40	0.15	1.0
SCMW 120408	**T5305**	0.8	–	–	–	–	–	–	205	0.20	4.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	185	0.20	4.0	–	–	–	–	–	–	35	0.15	1.0

SSBC(RL) EXT

P M K N S H

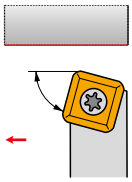
PRAMET

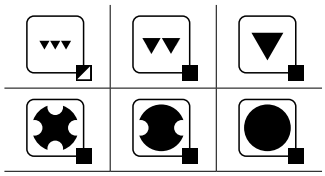
S

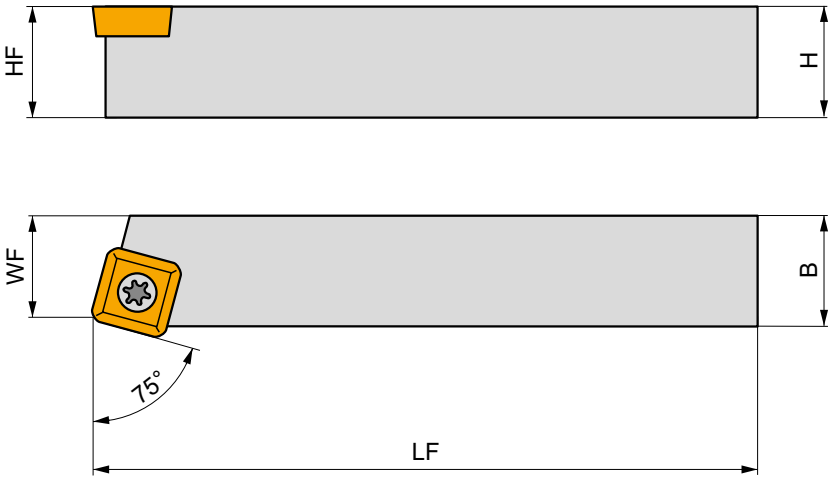


外圆用螺钉夹紧式车刀杆，使用SC..刀片，主偏角为75°

外圆用左/右手持式车刀杆，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。











	产品型号	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	0.47	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

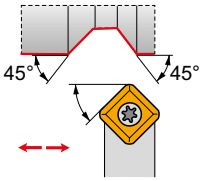
PRAMET

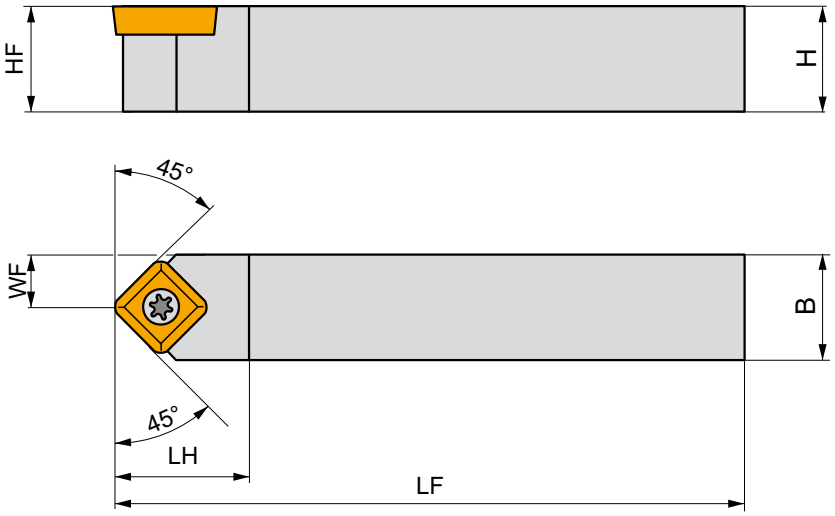
S

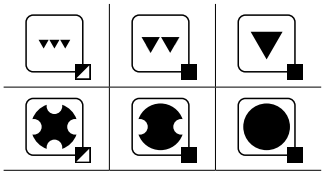


外圆用螺钉夹紧式车刀杆，使用SC..刀片，主偏角为45°

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	**SSDCN 1212 F 09**	12	12	12	6	80	–	0	0	0.12	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	0.42	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

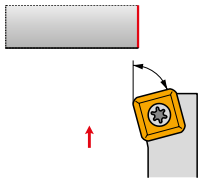
PRAMET

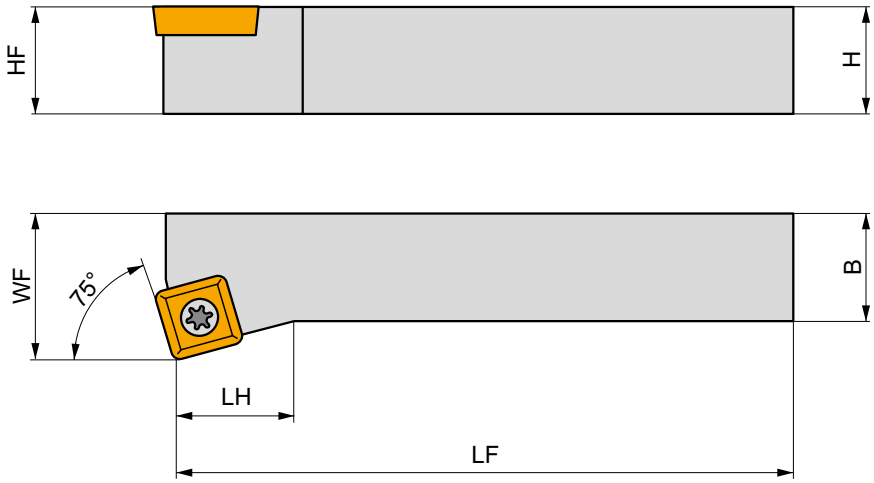
S

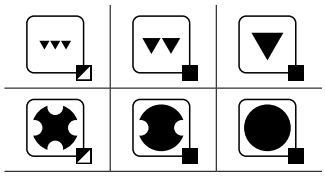


外圆用螺钉夹紧式车刀杆，使用SC..刀片，主偏角为75°（端面车削）

外圆用左/右手持式车刀杆，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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SSKCR 1212 F 09**	12	12	12	16	80	32	0	0	0.10	GI053	S08
	SSKCR 1616 H 09	16	16	16	20	100	32	0	0	0.25	GI053	S08
	SSKCR 2020 K 12-M-A	20	20	20	25	125	36	0	0	0.75	GI015	SS20
	SSKCR 2525 M 12-M-A	25	25	25	32	150	36	0	0	0.75	GI015	SS20
L	**SSKCL 1212 F 09**	12	12	12	16	80	32	0	0	0.10	GI053	S08
	SSKCL 1616 H 09	16	16	16	20	100	32	0	0	0.22	GI053	S08
	SSKCL 2020 K 12-M-A	20	20	20	25	125	36	0	0	0.45	GI015	SS20
	SSKCL 2525 M 12-M-A	25	25	25	32	150	36	0	0	0.80	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

KHS-SBC(RL)

P M K

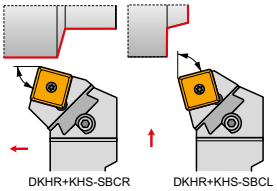
PRAMET

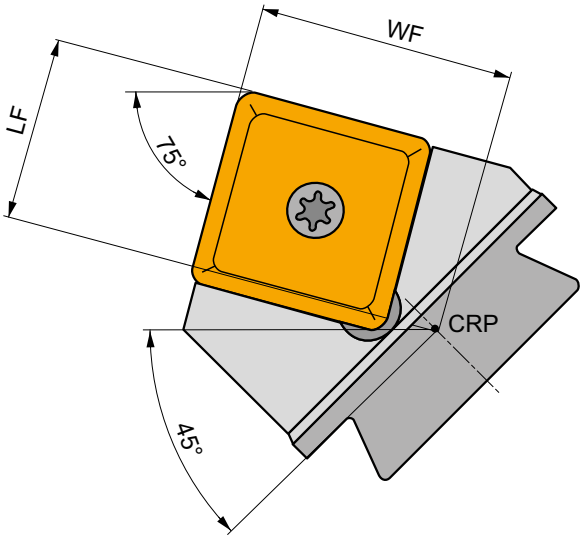
S

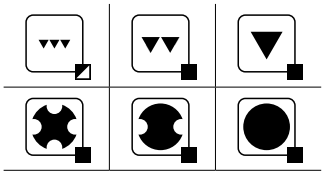


模块化KHS螺丝夹紧式车刀刀夹，使用SC..刀片，主偏角为75°。

燕尾形左/右手杠杆夹紧式车削车刀夹，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。









	产品型号	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	1.50	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

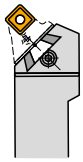
DKH(RL)

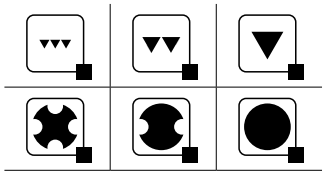
PRAMET

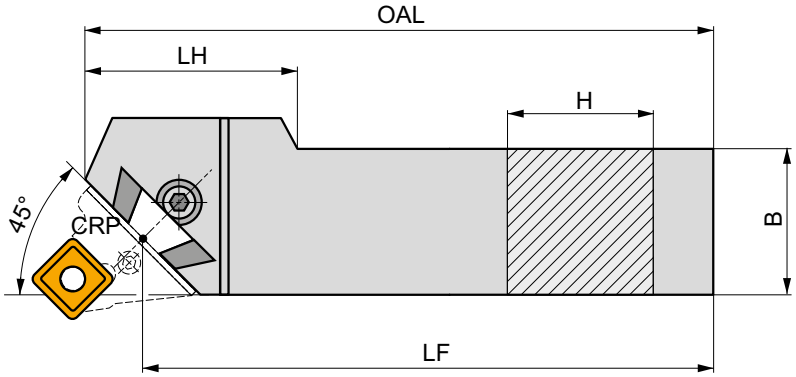


使用KHP/KHS重载车刀刀夹的外圆用刀柄

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。







	产品型号	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

SSSC(RL) INT

P M K N S H

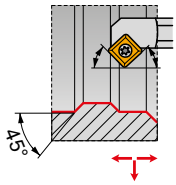
PRAMET

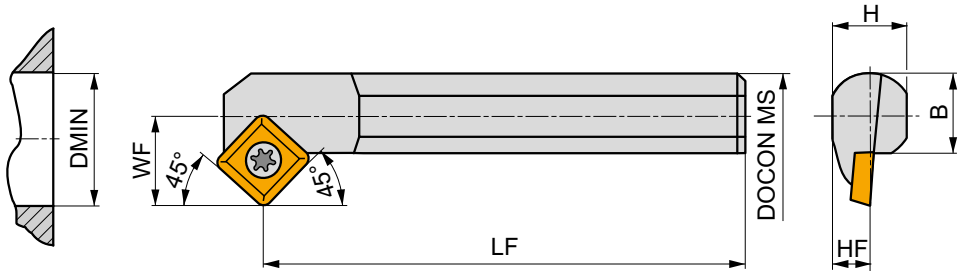
S

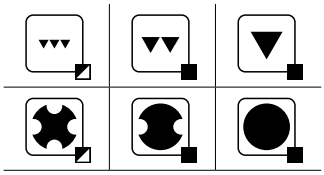


内孔用螺钉夹紧式镗杆，使用SC..刀片，主偏角为45°。

内孔用左/右手镗杆，螺钉锁紧式。使用SC..09刀片，主偏角为45°。内孔最小加工直径为Ø25mm的刀柄。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。可提供Ø20至Ø25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
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	1.15	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	1.11	GI053	S04

GI053	SC.. 09T3..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P

SP

09/ 12/ 15/ 19/ 25

硬质合金刀片

SPMR



146

SPUN



146

CER刀片

SPGN CER

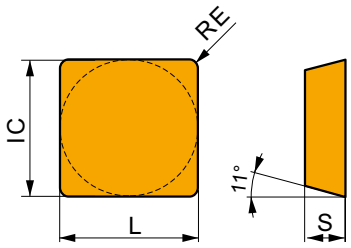


147

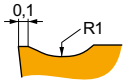
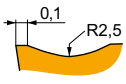
SPMR

PRAMET

	IC (mm)	L (mm)	S (mm)
0903	9.525	9.53	3.18
1203	12.700	12.70	3.18



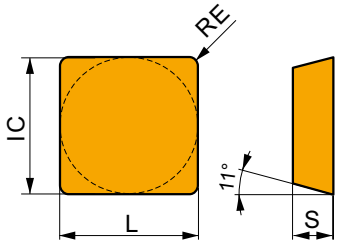
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
断屑槽46，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	–	–	–	–	–	–	–	–	–
																				
断屑槽48，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	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 205	0.22	2.2	◪ 120	0.22	2.2	◪ 190	0.22	2.2	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–

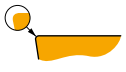
SPUN

PRAMET

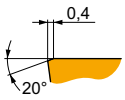
	IC (mm)	L (mm)	M (mm)	S (mm)
1203	12.700	12.70	2	3.18
1504	15.875	15.88	3	4.76
1904	19.050	19.05	3	4.76
2506	25.400	25.40	4	6.35



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。

产品型号		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)
																				
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	–	–	–	–	–	–	–	–	–

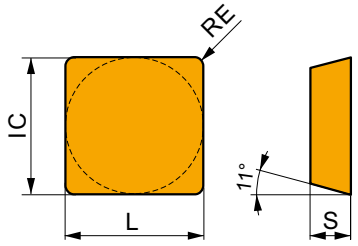
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
 			E																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
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	–	–	–	–	–	–	–	–	–
 			S																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
SPUN 250620S	6640	2.0	80	0.40	12.0	–	–	–	75	0.40	12.0	–	–	–	–	–	–	–	–	–

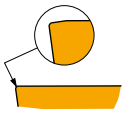
SPGN CER

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。

产品型号		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																	
			适用于高线速度连续切削。																	
SPGN 120308 T01020	TC100	0.8	–	–	–	–	–	–	530	0.20	1.5	–	–	–	–	–	–	–	–	–

TC

06/ 09/ 11/16

硬质合金刀片

TCGT



149

TCMT



150

TCMW



154

CBN刀片

TCGW CBN



154

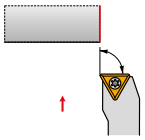
匹配正确的尺寸（示例）

刀片	刀杆
TCMT 110204E-FF2	STFCR 1616 H 11

ISO 外圆车削

STFC(RL) EXT

90° | TC..



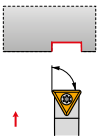
11
16

16×16
25×25

155 | 149 – 154

STFC(RL)-A EXT

90° | TC..



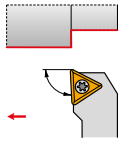
11

20×20

156 | 149 – 154

STJC(RL) EXT

93° | TC..



11
16

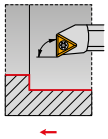
16×16
25×25

157 | 149 – 154

ISO内孔车削

STFC(RL) INT

90° | TC..



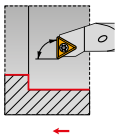
06
09
11
16

8,5
40

158 | 149 – 154

STFC(RL)-E INT

90° | TC..



06
09
11

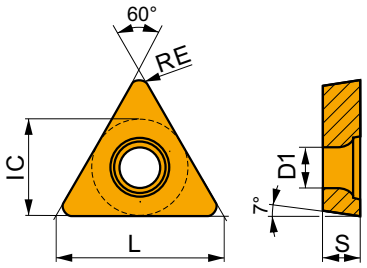
8,5
20

160 | 149 – 154

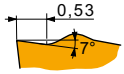
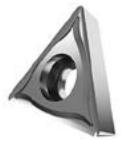
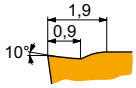
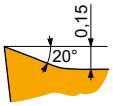
TCGT

PRAMET

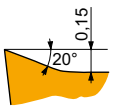
	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
1102-SF3	6.350	2.80	11.00	2.58
16T3	9.525	4.40	16.50	3.97
16T3-SF3	9.525	4.40	16.50	4.22



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

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
AL断屑槽，具有大正前角设计，适用于精加工至粗加工，连续切削至轻微断续切削。																				
TCGT 090202F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	■ 375	0.12	1.0	–	–	–	–	–	–
	T0315	0.2	–	–	–	–	–	–	–	–	–	■ 555	0.12	1.0	–	–	–	–	–	–
TCGT 090204F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	■ 300	0.24	1.0	–	–	–	–	–	–
	T0315	0.4	–	–	–	–	–	–	–	–	–	■ 450	0.24	1.0	–	–	–	–	–	–
TCGT 110202F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	■ 360	0.12	1.5	–	–	–	–	–	–
	T0315	0.2	–	–	–	–	–	–	–	–	–	■ 525	0.12	1.5	–	–	–	–	–	–
TCGT 110204F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	■ 285	0.24	1.5	–	–	–	–	–	–
	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	–	–	–	–	–	–
	T0315	0.4	–	–	–	–	–	–	–	–	–	■ 405	0.24	2.4	–	–	–	–	–	–
TCGT 16T308F-AL	**HF7**	0.8	–	–	–	–	–	–	–	–	–	■ 255	0.48	2.4	–	–	–	–	–	–
	T0315	0.8	–	–	–	–	–	–	–	–	–	■ 360	0.48	2.4	–	–	–	–	–	–
																				
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
TCGT 06T102E-FF2	**T8330**	0.2	■ 175	0.05	0.8	–	–	–	■ 165	0.05	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.2	■ 235	0.05	0.8	–	–	–	◪ 190	0.05	0.8	–	–	–	–	–	–	–	–	–
	TT010	0.2	■ 295	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCGT 090202E-FF2	**TT010**	0.2	■ 295	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
NF1断屑槽，具有正前角设计，适用于超精加工至中度加工，连续切削。																				
TCGT 110204E-NF1	**H07**	0.4	–	–	–	◪ 80	0.09	0.8	–	–	–	◪ 415	0.12	0.8	■ 40	0.08	0.6	–	–	–
	T6310	0.4	■ 155	0.10	0.8	■ 110	0.09	0.8	–	–	–	◪ 465	0.12	0.8	■ 45	0.08	0.6	◪ 30	0.15	1.0
	T7325	0.4	◪ 180	0.10	0.8	■ 140	0.09	0.8	–	–	–	–	–	–	■ 55	0.08	0.6	–	–	–
																				
SF3断屑槽，具有大正前角设计，适用于精细的精加工，连续切削。																				
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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0

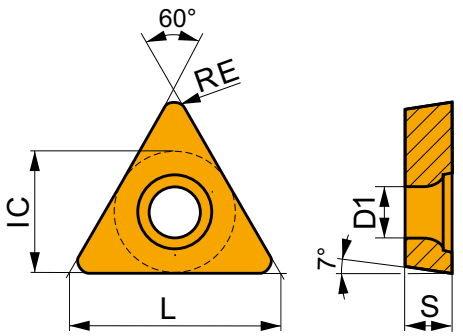
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
SF3断屑槽，具有大正前角设计，适用于精细的精加工，连续切削。																				
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	0.15	1.0
																				
ER-SI断屑槽，具有正前角设计，右手设计，适用于超精加工，连续切削。																				
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	–	–	–
	T8330	0.2	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
	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	**T8330**	0.4	180	0.12	0.8	105	0.11	0.8	170	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
	T8430	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
																				
EL-SI断屑槽，具有正前角，左手设计，适用于超精加工，连续切削。																				
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	–	–	–
	T8330	0.2	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
	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	–	–	–
	T8330	0.4	180	0.12	0.8	105	0.11	0.8	170	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
	T8430	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–

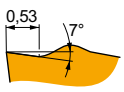
TCMT

PRAMET

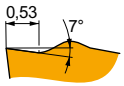
	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



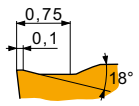
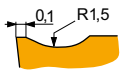
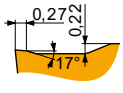
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	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)
																				
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
TCMT 06T102E-FF2	**T8330**	0.2	175	0.05	0.8	–	–	–	165	0.05	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.2	235	0.05	0.8	–	–	–	190	0.05	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.2	335	0.05	0.8	–	–	–	315	0.05	0.8	–	–	–	–	–	–	–	–	–

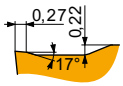
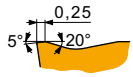
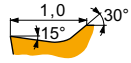
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
TCMT 06T104E-FF2	**T7325**	0.4	170	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	145	0.12	0.8	–	–	–	135	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	180	0.12	0.8	–	–	–	145	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	245	0.12	0.8	–	–	–	230	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	220	0.12	0.8	–	–	–	205	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2	**T5315**	0.4	240	0.12	1.0	–	–	–	225	0.12	1.0	–	–	–	–	–	–	–	–	–
	T7325	0.4	165	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	140	0.12	1.0	–	–	–	130	0.12	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.4	175	0.12	1.0	–	–	–	140	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.4	240	0.12	1.0	–	–	–	225	0.12	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.4	215	0.12	1.0	–	–	–	200	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2	**T7325**	0.4	170	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	145	0.12	0.8	–	–	–	135	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	180	0.12	0.8	–	–	–	145	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	245	0.12	0.8	–	–	–	230	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	220	0.12	0.8	–	–	–	205	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9335	0.4	185	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110208E-FF2	**T7325**	0.8	180	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	155	0.17	0.8	–	–	–	145	0.17	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.8	185	0.17	0.8	–	–	–	150	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.8	250	0.17	0.8	–	–	–	235	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	225	0.17	0.8	–	–	–	210	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2	**T7325**	0.4	170	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	145	0.12	0.8	–	–	–	135	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	180	0.12	0.8	–	–	–	145	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	245	0.12	0.8	–	–	–	230	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	220	0.12	0.8	–	–	–	205	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9335	0.4	185	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	TT010	0.4	295	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2	**T7325**	0.8	180	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	155	0.17	0.8	–	–	–	145	0.17	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.8	185	0.17	0.8	–	–	–	150	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.8	250	0.17	0.8	–	–	–	235	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	225	0.17	0.8	–	–	–	210	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9335	0.8	195	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
TCMT 110202E-FM	**T7325**	0.2	185	0.10	0.8	140	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.2	185	0.10	0.8	140	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.2	170	0.10	0.8	100	0.09	0.8	160	0.10	0.8	510	0.12	0.8	–	–	–	–	–	–
	T8330	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	480	0.12	0.8	–	–	–	–	–	–
	T8430	0.2	195	0.10	0.8	105	0.09	0.8	160	0.10	0.8	540	0.12	0.8	–	–	–	–	–	–
	T9315	0.2	270	0.10	0.8	–	–	–	255	0.10	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.2	245	0.10	0.8	145	0.09	0.8	230	0.10	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM	**T7325**	0.4	160	0.19	0.8	120	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	155	0.19	0.8	120	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	170	0.12	0.8	100	0.11	0.8	160	0.12	0.8	510	0.14	0.8	–	–	–	–	–	–
	T8330	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	–	–	–	–	–	–
	T8430	0.4	195	0.12	0.8	105	0.11	0.8	160	0.12	0.8	540	0.14	0.8	–	–	–	–	–	–
	T9315	0.4	270	0.12	0.8	–	–	–	255	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	205	0.18	0.8	120	0.16	0.8	190	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。

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		
																				
FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
TCMT 110208E-FM	**T7325**	0.8	195	0.17	0.8	150	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	175	0.17	0.8	105	0.15	0.8	165	0.17	0.8	525	0.20	0.8	–	–	–	–	–	–
	T8430	0.8	200	0.17	0.8	110	0.15	0.8	165	0.17	0.8	555	0.20	0.8	–	–	–	–	–	–
	T9315	0.8	275	0.17	0.8	–	–	–	260	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	250	0.17	0.8	150	0.15	0.8	235	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM	**T7325**	0.4	150	0.19	1.7	115	0.17	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	145	0.19	1.7	110	0.17	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	155	0.12	1.7	90	0.11	1.7	145	0.12	1.7	465	0.14	1.7	–	–	–	–	–	–
	T8330	0.4	150	0.12	1.7	90	0.11	1.7	140	0.12	1.7	450	0.14	1.7	–	–	–	–	–	–
	T8430	0.4	180	0.12	1.7	95	0.11	1.7	145	0.12	1.7	495	0.14	1.7	–	–	–	–	–	–
	T9315	0.4	250	0.12	1.7	–	–	–	235	0.12	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	190	0.18	1.7	110	0.16	1.7	180	0.18	1.7	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM	**T7325**	0.8	180	0.17	1.7	140	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	175	0.17	1.7	135	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	170	0.17	1.7	100	0.15	1.7	160	0.17	1.7	510	0.20	1.7	–	–	–	–	–	–
	T8330	0.8	160	0.17	1.7	95	0.15	1.7	150	0.17	1.7	480	0.20	1.7	–	–	–	–	–	–
	T8430	0.8	185	0.17	1.7	100	0.15	1.7	150	0.17	1.7	510	0.20	1.7	–	–	–	–	–	–
	T9315	0.8	255	0.17	1.7	–	–	–	240	0.17	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	230	0.17	1.7	135	0.15	1.7	215	0.17	1.7	–	–	–	–	–	–	–	–	–
																				
FM2断屑槽，适用于精加工至中等加工，连续至断续切削。																				
TCMT 110204E-FM2	**T8330**	0.4	145	0.12	0.8	85	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	180	0.12	0.8	95	0.11	0.8	145	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	220	0.12	0.8	130	0.11	0.8	205	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM2	**T8330**	0.8	155	0.17	0.8	90	0.15	0.8	145	0.17	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.8	185	0.17	0.8	100	0.15	0.8	150	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	225	0.17	0.8	135	0.15	0.8	210	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9335	0.8	195	0.17	0.8	115	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2	**T7325**	0.8	170	0.20	1.0	130	0.18	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	145	0.20	1.0	85	0.18	1.0	135	0.20	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	170	0.20	1.0	90	0.18	1.0	135	0.20	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	205	0.20	1.0	120	0.18	1.0	190	0.20	1.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	175	0.20	1.0	105	0.18	1.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
RF断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
TCMT 16T308E-RF	**T9325**	0.8	175	0.20	1.5	105	0.18	1.5	165	0.20	1.5	–	–	–	–	–	–	–	–	–
																				
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
TCMT 16T308E-RM	**T5305**	0.8	265	0.27	1.9	–	–	–	250	0.27	1.9	–	–	–	–	–	–	50	0.15	1.0
	T5315	0.8	235	0.27	1.9	–	–	–	220	0.27	1.9	–	–	–	–	–	–	45	0.15	1.0
	T7335	0.8	155	0.27	1.9	120	0.24	1.9	–	–	–	–	–	–	50	0.19	1.5	–	–	–
	T8330	0.8	145	0.27	1.9	85	0.24	1.9	135	0.27	1.9	–	–	–	35	0.19	1.5	25	0.15	1.0
	T8430	0.8	165	0.27	1.9	90	0.24	1.9	135	0.27	1.9	–	–	–	35	0.19	1.5	25	0.15	1.0
	T9315	0.8	215	0.27	1.9	–	–	–	200	0.27	1.9	–	–	–	–	–	–	40	0.15	1.0
	T9325	0.8	195	0.27	1.9	115	0.24	1.9	185	0.27	1.9	–	–	–	40	0.19	1.5	–	–	–

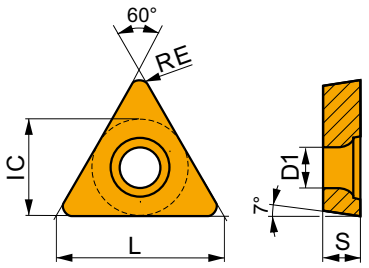
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
			RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
TCMT 16T312E-RM	**T5305**	1.2	280	0.27	1.9	–	–	–	265	0.27	1.9	–	–	–	–	–	–	55	0.15	1.0
	T5315	1.2	250	0.27	1.9	–	–	–	235	0.27	1.9	–	–	–	–	–	–	50	0.15	1.0
	T8330	1.2	150	0.27	1.9	90	0.24	1.9	140	0.27	1.9	–	–	–	35	0.19	1.5	30	0.15	1.0
	T8430	1.2	170	0.27	1.9	90	0.24	1.9	135	0.27	1.9	–	–	–	35	0.19	1.5	25	0.15	1.0
	T9315	1.2	225	0.27	1.9	–	–	–	210	0.27	1.9	–	–	–	–	–	–	45	0.15	1.0
	T9325	1.2	205	0.27	1.9	120	0.24	1.9	190	0.27	1.9	–	–	–	45	0.19	1.5	–	–	–
																				
			RM3断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
TCMT 16T304E-RM3	**T6310**	0.4	110	0.25	2.0	75	0.25	2.0	85	0.25	2.0	–	–	–	–	–	–	20	0.15	1.0
	T7325	0.4	125	0.25	2.0	95	0.25	2.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	110	0.25	2.0	65	0.25	2.0	100	0.25	2.0	–	–	–	–	–	–	20	0.15	1.0
	T8430	0.4	120	0.25	2.0	65	0.25	2.0	95	0.25	2.0	–	–	–	–	–	–	20	0.15	1.0
	T9315	0.4	165	0.25	2.0	–	–	–	155	0.25	2.0	–	–	–	–	–	–	30	0.15	1.0
	T9325	0.4	145	0.25	2.0	85	0.25	2.0	135	0.25	2.0	–	–	–	–	–	–	–	–	–
	T9335	0.4	125	0.25	2.0	75	0.25	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-RM3	**T6310**	0.8	125	0.27	2.0	90	0.27	2.0	100	0.27	2.0	–	–	–	–	–	–	25	0.15	1.0
	T7325	0.8	145	0.27	2.0	110	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	125	0.27	2.0	75	0.27	2.0	115	0.27	2.0	–	–	–	–	–	–	25	0.15	1.0
	T8430	0.8	135	0.27	2.0	75	0.27	2.0	110	0.27	2.0	–	–	–	–	–	–	20	0.15	1.0
	T9315	0.8	185	0.27	2.0	–	–	–	175	0.27	2.0	–	–	–	–	–	–	35	0.15	1.0
	T9325	0.8	170	0.27	2.0	100	0.27	2.0	160	0.27	2.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	145	0.27	2.0	85	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
			UR断屑槽，适用于精细的精加工，连续切削或轻微断续切削。																	
TCMT 110204E-UR	**T7325**	0.4	135	0.19	0.8	105	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	235	0.12	0.8	–	–	–	220	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	175	0.18	0.8	105	0.16	0.8	165	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR	**T7325**	0.4	135	0.19	0.8	105	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	235	0.12	0.8	–	–	–	220	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	175	0.18	0.8	105	0.16	0.8	165	0.18	0.8	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.8	170	0.17	0.8	130	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	150	0.17	0.8	90	0.15	0.8	140	0.17	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.8	240	0.17	0.8	–	–	–	225	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	–	–	–	–	–	–	–	–	–

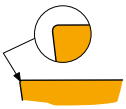
TCMW

PRAMET

	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



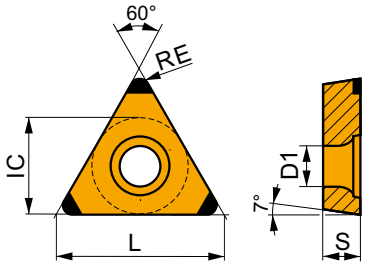
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
			E																	
适用于超精加工至中粗加工，连续至轻微断续切削。																				
TCMW 110204	**T5305**	0.4	–	–	–	–	–	–	200	0.10	1.2	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	180	0.10	1.2	–	–	–	–	–	–	35	0.15	1.0
TCMW 16T304	**T5305**	0.4	–	–	–	–	–	–	195	0.10	1.5	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	175	0.10	1.5	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.4	–	–	–	–	–	–	85	0.10	1.5	–	–	–	–	–	–	20	0.15	1.0
TCMW 16T308	**T5305**	0.8	–	–	–	–	–	–	190	0.18	1.5	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	165	0.18	1.5	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	85	0.18	1.5	–	–	–	–	–	–	20	0.15	1.0

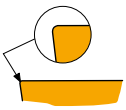
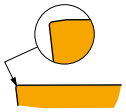
TCGW CBN

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。

产品型号		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																
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	0.15	1.0
			HSC	S																
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	0.15	1.0
TCGW 110208S01020C	**TB310**	0.8	–	–	–	–	–	–	400	0.15	0.6	–	–	–	105	0.11	0.5	85	0.15	1.0

STFC(RL) EXT

P M K N S H

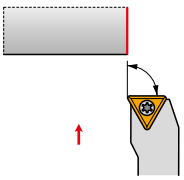
PRAMET

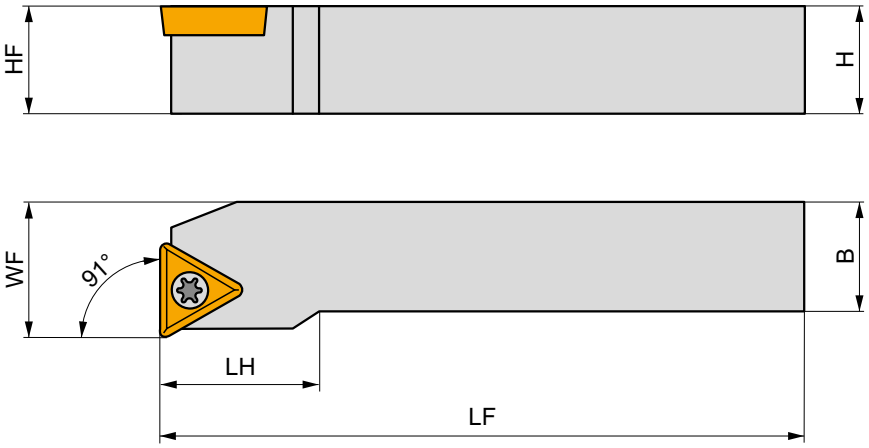
S

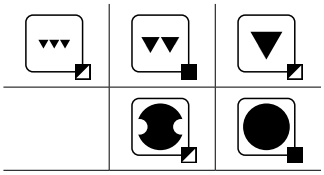


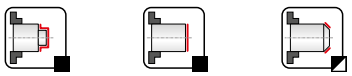
外圆用螺钉夹紧式车刀杆，使用TC..刀片，主偏角为91°（端面车削）。

外圆用左/右手持式车刀杆，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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**STFCR 1616 H 11**	16	16	16	20	100	18	0	0	0.20	GI056	S01
	STFCR 2020 K 16-M-A	20	20	20	25	125	25	0	0	0.40	GI016	ST10
	STFCR 2525 M 16-M-A	25	25	25	32	150	25	0	0	0.76	GI016	ST10
L	**STFCL 1616 H 11**	16	16	16	20	100	18	0	0	0.22	GI056	S01
	STFCL 2020 K 16-M-A	20	20	20	25	125	25	0	0	0.40	GI016	ST10
	STFCL 2525 M 16-M-A	25	25	25	32	150	25	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

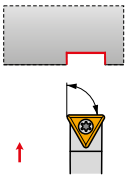
PRAMET

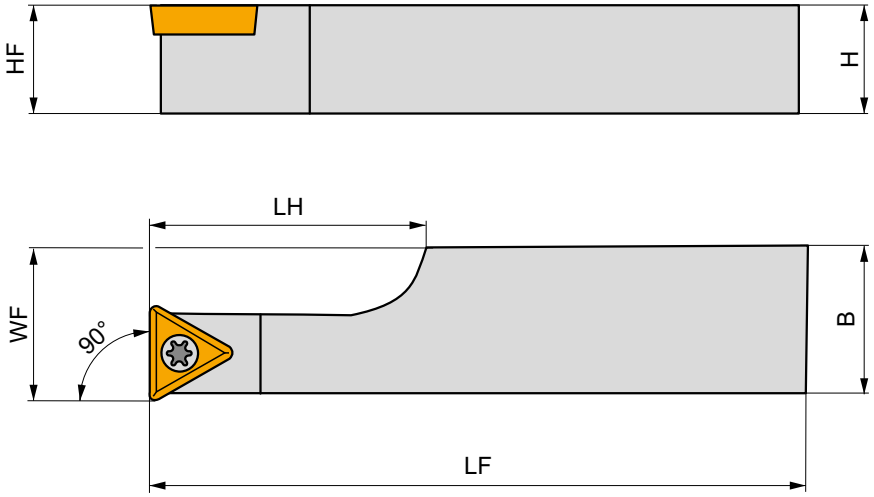
S

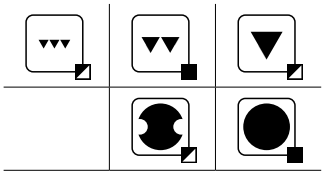


外圆用螺钉夹紧式车刀杆，使用TC..刀片，主偏角为90°（端面车削）。

外圆用左/右手持式车刀杆，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。









	产品型号	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	0.52	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

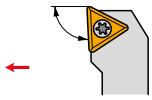
S

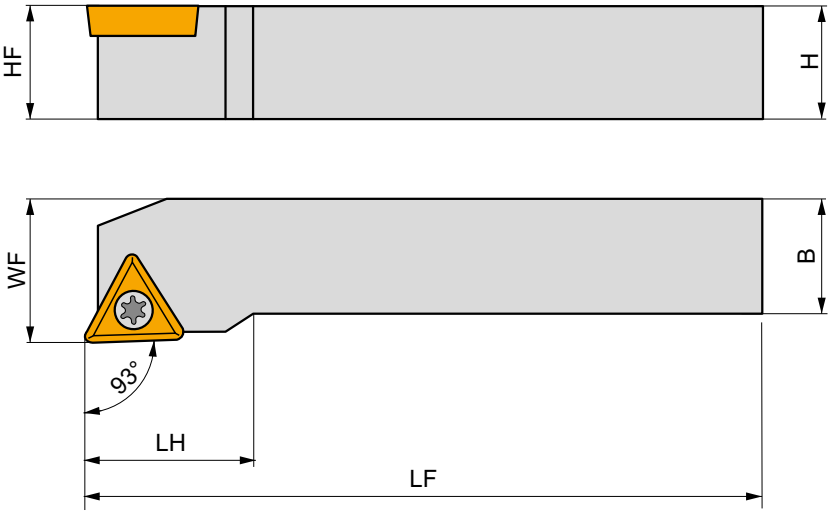


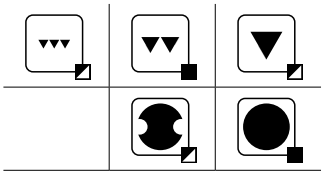
外圆用螺钉夹紧式车刀杆，使用TC..刀片，主偏角为93°。

外圆用左/右手持式车刀杆，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。











	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**STJCR 1616 H 11**	16	16	16	20	100	18	0	0	0.23	GI056	S01
	STJCR 2020 K 16-M-A	20	20	20	25	125	25	0	0	0.44	GI016	ST10
	STJCR 2525 M 16-M-A	25	25	25	32	150	25	0	0	0.76	GI016	ST10
L	**STJCL 1616 H 11**	16	16	16	20	100	18	0	0	0.22	GI056	S01
	STJCL 2020 K 16-M-A	20	20	20	25	125	25	0	0	0.43	GI016	ST10
	STJCL 2525 M 16-M-A	25	25	25	32	150	25	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

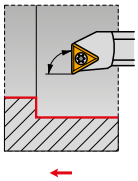
PRAMET

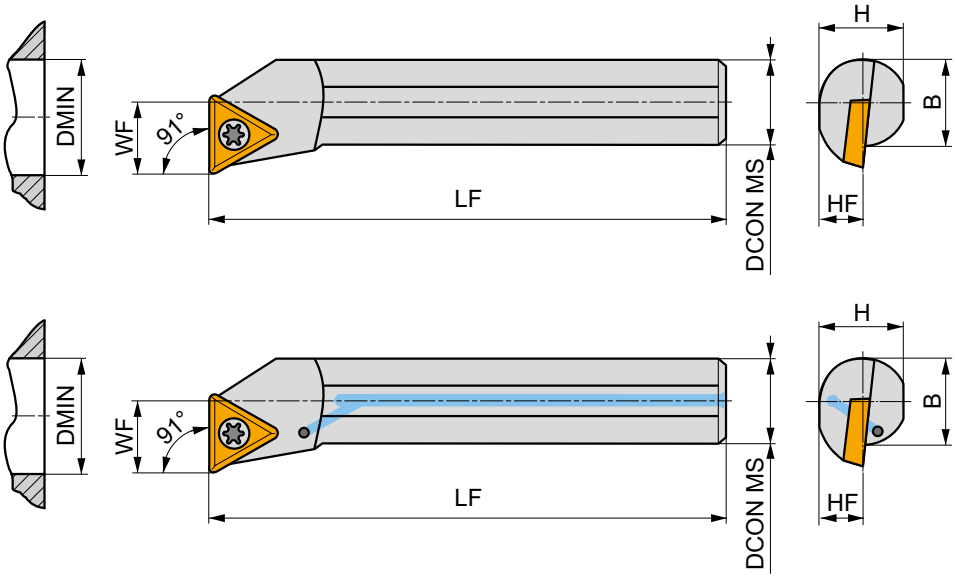
S

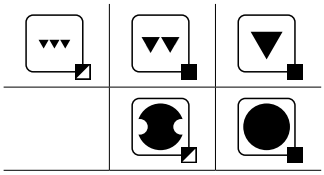


内孔用螺钉夹紧式镗杆，使用TC..刀片，主偏角为91°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为91°，使用TC..06至16刀片。内孔最小加工直径为Ø8.5mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø6至Ø32mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	✓	0.03	GI217	ST12
	A08H-STFCR 06	8	11	5.9	7	–	100	-10	0	✓	0.04	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	✓	0.27	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	✓	0.54	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	✓	0.67	GI016	S08
	S25T-STFCR 16	25	32	17	23	23	300	-3	0	–	1.15	GI016	S08
	A32S-STFCR 16	32	40	22	30	30	250	-10	0	✓	1.36	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	–	0.25	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

	产品型号	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	–	1.15	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

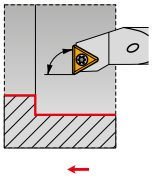
PRAMET

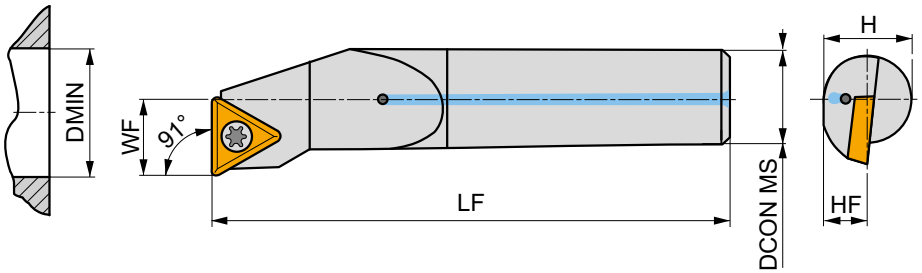
S

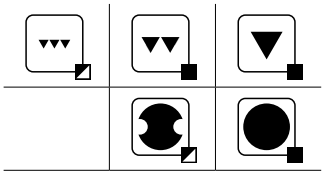


内孔用螺钉夹紧式硬质合金镗杆，使用TC..刀片，主偏角为91°。

内孔用左/右手硬质合金镗杆，有内冷通道，螺钉锁紧式。主偏角为91°，使用TC..06至11刀片。内孔最小加工直径为Ø8.5mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø6至Ø16mm的刀柄尺寸。刀具悬伸>3xD。









	产品型号	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

TP

09/ 11/ 16

硬质合金刀片

TPGX



162

TPMR



163

TPUN



164

CER刀片

TPGN CER

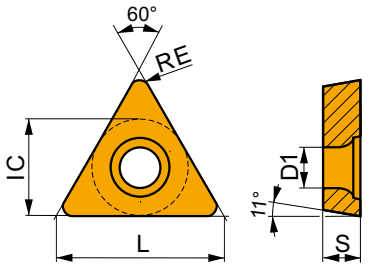


164

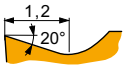
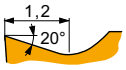
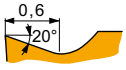
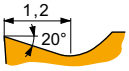
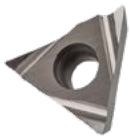
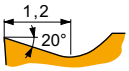
TPGX

PRAMET

	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



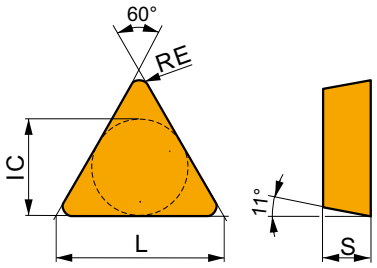
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
			FR-JQ断屑槽，具有正前角，右手设计，适用于超精加工，连续切削。																	
TPGX 110204FR-JQ	**TT010**	0.4	■ 295	0.06	0.5	◪ 175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
			FL-JQ断屑槽，具有正前角，左手设计，适用于超精加工，连续切削。																	
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	–	–	–	–	–	–	–	–	–	–	–	–
																				
			FL-JR断屑槽，具有正前角，左手设计，适用于超精加工，连续切削。																	
TPGX 16T304FL-JR	**TT010**	0.4	■ 295	0.06	0.5	◪ 175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
			FR-JZ断屑槽，具有正前角，右手设计，适用于超精加工，连续切削。																	
TPGX 090202FR-JZ	**TT010**	0.2	■ 280	0.06	0.5	◪ 165	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
			FL-JZ断屑槽，具有正前角，左手设计，适用于超精加工，连续切削。																	
TPGX 090202FL-JZ	**TT010**	0.2	■ 280	0.06	0.5	◪ 165	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

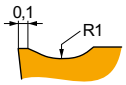
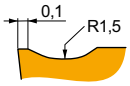
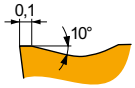
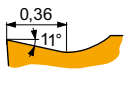
TPMR

PRAMET

	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



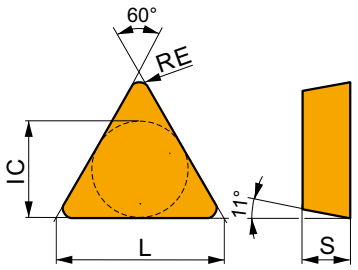
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
断屑槽46，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	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 175	0.15	1.0	◪ 105	0.15	1.0	◪ 165	0.15	1.0	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 205	0.15	1.0	◪ 120	0.15	1.0	◪ 190	0.15	1.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 180	0.15	1.0	◪ 105	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
断屑槽47，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	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 150	0.20	1.5	◪ 90	0.18	1.5	◪ 140	0.20	1.5	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 175	0.20	1.5	◪ 105	0.18	1.5	◪ 165	0.20	1.5	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 160	0.20	1.5	◪ 95	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
断屑槽61，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	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 120	0.35	1.8	◪ 70	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–
																				
PF2断屑槽，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	–	–	–	–	–	–	–	–	–	–	–	–

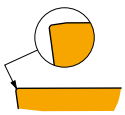
TPUN

PRAMET

	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18
2204	12.700	22.00	4.76
2706	15.875	27.50	6.35
3306	19.050	33.00	6.35



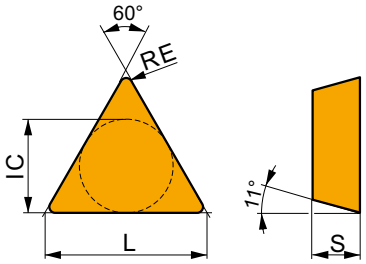
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc	M f	M ap	K vc	K f	K ap	N vc	N f	N ap	S vc	S f	S ap	H vc	H f	H ap
			E																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
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	–	–	–	–	–	–	–	–	–
			S																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
TPUN 270616S	**6640**	1.6	60	0.30	7.0	–	–	–	55	0.30	7.0	–	–	–	–	–	–	–	–	–
TPUN 330620S	**6640**	2.0	65	0.30	5.0	–	–	–	60	0.30	5.0	–	–	–	–	–	–	–	–	–

TPGN CER

PRAMET

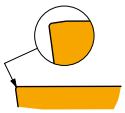
	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



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。

产品型号		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc	M f	M ap	K vc	K f	K ap	N vc	N f	N ap	S vc	S f	S ap	H vc	H f	H ap
			HSC		T															
			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	–	–	–	–	–	–	–	–	–

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

产品型号		RE (mm)	P vc (m/min)	P f (mm/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															
			适用于高线速度连续切削。																	
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	–	–	–	–	–	–	–	–	–

VB

硬质合金刀片

VBMT



168

CBN刀片

VBGW CBN



171

匹配正确的尺寸（示例）

刀片	刀杆
VBMT 160408E-FM	SVHCR 2020 K 16-M-A

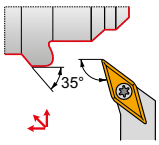
ISO 外圆车削

SVHB(C)(RL) EXT

107°30´

VB, VC..

11
16



16×16
25×25

172

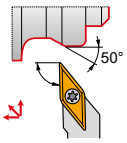
168 – 171
186 – 192

SVJB(C)(RL) EXT

93°

VB, VC..

11
13
16



12×12
32×25

173

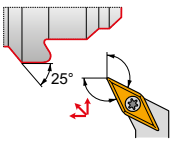
168 – 171
186 – 192

SVPB(C)(RL) EXT

117°30´

VB, VC..

11
16



16×16
32×25

174

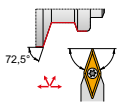
168 – 171
186 – 192

SVVB(C)N EXT

72°30´

VB, VC..

11
13
16



12×12
32×25

175

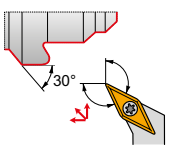
168 – 171
186 – 192

SVXB(C)(RL) EXT

98°

VB, VC..

11
13
16



12×12
32×25

176

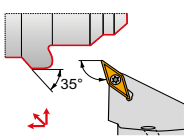
168 – 171
186 – 192

C.-SVHB(RL) EXT NEW

107°30´

VB, VC..

16



C4
C6

177

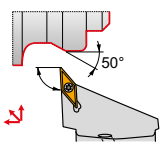
168 – 171
186 – 192

C.-SVJB(RL) EXT NEW

93°

VB, VC..

11
16



C3
C6

178

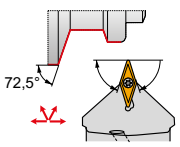
168 – 171
186 – 192

C.-SVVBN EXT NEW

72°30´

VB, VC..

16



C4
C6

179

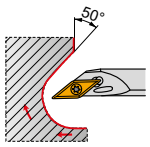
168 – 171
186 – 192

VB

ISO内孔车削

SVJB(RL) INT

93°





25 / 32

VB, VC..



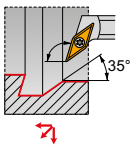
11

180

168 – 171
186 – 192

SVQB(C)(RL) INT

107°30´





20 / 50

VB, VC..



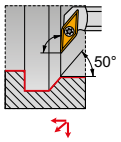
11
13
16

181

168 – 171
186 – 192

SVUB(C)(RL) INT

93°





20 / 50

VB, VC..



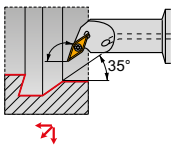
11
13
16

182

168 – 171
186 – 192

C.-SVQB(C)(RL) INT NEW

108°





33

VB, VC..



16

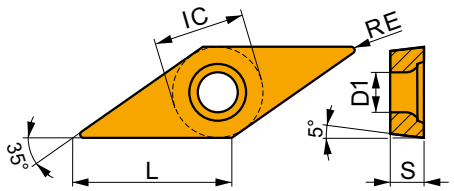
183

168 – 171
186 – 192

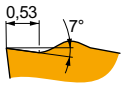
VBMT

PRAMET

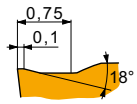
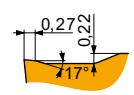
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.10	2.38
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



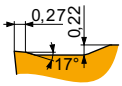
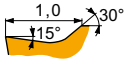
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
VBMT 160404E-FF2	**T7325**	0.4	◪ 145	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 125	0.12	0.8	–	–	–	■ 115	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 150	0.12	0.8	–	–	–	◪ 125	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 215	0.12	0.8	–	–	–	◪ 200	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 190	0.12	0.8	–	–	–	◪ 180	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
VBMT 110302E-FM	**T7325**	0.2	◪ 160	0.10	0.8	■ 120	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.2	◪ 145	0.10	0.8	■ 85	0.09	0.8	◪ 135	0.10	0.8	◪ 435	0.12	0.8	–	–	–	–	–	–
	T8330	0.2	■ 135	0.10	0.8	■ 80	0.09	0.8	◪ 125	0.10	0.8	◪ 405	0.12	0.8	–	–	–	–	–	–
	T8430	0.2	■ 170	0.10	0.8	■ 90	0.09	0.8	◪ 135	0.10	0.8	◪ 465	0.12	0.8	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	◪ 135	0.19	0.8	■ 105	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	◪ 145	0.12	0.8	■ 85	0.11	0.8	◪ 135	0.12	0.8	◪ 435	0.14	0.8	–	–	–	–	–	–
	T8330	0.4	■ 140	0.12	0.8	■ 80	0.11	0.8	◪ 130	0.12	0.8	◪ 420	0.14	0.8	–	–	–	–	–	–
	T8430	0.4	■ 170	0.12	0.8	■ 90	0.11	0.8	◪ 135	0.12	0.8	◪ 465	0.14	0.8	–	–	–	–	–	–
	T9315	0.4	■ 235	0.12	0.8	–	–	–	◪ 220	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 175	0.19	0.8	■ 105	0.17	0.8	◪ 165	0.19	0.8	–	–	–	–	–	–	–	–	–
VBMT 110308E-FM	**T7325**	0.8	◪ 170	0.17	0.8	■ 130	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 150	0.17	0.8	■ 90	0.15	0.8	◪ 140	0.17	0.8	◪ 450	0.20	0.8	–	–	–	–	–	–
	T8430	0.8	■ 175	0.17	0.8	■ 95	0.15	0.8	◪ 140	0.17	0.8	◪ 480	0.20	0.8	–	–	–	–	–	–
	T9315	0.8	■ 240	0.17	0.8	–	–	–	◪ 225	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 215	0.17	0.8	■ 125	0.15	0.8	◪ 200	0.17	0.8	–	–	–	–	–	–	–	–	–
VBMT 160402E-FM	**T7325**	0.2	◪ 150	0.10	1.2	■ 115	0.09	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.2	■ 130	0.10	1.2	■ 75	0.09	1.2	◪ 120	0.10	1.2	◪ 390	0.12	1.2	–	–	–	–	–	–
	T8430	0.2	■ 165	0.10	1.2	■ 90	0.09	1.2	◪ 135	0.10	1.2	◪ 450	0.12	1.2	–	–	–	–	–	–
	T9315	0.2	■ 230	0.10	1.2	–	–	–	◪ 215	0.10	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.2	■ 205	0.10	1.2	■ 120	0.09	1.2	◪ 190	0.10	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM	**T5315**	0.4	◪ 225	0.12	1.2	–	–	–	◪ 210	0.12	1.2	–	–	–	–	–	–	–	–	–
	T7325	0.4	◪ 130	0.19	1.2	■ 100	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	◪ 130	0.19	1.2	■ 100	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	◪ 140	0.12	1.2	■ 80	0.11	1.2	◪ 130	0.12	1.2	◪ 420	0.14	1.2	–	–	–	–	–	–
	T8330	0.4	■ 135	0.12	1.2	■ 80	0.11	1.2	◪ 125	0.12	1.2	◪ 405	0.14	1.2	–	–	–	–	–	–
	T8430	0.4	■ 165	0.12	1.2	■ 90	0.11	1.2	◪ 135	0.12	1.2	◪ 450	0.14	1.2	–	–	–	–	–	–
	T9315	0.4	■ 225	0.12	1.2	–	–	–	◪ 210	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 165	0.19	1.2	■ 95	0.17	1.2	◪ 155	0.19	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。

产品型号		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)
																				
			FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																	
VBMT 160408E-FM	**T5315**	0.8	◪ 235	0.17	1.2	–	–	–	◪ 220	0.17	1.2	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪ 165	0.17	1.2	■ 125	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪ 160	0.17	1.2	■ 120	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	◪ 150	0.17	1.2	■ 90	0.15	1.2	◪ 140	0.17	1.2	◪ 450	0.20	1.2	–	–	–	–	–	–
	T8330	0.8	■ 145	0.17	1.2	■ 85	0.15	1.2	◪ 135	0.17	1.2	◪ 435	0.20	1.2	–	–	–	–	–	–
	T8430	0.8	■ 170	0.17	1.2	■ 90	0.15	1.2	◪ 135	0.17	1.2	◪ 465	0.20	1.2	–	–	–	–	–	–
	T9310	0.8	■ 255	0.17	1.2	–	–	–	◪ 240	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 230	0.17	1.2	–	–	–	◪ 215	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 205	0.17	1.2	■ 120	0.15	1.2	◪ 190	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM	**T7325**	1.2	◪ 160	0.22	1.2	■ 120	0.22	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	1.2	■ 140	0.22	1.2	■ 80	0.22	1.2	◪ 130	0.22	1.2	◪ 420	0.26	1.2	–	–	–	–	–	–
	T8430	1.2	■ 155	0.22	1.2	■ 85	0.22	1.2	◪ 130	0.22	1.2	◪ 435	0.26	1.2	–	–	–	–	–	–
	T9315	1.2	■ 215	0.22	1.2	–	–	–	◪ 200	0.22	1.2	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 195	0.22	1.2	■ 115	0.22	1.2	◪ 185	0.22	1.2	–	–	–	–	–	–	–	–	–
																				
			FM2断屑槽，适用于精加工至中等加工，连续至断续切削。																	
VBMT 160404E-FM2	**T6310**	0.4	■ 120	0.12	1.2	◪ 85	0.11	1.2	■ 95	0.12	1.2	–	–	–	–	–	–	–	–	–
	T7325	0.4	◪ 140	0.12	1.2	◪ 105	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 125	0.12	1.2	◪ 75	0.11	1.2	■ 115	0.12	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 145	0.12	1.2	◪ 80	0.11	1.2	◪ 120	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 200	0.12	1.2	–	–	–	◪ 190	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 185	0.12	1.2	◪ 110	0.11	1.2	◪ 175	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 155	0.12	1.2	◪ 90	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2	**T6310**	0.8	■ 125	0.20	1.2	◪ 90	0.18	1.2	■ 100	0.20	1.2	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪ 145	0.20	1.2	◪ 110	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 125	0.20	1.2	◪ 75	0.18	1.2	■ 115	0.20	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 140	0.20	1.2	◪ 75	0.18	1.2	◪ 115	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 195	0.20	1.2	–	–	–	◪ 185	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 175	0.20	1.2	◪ 105	0.18	1.2	◪ 165	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 150	0.20	1.2	◪ 90	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2	**T8430**	1.2	■ 145	0.22	1.2	◪ 80	0.20	1.2	◪ 120	0.22	1.2	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 195	0.22	1.2	–	–	–	◪ 185	0.22	1.2	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 175	0.22	1.2	◪ 105	0.20	1.2	◪ 165	0.22	1.2	–	–	–	–	–	–	–	–	–
																				
			RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
VBMT 160404E-RM	**T5305**	0.4	◪ 270	0.12	1.2	–	–	–	■ 255	0.12	1.2	–	–	–	–	–	–	◪ 50	0.15	1.0
	T5315	0.4	◪ 235	0.12	1.2	–	–	–	■ 220	0.12	1.2	–	–	–	–	–	–	◪ 45	0.15	1.0
	T7335	0.4	◪ 140	0.18	1.2	■ 105	0.16	1.2	–	–	–	–	–	–	◪ 45	0.16	1.0	–	–	–
	T8330	0.4	■ 140	0.12	1.2	■ 80	0.11	1.2	■ 130	0.12	1.2	–	–	–	◪ 35	0.11	1.0	◪ 25	0.15	1.0
	T8430	0.4	■ 170	0.12	1.2	■ 90	0.11	1.2	◪ 135	0.12	1.2	–	–	–	◪ 35	0.11	1.0	◪ 25	0.15	1.0
	T9315	0.4	■ 235	0.12	1.2	–	–	–	◪ 220	0.12	1.2	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	0.4	■ 170	0.20	1.2	■ 100	0.18	1.2	◪ 160	0.20	1.2	–	–	–	◪ 35	0.18	1.0	–	–	–
VBMT 160408E-RM	**T5305**	0.8	◪ 285	0.17	1.2	–	–	–	■ 270	0.17	1.2	–	–	–	–	–	–	◪ 55	0.15	1.0
	T5315	0.8	◪ 250	0.17	1.2	–	–	–	■ 235	0.17	1.2	–	–	–	–	–	–	◪ 50	0.15	1.0
	T7335	0.8	◪ 155	0.20	1.2	■ 120	0.18	1.2	–	–	–	–	–	–	◪ 50	0.18	1.0	–	–	–
	T8330	0.8	■ 150	0.17	1.2	■ 90	0.15	1.2	■ 140	0.17	1.2	–	–	–	◪ 35	0.12	1.0	◪ 30	0.15	1.0
	T8430	0.8	■ 175	0.17	1.2	■ 95	0.15	1.2	◪ 140	0.17	1.2	–	–	–	◪ 35	0.12	1.0	◪ 30	0.15	1.0
	T9315	0.8	■ 240	0.17	1.2	–	–	–	◪ 225	0.17	1.2	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	0.8	■ 200	0.20	1.2	■ 120	0.18	1.2	◪ 190	0.20	1.2	–	–	–	◪ 45	0.18	1.0	–	–	–

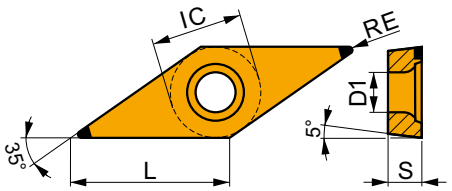
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
VBMT 160412E-RM	**T7335**	1.2	◪ 150	0.27	1.2	■ 115	0.24	1.2		–	–	–	–	–	–	◪ 45	0.19	1.0		–	–	–
	T8330	1.2	■ 140	0.27	1.2	■ 80	0.24	1.2	■ 130	0.27	1.2	–	–	–	◪ 35	0.19	1.0	◪ 25	0.15	1.0
	T8430	1.2	■ 155	0.27	1.2	■ 85	0.24	1.2	◪ 130	0.27	1.2	–	–	–	◪ 30	0.19	1.0	◪ 25	0.15	1.0
	T9315	1.2	■ 210	0.27	1.2	–	–	–	◪ 195	0.27	1.2	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	1.2	■ 185	0.27	1.2	■ 110	0.24	1.2	◪ 175	0.27	1.2	–	–	–	◪ 40	0.19	1.0	–	–	–
																				
UR断屑槽，适用于精细的精加工，连续切削或轻微断续切削。																				
VBMT 110202E-UR	**TT310**	0.2	■ 195	0.10	0.8	◪ 115	0.09	0.8		–	–	–	–	–	–	–	–	–	–	–
VBMT 110204E-UR	**T7325**	0.4	◪ 120	0.19	0.8	◪ 90	0.17	0.8		–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 120	0.12	0.8	◪ 70	0.11	0.8	■ 110	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 145	0.12	0.8	◪ 80	0.11	0.8	◪ 120	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 200	0.12	0.8	–	–	–	◪ 190	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 150	0.19	0.8	◪ 90	0.17	0.8	◪ 140	0.19	0.8	–	–	–	–	–	–	–	–	–
	TT310	0.4	■ 195	0.12	0.8	◪ 115	0.11	0.8		–	–	–	–	–	–	–	–	–	–	–
VBMT 160402E-UR	**T8330**	0.2	■ 115	0.10	1.2	◪ 65	0.09	1.2	■ 105	0.10	1.2	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.4	◪ 115	0.19	1.2	◪ 85	0.17	1.2		–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 115	0.12	1.2	◪ 65	0.11	1.2	■ 105	0.12	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 140	0.12	1.2	◪ 75	0.11	1.2	◪ 115	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9310	0.4	■ 215	0.12	1.2	–	–	–	◪ 200	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 190	0.12	1.2	–	–	–	◪ 180	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 145	0.18	1.2	◪ 85	0.16	1.2	◪ 135	0.18	1.2	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪ 140	0.17	1.2	◪ 105	0.15	1.2		–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 125	0.17	1.2	◪ 75	0.15	1.2	■ 115	0.17	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 145	0.17	1.2	◪ 80	0.15	1.2	◪ 120	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9310	0.8	■ 220	0.17	1.2	–	–	–	◪ 205	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 200	0.17	1.2	–	–	–	◪ 190	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 180	0.17	1.2	◪ 105	0.15	1.2	◪ 170	0.17	1.2	–	–	–	–	–	–	–	–	–
	TT310	0.8	■ 200	0.17	1.2	◪ 120	0.15	1.2		–	–	–	–	–	–	–	–	–	–	–
VBMT 160412E-UR	**T7325**	1.2	◪ 135	0.22	1.2	◪ 105	0.20	1.2		–	–	–	–	–	–	–	–	–	–	–
	T8330	1.2	■ 120	0.22	1.2	◪ 70	0.20	1.2	■ 110	0.22	1.2	–	–	–	–	–	–	–	–	–
	T8430	1.2	■ 135	0.22	1.2	◪ 75	0.20	1.2	◪ 110	0.22	1.2	–	–	–	–	–	–	–	–	–
	T9310	1.2	■ 205	0.22	1.2	–	–	–	◪ 190	0.22	1.2	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 185	0.22	1.2	–	–	–	◪ 175	0.22	1.2	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 170	0.22	1.2	◪ 100	0.20	1.2	◪ 160	0.22	1.2	–	–	–	–	–	–	–	–	–

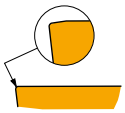
VBGW CBN

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。

产品型号		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															
			适用于精加工，连续切削。																	
VBGW 160404S01020B	**TB310**	0.4	–	–	–	–	–	–	340	0.10	0.4	–	–	–	90	0.07	0.3	70	0.15	1.0
VBGW 160408S01020B	**TB310**	0.8	–	–	–	–	–	–	350	0.15	0.6	–	–	–	90	0.11	0.5	70	0.15	1.0

SVHB(C)(RL) EXT

P M K N S H

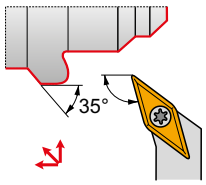
PRAMET

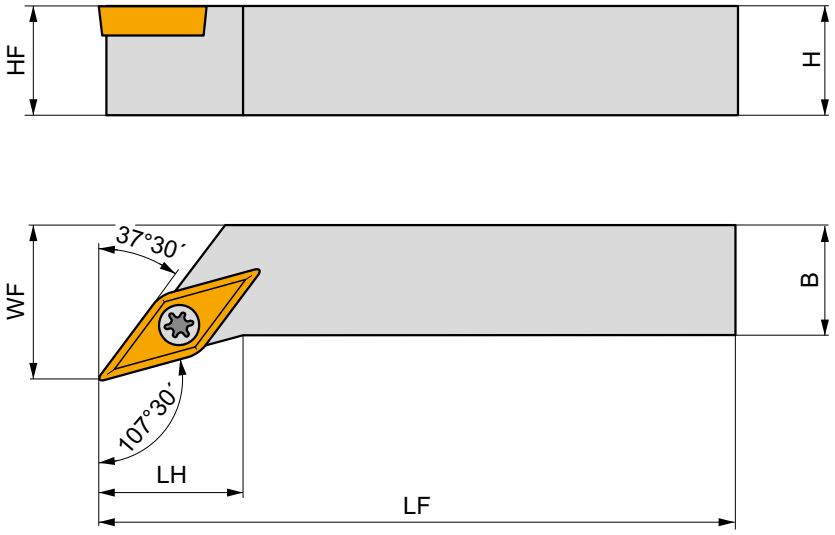
S

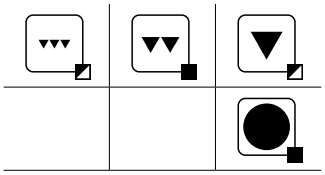


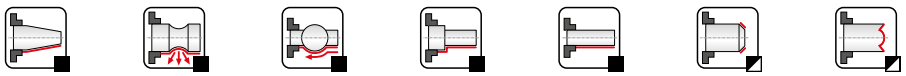
外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为107.5°。

外圆用左/右手持式车刀杆，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。









	产品型号	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	0.21	GI194	S01
	SVHCR 2020 K 16-M-A	20	20	20	25	125	20	0	0	0.40	GI017	SV10
	SVHCR 2525 M 16-M-A	25	25	25	32	150	20	0	0	0.68	GI017	SV10
L	**SVHBL 1616 H 11**	16	16	16	20	100	14	0	0	0.19	GI194	S01
	SVHCL 2020 K 16-M-A	20	20	20	25	125	20	0	0	0.40	GI017	SV10
	SVHCL 2525 M 16-M-A	25	25	25	32	150	20	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

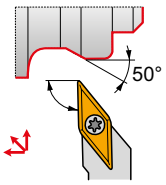
PRAMET

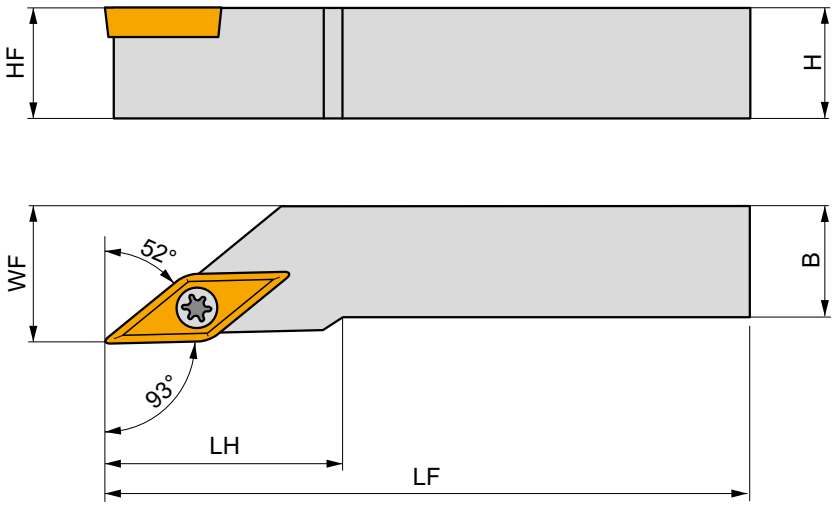
S

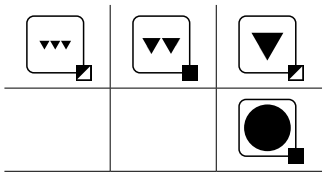


外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为93°。

外圆用左/右手持式车刀杆，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，最大的仿形车削角度最大为50°，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。









	产品型号	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	0.09	GI194	S01
	SVJBR 1616 H 11	16	16	16	20	100	20	0	0	0.20	GI194	S01
	SVJCR 1212 N 13	12	12	12	16	160	27	0	0	0.19	GI211	SV21
	SVJCR 1616 H 13	16	16	16	20	100	30	0	0	0.20	GI211	SV21
	SVJCR 2020 K 13	20	20	20	25	125	30	0	0	0.37	GI211	SV22
	SVJCR 2525 M 13	25	25	25	32	150	30	0	0	0.67	GI211	SV22
	SVJCR 2020 K 16-M-A	20	20	20	25	125	28	0	0	0.35	GI017	SV10
	SVJCR 2525 M 16-M-A	25	25	25	32	150	32	0	0	0.68	GI017	SV10
	SVJCR 3225 P 16-M-A	32	25	32	32	170	32	0	0	0.99	GI017	SV10
L	SVJBL 1212 F 11	12	12	12	16	80	20	0	0	0.09	GI194	S01
	SVJBL 1616 H 11	16	16	16	20	100	20	0	0	0.19	GI194	S01
	SVJCL 1212 N 13	12	12	12	16	160	27	0	0	0.19	GI211	SV21
	SVJCL 1616 H 13	16	16	16	20	100	30	0	0	0.20	GI211	SV21
	SVJCL 2020 K 13	20	20	20	25	125	30	0	0	0.37	GI211	SV22
	SVJCL 2525 M 13	25	25	25	32	150	30	0	0	0.67	GI211	SV22
	SVJCL 2020 K 16-M-A	20	20	20	25	125	28	0	0	0.40	GI017	SV10
	SVJCL 2525 M 16-M-A	25	25	25	32	150	32	0	0	0.70	GI017	SV10
	SVJCL 3225 P 16-M-A	32	25	32	32	170	32	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
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

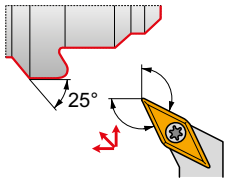
PRAMET

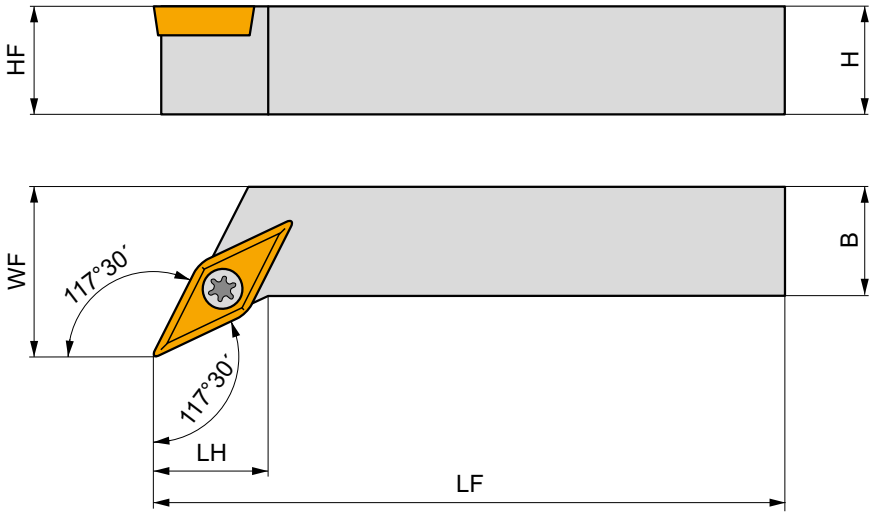
S

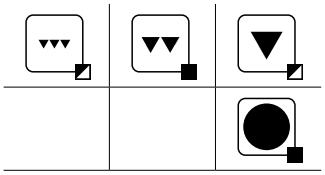


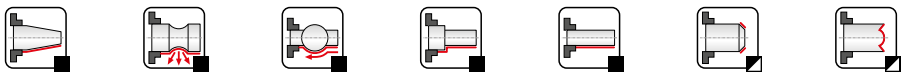
外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为117.5°。

外圆用左/右手持式车刀杆，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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SVPBR 1616 H 11**	16	16	16	20	100	12	0	0	0.20	GI194	S01
	SVPBR 2020 K 11	20	20	20	25	125	12	0	0	0.41	GI194	S01
	SVPCR 2020 K 16-M-A	20	20	20	25	125	20	0	0	0.40	GI017	SV10
	SVPCR 2525 M 16-M-A	25	25	25	32	150	25	0	0	0.75	GI017	SV10
	SVPCR 3225 P 16-M-A	32	25	32	32	170	25	0	0	1.10	GI017	SV10
L	**SVPBL 1616 H 11**	16	16	16	20	100	12	0	0	0.20	GI194	S01
	SVPBL 2020 K 11	20	20	20	25	125	12	0	0	0.39	GI194	S01
	SVPCL 2020 K 16-M-A	20	20	20	25	125	20	0	0	0.70	GI017	SV10
	SVPCL 2525 M 16-M-A	25	25	25	32	150	25	0	0	0.70	GI017	SV10
	SVPCL 3225 P 16-M-A	32	25	32	32	170	25	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

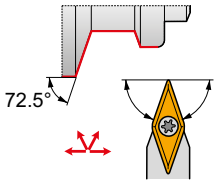
PRAMET

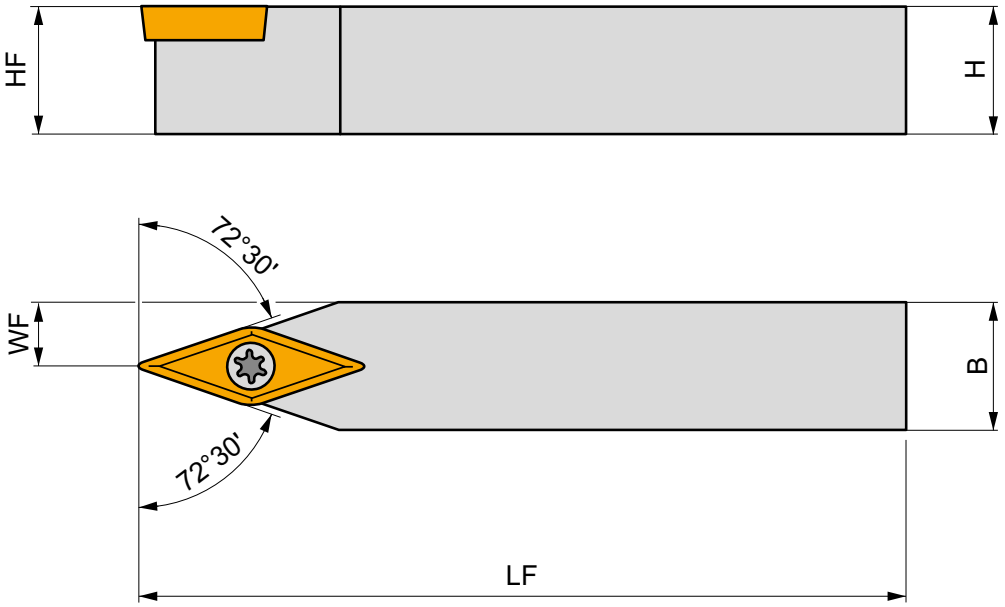
S

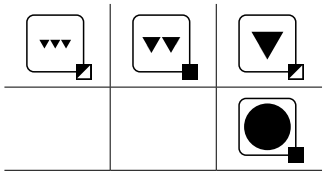


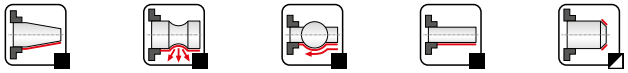
外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为72.5°。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	**SVVBN 1212 F 11**	12	12	12	6	80	–	0	0	0.11	GI194	S01
	SVVBN 1616 H 11	16	16	16	8	100	–	0	0	0.18	GI194	S01
	SVVBN 2020 K 11	20	20	20	10	125	–	0	0	0.38	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	0.68	GI017	SV10
	SVVCN 3225 P 16-M-A	32	25	32	12.5	170	–	0	0	0.98	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

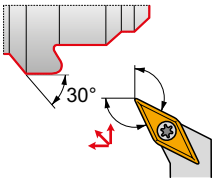
PRAMET

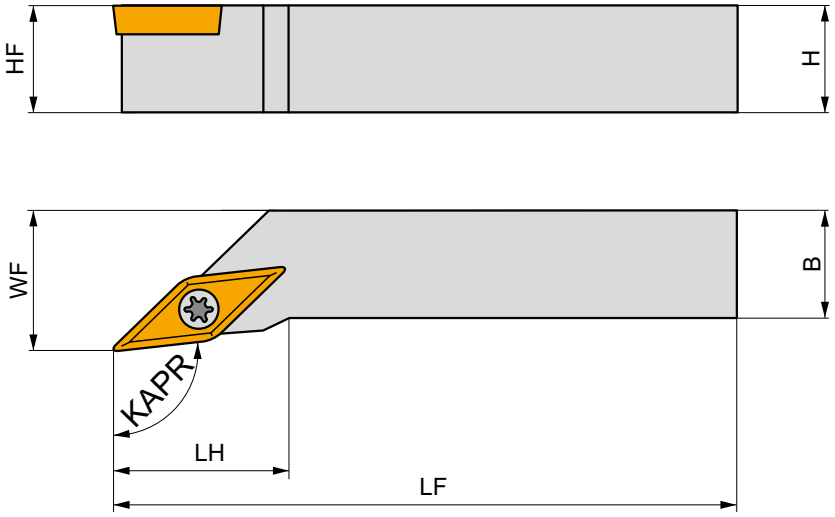
S

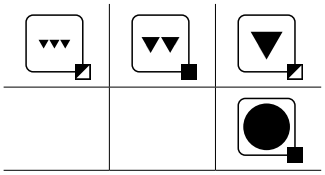


外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为98/113°。

外圆用左/右手持式车刀杆，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。









	产品型号	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	98	0	0	0.09	GI194	SO1
	SVXBR 1616 H 11	16	16	16	20	100	14	98	0	0	0.19	GI194	SO1
	SVXCR 2020 K 13	20	20	20	25	125	12	113	0	0	0.38	GI211	SV22
	SVXCR 2020 K 16-M-A	20	20	20	25	125	28	98	0	0	0.41	GI017	SV10
	SVXCR 2525 M 16-M-A	25	25	25	32	150	32	98	0	0	0.68	GI017	SV10
	SVXCR 3225 P 16-M-A	32	25	32	32	170	32	98	0	0	1.00	GI017	SV10
L	SVXBL 1212 F 11	12	12	12	16	80	20	98	0	0	0.09	GI194	SO1
	SVXBL 1616 H 11	16	16	16	20	100	14	98	0	0	0.19	GI194	SO1
	SVXCL 2020 K 13	20	20	20	25	125	12	113	0	0	0.38	GI211	SV22
	SVXCL 2020 K 16-M-A	20	20	20	25	125	28	98	0	0	0.38	GI017	SV10
	SVXCL 2525 M 16-M-A	25	25	25	32	150	32	98	0	0	0.69	GI017	SV10
	SVXCL 3225 P 16-M-A	32	25	32	32	170	32	98	0	0	0.99	GI017	SV10

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

		Nm						
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
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

NEW

C.-SVHB(RL) EXT

P M K N S H

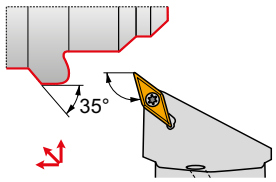
PRAMET

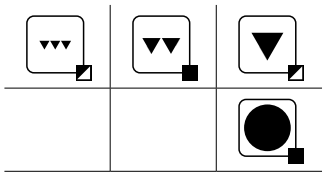
S

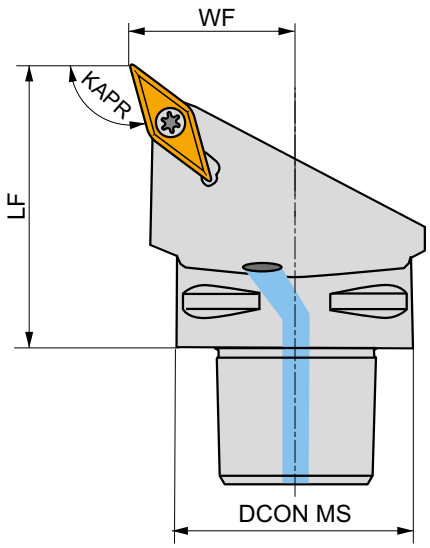


外圆用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为107.5°。

外圆用左/右手动刀具，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。









	产品型号	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

NEW

C.-SVJB(RL) EXT

P M K N S H

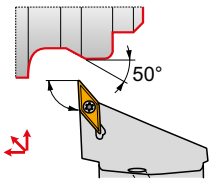
PRAMET

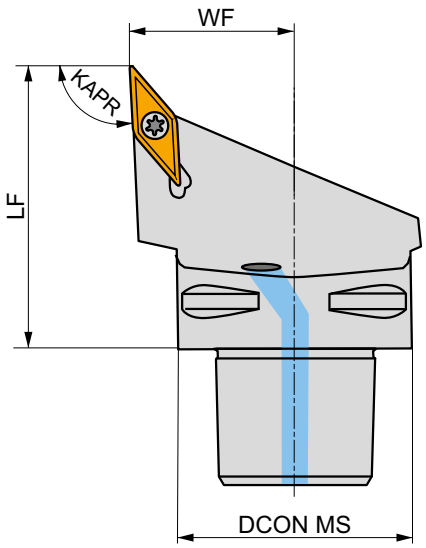
S

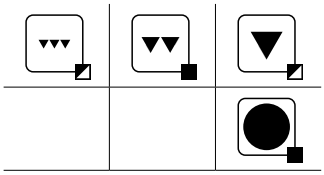


外圆用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为93°。

外圆用左/右手动刀具，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。









	产品型号	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	✓	0.35	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

NEW

C.-SVVBN EXT

P M K N S H

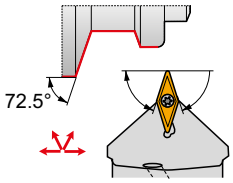
PRAMET

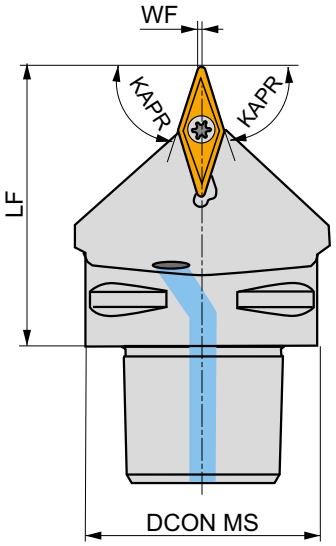
S

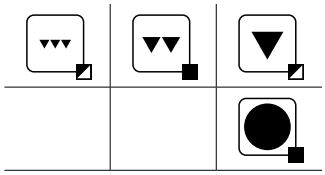


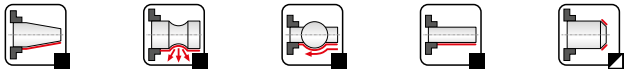
外圆用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为72.5°。

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。









	产品型号	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

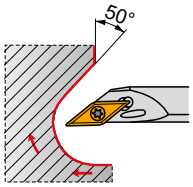
PRAMET

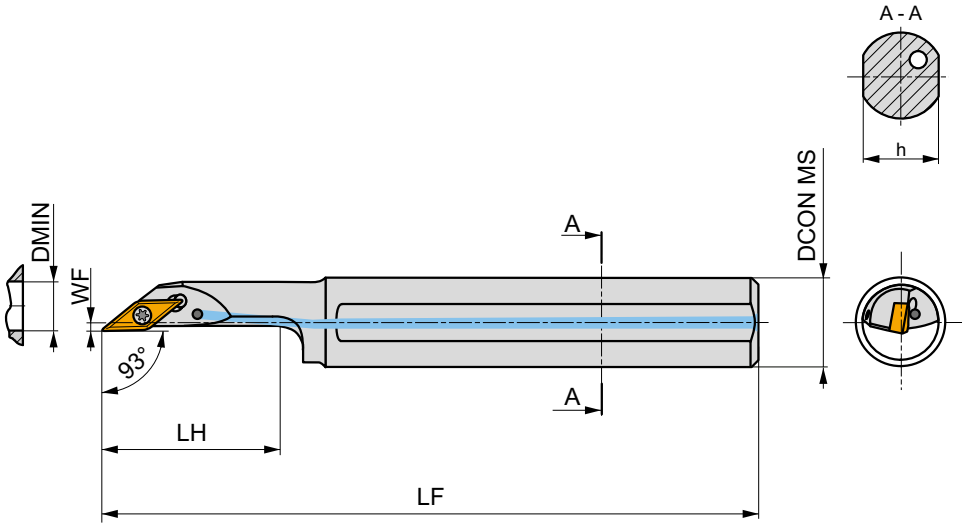
S

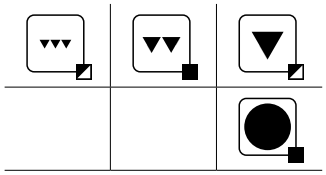


内孔用螺钉夹紧式镗杆，使用VB/VC..刀片，主偏角为93°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为93°，使用VB..11和VC..11刀片。内孔最小加工直径为Ø25mm。适用于50°以下的端面仿形车削。可提供Ø20和Ø25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	-5	-5	✓	0.44	GI194	S07
	A25S-SVJBR 11	25	32	3.5	23	250	50	-5	-5	✓	0.82	GI194	S07
L	**A20R-SVJBL 11**	20	25	2	18	200	40	-5	-5	✓	0.42	GI194	S07
	A25S-SVJBL 11	25	32	3.5	23	250	50	-5	-5	✓	0.82	GI194	S07

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

S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

SVQB(C)(RL) INT

P M K N S H

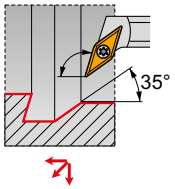
PRAMET

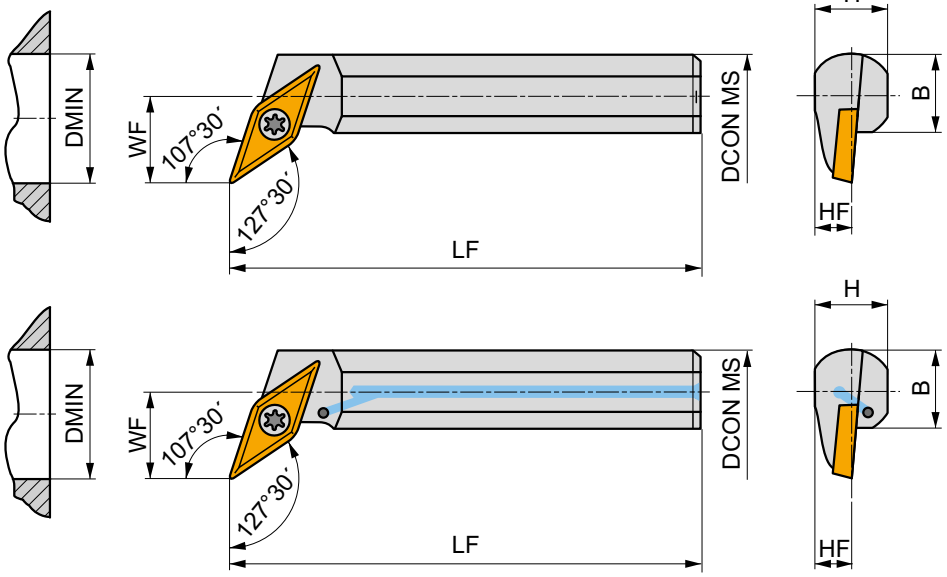
S

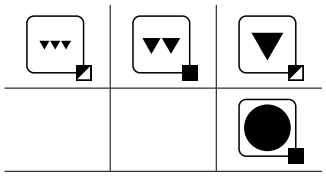


内孔用螺钉夹紧式镗杆，使用VB/VC..刀片，主偏角为107.5°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为107.5°，使用VB../VC..11和16刀片。内孔最小加工直径为Ø20mm。广泛的应用于内孔车削。可提供Ø16至Ø40mm的刀柄。









	产品型号	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	✓	0.58	GI194	S01
	A16R-SVQCR 13	16	21	11	15	15	200	-6	0	✓	0.30	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	–	1.10	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	✓	0.33	GI194	S01
	A20S-SVQBL 11	20	25	13	18	18.5	250	-4	0	✓	0.58	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	–	1.09	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

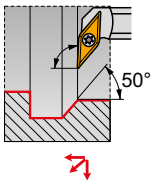
PRAMET

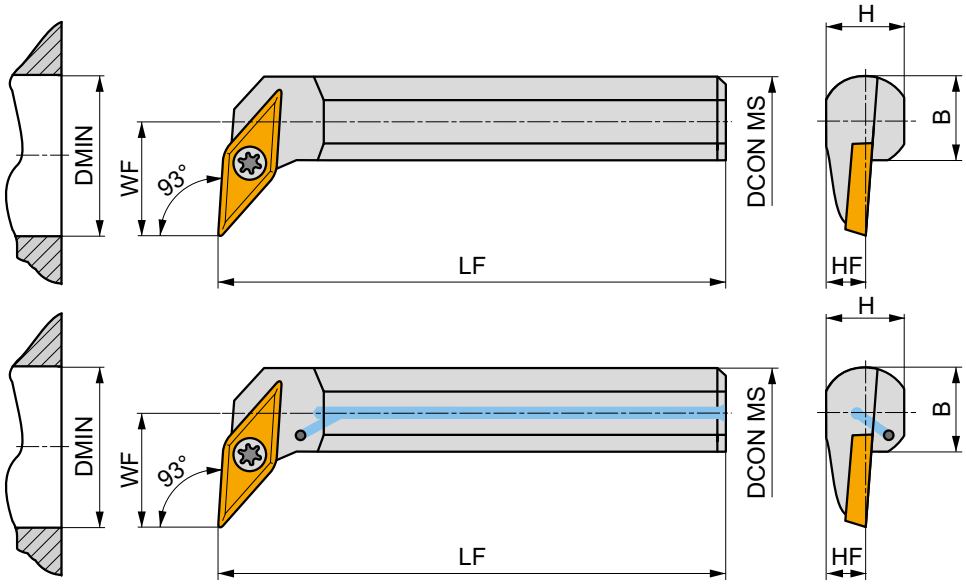
S

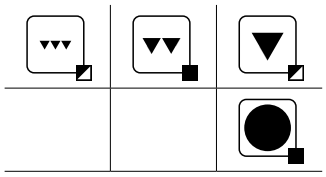


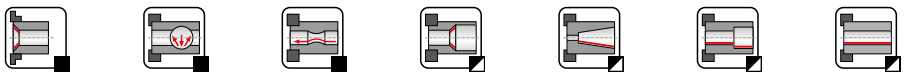
内孔用螺钉夹紧式镗杆，使用VB/VC..刀片，主偏角为93°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为93°，使用VB../VC..11和16刀片。内孔最小加工直径为Ø20mm。广泛的应用于内孔车削，和50°以下的仿形车削。可提供Ø16至Ø40mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	✓	0.34	GI194	S01
	A20S-SVUBR 11	20	25	13	18	18.8	250	-4	0	✓	0.58	GI194	S01
	A20S-SVUCR 13	20	25	13	19	18.5	250	-4	2	✓	0.40	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	✓	1.70	GI211	SV22
	S25T-SVUCR 16	25	32	17	23	23	300	-7	0	–	1.10	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	✓	0.34	GI194	S01
	A20S-SVUBL 11	20	25	13	18	18.5	250	-4	0	✓	0.58	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	✓	1.70	GI211	SV22
	S25T-SVUCL 16	25	32	17	23	23	300	-7	0	–	1.10	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

NEW

C.-SVQB(RL) INT

P M K N S H

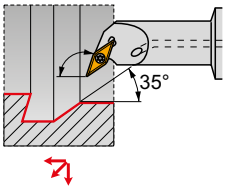
PRAMET

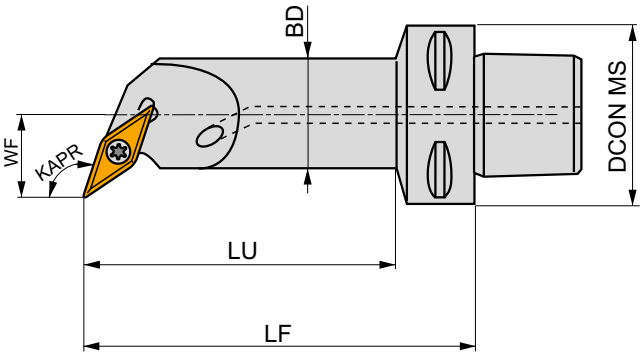
S

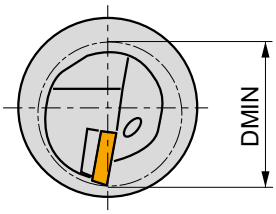


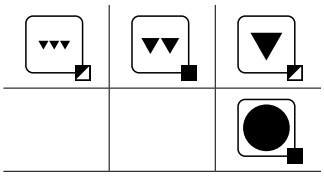
内孔用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为107.5°。

内孔用左/右手动刀具，有内冷通道，螺钉锁紧式。主偏角107.5°，使用VB..16或VC..16刀片。内孔最小加工直径为Ø33mm。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。











	产品型号	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
	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
	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 Nm	M 3.5	10.1	FLAG T15P/3,5

VC

07/ 11/ 13/ 16

硬质合金刀片

VCGT	VCGW	VCGX	VCMT	VCMW
				
186	189	189	190	191

PCD刀片

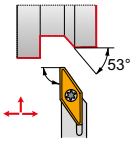
VCMW PCD

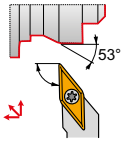
192

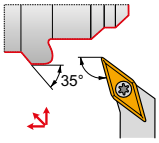
匹配正确的尺寸（示例）

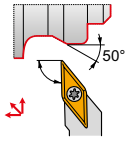
刀片	刀杆
VCGT 070204E-FF2	SVGCR 1010 M 07

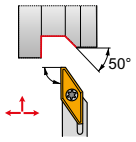
ISO 外圆车削

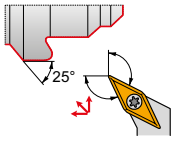
SVAC(RL)-DC EXT		
90°		VC..
		13
	10×10 / 25×25	
193		186 – 192

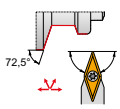
SVGC(RL) EXT		
90°		VC..
		07
	08×08 / 16×16	
194		186 – 192

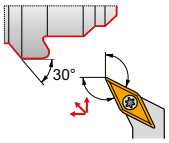
SVHB(C)(RL) EXT		
107°30´		VB, VC..
		11 16
	16×16 / 25×25	
195		168 – 171 186 – 192

SVJB(C)(RL) EXT		
93°		VB, VC..
		11 13 16
	12×12 / 32×25	
196		168 – 171 186 – 192

SVJC(RL)-DC EXT		
93°		VC..
		13
	10×10 / 25×25	
197		186 – 192

SVPB(C)(RL) EXT		
117°30´		VB, VC..
		11 16
	16×16 / 32×25	
198		168 – 171 186 – 192

SVVB(C)N EXT		
72°30´		VB, VC..
		11 13 16
	12×12 / 32×25	
199		168 – 171 186 – 192

SVXB(C)(RL) EXT		
98°		VB, VC..
		11 13 16
	12×12 / 32×25	
200		168 – 171 186 – 192

VC

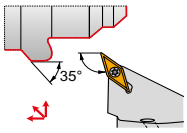
07/ 11/ 13/ 16

C.-SVHB(RL) EXT NEW

107°30´

VB, VC..

16



C4 / C6

201

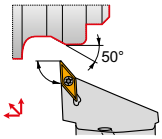
168 – 171
186 – 192

C.-SVJB(RL) EXT NEW

93°

VB, VC..

11
16



C3 / C6

202

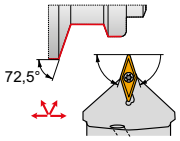
168 – 171
186 – 192

C.-SVVBN EXT NEW

72°30´

VB, VC..

16



C4 / C6

203

168 – 171
186 – 192

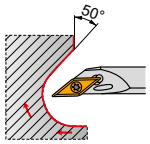
ISO内孔车削

SVJB(RL) INT

93°

VB, VC..

11



ØDmin

25 / 32

204

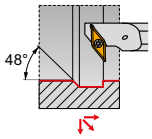
168 – 171
186 – 192

SVLC(RL) INT

95°

VC..

13



ØDmin

27 / 43

205

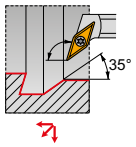
186 – 192

SVQB(C)(RL) INT

107°30´

VB, VC..

11
13
16



ØDmin

20 / 50

206

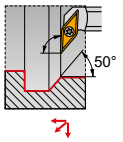
168 – 171
186 – 192

SVUB(C)(RL) INT

93°

VB, VC..

11
13
16



ØDmin

20 / 50

207

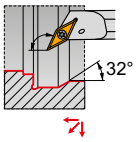
168 – 171
186 – 192

SVXC(RL) INT

113°

VC..

07



ØDmin

12,5 / 17,5

208

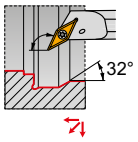
186 – 192

SVXC(RL)-E INT

113°

VC..

07



ØDmin

12,5 / 17,5

209

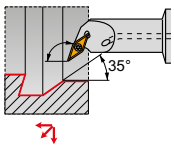
186 – 192

C.-SVQB(C)(RL) INT NEW

108°

VB, VC..

16



ØDmin

33

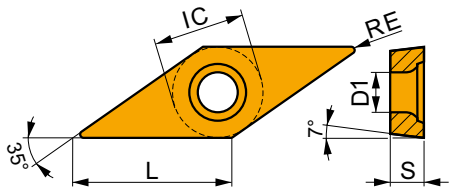
210

168 – 171
186 – 192

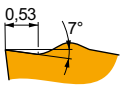
VCGT

PRAMET

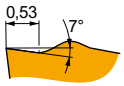
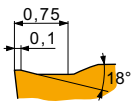
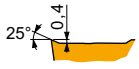
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	3.970	2.20	6.90	2.38
1102-SF3	6.350	2.80	11.10	2.58
1103	6.350	2.80	11.10	3.18
1103-SF3	6.350	2.80	11.10	3.43
1303	7.940	3.40	13.80	3.18
1303-AL	7.940	3.40	13.80	3.43
1303-SF3	7.940	3.40	13.80	3.43
1604	9.525	4.40	16.60	4.76
1604-SF3	9.525	4.40	16.60	5.01



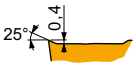
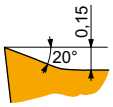
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
AL断屑槽，具有大正前角设计，适用于精加工至粗加工，连续切削至轻微断续切削。																				
VCGT 070202F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	315	0.12	1.0	–	–	–	–	–	–
VCGT 110302F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	300	0.12	1.5	–	–	–	–	–	–
	T0315	0.2	–	–	–	–	–	–	–	–	–	465	0.12	0.8	–	–	–	–	–	–
VCGT 110304F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	240	0.24	1.5	–	–	–	–	–	–
	T0315	0.4	–	–	–	–	–	–	–	–	–	375	0.24	0.8	–	–	–	–	–	–
VCGT 130302F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	285	0.12	1.7	–	–	–	–	–	–
	T0315	0.2	–	–	–	–	–	–	–	–	–	420	0.12	1.7	–	–	–	–	–	–
VCGT 130304F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	240	0.24	1.7	–	–	–	–	–	–
	T0315	0.4	–	–	–	–	–	–	–	–	–	345	0.24	1.7	–	–	–	–	–	–
VCGT 130308F-AL	**HF7**	0.8	–	–	–	–	–	–	–	–	–	210	0.48	1.7	–	–	–	–	–	–
	T0315	0.8	–	–	–	–	–	–	–	–	–	315	0.48	1.7	–	–	–	–	–	–
VCGT 160402F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	285	0.12	2.4	–	–	–	–	–	–
	T0315	0.2	–	–	–	–	–	–	–	–	–	420	0.12	2.4	–	–	–	–	–	–
VCGT 160404F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	225	0.24	2.4	–	–	–	–	–	–
	T0315	0.4	–	–	–	–	–	–	–	–	–	330	0.24	2.4	–	–	–	–	–	–
VCGT 160408F-AL	**HF7**	0.8	–	–	–	–	–	–	–	–	–	210	0.48	2.4	–	–	–	–	–	–
	T0315	0.8	–	–	–	–	–	–	–	–	–	300	0.48	2.4	–	–	–	–	–	–
VCGT 160412F-AL	**HF7**	1.2	–	–	–	–	–	–	–	–	–	180	0.72	2.4	–	–	–	–	–	–
	T0315	1.2	–	–	–	–	–	–	–	–	–	270	0.72	2.4	–	–	–	–	–	–
																				
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
VCGT 070202E-FF2	**T8315**	0.2	150	0.05	0.8	–	–	–	140	0.05	0.8	–	–	–	–	–	–	–	–	–
	T8330	0.2	145	0.05	0.8	–	–	–	135	0.05	0.8	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T8330	0.4	120	0.12	0.8	–	–	–	110	0.12	0.8	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T7325	0.2	165	0.05	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.2	140	0.05	1.0	–	–	–	130	0.05	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.2	185	0.05	1.0	–	–	–	150	0.05	1.0	–	–	–	–	–	–	–	–	–
	T9315	0.2	265	0.05	1.0	–	–	–	250	0.05	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.2	240	0.05	1.0	–	–	–	225	0.05	1.0	–	–	–	–	–	–	–	–	–
	TT010	0.2	240	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。

产品型号		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)
																				
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
VCGT 130304E-FF2	T5315	0.4	◪	195	0.12	1.0		–	–	–	■	185	0.12	1.0		–	–	–		–	–	–		–	–	–
	T7325	0.4	◪	135	0.12	1.0		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
	T8330	0.4	■	115	0.12	1.0		–	–	–	■	105	0.12	1.0		–	–	–		–	–	–		–	–	–
	T8430	0.4	■	140	0.12	1.0		–	–	–	◪	115	0.12	1.0		–	–	–		–	–	–		–	–	–
	T9315	0.4	■	195	0.12	1.0		–	–	–	◪	185	0.12	1.0		–	–	–		–	–	–		–	–	–
	T9325	0.4	■	175	0.12	1.0		–	–	–	◪	165	0.12	1.0		–	–	–		–	–	–		–	–	–
	TT010	0.4	■	245	0.06	0.5		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
VCGT 130308E-FF2	T7325	0.8	◪	145	0.17	1.0		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
	T9315	0.8	■	200	0.17	1.0		–	–	–	◪	190	0.17	1.0		–	–	–		–	–	–		–	–	–
	T9325	0.8	■	180	0.17	1.0		–	–	–	◪	170	0.17	1.0		–	–	–		–	–	–		–	–	–
	TT010	0.8	■	245	0.10	0.8		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
																				
FM2断屑槽，适用于精加工至中等加工，连续至断续切削。																				
VCGT 130308E-FM2	T8330	0.8	■	125	0.17	1.0	◪	75	0.15	1.0	■	115	0.17	1.0		–	–	–		–	–	–		–	–	–
	T8430	0.8	■	145	0.17	1.0	◪	80	0.15	1.0	◪	120	0.17	1.0		–	–	–		–	–	–		–	–	–
	T9325	0.8	■	180	0.17	1.0	◪	105	0.15	1.0	◪	170	0.17	1.0		–	–	–		–	–	–		–	–	–
																				
NF2断屑槽，具有正前角设计，适用于超精加工至中粗加工，连续切削。																				
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		–	–	–
	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		–	–	–
	T7325	0.2	◪	150	0.07	1.0	■	115	0.06	1.0		–	–	–		–	–	–	■	45	0.06	0.8		–	–	–
	T7335	0.2	◪	150	0.07	1.0	■	115	0.06	1.0		–	–	–		–	–	–	■	45	0.06	0.8		–	–	–
	T9315	0.2	◪	200	0.10	1.0		–	–	–	◪	190	0.10	1.0		–	–	–		–	–	–		–	–	–
	T9325	0.2	◪	210	0.07	1.0	■	125	0.06	1.0	◪	195	0.07	1.0		–	–	–	◪	45	0.06	0.8		–	–	–
	T9335	0.2	◪	155	0.10	1.0	■	90	0.09	1.0		–	–	–		–	–	–	◪	30	0.07	0.8		–	–	–
	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		–	–	–
	T5315	0.4	◪	195	0.12	1.0		–	–	–	◪	185	0.12	1.0		–	–	–		–	–	–		–	–	–
	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		–	–	–
	T7325	0.4	◪	135	0.12	1.0	■	105	0.11	1.0		–	–	–		–	–	–	■	40	0.08	0.8		–	–	–
	T7335	0.4	◪	135	0.12	1.0	■	105	0.11	1.0		–	–	–		–	–	–	■	40	0.08	0.8		–	–	–
	T9315	0.4	◪	210	0.10	1.0		–	–	–	◪	195	0.10	1.0		–	–	–		–	–	–		–	–	–
	T9325	0.4	◪	175	0.12	1.0	■	105	0.11	1.0	◪	165	0.12	1.0		–	–	–	◪	35	0.08	0.8		–	–	–
	T9335	0.4	◪	150	0.12	1.0	■	90	0.11	1.0		–	–	–		–	–	–	◪	30	0.11	0.8		–	–	–
	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		–	–	–		–	–	–		–	–	–
	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		–	–	–
	T7325	0.8	◪	145	0.17	1.0	■	110	0.15	1.0		–	–	–		–	–	–	■	45	0.12	0.8		–	–	–
	T7335	0.8	◪	140	0.17	1.0	■	105	0.15	1.0		–	–	–		–	–	–	■	45	0.12	0.8		–	–	–
	T9315	0.8	◪	200	0.17	1.0		–	–	–	◪	190	0.17	1.0		–	–	–		–	–	–		–	–	–
	T9325	0.8	◪	180	0.17	1.0	■	105	0.15	1.0	◪	170	0.17	1.0		–	–	–	◪	40	0.12	0.8		–	–	–
	T9335	0.8	◪	155	0.18	1.0	■	90	0.16	1.0		–	–	–		–	–	–	◪	30	0.16	0.8		–	–	–
	TT010	0.8	◪	245	0.10	0.8	◪	145	0.09	0.8		–	–	–		–	–	–		–	–	–		–	–	–
																				
SF2断屑槽，具有大正前角设计，适用于精细的精加工，连续切削。																				
VCGT 130301E-SF2	H07	0.1		–	–	–	◪	80	0.05	1.0		–	–	–	◪	405	0.06	1.0	■	40	0.04	0.8		–	–	–
	T6310	0.1	◪	140	0.05	1.0	■	100	0.05	1.0		–	–	–	◪	420	0.06	1.0	■	40	0.04	0.8		–	–	–

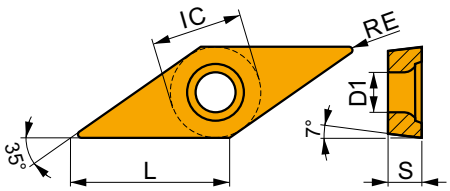
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
			 SF2断屑槽，具有大正前角设计，适用于精细的精加工，连续切削。																	
VCGT 130302E-SF2	H07	0.2	–	–	–	80	0.05	1.0	–	–	–	405	0.06	1.0	40	0.04	0.8	–	–	–
	HF7	0.2	–	–	–	90	0.05	1.0	–	–	–	450	0.06	1.0	–	–	–	–	–	–
	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	–	–	–
	HF7	0.4	–	–	–	75	0.09	1.0	–	–	–	375	0.12	1.0	–	–	–	–	–	–
	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	H07	0.8	–	–	–	75	0.09	1.0	–	–	–	390	0.12	1.0	35	0.08	0.8	–	–	–
	HF7	0.8	–	–	–	85	0.09	1.0	–	–	–	435	0.12	1.0	–	–	–	–	–	–
	T6310	0.8	145	0.10	1.0	100	0.09	1.0	–	–	–	435	0.12	1.0	40	0.08	0.8	–	–	–
			 SF3断屑槽，具有大正前角设计，适用于精细的精加工，连续切削。																	
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	–	–	–
	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	0.15	1.0
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	0.15	1.0
VCGT 110201E-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	0.15	1.0
VCGT 110202E-SF3	H07	0.2	–	–	–	80	0.05	0.8	130	0.05	0.8	415	0.06	0.8	40	0.04	0.6	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	0.15	1.0
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	0.15	1.0
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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0
	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	0.15	1.0
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	–	–	–
	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	0.15	1.0

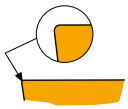
VCGW

PRAMET

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



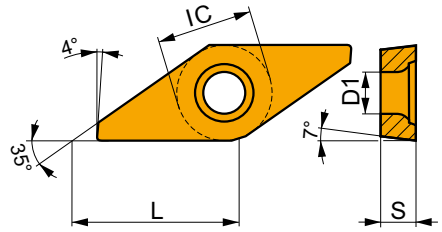
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
			 适用于超精加工至中粗加工，连续至轻微断续切削。																	
VCGW 130302	**T5305**	0.2	–	–	–	–	–	–	■ 170	0.08	1.3	–	–	–	–	–	–	◪ 35	0.15	1.0
VCGW 130304	**T5305**	0.4	–	–	–	–	–	–	■ 165	0.10	1.3	–	–	–	–	–	–	◪ 35	0.15	1.0
VCGW 130308	**T5305**	0.8	–	–	–	–	–	–	■ 160	0.18	1.3	–	–	–	–	–	–	◪ 30	0.15	1.0

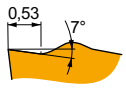
VCGX

PRAMET

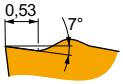
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18



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。

产品型号		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)
			 FR-FF2断屑槽，具有正前角，右手设计，适用于超精加工至精加工，连续切削。																	
VCGX 130300FR-FF2	**T6310**	0.0	■	140	0.05	1.0	–	–	–	■	110	0.05	1.0	–	–	–	–	–	–	–	–	–
	T8315	0.0	◪	150	0.05	1.0	–	–	–	■	140	0.05	1.0	–	–	–	–	–	–	–	–	–
	TT010	0.0	■	240	0.05	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2	**T6310**	0.1	■	140	0.05	1.0	–	–	–	■	110	0.05	1.0	–	–	–	–	–	–	–	–	–
	T8315	0.1	◪	150	0.05	1.0	–	–	–	■	140	0.05	1.0	–	–	–	–	–	–	–	–	–
	TT010	0.1	■	240	0.05	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–

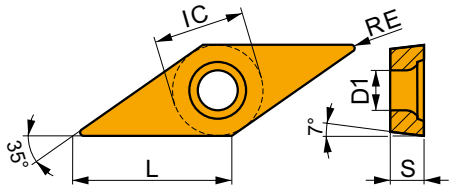
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
			FL-FF2断屑槽，具有正前角，左手设计，适用于超精加工至精加工，连续切削。																	
VCGX 130300FL-FF2	**T6310**	0.0	■ 140	0.05	1.0	–	–	–	■ 110	0.05	1.0	–	–	–	–	–	–	–	–	–
	T8315	0.0	◪ 150	0.05	1.0	–	–	–	■ 140	0.05	1.0	–	–	–	–	–	–	–	–	–
	TT010	0.0	■ 240	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGX 130301FL-FF2	**T6310**	0.1	■ 140	0.05	1.0	–	–	–	■ 110	0.05	1.0	–	–	–	–	–	–	–	–	–
	T8315	0.1	◪ 150	0.05	1.0	–	–	–	■ 140	0.05	1.0	–	–	–	–	–	–	–	–	–

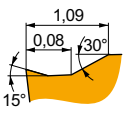
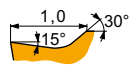
VCMT

PRAMET

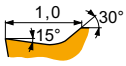
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



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。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
			FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																	
VCMT 160404E-FM	**T7325**	0.4	◪ 125	0.19	1.2	■ 95	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 130	0.12	1.2	■ 75	0.11	1.2	◪ 120	0.12	1.2	◪ 390	0.14	1.2	–	–	–	–	–	–
	T8430	0.4	■ 150	0.12	1.2	■ 80	0.11	1.2	◪ 125	0.12	1.2	◪ 420	0.14	1.2	–	–	–	–	–	–
	T9315	0.4	■ 210	0.12	1.2	–	–	–	◪ 195	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 155	0.19	1.2	■ 90	0.17	1.2	◪ 145	0.19	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM	**T7325**	0.8	◪ 155	0.17	1.2	■ 120	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 135	0.17	1.2	■ 80	0.15	1.2	◪ 125	0.17	1.2	◪ 405	0.20	1.2	–	–	–	–	–	–
	T8430	0.8	■ 155	0.17	1.2	■ 85	0.15	1.2	◪ 130	0.17	1.2	◪ 435	0.20	1.2	–	–	–	–	–	–
	T9315	0.8	■ 220	0.17	1.2	–	–	–	◪ 205	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 195	0.17	1.2	■ 115	0.15	1.2	◪ 185	0.17	1.2	–	–	–	–	–	–	–	–	–
																				
			UR断屑槽，适用于精细的精加工，连续切削或轻微断续切削。																	
VCMT 110304E-UR	**T7325**	0.4	◪ 110	0.19	0.8	◪ 85	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 110	0.12	0.8	◪ 65	0.11	0.8	■ 100	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 135	0.12	0.8	◪ 75	0.11	0.8	◪ 110	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 190	0.12	0.8	–	–	–	◪ 180	0.12	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 140	0.19	0.8	◪ 80	0.17	0.8	◪ 130	0.19	0.8	–	–	–	–	–	–	–	–	–
VCMT 110308E-UR	**T7325**	0.8	◪ 140	0.17	0.8	◪ 105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 125	0.17	0.8	◪ 75	0.15	0.8	■ 115	0.17	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 140	0.17	0.8	◪ 75	0.15	0.8	◪ 115	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 195	0.17	0.8	–	–	–	◪ 185	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 175	0.17	0.8	◪ 105	0.15	0.8	◪ 165	0.17	0.8	–	–	–	–	–	–	–	–	–

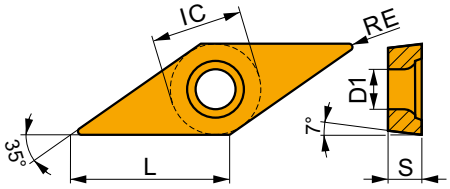
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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，适用于精细的精加工，连续切削或轻微断续切削。																				
VCMT 160404E-UR	**T7325**	0.4	110	0.19	1.2	85	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	110	0.12	1.2	65	0.11	1.2	100	0.12	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.4	130	0.12	1.2	70	0.11	1.2	105	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.4	180	0.12	1.2	–	–	–	170	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	135	0.19	1.2	80	0.17	1.2	125	0.19	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-UR	**T7325**	0.8	135	0.17	1.2	105	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	115	0.17	1.2	65	0.15	1.2	105	0.17	1.2	–	–	–	–	–	–	–	–	–
	T8430	0.8	135	0.17	1.2	75	0.15	1.2	110	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.8	190	0.17	1.2	–	–	–	180	0.17	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	170	0.17	1.2	100	0.15	1.2	160	0.17	1.2	–	–	–	–	–	–	–	–	–

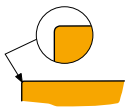
VCMW

PRAMET

	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



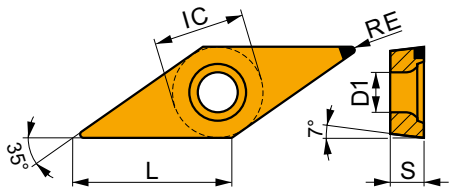
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
																				
适用于超精加工至中粗加工，连续至轻微断续切削。																				
VCMW 110302	**T5305**	0.2	–	–	–	–	–	–	170	0.08	1.2	–	–	–	–	–	–	35	0.15	1.0
	T5315	0.2	–	–	–	–	–	–	145	0.08	1.2	–	–	–	–	–	–	30	0.15	1.0
	T6310	0.2	–	–	–	–	–	–	70	0.08	1.2	–	–	–	–	–	–	15	0.15	1.0
VCMW 110304	**T5305**	0.4	–	–	–	–	–	–	165	0.10	1.2	–	–	–	–	–	–	35	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	145	0.10	1.2	–	–	–	–	–	–	30	0.15	1.0
	T6310	0.4	–	–	–	–	–	–	70	0.10	1.2	–	–	–	–	–	–	15	0.15	1.0
VCMW 160404	**T5305**	0.4	–	–	–	–	–	–	165	0.10	1.5	–	–	–	–	–	–	35	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	140	0.10	1.5	–	–	–	–	–	–	30	0.15	1.0
	T6310	0.4	–	–	–	–	–	–	70	0.10	1.5	–	–	–	–	–	–	15	0.15	1.0
VCMW 160408	**T5305**	0.8	–	–	–	–	–	–	155	0.18	1.5	–	–	–	–	–	–	30	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	135	0.18	1.5	–	–	–	–	–	–	25	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	70	0.18	1.5	–	–	–	–	–	–	15	0.15	1.0

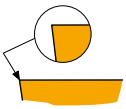
VCMW PCD

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。

产品型号		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	–	–	–	–	–	–

SVAC(RL)-DC EXT

P M K N S H

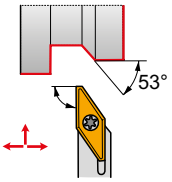
PRAMET

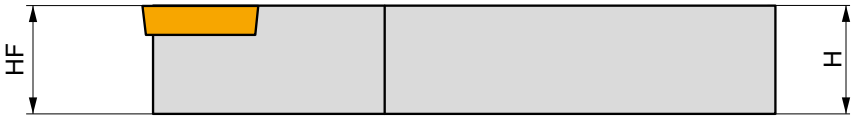
S

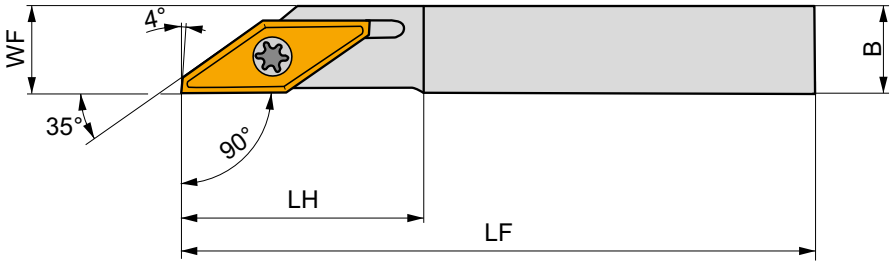


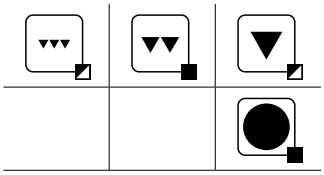
外圆用螺钉夹紧瑞士式车刀杆，使用VCGX13刀片，主偏角为90°。

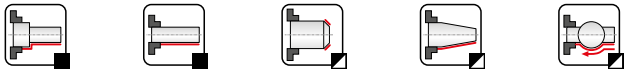
外圆用左/右手持车刀杆，螺钉锁紧式。使用VCGX13瑞士类型正前角刀片。适用于外圆表面，有阶梯外圆的轴向车削，锥面，仿形车削角度最大为53°，和倒角车削。可提供10x10至25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SVACR 1010 L 13-DC**	10	10	10	10	140	25	0	0	0.12	GI222	SV20
	SVACR 1212 L 13-DC	12	12	12	12	140	25	0	0	0.17	GI222	SV20
	SVACR 1616 M 13-DC	16	16	16	16	150	25	0	0	0.29	GI222	SV20
	SVACR 2020 M 13-DC	20	20	20	20	150	25	0	0	0.46	GI222	SV20
	SVACR 2525 M 13-DC	25	25	25	25	150	25	0	0	0.67	GI222	SV20
L	**SVACL 1010 L 13-DC**	10	10	10	10	140	25	0	0	0.10	GI222	SV20
	SVACL 1212 L 13-DC	12	12	12	12	140	25	0	0	0.19	GI222	SV20
	SVACL 1616 M 13-DC	16	16	16	16	150	25	0	0	0.29	GI222	SV20
	SVACL 2020 M 13-DC	20	20	20	20	150	25	0	0	0.43	GI222	SV20
	SVACL 2525 M 13-DC	25	25	25	25	150	25	0	0	0.67	GI222	SV20

GI222	VCGX 1303..

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

SVGC(RL) EXT

P M K N S H

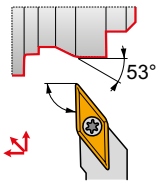
PRAMET

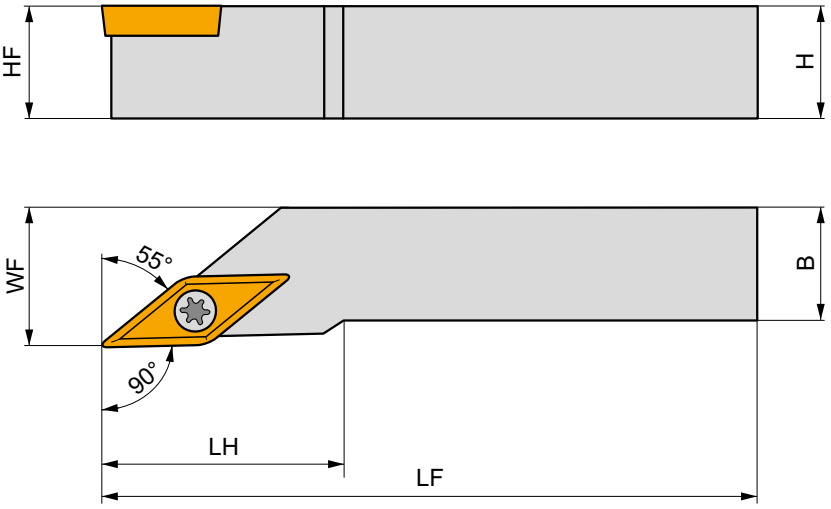
S

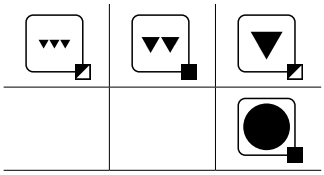


外圆用螺钉夹紧式车刀杆，使用VC..刀片，主偏角为90°。

外圆用左/右手持式车刀杆，螺钉锁紧式。使用VC..07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53°，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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SVGCR 0808 K 07**	8	8	8	8.5	125	15	0	0	0.07	GI234	SV23
	SVGCR 1010 M 07	10	10	10	10.5	150	15	0	0	0.13	GI234	SV23
	SVGCR 1212 M 07	12	12	12	12.5	150	18	0	0	0.17	GI234	SV23
	SVGCR 1616 P 07	16	16	16	16.3	170	23	0	0	0.33	GI234	SV23
L	**SVGCL 0808 K 07**	8	8	8	8.5	125	15	0	0	0.07	GI234	SV23
	SVGCL 1010 M 07	10	10	10	10.5	150	15	0	0	0.13	GI234	SV23
	SVGCL 1212 M 07	12	12	12	12.5	150	18	0	0	0.17	GI234	SV23
	SVGCL 1616 P 07	16	16	16	16.3	170	23	0	0	0.33	GI234	SV23

GI234	VC.. 0702..

SV23	DVF 3584	0.6 Nm	M 2	5.5	DMD 1650

SVHB(C)(RL) EXT

P M K N S H

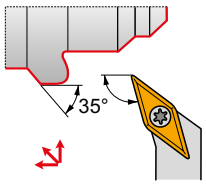
PRAMET

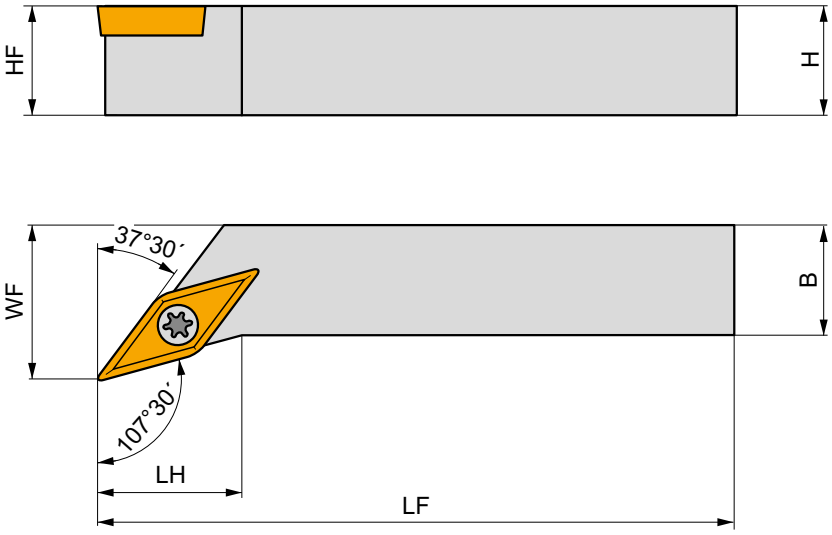
S

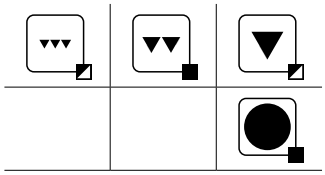


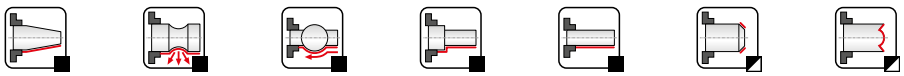
外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为107.5°。

外圆用左/右手持式车刀杆，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。









	产品型号	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	0.21	GI194	S01
	SVHCR 2020 K 16-M-A	20	20	20	25	125	20	0	0	0.40	GI017	SV10
	SVHCR 2525 M 16-M-A	25	25	25	32	150	20	0	0	0.68	GI017	SV10
L	**SVHBL 1616 H 11**	16	16	16	20	100	14	0	0	0.19	GI194	S01
	SVHCL 2020 K 16-M-A	20	20	20	25	125	20	0	0	0.40	GI017	SV10
	SVHCL 2525 M 16-M-A	25	25	25	32	150	20	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

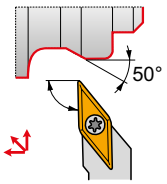
PRAMET

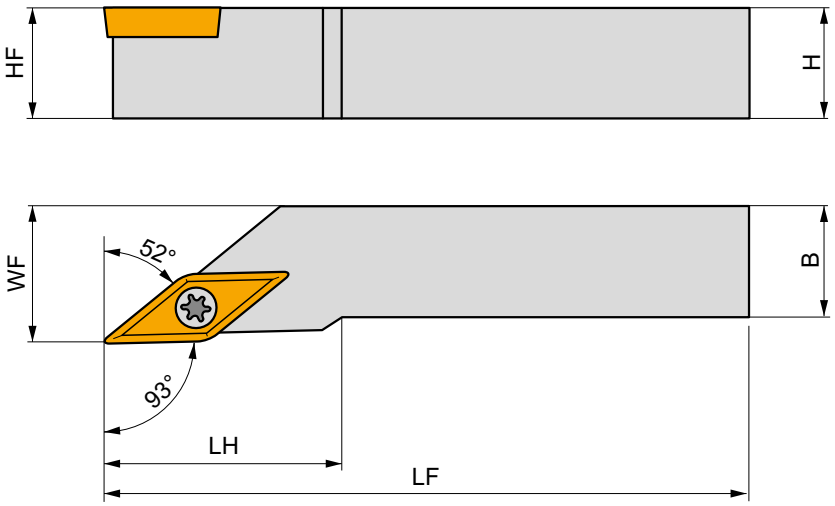
S

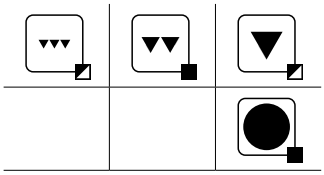


外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为93°。

外圆用左/右手持式车刀杆，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，最大的仿形车削角度最大为50°，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。









	产品型号	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	0.09	GI194	S01
	SVJBR 1616 H 11	16	16	16	20	100	20	0	0	0.20	GI194	S01
	SVJCR 1212 N 13	12	12	12	16	160	27	0	0	0.19	GI211	SV21
	SVJCR 1616 H 13	16	16	16	20	100	30	0	0	0.20	GI211	SV21
	SVJCR 2020 K 13	20	20	20	25	125	30	0	0	0.37	GI211	SV22
	SVJCR 2525 M 13	25	25	25	32	150	30	0	0	0.67	GI211	SV22
	SVJCR 2020 K 16-M-A	20	20	20	25	125	28	0	0	0.35	GI017	SV10
	SVJCR 2525 M 16-M-A	25	25	25	32	150	32	0	0	0.68	GI017	SV10
	SVJCR 3225 P 16-M-A	32	25	32	32	170	32	0	0	0.99	GI017	SV10
L	SVJBL 1212 F 11	12	12	12	16	80	20	0	0	0.09	GI194	S01
	SVJBL 1616 H 11	16	16	16	20	100	20	0	0	0.19	GI194	S01
	SVJCL 1212 N 13	12	12	12	16	160	27	0	0	0.19	GI211	SV21
	SVJCL 1616 H 13	16	16	16	20	100	30	0	0	0.20	GI211	SV21
	SVJCL 2020 K 13	20	20	20	25	125	30	0	0	0.37	GI211	SV22
	SVJCL 2525 M 13	25	25	25	32	150	30	0	0	0.67	GI211	SV22
	SVJCL 2020 K 16-M-A	20	20	20	25	125	28	0	0	0.40	GI017	SV10
	SVJCL 2525 M 16-M-A	25	25	25	32	150	32	0	0	0.70	GI017	SV10
	SVJCL 3225 P 16-M-A	32	25	32	32	170	32	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
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

SVJC(RL)-DC EXT

P M K N S H

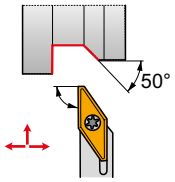
PRAMET

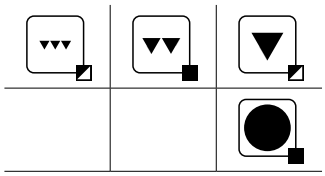
S



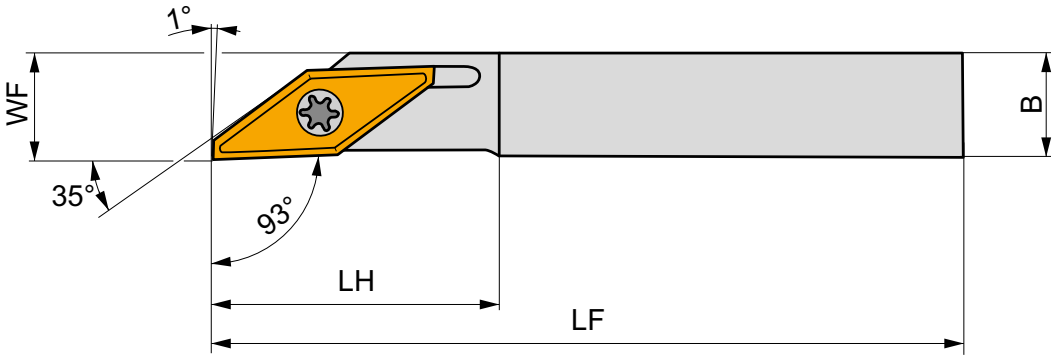
外圆用螺钉夹紧瑞士式车刀杆，使用VCGX13刀片，主偏角为93°。

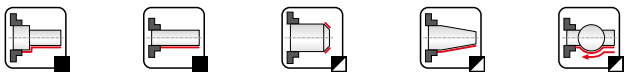
外圆用左/右手持车刀杆，螺钉锁紧式。使用VCGX 13瑞士类型的正前角刀片。适用于外圆表面，有阶梯外圆的轴向车削，锥面，仿形车削角度最大为50°，和倒角车削。可提供10x10至25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SVJCR 1010 L 13-DC**	10	10	10	0	140	25	0	0	0.12	GI222	SV20
	SVJCR 1212 L 13-DC	12	12	12	0	140	25	0	0	0.17	GI222	SV20
	SVJCR 1616 M 13-DC	16	16	16	0	150	25	0	0	0.29	GI222	SV20
	SVJCR 2020 M 13-DC	20	20	20	0	150	25	0	0	0.45	GI222	SV20
	SVJCR 2525 M 13-DC	25	25	25	0	150	25	0	0	0.68	GI222	SV20
L	**SVJCL 1010 L 13-DC**	10	10	10	0	140	25	0	0	0.12	GI222	SV20
	SVJCL 1212 L 13-DC	12	12	12	0	140	25	0	0	0.17	GI222	SV20
	SVJCL 1616 M 13-DC	16	16	16	0	150	25	0	0	0.30	GI222	SV20
	SVJCL 2020 M 13-DC	20	20	20	0	150	25	0	0	0.47	GI222	SV20
	SVJCL 2525 M 13-DC	25	25	25	0	150	25	0	0	0.69	GI222	SV20

GI222	VCGX 1303..

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

SVPB(C)(RL) EXT

P M K N S H

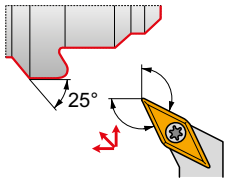
PRAMET

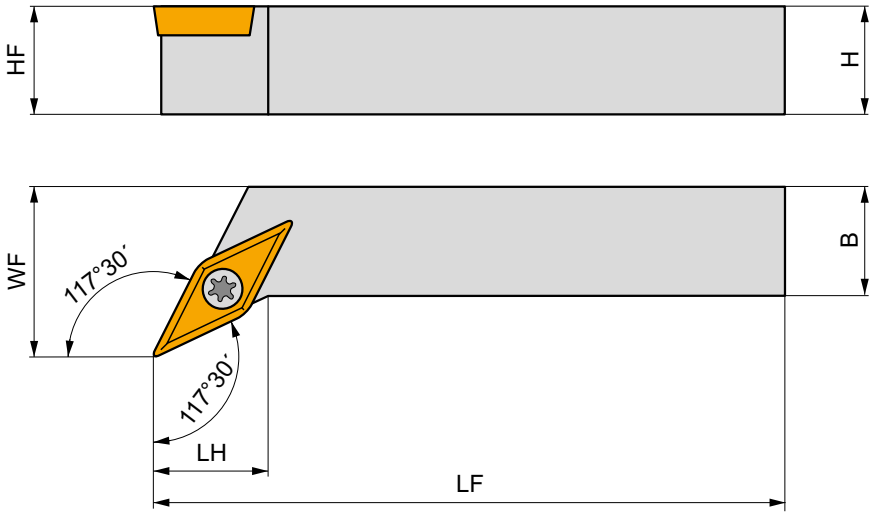
S

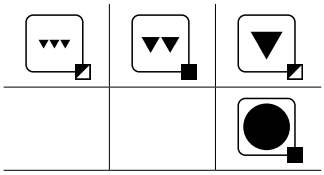


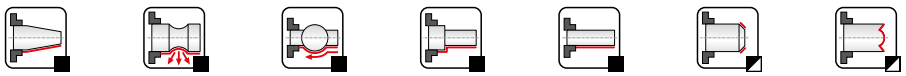
外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为117.5°。

外圆用左/右手持式车刀杆，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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SVPBR 1616 H 11**	16	16	16	20	100	12	0	0	0.20	GI194	S01
	SVPBR 2020 K 11	20	20	20	25	125	12	0	0	0.41	GI194	S01
	SVPCR 2020 K 16-M-A	20	20	20	25	125	20	0	0	0.40	GI017	SV10
	SVPCR 2525 M 16-M-A	25	25	25	32	150	25	0	0	0.75	GI017	SV10
	SVPCR 3225 P 16-M-A	32	25	32	32	170	25	0	0	1.10	GI017	SV10
L	**SVPBL 1616 H 11**	16	16	16	20	100	12	0	0	0.20	GI194	S01
	SVPBL 2020 K 11	20	20	20	25	125	12	0	0	0.39	GI194	S01
	SVPCL 2020 K 16-M-A	20	20	20	25	125	20	0	0	0.70	GI017	SV10
	SVPCL 2525 M 16-M-A	25	25	25	32	150	25	0	0	0.70	GI017	SV10
	SVPCL 3225 P 16-M-A	32	25	32	32	170	25	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

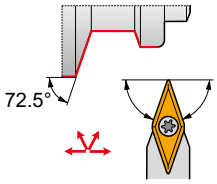
PRAMET

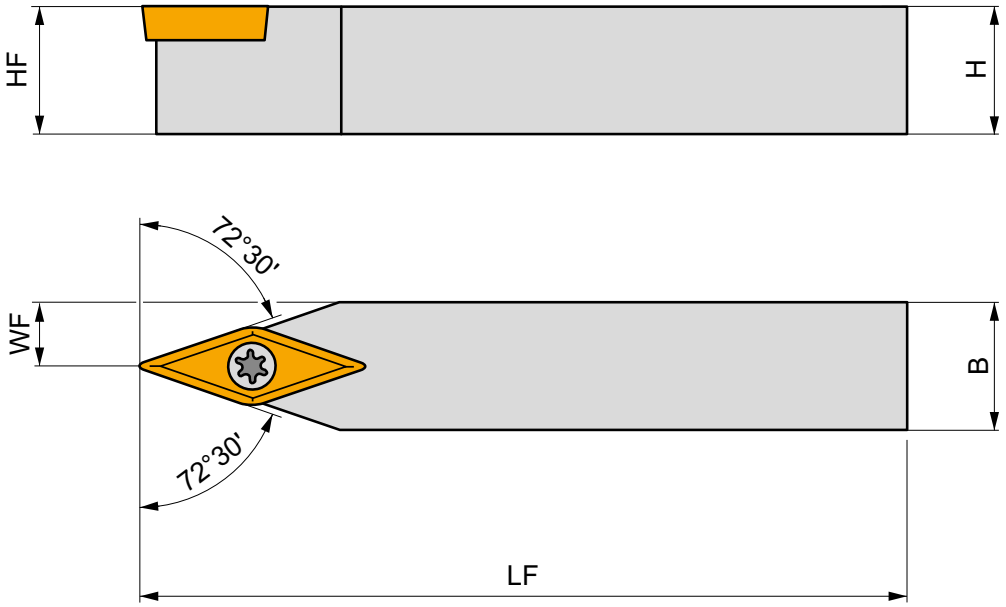
S

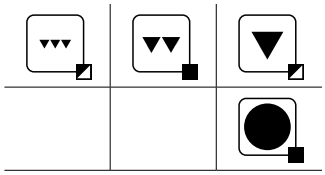


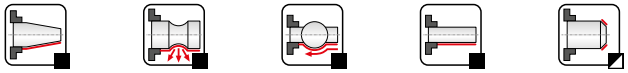
外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为72.5°。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	**SVVBN 1212 F 11**	12	12	12	6	80	–	0	0	0.11	GI194	S01
	SVVBN 1616 H 11	16	16	16	8	100	–	0	0	0.18	GI194	S01
	SVVBN 2020 K 11	20	20	20	10	125	–	0	0	0.38	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	0.68	GI017	SV10
	SVVCN 3225 P 16-M-A	32	25	32	12.5	170	–	0	0	0.98	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

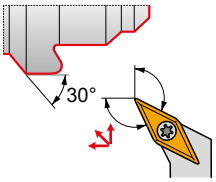
PRAMET

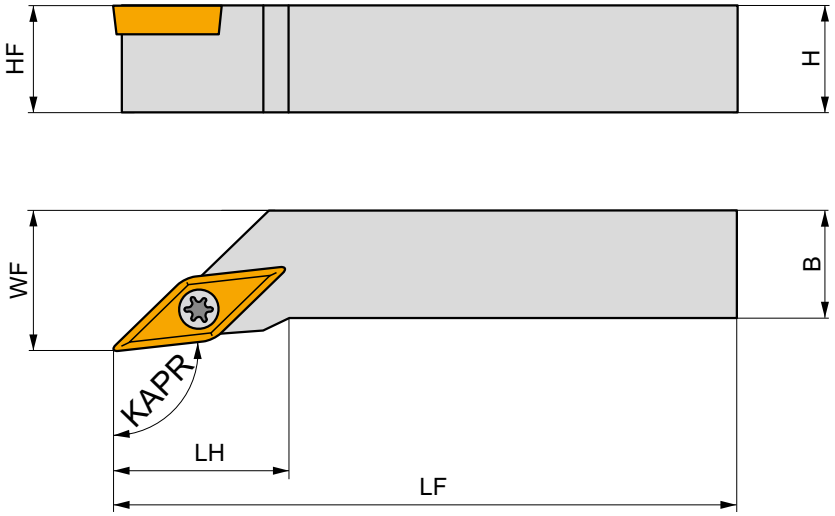
S

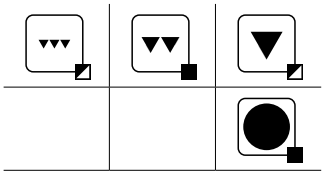


外圆用螺钉夹紧式车刀杆，使用VB/VC..刀片，主偏角为98/113°。

外圆用左/右手持式车刀杆，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。









	产品型号	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	98	0	0	0.09	GI194	SO1
	SVXBR 1616 H 11	16	16	16	20	100	14	98	0	0	0.19	GI194	SO1
	SVXCR 2020 K 13	20	20	20	25	125	12	113	0	0	0.38	GI211	SV22
	SVXCR 2020 K 16-M-A	20	20	20	25	125	28	98	0	0	0.41	GI017	SV10
	SVXCR 2525 M 16-M-A	25	25	25	32	150	32	98	0	0	0.68	GI017	SV10
	SVXCR 3225 P 16-M-A	32	25	32	32	170	32	98	0	0	1.00	GI017	SV10
L	SVXBL 1212 F 11	12	12	12	16	80	20	98	0	0	0.09	GI194	SO1
	SVXBL 1616 H 11	16	16	16	20	100	14	98	0	0	0.19	GI194	SO1
	SVXCL 2020 K 13	20	20	20	25	125	12	113	0	0	0.38	GI211	SV22
	SVXCL 2020 K 16-M-A	20	20	20	25	125	28	98	0	0	0.38	GI017	SV10
	SVXCL 2525 M 16-M-A	25	25	25	32	150	32	98	0	0	0.69	GI017	SV10
	SVXCL 3225 P 16-M-A	32	25	32	32	170	32	98	0	0	0.99	GI017	SV10

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

		Nm						
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
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

NEW

C.-SVHB(RL) EXT

P M K N S H

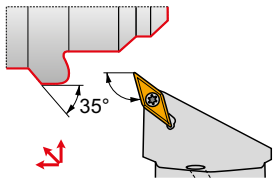
PRAMET

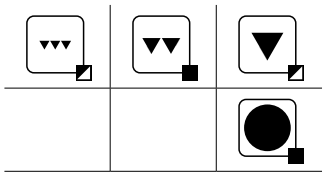
S

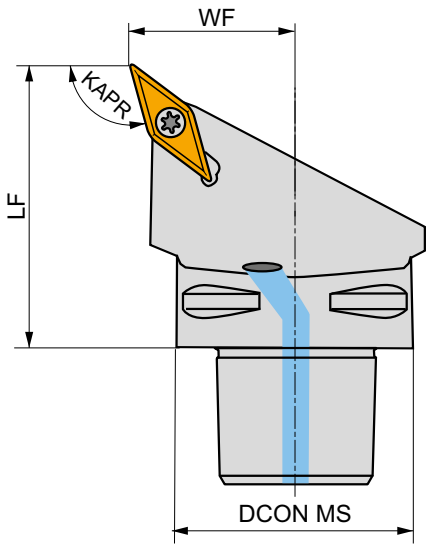


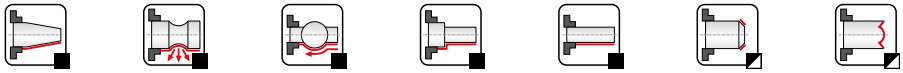
外圆用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为107.5°。

外圆用左/右手动刀具，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。









	产品型号	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

NEW

C.-SVJB(RL) EXT

P M K N S H

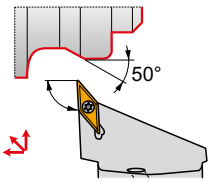
PRAMET

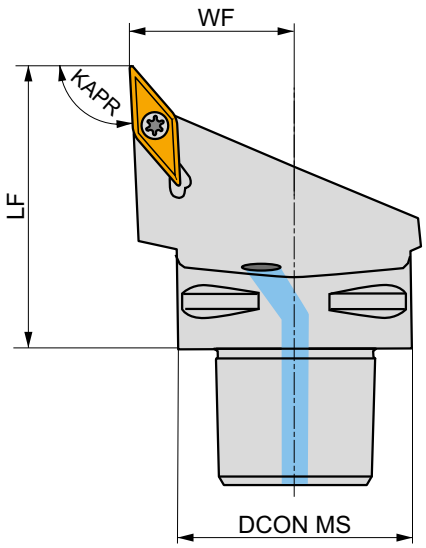
S

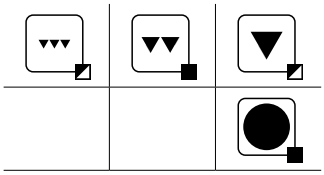


外圆用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为93°。

外圆用左/右手动刀具，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。









	产品型号	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	✓	0.35	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

NEW

C.-SVVBN EXT

P M K N S H

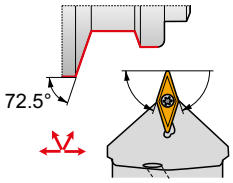
PRAMET

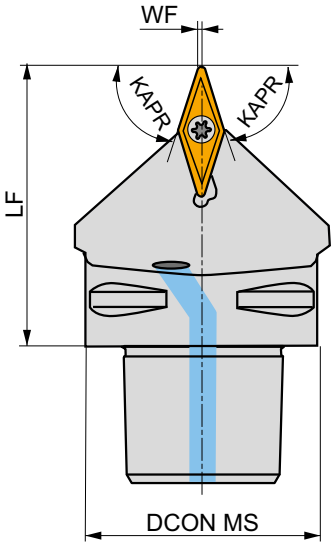
S

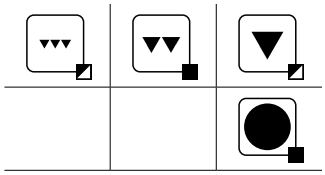


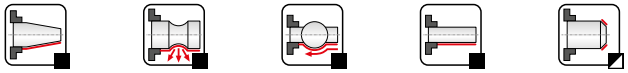
外圆用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为72.5°。

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。









	产品型号	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

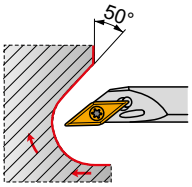
PRAMET

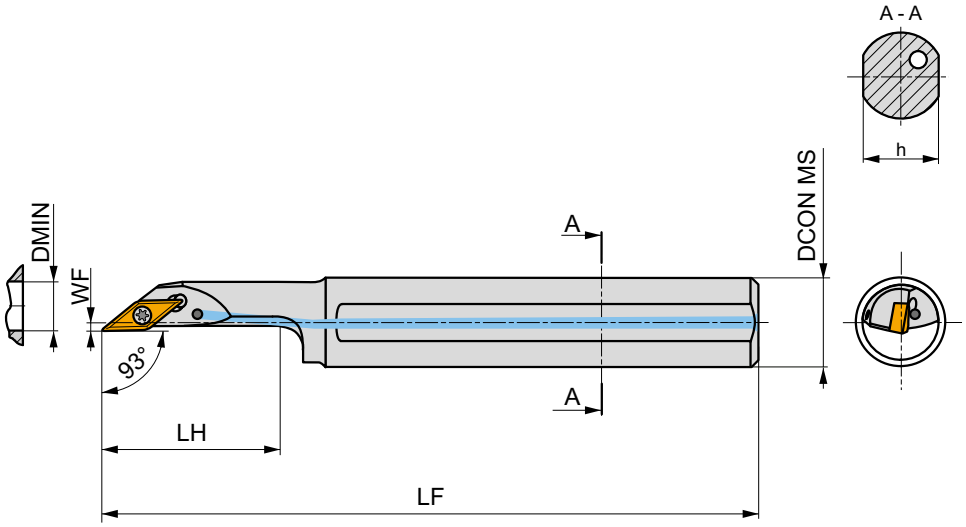
S

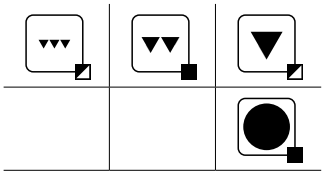


内孔用螺钉夹紧式镗杆，使用VB/VC..刀片，主偏角为93°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为93°，使用VB..11和VC..11刀片。内孔最小加工直径为Ø25mm。适用于50°以下的端面仿形车削。可提供Ø20和Ø25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	-5	-5	✓	0.44	GI194	S07
	A25S-SVJBR 11	25	32	3.5	23	250	50	-5	-5	✓	0.82	GI194	S07
L	**A20R-SVJBL 11**	20	25	2	18	200	40	-5	-5	✓	0.42	GI194	S07
	A25S-SVJBL 11	25	32	3.5	23	250	50	-5	-5	✓	0.82	GI194	S07

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

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

SVLC(RL) INT

P M K N S H

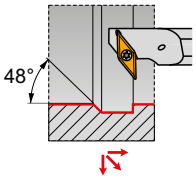
PRAMET

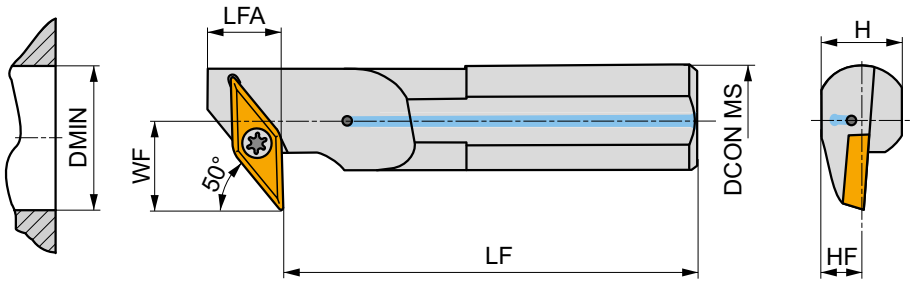
S

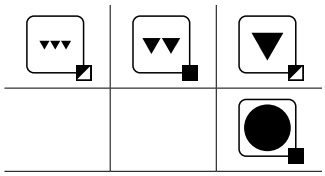


内孔用螺钉夹紧式镗杆，使用VC..刀片，主偏角为50°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为50°，使用VC..13刀片。内孔最小加工直径为Ø27mm泛，广泛的应用于内孔拉削应用， 和48°以下的仿形车削。可提供Ø20至Ø32mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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

SVQB(C)(RL) INT

P M K N S H

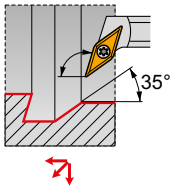
PRAMET

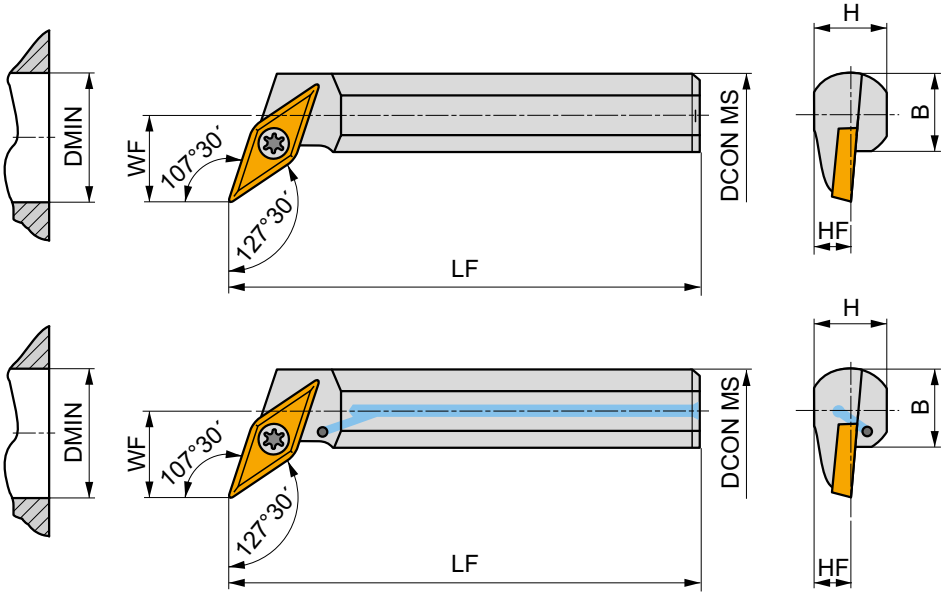
S

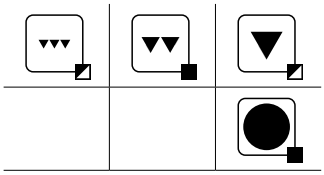


内孔用螺钉夹紧式镗杆，使用VB/VC..刀片，主偏角为107.5°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为107.5°，使用VB../VC..11和16刀片。内孔最小加工直径为Ø20mm。广泛的应用于内孔车削。可提供Ø16至Ø40mm的刀柄。









	产品型号	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	✓	0.58	GI194	S01
	A16R-SVQCR 13	16	21	11	15	15	200	-6	0	✓	0.30	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	–	1.10	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	✓	0.33	GI194	S01
	A20S-SVQBL 11	20	25	13	18	18.5	250	-4	0	✓	0.58	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	–	1.09	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

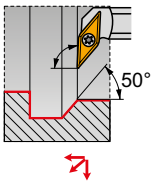
PRAMET

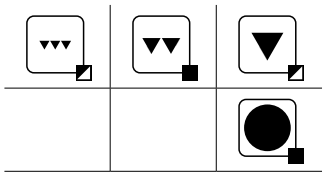
S

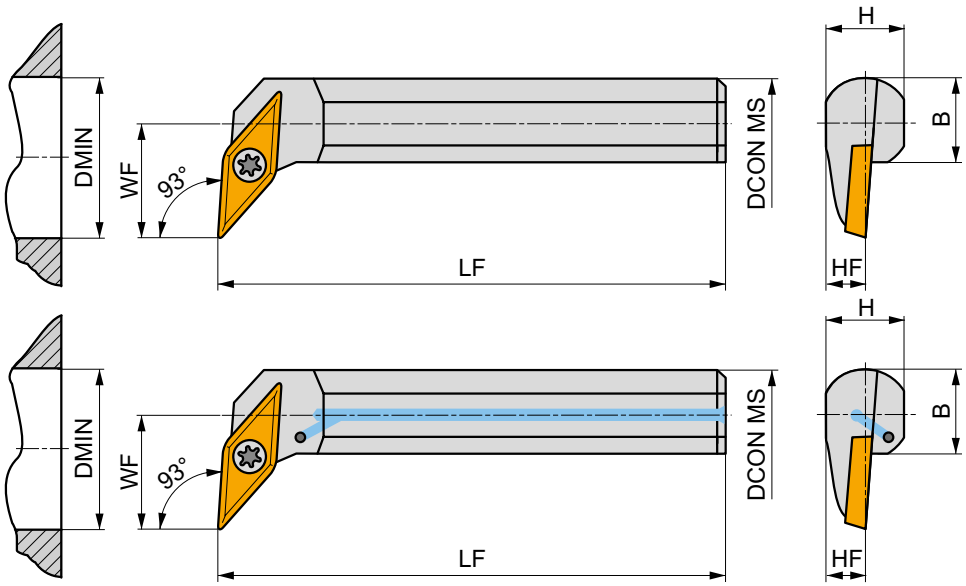


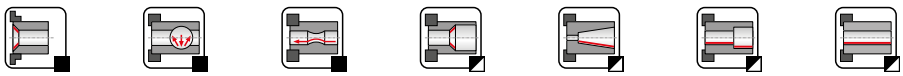
内孔用螺钉夹紧式镗杆，使用VB/VC..刀片，主偏角为93°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为93°，使用VB../VC..11和16刀片。内孔最小加工直径为Ø20mm。广泛的应用于内孔车削，和50°以下的仿形车削。可提供Ø16至Ø40mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	✓	0.34	GI194	S01
	A20S-SVUBR 11	20	25	13	18	18.8	250	-4	0	✓	0.58	GI194	S01
	A20S-SVUCR 13	20	25	13	19	18.5	250	-4	2	✓	0.40	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	✓	1.70	GI211	SV22
	S25T-SVUCR 16	25	32	17	23	23	300	-7	0	–	1.10	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	✓	0.34	GI194	S01
	A20S-SVUBL 11	20	25	13	18	18.5	250	-4	0	✓	0.58	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	✓	1.70	GI211	SV22
	S25T-SVUCL 16	25	32	17	23	23	300	-7	0	–	1.10	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

SVXC(RL) INT

P M K N S H

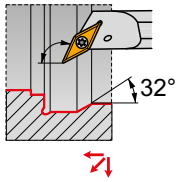
PRAMET

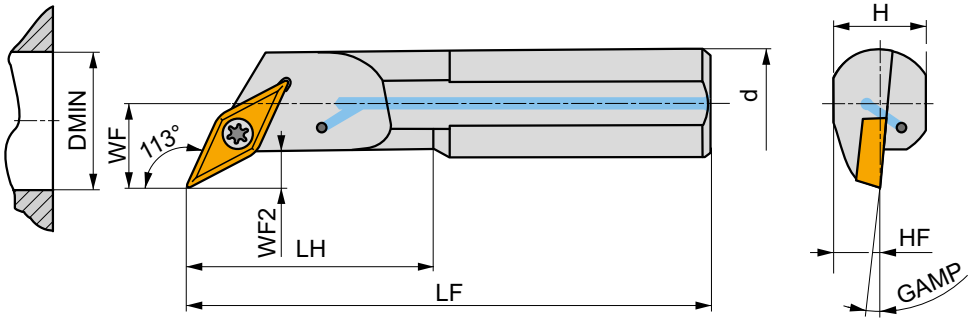
S

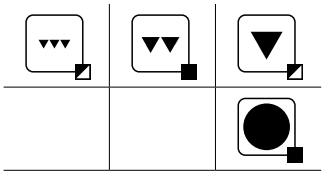


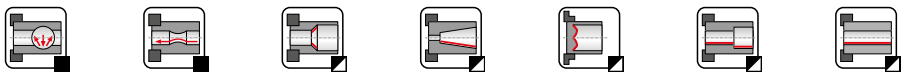
内孔用螺钉夹紧式镗杆，使用VC..刀片，主偏角为113°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为113°，使用VC..07刀片。内孔最小加工直径为Ø12.5mm。广泛的应用于内孔车削，和32°以下的仿形车削。可提供Ø10至Ø16mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	HF (mm)	LH (mm)	WF2 (mm)	GAMP (°)		kg		
R	**A10H-SVXCR 07**	10	12.5	7	9	100	4.5	22	3	-10	✓	0.06	GI234	SV23
	A12K-SVXCR 07	12	15.5	9	11	125	5.5	28	3	-8	✓	0.11	GI234	SV23
	A16M-SVXCR 07	16	17.5	11	15	150	7.5	36	3	-6	✓	0.19	GI234	SV23
L	**A10H-SVXCL 07**	10	12.5	7	9	100	4.5	22	3	-10	✓	0.06	GI234	SV23
	A12K-SVXCL 07	12	15.5	9	11	125	5.5	28	3	-8	✓	0.11	GI234	SV23
	A16M-SVXCL 07	16	17.5	11	15	150	7.5	36	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

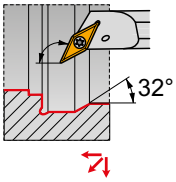
PRAMET

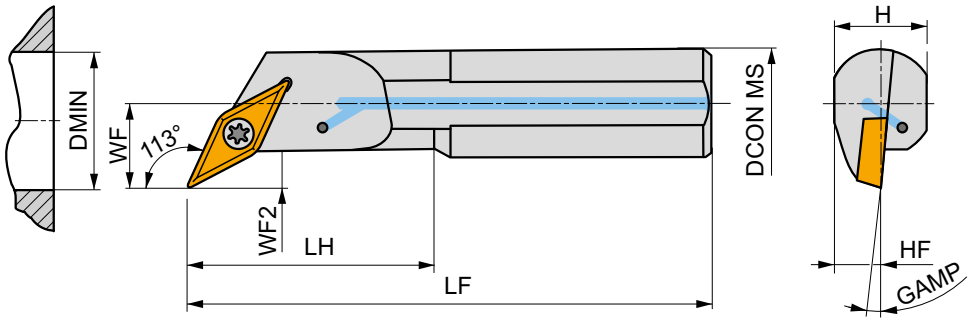
S

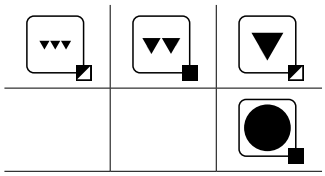


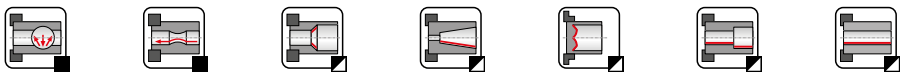
内孔用螺钉夹紧式硬质合金镗杆，使用VC..刀片，主偏角为113°。

内孔用左/右手硬质合金镗杆，有内冷通道，螺钉锁紧式。主偏角为113°，使用VC..07刀片。内孔最小加工直径为Ø12.5mm。广泛的应用于内孔车削，和32°以下的仿形车削。可提供Ø10至Ø16mm的刀柄。刀具悬伸>3xD。









	产品型号	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	WF2 (mm)	GAMP (°)		kg		
R	**E10H-SVXCR 07**	10	12.5	7	9	4.5	100	22	3	-10	✓	0.10	GI234	SV23
	E12K-SVXCR 07	12	15.5	9	11	5.5	125	28	3	-8	✓	0.19	GI234	SV23
	E16M-SVXCR 07	16	17.5	11	15	7.5	150	36	3	-6	✓	0.33	GI234	SV23
L	**E10H-SVXCL 07**	10	12.5	7	9	4.5	100	22	3	-10	✓	0.10	GI234	SV23
	E12K-SVXCL 07	12	15.5	9	11	5.5	125	28	3	-8	✓	0.19	GI234	SV23
	E16M-SVXCL 07	16	17.5	11	15	7.5	150	36	3	-6	✓	0.33	GI234	SV23

GI234	VC.. 0702..

		Nm			
SV23	DVF 3584	0.6	M 2	5.5	DMD 1650

NEW

C.-SVQB(RL) INT

P M K N S H

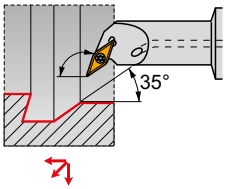
PRAMET

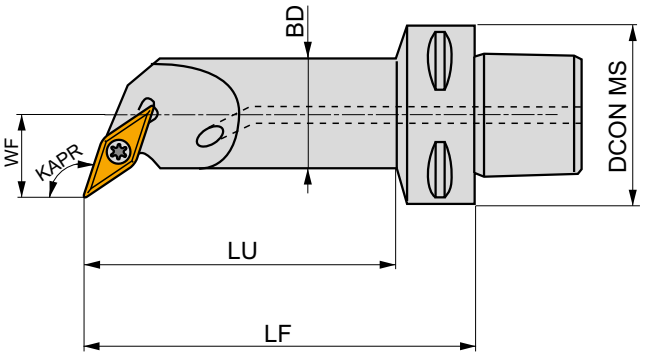
S

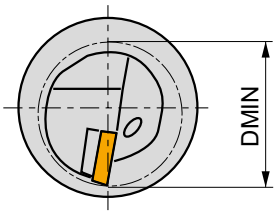


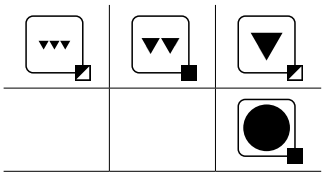
内孔用PSC快速更换式刀柄，螺钉夹紧式，使用VB/VC..刀片，主偏角为107.5°。

内孔用左/右手动刀具，有内冷通道，螺钉锁紧式。主偏角107.5°，使用VB..16或VC..16刀片。内孔最小加工直径为Ø33mm。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。











	产品型号	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
	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
	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 Nm	M 3.5	10.1	FLAG T15P/3,5

WC

02/ 06/ 08/ 16

硬质合金刀片

WCGT



212

WCGX



213

WCMT



213

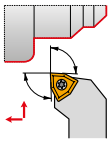
匹配正确的尺寸（示例）

刀片	刀杆
WCGT 020102E-FF2	A0508H-SWUCR 02

ISO 外圆车削

SWLC(RL) EXT

95°



16×16
25×25

WC..
06
08

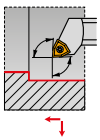
215

212 – 214

ISO内孔车削

SWLC(RL) INT

95°



ØDmin 25/40

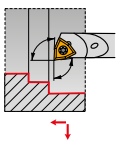
WC..
06
08

216

212 – 214

SWUC(RL) INT

93°



ØDmin 5,8/7,8

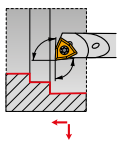
WC..
02

217

212 – 214

SWUC(RL)-E INT

93°



ØDmin 5,8/7,8

WC..
02

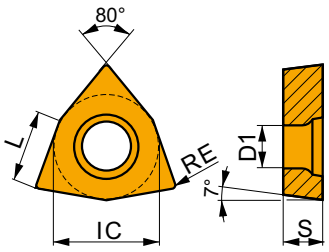
218

212 – 214

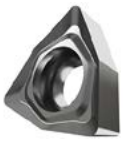
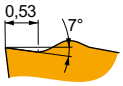
WCGT

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0201	3.970	2.20	2.70	1.59
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



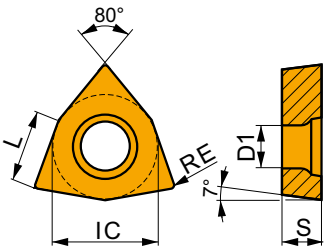
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
AL断屑槽，具有大正前角设计，适用于精加工至粗加工，连续切削至轻微断续切削。																				
WCGT 06T302F-AL	**HF7**	0.2	–	–	–	–	–	–	–	–	–	■ 450	0.12	1.0	–	–	–	–	–	–
WCGT 06T304F-AL	**HF7**	0.4	–	–	–	–	–	–	–	–	–	■ 360	0.24	1.0	–	–	–	–	–	–
	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	–	–	–	–	–	–
	T0315	1.2	–	–	–	–	–	–	–	–	–	■ 375	0.72	2.4	–	–	–	–	–	–
																				
FF2断屑槽，具有正前角设计，适用于超精加工至精加工，连续切削至轻微断续切削。																				
WCGT 020102E-FF2	**HF7**	0.2	–	–	–	–	–	–	■ 210	0.05	0.8	–	–	–	–	–	–	–	–	–
	T8330	0.2	■ 205	0.05	0.8	–	–	–	■ 190	0.05	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.2	■ 280	0.05	0.8	–	–	–	◪ 230	0.05	0.8	–	–	–	–	–	–	–	–	–
	TT010	0.2	■ 345	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WCGT 020104E-FF2	**HF7**	0.4	–	–	–	–	–	–	■ 155	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 170	0.12	0.8	–	–	–	■ 160	0.12	0.8	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 205	0.12	0.8	–	–	–	◪ 170	0.12	0.8	–	–	–	–	–	–	–	–	–
	TT010	0.4	■ 350	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

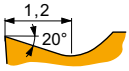
WCGX

PRAMET

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



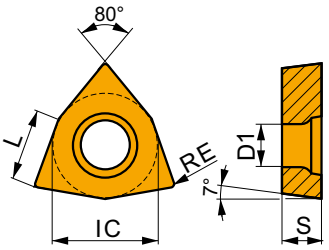
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			F																	
			JZ断屑槽，左手设计，适用于超精加工，连续切削。																	
WCGX 020102FL-JZ	**TT010**	0.2	■ 330	0.06	0.5	◪ 195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

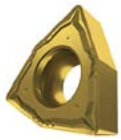
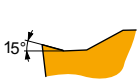
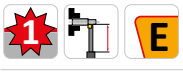
WCMT

PRAMET

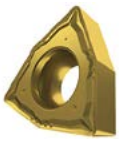
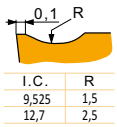
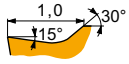
	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



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。

产品型号		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，适用于精加工至中粗加工，连续切削至轻微断续切削。																	
WCMT 06T304E-FM	**T7325**	0.4	◪ 195	0.15	1.2	■ 150	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.4	◪ 190	0.15	1.2	■ 145	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	◪ 180	0.15	1.2	■ 105	0.14	1.2	◪ 170	0.15	1.2	◪ 540	0.18	1.2	–	–	–	–	–	–
	T8330	0.4	■ 170	0.15	1.2	■ 100	0.14	1.2	◪ 160	0.15	1.2	◪ 510	0.18	1.2	–	–	–	–	–	–
	T8430	0.4	■ 200	0.15	1.2	■ 110	0.14	1.2	◪ 165	0.15	1.2	◪ 555	0.18	1.2	–	–	–	–	–	–
	T9315	0.4	■ 275	0.15	1.2	–	–	–	◪ 260	0.15	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 245	0.15	1.2	■ 145	0.15	1.2	◪ 230	0.15	1.2	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM	**T7325**	0.8	◪ 215	0.20	1.2	■ 165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪ 205	0.20	1.2	■ 155	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	◪ 195	0.20	1.2	■ 115	0.18	1.2	◪ 185	0.20	1.2	◪ 585	0.24	1.2	–	–	–	–	–	–
	T8330	0.8	■ 185	0.20	1.2	■ 110	0.18	1.2	◪ 175	0.20	1.2	◪ 555	0.24	1.2	–	–	–	–	–	–
	T8430	0.8	■ 210	0.20	1.2	■ 115	0.18	1.2	◪ 175	0.20	1.2	◪ 585	0.24	1.2	–	–	–	–	–	–
	T9315	0.8	■ 290	0.20	1.2	–	–	–	◪ 275	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 260	0.20	1.2	■ 155	0.18	1.2	◪ 245	0.20	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。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
			FM断屑槽，适用于精加工至中粗加工，连续切削至轻微断续切削。																	
WCMT 080404E-FM	**T7325**	0.4	190	0.15	1.7	145	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	170	0.15	1.7	100	0.14	1.7	160	0.15	1.7	510	0.18	1.7	–	–	–	–	–	–
	T8330	0.4	165	0.15	1.7	95	0.14	1.7	155	0.15	1.7	495	0.18	1.7	–	–	–	–	–	–
	T8430	0.4	195	0.15	1.7	105	0.14	1.7	160	0.15	1.7	540	0.18	1.7	–	–	–	–	–	–
	T9315	0.4	265	0.15	1.7	–	–	–	250	0.15	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	240	0.15	1.7	140	0.15	1.7	225	0.15	1.7	–	–	–	–	–	–	–	–	–
WCMT 080408E-FM	**T7325**	0.8	205	0.20	1.7	155	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	200	0.20	1.7	155	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–
	T8330	0.8	180	0.20	1.7	105	0.18	1.7	170	0.20	1.7	540	0.24	1.7	–	–	–	–	–	–
	T8430	0.8	205	0.20	1.7	110	0.18	1.7	170	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–
	T9315	0.8	280	0.20	1.7	–	–	–	265	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	250	0.20	1.7	150	0.18	1.7	235	0.20	1.7	–	–	–	–	–	–	–	–	–
WCMT 080412E-FM	**T8330**	1.2	175	0.27	1.7	105	0.24	1.7	165	0.27	1.7	525	0.32	1.7	–	–	–	–	–	–
	T8430	1.2	190	0.27	1.7	105	0.24	1.7	155	0.27	1.7	525	0.32	1.7	–	–	–	–	–	–
	T9325	1.2	235	0.27	1.7	140	0.24	1.7	220	0.27	1.7	–	–	–	–	–	–	–	–	–
	 I.C. 9,525 12,7 R 1,5 2,5																			
			RF断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
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	–	–	–	–	–	–	–	–	–	–	–	–
																				
			UR断屑槽，适用于精细的精加工，连续切削或轻微断续切削。																	
WCMT 06T308E-UR	**T7325**	0.8	185	0.20	1.2	140	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.8	250	0.20	1.2	–	–	–	235	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	225	0.20	1.2	135	0.18	1.2	210	0.20	1.2	–	–	–	–	–	–	–	–	–

SWLC(RL) EXT

P M K N S H

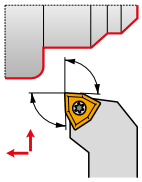
PRAMET

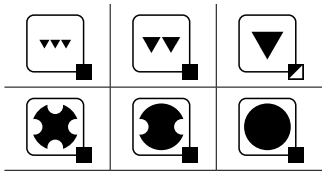
S

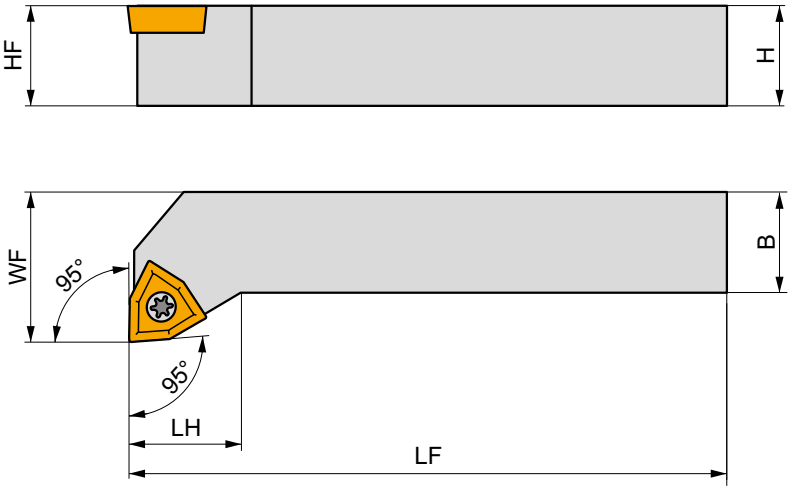


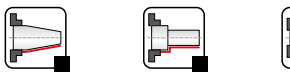
外圆用螺钉夹紧式车刀杆，使用WC..刀片，主偏角为95°

外圆用左/右手持式车刀杆，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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SWLCR 1616 H 06**	16	16	16	20	100	15	0	0	0.24	GI055	S04
	SWLCR 2020 K 06	20	20	20	25	125	15	0	0	0.40	GI055	S04
	SWLCR 2525 M 08	25	25	25	32	150	20	0	0	0.77	GI049	S09
L	**SWLCL 1616 H 06**	16	16	16	20	100	15	0	0	0.23	GI055	S04
	SWLCL 2020 K 06	20	20	20	25	125	15	0	0	0.40	GI055	S04
	SWLCL 2525 M 08	25	25	25	32	150	20	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

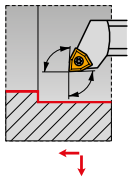
PRAMET

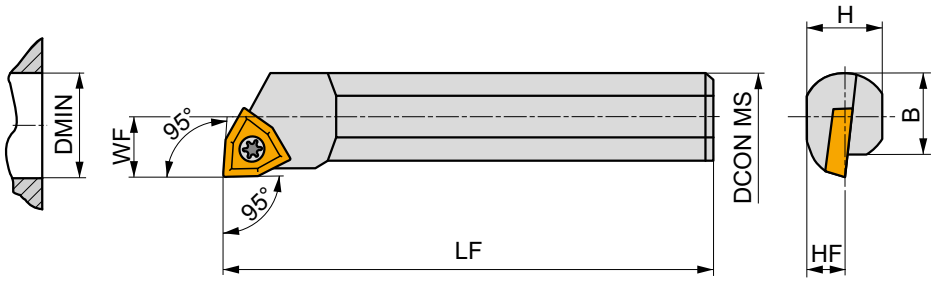
S

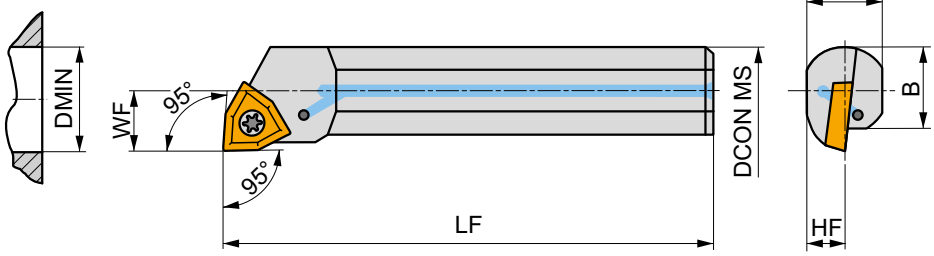


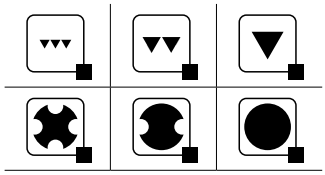
内孔用螺钉夹紧式镗杆，使用WC..刀片，主偏角为95°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为95°，使用WC..06和08刀片。内孔最小加工直径为Ø25mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø20至Ø32mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	–	0.62	GI055	S04
	A25R-SWLCR 06	25	32	17	23	23	200	-7	0	✓	0.70	GI055	S04
	S25T-SWLCR 06	25	32	17	23	23	300	-7	0	–	1.15	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	✓	0.70	GI055	S04
	S25T-SWLCL 06	25	32	17	23	23	300	-7	0	–	1.15	GI055	S04
	A25R-SWLCL 08	25	32	17	23	23	200	-7	0	✓	0.70	GI049	S04
	A32S-SWLCL 08	32	40	22	30	30	250	-5	0	✓	1.32	GI049	S09
	S32U-SWLCL 08	32	40	22	30	30	350	-5	0	–	4.10	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

SWUC(RL) INT

P M K N S H

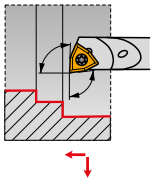
PRAMET

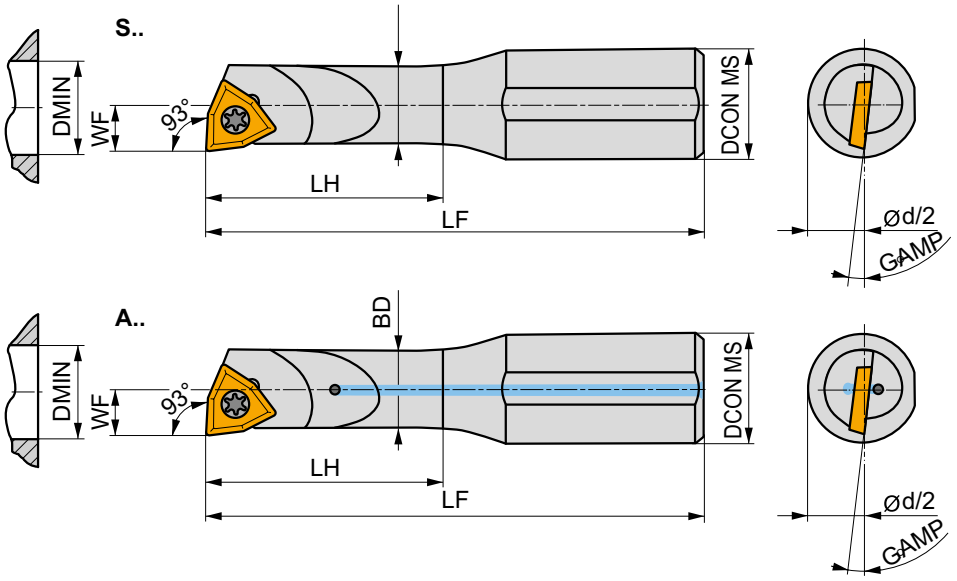
S

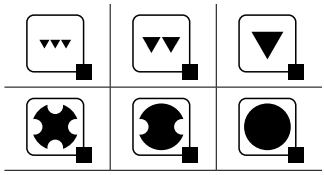


内孔用螺钉夹紧式镗杆，使用WC..刀片，主偏角为93°。

内孔用左/右手镗杆，有内冷通道，螺钉锁紧式。主偏角为93°，使用WC刀片。0201刀片。内孔最小加工直径为Ø5.8mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。。仅适用于Ø8mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	-17	✓	0.09	GI221	SW21
	S0508H-SWUCR 02	8	5.8	5	2.9	100	18	-17	–	0.04	GI221	SW21
	A0608H-SWUCR 02	8	7.8	6	3.9	100	24	-12	✓	0.04	GI221	SW21
	S0608H-SWUCR 02	8	7.8	6	3.9	100	24	-12	–	0.04	GI221	SW21
L	A0508H-SWUCL 02	8	5.8	5	2.9	100	18	-17	✓	0.04	GI221	SW21
	S0508H-SWUCL 02	8	5.8	5	2.9	100	18	-17	–	0.04	GI221	SW21
	A0608H-SWUCL 02	8	7.8	6	3.9	100	24	-12	✓	0.04	GI221	SW21
	S0608H-SWUCL 02	8	7.8	6	3.9	100	24	-12	–	0.04	GI221	SW21

GI221	WC.. 0201..

		Nm			
SW21	T20.037	0.6	M 2	3.7	DMD 1650

SWUC(RL)-E INT

P M K N S H

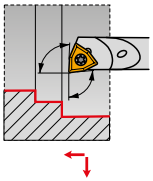
PRAMET

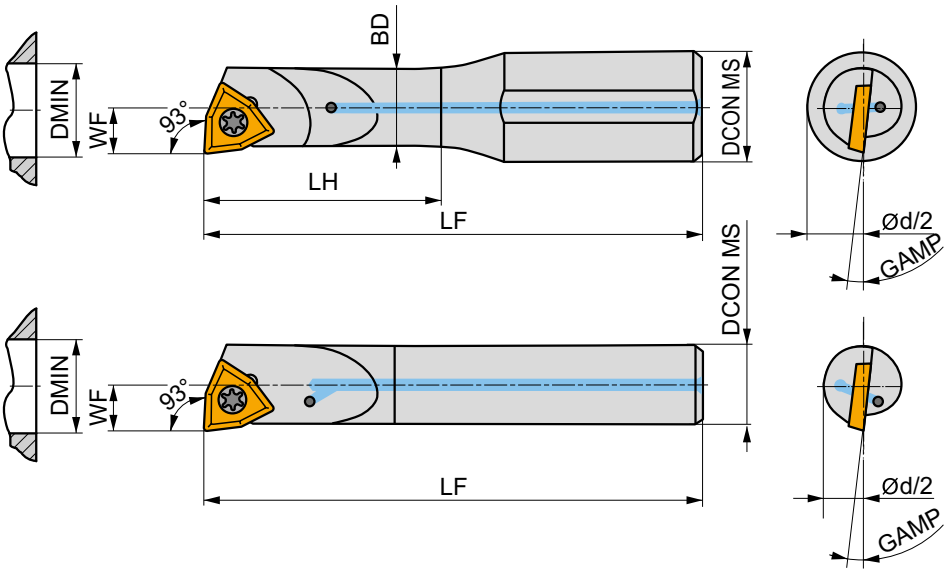
S

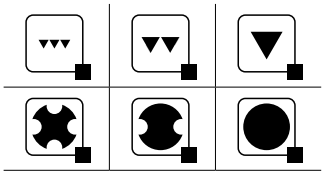


内孔用螺钉夹紧式硬质合金镗杆，使用WC..刀片，主偏角为93°

内孔用左/右手硬质合金镗杆，有内冷通道，螺钉锁紧式。主偏角为93°，使用WC..0201刀片。内孔最小加工直径为Ø5.8mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø5至Ø8mm的刀柄尺寸。刀具悬伸>3xD。









	产品型号	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	-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	-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	-17	✓	0.07	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	-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 Nm	M 2	3.7	DMD 1650



负前角刀片

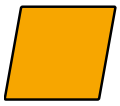
CN

09/ 12/ 16/ 19/ 25

硬质合金刀片

CNGG	CNMA	CNMG	CNMM
			
222	222	223	234

CER和CBN刀片

CNGA CER	CNGN CER	CNGA CBN
		
238	238	239

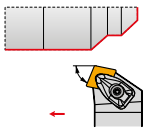
匹配正确的尺寸（示例）

刀片	刀杆
CNMM 120412E-OR	DCBNR 2525 M 12

ISO 外圆车削

DCBN(RL) EXT

75°



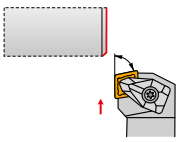
CN..: 12, 16, 19

20×20 / 40×40

240 | 222 – 239

DCKN(RL) EXT

75°



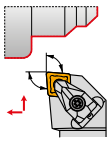
CN..: 12, 16

20×20 / 32×32

242 | 222 – 239

DCLN(RL) EXT

95°



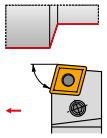
CN..: 09, 12, 16, 19

16×16 / 40×40

243 | 222 – 239

PCBN(RL) EXT

75°



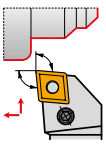
CN..: 12, 16, 19, 25

20×20 / 50×50

245 | 222 – 239

PCLN(RL) EXT

95°



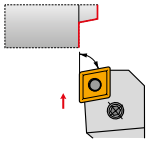
CN..: 12, 16, 19, 25

20×20 / 50×50

247 | 222 – 239

PCKN(RL) EXT

75°



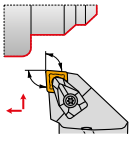
CN..: 12, 16, 19

20×20 / 40×40

246 | 222 – 239

C.-DCLN(RL) EXT NEW

95°



CN..: 12, 16, 19

C3 / C8

249 | 222 – 239

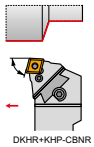
CN

09/ 12/ 16/ 19/ 25

ISO外圆重载车削

KHP-CBNR + DKH(RL)

75°





40×50
60×80

251, 253

CN..

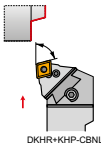


25

222 – 239

KHP-CBNL + DKH(RL)

75°





40×50
60×80

251, 253

CN..

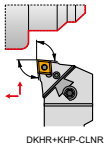


25

222 – 239

KHP-CLNR/L + DKH(RL)

95°





40×50
60×80

252, 253

CN..



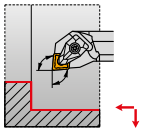
19
25

222 – 239

ISO内孔车削

DCLN(RL) INT

95°





32
50

254

CN..

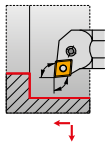


09
12

222 – 239

PCLN(RL) INT

95°





20
80

255

CN..

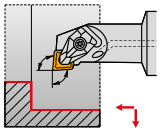


09
12
16
19

222 – 239

C.-DCLN(RL) INT NEW

95°





25
50

257

CN..



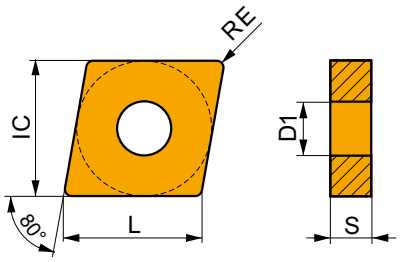
09
12
16

222 – 239

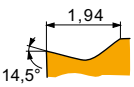
CNGG

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。

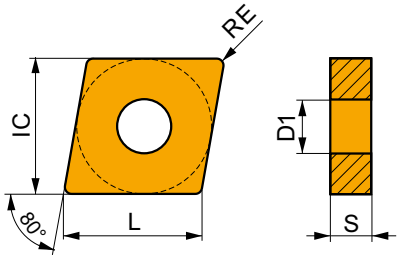
产品型号		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
CNGG 120402E-SF	**H07**	0.2	–	–	–	105	0.09	1.0	165	0.10	1.0	525	0.12	1.0	50	0.08	0.8	–	–	–
	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	0.15	1.0
	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	0.15	1.0
	T8330	0.2	195	0.10	1.0	115	0.09	1.0	185	0.10	1.0	585	0.12	1.0	45	0.08	0.8	35	0.15	1.0
	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	0.15	1.0

SF断屑槽，具有正前角设计，适用于连续切削中对薄壁进行超精加工。

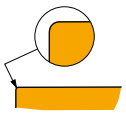
CNMA

PRAMET

	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

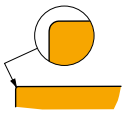
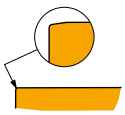


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
CNMA 120404	**T5305**	0.4	–	–	–	–	–	–	235	0.10	4.0	–	–	–	–	–	–	50	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	200	0.10	4.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 120408	**T5305**	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	190	0.20	4.0	–	–	–	–	–	–	40	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.15	1.0
CNMA 120412	**T5305**	1.2	–	–	–	–	–	–	195	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.2	–	–	–	–	–	–	180	0.30	4.0	–	–	–	–	–	–	35	0.15	1.0
	T6310	1.2	–	–	–	–	–	–	95	0.30	4.0	–	–	–	–	–	–	20	0.15	1.0
CNMA 120416	**T5305**	1.6	–	–	–	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.6	–	–	–	–	–	–	170	0.40	4.0	–	–	–	–	–	–	35	0.15	1.0

适用于超精加工至中粗加工，连续至轻微断续切削。

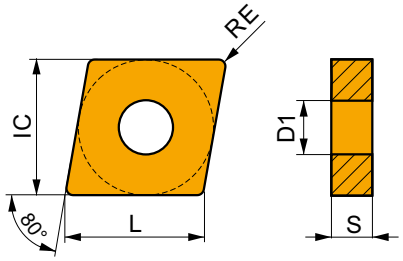
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
			E																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
CNMA 160612	T5305	1.2	–	–	–	–	–	–	190	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.2	–	–	–	–	–	–	175	0.30	5.0	–	–	–	–	–	–	35	0.15	1.0
	T6310	1.2	–	–	–	–	–	–	90	0.30	5.0	–	–	–	–	–	–	20	0.15	1.0
CNMA 160616	T5305	1.6	–	–	–	–	–	–	185	0.40	5.0	–	–	–	–	–	–	35	0.15	1.0
	T5315	1.6	–	–	–	–	–	–	165	0.40	5.0	–	–	–	–	–	–	35	0.15	1.0
CNMA 190612	T5305	1.2	–	–	–	–	–	–	190	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.2	–	–	–	–	–	–	170	0.30	6.0	–	–	–	–	–	–	35	0.15	1.0
	T6310	1.2	–	–	–	–	–	–	85	0.30	6.0	–	–	–	–	–	–	20	0.15	1.0
CNMA 190616	T5305	1.6	–	–	–	–	–	–	180	0.40	6.0	–	–	–	–	–	–	35	0.15	1.0
	T5315	1.6	–	–	–	–	–	–	160	0.40	6.0	–	–	–	–	–	–	30	0.15	1.0
			S																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
CNMA 120408S	T5305	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.15	1.0
CNMA 120412S	T5305	1.2	–	–	–	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.15	1.0
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	0.15	1.0

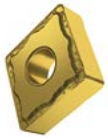
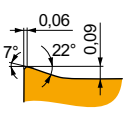
CNMG

PRAMET

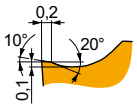
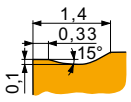
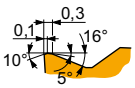
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.880	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



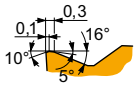
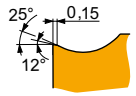
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
			U	S																
			FF断屑槽，具有大正前角设计，适用于超精加工，连续切削至轻微断续切削。																	
CNMG 120404E-FF	T7325	0.4	235	0.12	1.0	180	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	220	0.12	1.0	130	0.11	1.0	205	0.12	1.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-FF	T7325	0.8	265	0.15	1.0	205	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	245	0.15	1.0	145	0.14	1.0	230	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。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
			FM断屑槽，具有正前角设计，适用于精加工至中粗加工，连续切削至轻微断续切削。																	
CNMG 090304E-FM	**T7325**	0.4	195	0.20	1.4	150	0.18	1.4	–	–	–	–	–	–	60	0.16	1.1	–	–	–
	T8330	0.4	175	0.20	1.4	105	0.18	1.4	165	0.20	1.4	–	–	–	40	0.14	1.1	–	–	–
	T8430	0.4	195	0.20	1.4	105	0.18	1.4	160	0.20	1.4	–	–	–	40	0.14	1.1	–	–	–
	T9315	0.4	265	0.20	1.4	–	–	–	250	0.20	1.4	–	–	–	–	–	–	–	–	–
	T9325	0.4	240	0.20	1.4	140	0.18	1.4	225	0.20	1.4	–	–	–	50	0.16	1.1	–	–	–
CNMG 090308E-FM	**T7325**	0.8	235	0.20	1.4	180	0.18	1.4	–	–	–	–	–	–	75	0.16	1.1	–	–	–
	T8330	0.8	205	0.20	1.4	120	0.18	1.4	190	0.20	1.4	–	–	–	50	0.14	1.1	–	–	–
	T8430	0.8	235	0.20	1.4	125	0.18	1.4	190	0.20	1.4	–	–	–	50	0.14	1.1	–	–	–
	T9315	0.8	315	0.20	1.4	–	–	–	295	0.20	1.4	–	–	–	–	–	–	–	–	–
	T9325	0.8	285	0.20	1.4	170	0.18	1.4	270	0.20	1.4	–	–	–	60	0.16	1.1	–	–	–
CNMG 120404E-FM	**T7325**	0.4	185	0.20	2.1	140	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
	T7335	0.4	180	0.20	2.1	140	0.18	2.1	–	–	–	–	–	–	55	0.16	1.7	–	–	–
	T8315	0.4	175	0.20	2.1	105	0.18	2.1	165	0.20	2.1	–	–	–	40	0.14	1.7	–	–	–
	T8330	0.4	165	0.20	2.1	95	0.18	2.1	155	0.20	2.1	–	–	–	40	0.14	1.7	–	–	–
	T8430	0.4	190	0.20	2.1	105	0.18	2.1	155	0.20	2.1	–	–	–	40	0.14	1.7	–	–	–
	T9310	0.4	285	0.20	2.1	–	–	–	270	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9315	0.4	255	0.20	2.1	–	–	–	240	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9325	0.4	230	0.20	2.1	135	0.18	2.1	215	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
	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	–	–	–
	T7335	0.8	215	0.20	2.1	165	0.18	2.1	–	–	–	–	–	–	65	0.16	1.7	–	–	–
	T8315	0.8	205	0.20	2.1	120	0.18	2.1	190	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
	T8330	0.8	195	0.20	2.1	115	0.18	2.1	185	0.20	2.1	–	–	–	45	0.16	1.7	–	–	–
	T8430	0.8	225	0.20	2.1	120	0.18	2.1	185	0.20	2.1	–	–	–	45	0.16	1.7	–	–	–
	T9310	0.8	335	0.20	2.1	–	–	–	315	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9315	0.8	305	0.20	2.1	–	–	–	285	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9325	0.8	275	0.20	2.1	165	0.18	2.1	260	0.20	2.1	–	–	–	60	0.16	1.7	–	–	–
	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	–	–	–
	T9315	1.2	285	0.27	2.1	–	–	–	270	0.27	2.1	–	–	–	–	–	–	–	–	–
	T9325	1.2	255	0.27	2.1	150	0.24	2.1	240	0.27	2.1	–	–	–	55	0.19	1.7	–	–	–
																				
			KR断屑槽，适用于中粗加工至重载粗加工，连续至断续切削。																	
CNMG 120408E-KR	**T5305**	0.8	255	0.35	4.0	–	–	–	240	0.35	4.0	–	–	–	–	–	–	50	0.15	1.0
	T5315	0.8	225	0.35	4.0	–	–	–	210	0.35	4.0	–	–	–	–	–	–	45	0.15	1.0
CNMG 120412E-KR	**T5305**	1.2	255	0.40	4.0	–	–	–	240	0.40	4.0	–	–	–	–	–	–	50	0.15	1.0
	T5315	1.2	230	0.40	4.0	–	–	–	215	0.40	4.0	–	–	–	–	–	–	45	0.15	1.0
																				
			M断屑槽，适用于精加工至中粗加工，连续至断续切削。																	
CNMG 090308E-M	**T9315**	0.8	230	0.32	1.8	–	–	–	215	0.32	1.8	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.8	205	0.32	1.8	–	–	–	190	0.32	1.8	–	–	–	–	–	–	–	–	–
	T9335	0.8	180	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120404E-M	**T5315**	0.4	245	0.20	2.1	–	–	–	230	0.20	2.1	–	–	–	–	–	–	45	0.15	1.0
	T9310	0.4	260	0.20	2.1	–	–	–	245	0.20	2.1	–	–	–	–	–	–	50	0.15	1.0
	T9315	0.4	235	0.20	2.1	–	–	–	220	0.20	2.1	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.4	210	0.20	2.1	–	–	–	195	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9335	0.4	180	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

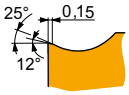
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			M断屑槽，适用于精加工至中粗加工，连续至断续切削。																	
CNMG 120408E-M	**6640**	0.8	■	165	0.32	2.1	–	–	–	■	155	0.32	2.1	–	–	–	–	–	–	–	–	–
	T5305	0.8	◪	280	0.32	2.1	–	–	–	■	265	0.32	2.1	–	–	–	–	–	–	◪	55	0.15	1.0
	T5315	0.8	◪	250	0.32	2.1	–	–	–	■	235	0.32	2.1	–	–	–	–	–	–	◪	50	0.15	1.0
	T8330	0.8	■	155	0.32	2.1	–	–	–	■	145	0.32	2.1	–	–	–	–	–	–	◪	30	0.15	1.0
	T8430	0.8	■	170	0.32	2.1	–	–	–	◪	135	0.32	2.1	–	–	–	–	–	–	◪	25	0.15	1.0
	T9310	0.8	■	245	0.32	2.1	–	–	–	◪	230	0.32	2.1	–	–	–	–	–	–	◪	45	0.15	1.0
	T9315	0.8	■	225	0.32	2.1	–	–	–	◪	210	0.32	2.1	–	–	–	–	–	–	◪	45	0.15	1.0
	T9325	0.8	■	200	0.32	2.1	–	–	–	◪	190	0.32	2.1	–	–	–	–	–	–		–	–	–
	T9335	0.8	■	180	0.32	2.1	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 120412E-M	**T5305**	1.2	◪	275	0.40	2.1	–	–	–	■	260	0.40	2.1	–	–	–	–	–	–	◪	55	0.15	1.0
	T5315	1.2	◪	245	0.40	2.1	–	–	–	■	230	0.40	2.1	–	–	–	–	–	–	◪	45	0.15	1.0
	T9310	1.2	■	235	0.40	2.1	–	–	–	◪	220	0.40	2.1	–	–	–	–	–	–	◪	45	0.15	1.0
	T9315	1.2	■	220	0.40	2.1	–	–	–	◪	205	0.40	2.1	–	–	–	–	–	–	◪	40	0.15	1.0
	T9325	1.2	■	195	0.40	2.1	–	–	–	◪	185	0.40	2.1	–	–	–	–	–	–		–	–	–
	T9335	1.2	■	170	0.40	2.1	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 120416E-M	**T9325**	1.6	■	200	0.40	2.1	–	–	–	◪	190	0.40	2.1	–	–	–	–	–	–		–	–	–
	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	0.15	1.0
	T9315	0.8	■	215	0.32	3.6	–	–	–	◪	200	0.32	3.6	–	–	–	–	–	–	◪	40	0.15	1.0
	T9325	0.8	■	190	0.32	3.6	–	–	–	◪	180	0.32	3.6	–	–	–	–	–	–		–	–	–
	T9335	0.8	■	170	0.32	3.6	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 160612E-M	**T9315**	1.2	■	210	0.40	3.6	–	–	–	◪	195	0.40	3.6	–	–	–	–	–	–	◪	40	0.15	1.0
	T9325	1.2	■	185	0.40	3.6	–	–	–	◪	175	0.40	3.6	–	–	–	–	–	–		–	–	–
	T9335	1.2	■	160	0.40	3.6	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 160616E-M	**T9325**	1.6	■	190	0.40	3.6	–	–	–	◪	180	0.40	3.6	–	–	–	–	–	–		–	–	–
	T9335	1.6	■	165	0.40	3.6	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190608E-M	**T9315**	0.8	■	210	0.32	4.2	–	–	–	◪	195	0.32	4.2	–	–	–	–	–	–	◪	40	0.15	1.0
	T9325	0.8	■	190	0.32	4.2	–	–	–	◪	180	0.32	4.2	–	–	–	–	–	–		–	–	–
	T9335	0.8	■	165	0.32	4.2	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190612E-M	**6640**	1.2	■	145	0.40	4.2	–	–	–	■	135	0.40	4.2	–	–	–	–	–	–		–	–	–
	T9310	1.2	■	220	0.40	4.2	–	–	–	◪	205	0.40	4.2	–	–	–	–	–	–	◪	40	0.15	1.0
	T9315	1.2	■	205	0.40	4.2	–	–	–	◪	190	0.40	4.2	–	–	–	–	–	–	◪	40	0.15	1.0
	T9325	1.2	■	185	0.40	4.2	–	–	–	◪	175	0.40	4.2	–	–	–	–	–	–		–	–	–
	T9335	1.2	■	160	0.40	4.2	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190616E-M	**T9310**	1.6	■	230	0.40	4.2	–	–	–	◪	215	0.40	4.2	–	–	–	–	–	–	◪	45	0.15	1.0
	T9315	1.6	■	215	0.40	4.2	–	–	–	◪	200	0.40	4.2	–	–	–	–	–	–	◪	40	0.15	1.0
	T9325	1.6	■	190	0.40	4.2	–	–	–	◪	180	0.40	4.2	–	–	–	–	–	–		–	–	–
	T9335	1.6	■	165	0.40	4.2	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
																				
			NF断屑槽，具有大正前角设计，适用于超精加工至中度加工，连续切削。																	
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	–	–	–
	T7335	0.4	◪	210	0.18	0.8	■	160	0.16	0.8		–	–	–		–	–	–	◪	65	0.16	0.6	–	–	–
	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	–	–	–
	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	–	–	–
	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	**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	–	–	–
	T7335	0.8	◪	240	0.19	1.0	■	185	0.17	1.0		–	–	–		–	–	–	◪	75	0.15	0.8	–	–	–
	T8330	0.8	■	215	0.19	1.0	■	125	0.17	1.0	◪	200	0.19	1.0	◪	645	0.23	1.0	◪	50	0.15	0.8	–	–	–
	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	–	–	–
	T9325	0.8	■	300	0.19	1.0	■	180	0.17	1.0	◪	285	0.19	1.0		–	–	–	◪	65	0.15	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。

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		

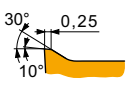




NF断屑槽，具有大正前角设计，适用于超精加工至中度加工，连续切削。

CNMG 120404E-NF	**HF7**	0.4	–	–	–	95	0.15	1.7	155	0.17	1.7	495	0.20	1.7	–	–	–	–	–	–
	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	–	–	–
	T7325	0.4	200	0.18	1.7	155	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–
	T7335	0.4	195	0.18	1.7	150	0.16	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
	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	–	–	–
	T8330	0.4	180	0.17	1.7	105	0.15	1.7	170	0.17	1.7	540	0.20	1.7	45	0.14	1.4	–	–	–
	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	–	–	–
	T9315	0.4	285	0.17	1.7	–	–	–	270	0.17	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	250	0.18	1.7	150	0.16	1.7	235	0.18	1.7	–	–	–	55	0.16	1.4	–	–	–
CNMG 120408E-NF	**HF7**	0.8	–	–	–	110	0.17	1.7	180	0.19	1.7	570	0.23	1.7	–	–	–	–	–	–
	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	–	–	–
	T7325	0.8	235	0.19	1.7	180	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
	T7335	0.8	225	0.19	1.7	175	0.17	1.7	–	–	–	–	–	–	70	0.15	1.4	–	–	–
	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	–	–	–
	T8330	0.8	200	0.19	1.7	120	0.17	1.7	190	0.19	1.7	600	0.23	1.7	50	0.15	1.4	–	–	–
	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	–	–	–
	T9315	0.8	320	0.19	1.7	–	–	–	300	0.19	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	285	0.19	1.7	170	0.17	1.7	270	0.19	1.7	–	–	–	60	0.15	1.4	–	–	–
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	–	–	–
	T7325	1.2	205	0.30	2.1	155	0.27	2.1	–	–	–	–	–	–	65	0.21	1.7	–	–	–
	T7335	1.2	200	0.30	2.1	155	0.27	2.1	–	–	–	–	–	–	65	0.21	1.7	–	–	–
	T8330	1.2	185	0.30	2.1	110	0.27	2.1	175	0.30	2.1	555	0.36	2.1	45	0.21	1.7	–	–	–
	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	–	–	–
	T9315	1.2	275	0.30	2.1	–	–	–	260	0.30	2.1	–	–	–	–	–	–	–	–	–
	T9325	1.2	245	0.30	2.1	145	0.27	2.1	230	0.30	2.1	–	–	–	55	0.21	1.7	–	–	–

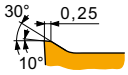
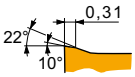




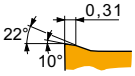
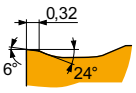
NM断屑槽，具有大正前角设计，适用于连续切削的精细，中度和粗加工。

CNMG 120404E-NM	**T7325**	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
	T7335	0.4	190	0.20	2.1	145	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
	T8315	0.4	180	0.20	2.1	105	0.18	2.1	–	–	–	540	0.24	2.1	45	0.16	1.7	–	–	–
	T8330	0.4	170	0.20	2.1	100	0.18	2.1	–	–	–	510	0.24	2.1	40	0.16	1.7	–	–	–
	T8430	0.4	195	0.20	2.1	105	0.18	2.1	–	–	–	540	0.24	2.1	40	0.16	1.7	–	–	–
	T9315	0.4	270	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.4	240	0.20	2.1	140	0.18	2.1	–	–	–	–	–	–	50	0.16	1.7	–	–	–
CNMG 120408E-NM	**T7325**	0.8	215	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
	T7335	0.8	210	0.25	2.1	160	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
	T8315	0.8	205	0.25	2.1	120	0.23	2.1	–	–	–	615	0.30	2.1	50	0.20	1.7	–	–	–
	T8330	0.8	195	0.25	2.1	115	0.23	2.1	–	–	–	585	0.30	2.1	45	0.20	1.7	–	–	–
	T8430	0.8	210	0.25	2.1	115	0.23	2.1	–	–	–	585	0.30	2.1	45	0.20	1.7	–	–	–
	T9315	0.8	290	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	260	0.25	2.1	155	0.23	2.1	–	–	–	–	–	–	55	0.20	1.7	–	–	–
CNMG 120412E-NM	**T7325**	1.2	215	0.30	2.1	165	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
	T7335	1.2	210	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
	T8315	1.2	205	0.30	2.1	120	0.27	2.1	–	–	–	615	0.36	2.1	50	0.24	1.7	–	–	–
	T8330	1.2	195	0.30	2.1	115	0.27	2.1	–	–	–	585	0.36	2.1	45	0.24	1.7	–	–	–
	T8430	1.2	210	0.30	2.1	115	0.27	2.1	–	–	–	585	0.36	2.1	45	0.24	1.7	–	–	–
	T9315	1.2	285	0.30	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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	–	–	–
	T7335	0.8	190	0.30	3.6	145	0.27	3.6	–	–	–	–	–	–	60	0.27	2.9	–	–	–
	T8315	0.8	185	0.30	3.6	110	0.27	3.6	–	–	–	555	0.36	3.6	45	0.27	2.9	–	–	–
	T8330	0.8	170	0.30	3.6	100	0.27	3.6	–	–	–	510	0.36	3.6	40	0.27	2.9	–	–	–
	T8430	0.8	185	0.30	3.6	100	0.27	3.6	–	–	–	510	0.36	3.6	40	0.27	2.9	–	–	–
	T9325	0.8	225	0.30	3.6	135	0.27	3.6	–	–	–	–	–	–	50	0.27	2.9	–	–	–

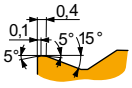
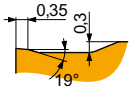
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
NM断屑槽，具有大正前角设计，适用于连续切削的精细，中度和粗加工。																				
CNMG 160612E-NM	**T7325**	1.2	205	0.30	3.6	155	0.27	3.6	–	–	–	–	–	–	65	0.27	2.9	–	–	–
	T7335	1.2	200	0.30	3.6	155	0.27	3.6	–	–	–	–	–	–	65	0.27	2.9	–	–	–
	T8315	1.2	195	0.30	3.6	115	0.27	3.6	–	–	–	585	0.36	3.6	45	0.27	2.9	–	–	–
	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	–	–	–
	T7335	1.2	180	0.35	4.2	140	0.32	4.2	–	–	–	–	–	–	55	0.32	3.4	–	–	–
	T8315	1.2	180	0.35	4.2	105	0.32	4.2	–	–	–	540	0.42	4.2	45	0.32	3.4	–	–	–
	T8330	1.2	170	0.35	4.2	100	0.32	4.2	–	–	–	510	0.42	4.2	40	0.32	3.4	–	–	–
	T8430	1.2	180	0.35	4.2	95	0.32	4.2	–	–	–	495	0.42	4.2	35	0.32	3.4	–	–	–
	T9325	1.2	220	0.35	4.2	130	0.32	4.2	–	–	–	–	–	–	45	0.32	3.4	–	–	–
																				
NMR断屑槽，具有正前角设计，适用于中度至粗加工，连续切削。																				
CNMG 090308E-NMR	**T7325**	0.8	175	0.35	1.6	135	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
	T7335	0.8	170	0.35	1.6	130	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
	T9325	0.8	200	0.35	1.6	120	0.32	1.6	–	–	–	–	–	–	45	0.25	1.3	–	–	–
CNMG 120404E-NMR	**T6310**	0.4	140	0.25	2.7	100	0.23	2.7	–	–	–	–	–	–	40	0.20	2.2	–	–	–
	T7325	0.4	155	0.25	2.7	120	0.23	2.7	–	–	–	–	–	–	50	0.20	2.2	–	–	–
	T7335	0.4	155	0.25	2.0	120	0.23	2.0	–	–	–	–	–	–	50	0.20	1.6	–	–	–
	T8330	0.4	140	0.25	2.0	80	0.23	2.0	–	–	–	–	–	–	35	0.20	1.6	–	–	–
	T8430	0.4	150	0.25	2.7	80	0.23	2.7	–	–	–	–	–	–	30	0.20	2.2	–	–	–
	T9315	0.4	215	0.25	2.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.4	190	0.25	2.0	110	0.23	2.0	–	–	–	–	–	–	40	0.20	1.6	–	–	–
CNMG 120408E-NMR	**T6310**	0.8	150	0.35	2.7	105	0.32	2.7	–	–	–	–	–	–	45	0.25	2.2	–	–	–
	T7325	0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.25	2.2	–	–	–
	T7335	0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.25	2.2	–	–	–
	T8330	0.8	150	0.35	2.7	90	0.32	2.7	–	–	–	–	–	–	35	0.25	2.2	–	–	–
	T8430	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
	T9315	0.8	210	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	190	0.35	2.7	110	0.32	2.7	–	–	–	–	–	–	40	0.25	2.2	–	–	–
CNMG 120412E-NMR	**T6310**	1.2	150	0.40	2.7	105	0.36	2.7	–	–	–	–	–	–	45	0.28	2.2	–	–	–
	T7325	1.2	170	0.40	2.7	130	0.36	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
	T7335	1.2	160	0.40	2.7	120	0.36	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
	T8330	1.2	150	0.40	2.7	90	0.36	2.7	–	–	–	–	–	–	35	0.28	2.2	–	–	–
	T8430	1.2	155	0.40	2.7	85	0.36	2.7	–	–	–	–	–	–	30	0.28	2.2	–	–	–
	T9315	1.2	215	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.2	190	0.40	2.7	110	0.36	2.7	–	–	–	–	–	–	40	0.28	2.2	–	–	–
CNMG 120416E-NMR	**T7325**	1.6	170	0.45	2.7	130	0.41	2.7	–	–	–	–	–	–	55	0.32	2.2	–	–	–
	T7335	1.6	160	0.45	2.7	120	0.41	2.7	–	–	–	–	–	–	50	0.32	2.2	–	–	–
	T9325	1.6	190	0.45	2.7	110	0.41	2.7	–	–	–	–	–	–	40	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	–	–	–
	T7335	0.8	150	0.35	4.0	115	0.32	4.0	–	–	–	–	–	–	45	0.25	3.2	–	–	–
	T9315	0.8	205	0.35	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	185	0.35	4.0	110	0.32	4.0	–	–	–	–	–	–	40	0.25	3.2	–	–	–
CNMG 160612E-NMR	**T7325**	1.2	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
	T7335	1.2	155	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
	T8330	1.2	145	0.40	4.0	85	0.36	4.0	–	–	–	–	–	–	35	0.28	3.2	–	–	–
	T8430	1.2	150	0.40	4.0	80	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
	T9315	1.2	205	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.2	185	0.40	4.0	110	0.36	4.0	–	–	–	–	–	–	40	0.28	3.2	–	–	–

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

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		
																				
NMR断屑槽，具有正前角设计，适用于中度至粗加工，连续切削。																				
CNMG 160616E-NMR	**T7325**	1.6	◪ 165	0.45	4.0	■ 125	0.41	4.0	–	–	–	–	–	–	■ 50	0.32	3.2	–	–	–
	T7335	1.6	◪ 155	0.45	4.0	■ 120	0.41	4.0	–	–	–	–	–	–	■ 50	0.32	3.2	–	–	–
	T8330	1.6	■ 145	0.45	4.0	■ 85	0.41	4.0	–	–	–	–	–	–	◪ 35	0.32	3.2	–	–	–
	T8430	1.6	■ 150	0.45	4.0	■ 80	0.41	4.0	–	–	–	–	–	–	◪ 30	0.32	3.2	–	–	–
	T9315	1.6	■ 200	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.6	■ 180	0.45	4.0	■ 105	0.41	4.0	–	–	–	–	–	–	◪ 40	0.32	3.2	–	–	–
CNMG 190608E-NMR	**T6310**	0.8	■ 140	0.35	5.2	■ 100	0.32	5.2	–	–	–	–	–	–	■ 40	0.25	4.2	–	–	–
	T7325	0.8	◪ 155	0.35	5.2	■ 120	0.32	5.2	–	–	–	–	–	–	■ 50	0.25	4.2	–	–	–
	T7335	0.8	◪ 150	0.35	5.2	■ 115	0.32	5.2	–	–	–	–	–	–	■ 45	0.25	4.2	–	–	–
	T9315	0.8	■ 195	0.35	5.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 180	0.35	5.2	■ 105	0.32	5.2	–	–	–	–	–	–	◪ 40	0.25	4.2	–	–	–
CNMG 190612E-NMR	**T6310**	1.2	■ 140	0.40	5.2	■ 100	0.36	5.2	–	–	–	–	–	–	■ 40	0.28	4.2	–	–	–
	T7325	1.2	◪ 160	0.40	5.2	■ 120	0.36	5.2	–	–	–	–	–	–	■ 50	0.28	4.2	–	–	–
	T7335	1.2	◪ 150	0.40	5.2	■ 115	0.36	5.2	–	–	–	–	–	–	■ 45	0.28	4.2	–	–	–
	T8330	1.2	■ 140	0.40	5.2	■ 80	0.36	5.2	–	–	–	–	–	–	◪ 35	0.28	4.2	–	–	–
	T8430	1.2	■ 145	0.40	5.2	■ 80	0.36	5.2	–	–	–	–	–	–	◪ 30	0.28	4.2	–	–	–
	T9315	1.2	■ 200	0.40	5.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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	–	–	–
	T7335	1.6	◪ 150	0.45	5.2	■ 115	0.41	5.2	–	–	–	–	–	–	■ 45	0.32	4.2	–	–	–
	T9315	1.6	■ 195	0.45	5.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.6	■ 175	0.45	5.2	■ 105	0.41	5.2	–	–	–	–	–	–	◪ 35	0.32	4.2	–	–	–
																				
NRM断屑槽，具有正前角设计，适用于中粗加工至粗加工，连续至中等间断切削。																				
CNMG 120408-NRM	**T7325**	0.8	◪ 160	0.35	4.0	■ 120	0.32	4.0	–	–	–	–	–	–	■ 50	0.28	3.2	–	–	–
	T7335	0.8	◪ 150	0.35	4.0	■ 115	0.32	4.0	–	–	–	–	–	–	■ 45	0.28	3.2	–	–	–
	T9315	0.8	■ 205	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	–	–	–
	T7335	1.2	◪ 155	0.40	4.0	■ 120	0.36	4.0	–	–	–	–	–	–	■ 50	0.28	3.2	–	–	–
	T9315	1.2	■ 205	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120416-NRM	**T7325**	1.6	◪ 165	0.45	4.0	■ 125	0.41	4.0	–	–	–	–	–	–	■ 50	0.36	3.2	–	–	–
	T7335	1.6	◪ 155	0.45	4.0	■ 120	0.41	4.0	–	–	–	–	–	–	■ 50	0.36	3.2	–	–	–
	T9315	1.6	■ 200	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160608-NRM	**T7325**	0.8	◪ 155	0.35	6.0	■ 120	0.32	6.0	–	–	–	–	–	–	■ 50	0.28	4.8	–	–	–
	T7335	0.8	◪ 145	0.35	6.0	■ 110	0.32	6.0	–	–	–	–	–	–	■ 45	0.28	4.8	–	–	–
	T9315	0.8	■ 195	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	–	–	–
	T7335	1.2	◪ 150	0.40	6.0	■ 115	0.36	6.0	–	–	–	–	–	–	■ 45	0.32	4.8	–	–	–
	T9315	1.2	■ 200	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	–	–	–
	T7335	1.6	◪ 150	0.45	6.0	■ 115	0.41	6.0	–	–	–	–	–	–	■ 45	0.36	4.8	–	–	–
	T9315	1.6	■ 195	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190608-NRM	**T7325**	0.8	◪ 150	0.35	8.0	■ 115	0.32	8.0	–	–	–	–	–	–	■ 45	0.28	6.4	–	–	–
	T7335	0.8	◪ 140	0.35	8.0	■ 105	0.32	8.0	–	–	–	–	–	–	■ 45	0.28	6.4	–	–	–
	T9315	0.8	■ 190	0.35	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612-NRM	**T7325**	1.2	◪ 155	0.40	8.0	■ 120	0.36	8.0	–	–	–	–	–	–	■ 50	0.32	6.4	–	–	–
	T7335	1.2	◪ 145	0.40	8.0	■ 110	0.36	8.0	–	–	–	–	–	–	■ 45	0.32	6.4	–	–	–
	T9315	1.2	■ 190	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	–	–	–
	T7335	1.6	◪ 145	0.45	8.0	■ 110	0.41	8.0	–	–	–	–	–	–	■ 45	0.36	6.4	–	–	–
	T9315	1.6	■ 190	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	–	–	–
	T7335	2.4	◪ 90	0.70	10.0	■ 70	0.63	10.0	–	–	–	–	–	–	■ 25	0.49	8.0	–	–	–
	T9315	2.4	■ 115	0.70	10.0	–	–	–	◪ 105	0.70	10.0	–	–	–	–	–	–	–	–	–

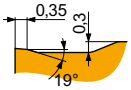
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
R断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
CNMG 120408E-R	**6640**	0.8	■	140	0.40	4.0	–	–	–	■	130	0.40	4.0	–	–	–	–	–	–	–	–	–
	T5305	0.8	◪	240	0.40	4.0	–	–	–	■	225	0.40	4.0	–	–	–	–	–	–	◪	45	0.15	1.0
	T5315	0.8	◪	215	0.40	4.0	–	–	–	■	200	0.40	4.0	–	–	–	–	–	–	◪	40	0.15	1.0
	T9310	0.8	■	205	0.40	4.0	–	–	–	◪	190	0.40	4.0	–	–	–	–	–	–	◪	40	0.15	1.0
	T9315	0.8	■	190	0.40	4.0	–	–	–	◪	180	0.40	4.0	–	–	–	–	–	–	◪	35	0.15	1.0
	T9325	0.8	■	175	0.40	4.0	–	–	–	◪	165	0.40	4.0	–	–	–	–	–	–		–	–	–
	T9335	0.8	■	150	0.40	4.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 120412E-R	**T5305**	1.2	◪	245	0.45	4.0	–	–	–	■	230	0.45	4.0	–	–	–	–	–	–	◪	45	0.15	1.0
	T5315	1.2	◪	220	0.45	4.0	–	–	–	■	205	0.45	4.0	–	–	–	–	–	–	◪	40	0.15	1.0
	T9315	1.2	■	195	0.45	4.0	–	–	–	◪	185	0.45	4.0	–	–	–	–	–	–	◪	35	0.15	1.0
	T9325	1.2	■	175	0.45	4.0	–	–	–	◪	165	0.45	4.0	–	–	–	–	–	–		–	–	–
	T9335	1.2	■	155	0.45	4.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 120416E-R	**T5315**	1.6	◪	225	0.50	4.0	–	–	–	■	210	0.50	4.0	–	–	–	–	–	–	◪	45	0.15	1.0
	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	0.15	1.0
CNMG 160612E-R	**T5305**	1.2	◪	235	0.45	5.5	–	–	–	■	220	0.45	5.5	–	–	–	–	–	–	◪	45	0.15	1.0
	T5315	1.2	◪	215	0.45	5.5	–	–	–	■	200	0.45	5.5	–	–	–	–	–	–	◪	40	0.15	1.0
	T7335	1.2	◪	145	0.45	5.5	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
	T9310	1.2	■	205	0.45	5.5	–	–	–	◪	190	0.45	5.5	–	–	–	–	–	–	◪	40	0.15	1.0
	T9315	1.2	■	190	0.45	5.5	–	–	–	◪	180	0.45	5.5	–	–	–	–	–	–	◪	35	0.15	1.0
	T9325	1.2	■	170	0.45	5.5	–	–	–	◪	160	0.45	5.5	–	–	–	–	–	–		–	–	–
CNMG 160616E-R	**T5305**	1.6	◪	240	0.50	5.5	–	–	–	■	225	0.50	5.5	–	–	–	–	–	–	◪	45	0.15	1.0
CNMG 190608E-R	**T5315**	0.8	◪	205	0.40	7.0	–	–	–	■	190	0.40	7.0	–	–	–	–	–	–	◪	40	0.15	1.0
CNMG 190612E-R	**6640**	1.2	■	135	0.45	7.0	–	–	–	■	125	0.45	7.0	–	–	–	–	–	–		–	–	–
	T5305	1.2	◪	230	0.45	7.0	–	–	–	■	215	0.45	7.0	–	–	–	–	–	–	◪	45	0.15	1.0
	T5315	1.2	◪	210	0.45	7.0	–	–	–	■	195	0.45	7.0	–	–	–	–	–	–	◪	40	0.15	1.0
	T9315	1.2	■	185	0.45	7.0	–	–	–	◪	175	0.45	7.0	–	–	–	–	–	–	◪	35	0.15	1.0
	T9325	1.2	■	165	0.45	7.0	–	–	–	◪	155	0.45	7.0	–	–	–	–	–	–		–	–	–
	T9335	1.2	■	145	0.45	7.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190616E-R	**6640**	1.6	■	130	0.50	7.0	–	–	–	■	120	0.50	7.0	–	–	–	–	–	–		–	–	–
	T5305	1.6	◪	235	0.50	7.0	–	–	–	■	220	0.50	7.0	–	–	–	–	–	–	◪	45	0.15	1.0
	T5315	1.6	◪	210	0.50	7.0	–	–	–	■	195	0.50	7.0	–	–	–	–	–	–	◪	40	0.15	1.0
	T9310	1.6	■	195	0.50	7.0	–	–	–	◪	185	0.50	7.0	–	–	–	–	–	–	◪	35	0.15	1.0
	T9315	1.6	■	180	0.50	7.0	–	–	–	◪	170	0.50	7.0	–	–	–	–	–	–	◪	35	0.15	1.0
	T9325	1.6	■	165	0.50	7.0	–	–	–	◪	155	0.50	7.0	–	–	–	–	–	–		–	–	–
	T9335	1.6	■	145	0.50	7.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
																				
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
CNMG 120408E-RM	**T5305**	0.8	◪	275	0.40	4.0		–	–	–	◪	260	0.40	4.0	–	–	–	–	–	–	–	–	–
	T5315	0.8	◪	250	0.40	4.0		–	–	–	◪	235	0.40	4.0	–	–	–	–	–	–	–	–	–
	T6310	0.8	■	155	0.40	4.0	◪	110	0.36	4.0	◪	125	0.40	4.0	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪	180	0.40	4.0	◪	140	0.36	4.0		–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪	165	0.40	4.0	◪	125	0.36	4.0		–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	◪	165	0.40	4.0	◪	95	0.36	4.0	◪	155	0.40	4.0	–	–	–	–	–	–	–	–	–
	T8330	0.8	■	155	0.40	4.0	◪	90	0.36	4.0	◪	145	0.40	4.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	■	165	0.40	4.0	◪	90	0.36	4.0	◪	135	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9310	0.8	■	240	0.40	4.0		–	–	–	◪	225	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	■	220	0.40	4.0		–	–	–	◪	205	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■	200	0.40	4.0	◪	120	0.36	4.0	◪	190	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	■	170	0.40	4.0	◪	100	0.36	4.0		–	–	–	–	–	–	–	–	–	–	–	–

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

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		





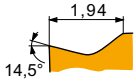
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。

CNMG 120412E-RM	**T5305**	1.2	280	0.45	4.0	–	–	–	265	0.45	4.0	–	–	–	–	–	–	–	–	–
	T5315	1.2	250	0.45	4.0	–	–	–	235	0.45	4.0	–	–	–	–	–	–	–	–	–
	T6310	1.2	160	0.45	4.0	115	0.41	4.0	125	0.45	4.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	180	0.45	4.0	140	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	170	0.45	4.0	130	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	1.2	170	0.45	4.0	100	0.41	4.0	160	0.45	4.0	–	–	–	–	–	–	–	–	–
	T8330	1.2	160	0.45	4.0	95	0.41	4.0	150	0.45	4.0	–	–	–	–	–	–	–	–	–
	T8430	1.2	170	0.45	4.0	90	0.41	4.0	135	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9310	1.2	240	0.45	4.0	–	–	–	225	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	220	0.45	4.0	–	–	–	205	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	200	0.45	4.0	120	0.41	4.0	190	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	175	0.45	4.0	105	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120416E-RM	**T5305**	1.6	280	0.50	4.0	–	–	–	265	0.50	4.0	–	–	–	–	–	–	–	–	–
	T5315	1.6	255	0.50	4.0	–	–	–	240	0.50	4.0	–	–	–	–	–	–	–	–	–
	T7325	1.6	185	0.50	4.0	140	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.6	175	0.50	4.0	135	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	1.6	160	0.50	4.0	95	0.45	4.0	150	0.50	4.0	–	–	–	–	–	–	–	–	–
	T8430	1.6	170	0.50	4.0	90	0.45	4.0	135	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9310	1.6	240	0.50	4.0	–	–	–	225	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9315	1.6	220	0.50	4.0	–	–	–	205	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	205	0.50	4.0	120	0.45	4.0	190	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	175	0.50	4.0	105	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160608E-RM	**T5305**	0.8	265	0.40	6.0	–	–	–	250	0.40	6.0	–	–	–	–	–	–	–	–	–
	T5315	0.8	240	0.40	6.0	–	–	–	225	0.40	6.0	–	–	–	–	–	–	–	–	–
	T8330	0.8	150	0.40	6.0	90	0.36	6.0	140	0.40	6.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	155	0.40	6.0	85	0.36	6.0	130	0.40	6.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	215	0.40	6.0	–	–	–	200	0.40	6.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	190	0.40	6.0	110	0.36	6.0	180	0.40	6.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	165	0.40	6.0	95	0.36	6.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612E-RM	**T5305**	1.2	270	0.45	6.0	–	–	–	255	0.45	6.0	–	–	–	–	–	–	–	–	–
	T5315	1.2	245	0.45	6.0	–	–	–	230	0.45	6.0	–	–	–	–	–	–	–	–	–
	T6310	1.2	155	0.45	6.0	110	0.41	6.0	125	0.45	6.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	170	0.45	6.0	130	0.41	6.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	1.2	155	0.45	6.0	90	0.41	6.0	145	0.45	6.0	–	–	–	–	–	–	–	–	–
	T8430	1.2	155	0.45	6.0	85	0.41	6.0	130	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9310	1.2	230	0.45	6.0	–	–	–	215	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	215	0.45	6.0	–	–	–	200	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	165	0.45	6.0	95	0.41	6.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM	**T5305**	1.6	270	0.50	6.0	–	–	–	255	0.50	6.0	–	–	–	–	–	–	–	–	–
	T5315	1.6	245	0.50	6.0	–	–	–	230	0.50	6.0	–	–	–	–	–	–	–	–	–
	T7325	1.6	175	0.50	6.0	135	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.6	165	0.50	6.0	125	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	1.6	225	0.50	6.0	–	–	–	210	0.50	6.0	–	–	–	–	–	–	–	–	–
	T9315	1.6	215	0.50	6.0	–	–	–	200	0.50	6.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	165	0.50	6.0	95	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190608E-RM	**T5305**	0.8	260	0.40	7.5	–	–	–	245	0.40	7.5	–	–	–	–	–	–	–	–	–
	T5315	0.8	230	0.40	7.5	–	–	–	215	0.40	7.5	–	–	–	–	–	–	–	–	–
	T7335	0.8	155	0.40	7.5	120	0.36	7.5	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.8	210	0.40	7.5	–	–	–	195	0.40	7.5	–	–	–	–	–	–	–	–	–
	T9325	0.8	190	0.40	7.5	110	0.36	7.5	180	0.40	7.5	–	–	–	–	–	–	–	–	–
	T9335	0.8	160	0.40	7.5	95	0.36	7.5	–	–	–	–	–	–	–	–	–	–	–	–

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

产品型号		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
CNMG 190612E-RM	**T5305**	1.2	260	0.45	7.5	–	–	–	245	0.45	7.5	–	–	–	–	–	–	–	–	–
	T5315	1.2	240	0.45	7.5	–	–	–	225	0.45	7.5	–	–	–	–	–	–	–	–	–
	T6310	1.2	155	0.45	7.5	110	0.41	7.5	125	0.45	7.5	–	–	–	–	–	–	–	–	–
	T7325	1.2	170	0.45	7.5	130	0.41	7.5	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	160	0.45	7.5	120	0.41	7.5	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	1.2	155	0.45	7.5	90	0.41	7.5	145	0.45	7.5	–	–	–	–	–	–	–	–	–
	T8430	1.2	150	0.45	7.5	80	0.41	7.5	125	0.45	7.5	–	–	–	–	–	–	–	–	–
	T9310	1.2	220	0.45	7.5	–	–	–	205	0.45	7.5	–	–	–	–	–	–	–	–	–
	T9315	1.2	210	0.45	7.5	–	–	–	195	0.45	7.5	–	–	–	–	–	–	–	–	–
	T9325	1.2	185	0.45	7.5	110	0.41	7.5	175	0.45	7.5	–	–	–	–	–	–	–	–	–
	T9335	1.2	165	0.45	7.5	95	0.41	7.5	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM	**T5305**	1.6	265	0.50	7.5	–	–	–	250	0.50	7.5	–	–	–	–	–	–	–	–	–
	T5315	1.6	240	0.50	7.5	–	–	–	225	0.50	7.5	–	–	–	–	–	–	–	–	–
	T6310	1.6	155	0.50	7.5	110	0.45	7.5	125	0.50	7.5	–	–	–	–	–	–	–	–	–
	T7325	1.6	175	0.50	7.5	135	0.45	7.5	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.6	160	0.50	7.5	120	0.45	7.5	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	1.6	225	0.50	7.5	–	–	–	210	0.50	7.5	–	–	–	–	–	–	–	–	–
	T9315	1.6	210	0.50	7.5	–	–	–	195	0.50	7.5	–	–	–	–	–	–	–	–	–
	T9325	1.6	190	0.50	7.5	110	0.45	7.5	180	0.50	7.5	–	–	–	–	–	–	–	–	–
	T9335	1.6	160	0.50	7.5	95	0.45	7.5	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 250924E-RM	**T7325**	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9226	2.4	90	0.80	12.0	50	0.72	12.0	85	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	120	0.80	12.0	–	–	–	110	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	85	0.80	12.0	50	0.72	12.0	–	–	–	–	–	–	–	–	–	–	–	–

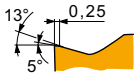




SF断屑槽，具有正前角设计，适用于薄壁，连续切削进行超精加工。

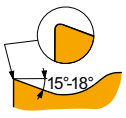
CNMG 120404E-SF	**H07**	0.4	–	–	–	90	0.14	1.0	145	0.15	1.0	470	0.18	1.0	45	0.12	0.8	–	–	–
	T6310	0.4	180	0.15	1.0	125	0.14	1.0	145	0.15	1.0	540	0.18	1.0	50	0.12	0.8	35	0.15	1.0
	T7325	0.4	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
	T7335	0.4	200	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
	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	0.15	1.0
	T8330	0.4	180	0.15	1.0	105	0.14	1.0	170	0.15	1.0	540	0.18	1.0	45	0.12	0.8	35	0.15	1.0
	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	0.15	1.0
	T9315	0.4	300	0.15	1.0	–	–	–	285	0.15	1.0	–	–	–	–	–	–	60	0.15	1.0
	T9325	0.4	255	0.17	1.0	150	0.15	1.0	240	0.17	1.0	–	–	–	55	0.15	0.8	–	–	–
CNMG 120408E-SF	**H07**	0.8	–	–	–	95	0.18	1.0	155	0.20	1.0	495	0.24	1.0	50	0.14	0.8	–	–	–
	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	0.15	1.0
	T7325	0.8	230	0.20	1.0	175	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
	T7335	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
	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	0.15	1.0
	T8330	0.8	200	0.20	1.0	120	0.18	1.0	190	0.20	1.0	600	0.24	1.0	50	0.14	0.8	40	0.15	1.0
	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	0.15	1.0
	T9315	0.8	315	0.20	1.0	–	–	–	295	0.20	1.0	–	–	–	–	–	–	60	0.15	1.0
	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	0.15	1.0
	T7325	1.2	220	0.25	1.5	170	0.23	1.5	–	–	–	–	–	–	70	0.18	1.2	–	–	–
	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	0.15	1.0
	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	0.15	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。

产品型号		RE	P			M			K			N			S			H		
			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)
																				

SM断屑槽，具有正前角设计，适用于中等加工，连续或间断进行切削。

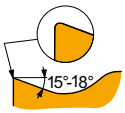
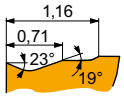
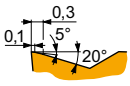
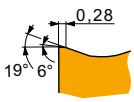
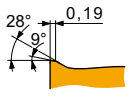
CNMG 120404E-SM	**T6310**	0.4	■ 155	0.22	2.0	■ 110	0.20	2.0	■ 125	0.22	2.0	◪ 465	0.26	2.0	■ 45	0.20	1.6	◪ 30	0.15	1.0
	T7325	0.4	◪ 175	0.22	2.0	■ 135	0.20	2.0	–	–	–	–	–	–	■ 55	0.20	1.6	–	–	–
	T7335	0.4	◪ 170	0.22	2.0	■ 130	0.20	2.0	–	–	–	–	–	–	■ 55	0.20	1.6	–	–	–
	T8330	0.4	■ 155	0.22	2.0	■ 90	0.20	2.0	■ 145	0.22	2.0	◪ 465	0.26	2.0	◪ 35	0.20	1.6	◪ 30	0.15	1.0
	T8430	0.4	■ 170	0.22	2.0	■ 90	0.20	2.0	◪ 135	0.22	2.0	◪ 465	0.26	2.0	◪ 35	0.20	1.6	◪ 25	0.15	1.0
	T9315	0.4	■ 245	0.20	2.0	–	–	–	◪ 230	0.20	2.0	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	0.4	■ 210	0.22	2.0	■ 125	0.20	2.0	◪ 195	0.22	2.0	–	–	–	◪ 45	0.20	1.6	–	–	–
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	0.15	1.0
	T7325	0.8	◪ 200	0.25	2.0	■ 155	0.23	2.0	–	–	–	–	–	–	■ 65	0.20	1.6	–	–	–
	T7335	0.8	◪ 190	0.25	2.0	■ 145	0.23	2.0	–	–	–	–	–	–	■ 60	0.20	1.6	–	–	–
	T8330	0.8	■ 175	0.25	2.0	■ 105	0.23	2.0	■ 165	0.25	2.0	◪ 525	0.30	2.0	◪ 40	0.20	1.6	◪ 35	0.15	1.0
	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	0.15	1.0
	T9315	0.8	■ 265	0.25	2.0	–	–	–	◪ 250	0.25	2.0	–	–	–	–	–	–	◪ 50	0.15	1.0
	T9325	0.8	■ 235	0.25	2.0	■ 140	0.23	2.0	◪ 220	0.25	2.0	–	–	–	◪ 50	0.20	1.6	–	–	–
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
	T7325	1.2	◪ 195	0.30	2.0	■ 150	0.27	2.0	–	–	–	–	–	–	■ 60	0.24	1.6	–	–	–
	T7335	1.2	◪ 190	0.30	2.0	■ 145	0.27	2.0	–	–	–	–	–	–	■ 60	0.24	1.6	–	–	–
	T8330	1.2	■ 175	0.30	2.0	■ 105	0.27	2.0	■ 165	0.30	2.0	◪ 525	0.36	2.0	◪ 40	0.24	1.6	◪ 35	0.15	1.0
	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
	T9315	1.2	■ 260	0.30	2.0	–	–	–	◪ 245	0.30	2.0	–	–	–	–	–	–	◪ 50	0.15	1.0
	T9325	1.2	■ 235	0.30	2.0	■ 140	0.27	2.0	◪ 220	0.30	2.0	–	–	–	◪ 50	0.24	1.6	–	–	–
CNMG 160608E-SM	**T7325**	0.8	◪ 185	0.26	3.0	■ 140	0.23	3.0	–	–	–	–	–	–	■ 60	0.23	2.4	–	–	–
	T7335	0.8	◪ 180	0.26	3.0	■ 140	0.23	3.0	–	–	–	–	–	–	■ 55	0.23	2.4	–	–	–
	T8330	0.8	■ 165	0.26	3.0	■ 95	0.23	3.0	■ 155	0.26	3.0	◪ 495	0.31	3.0	◪ 40	0.23	2.4	◪ 30	0.15	1.0
	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	0.15	1.0
	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
	T7325	1.2	◪ 190	0.30	3.0	■ 145	0.27	3.0	–	–	–	–	–	–	■ 60	0.27	2.4	–	–	–
	T7335	1.2	◪ 180	0.30	3.0	■ 140	0.27	3.0	–	–	–	–	–	–	■ 55	0.27	2.4	–	–	–
	T9315	1.2	■ 250	0.30	3.0	–	–	–	◪ 235	0.30	3.0	–	–	–	–	–	–	◪ 50	0.15	1.0
	T9325	1.2	■ 225	0.30	3.0	■ 135	0.27	3.0	◪ 210	0.30	3.0	–	–	–	◪ 50	0.27	2.4	–	–	–
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
	T7325	1.2	◪ 185	0.30	4.0	■ 140	0.27	4.0	–	–	–	–	–	–	■ 60	0.27	3.2	–	–	–
	T7335	1.2	◪ 175	0.30	4.0	■ 135	0.27	4.0	–	–	–	–	–	–	■ 55	0.27	3.2	–	–	–
	T9315	1.2	■ 245	0.30	4.0	–	–	–	◪ 230	0.30	4.0	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	1.2	■ 220	0.30	4.0	■ 130	0.27	4.0	◪ 205	0.30	4.0	–	–	–	◪ 45	0.27	3.2	–	–	–

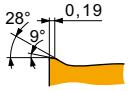
ER-SI断屑槽，具有正前角设计，右手设计，适用于超精加工至中粗加工，连续切削。

CNMG 120404ER-SI	**T7325**	0.4	◪ 220	0.20	1.7	■ 170	0.18	1.7	–	–	–	–	–	–	◪ 70	0.18	1.4	–	–	–
	T7335	0.4	◪ 215	0.20	1.7	■ 165	0.18	1.7	–	–	–	–	–	–	◪ 65	0.18	1.4	–	–	–
	T8330	0.4	■ 195	0.20	1.7	■ 115	0.18	1.7	–	–	–	◪ 585	0.24	1.7	◪ 45	0.18	1.4	–	–	–
	T8430	0.4	■ 225	0.20	1.7	■ 120	0.18	1.7	–	–	–	◪ 615	0.24	1.7	◪ 45	0.18	1.4	–	–	–
	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	–	–	–
	T7335	0.8	◪ 205	0.35	1.7	■ 155	0.32	1.7	–	–	–	–	–	–	◪ 65	0.25	1.4	–	–	–
	T8315	0.8	◪ 205	0.35	1.7	■ 120	0.32	1.7	–	–	–	◪ 615	0.42	1.7	◪ 50	0.25	1.4	–	–	–
	T8330	0.8	■ 195	0.35	1.7	■ 115	0.32	1.7	–	–	–	◪ 585	0.42	1.7	◪ 45	0.25	1.4	–	–	–
	T8430	0.8	■ 210	0.35	1.7	■ 115	0.32	1.7	–	–	–	◪ 585	0.42	1.7	◪ 45	0.25	1.4	–	–	–
	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	–	–	–

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

产品型号		RE	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)
			E																	
EL-SI断屑槽，具有正前角，左手设计，适用于超精加工至中粗加工，连续切削。																				
CNMG 120404EL-SI	**T7325**	0.4	220	0.20	1.7	170	0.18	1.7	–	–	–	–	–	–	70	0.18	1.4	–	–	–
	T7335	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
	T8330	0.4	195	0.20	1.7	115	0.18	1.7	–	–	–	585	0.24	1.7	45	0.18	1.4	–	–	–
	T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
	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	–	–	–
	T7335	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
	T8315	0.8	205	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	50	0.25	1.4	–	–	–
	T8330	0.8	195	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
	T8430	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
	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	–	–	–
			W	E																
W-F修光刃断屑槽，可提高进给量并改善表面光洁度，从而完成精细的精加工。																				
CNMG 120408W-F	**T9315**	0.8	215	0.45	0.8	–	–	–	200	0.45	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	190	0.45	0.8	–	–	–	180	0.45	0.8	–	–	–	–	–	–	–	–	–
			W	S																
W-M修光刃断屑槽，适用于中粗加工至粗加工，并提供更高的进给量并改善了表面光洁度。																				
CNMG 120408W-M	**T5315**	0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
	T9315	0.8	200	0.45	1.5	–	–	–	190	0.45	1.5	–	–	–	–	–	–	–	–	–
	T9325	0.8	185	0.45	1.5	–	–	–	175	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-M	**T5315**	1.2	230	0.55	1.5	–	–	–	215	0.55	1.5	–	–	–	–	–	–	–	–	–
	T9315	1.2	200	0.55	1.5	–	–	–	190	0.55	1.5	–	–	–	–	–	–	–	–	–
	T9325	1.2	180	0.55	1.5	–	–	–	170	0.55	1.5	–	–	–	–	–	–	–	–	–
			W	S																
W-MR修光刃断屑槽，适用于精加工至粗加工，并提供更高的进给量并改善了表面光洁度。																				
CNMG 120404W-MR	**T9315**	0.4	200	0.30	1.5	–	–	–	190	0.30	1.5	–	–	–	–	–	–	–	–	–
	T9325	0.4	180	0.30	1.5	105	0.27	1.5	170	0.30	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR	**T5315**	0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
	T9310	0.8	215	0.45	1.5	–	–	–	200	0.45	1.5	–	–	–	–	–	–	–	–	–
	T9315	0.8	200	0.45	1.5	–	–	–	190	0.45	1.5	–	–	–	–	–	–	–	–	–
	T9325	0.8	185	0.45	1.5	110	0.41	1.5	175	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR	**T5315**	1.2	230	0.55	1.5	–	–	–	215	0.55	1.5	–	–	–	–	–	–	–	–	–
	T9310	1.2	210	0.55	1.5	–	–	–	195	0.55	1.5	–	–	–	–	–	–	–	–	–
	T9315	1.2	200	0.55	1.5	–	–	–	190	0.55	1.5	–	–	–	–	–	–	–	–	–
	T9325	1.2	180	0.55	1.5	105	0.50	1.5	170	0.55	1.5	–	–	–	–	–	–	–	–	–
			W	1	U	S														
W-NM修光刃断屑槽，适用于精加工至粗加工，并提供更高的进给量并改善了表面光洁度。																				
CNMG 120404W-NM	**T7325**	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
	T7335	0.4	190	0.20	2.1	145	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
	T9315	0.4	270	0.20	2.1	–	–	–	255	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9325	0.4	240	0.20	2.1	140	0.18	2.1	225	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–

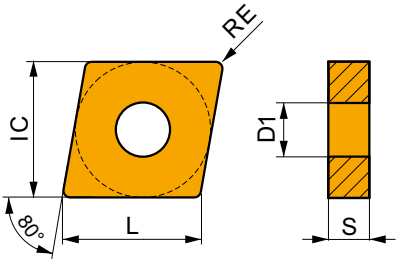
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		
																				
			W-NM修光刃断屑槽，适用于精加工至粗加工，并提供更高的进给量并改善了表面光洁度。																	
CNMG 120408W-NM	**T7325**	0.8	215	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
	T7335	0.8	210	0.25	2.1	160	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
	T9315	0.8	290	0.25	2.1	–	–	–	275	0.25	2.1	–	–	–	–	–	–	–	–	–
	T9325	0.8	260	0.25	2.1	155	0.23	2.1	245	0.25	2.1	–	–	–	55	0.20	1.7	–	–	–
CNMG 120412W-NM	**T7325**	1.2	215	0.30	2.1	165	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
	T7335	1.2	210	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
	T9315	1.2	285	0.30	2.1	–	–	–	270	0.30	2.1	–	–	–	–	–	–	–	–	–
	T9325	1.2	255	0.30	2.1	150	0.27	2.1	240	0.30	2.1	–	–	–	55	0.24	1.7	–	–	–

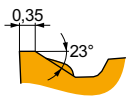
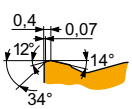
CNMM

PRAMET

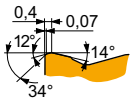
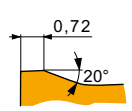
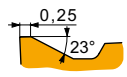
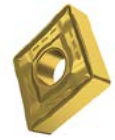
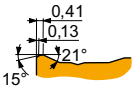
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



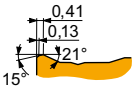
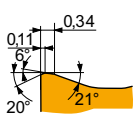
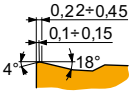
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		
																				
			DR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
CNMM 160612E-DR	**T9315**	1.2	225	0.45	6.0	–	–	–	210	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	200	0.45	6.0	120	0.41	6.0	190	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	170	0.45	6.0	100	0.41	6.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190608E-DR	**T9315**	0.8	215	0.40	8.0	–	–	–	200	0.40	8.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	190	0.40	8.0	110	0.36	8.0	180	0.40	8.0	–	–	–	–	–	–	–	–	–
CNMM 190612E-DR	**T9315**	1.2	220	0.45	8.0	–	–	–	205	0.45	8.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	195	0.45	8.0	115	0.41	8.0	185	0.45	8.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	170	0.45	8.0	100	0.41	8.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190616E-DR	**T9325**	1.6	195	0.50	9.0	115	0.45	9.0	185	0.50	9.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	170	0.50	9.0	100	0.45	9.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
			HR断屑槽，适用于粗加工至重载粗加工，连续切削至间断切削。																	
CNMM 190616E-HR	**6640**	1.6	75	0.60	10.0	45	0.54	10.0	70	0.60	10.0	–	–	–	–	–	–	–	–	–
	T8345	1.6	55	0.60	10.0	30	0.54	10.0	50	0.60	10.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	105	0.60	10.0	60	0.54	10.0	95	0.60	10.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	80	0.60	10.0	45	0.54	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR	**T8345**	2.4	60	0.65	10.0	35	0.59	10.0	55	0.65	10.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	115	0.65	10.0	–	–	–	105	0.65	10.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	100	0.65	10.0	60	0.59	10.0	95	0.65	10.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	85	0.65	10.0	50	0.59	10.0	–	–	–	–	–	–	–	–	–	–	–	–

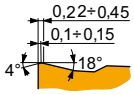
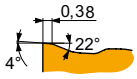
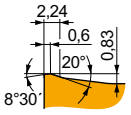
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			HR断屑槽，适用于粗加工至重载粗加工，连续切削至间断切削。																	
CNMM 250924E-HR	**6640**	2.4	■ 75	0.65	14.0	◪ 45	0.59	14.0	■ 70	0.65	14.0	–	–	–	–	–	–	–	–	–
	T8345	2.4	■ 55	0.65	14.0	◪ 30	0.59	14.0	◪ 50	0.65	14.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	■ 110	0.65	14.0	–	–	–	◪ 100	0.65	14.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	■ 100	0.65	14.0	◪ 60	0.59	14.0	◪ 95	0.65	14.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	■ 80	0.65	14.0	◪ 45	0.59	14.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
			HR2断屑槽，适用于粗加工至重载粗加工，连续切削至间断切削。																	
CNMM 190616-HR2	**T9226**	1.6	■ 85	0.65	10.0	◪ 50	0.59	10.0	◪ 80	0.65	10.0	–	–	–	–	–	–	–	–	–
	T9315	1.6	■ 110	0.65	10.0	–	–	–	◪ 100	0.65	10.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	■ 80	0.65	10.0	◪ 45	0.59	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190624-HR2	**T9226**	2.4	■ 80	0.85	10.0	◪ 45	0.77	10.0	◪ 75	0.85	10.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	■ 100	0.85	10.0	–	–	–	◪ 95	0.85	10.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	■ 75	0.85	10.0	◪ 45	0.77	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2	**T9315**	2.4	■ 100	0.85	12.0	–	–	–	◪ 95	0.85	12.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	■ 75	0.85	12.0	◪ 45	0.77	12.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
			NR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
CNMM 120408E-NR	**6640**	0.8	■ 155	0.40	3.0	■ 90	0.36	3.0	◪ 145	0.40	3.0	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪ 175	0.40	3.0	■ 135	0.36	3.0	–	–	–	–	–	–	◪ 55	0.28	2.4	–	–	–
	T7335	0.8	◪ 165	0.40	3.0	■ 125	0.36	3.0	–	–	–	–	–	–	◪ 50	0.28	2.4	–	–	–
	T8330	0.8	■ 155	0.40	3.0	■ 90	0.36	3.0	◪ 145	0.40	3.0	–	–	–	◪ 35	0.28	2.4	–	–	–
	T8430	0.8	■ 165	0.40	3.0	■ 90	0.36	3.0	◪ 135	0.40	3.0	–	–	–	◪ 35	0.28	2.4	–	–	–
	T9315	0.8	■ 215	0.40	3.0	–	–	–	◪ 200	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 195	0.40	3.0	■ 115	0.36	3.0	◪ 185	0.40	3.0	–	–	–	◪ 40	0.28	2.4	–	–	–
CNMM 120412E-NR	**T7325**	1.2	◪ 185	0.40	3.0	■ 140	0.36	3.0	–	–	–	–	–	–	◪ 60	0.28	2.4	–	–	–
	T7335	1.2	◪ 175	0.40	3.0	■ 135	0.36	3.0	–	–	–	–	–	–	◪ 55	0.28	2.4	–	–	–
	T8330	1.2	■ 165	0.40	3.0	■ 95	0.36	3.0	◪ 155	0.40	3.0	–	–	–	◪ 40	0.28	2.4	–	–	–
	T8430	1.2	■ 170	0.40	3.0	■ 90	0.36	3.0	◪ 135	0.40	3.0	–	–	–	◪ 35	0.28	2.4	–	–	–
	T9325	1.2	■ 205	0.40	3.0	■ 120	0.36	3.0	◪ 190	0.40	3.0	–	–	–	◪ 45	0.28	2.4	–	–	–
																				
			NR2断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
CNMM 120408E-NR2	**T7325**	0.8	◪ 165	0.40	5.0	■ 125	0.36	5.0	–	–	–	–	–	–	◪ 50	0.28	4.0	–	–	–
	T7335	0.8	◪ 155	0.40	5.0	■ 120	0.36	5.0	–	–	–	–	–	–	◪ 50	0.28	4.0	–	–	–
	T8330	0.8	■ 150	0.40	5.0	■ 90	0.36	5.0	◪ 140	0.40	5.0	–	–	–	◪ 35	0.28	4.0	–	–	–
	T8430	0.8	■ 150	0.40	5.0	■ 80	0.36	5.0	◪ 125	0.40	5.0	–	–	–	◪ 30	0.28	4.0	–	–	–
	T9315	0.8	■ 205	0.40	5.0	–	–	–	◪ 190	0.40	5.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 185	0.40	5.0	■ 110	0.36	5.0	◪ 175	0.40	5.0	–	–	–	◪ 40	0.28	4.0	–	–	–
CNMM 120412E-NR2	**T7335**	1.2	◪ 155	0.45	5.0	■ 120	0.41	5.0	–	–	–	–	–	–	◪ 50	0.32	4.0	–	–	–
	T8330	1.2	■ 150	0.45	5.0	■ 90	0.41	5.0	◪ 140	0.45	5.0	–	–	–	◪ 35	0.32	4.0	–	–	–
	T8430	1.2	■ 150	0.45	5.0	■ 80	0.41	5.0	◪ 125	0.45	5.0	–	–	–	◪ 30	0.32	4.0	–	–	–
	T9315	1.2	■ 205	0.45	5.0	–	–	–	◪ 190	0.45	5.0	–	–	–	–	–	–	–	–	–
	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	**T8330**	0.8	■ 145	0.40	6.0	■ 85	0.36	6.0	◪ 135	0.40	6.0	–	–	–	◪ 35	0.32	4.8	–	–	–
	T8430	0.8	■ 150	0.40	6.0	■ 80	0.36	6.0	◪ 125	0.40	6.0	–	–	–	◪ 30	0.32	4.8	–	–	–
	T9325	0.8	■ 180	0.40	6.0	■ 105	0.36	6.0	◪ 170	0.40	6.0	–	–	–	◪ 40	0.32	4.8	–	–	–

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

产品型号		RE	P			M			K			N			S			H		
			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)
																				
NR2断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
CNMM 160612E-NR2	**T7325**	1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
	T7335	1.2	155	0.45	6.0	120	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
	T8330	1.2	145	0.45	6.0	85	0.41	6.0	135	0.45	6.0	–	–	–	35	0.36	4.8	–	–	–
	T8430	1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	–	–	–	30	0.36	4.8	–	–	–
	T9315	1.2	205	0.45	6.0	–	–	–	190	0.45	6.0	–	–	–	–	–	–	–	–	–
	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	–	–	–
	T7335	1.6	160	0.50	6.0	120	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
	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	–	–	–
	T7335	1.2	145	0.45	9.0	110	0.41	9.0	–	–	–	–	–	–	45	0.36	7.2	–	–	–
	T8330	1.2	140	0.45	9.0	80	0.41	9.0	130	0.45	9.0	–	–	–	35	0.36	7.2	–	–	–
	T8430	1.2	140	0.45	9.0	75	0.41	9.0	115	0.45	9.0	–	–	–	30	0.36	7.2	–	–	–
	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	–	–	–
	T7335	1.6	150	0.50	9.0	115	0.45	9.0	–	–	–	–	–	–	45	0.40	7.2	–	–	–
	T8330	1.6	140	0.50	9.0	80	0.45	9.0	130	0.50	9.0	–	–	–	35	0.40	7.2	–	–	–
	T8430	1.6	140	0.50	9.0	75	0.45	9.0	115	0.50	9.0	–	–	–	30	0.40	7.2	–	–	–
	T9315	1.6	195	0.50	9.0	–	–	–	185	0.50	9.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	175	0.50	9.0	105	0.45	9.0	165	0.50	9.0	–	–	–	35	0.40	7.2	–	–	–
CNMM 190624E-NR2	**T7335**	2.4	130	0.80	9.0	100	0.72	9.0	–	–	–	–	–	–	40	0.56	7.2	–	–	–
	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	**T7325**	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
	T7335	2.4	95	0.80	12.0	70	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
	T8430	2.4	80	0.80	12.0	45	0.72	12.0	65	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
	T9315	2.4	110	0.80	12.0	–	–	–	100	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	100	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
																				
NRM断屑槽，具有正前角设计，适用于中粗加工至粗加工，连续至断续切削。																				
CNMM 250924-NRM	**T7325**	2.4	95	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	30	0.49	8.0	–	–	–
	T7335	2.4	90	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	25	0.49	8.0	–	–	–
	T9315	2.4	115	0.70	10.0	–	–	–	105	0.70	10.0	–	–	–	–	–	–	–	–	–
																				
OR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
CNMM 120408E-OR	**T8330**	0.8	150	0.40	5.0	90	0.36	5.0	140	0.40	5.0	–	–	–	35	0.28	4.0	–	–	–
	T8430	0.8	150	0.40	5.0	80	0.36	5.0	125	0.40	5.0	–	–	–	30	0.28	4.0	–	–	–
	T9315	0.8	205	0.40	5.0	–	–	–	190	0.40	5.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	185	0.40	5.0	110	0.36	5.0	175	0.40	5.0	–	–	–	40	0.28	4.0	–	–	–
	T9335	0.8	160	0.40	5.0	95	0.36	5.0	–	–	–	–	–	–	35	0.28	4.0	–	–	–
CNMM 120412E-OR	**T9315**	1.2	205	0.45	5.0	–	–	–	190	0.45	5.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	185	0.45	5.0	110	0.41	5.0	175	0.45	5.0	–	–	–	40	0.36	4.0	–	–	–
	T9335	1.2	165	0.45	5.0	95	0.41	5.0	–	–	–	–	–	–	35	0.36	4.0	–	–	–
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	–	–	–
	T9335	1.6	165	0.50	5.0	95	0.45	5.0	–	–	–	–	–	–	35	0.40	4.0	–	–	–
CNMM 160608E-OR	**T9315**	0.8	205	0.40	6.0	–	–	–	190	0.40	6.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	180	0.40	6.0	105	0.36	6.0	170	0.40	6.0	–	–	–	40	0.32	4.8	–	–	–
	T9335	0.8	160	0.40	6.0	95	0.36	6.0	–	–	–	–	–	–	35	0.32	4.8	–	–	–
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	–	–	–
	T9315	1.2	205	0.45	6.0	–	–	–	190	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–

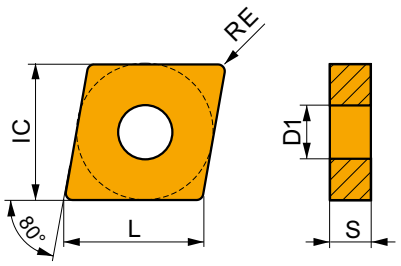
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
OR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
CNMM 160616E-OR	**T9315**	1.6	■	205	0.50	6.0		–	–	–	◪	190	0.50	6.0	–	–	–		–	–	–	–	–	–
	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-OR	**T8330**	1.2	■	140	0.45	9.0	◪	80	0.41	9.0	■	130	0.45	9.0	–	–	–	◪	35	0.36	7.2	–	–	–
	T8430	1.2	■	140	0.45	9.0	◪	75	0.41	9.0	◪	115	0.45	9.0	–	–	–	◪	30	0.36	7.2	–	–	–
	T9315	1.2	■	195	0.45	9.0		–	–	–	◪	185	0.45	9.0	–	–	–		–	–	–	–	–	–
	T9325	1.2	■	175	0.45	9.0	◪	105	0.41	9.0	◪	165	0.45	9.0	–	–	–	◪	35	0.36	7.2	–	–	–
	T9335	1.2	■	150	0.45	9.0	◪	90	0.41	9.0		–	–	–	–	–	–	◪	30	0.36	7.2	–	–	–
CNMM 190616E-OR	**T8330**	1.6	■	140	0.50	9.0	◪	80	0.45	9.0	■	130	0.50	9.0	–	–	–	◪	35	0.40	7.2	–	–	–
	T8345	1.6	■	120	0.50	9.0	◪	70	0.45	9.0	◪	110	0.50	9.0	–	–	–	◪	30	0.40	7.2	–	–	–
	T8430	1.6	■	140	0.50	9.0	◪	75	0.45	9.0	◪	115	0.50	9.0	–	–	–	◪	30	0.40	7.2	–	–	–
	T9315	1.6	■	195	0.50	9.0		–	–	–	◪	185	0.50	9.0	–	–	–		–	–	–	–	–	–
	T9325	1.6	■	175	0.50	9.0	◪	105	0.45	9.0	◪	165	0.50	9.0	–	–	–	◪	35	0.40	7.2	–	–	–
	T9335	1.6	■	155	0.50	9.0	◪	90	0.45	9.0		–	–	–	–	–	–	◪	30	0.40	7.2	–	–	–
CNMM 190624E-OR	**T9315**	2.4	■	165	0.80	9.0		–	–	–	◪	155	0.80	9.0	–	–	–		–	–	–	–	–	–
	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-OR	**T8330**	2.4	■	75	1.00	12.0	◪	45	0.90	12.0	■	70	1.00	12.0	–	–	–	◪	15	0.70	9.6	–	–	–
	T8430	2.4	■	75	1.00	12.0	◪	40	0.90	12.0	◪	60	1.00	12.0	–	–	–	◪	15	0.70	9.6	–	–	–
	T9315	2.4	■	100	1.00	12.0		–	–	–	◪	95	1.00	12.0	–	–	–		–	–	–	–	–	–
	T9325	2.4	■	95	1.00	12.0	◪	55	0.90	12.0	◪	90	1.00	12.0	–	–	–	◪	20	0.70	9.6	–	–	–
	T9335	2.4	■	75	1.00	12.0	◪	45	0.90	12.0		–	–	–	–	–	–	◪	15	0.70	9.6	–	–	–
																				
OR1断屑槽，适用于中粗加工至重载粗加工，连续至断续切削。																				
CNMM 190616E-OR1	**T9325**	1.6	■	175	0.50	9.0	◪	105	0.45	9.0	◪	165	0.50	9.0	–	–	–	◪	35	0.35	7.2	–	–	–
	T9335	1.6	■	155	0.50	9.0	◪	90	0.45	9.0		–	–	–	–	–	–	◪	30	0.35	7.2	–	–	–
																				
断屑槽923，适用于中粗加工至重载粗加工，连续至重断续切削。																				
CNMM 250924S-923	**T8330**	2.4	■	75	0.85	12.0	■	45	0.77	12.0	◪	70	0.85	12.0	–	–	–	◪	15	0.60	9.6	–	–	–
	T8430	2.4	■	75	0.85	12.0	■	40	0.77	12.0	◪	60	0.85	12.0	–	–	–	◪	15	0.60	9.6	–	–	–
	T9335	2.4	■	75	0.85	12.0	■	45	0.77	12.0		–	–	–	–	–	–	◪	15	0.60	9.6	–	–	–

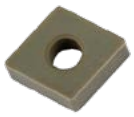
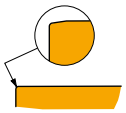
CNGA CER

PRAMET

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



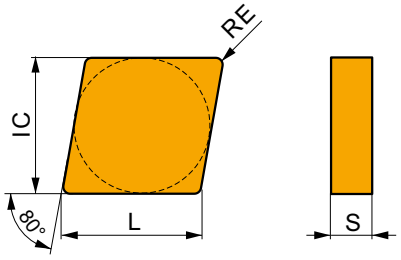
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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																	
			适用于高线速度连续切削。																	
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	–	–	–	–	–	–	–	–	–

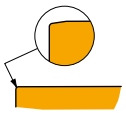
CNGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
1204	12.700	12.90	4.76
1207	12.700	12.90	7.94



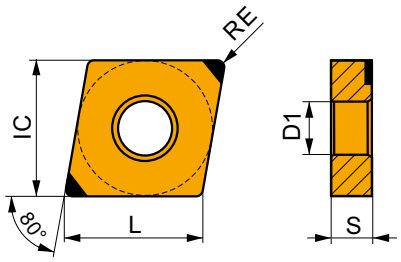
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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																	
			适用于高线速度连续切削。																	
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	–	–	–	–	–	–	–	–	–

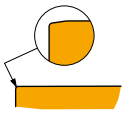
CNGA CBN

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。

产品型号		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															
			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	0.15	1.0
CNGA 120408S01020B	TB310	0.8	–	–	–	–	–	–	530	0.15	0.6	–	–	–	140	0.11	0.5	110	0.15	1.0

DCBN(RL) EXT

P M K N S H

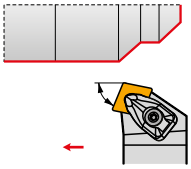
PRAMET

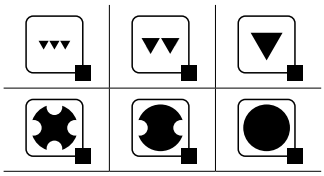
D

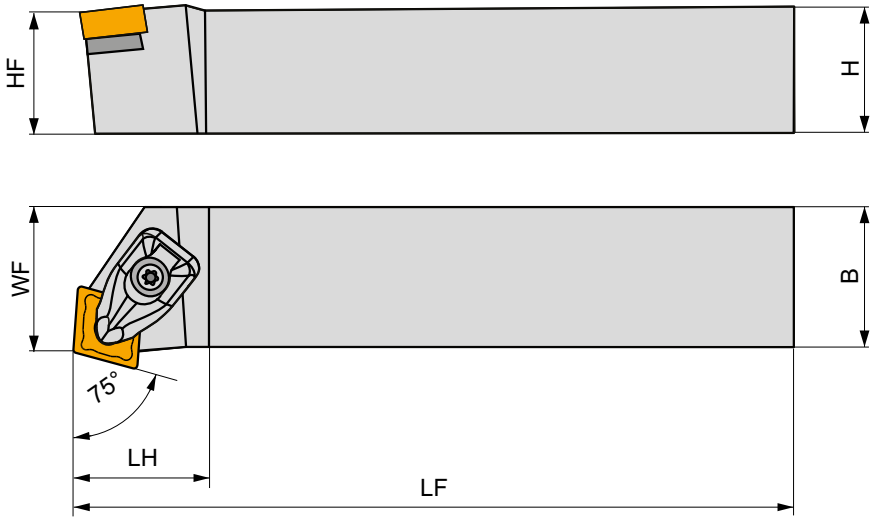


外圆用双重夹紧车刀杆，使用CN..刀片，主偏角为75°。

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。











	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg			
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	-6	-6	1.11	GI050	DC16	AT005
	DCBNR 3232 P 19	32	32	32	27	170	46.1	-6	-6	1.39	GI042	DC19	–
	DCBNR 4040 S 19	40	40	40	35	250	46.7	-6	-6	3.16	GI042	DC19	–
L	DCBNL 2020 K 12	20	20	20	17	125	34.2	-6	-6	0.43	GI043	DC12	AT001
	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	-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

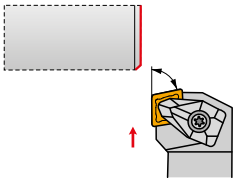
PRAMET

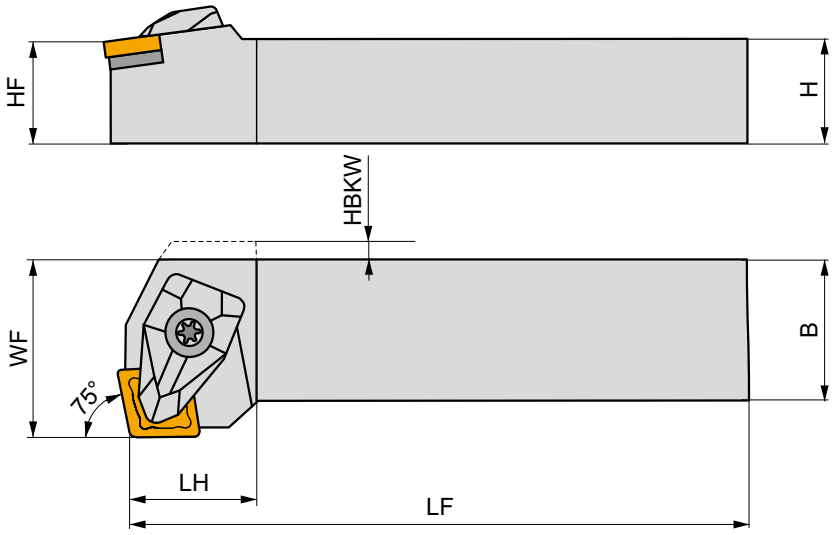
D

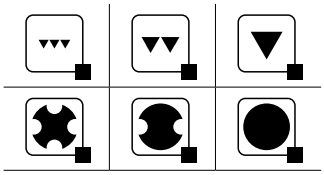


外圆用双重夹紧车刀杆，使用CN..刀片，主偏角为75°（端面）。

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。







	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	HBKW (mm)	LAMS (°)	GAMO (°)	kg			
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	–	-6	-6	1.46	GI050	DC16	AT005
L	**DCKNL 2020 K 12**	20	20	20	25	125	21.2	4.5	-6	-6	0.46	GI043	DC12	AT001
	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	–	-6	-6	1.46	GI050	DC16	AT005

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

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

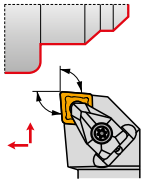
PRAMET

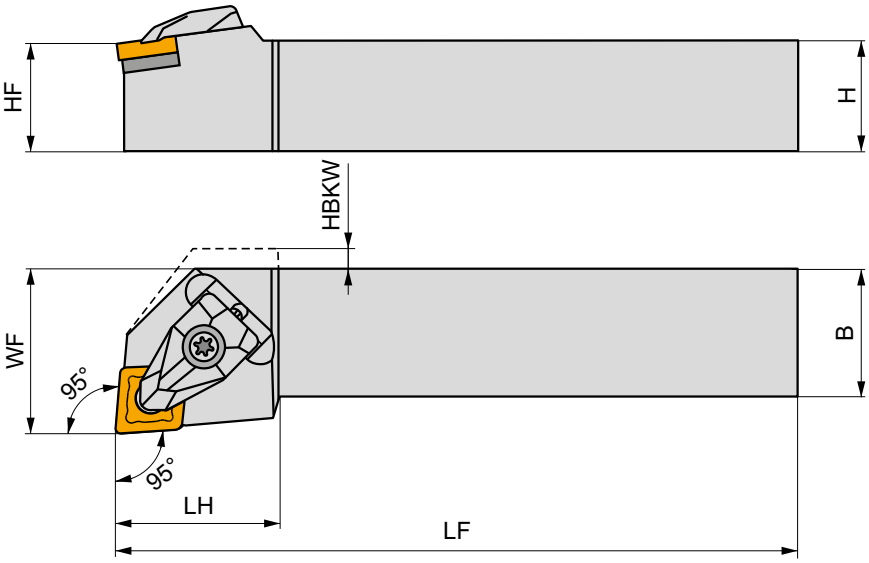
D

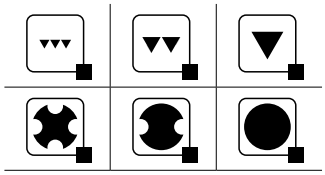


外圆用双重夹紧车削刀杆，使用CN..刀片，主偏角为95°。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	HBKW (mm)	LAMS (°)	GAMO (°)	kg			
R	DCLNR 1616 H 09	16	16	16	20	100	25	–	-6	-6	0.27	GI133	DC09	–
	DCLNR 2020 K 09	20	20	20	25	125	25	–	-6	-6	0.44	GI133	DC09	–
	DCLNR 2525 M 09	25	25	25	32	150	25	–	-6	-6	0.78	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	–	-6	-6	0.44	GI043	DC12	AT001
	DCLNR 2525 M 12	25	25	25	32	150	30	–	-6	-6	0.78	GI043	DC12	AT001
	DCLNR 3225 P 12	32	25	32	32	170	30	–	-6	-6	1.10	GI043	DC12	AT001
	DCLNR 2525 M 16	25	25	25	32	150	39	–	-6	-6	0.81	GI050	DC16	AT005
	DCLNR 3225 P 16	32	25	32	32	170	35	–	-6	-6	1.20	GI050	DC16	AT005
	DCLNR 3232 P 19	32	32	32	40	170	40	–	-6	-6	1.55	GI042	DC19	–
	DCLNR 4040 S 19	40	40	40	50	250	43.4	–	-6	-6	3.26	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	–	-6	-6	0.44	GI043	DC12	AT001
	DCLNL 2525 M 12	25	25	25	32	150	32	–	-6	-6	0.78	GI043	DC12	AT001
	DCLNL 3225 P 12	32	25	32	32	170	32	–	-6	-6	1.10	GI043	DC12	AT001
	DCLNL 2525 M 16	25	25	25	32	150	39	–	-6	-6	0.81	GI050	DC16	AT005
	DCLNL 3225 P 16	32	25	32	32	170	39	–	-6	-6	1.20	GI050	DC16	AT005
	DCLNL 3232 P 19	32	32	32	40	170	43.2	–	-6	-6	1.51	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

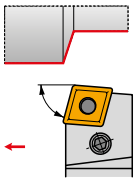
PRAMET

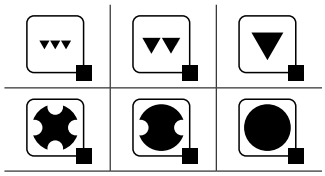
P

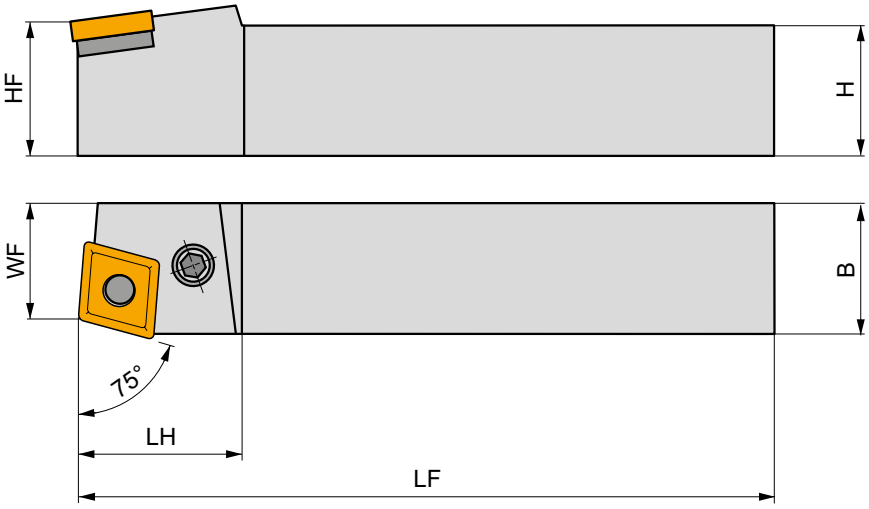


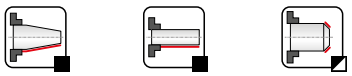
外圆用杠杆锁车削刀杆，使用CN..刀片，主偏角为75°。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PCBNR 2020 K 12	20	20	20	17	125	36	-6	-6	0.43	GI043	PC22
	PCBNR 2525 M 12	25	25	25	22	150	36	-6	-6	0.63	GI043	PC20
	PCBNR 3225 P 12	32	25	32	22	170	36	-6	-6	0.70	GI043	PC20
	PCBNR 3232 P 16	32	32	32	27	170	40	-6	-6	1.36	GI050	PC40
	PCBNR 3232 P 19	32	32	32	27	170	45	-6	-6	1.10	GI042	PC50
	PCBNR 4040 S 19	40	40	40	35	250	45	-6	-6	3.15	GI042	PC50
	PCBNR 4040 S 25	40	40	40	35	250	45	-6	-6	3.10	GI062	PC60
	PCBNR 5050 T 25	50	50	50	43	300	50	-6	-6	5.80	GI062	PC60
L	PCBNL 2020 K 12	20	20	20	17	125	36	-6	-6	0.38	GI043	PC22
	PCBNL 2525 M 12	25	25	25	22	150	36	-6	-6	0.73	GI043	PC20
	PCBNL 3225 P 12	32	25	32	22	170	36	-6	-6	0.70	GI043	PC20
	PCBNL 3232 P 16	32	32	32	27	170	40	-6	-6	1.25	GI050	PC40
	PCBNL 3232 P 19	32	32	32	27	170	45	-6	-6	1.10	GI042	PC50
	PCBNL 4040 S 19	40	40	40	35	250	45	-6	-6	3.15	GI042	PC50
	PCBNL 4040 S 25	40	40	40	35	250	45	-6	-6	3.15	GI062	PC60
	PCBNL 5050 T 25	50	50	50	43	300	50	-6	-6	5.80	GI062	PC60

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

				Nm					
PC20	CNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PC22	CNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXK 4
PC40	CNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4
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

PCKN(RL) EXT

P M K N S H

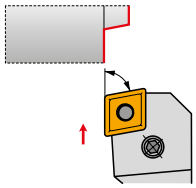
PRAMET

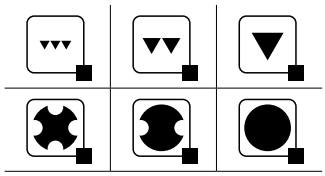
P

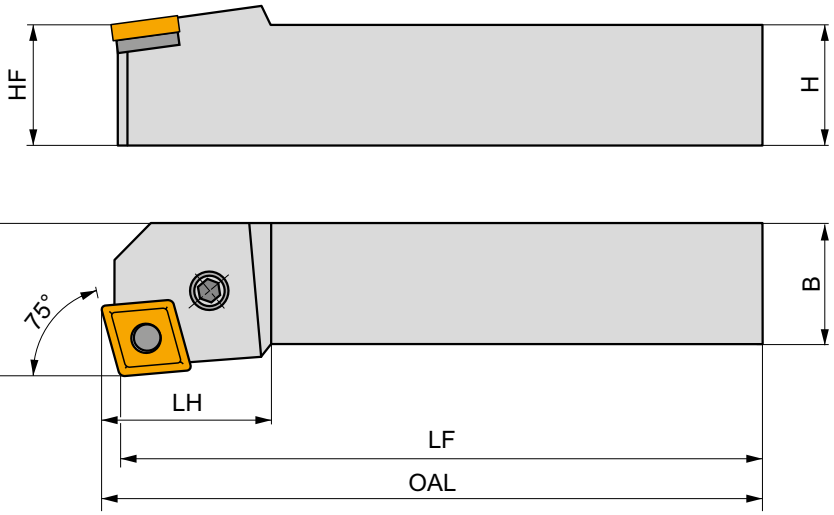


外圆用杠杆夹紧式车刀杆，使用CN..刀片，主偏角为75°（端面车削）。

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。











	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PCKNR 2020 K 12**	20	20	20	25	125	36	-6	-6	0.42	GI043	PC22
	PCKNR 2525 M 12	25	25	25	32	150	36	-6	-6	0.79	GI043	PC20
	PCKNR 3225 P 12	32	25	32	32	170	36	-6	-6	0.85	GI043	PC20
	PCKNR 3232 P 16	32	32	32	40	170	40	-6	-6	1.43	GI050	PC40
	PCKNR 3232 P 19	32	32	32	40	170	45	-6	-6	1.40	GI042	PC50
	PCKNR 4040 S 19	40	40	40	50	250	45	-6	-6	3.25	GI042	PC50
L	**PCKNL 2020 K 12**	20	20	20	25	125	36	-6	-6	0.42	GI043	PC22
	PCKNL 2525 M 12	25	25	25	32	150	36	-6	-6	0.78	GI043	PC20
	PCKNL 3225 P 12	32	25	32	32	170	36	-6	-6	1.15	GI043	PC20
	PCKNL 3232 P 16	32	32	32	40	170	40	-6	-6	1.40	GI050	PC40
	PCKNL 3232 P 19	32	32	32	40	170	45	-6	-6	1.40	GI042	PC50
	PCKNL 4040 S 19	40	40	40	50	250	45	-6	-6	3.27	GI042	PC50

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

				Nm					
PC20	CNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PC22	CNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXK 4
PC40	CNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4
PC50	CNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5

PCLN(RL) EXT

P M K N S H

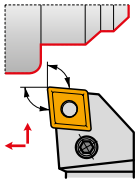
PRAMET

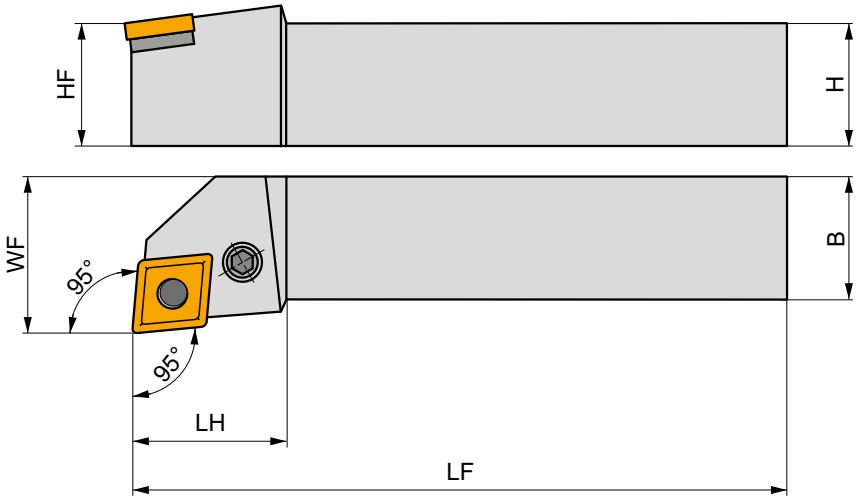
P

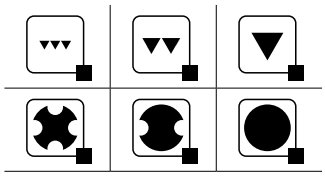


外圆用杠杆锁车削刀杆，使用CN..刀片，主偏角为95°。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PCLNR 2020 K 12	20	20	20	25	125	36	-6	-6	0.44	GI043	PC22
	PCLNR 2525 M 12	25	25	25	32	150	36	-6	-6	0.68	GI043	PC20
	PCLNR 3225 P 12	32	25	32	32	170	36	-6	-6	0.98	GI043	PC20
	PCLNR 3225 P 16	32	25	32	32	170	40	-6	-6	1.10	GI050	PC40
	PCLNR 3232 P 19	32	32	32	40	170	45	-6	-6	1.40	GI042	PC50
	PCLNR 4040 R 19	40	40	40	50	200	45	-6	-6	2.50	GI042	PC50
	PCLNR 4040 S 19	40	40	40	50	250	45	-6	-6	3.19	GI042	PC50
	PCLNR 4040 S 25	40	40	40	50	250	45	-6	-6	3.15	GI062	PC60
	PCLNR 5050 T 25	50	50	50	60	300	50	-6	-6	5.90	GI062	PC60
L	PCLNL 2020 K 12	20	20	20	25	125	36	-6	-6	0.42	GI043	PC22
	PCLNL 2525 M 12	25	25	25	32	150	36	-6	-6	0.75	GI043	PC20
	PCLNL 3225 P 12	32	25	32	32	170	36	-6	-6	1.10	GI043	PC20
	PCLNL 3225 P 16	32	25	32	32	170	40	-6	-6	1.10	GI050	PC40
	PCLNL 3232 P 19	32	32	32	40	170	45	-6	-6	1.42	GI042	PC50
	PCLNL 4040 R 19	40	40	40	50	200	45	-6	-6	2.60	GI042	PC50
	PCLNL 4040 S 19	40	40	40	50	250	45	-6	-6	3.19	GI042	PC50
	PCLNL 4040 S 25	40	40	40	50	250	45	-6	-6	2.45	GI062	PC60
	PCLNL 5050 T 25	50	50	50	60	300	50	-6	-6	5.90	GI062	PC60

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

				Nm					
PC20	CNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PC22	CNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXK 4
PC40	CNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4
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

NEW

C.-DCLN(RL) EXT

P M K N S H

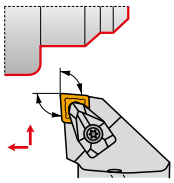
PRAMET

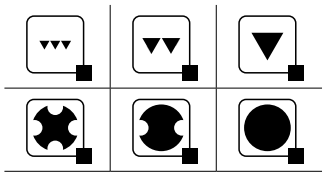
D

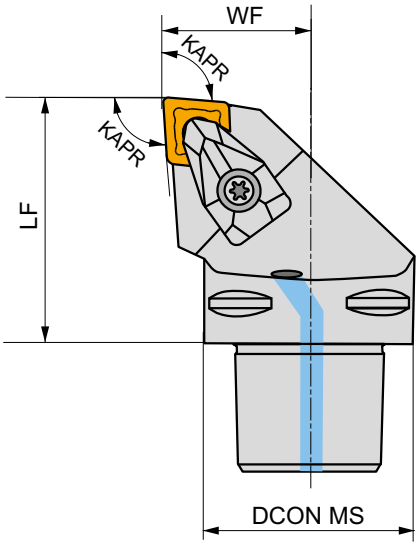


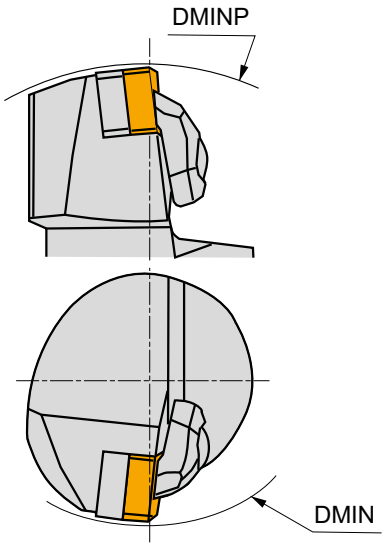
外圆用PSC快速更换式刀柄，双重夹紧，使用CN..刀片，主偏角为95°。

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。











	产品型号	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	✓	0.48	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	–

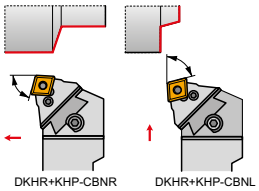
KHP-CBN(RL)

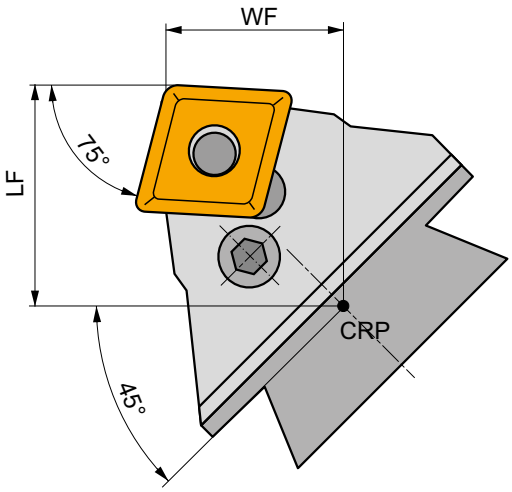
P M K

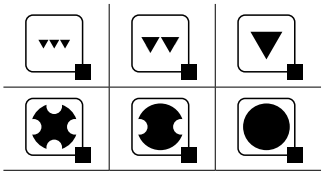
PRAMET P



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/右手杠杆夹紧式车刀夹，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。









产品型号		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 Nm	M 10x1	33	NT 08	MT 08	HXK 5

KHP-CLN(RL)

P M K

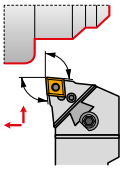
PRAMET

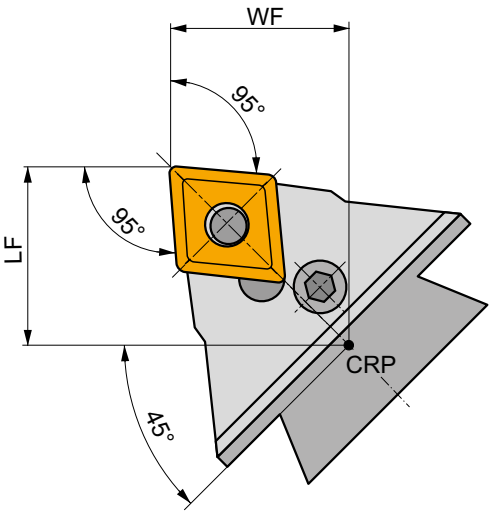
P

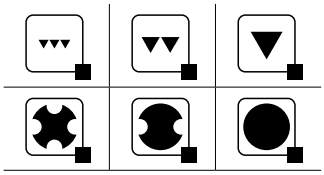


模块化KHP杠杆夹紧式车刀刀夹，使用CN..刀片，主偏角为95°。

燕尾形左/右手杠杆夹紧式车刀夹，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。









	产品型号	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-CLNR 19**	35	45	-6	-6	1.30	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

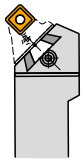
DKH(RL)

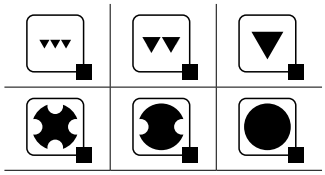
PRAMET

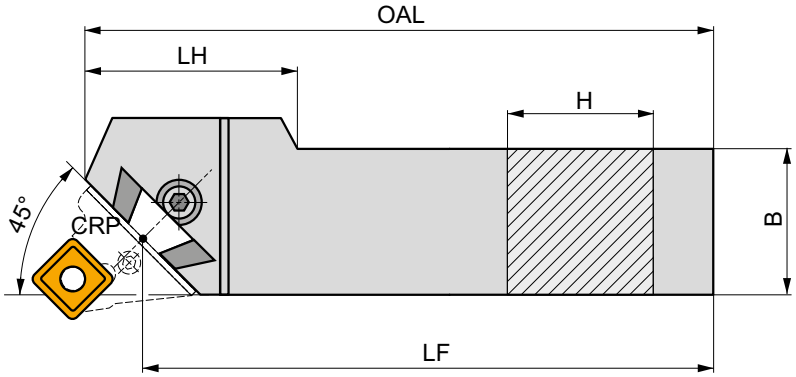


使用KHP/KHS重载车刀刀夹的外圆用刀柄

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。







	产品型号	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

DCLN(RL) INT

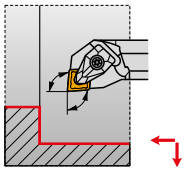
P M K N S H

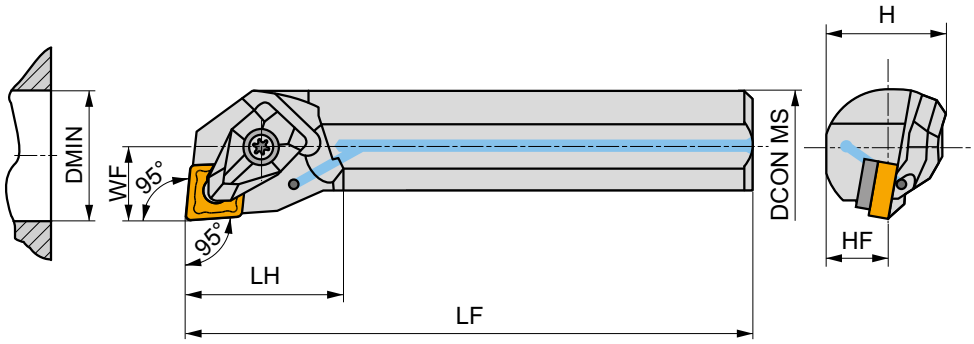
PRAMET D

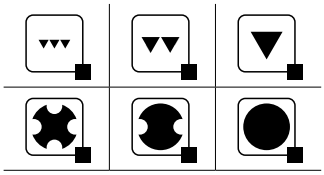


内孔用双重夹紧镗杆，使用CN..刀片，主偏角为95°

内孔用左/右手双重夹紧镗杆，有内冷通道，主偏角为95°，使用CN..09和12刀片。内孔最小加工直径为Ø32mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø25至Ø40mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	-11	-6	✓	1.13	GI133	DC09
	A25T-DCLNR 12	25	32	17	23	11.5	300	31	-12	-6	✓	1.12	GI043	DCI12
	A32T-DCLNR 12	32	40	22	30	15	300	30	-10	-6	✓	1.68	GI043	DCI12
	A40T-DCLNR 12	40	50	27	37	18.5	300	32	-15	-6	✓	2.56	GI043	DC12
L	**A25T-DCLNL 09**	25	32	17	23	11.5	300	31	-11	-6	✓	1.12	GI133	DC09
	A25T-DCLNL 12	25	32	17	23	11.5	300	31	-12	-6	✓	1.11	GI043	DCI12
	A32T-DCLNL 12	32	40	22	30	15	300	30	-10	-6	✓	1.68	GI043	DCI12
	A40T-DCLNL 12	40	50	27	37	18.5	300	32	-15	-6	✓	2.56	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

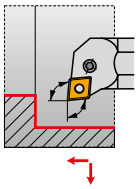
PRAMET

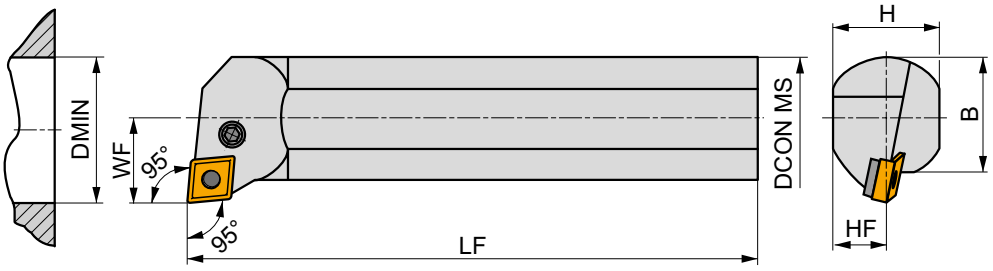
P

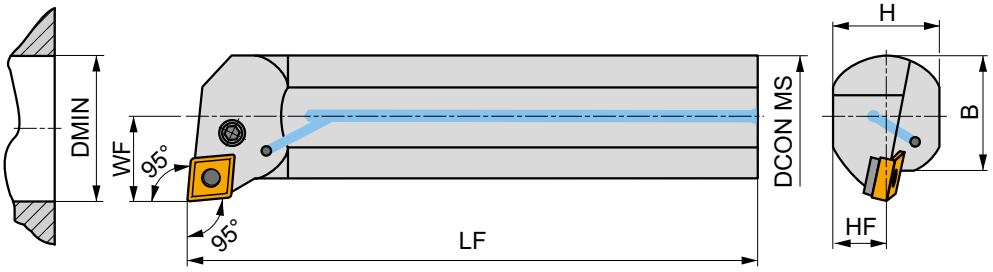


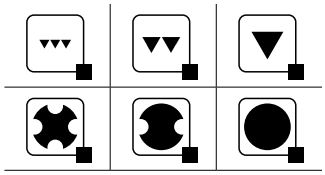
外圆用杠杆夹紧式镗杆，使用CN..刀片，主偏角为95°。

内孔用左/右手杠杆夹紧式镗杆，有内冷通道，主偏角为95°，使用CN..09、12、16和19刀片。内孔最小加工直径为Ø20mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø16至Ø60mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16M-PCLNR 09	16	20	11	15	15	150	-13.5	-5	✓	0.22	GI133	PC09
	A20Q-PCLNR 09	20	25	13	18	18	180	-13.5	-5	✓	0.36	GI133	PC09
	A25R-PCLNR 12	25	32	17	23	23	200	-13	-7	✓	0.65	GI043	PC25
	S25T-PCLNR 12	25	32	17	23	23	300	-13	-7	–	1.10	GI043	PC25
	A32S-PCLNR 12	32	40	22	30	30	250	-12	-6	✓	1.48	GI043	PC21
	A40T-PCLNR 12	40	50	27	38	38	300	-12	-6	✓	2.40	GI043	PC20
	A40T-PCLNR 16	40	50	27	38	38	300	-12	-6	✓	2.90	GI050	PC41
	A50U-PCLNR 16	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI050	PC40
	A60V-PCLNR 16	60	80	43	57	58.5	400	-12	-6	✓	8.70	GI050	PC40
	A50U-PCLNR 19	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI042	PC50
	A60V-PCLNR 19	60	80	43	57	58.5	400	-12	-6	✓	8.22	GI042	PC50
L	A16M-PCLNL 09	16	20	11	15	15	150	-13.5	-5	✓	0.20	GI133	PC09
	A20Q-PCLNL 09	20	25	13	18	18	180	-13.5	-5	✓	0.34	GI133	PC09
	A25R-PCLNL 12	25	32	17	23	23	200	-13	-7	✓	0.65	GI043	PC25
	S25T-PCLNL 12	25	32	17	23	23	300	-13	-7	–	1.15	GI043	PC25
	A32S-PCLNL 12	32	40	22	30	30	250	-12	-6	✓	1.48	GI043	PC21
	A40T-PCLNL 12	40	50	27	38	38	300	-12	-6	✓	2.58	GI043	PC20
	A40T-PCLNL 16	40	50	27	38	38	300	-12	-6	✓	2.58	GI050	PC41
	A50U-PCLNL 16	50	63	35	47	48.5	350	-12	-6	✓	4.95	GI050	PC40
	A60V-PCLNL 16	60	80	43	57	58.5	400	-12	-6	✓	8.70	GI050	PC40
	A50U-PCLNL 19	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI042	PC50
	A60V-PCLNL 19	60	80	43	57	58.5	400	-12	-6	✓	8.40	GI042	PC50

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

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

PC09	–	PU 8451	PS 8290	2.0	M 5	12	–	–	HXK 2
PC20	CNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PC21	CNU 120312	PU 02	US 41	6.0	M 8x1	17	NT 05	MT 05	HXK 4
PC25	–	PU 32	US 46	5.0	M 6x0.75	13.2	–	–	HXK 3
PC40	CNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4
PC41	CNU 150312	PU 04	US 40	6.0	M 8x1	20.5	NT 07	MT 07	HXK 4
PC50	CNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5

NEW

C.-DCLN(RL) INT

P M K N S H

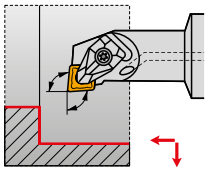
PRAMET

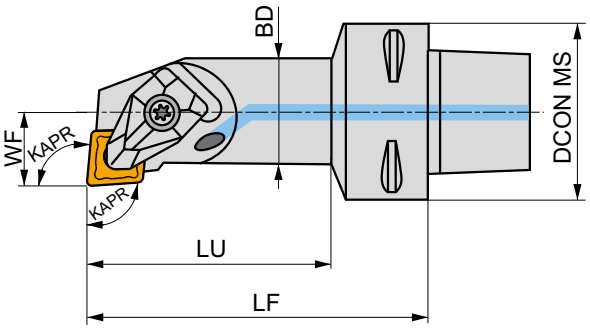
D

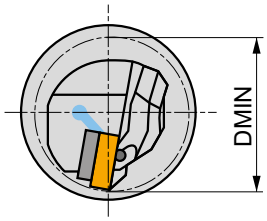


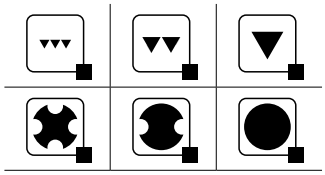
内孔用PSC快速更换式刀柄，双重夹紧，使用CN..刀片，主偏角为95°。

内孔用左/右手双重夹紧刀具，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。最小直径Ø25mm。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。











	产品型号	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
	C4-DCLNR-17090-12	40	32	17	90	68	25	95	-12	-6	✓	0.53	GI043	DCI12
	C5-DCLNR-17090-12	50	32	17	90	66	25	95	-12	-6	✓	0.72	GI043	DCI12
	C6-DCLNR-17100-12	63	32	17	100	72	25	95	-12	-6	✓	1.15	GI043	DCI12
	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
	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	–

DN

11/ 15

硬质合金刀片

DNMA



260

DNMG



260

DNMM



270

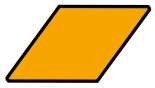
CER和CBN刀片

DNGA CER



271

DNGN CER



271

DNGA CBN



272

匹配正确的尺寸（示例）

刀片	刀杆
DNMG 150404E-SF	DDJNL 2020 K 15

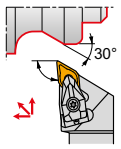
ISO 外圆车削

DDJN(RL) EXT

93°

DN..

11
15



20×20
32×32

273

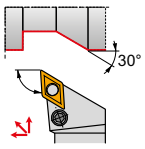
260 – 272

PDJN(RL) EXT

93°

DN..

11
15



20×20
32×32

274

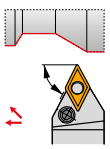
260 – 272

PDNN(RL) EXT

62°30´

DN..

11
15



20×20
32×25

275

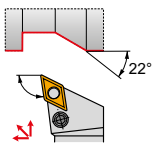
260 – 272

PDXN(RL) EXT

98°

DN..

15



20×20
32×25

276

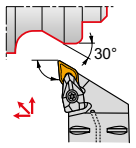
260 – 272

C.-DDJN(RL) EXT NEW

93°

DN..

11
15



C4
C6

277

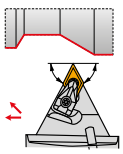
260 – 272

C.-DDNNN EXT NEW

62,5°

DN..

15



C5
C6

278

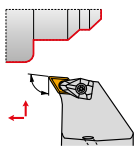
260 – 272

C.-DDUN(RL) EXT NEW

93°

DN..

15



C5
C6

279

260 – 272

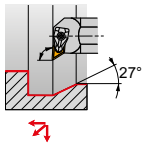
DN

11/ 15

ISO内孔车削

DDUN(RL) INT

93°



DN..



11
15



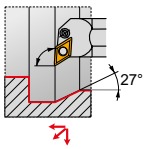
25
50

280

260 – 272

PDUN(RL) INT

93°



DN..



11
15



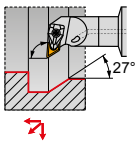
25
60

281

260 – 272

C.-DDUN(RL) INT NEW

93°



DN..



11



12

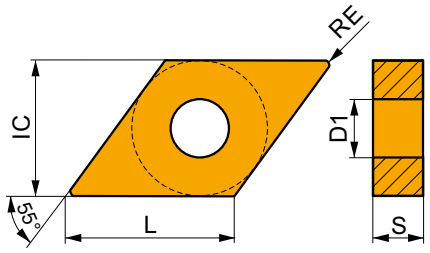
282

260 – 272

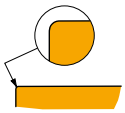
DNMA

PRAMET

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



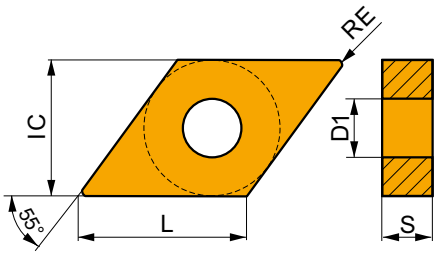
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
			E																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
DNMA 150404	**T5305**	0.4	–	–	–	–	–	–	205	0.10	1.7	–	–	–	–	–	–	40	0.15	1.0
DNMA 150408	**T5305**	0.8	–	–	–	–	–	–	190	0.20	1.7	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	165	0.20	1.7	–	–	–	–	–	–	35	0.15	1.0
DNMA 150604	**T5305**	0.4	–	–	–	–	–	–	205	0.10	1.7	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	180	0.10	1.7	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.4	–	–	–	–	–	–	85	0.10	1.7	–	–	–	–	–	–	20	0.15	1.0
DNMA 150608	**T5305**	0.8	–	–	–	–	–	–	190	0.20	1.7	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	165	0.20	1.7	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	85	0.20	1.7	–	–	–	–	–	–	20	0.15	1.0
DNMA 150612	**T5305**	1.2	–	–	–	–	–	–	200	0.20	1.7	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.2	–	–	–	–	–	–	175	0.20	1.7	–	–	–	–	–	–	35	0.15	1.0

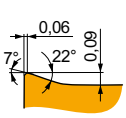
DNMG

PRAMET

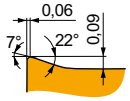
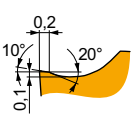
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	4.76



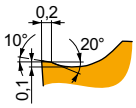
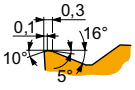
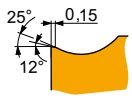
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
			U	S																
			FF断屑槽，具有大正前角设计，适用于超精加工，连续切削至轻微断续切削。																	
DNMG 110402E-FF	**T8315**	0.2	175	0.10	0.8	105	0.09	0.8	165	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	–	–	–	–	–	–	–	–	–
	T8330	0.4	165	0.12	0.8	95	0.11	0.8	155	0.12	0.8	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–

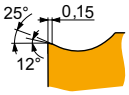
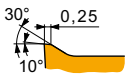
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	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)
																				
FF断屑槽，具有大正前角设计，适用于超精加工，连续切削至轻微断续切削。																				
DNMG 150404E-FF	T8315	0.4	175	0.12	1.0	105	0.11	1.0	165	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150604E-FF	T7325	0.4	190	0.12	1.0	145	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	175	0.12	1.0	105	0.11	1.0	165	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-FF	T7325	0.8	210	0.15	1.0	160	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	–	–	–	–	–	–	–	–	–
																				
FM断屑槽，具有正前角设计，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
DNMG 110404E-FM	T7325	0.4	165	0.20	0.8	125	0.18	0.8	–	–	–	–	–	–	50	0.20	0.6	–	–	–
	T8315	0.4	150	0.20	0.8	90	0.18	0.8	140	0.20	0.8	–	–	–	35	0.14	0.6	–	–	–
	T8330	0.4	145	0.20	0.8	85	0.18	0.8	135	0.20	0.8	–	–	–	35	0.14	0.6	–	–	–
	T8430	0.4	165	0.20	0.8	90	0.18	0.8	135	0.20	0.8	–	–	–	35	0.14	0.6	–	–	–
	T9310	0.4	245	0.20	0.8	–	–	–	230	0.20	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.4	225	0.20	0.8	–	–	–	210	0.20	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	200	0.20	0.8	120	0.18	0.8	190	0.20	0.8	–	–	–	45	0.20	0.6	–	–	–
DNMG 110408E-FM	T7325	0.8	200	0.20	0.8	155	0.18	0.8	–	–	–	–	–	–	65	0.16	0.6	–	–	–
	T8315	0.8	180	0.20	0.8	105	0.18	0.8	170	0.20	0.8	–	–	–	45	0.14	0.6	–	–	–
	T8330	0.8	175	0.20	0.8	105	0.18	0.8	165	0.20	0.8	–	–	–	40	0.14	0.6	–	–	–
	T8430	0.8	195	0.20	0.8	105	0.18	0.8	160	0.20	0.8	–	–	–	40	0.14	0.6	–	–	–
	T9310	0.8	295	0.20	0.8	–	–	–	280	0.20	0.8	–	–	–	–	–	–	–	–	–
	T9315	0.8	270	0.20	0.8	–	–	–	255	0.20	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	240	0.20	0.8	140	0.18	0.8	225	0.20	0.8	–	–	–	50	0.16	0.6	–	–	–
DNMG 150404E-FM	T7325	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.20	1.4	–	–	–
	T8330	0.4	135	0.20	1.7	80	0.18	1.7	125	0.20	1.7	–	–	–	30	0.14	1.4	–	–	–
	T8430	0.4	150	0.20	1.7	80	0.18	1.7	125	0.20	1.7	–	–	–	30	0.14	1.4	–	–	–
	T9315	0.4	210	0.20	1.7	–	–	–	195	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.20	1.4	–	–	–
DNMG 150408E-FM	T7325	0.8	180	0.20	1.7	140	0.18	1.7	–	–	–	–	–	–	55	0.16	1.4	–	–	–
	T8330	0.8	160	0.20	1.7	95	0.18	1.7	150	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
	T8430	0.8	185	0.20	1.7	100	0.18	1.7	150	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
	T9315	0.8	250	0.20	1.7	–	–	–	235	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	225	0.20	1.7	135	0.18	1.7	210	0.20	1.7	–	–	–	50	0.16	1.4	–	–	–
DNMG 150604E-FM	T7325	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.20	1.4	–	–	–
	T7335	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.20	1.4	–	–	–
	T8315	0.4	140	0.20	1.7	80	0.18	1.7	130	0.20	1.7	–	–	–	35	0.14	1.4	–	–	–
	T8330	0.4	135	0.20	1.7	80	0.18	1.7	125	0.20	1.7	–	–	–	30	0.14	1.4	–	–	–
	T8430	0.4	150	0.20	1.7	80	0.18	1.7	125	0.20	1.7	–	–	–	30	0.14	1.4	–	–	–
	T9310	0.4	230	0.20	1.7	–	–	–	215	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9315	0.4	210	0.20	1.7	–	–	–	195	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.20	1.4	–	–	–
	TT310	0.4	210	0.20	1.7	125	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-FM	T7325	0.8	180	0.20	1.7	140	0.18	1.7	–	–	–	–	–	–	55	0.16	1.4	–	–	–
	T7335	0.8	175	0.20	1.7	135	0.18	1.7	–	–	–	–	–	–	55	0.16	1.4	–	–	–
	T8315	0.8	170	0.20	1.7	100	0.18	1.7	160	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
	T8330	0.8	160	0.20	1.7	95	0.18	1.7	150	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
	T8430	0.8	185	0.20	1.7	100	0.18	1.7	150	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
	T9310	0.8	275	0.20	1.7	–	–	–	260	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9315	0.8	250	0.20	1.7	–	–	–	235	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	225	0.20	1.7	135	0.18	1.7	210	0.20	1.7	–	–	–	50	0.16	1.4	–	–	–
	TT310	0.8	250	0.20	1.7	150	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-FM	T7325	1.2	180	0.25	1.7	140	0.23	1.7	–	–	–	–	–	–	55	0.18	1.4	–	–	–
	T8430	1.2	175	0.25	1.7	95	0.23	1.7	140	0.25	1.7	–	–	–	35	0.18	1.4	–	–	–
	T9310	1.2	260	0.25	1.7	–	–	–	245	0.25	1.7	–	–	–	–	–	–	–	–	–
	T9315	1.2	240	0.25	1.7	–	–	–	225	0.25	1.7	–	–	–	–	–	–	–	–	–
	T9325	1.2	215	0.25	1.7	125	0.23	1.7	200	0.25	1.7	–	–	–	45	0.18	1.4	–	–	–

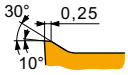
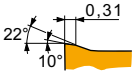
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
FM断屑槽，具有正前角设计，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
DNMG 150616E-FM	**T9315**	1.6	■ 235	0.30	1.7	–	–	–	◪ 220	0.30	1.7	–	–	–	–	–	–	–	–	–
	T9325	1.6	■ 210	0.30	1.7	◪ 125	0.27	1.7	◪ 195	0.30	1.7	–	–	–	◪ 45	0.21	1.4	–	–	–
																				
M断屑槽，适用于精加工至中粗加工，连续至断续切削。																				
DNMG 110404E-M	**T5315**	0.4	◪ 210	0.20	1.2	–	–	–	■ 195	0.20	1.2	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	0.4	■ 195	0.20	1.2	–	–	–	◪ 185	0.20	1.2	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	0.4	■ 175	0.20	1.2	–	–	–	◪ 165	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 150	0.20	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110408E-M	**T5315**	0.8	◪ 215	0.30	1.2	–	–	–	■ 200	0.30	1.2	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	0.8	■ 200	0.30	1.2	–	–	–	◪ 190	0.30	1.2	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	0.8	■ 175	0.30	1.2	–	–	–	◪ 165	0.30	1.2	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 155	0.30	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110412E-M	**T9315**	1.2	■ 185	0.40	1.2	–	–	–	◪ 175	0.40	1.2	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	1.2	■ 165	0.40	1.2	–	–	–	◪ 155	0.40	1.2	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 140	0.40	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150404E-M	**T5315**	0.4	◪ 200	0.20	1.9	–	–	–	■ 190	0.20	1.9	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	0.4	■ 190	0.20	1.9	–	–	–	◪ 180	0.20	1.9	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	0.4	■ 170	0.20	1.9	–	–	–	◪ 160	0.20	1.9	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 145	0.20	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150408E-M	**T5315**	0.8	◪ 205	0.30	1.9	–	–	–	■ 190	0.30	1.9	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	0.8	■ 190	0.30	1.9	–	–	–	◪ 180	0.30	1.9	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	0.8	■ 170	0.30	1.9	–	–	–	◪ 160	0.30	1.9	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 145	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150412E-M	**T5315**	1.2	◪ 200	0.40	1.9	–	–	–	■ 190	0.40	1.9	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	1.2	■ 175	0.40	1.9	–	–	–	◪ 165	0.40	1.9	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	1.2	■ 160	0.40	1.9	–	–	–	◪ 150	0.40	1.9	–	–	–	–	–	–	–	–	–
DNMG 150604E-M	**T5315**	0.4	◪ 200	0.20	1.9	–	–	–	■ 190	0.20	1.9	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	0.4	■ 190	0.20	1.9	–	–	–	◪ 180	0.20	1.9	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	0.4	■ 170	0.20	1.9	–	–	–	◪ 160	0.20	1.9	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 145	0.20	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-M	**T5315**	0.8	◪ 205	0.30	1.9	–	–	–	■ 190	0.30	1.9	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9310	0.8	■ 205	0.30	1.9	–	–	–	◪ 190	0.30	1.9	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	0.8	■ 190	0.30	1.9	–	–	–	◪ 180	0.30	1.9	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	0.8	■ 170	0.30	1.9	–	–	–	◪ 160	0.30	1.9	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 145	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-M	**T5315**	1.2	◪ 200	0.40	1.9	–	–	–	■ 190	0.40	1.9	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9310	1.2	■ 190	0.40	1.9	–	–	–	◪ 180	0.40	1.9	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9315	1.2	■ 175	0.40	1.9	–	–	–	◪ 165	0.40	1.9	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	1.2	■ 160	0.40	1.9	–	–	–	◪ 150	0.40	1.9	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 140	0.40	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
NF断屑槽，具有大正前角设计，适用于超精加工至中度加工，连续切削。																				
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	–	–	–
	T7325	0.4	◪ 170	0.18	0.8	■ 130	0.16	0.8	–	–	–	–	–	–	◪ 55	0.16	0.6	–	–	–
	T7335	0.4	◪ 165	0.18	0.8	■ 125	0.16	0.8	–	–	–	–	–	–	◪ 50	0.16	0.6	–	–	–
	T8330	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	–	–	–
	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	–	–	–
	T9315	0.4	■ 255	0.15	0.8	–	–	–	◪ 240	0.15	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 210	0.18	0.8	■ 125	0.16	0.8	◪ 195	0.18	0.8	–	–	–	◪ 45	0.16	0.6	–	–	–

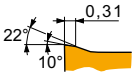
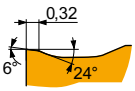
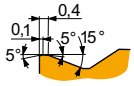
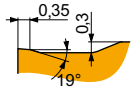
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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断屑槽，具有大正前角设计，适用于超精加工至中度加工，连续切削。																	
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	–	–	–
	T7325	0.8	◪ 200	0.18	1.0	■ 155	0.16	1.0	–	–	–	–	–	–	◪ 65	0.16	0.8	–	–	–
	T7335	0.8	◪ 195	0.18	1.0	■ 150	0.16	1.0	–	–	–	–	–	–	◪ 60	0.16	0.8	–	–	–
	T8330	0.8	■ 175	0.17	1.0	■ 105	0.15	1.0	◪ 165	0.17	1.0	◪ 525	0.20	1.0	◪ 40	0.14	0.8	–	–	–
	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	–	–	–
	T9315	0.8	■ 280	0.17	1.0	–	–	–	◪ 265	0.17	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 250	0.18	1.0	■ 150	0.16	1.0	◪ 235	0.18	1.0	–	–	–	◪ 55	0.16	0.8	–	–	–
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	–	–	–
	T7325	0.4	◪ 160	0.18	1.7	■ 120	0.16	1.7	–	–	–	–	–	–	◪ 50	0.16	1.4	–	–	–
	T7335	0.4	◪ 155	0.18	1.7	■ 120	0.16	1.7	–	–	–	–	–	–	◪ 50	0.16	1.4	–	–	–
	T8330	0.4	■ 140	0.17	1.7	■ 80	0.15	1.7	◪ 130	0.17	1.7	◪ 420	0.20	1.7	◪ 35	0.15	1.4	–	–	–
	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	–	–	–
	T9315	0.4	■ 235	0.15	1.7	–	–	–	◪ 220	0.15	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 200	0.18	1.7	■ 120	0.16	1.7	◪ 190	0.18	1.7	–	–	–	◪ 45	0.16	1.4	–	–	–
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	–	–	–
	T7325	0.8	◪ 190	0.18	1.7	■ 145	0.16	1.7	–	–	–	–	–	–	◪ 60	0.16	1.4	–	–	–
	T7335	0.8	◪ 185	0.18	1.7	■ 140	0.16	1.7	–	–	–	–	–	–	◪ 60	0.16	1.4	–	–	–
	T8330	0.8	■ 165	0.18	1.7	■ 95	0.16	1.7	◪ 155	0.18	1.7	◪ 495	0.22	1.7	◪ 40	0.16	1.4	–	–	–
	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	–	–	–
	T9315	0.8	■ 270	0.17	1.7	–	–	–	◪ 255	0.17	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 235	0.18	1.7	■ 140	0.16	1.7	◪ 220	0.18	1.7	–	–	–	◪ 50	0.16	1.4	–	–	–
DNMG 150604E-NF	**HF7**	0.4	–	–	–	◪ 80	0.14	1.9	◪ 130	0.15	1.9	◪ 420	0.18	1.9	–	–	–	–	–	–
	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	–	–	–
	T7325	0.4	◪ 155	0.18	1.9	■ 120	0.16	1.9	–	–	–	–	–	–	◪ 50	0.16	1.5	–	–	–
	T7335	0.4	◪ 150	0.18	1.9	■ 115	0.16	1.9	–	–	–	–	–	–	◪ 45	0.16	1.5	–	–	–
	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	–	–	–
	T8330	0.4	■ 140	0.17	1.9	■ 80	0.15	1.9	◪ 130	0.17	1.9	◪ 420	0.20	1.9	◪ 35	0.15	1.5	–	–	–
	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	–	–	–
	T9315	0.4	■ 235	0.15	1.9	–	–	–	◪ 220	0.15	1.9	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 195	0.18	1.9	■ 115	0.16	1.9	◪ 185	0.18	1.9	–	–	–	◪ 40	0.16	1.5	–	–	–
DNMG 150608E-NF	**HF7**	0.8	–	–	–	◪ 90	0.15	1.9	◪ 145	0.17	1.9	◪ 465	0.20	1.9	–	–	–	–	–	–
	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	–	–	–
	T7325	0.8	◪ 185	0.18	1.9	■ 140	0.16	1.9	–	–	–	–	–	–	◪ 60	0.16	1.5	–	–	–
	T7335	0.8	◪ 180	0.18	1.9	■ 140	0.16	1.9	–	–	–	–	–	–	◪ 55	0.16	1.5	–	–	–
	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	–	–	–
	T8330	0.8	■ 165	0.18	1.9	■ 95	0.16	1.9	◪ 155	0.18	1.9	◪ 495	0.22	1.9	◪ 40	0.16	1.5	–	–	–
	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	–	–	–
	T9315	0.8	■ 265	0.17	1.9	–	–	–	◪ 250	0.17	1.9	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 230	0.18	1.9	■ 135	0.16	1.9	◪ 215	0.18	1.9	–	–	–	◪ 50	0.16	1.5	–	–	–
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	–	–	–
	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	–	–	–
	T9325	1.2	■ 200	0.30	1.5	■ 120	0.27	1.5	◪ 190	0.30	1.5	–	–	–	◪ 45	0.21	1.2	–	–	–
																				
			NM断屑槽，具有大正前角设计，适用于精加工，中度至粗加工，连续切削。																	
DNMG 110404E-NM	**T7325**	0.4	◪ 175	0.20	0.8	■ 135	0.18	0.8	–	–	–	–	–	–	■ 55	0.20	0.6	–	–	–
	T7335	0.4	◪ 165	0.20	0.8	■ 125	0.18	0.8	–	–	–	–	–	–	■ 50	0.20	0.6	–	–	–
	T8315	0.4	◪ 160	0.20	0.8	■ 95	0.18	0.8	–	–	–	◪ 480	0.24	0.8	◪ 40	0.20	0.6	–	–	–
	T8330	0.4	■ 150	0.20	0.8	■ 90	0.18	0.8	–	–	–	◪ 450	0.24	0.8	◪ 35	0.20	0.6	–	–	–
	T8430	0.4	■ 175	0.20	0.8	■ 95	0.18	0.8	–	–	–	◪ 480	0.24	0.8	◪ 35	0.20	0.6	–	–	–
	T9325	0.4	■ 210	0.20	0.8	■ 125	0.18	0.8	–	–	–	–	–	–	◪ 45	0.20	0.6	–	–	–

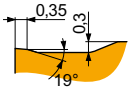
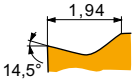
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
NM断屑槽，具有大正前角设计，适用于精加工，中度至粗加工，连续切削。																				
DNMG 110408E-NM	**T7325**	0.8	190	0.25	0.8	145	0.23	0.8	–	–	–	–	–	–	60	0.20	0.6	–	–	–
	T7335	0.8	185	0.25	0.8	140	0.23	0.8	–	–	–	–	–	–	60	0.20	0.6	–	–	–
	T8315	0.8	180	0.25	0.8	105	0.23	0.8	–	–	–	540	0.30	0.8	45	0.20	0.6	–	–	–
	T8330	0.8	170	0.25	0.8	100	0.23	0.8	–	–	–	510	0.30	0.8	40	0.20	0.6	–	–	–
	T8430	0.8	190	0.25	0.8	105	0.23	0.8	–	–	–	525	0.30	0.8	40	0.20	0.6	–	–	–
	T9325	0.8	230	0.25	0.8	135	0.23	0.8	–	–	–	–	–	–	50	0.20	0.6	–	–	–
DNMG 150408E-NM	**T7335**	0.8	170	0.25	1.9	130	0.23	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
	T8330	0.8	155	0.25	1.9	90	0.23	1.9	–	–	–	465	0.30	1.9	35	0.20	1.5	–	–	–
	T8430	0.8	175	0.25	1.9	95	0.23	1.9	–	–	–	480	0.30	1.9	35	0.20	1.5	–	–	–
	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	–	–	–
	T7335	0.4	150	0.20	1.9	115	0.18	1.9	–	–	–	–	–	–	45	0.20	1.5	–	–	–
	T8315	0.4	150	0.20	1.9	90	0.18	1.9	–	–	–	450	0.24	1.9	35	0.20	1.5	–	–	–
	T8330	0.4	135	0.20	1.9	80	0.18	1.9	–	–	–	405	0.24	1.9	30	0.20	1.5	–	–	–
	T8430	0.4	155	0.20	1.9	85	0.18	1.9	–	–	–	435	0.24	1.9	30	0.20	1.5	–	–	–
	T9315	0.4	220	0.20	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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	–	–	–
	T7335	0.8	170	0.25	1.9	130	0.23	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
	T8315	0.8	165	0.25	1.9	95	0.23	1.9	–	–	–	495	0.30	1.9	40	0.20	1.5	–	–	–
	T8330	0.8	155	0.25	1.9	90	0.23	1.9	–	–	–	465	0.30	1.9	35	0.20	1.5	–	–	–
	T8430	0.8	175	0.25	1.9	95	0.23	1.9	–	–	–	480	0.30	1.9	35	0.20	1.5	–	–	–
	T9315	0.8	235	0.25	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	210	0.25	1.9	125	0.23	1.9	–	–	–	–	–	–	45	0.20	1.5	–	–	–
DNMG 150612E-NM	**T7325**	1.2	175	0.30	1.9	135	0.27	1.9	–	–	–	–	–	–	55	0.24	1.5	–	–	–
	T7335	1.2	170	0.30	1.9	130	0.27	1.9	–	–	–	–	–	–	55	0.24	1.5	–	–	–
	T8315	1.2	165	0.30	1.9	95	0.27	1.9	–	–	–	495	0.36	1.9	40	0.24	1.5	–	–	–
	T9325	1.2	205	0.30	1.9	120	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
																				
NMR断屑槽，具有正前角设计，适用于中度至粗加工，连续切削。																				
DNMG 110404E-NMR	**T7325**	0.4	150	0.20	0.8	115	0.18	0.8	–	–	–	–	–	–	45	0.18	0.6	–	–	–
	T9315	0.4	205	0.20	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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	–	–	–
	T9315	0.8	205	0.30	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	185	0.30	0.8	110	0.27	0.8	–	–	–	–	–	–	40	0.24	0.6	–	–	–
DNMG 110412E-NMR	**T7325**	1.2	155	0.30	1.6	120	0.27	1.6	–	–	–	–	–	–	50	0.24	1.3	–	–	–
	T9315	1.2	200	0.30	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.2	180	0.30	1.6	105	0.27	1.6	–	–	–	–	–	–	40	0.24	1.3	–	–	–
DNMG 150404E-NMR	**T7325**	0.4	140	0.20	1.9	105	0.18	1.9	–	–	–	–	–	–	45	0.18	1.5	–	–	–
	T7335	0.4	130	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	40	0.18	1.5	–	–	–
	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	–	–	–
	T7335	0.8	140	0.30	1.9	105	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
	T8330	0.8	125	0.30	1.9	75	0.27	1.9	–	–	–	–	–	–	30	0.24	1.5	–	–	–
	T8430	0.8	135	0.30	1.9	75	0.27	1.9	–	–	–	–	–	–	25	0.24	1.5	–	–	–
	T9315	0.8	190	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	170	0.30	1.9	100	0.27	1.9	–	–	–	–	–	–	35	0.24	1.5	–	–	–
DNMG 150604E-NMR	**T7325**	0.4	140	0.20	1.9	105	0.18	1.9	–	–	–	–	–	–	45	0.18	1.5	–	–	–
	T7335	0.4	130	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	40	0.18	1.5	–	–	–
	T8330	0.4	120	0.20	1.9	70	0.18	1.9	–	–	–	–	–	–	30	0.18	1.5	–	–	–
	T8430	0.4	135	0.20	1.9	75	0.18	1.9	–	–	–	–	–	–	25	0.18	1.5	–	–	–
	T9315	0.4	190	0.20	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.4	170	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	35	0.18	1.5	–	–	–

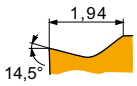
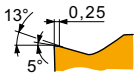
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			NMR断屑槽，具有正前角设计，适用于中度至粗加工，连续切削。																	
DNMG 150608E-NMR	**T6310**	0.8	■ 125	0.30	1.9	■ 90	0.27	1.9	–	–	–	–	–	–	■ 35	0.24	1.5	–	–	–
	T7325	0.8	◪ 145	0.30	1.9	■ 110	0.27	1.9	–	–	–	–	–	–	■ 45	0.24	1.5	–	–	–
	T7335	0.8	◪ 140	0.30	1.9	■ 105	0.27	1.9	–	–	–	–	–	–	■ 45	0.24	1.5	–	–	–
	T8330	0.8	■ 125	0.30	1.9	■ 75	0.27	1.9	–	–	–	–	–	–	◪ 30	0.24	1.5	–	–	–
	T8430	0.8	■ 135	0.30	1.9	■ 75	0.27	1.9	–	–	–	–	–	–	◪ 25	0.24	1.5	–	–	–
	T9315	0.8	■ 190	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 170	0.30	1.9	■ 100	0.27	1.9	–	–	–	–	–	–	◪ 35	0.24	1.5	–	–	–
DNMG 150612E-NMR	**T7325**	1.2	◪ 155	0.30	1.9	■ 120	0.27	1.9	–	–	–	–	–	–	■ 50	0.24	1.5	–	–	–
	T7335	1.2	◪ 145	0.30	1.9	■ 110	0.27	1.9	–	–	–	–	–	–	■ 45	0.24	1.5	–	–	–
	T8330	1.2	■ 135	0.30	1.9	■ 80	0.27	1.9	–	–	–	–	–	–	◪ 30	0.24	1.5	–	–	–
	T8430	1.2	■ 145	0.30	1.9	■ 80	0.27	1.9	–	–	–	–	–	–	◪ 30	0.24	1.5	–	–	–
	T9315	1.2	■ 200	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 180	0.30	1.9	■ 105	0.27	1.9	–	–	–	–	–	–	◪ 40	0.24	1.5	–	–	–
																				
			NRM断屑槽，具有正前角设计，适用于中粗加工至粗加工，连续至中等间断切削。																	
DNMG 150408-NRM	**T7325**	0.8	◪ 140	0.30	3.0	■ 105	0.27	3.0	–	–	–	–	–	–	■ 45	0.24	2.4	–	–	–
	T7335	0.8	◪ 130	0.30	3.0	■ 100	0.27	3.0	–	–	–	–	–	–	■ 40	0.24	2.4	–	–	–
	T9315	0.8	■ 180	0.30	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150604-NRM	**T7325**	0.4	◪ 130	0.20	3.0	■ 100	0.18	3.0	–	–	–	–	–	–	■ 40	0.20	2.4	–	–	–
	T7335	0.4	◪ 130	0.20	3.0	■ 100	0.18	3.0	–	–	–	–	–	–	■ 40	0.20	2.4	–	–	–
	T9315	0.4	■ 180	0.20	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608-NRM	**T7325**	0.8	◪ 140	0.30	3.0	■ 105	0.27	3.0	–	–	–	–	–	–	■ 45	0.24	2.4	–	–	–
	T7335	0.8	◪ 130	0.30	3.0	■ 100	0.27	3.0	–	–	–	–	–	–	■ 40	0.24	2.4	–	–	–
	T9315	0.8	■ 180	0.30	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612-NRM	**T7325**	1.2	◪ 145	0.30	3.0	■ 110	0.27	3.0	–	–	–	–	–	–	■ 45	0.27	2.4	–	–	–
	T7335	1.2	◪ 140	0.30	3.0	■ 105	0.27	3.0	–	–	–	–	–	–	■ 45	0.27	2.4	–	–	–
	T9315	1.2	■ 190	0.30	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
			R断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
DNMG 150408E-R	**T5315**	0.8	◪ 175	0.40	3.0	–	–	–	■ 165	0.40	3.0	–	–	–	–	–	–	◪ 35	0.15	1.0
DNMG 150608E-R	**T5305**	0.8	◪ 200	0.40	3.0	–	–	–	■ 190	0.40	3.0	–	–	–	–	–	–	◪ 40	0.15	1.0
	T5315	0.8	◪ 175	0.40	3.0	–	–	–	■ 165	0.40	3.0	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9310	0.8	■ 170	0.40	3.0	–	–	–	◪ 160	0.40	3.0	–	–	–	–	–	–	◪ 30	0.15	1.0
	T9315	0.8	■ 155	0.40	3.0	–	–	–	◪ 145	0.40	3.0	–	–	–	–	–	–	◪ 30	0.15	1.0
	T9325	0.8	■ 140	0.40	3.0	–	–	–	◪ 130	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-R	**T5305**	1.2	◪ 210	0.40	3.0	–	–	–	■ 195	0.40	3.0	–	–	–	–	–	–	◪ 40	0.15	1.0
	T5315	1.2	◪ 185	0.40	3.0	–	–	–	■ 175	0.40	3.0	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9310	1.2	■ 180	0.40	3.0	–	–	–	◪ 170	0.40	3.0	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9315	1.2	■ 165	0.40	3.0	–	–	–	◪ 155	0.40	3.0	–	–	–	–	–	–	◪ 30	0.15	1.0
	T9325	1.2	■ 150	0.40	3.0	–	–	–	◪ 140	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150616E-R	**T9325**	1.6	■ 155	0.40	3.0	–	–	–	◪ 145	0.40	3.0	–	–	–	–	–	–	–	–	–
																				
			RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
DNMG 110408E-RM	**T9315**	0.8	■ 190	0.40	2.0	–	–	–	◪ 180	0.40	2.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 170	0.40	2.0	◪ 100	0.36	2.0	◪ 160	0.40	2.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 145	0.40	2.0	◪ 85	0.36	2.0	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110412E-RM	**T9315**	1.2	■ 230	0.30	2.0	–	–	–	◪ 215	0.30	2.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 205	0.30	2.0	◪ 120	0.27	2.0	◪ 190	0.30	2.0	–	–	–	–	–	–	–	–	–

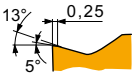
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
			RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
DNMG 150408E-RM	**T9315**	0.8	■ 180	0.40	3.0	–	–	–	◪ 170	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 165	0.40	3.0	◪ 95	0.36	3.0	◪ 155	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 140	0.40	3.0	◪ 80	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150412E-RM	**T7325**	1.2	◪ 155	0.40	3.0	◪ 120	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 190	0.40	3.0	–	–	–	◪ 180	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 170	0.40	3.0	◪ 100	0.36	3.0	◪ 160	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 150	0.40	3.0	◪ 90	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-RM	**T5305**	0.8	◪ 230	0.40	3.0	–	–	–	◪ 215	0.40	3.0	–	–	–	–	–	–	–	–	–
	T5315	0.8	◪ 205	0.40	3.0	–	–	–	◪ 190	0.40	3.0	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪ 145	0.40	3.0	◪ 110	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪ 135	0.40	3.0	◪ 105	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	◪ 135	0.40	3.0	◪ 80	0.36	3.0	◪ 125	0.40	3.0	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 130	0.40	3.0	◪ 75	0.36	3.0	◪ 120	0.40	3.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 135	0.40	3.0	◪ 75	0.36	3.0	◪ 110	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9310	0.8	■ 200	0.40	3.0	–	–	–	◪ 190	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 180	0.40	3.0	–	–	–	◪ 170	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 165	0.40	3.0	◪ 95	0.36	3.0	◪ 155	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 140	0.40	3.0	◪ 80	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-RM	**T5305**	1.2	◪ 240	0.40	3.0	–	–	–	◪ 225	0.40	3.0	–	–	–	–	–	–	–	–	–
	T5315	1.2	◪ 215	0.40	3.0	–	–	–	◪ 200	0.40	3.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	◪ 155	0.40	3.0	◪ 120	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	◪ 145	0.40	3.0	◪ 110	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	1.2	■ 135	0.40	3.0	◪ 80	0.36	3.0	◪ 125	0.40	3.0	–	–	–	–	–	–	–	–	–
	T8430	1.2	■ 140	0.40	3.0	◪ 75	0.36	3.0	◪ 115	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9310	1.2	■ 210	0.40	3.0	–	–	–	◪ 195	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 190	0.40	3.0	–	–	–	◪ 180	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 170	0.40	3.0	◪ 100	0.36	3.0	◪ 160	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 150	0.40	3.0	◪ 90	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150616E-RM	**T5315**	1.6	◪ 225	0.40	3.0	–	–	–	◪ 210	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9315	1.6	■ 200	0.40	3.0	–	–	–	◪ 190	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	■ 180	0.40	3.0	◪ 105	0.36	3.0	◪ 170	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	■ 155	0.40	3.0	◪ 90	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
			SF断屑槽，具有正前角设计，适用于薄壁，连续切削进行超精加工。																	
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	0.15	1.0
	T7325	0.4	◪ 165	0.17	0.8	■ 125	0.15	0.8	–	–	–	–	–	–	■ 50	0.15	0.6	–	–	–
	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	0.15	1.0
	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	0.15	1.0
	T9315	0.4	■ 245	0.15	0.8	–	–	–	◪ 230	0.15	0.8	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	0.4	■ 210	0.17	0.8	■ 125	0.15	0.8	◪ 195	0.17	0.8	–	–	–	◪ 45	0.15	0.6	–	–	–
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	0.15	1.0
	T7325	0.8	◪ 195	0.17	0.8	■ 150	0.15	0.8	–	–	–	–	–	–	■ 60	0.15	0.6	–	–	–
	T7335	0.8	◪ 195	0.17	0.8	■ 150	0.15	0.8	–	–	–	–	–	–	■ 60	0.15	0.6	–	–	–
	T8315	0.8	◪ 180	0.17	0.8	■ 105	0.15	0.8	■ 170	0.17	0.8	◪ 540	0.20	0.8	◪ 45	0.14	0.6	■ 35	0.15	1.0
	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	0.15	1.0
	T9325	0.8	■ 250	0.17	0.8	■ 150	0.15	0.8	◪ 235	0.17	0.8	–	–	–	◪ 55	0.15	0.6	–	–	–
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	0.15	1.0
	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	0.15	1.0
	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	0.15	1.0
	T9325	0.4	■ 195	0.17	1.5	■ 115	0.15	1.5	◪ 185	0.17	1.5	–	–	–	◪ 40	0.15	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。

产品型号		RE	P			M			K			N			S			H		
			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)
			 SF断屑槽，具有正前角设计，适用于薄壁，连续切削进行超精加工。																	
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	0.15	1.0
	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	0.15	1.0
	T8330	0.8	■ 160	0.17	1.5	■ 95	0.15	1.5	■ 150	0.17	1.5	◪ 480	0.20	1.5	◪ 40	0.14	1.2	◪ 30	0.15	1.0
	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	0.15	1.0
	T9325	0.8	■ 235	0.17	1.5	■ 140	0.15	1.5	◪ 220	0.17	1.5	–	–	–	◪ 50	0.15	1.2	–	–	–
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	–	–	–
	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	0.15	1.0
	T7325	0.4	◪ 155	0.17	1.5	■ 120	0.15	1.5	–	–	–	–	–	–	■ 50	0.15	1.2	–	–	–
	T7335	0.4	◪ 150	0.17	1.5	■ 115	0.15	1.5	–	–	–	–	–	–	■ 45	0.15	1.2	–	–	–
	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	0.15	1.0
	T8330	0.4	■ 140	0.15	1.5	■ 80	0.14	1.5	■ 130	0.15	1.5	◪ 420	0.18	1.5	◪ 35	0.12	1.2	◪ 25	0.15	1.0
	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	0.15	1.0
	T9315	0.4	■ 230	0.15	1.5	–	–	–	◪ 215	0.15	1.5	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	0.4	■ 195	0.17	1.5	■ 115	0.15	1.5	◪ 185	0.17	1.5	–	–	–	◪ 40	0.15	1.2	–	–	–
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	–	–	–
	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	0.15	1.0
	T7325	0.8	◪ 185	0.17	1.5	■ 140	0.15	1.5	–	–	–	–	–	–	■ 60	0.15	1.2	–	–	–
	T7335	0.8	◪ 180	0.17	1.5	■ 140	0.15	1.5	–	–	–	–	–	–	■ 55	0.15	1.2	–	–	–
	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	0.15	1.0
	T8330	0.8	■ 160	0.17	1.5	■ 95	0.15	1.5	■ 150	0.17	1.5	◪ 480	0.20	1.5	◪ 40	0.14	1.2	◪ 30	0.15	1.0
	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	0.15	1.0
	T9315	0.8	■ 255	0.17	1.5	–	–	–	◪ 240	0.17	1.5	–	–	–	–	–	–	◪ 50	0.15	1.0
	T9325	0.8	■ 235	0.17	1.5	■ 140	0.15	1.5	◪ 220	0.17	1.5	–	–	–	◪ 50	0.15	1.2	–	–	–
DNMG 150612E-SF	**T6310**	1.2	■ 145	0.30	1.5	■ 100	0.27	1.5	■ 115	0.30	1.5	◪ 435	0.36	1.5	■ 40	0.21	1.2	■ 25	0.15	1.0
	T7325	1.2	◪ 165	0.30	1.5	■ 125	0.27	1.5	–	–	–	–	–	–	■ 50	0.21	1.2	–	–	–
	T9315	1.2	■ 210	0.30	1.5	–	–	–	◪ 195	0.30	1.5	–	–	–	–	–	–	◪ 40	0.15	1.0
			 SM断屑槽，具有正前角设计，适用于中等加工，连续或间断进行切削。																	
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	0.20	0.6	◪ 25	0.15	1.0
	T7325	0.4	◪ 160	0.20	0.8	■ 120	0.18	0.8	–	–	–	–	–	–	■ 50	0.20	0.6	–	–	–
	T7335	0.4	◪ 150	0.20	0.8	■ 115	0.18	0.8	–	–	–	–	–	–	■ 45	0.20	0.6	–	–	–
	T8430	0.4	■ 155	0.20	0.8	■ 85	0.18	0.8	◪ 130	0.20	0.8	◪ 435	0.24	0.8	◪ 30	0.20	0.6	◪ 25	0.15	1.0
	T9325	0.4	■ 190	0.20	0.8	■ 110	0.18	0.8	◪ 180	0.20	0.8	–	–	–	◪ 40	0.20	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	0.15	1.0
	T7325	0.8	◪ 170	0.25	1.2	■ 130	0.23	1.2	–	–	–	–	–	–	■ 55	0.20	1.0	–	–	–
	T7335	0.8	◪ 160	0.25	1.2	■ 120	0.23	1.2	–	–	–	–	–	–	■ 50	0.20	1.0	–	–	–
	T8330	0.8	■ 150	0.25	1.2	■ 90	0.23	1.2	■ 140	0.25	1.2	◪ 450	0.30	1.2	◪ 35	0.20	1.0	◪ 30	0.15	1.0
	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	0.15	1.0
	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	■ 125	0.22	1.7	■ 90	0.20	1.7	■ 100	0.22	1.7	◪ 375	0.26	1.7	■ 35	0.20	1.4	◪ 25	0.15	1.0
DNMG 150408E-SM	**T6310**	0.8	■ 140	0.25	2.1	■ 100	0.23	2.1	■ 110	0.25	2.1	◪ 420	0.30	2.1	■ 40	0.20	1.7	◪ 25	0.15	1.0
DNMG 150604E-SM	**T6310**	0.4	■ 125	0.22	1.7	■ 90	0.20	1.7	■ 100	0.22	1.7	◪ 375	0.26	1.7	■ 35	0.20	1.4	◪ 25	0.15	1.0
	T7325	0.4	◪ 140	0.22	1.7	■ 105	0.20	1.7	–	–	–	–	–	–	■ 45	0.20	1.4	–	–	–
	T7335	0.4	◪ 140	0.22	1.7	■ 105	0.20	1.7	–	–	–	–	–	–	■ 45	0.20	1.4	–	–	–
	T8330	0.4	■ 125	0.22	1.7	■ 75	0.20	1.7	■ 115	0.22	1.7	◪ 375	0.26	1.7	◪ 30	0.20	1.4	◪ 25	0.15	1.0
	T8430	0.4	■ 140	0.22	1.7	■ 75	0.20	1.7	◪ 115	0.22	1.7	◪ 390	0.26	1.7	◪ 30	0.20	1.4	◪ 20	0.15	1.0
	T9315	0.4	■ 200	0.20	1.7	–	–	–	◪ 190	0.20	1.7	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	0.4	■ 170	0.22	1.7	■ 100	0.20	1.7	◪ 160	0.22	1.7	–	–	–	◪ 35	0.20	1.4	–	–	–

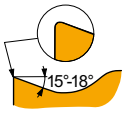
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				

SM断屑槽，具有正前角设计，适用于中等加工，连续或间断进行切削。

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	0.15	1.0
	T7325	0.8	◪ 160	0.25	1.7	■ 120	0.23	1.7	–	–	–	–	–	–	■ 50	0.20	1.4	–	–	–
	T7335	0.8	◪ 155	0.25	1.7	■ 120	0.23	1.7	–	–	–	–	–	–	■ 50	0.20	1.4	–	–	–
	T8330	0.8	■ 140	0.25	1.7	■ 80	0.23	1.7	■ 130	0.25	1.7	◪ 420	0.30	1.7	◪ 35	0.20	1.4	◪ 25	0.15	1.0
	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	0.15	1.0
	T9315	0.8	■ 215	0.25	1.7	–	–	–	◪ 200	0.25	1.7	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	0.8	■ 195	0.25	1.7	■ 115	0.23	1.7	◪ 185	0.25	1.7	–	–	–	◪ 40	0.20	1.4	–	–	–
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	1.0
	T7325	1.2	◪ 160	0.30	1.7	■ 120	0.27	1.7	–	–	–	–	–	–	■ 50	0.24	1.4	–	–	–
	T7335	1.2	◪ 155	0.30	1.7	■ 120	0.27	1.7	–	–	–	–	–	–	■ 50	0.24	1.4	–	–	–
	T8330	1.2	■ 145	0.30	1.7	■ 85	0.27	1.7	■ 135	0.30	1.7	◪ 435	0.36	1.7	◪ 35	0.24	1.4	◪ 25	0.15	1.0
	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	1.0
	T9315	1.2	■ 210	0.30	1.7	–	–	–	◪ 195	0.30	1.7	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	1.2	■ 190	0.30	1.7	■ 110	0.27	1.7	◪ 180	0.30	1.7	–	–	–	◪ 40	0.24	1.4	–	–	–

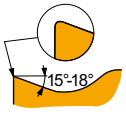




ER-SI断屑槽，具有正前角设计，右手设计，适用于超精加工至中粗加工，连续切削。

DNMG 110404ER-SI	**T7325**	0.4	◪ 185	0.20	1.0	■ 140	0.18	1.0	–	–	–	–	–	–	◪ 60	0.18	0.8	–	–	–
	T7335	0.4	◪ 180	0.20	1.0	■ 140	0.18	1.0	–	–	–	–	–	–	◪ 55	0.18	0.8	–	–	–
	T8330	0.4	■ 160	0.20	1.0	■ 95	0.18	1.0	–	–	–	◪ 480	0.24	1.0	◪ 40	0.18	0.8	–	–	–
	T8430	0.4	■ 185	0.20	1.0	■ 100	0.18	1.0	–	–	–	◪ 510	0.24	1.0	◪ 40	0.18	0.8	–	–	–
	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	–	–	–
	T8330	0.8	■ 165	0.35	1.0	■ 95	0.32	1.0	–	–	–	◪ 495	0.42	1.0	◪ 40	0.25	0.8	–	–	–
	T8430	0.8	■ 180	0.35	1.0	■ 95	0.32	1.0	–	–	–	◪ 495	0.42	1.0	◪ 35	0.25	0.8	–	–	–
	T9325	0.8	■ 210	0.35	1.0	■ 125	0.32	1.0	–	–	–	–	–	–	◪ 45	0.25	0.8	–	–	–
DNMG 150404ER-SI	**T8330**	0.4	■ 155	0.20	1.5	■ 90	0.18	1.5	–	–	–	◪ 465	0.24	1.5	◪ 35	0.18	1.2	–	–	–
	T8430	0.4	■ 175	0.20	1.5	■ 95	0.18	1.5	–	–	–	◪ 480	0.24	1.5	◪ 35	0.18	1.2	–	–	–
	T9325	0.4	■ 220	0.20	1.5	■ 130	0.18	1.5	–	–	–	–	–	–	◪ 45	0.18	1.2	–	–	–
DNMG 150408ER-SI	**T8330**	0.8	■ 160	0.35	1.5	■ 95	0.32	1.5	–	–	–	◪ 480	0.42	1.5	◪ 40	0.25	1.2	–	–	–
	T8430	0.8	■ 170	0.35	1.5	■ 90	0.32	1.5	–	–	–	◪ 465	0.42	1.5	◪ 35	0.25	1.2	–	–	–
	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	–	–	–
	T7335	0.4	◪ 170	0.20	1.5	■ 130	0.18	1.5	–	–	–	–	–	–	◪ 55	0.18	1.2	–	–	–
	T8315	0.4	◪ 165	0.20	1.5	■ 95	0.18	1.5	–	–	–	◪ 495	0.24	1.5	◪ 40	0.18	1.2	–	–	–
	T8330	0.4	■ 155	0.20	1.5	■ 90	0.18	1.5	–	–	–	◪ 465	0.24	1.5	◪ 35	0.18	1.2	–	–	–
	T8430	0.4	■ 175	0.20	1.5	■ 95	0.18	1.5	–	–	–	◪ 480	0.24	1.5	◪ 35	0.18	1.2	–	–	–
	T9325	0.4	■ 220	0.20	1.5	■ 130	0.18	1.5	–	–	–	–	–	–	◪ 45	0.18	1.2	–	–	–
	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	–	–	–
	T7335	0.8	◪ 170	0.35	1.5	■ 130	0.32	1.5	–	–	–	–	–	–	◪ 55	0.25	1.2	–	–	–
	T8315	0.8	◪ 165	0.35	1.5	■ 95	0.32	1.5	–	–	–	◪ 495	0.42	1.5	◪ 40	0.25	1.2	–	–	–
	T8330	0.8	■ 160	0.35	1.5	■ 95	0.32	1.5	–	–	–	◪ 480	0.42	1.5	◪ 40	0.25	1.2	–	–	–
	T8430	0.8	■ 170	0.35	1.5	■ 90	0.32	1.5	–	–	–	◪ 465	0.42	1.5	◪ 35	0.25	1.2	–	–	–
	T9325	0.8	■ 200	0.35	1.5	■ 120	0.32	1.5	–	–	–	–	–	–	◪ 45	0.25	1.2	–	–	–
	T9335	0.8	■ 180	0.35	1.5	■ 105	0.32	1.5	–	–	–	–	–	–	◪ 40	0.25	1.2	–	–	–

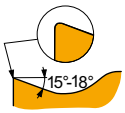
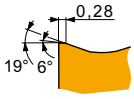
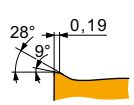




EL-SI断屑槽，具有正前角，左手设计，适用于超精加工至中粗加工，连续切削。

DNMG 110404EL-SI	**T7335**	0.4	◪ 180	0.20	1.0	■ 140	0.18	1.0	–	–	–	–	–	–	◪ 55	0.18	0.8	–	–	–
	T8330	0.4	■ 160	0.20	1.0	■ 95	0.18	1.0	–	–	–	◪ 480	0.24	1.0	◪ 40	0.18	0.8	–	–	–
	T8430	0.4	■ 185	0.20	1.0	■ 100	0.18	1.0	–	–	–	◪ 510	0.24	1.0	◪ 40	0.18	0.8	–	–	–
	T9325	0.4	■ 225	0.20	1.0	■ 135	0.18	1.0	–	–	–	–	–	–	◪ 50	0.18	0.8	–	–	–

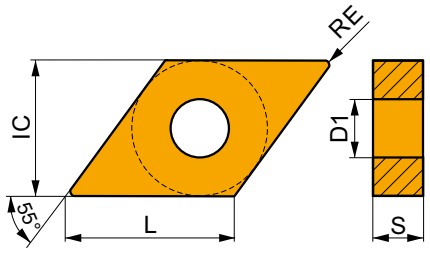
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			EL-SI断屑槽，具有正前角，左手设计，适用于超精加工至中粗加工，连续切削。																	
DNMG 110408EL-SI	**T7325**	0.8	◪ 185	0.35	1.0	■ 140	0.32	1.0	–	–	–	–	–	–	◪ 60	0.25	0.8	–	–	–
	T8330	0.8	■ 165	0.35	1.0	■ 95	0.32	1.0	–	–	–	◪ 495	0.42	1.0	◪ 40	0.25	0.8	–	–	–
	T8430	0.8	■ 180	0.35	1.0	■ 95	0.32	1.0	–	–	–	◪ 495	0.42	1.0	◪ 35	0.25	0.8	–	–	–
	T9325	0.8	■ 210	0.35	1.0	■ 125	0.32	1.0	–	–	–	–	–	–	◪ 45	0.25	0.8	–	–	–
DNMG 150404EL-SI	**T8330**	0.4	■ 155	0.20	1.5	■ 90	0.18	1.5	–	–	–	◪ 465	0.24	1.5	◪ 35	0.18	1.2	–	–	–
	T8430	0.4	■ 175	0.20	1.5	■ 95	0.18	1.5	–	–	–	◪ 480	0.24	1.5	◪ 35	0.18	1.2	–	–	–
	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	–	–	–
	T8330	0.8	■ 160	0.35	1.5	■ 95	0.32	1.5	–	–	–	◪ 480	0.42	1.5	◪ 40	0.25	1.2	–	–	–
	T8430	0.8	■ 170	0.35	1.5	■ 90	0.32	1.5	–	–	–	◪ 465	0.42	1.5	◪ 35	0.25	1.2	–	–	–
	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	–	–	–
	T7335	0.4	◪ 170	0.20	1.5	■ 130	0.18	1.5	–	–	–	–	–	–	◪ 55	0.18	1.2	–	–	–
	T8315	0.4	◪ 165	0.20	1.5	■ 95	0.18	1.5	–	–	–	◪ 495	0.24	1.5	◪ 40	0.18	1.2	–	–	–
	T8330	0.4	■ 155	0.20	1.5	■ 90	0.18	1.5	–	–	–	◪ 465	0.24	1.5	◪ 35	0.18	1.2	–	–	–
	T8430	0.4	■ 175	0.20	1.5	■ 95	0.18	1.5	–	–	–	◪ 480	0.24	1.5	◪ 35	0.18	1.2	–	–	–
	T9325	0.4	■ 220	0.20	1.5	■ 130	0.18	1.5	–	–	–	–	–	–	◪ 45	0.18	1.2	–	–	–
	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	–	–	–
	T7335	0.8	◪ 170	0.35	1.5	■ 130	0.32	1.5	–	–	–	–	–	–	◪ 55	0.25	1.2	–	–	–
	T8315	0.8	◪ 165	0.35	1.5	■ 95	0.32	1.5	–	–	–	◪ 495	0.42	1.5	◪ 40	0.25	1.2	–	–	–
	T8330	0.8	■ 160	0.35	1.5	■ 95	0.32	1.5	–	–	–	◪ 480	0.42	1.5	◪ 40	0.25	1.2	–	–	–
	T8430	0.8	■ 170	0.35	1.5	■ 90	0.32	1.5	–	–	–	◪ 465	0.42	1.5	◪ 35	0.25	1.2	–	–	–
	T9325	0.8	■ 200	0.35	1.5	■ 120	0.32	1.5	–	–	–	–	–	–	◪ 45	0.25	1.2	–	–	–
	T9335	0.8	■ 180	0.35	1.5	■ 105	0.32	1.5	–	–	–	–	–	–	◪ 40	0.25	1.2	–	–	–
																				
			W-MR修光刃断屑槽，适用于精加工至粗加工，并提供更高的进给量并改善了表面光洁度。																	
DNMG 150608W-MR	**T5315**	0.8	◪ 190	0.40	1.5	–	–	–	◪ 180	0.40	1.5	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 170	0.40	1.5	–	–	–	◪ 160	0.40	1.5	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 155	0.40	1.5	◪ 90	0.36	1.5	◪ 145	0.40	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR	**T9310**	1.2	■ 175	0.50	1.5	–	–	–	◪ 165	0.50	1.5	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 160	0.50	1.5	–	–	–	◪ 150	0.50	1.5	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 145	0.50	1.5	◪ 85	0.45	1.5	◪ 135	0.50	1.5	–	–	–	–	–	–	–	–	–
																				
			W-NM修光刃断屑槽，适用于精加工至粗加工，并提供更高的进给量并改善了表面光洁度。																	
DNMX 150604W-NM	**T7325**	0.4	◪ 145	0.30	1.5	◪ 110	0.27	1.5	–	–	–	–	–	–	◪ 45	0.21	1.2	–	–	–
	T7335	0.4	◪ 135	0.30	1.5	◪ 105	0.27	1.5	–	–	–	–	–	–	◪ 40	0.21	1.2	–	–	–
	T9315	0.4	■ 185	0.30	1.5	–	–	–	◪ 175	0.30	1.5	–	–	–	–	–	–	–	–	–
DNMX 150608W-NM	**T7325**	0.8	◪ 155	0.40	1.5	◪ 120	0.36	1.5	–	–	–	–	–	–	◪ 50	0.28	1.2	–	–	–
	T7335	0.8	◪ 145	0.40	1.5	◪ 110	0.36	1.5	–	–	–	–	–	–	◪ 45	0.28	1.2	–	–	–
	T9315	0.8	■ 195	0.40	1.5	–	–	–	◪ 185	0.40	1.5	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 175	0.40	1.5	◪ 105	0.36	1.5	◪ 165	0.40	1.5	–	–	–	◪ 35	0.28	1.2	–	–	–

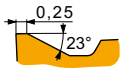
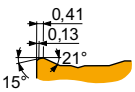
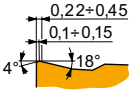
DNMM

PRAMET

	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



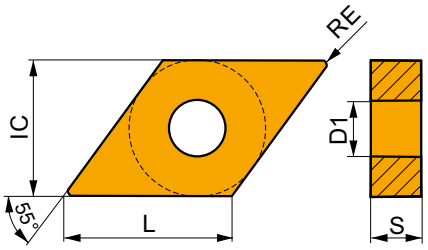
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
NR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
DNMM 150408E-NR	**T9325**	0.8	■ 155	0.40	3.0	■ 90	0.36	3.0	◪ 145	0.40	3.0	–	–	–	◪ 30	0.28	2.4	–	–	–
DNMM 150608E-NR	**T7325**	0.8	◪ 140	0.40	3.0	■ 105	0.36	3.0	–	–	–	–	–	–	◪ 45	0.28	2.4	–	–	–
	T8330	0.8	■ 125	0.40	3.0	■ 75	0.36	3.0	◪ 115	0.40	3.0	–	–	–	◪ 30	0.28	2.4	–	–	–
	T8430	0.8	■ 130	0.40	3.0	■ 70	0.36	3.0	◪ 105	0.40	3.0	–	–	–	◪ 25	0.28	2.4	–	–	–
	T9325	0.8	■ 155	0.40	3.0	■ 90	0.36	3.0	◪ 145	0.40	3.0	–	–	–	◪ 30	0.28	2.4	–	–	–
																				
NR2断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
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	–	–	–
																				
OR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
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	**T9315**	1.2	■ 180	0.40	3.0	–	–	–	◪ 170	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 165	0.40	3.0	◪ 95	0.36	3.0	◪ 155	0.40	3.0	–	–	–	◪ 35	0.32	2.4	–	–	–
	T9335	1.2	■ 145	0.40	3.0	◪ 85	0.36	3.0	–	–	–	–	–	–	◪ 30	0.32	2.4	–	–	–
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	–	–	–

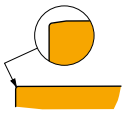
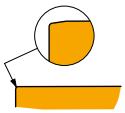
DNGA CER

PRAMET

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



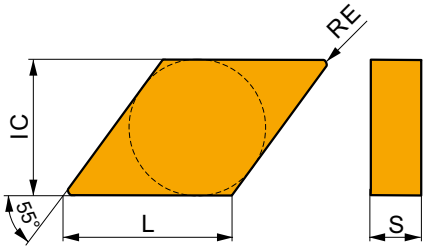
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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																	
			适用于高线速度连续切削。																	
DNGA 150408 S02020	**TC100**	0.8	–	–	–	–	–	–	450	0.20	1.5	–	–	–	–	–	–	–	–	–
			HSC T																	
			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	–	–	–	–	–	–	–	–	–

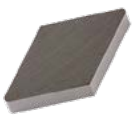
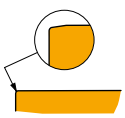
DNGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
1504	12.700	15.50	4.76



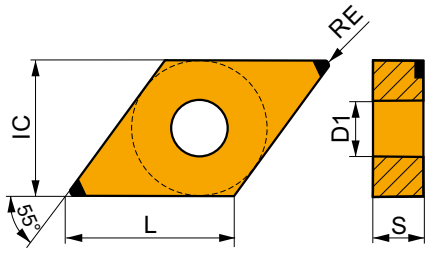
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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																	
			适用于高线速度连续切削。																	
DNGN 150408 T01020	**TC100**	0.8	–	–	–	–	–	–	450	0.20	1.5	–	–	–	–	–	–	–	–	–

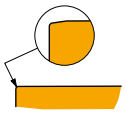
DNGA CBN

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。

产品型号		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															
			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	0.15	1.0

DDJN(RL) EXT

P M K N S H

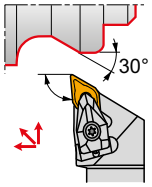
PRAMET

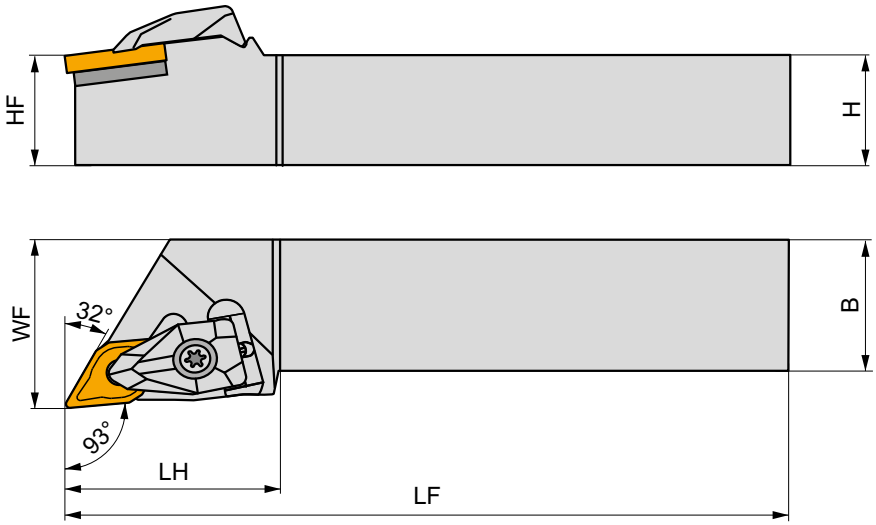
D

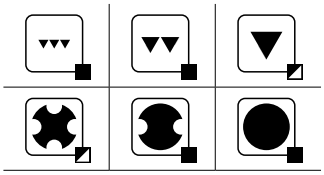


外圆用双重夹紧车刀杆，使用DN..刀片，主偏角为93°。

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。









	产品型号	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	0.45	GI046	DD11	–
	DDJNR 2525 M 11	25	25	25	32	150	30.2	-7	-6	0.77	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	1.12	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	0.45	GI046	DD11	–
	DDJNL 2525 M 11	25	25	25	32	150	30.2	-7	-6	0.77	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

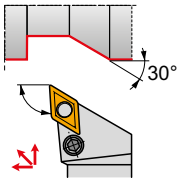
PRAMET

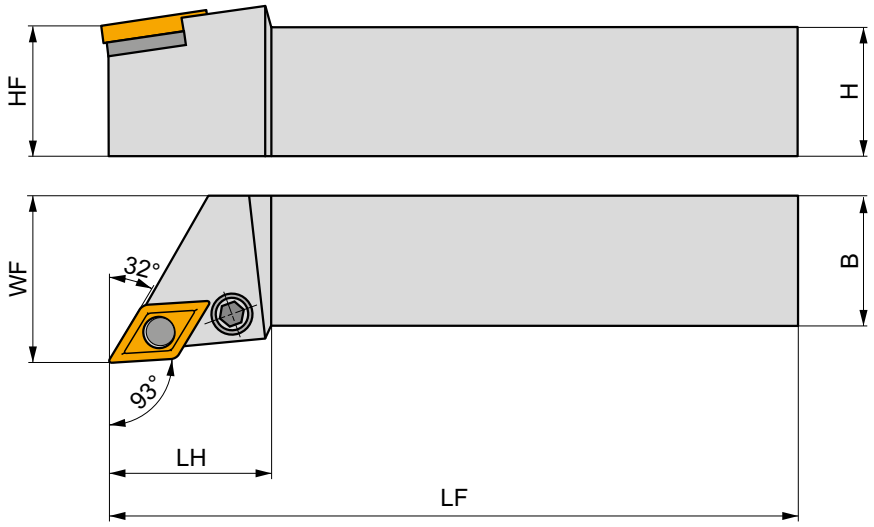
P

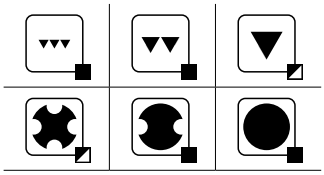


外圆用杠杆夹紧式车刀杆，使用DN..刀片，主偏角为93°。

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。









	产品型号	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	30	-6	-6	0.43	GI046	PD60
	PDJNR 2525 M 11	25	25	25	32	150	30	-6	-6	0.73	GI046	PD60
	PDJNR 3225 P 11	32	25	32	32	170	30	-6	-6	1.10	GI046	PD60
	PDJNR 2020 K 15	20	20	20	25	125	40	-6	-6	0.44	GI044	PD31
	PDJNR 2525 M 15	25	25	25	32	150	40	-6	-6	0.73	GI044	PD30
	PDJNR 3225 P 15	32	25	32	32	170	40	-6	-6	1.05	GI044	PD30
	PDJNR 3232 P 15	32	32	32	40	170	40	-6	-6	1.30	GI044	PD30
L	PDJNL 2020 K 11	20	20	20	25	125	30	-6	-6	0.41	GI046	PD60
	PDJNL 2525 M 11	25	25	25	32	150	30	-6	-6	0.73	GI046	PD60
	PDJNL 3225 P 11	32	25	32	32	170	30	-6	-6	1.10	GI046	PD60
	PDJNL 2020 K 15	20	20	20	25	125	40	-6	-6	0.42	GI044	PD31
	PDJNL 2525 M 15	25	25	25	32	150	40	-6	-6	0.73	GI044	PD30
	PDJNL 3225 P 15	32	25	32	32	170	40	-6	-6	0.98	GI044	PD30
	PDJNL 3232 P 15	32	32	32	40	170	40	-6	-6	1.30	GI044	PD30

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

				Nm					
PD30	DNU 150308	PU 03	US 36	6.0	M 8x1	26	NT 05	MT 05	HXK 4
PD31	DNU 150308	PU 03	US 40	6.0	M 8x1	20.5	NT 05	MT 05	HXK 4
PD60	PDN 110308	PU 3512	PS 0616	3.0	M 6	16	NT 5153	MT 0912	HXK 2.5

PDNN(RL) EXT

P M K N S H

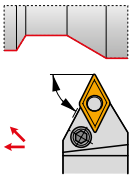
PRAMET

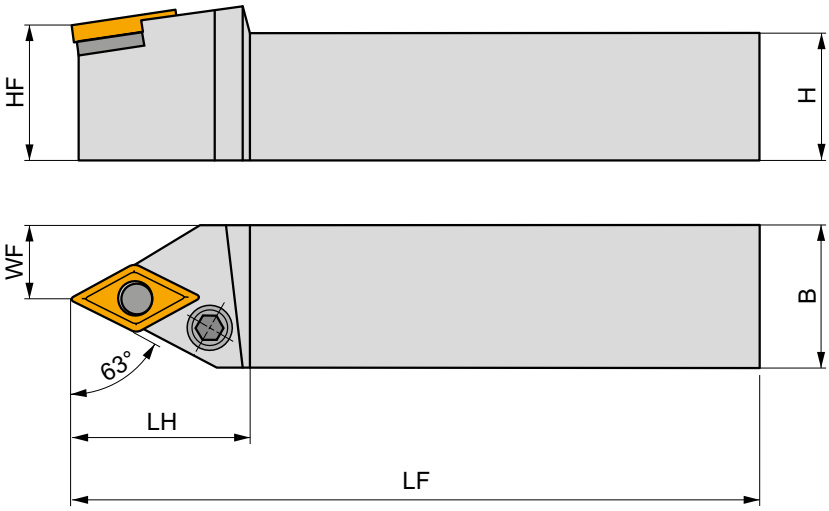
P

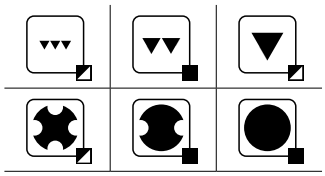


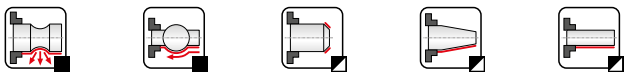
外圆用杠杆夹紧式车刀杆，使用DN..刀片，主偏角为63°。

外圆用左/右手柄锁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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PDNNR 2020 K 11**	20	20	20	10	125	24	-6	-6	0.39	GI046	PD60
	PDNNR 2525 M 11	25	25	25	12.5	150	30	-6	-6	0.60	GI046	PD60
	PDNNR 2525 M 15	25	25	25	12.5	150	40	-6	-6	0.64	GI044	PD30
	PDNNR 3225 P 15	32	25	32	12.5	170	40	-6	-6	1.05	GI044	PD30
L	**PDNNL 2020 K 11**	20	20	20	10	125	24	-6	-6	0.40	GI046	PD60
	PDNNL 2525 M 11	25	25	25	12.5	150	30	-6	-6	0.60	GI046	PD60
	PDNNL 2525 M 15	25	25	25	12.5	150	40	-6	-6	0.07	GI044	PD30
	PDNNL 3225 P 15	32	25	32	12.5	170	40	-6	-6	1.05	GI044	PD30

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

				Nm					
PD30	DNU 150308	PU 03	US 36	6.0	M 8x1	26	NT 05	MT 05	HXK 4
PD60	PDN 110308	PU 3512	PS 0616	3.0	M 6	16	NT 5153	MT 0912	HXK 2.5

PDXN(RL) EXT

P M K N S H

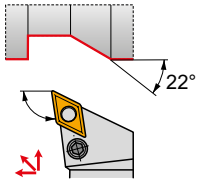
PRAMET

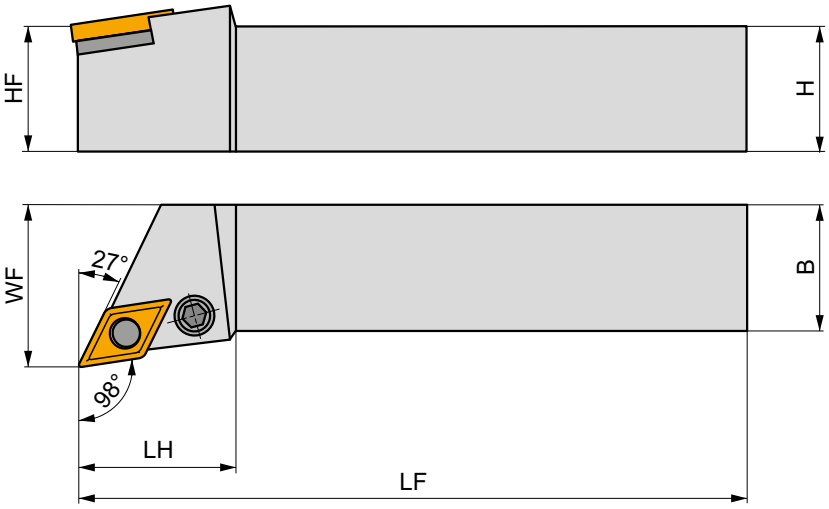
P

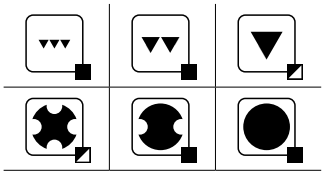
外圆用杠杆夹紧式车刀杆，使用DN..刀片，主偏角为98°。

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。











	产品型号	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	-6	-6	0.43	GI044	PD31
	PDXNR 2525 M 15	25	25	25	32	150	40	-6	-6	0.73	GI044	PD30
	PDXNR 3225 P 15	32	25	32	32	170	40	-6	-6	0.80	GI044	PD30
L	**PDXNL 2020 K 15**	20	20	20	25	125	40	-6	-6	0.42	GI044	PD31
	PDXNL 2525 M 15	25	25	25	32	150	40	-6	-6	0.71	GI044	PD30
	PDXNL 3225 P 15	32	25	32	32	170	40	-6	-6	0.95	GI044	PD30

GI044	DN.. 1506..

				Nm					
PD30	DNU 150308	PU 03	US 36	6.0	M 8x1	26	NT 05	MT 05	HXK 4
PD31	DNU 150308	PU 03	US 40	6.0	M 8x1	20.5	NT 05	MT 05	HXK 4

NEW

C.-DDJN(RL) EXT

P M K N S H

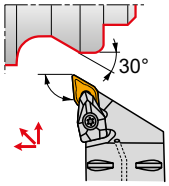
PRAMET

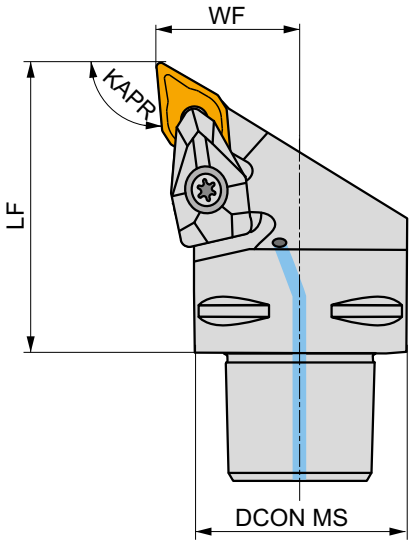
D

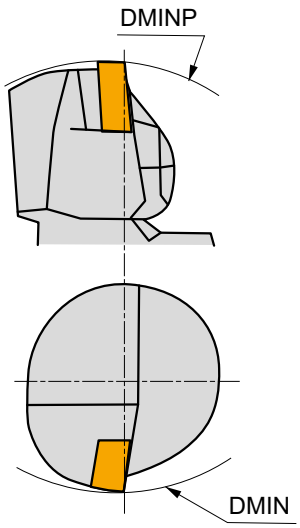


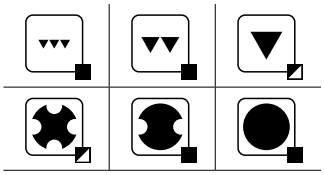
外圆用PSC快速更换式刀柄，双重夹紧，使用DN..刀片，主偏角为93°。

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。











	产品型号	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

NEW

C.-DDNNN EXT

P M K N S H

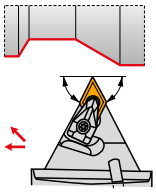
PRAMET

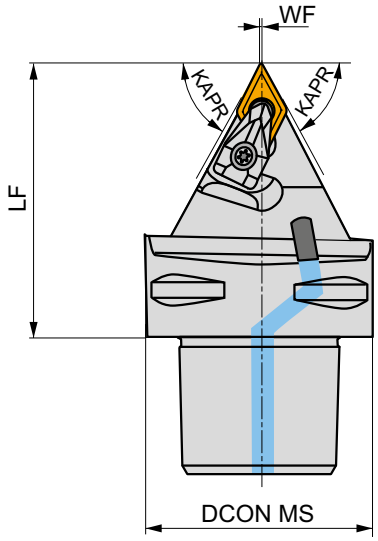
D

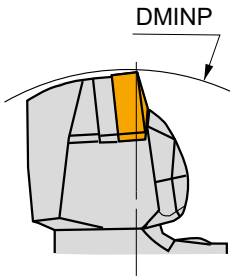


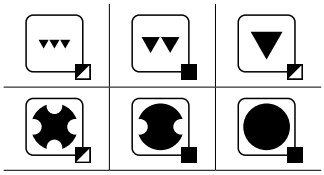
外圆用PSC快速更换式刀柄，双重夹紧，使用DN..刀片，主偏角为62.5°。

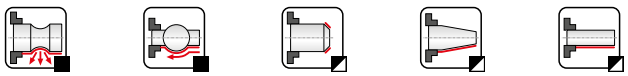
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为62.5°。使用DN..15尺寸的负前角刀片。适用于锥面和无阶梯外圆的轴向车削，仿形和倒角车削。可提供C5和C6刀柄。刀杆经过处理，使用寿命更长。











	产品型号	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 Nm	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

NEW

C.-DDUN(RL) EXT

P M K N S H

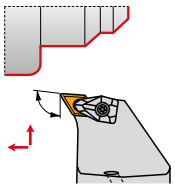
PRAMET

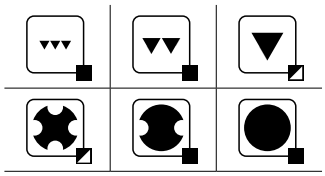
D

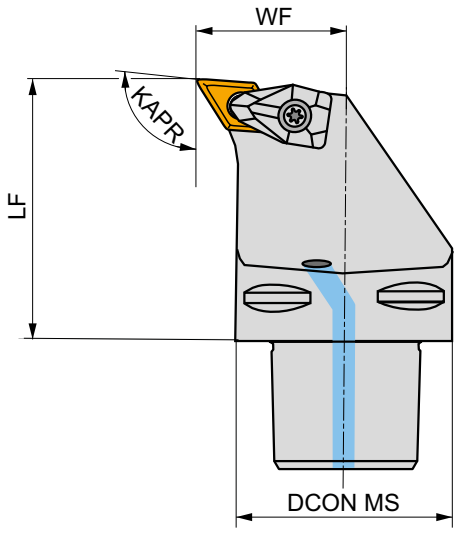


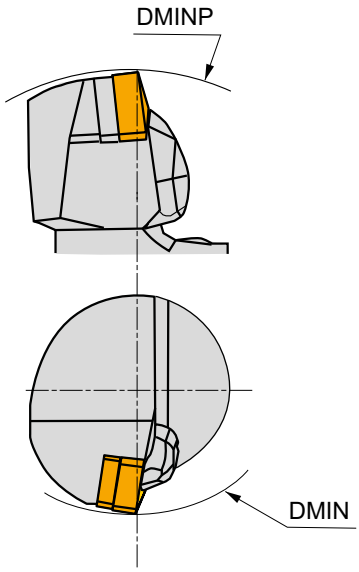
外圆用PSC快速更换式刀柄，双重夹紧，使用DN..刀片，主偏角为93°（端面）。

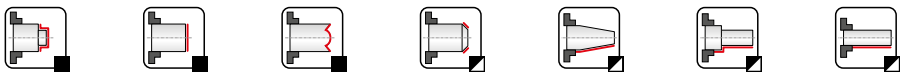
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为93°。使用DN..15尺寸的负前角刀片。适用于有阶梯外圆的端面车削，端面仿形，锥面，轴向车削和倒角车削。可提供C5和C6刀柄。刀杆经过处理，使用寿命更长。











	产品型号	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
	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..

		Nm				
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

DDUN(RL) INT

P M K N S H

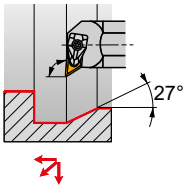
PRAMET

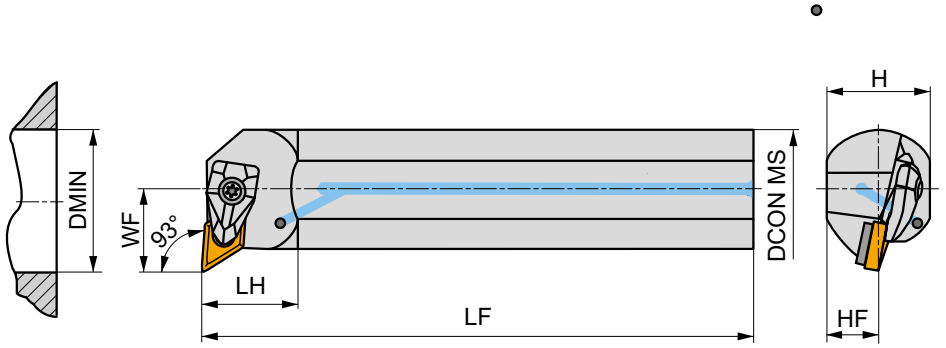
D

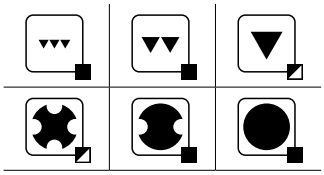


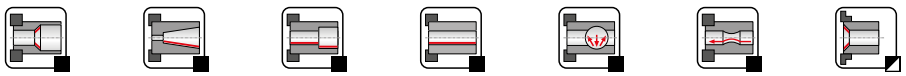
内孔用双重夹紧镗杆，使用DN..刀片，主偏角为93°。

内孔用左/右手双重夹紧钳镗杆，有内冷通道，主偏角为93°，使用DN..11和15刀片。内孔最小加工直径为Ø32mm。广泛的应用于内孔车削，仿形车削角度最大为27°。可提供Ø25至Ø50mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNR 11	32	40	22	30	15	300	30	-10	-6	✓	1.68	GI046	DD11	–
	A40T-DDUNR 15	40	50	27	37	18.5	300	36	-11	-6	✓	2.59	GI044	DD154	AT002
	A50U-DDUNR 15	50	63	35	47	23.5	350	39	-8	-6	✓	5.23	GI044	DD154	AT002
L	**A25T-DDUNL 11**	25	32	17	23	11.5	300	28	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNL 11	32	40	22	30	15	300	30	-10	-6	✓	1.69	GI046	DD11	–
	A40T-DDUNL 15	40	50	27	37	18.5	300	36	-11	-6	✓	2.59	GI044	DD154	AT002
	A50U-DDUNL 15	50	63	35	47	23.5	350	39	-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

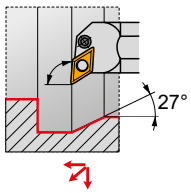
PRAMET

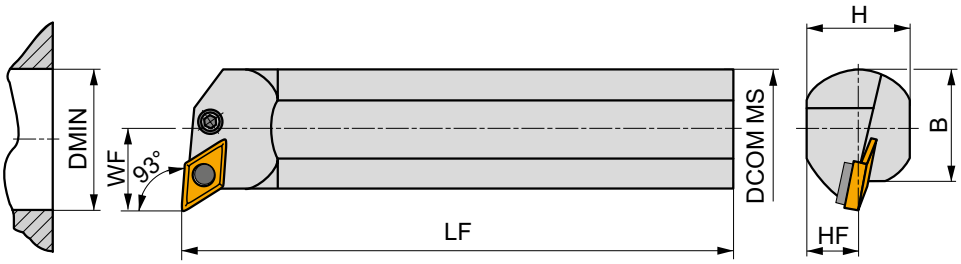
P

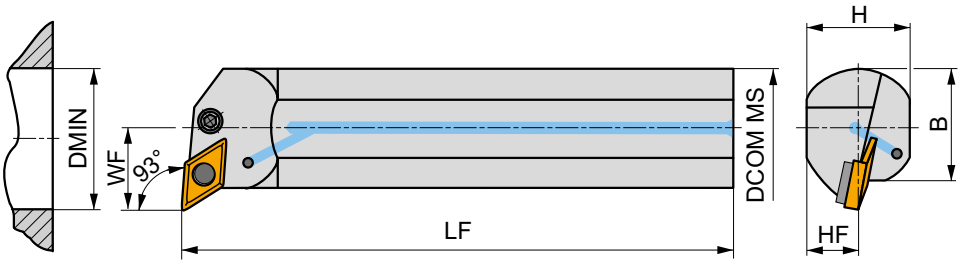


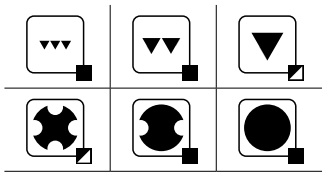
外圆用杠杆夹紧式车刀杆，使用DN..刀片，主偏角为93°。

内孔用左/右手杠杆夹紧式镗杆，有内冷通道，主偏角为93°，使用DN..11和15刀片。内孔最小加工直径为Ø32mm。广泛的应用于内孔车削，仿形车削角度最大为27°。可提供Ø25至Ø60mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**S25T-PDUNR 11-A**	25	32	17	23	23	300	-12	-6	–	1.10	GI046	PD61
	S32U-PDUNR 11	32	40	22	30	30	350	-12	-6	–	2.10	GI046	PD60
	A32S-PDUNR 15	32	40	32	30	30	250	-12	-6	✓	1.47	GI097	PD33
	A40T-PDUNR 15	40	50	27	38	38	300	-12	-6	✓	2.40	GI097	PD30
	A50U-PDUNR 15	50	63	35	47	48.5	350	-12	-6	✓	4.95	GI097	PD30
	A60V-PDUNR 15	60	80	43	57	58.5	400	-12	-6	✓	8.22	GI097	PD30
L	**S25T-PDUNL 11-A**	25	32	17	23	23	300	-12	-6	–	1.11	GI046	PD61
	S32U-PDUNL 11	32	40	22	30	30	350	-12	-6	–	2.09	GI046	PD60
	A32S-PDUNL 15	32	40	32	30	30	250	-12	-6	✓	1.47	GI097	PD33
	A40T-PDUNL 15	40	50	27	38	38	300	-12	-6	✓	2.56	GI097	PD30
	A50U-PDUNL 15	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI097	PD30
	A60V-PDUNL 15	60	80	43	57	58.5	400	-12	-6	✓	8.16	GI097	PD30

GI046	DN.. 1104..
GI097	DN.. 1504..

				Nm					
PD30	DNU 150308	PU 03	US 36	6.0	M 8x1	26	NT 05	MT 05	HXK 4
PD33	–	PU 03-A	US 41	6.0	M 8x1	17	NT 15	MT 05	HXK 4
PD60	PDN 110308	PU 3512	PS 0616	3.0	M 6	16	NT 5153	MT 0912	HXK 2.5
PD61	–	PU 3611-A	PS 0512-A	2.0	M 5	12	–	–	HXK 2

NEW

C.-DDUN(RL) INT

P M K N S H

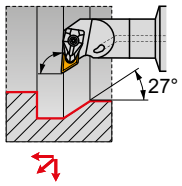
PRAMET

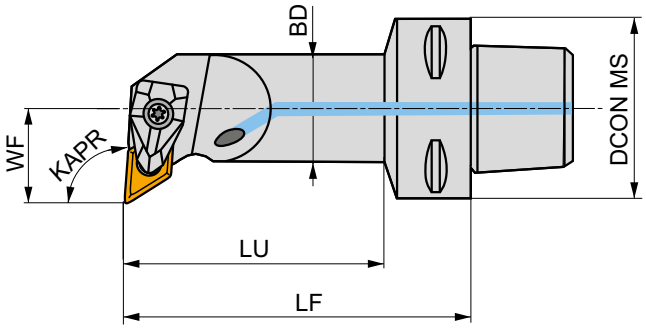
D

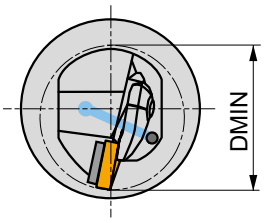


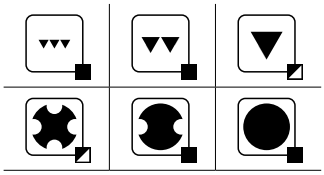
内孔用PSC快速更换式刀柄，双重夹紧，使用DN..刀片，主偏角为93°。

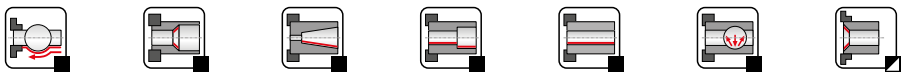
内孔用左/右手双重夹紧紧刀具，有内冷通道，主偏角为93°，使用DN..11刀片。适用于内孔车削应用，仿形车削角度最大为27°。包括最小内径Ø32mm。可提供C4的PSC刀柄，车削长度为68mm。刀杆经过处理，使用寿命更长。











	产品型号	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

KN 16

硬质合金刀片

KNUX



284

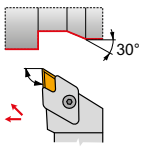
匹配正确的尺寸（示例）

刀片	刀杆
KNUX 160405L-22	CKJNR 2020 K 16

ISO 外圆车削

CKJN(RL) EXT

93°





20×20
32×25

287

KN..



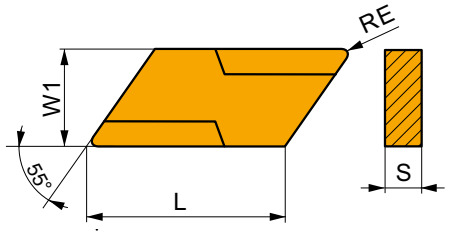
16

284 – 286

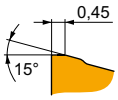
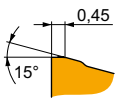
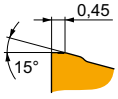
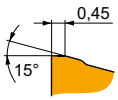
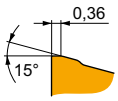
KNUX

PRAMET

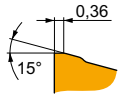
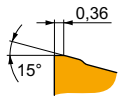
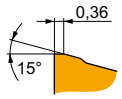
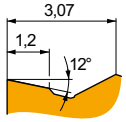
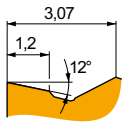
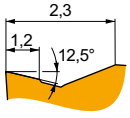
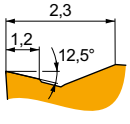
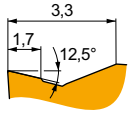
	W1 (mm)	L (mm)	S (mm)
1604	9.525	19.50	4.76



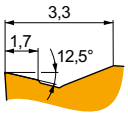
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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断屑槽，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	–	–	–	–	–	–	–	–	–
	T7325	0.5	130	0.25	2.7	100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.5	125	0.25	2.7	95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.5	155	0.25	2.7	90	0.25	2.7	145	0.25	2.7	–	–	–	–	–	–	–	–	–
	T9335	0.5	135	0.25	2.7	80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
R-22断屑槽，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	–	–	–	–	–	–	–	–	–
	T7325	0.5	130	0.25	2.7	100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.5	125	0.25	2.7	95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.5	155	0.25	2.7	90	0.25	2.7	145	0.25	2.7	–	–	–	–	–	–	–	–	–
	T9335	0.5	135	0.25	2.7	80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
L-22断屑槽，左手设计，适用于精加工至中粗加工，连续切削。																				
KNUX 160410L-22	**T9335**	1.0	155	0.32	2.7	90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
R-22断屑槽，右手设计，适用于精加工至中粗加工，连续切削。																				
KNUX 160410R-22	**T9335**	1.0	155	0.32	2.7	90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
L-32断屑槽，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	–	–	–	–	–	–	–	–	–
	T7325	0.5	130	0.25	2.7	100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.5	125	0.25	2.7	95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.5	155	0.25	2.7	90	0.25	2.7	145	0.25	2.7	–	–	–	–	–	–	–	–	–
	T9335	0.5	135	0.25	2.7	80	0.25	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。

产品型号		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)
																				
R-32槽型，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	–	–	–	–	–	–	–	–	–
	T7325	0.5	◪ 130	0.25	2.7	◪ 100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.5	◪ 125	0.25	2.7	◪ 95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.5	■ 155	0.25	2.7	◪ 90	0.25	2.7	◪ 145	0.25	2.7	–	–	–	–	–	–	–	–	–
	T9335	0.5	■ 135	0.25	2.7	◪ 80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
L-32断屑槽，左手设计，适用于精加工至中粗加工，连续切削。																				
KNUX 160410L-32	**T9325**	1.0	■ 175	0.32	2.7	◪ 105	0.29	2.7	◪ 165	0.32	2.7	–	–	–	–	–	–	–	–	–
	T9335	1.0	■ 155	0.32	2.7	◪ 90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
R-32槽型，右手设计，适用于精加工至中粗加工，连续切削。																				
KNUX 160410R-32	**T9325**	1.0	■ 175	0.32	2.7	◪ 105	0.29	2.7	◪ 165	0.32	2.7	–	–	–	–	–	–	–	–	–
	T9335	1.0	■ 155	0.32	2.7	◪ 90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																				
ER-72断屑槽，右手设计，适用于精细的精加工，连续切削。																				
KNUX 160405ER-72	**T5315**	0.5	◪ 250	0.20	2.0	–	–	–	■ 235	0.20	2.0	–	–	–	–	–	–	–	–	–
	T9325	0.5	■ 215	0.20	2.0	◪ 125	0.18	2.0	◪ 200	0.20	2.0	–	–	–	◪ 45	0.16	1.6	–	–	–
	T9335	0.5	■ 185	0.20	2.0	◪ 110	0.18	2.0	–	–	–	–	–	–	◪ 40	0.16	1.6	–	–	–
																				
EL-72断屑槽，左手设计，适用于精细的精加工，连续切削。																				
KNUX 160405EL-72	**T5315**	0.5	◪ 250	0.20	2.0	–	–	–	■ 235	0.20	2.0	–	–	–	–	–	–	–	–	–
	T9325	0.5	■ 215	0.20	2.0	◪ 125	0.18	2.0	◪ 200	0.20	2.0	–	–	–	◪ 45	0.16	1.6	–	–	–
	T9335	0.5	■ 185	0.20	2.0	◪ 110	0.18	2.0	–	–	–	–	–	–	◪ 40	0.16	1.6	–	–	–
																				
ER-73槽型，右手设计，适用于精加工至中粗加工，连续切削。																				
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	–	–	–	–	–	–	–	–	–
	T5315	1.0	◪ 235	0.40	3.0	–	–	–	■ 220	0.40	3.0	–	–	–	–	–	–	–	–	–
																				
EL-73断屑槽，左手设计，适用于精加工至中粗加工，连续切削。																				
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	–	–	–	–	–	–	–	–	–
																				
ER-74槽型，右手设计，可完成从粗加工至粗加工，连续切削。																				
KNUX 160415SR-74	**6640**	1.5	■ 155	0.45	3.0	◪ 90	0.41	3.0	■ 145	0.45	3.0	–	–	–	–	–	–	–	–	–

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

产品型号		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)
			 EL-74断屑槽，左手设计，可完成从粗加工至粗加工，连续切削。																	
KNUX 160415SL-74	**6640**	1.5	■ 155	0.45	3.0	◪ 90	0.41	3.0	■ 145	0.45	3.0	–	–	–	–	–	–	–	–	–

CKJN(RL) EXT

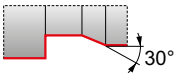
P M K N S H

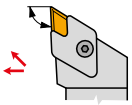
PRAMET C

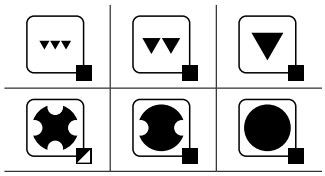


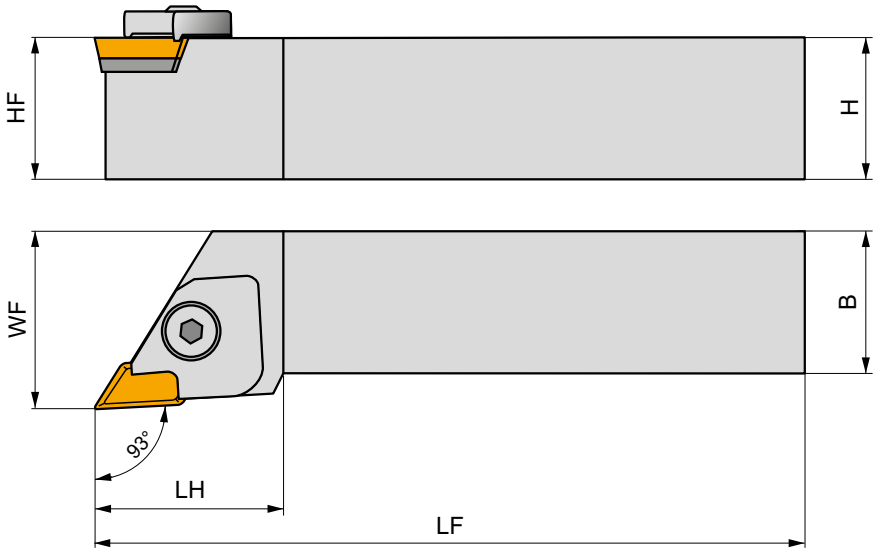
外圆用顶部夹紧车削刀杆，使用KN..16刀片，主偏角为93°。

外圆用左/右手顶部夹具刀具夹，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。











	产品型号	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	1	-5	0.43	GI066	R1
	CKJNR 2525 M 16	25	25	25	32	150	34	1	-5	0.70	GI066	R
	CKJNR 3225 P 16	32	25	32	32	170	34	1	-5	1.05	GI066	R
L	**CKJNL 2020 K 16**	20	20	20	30	125	34	1	-5	0.43	GI067	L1
	CKJNL 2525 M 16	25	25	25	32	150	34	1	-5	0.74	GI067	L
	CKJNL 3225 P 16	32	25	32	32	170	34	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
R	KNN 190412R	NT 03	UP 25	–	US 83	6.0	PR 07	K 23	HXK 4
R1	KNN 190412R	NT 03	UP 25	–	US 83	6.0	PR 07	K 22	HXK 4

LN 40/ 50

硬质合金刀片

LNUX 40, LN.X 50



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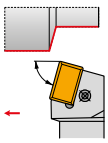
匹配正确的尺寸（示例）

刀片	刀杆
LNUX **40**-1129003	KHP-LBNR **40**-A

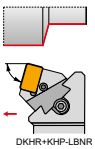
ISO 外圆车削

PLBN(RL) EXT

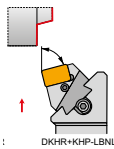
75°	LN..
	 40 50
 60×60	
290	289

ISO外圆重载车削

KHP-LBNR + DKH(RL)

75°	LN..
	 40
 40×50 60×80	
291, 292	289

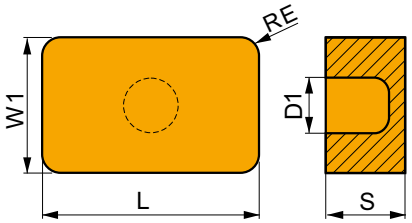
KHP-LBNL + DKH(RL)

75°	LN..
	 40
 40×50 60×80	
291, 292	289

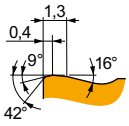
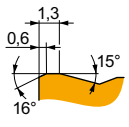
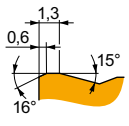
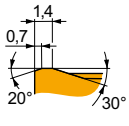
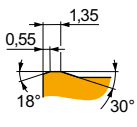
LNUX 40, LN.X 50

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
50-2	25.400	6.45	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。

产品型号		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)
																				
			适用于重载粗加工，连续至断续切削。																	
LNUX 40-1129002	**T9226**	3.2	45	1.35	25.0	–	–	–	40	1.35	25.0	–	–	–	–	–	–	–	–	–
	T9325	3.2	55	1.35	25.0	–	–	–	50	1.35	25.0	–	–	–	–	–	–	–	–	–
	T9335	3.2	40	1.35	25.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
			适用于重载粗加工，连续至断续切削。																	
LNUX 40-1129003	**T9226**	3.2	45	1.35	25.0	–	–	–	40	1.35	25.0	–	–	–	–	–	–	–	–	–
	T9325	3.2	55	1.35	25.0	–	–	–	50	1.35	25.0	–	–	–	–	–	–	–	–	–
	T9335	3.2	40	1.35	25.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
			适用于重载粗加工，连续至断续切削。																	
LNUX 50-1275000	**T9226**	3.2	45	1.35	25.0	–	–	–	40	1.35	25.0	–	–	–	–	–	–	–	–	–
	T9325	3.2	55	1.35	25.0	–	–	–	50	1.35	25.0	–	–	–	–	–	–	–	–	–
																				
			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	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
			适用于重载粗加工，连续至断续切削。																	
LNMX 50-2284000	**T9315**	3.2	60	1.50	25.0	–	–	–	55	1.50	25.0	–	–	–	–	–	–	–	–	–

PLBN(RL) EXT

P M K

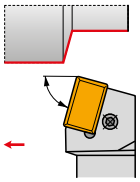
PRAMET

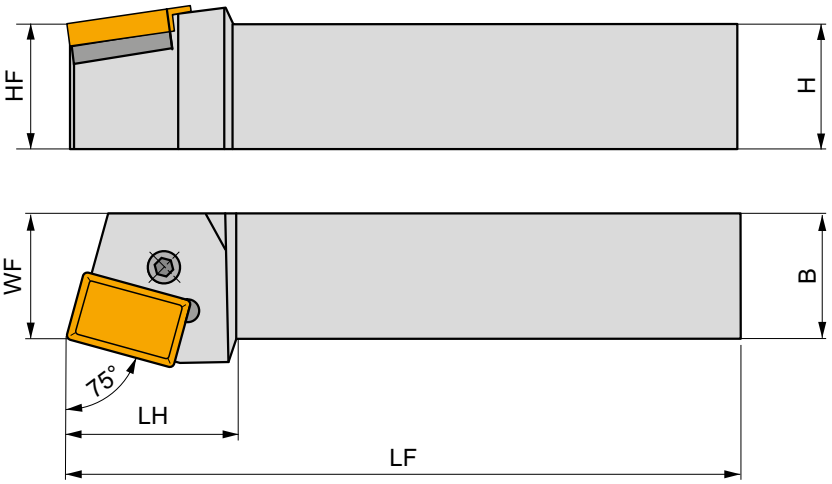
P

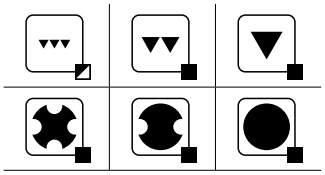


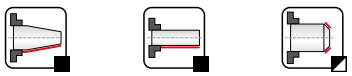
外圆用杠杆夹紧式重载车刀杆，使用LNUX刀片，主偏角为75°。

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。









	产品型号	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	-6	-6	13.00	GI102	PL71
	PLBNR 6060 V 50	60	60	60	60	400	70	-6	-6	12.75	GI145	PL72
	PLBNR 6060 V 50-2	60	60	60	60	400	70	-6	-6	11.60	GI291	PL73
L	**PLBNL 6060 V 40-A**	60	60	60	60	400	64	-6	-6	11.14	GI102	PL71
	PLBNL 6060 V 50	60	60	60	60	400	70	-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

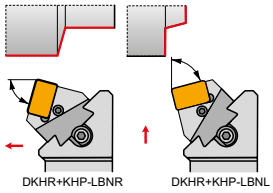
PRAMET

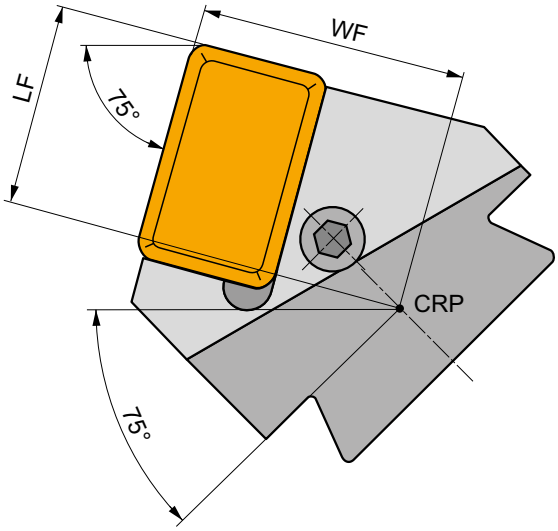
P

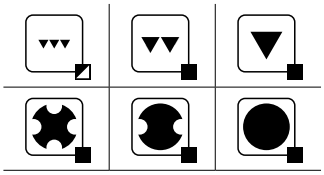


模块化KHP杠杆夹紧式车刀刀夹，使用LNUX刀片，主偏角为75°

燕尾形左/右手杠杆夹紧式车刀夹，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。车刀夹经过处理，使用寿命更长。









	产品型号	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

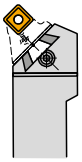
DKH(RL)

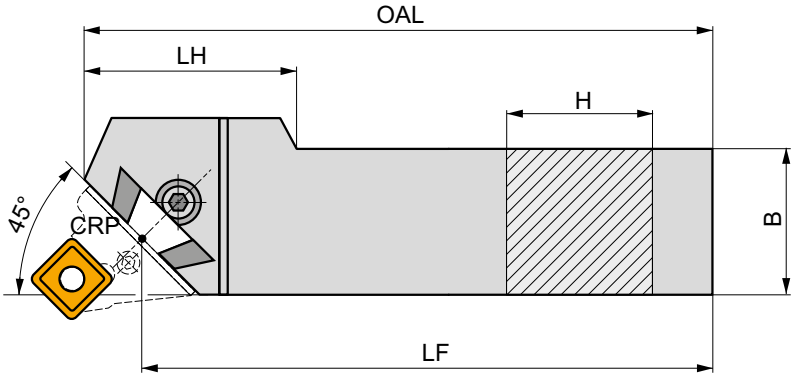
PRAMET

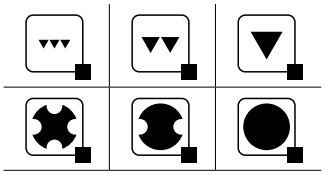


使用KHP/KHS重载车刀刀夹的外圆用刀柄

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。







	产品型号	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

RN

09/ 12/ 15/ 19/ 25

硬质合金刀片

RNMG



294

CER刀片

RNGN CER



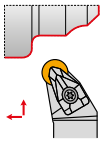
294

匹配正确的尺寸（示例）

刀片	刀杆
RNMG 120400E-08	DRSNR 2525 M 12

ISO 外圆车削

DRSN(RL) EXT



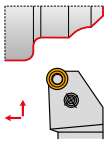
RN..

12

25×25

295 | 294

PRSN(RL) EXT



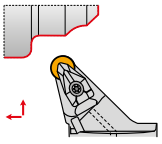
RN..

12
15
19

25×25
40×40

296 | 294

C.-DRSN(RL) EXT NEW



RN..

12

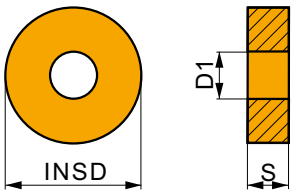
C6

297 | 294

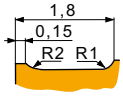
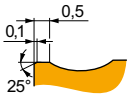
RNMG

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



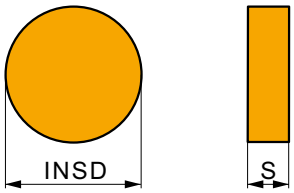
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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																	
断屑槽08，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	0.15	1.0
	T9315	–	150	0.70	3.0	–	–	–	140	0.70	3.0	–	–	–	–	–	–	30	0.15	1.0
	T9325	–	135	0.70	3.0	–	–	–	125	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 150600E-08	**T5305**	–	295	0.70	3.0	–	–	–	280	0.70	3.0	–	–	–	–	–	–	55	0.15	1.0
	T9315	–	225	0.70	3.0	–	–	–	210	0.70	3.0	–	–	–	–	–	–	45	0.15	1.0
	T9325	–	205	0.70	3.0	–	–	–	190	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 190600E-08	**T9315**	–	150	0.70	3.0	–	–	–	140	0.70	3.0	–	–	–	–	–	–	30	0.15	1.0
	T9325	–	135	0.70	3.0	–	–	–	125	0.70	3.0	–	–	–	–	–	–	–	–	–
			HFC P																	
断屑槽081，适用于粗加工至重载粗加工，连续切削至间断切削。																				
RNMG 250900E-081	**T9315**	–	145	0.90	5.0	–	–	–	135	0.90	5.0	–	–	–	–	–	–	25	0.15	1.0
	T9325	–	130	0.90	5.0	–	–	–	120	0.90	5.0	–	–	–	–	–	–	–	–	–

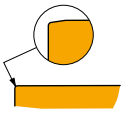
RNGN CER

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。

产品型号		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															
适用于高线速度连续切削。																				
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	–	–	–	–	–	–	–	–	–

DRSN(RL) EXT

P M K H

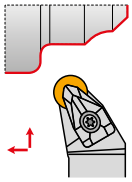
PRAMET

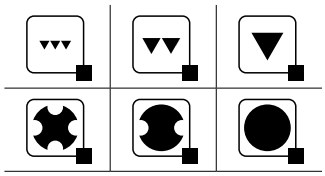
D

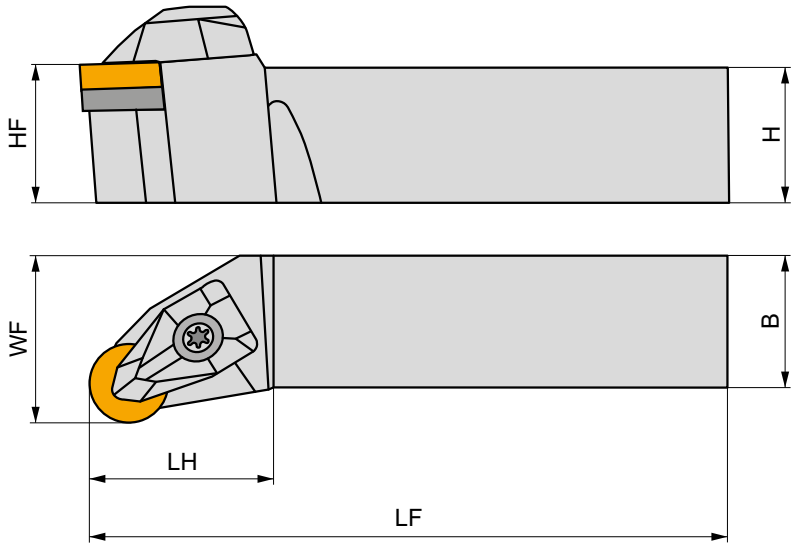


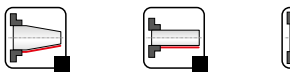
外圆用双重夹紧刀杆，使用RN..刀片。

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。









	产品型号	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 Nm	DRS 155-02	US 2002-T15P	FLAG T15P/3,5

PRSN(RL) EXT

P M K H

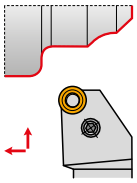
PRAMET

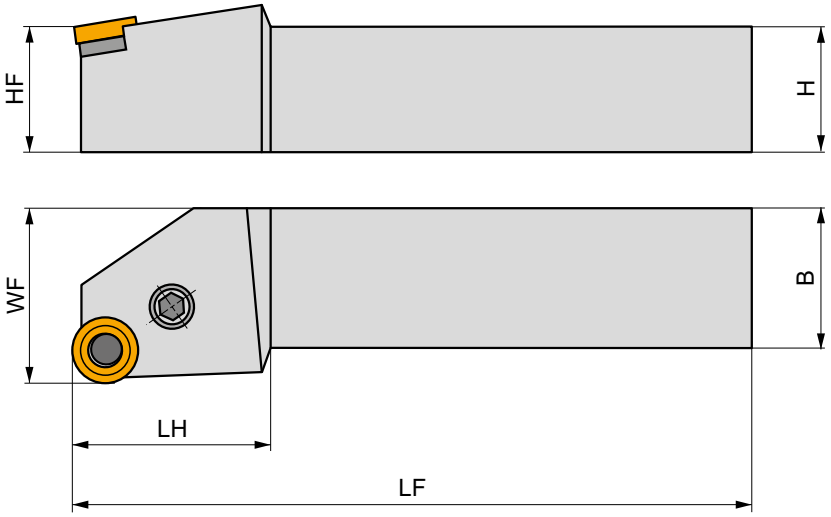
P

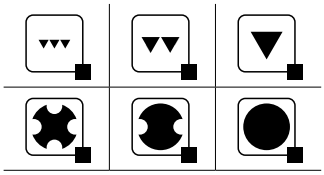


外圆用杠杆夹紧式车刀杆，使用DN..刀片。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PRSNR 2525 M 12**	25	25	25	32	150	32	-6	-6	0.68	GI083	PR20
	PRSNR 3232 P 15	32	32	32	40	170	38	-6	-6	1.40	GI105	PR40
	PRSNR 4040 R 19	40	40	40	50	200	40	-6	-6	2.49	GI106	PR50
L	**PRSNL 2525 M 12**	25	25	25	32	150	32	-6	-6	0.74	GI083	PR20
	PRSNL 3232 P 15	32	32	32	40	170	38	-6	-6	1.40	GI105	PR40
	PRSNL 4040 R 19	40	40	40	50	200	40	-6	-6	2.48	GI106	PR50

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

				Nm					
PR20	RNU 120300	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PR40	RNU 150300	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4
PR50	RNU 190400	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5

NEW

C.-DRSN(RL) EXT

P M K H

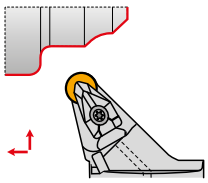
PRAMET

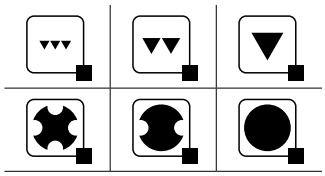
D

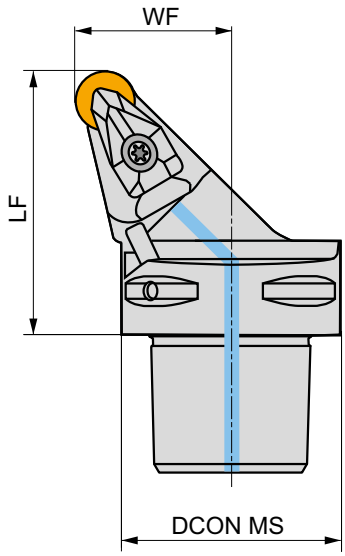


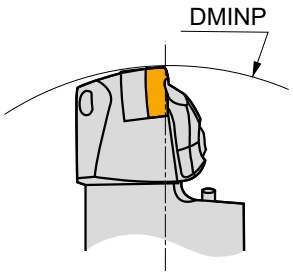
外圆用PSC快速更换式刀柄，双重夹紧，使用RN..刀片。

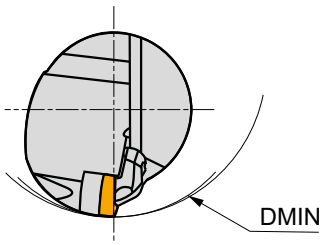
外圆用左/右手双重夹紧紧刀具，有内冷通道，使用圆形RN..12尺寸负前角刀片。适用于无阶梯外圆的轴向车削，仿形，锥面和倒角车削。可提供C6刀柄。刀杆经过处理，使用寿命更长。

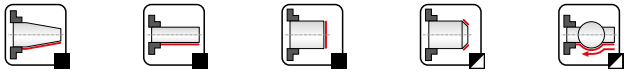












	产品型号	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg			
R	C6-DRSNR-45065-12	63	110	190	45	65	-6	-6	✓	1.11	GI083	C-DR12	–
L	C6-DRSNL-45065-12	63	110	190	45	65	-6	-6	✓	1.10	GI083	C-DR12	–

GI083	RN.. 120400

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

SN

09/ 12/ 15/ 19/ 25

硬质合金刀片

SNMA



300

SNMG



301

SNMM



307

SNMX



311

CER刀片

SNGA CER



311

SNGN CER



312

匹配正确的尺寸（示例）

刀片	刀杆
SNMG 190616E-RM	DSDNN 3232 P 19

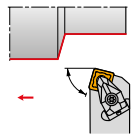
ISO 外圆车削

DSBN(RL) EXT

75°

SN..

12
15
19



20×20
40×40

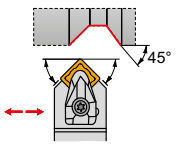
313 | 300 – 312

DSDNN EXT

45°

SN..

12
15
19
25



20×20
40×40

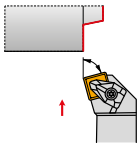
315 | 300 – 312

DSKN(RL) EXT

75°

SN..

12
19



25×25
32×32

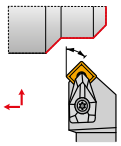
316 | 300 – 312

DSSN(RL) EXT

45°

SN..

12
15
19



20×20
40×40

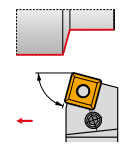
317 | 300 – 312

PSBN(RL) EXT

75°

SN..

12
15
19
25



20×20
50×50

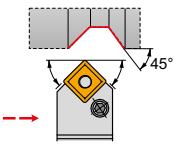
318 | 300 – 312

PSDNN EXT

45°

SN..

12
15
19
25



20×20
50×50

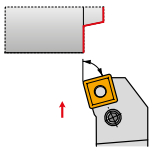
320 | 300 – 312

PSKN(RL) EXT

75°

SN..

12
15
19
25



20×20
50×50

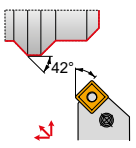
321 | 300 – 312

PSSN(RL) EXT

45°

SN..

19
25



40×40
50×50

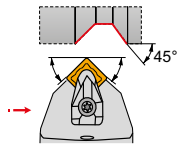
323 | 300 – 312

SN

09/ 12/ 15/ 19/ 25

C.-DSDNN EXT NEW

45°



SN..

12
19

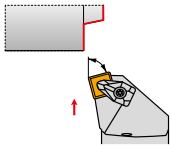
C4
C6

324

300 – 312

C.-DSKN(RL) EXT NEW

75°



SN..

12

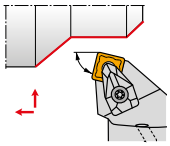
C4

325

300 – 312

C.-DSRN(RL) EXT NEW

75°



SN..

12
19

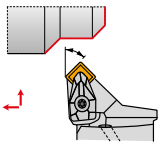
C4
C6

326

300 – 312

C.-DSSN(RL) EXT NEW

45°



SN..

12

C4
C5

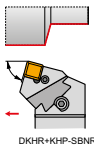
327

300 – 312

ISO外圆重载车削

KHP-SBNR + DKH(RL)

75°



SN..

25

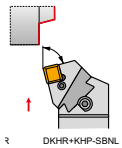
40×50
60×80

328, 330

300 – 312

KHP-SBNL + DKH(RL)

75°



SN..

25

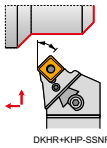
40×50
60×80

328, 330

300 – 312

KHP-SSNR/L + DKH(RL)

45°



SN..

19
25

40×50
60×80

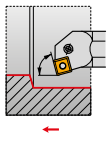
329, 330

300 – 312

ISO内孔车削

PSKN(RL) INT

93°



SN..

11
15

32
80

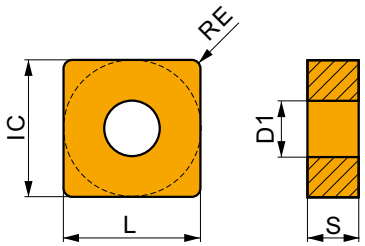
331

300 – 312

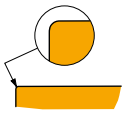
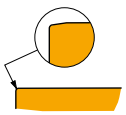
SNMA

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.875	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	9.525



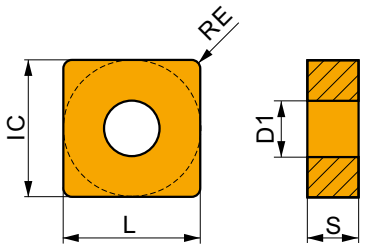
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
适用于超精加工至中粗加工，连续至轻微断续切削。																				
SNMA 120408	**T5305**	0.8	–	–	–	–	–	–	230	0.20	4.0	–	–	–	–	–	–	45	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	200	0.20	4.0	–	–	–	–	–	–	40	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.15	1.0
SNMA 120412	**T5305**	1.2	–	–	–	–	–	–	205	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
	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
	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
	T5315	1.2	–	–	–	–	–	–	180	0.30	6.0	–	–	–	–	–	–	35	0.15	1.0
SNMA 190616	**T5305**	1.6	–	–	–	–	–	–	190	0.40	6.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.6	–	–	–	–	–	–	170	0.40	6.0	–	–	–	–	–	–	35	0.15	1.0
SNMA 250724	**T5305**	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.15	1.0
	T5315	2.4	–	–	–	–	–	–	90	0.60	8.0	–	–	–	–	–	–	15	0.15	1.0
SNMA 250924	**T5305**	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.15	1.0
	T5315	2.4	–	–	–	–	–	–	90	0.60	8.0	–	–	–	–	–	–	15	0.15	1.0
																				
适用于超精加工至中粗加工，连续至轻微断续切削。																				
SNMA 120412S	**T5305**	1.2	–	–	–	–	–	–	205	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 190616S	**T5305**	1.6	–	–	–	–	–	–	195	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 250724S	**T5305**	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.15	1.0
SNMA 250924S	**T5305**	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.15	1.0

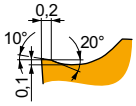
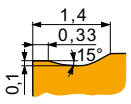
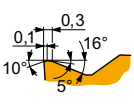
SNMG

PRAMET

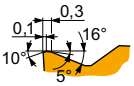
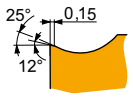
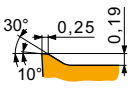
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.875	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.525



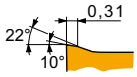
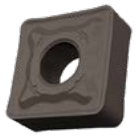
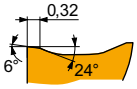
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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，具有正前角设计，适用于精加工至中粗加工，连续切削至轻微断续切削。																	
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	–	–	–
	T7325	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
	T8315	0.4	180	0.20	2.1	105	0.18	2.1	170	0.20	2.1	–	–	–	45	0.14	1.7	–	–	–
	T8330	0.4	175	0.20	2.1	105	0.18	2.1	165	0.20	2.1	–	–	–	40	0.14	1.7	–	–	–
	T8430	0.4	195	0.20	2.1	105	0.18	2.1	160	0.20	2.1	–	–	–	40	0.14	1.7	–	–	–
	T9315	0.4	270	0.20	2.1	–	–	–	255	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9325	0.4	240	0.20	2.1	140	0.18	2.1	225	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
SNMG 120408E-FM	**T7325**	0.8	235	0.20	2.1	180	0.18	2.1	–	–	–	–	–	–	75	0.16	1.7	–	–	–
	T8315	0.8	215	0.20	2.1	125	0.18	2.1	200	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
	T8330	0.8	205	0.20	2.1	120	0.18	2.1	190	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
	T8430	0.8	235	0.20	2.1	125	0.18	2.1	190	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
	T9310	0.8	355	0.20	2.1	–	–	–	335	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9315	0.8	320	0.20	2.1	–	–	–	300	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9325	0.8	290	0.20	2.1	170	0.18	2.1	275	0.20	2.1	–	–	–	65	0.16	1.7	–	–	–
SNMG 120412E-FM	**T8330**	1.2	200	0.27	2.1	120	0.24	2.1	190	0.27	2.1	–	–	–	50	0.19	1.7	–	–	–
	T8430	1.2	220	0.27	2.1	120	0.24	2.1	180	0.27	2.1	–	–	–	45	0.19	1.7	–	–	–
	T9315	1.2	300	0.27	2.1	–	–	–	285	0.27	2.1	–	–	–	–	–	–	–	–	–
	T9325	1.2	270	0.27	2.1	160	0.24	2.1	255	0.27	2.1	–	–	–	60	0.19	1.7	–	–	–
SNMG 120416E-FM	**T8330**	1.6	200	0.32	2.1	120	0.29	2.1	190	0.32	2.1	–	–	–	50	0.22	1.7	–	–	–
	T8430	1.6	220	0.32	2.1	120	0.29	2.1	180	0.32	2.1	–	–	–	45	0.22	1.7	–	–	–
	T9325	1.6	260	0.32	2.1	155	0.29	2.1	245	0.32	2.1	–	–	–	55	0.22	1.7	–	–	–
																				
			KR断屑槽，适用于中粗加工至重载粗加工，连续至断续切削。																	
SNMG 120408E-KR	**T5305**	0.8	265	0.35	3.8	–	–	–	250	0.35	3.8	–	–	–	–	–	–	50	0.15	1.0
	T5315	0.8	235	0.35	3.8	–	–	–	220	0.35	3.8	–	–	–	–	–	–	45	0.15	1.0
SNMG 120412E-KR	**T5305**	1.2	265	0.40	3.8	–	–	–	250	0.40	3.8	–	–	–	–	–	–	50	0.15	1.0
	T5315	1.2	240	0.40	3.8	–	–	–	225	0.40	3.8	–	–	–	–	–	–	45	0.15	1.0
																				
			M断屑槽，适用于精加工至中粗加工，连续至断续切削。																	
SNMG 120408E-M	**T5305**	0.8	290	0.32	2.1	–	–	–	275	0.32	2.1	–	–	–	–	–	–	55	0.15	1.0
	T5315	0.8	260	0.32	2.1	–	–	–	245	0.32	2.1	–	–	–	–	–	–	50	0.15	1.0
	T9310	0.8	255	0.32	2.1	–	–	–	240	0.32	2.1	–	–	–	–	–	–	50	0.15	1.0
	T9315	0.8	235	0.32	2.1	–	–	–	220	0.32	2.1	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.8	210	0.32	2.1	–	–	–	195	0.32	2.1	–	–	–	–	–	–	–	–	–
	T9335	0.8	185	0.32	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

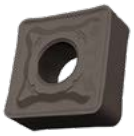
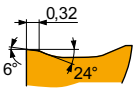
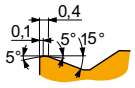
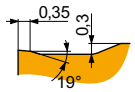
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
M断屑槽，适用于精加工至中粗加工，连续至断续切削。																				
SNMG 120412E-M	**T9315**	1.2	■ 230	0.40	2.1	–	–	–	◪ 215	0.40	2.1	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	1.2	■ 200	0.40	2.1	–	–	–	◪ 190	0.40	2.1	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 175	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120416E-M	**T9325**	1.6	■ 210	0.40	2.1	–	–	–	◪ 195	0.40	2.1	–	–	–	–	–	–	–	–	–
SNMG 150612E-M	**T9315**	1.2	■ 220	0.40	3.4	–	–	–	◪ 205	0.40	3.4	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	1.2	■ 195	0.40	3.4	–	–	–	◪ 185	0.40	3.4	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 170	0.40	3.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190612E-M	**T9315**	1.2	■ 215	0.40	4.0	–	–	–	◪ 200	0.40	4.0	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	1.2	■ 190	0.40	4.0	–	–	–	◪ 180	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 165	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-M	**T9315**	1.6	■ 225	0.40	4.0	–	–	–	◪ 210	0.40	4.0	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	1.6	■ 200	0.40	4.0	–	–	–	◪ 190	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	■ 175	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
NF断屑槽，具有大正前角设计，适用于超精加工至中度加工，连续切削。																				
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	–	–	–
	T7325	0.4	◪ 210	0.18	1.7	■ 160	0.16	1.7	–	–	–	–	–	–	◪ 65	0.16	1.4	–	–	–
	T7335	0.4	◪ 205	0.18	1.7	■ 155	0.16	1.7	–	–	–	–	–	–	◪ 65	0.16	1.4	–	–	–
	T8330	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	–	–	–
	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	–	–	–
	T9315	0.4	■ 300	0.17	1.7	–	–	–	◪ 285	0.17	1.7	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–
	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	–	–	–
	T7325	0.8	◪ 245	0.19	1.7	■ 190	0.17	1.7	–	–	–	–	–	–	◪ 75	0.15	1.4	–	–	–
	T7335	0.8	◪ 240	0.19	1.7	■ 185	0.17	1.7	–	–	–	–	–	–	◪ 75	0.15	1.4	–	–	–
	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	–	–	–
	T8330	0.8	■ 210	0.19	1.7	■ 125	0.17	1.7	◪ 195	0.19	1.7	◪ 630	0.23	1.7	◪ 50	0.15	1.4	–	–	–
	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	–	–	–
	T9315	0.8	■ 340	0.19	1.7	–	–	–	◪ 320	0.19	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 300	0.19	1.7	■ 180	0.17	1.7	◪ 285	0.19	1.7	–	–	–	◪ 65	0.15	1.4	–	–	–
																				
NM断屑槽，具有大正前角设计，适用于连续切削中进行精细，中度和粗加工。																				
SNMG 120408E-NM	**T7325**	0.8	◪ 225	0.25	2.1	■ 175	0.23	2.1	–	–	–	–	–	–	■ 70	0.20	1.7	–	–	–
	T7335	0.8	◪ 220	0.25	2.1	■ 170	0.23	2.1	–	–	–	–	–	–	■ 70	0.20	1.7	–	–	–
	T8315	0.8	◪ 215	0.25	2.1	■ 125	0.23	2.1	–	–	–	◪ 645	0.30	2.1	◪ 50	0.20	1.7	–	–	–
	T8330	0.8	■ 205	0.25	2.1	■ 120	0.23	2.1	–	–	–	◪ 615	0.30	2.1	◪ 50	0.20	1.7	–	–	–
	T8430	0.8	■ 225	0.25	2.1	■ 120	0.23	2.1	–	–	–	◪ 615	0.30	2.1	◪ 45	0.20	1.7	–	–	–
	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	–	–	–
	T7335	1.2	◪ 220	0.30	2.1	■ 170	0.27	2.1	–	–	–	–	–	–	■ 70	0.24	1.7	–	–	–
	T8315	1.2	◪ 215	0.30	2.1	■ 125	0.27	2.1	–	–	–	◪ 645	0.36	2.1	◪ 50	0.24	1.7	–	–	–
	T9325	1.2	■ 270	0.30	2.1	■ 160	0.27	2.1	–	–	–	–	–	–	◪ 60	0.24	1.7	–	–	–

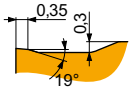
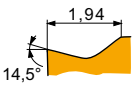
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
NMR断屑槽，具有正前角设计，适用于中度至粗加工，连续切削。																				
SNMG 120408E-NMR	T6310	0.8	■	155	0.35	2.6	■	110	0.32	2.6	–	–	–	–	–	–	■	45	0.25	2.1	–	–	–
	T7325	0.8	◪	175	0.35	2.6	■	135	0.32	2.6	–	–	–	–	–	–	■	55	0.25	2.1	–	–	–
	T7335	0.8	◪	165	0.35	2.6	■	125	0.32	2.6	–	–	–	–	–	–	■	50	0.25	2.1	–	–	–
	T8330	0.8	■	155	0.35	2.6	■	90	0.32	2.6	–	–	–	–	–	–	◪	35	0.25	2.1	–	–	–
	T8430	0.8	■	165	0.35	2.6	■	90	0.32	2.6	–	–	–	–	–	–	◪	35	0.25	2.1	–	–	–
	T9315	0.8	■	225	0.35	2.6		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
	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	–	–	–
	T7325	1.2	◪	175	0.40	2.6	■	135	0.36	2.6	–	–	–	–	–	–	■	55	0.28	2.1	–	–	–
	T7335	1.2	◪	165	0.40	2.6	■	125	0.36	2.6	–	–	–	–	–	–	■	50	0.28	2.1	–	–	–
	T9315	1.2	■	225	0.40	2.6		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
	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	–	–	–
	T7335	1.6	◪	170	0.45	2.6	■	130	0.41	2.6	–	–	–	–	–	–	■	55	0.32	2.1	–	–	–
	T9325	1.6	■	200	0.45	2.6	■	120	0.41	2.6	–	–	–	–	–	–	◪	45	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	–	–	–
	T7325	1.2	◪	170	0.40	3.8	■	130	0.36	3.8	–	–	–	–	–	–	■	55	0.28	3.0	–	–	–
	T9315	1.2	■	215	0.40	3.8		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
	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	–	–	–
	T7325	1.2	◪	165	0.40	5.2	■	125	0.36	5.2	–	–	–	–	–	–	■	50	0.28	4.2	–	–	–
	T7335	1.2	◪	155	0.40	5.2	■	120	0.36	5.2	–	–	–	–	–	–	■	50	0.28	4.2	–	–	–
	T9315	1.2	■	210	0.40	5.2		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
	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	–	–	–
	T7325	1.6	◪	170	0.45	5.2	■	130	0.41	5.2	–	–	–	–	–	–	■	55	0.32	4.2	–	–	–
	T7335	1.6	◪	155	0.45	5.2	■	120	0.41	5.2	–	–	–	–	–	–	■	50	0.32	4.2	–	–	–
	T9315	1.6	■	205	0.45	5.2		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
	T9325	1.6	■	185	0.45	5.2	■	110	0.41	5.2	–	–	–	–	–	–	◪	40	0.32	4.2	–	–	–
																				
NRM断屑槽，具有正前角设计，适用于中粗加工至粗加工，连续至中等间断切削。																				
SNMG 120408-NRM	T7325	0.8	◪	175	0.35	2.6	■	135	0.32	2.6	–	–	–	–	–	–	■	55	0.28	2.1	–	–	–
	T7335	0.8	◪	165	0.35	2.6	■	125	0.32	2.6	–	–	–	–	–	–	■	50	0.28	2.1	–	–	–
	T9315	0.8	■	225	0.35	2.6		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 120412-NRM	T7325	1.2	◪	175	0.40	3.0	■	135	0.36	3.0	–	–	–	–	–	–	■	55	0.28	2.4	–	–	–
	T7335	1.2	◪	165	0.40	3.0	■	125	0.36	3.0	–	–	–	–	–	–	■	50	0.28	2.4	–	–	–
	T9315	1.2	■	220	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	–	–	–
	T7335	1.2	◪	160	0.40	4.0	■	120	0.36	4.0	–	–	–	–	–	–	■	50	0.32	3.2	–	–	–
	T9315	1.2	■	215	0.40	4.0		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 150616-NRM	T7325	1.6	◪	170	0.45	5.0	■	130	0.41	5.0	–	–	–	–	–	–	■	55	0.36	4.0	–	–	–
	T7335	1.6	◪	155	0.45	5.0	■	120	0.41	5.0	–	–	–	–	–	–	■	50	0.36	4.0	–	–	–
	T9315	1.6	■	205	0.45	5.0		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 190612-NRM	T7325	1.2	◪	165	0.40	5.2	■	125	0.36	5.2	–	–	–	–	–	–	■	50	0.32	4.2	–	–	–
	T7335	1.2	◪	155	0.40	5.2	■	120	0.36	5.2	–	–	–	–	–	–	■	50	0.32	4.2	–	–	–
	T9315	1.2	■	210	0.40	5.2		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 190616-NRM	T7325	1.6	◪	170	0.45	5.2	■	130	0.41	5.2	–	–	–	–	–	–	■	55	0.36	4.2	–	–	–
	T7335	1.6	◪	155	0.45	5.2	■	120	0.41	5.2	–	–	–	–	–	–	■	50	0.36	4.2	–	–	–
	T9315	1.6	■	205	0.45	5.2		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 250724-NRM	T7325	2.4	◪	105	0.65	9.0	■	80	0.59	9.0	–	–	–	–	–	–	■	30	0.46	7.2	–	–	–
	T7335	2.4	◪	100	0.65	9.0	■	75	0.59	9.0	–	–	–	–	–	–	■	30	0.46	7.2	–	–	–
	T9315	2.4	■	120	0.65	9.0		–	–	–	◪	110	0.65	9.0	–	–	–	–	–	–	–	–	–

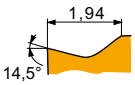
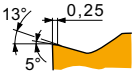
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
NRM断屑槽，具有正前角设计，适用于中粗加工至粗加工，连续至中等间断切削。																				
SNMG 250924-NRM	**T7325**	2.4	105	0.70	9.0	80	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
	T7335	2.4	95	0.70	9.0	70	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
	T9315	2.4	120	0.70	9.0	–	–	–	110	0.70	9.0	–	–	–	–	–	–	–	–	–
																				
R断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SNMG 120408E-R	**6640**	0.8	145	0.40	3.8	–	–	–	135	0.40	3.8	–	–	–	–	–	–	–	–	–
	T5305	0.8	250	0.40	3.8	–	–	–	235	0.40	3.8	–	–	–	–	–	–	50	0.15	1.0
	T9315	0.8	200	0.40	3.8	–	–	–	190	0.40	3.8	–	–	–	–	–	–	40	0.15	1.0
	T9325	0.8	180	0.40	3.8	–	–	–	170	0.40	3.8	–	–	–	–	–	–	–	–	–
	T9335	0.8	155	0.40	3.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120412E-R	**T5305**	1.2	255	0.45	3.8	–	–	–	240	0.45	3.8	–	–	–	–	–	–	50	0.15	1.0
	T9310	1.2	220	0.45	3.8	–	–	–	205	0.45	3.8	–	–	–	–	–	–	40	0.15	1.0
	T9325	1.2	180	0.45	3.8	–	–	–	170	0.45	3.8	–	–	–	–	–	–	–	–	–
	T9335	1.2	160	0.45	3.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120416E-R	**T9315**	1.6	205	0.50	3.8	–	–	–	190	0.50	3.8	–	–	–	–	–	–	40	0.15	1.0
	T9325	1.6	185	0.50	3.8	–	–	–	175	0.50	3.8	–	–	–	–	–	–	–	–	–
SNMG 150612E-R	**T5305**	1.2	250	0.45	4.5	–	–	–	235	0.45	4.5	–	–	–	–	–	–	50	0.15	1.0
	T5315	1.2	230	0.45	4.5	–	–	–	215	0.45	4.5	–	–	–	–	–	–	45	0.15	1.0
	T9315	1.2	200	0.45	4.5	–	–	–	190	0.45	4.5	–	–	–	–	–	–	40	0.15	1.0
	T9325	1.2	180	0.45	4.5	–	–	–	170	0.45	4.5	–	–	–	–	–	–	–	–	–
SNMG 150616E-R	**T5315**	1.6	230	0.50	4.5	–	–	–	215	0.50	4.5	–	–	–	–	–	–	45	0.15	1.0
	T9325	1.6	180	0.50	4.5	–	–	–	170	0.50	4.5	–	–	–	–	–	–	–	–	–
SNMG 190612E-R	**6640**	1.2	140	0.45	6.0	–	–	–	130	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9310	1.2	210	0.45	6.0	–	–	–	195	0.45	6.0	–	–	–	–	–	–	40	0.15	1.0
	T9315	1.2	195	0.45	6.0	–	–	–	185	0.45	6.0	–	–	–	–	–	–	35	0.15	1.0
	T9325	1.2	175	0.45	6.0	–	–	–	165	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R	**T9310**	1.6	205	0.50	6.0	–	–	–	190	0.50	6.0	–	–	–	–	–	–	40	0.15	1.0
	T9315	1.6	195	0.50	6.0	–	–	–	185	0.50	6.0	–	–	–	–	–	–	35	0.15	1.0
	T9325	1.6	175	0.50	6.0	–	–	–	165	0.50	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	150	0.50	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SNMG 120408E-RM	**T5305**	0.8	290	0.40	4.0	–	–	–	275	0.40	4.0	–	–	–	–	–	–	–	–	–
	T5315	0.8	260	0.40	4.0	–	–	–	245	0.40	4.0	–	–	–	–	–	–	–	–	–
	T6310	0.8	165	0.40	4.0	115	0.36	4.0	130	0.40	4.0	–	–	–	–	–	–	–	–	–
	T7325	0.8	185	0.40	4.0	140	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	175	0.40	4.0	135	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	175	0.40	4.0	105	0.36	4.0	165	0.40	4.0	–	–	–	–	–	–	–	–	–
	T8330	0.8	165	0.40	4.0	95	0.36	4.0	155	0.40	4.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	175	0.40	4.0	95	0.36	4.0	140	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9310	0.8	250	0.40	4.0	–	–	–	235	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	235	0.40	4.0	–	–	–	220	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	210	0.40	4.0	125	0.36	4.0	195	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	180	0.40	4.0	105	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–

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

产品型号		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)
																				
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SNMG 120412E-RM	**T5305**	1.2	◪ 295	0.45	4.0	–	–	–	◪ 280	0.45	4.0	–	–	–	–	–	–	–	–	–
	T5315	1.2	◪ 265	0.45	4.0	–	–	–	◪ 250	0.45	4.0	–	–	–	–	–	–	–	–	–
	T6310	1.2	■ 165	0.45	4.0	◪ 115	0.41	4.0	◪ 130	0.45	4.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	◪ 190	0.45	4.0	◪ 145	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	◪ 180	0.45	4.0	◪ 140	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	1.2	■ 250	0.45	4.0	–	–	–	◪ 235	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 235	0.45	4.0	–	–	–	◪ 220	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 210	0.45	4.0	◪ 125	0.41	4.0	◪ 195	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 185	0.45	4.0	◪ 110	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120416E-RM	**T5315**	1.6	◪ 270	0.50	4.0	–	–	–	◪ 255	0.50	4.0	–	–	–	–	–	–	–	–	–
	T7335	1.6	◪ 180	0.50	4.0	◪ 140	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	1.6	■ 170	0.50	4.0	◪ 100	0.45	4.0	◪ 160	0.50	4.0	–	–	–	–	–	–	–	–	–
	T8430	1.6	■ 175	0.50	4.0	◪ 95	0.45	4.0	◪ 140	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9315	1.6	■ 230	0.50	4.0	–	–	–	◪ 215	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	■ 215	0.50	4.0	◪ 125	0.45	4.0	◪ 200	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	■ 180	0.50	4.0	◪ 105	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 150612E-RM	**T5315**	1.2	◪ 255	0.45	5.0	–	–	–	◪ 240	0.45	5.0	–	–	–	–	–	–	–	–	–
	T6310	1.2	■ 165	0.45	5.0	◪ 115	0.41	5.0	◪ 130	0.45	5.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	◪ 185	0.45	5.0	◪ 140	0.41	5.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	◪ 175	0.45	5.0	◪ 135	0.41	5.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	1.2	■ 245	0.45	5.0	–	–	–	◪ 230	0.45	5.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 225	0.45	5.0	–	–	–	◪ 210	0.45	5.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 205	0.45	5.0	◪ 120	0.41	5.0	◪ 190	0.45	5.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 180	0.45	5.0	◪ 105	0.41	5.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 150616E-RM	**T7335**	1.6	◪ 175	0.50	5.0	◪ 135	0.45	5.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	1.6	■ 230	0.50	5.0	–	–	–	◪ 215	0.50	5.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	■ 205	0.50	5.0	◪ 120	0.45	5.0	◪ 190	0.50	5.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	■ 180	0.50	5.0	◪ 105	0.45	5.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM	**T5305**	1.2	◪ 275	0.45	7.0	–	–	–	◪ 260	0.45	7.0	–	–	–	–	–	–	–	–	–
	T5315	1.2	◪ 250	0.45	7.0	–	–	–	◪ 235	0.45	7.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	◪ 180	0.45	7.0	◪ 140	0.41	7.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	◪ 165	0.45	7.0	◪ 125	0.41	7.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	1.2	■ 240	0.45	7.0	–	–	–	◪ 225	0.45	7.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 220	0.45	7.0	–	–	–	◪ 205	0.45	7.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 195	0.45	7.0	◪ 115	0.41	7.0	◪ 185	0.45	7.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 175	0.45	7.0	◪ 105	0.41	7.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-RM	**T5305**	1.6	◪ 285	0.50	7.0	–	–	–	◪ 270	0.50	7.0	–	–	–	–	–	–	–	–	–
	T5315	1.6	◪ 250	0.50	7.0	–	–	–	◪ 235	0.50	7.0	–	–	–	–	–	–	–	–	–
	T6310	1.6	■ 160	0.50	7.0	◪ 115	0.45	7.0	◪ 125	0.50	7.0	–	–	–	–	–	–	–	–	–
	T7335	1.6	◪ 170	0.50	7.0	◪ 130	0.45	7.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	1.6	■ 240	0.50	7.0	–	–	–	◪ 225	0.50	7.0	–	–	–	–	–	–	–	–	–
	T9315	1.6	■ 220	0.50	7.0	–	–	–	◪ 205	0.50	7.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	■ 200	0.50	7.0	◪ 120	0.45	7.0	◪ 190	0.50	7.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	■ 175	0.50	7.0	◪ 105	0.45	7.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 250924E-RM	**T7325**	2.4	◪ 110	0.80	12.0	◪ 85	0.72	12.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	2.4	◪ 105	0.80	12.0	◪ 80	0.72	12.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9226	2.4	■ 95	0.80	12.0	◪ 55	0.72	12.0	◪ 90	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	■ 125	0.80	12.0	–	–	–	◪ 115	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	■ 110	0.80	12.0	◪ 65	0.72	12.0	◪ 100	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	■ 90	0.80	12.0	◪ 50	0.72	12.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
SF断屑槽，具有正前角设计，适用于薄壁，连续切削进行超精加工。																				
SNMG 120404E-SF	**T7325**	0.4	◪ 215	0.17	1.0	■ 165	0.15	1.0	–	–	–	–	–	–	■ 65	0.15	0.8	–	–	–
	T9325	0.4	■ 265	0.17	1.0	■ 155	0.15	1.0	◪ 250	0.17	1.0	–	–	–	◪ 55	0.15	0.8	–	–	–

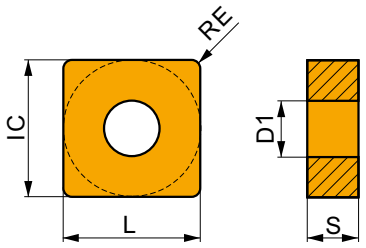
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		
																				
SF断屑槽，具有正前角设计，适用于薄壁，连续切削进行超精加工。																				
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	–	–	–
	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	0.15	1.0
	T7325	0.8	245	0.20	1.0	190	0.18	1.0	–	–	–	–	–	–	75	0.16	0.8	–	–	–
	T7335	0.8	235	0.20	1.0	180	0.18	1.0	–	–	–	–	–	–	75	0.16	0.8	–	–	–
	T8315	0.8	225	0.20	1.0	135	0.18	1.0	210	0.20	1.0	675	0.24	1.0	55	0.14	0.8	45	0.15	1.0
	T8330	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	0.15	1.0
	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	0.15	1.0
	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	0.15	1.0
	T7325	1.2	230	0.25	1.5	175	0.23	1.5	–	–	–	–	–	–	70	0.18	1.2	–	–	–
	T8330	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	0.15	1.0
	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	0.15	1.0
																				
SM断屑槽，具有正前角设计，适用于中等加工，连续至断续切削。																				
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	0.15	1.0
	T7325	0.8	210	0.25	1.8	160	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
	T7335	0.8	205	0.25	1.8	155	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
	T8330	0.8	185	0.25	1.8	110	0.23	1.8	175	0.25	1.8	555	0.30	1.8	45	0.20	1.4	35	0.15	1.0
	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	0.15	1.0
	T9315	0.8	280	0.25	1.8	–	–	–	265	0.25	1.8	–	–	–	–	–	–	55	0.15	1.0
	T9325	0.8	255	0.25	1.8	150	0.23	1.8	240	0.25	1.8	–	–	–	55	0.20	1.4	–	–	–
SNMG 120412E-SM	**T7325**	1.2	210	0.30	1.8	160	0.27	1.8	–	–	–	–	–	–	65	0.24	1.4	–	–	–
	T7335	1.2	200	0.30	1.8	155	0.27	1.8	–	–	–	–	–	–	65	0.24	1.4	–	–	–
	T9315	1.2	275	0.30	1.8	–	–	–	260	0.30	1.8	–	–	–	–	–	–	55	0.15	1.0
	T9325	1.2	245	0.30	1.8	145	0.27	1.8	230	0.30	1.8	–	–	–	55	0.24	1.4	–	–	–
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
	T7325	1.2	195	0.30	4.0	150	0.27	4.0	–	–	–	–	–	–	60	0.27	3.2	–	–	–
	T7335	1.2	185	0.30	4.0	140	0.27	4.0	–	–	–	–	–	–	60	0.27	3.2	–	–	–
	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	**T7325**	1.6	190	0.40	4.0	145	0.36	4.0	–	–	–	–	–	–	60	0.32	3.2	–	–	–
	T7335	1.6	175	0.40	4.0	135	0.36	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
	T9325	1.6	210	0.40	4.0	125	0.36	4.0	195	0.40	4.0	–	–	–	45	0.32	3.2	–	–	–

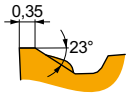
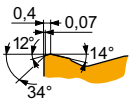
SNMM

PRAMET

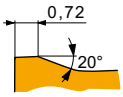
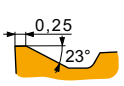
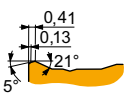
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.875	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.525



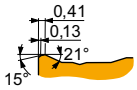
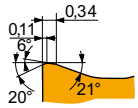
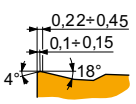
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
DR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SNMM 120412E-DR	**T9315**	1.2	245	0.45	4.7	–	–	–	230	0.45	4.7	–	–	–	–	–	–	–	–	–
	T9325	1.2	220	0.45	4.7	130	0.41	4.7	205	0.45	4.7	–	–	–	–	–	–	–	–	–
	T9335	1.2	185	0.45	4.7	110	0.41	4.7	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 150612E-DR	**T9325**	1.2	210	0.45	6.0	125	0.41	6.0	195	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	180	0.45	6.0	105	0.41	6.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190612E-DR	**6640**	1.2	170	0.45	6.0	100	0.41	6.0	160	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	210	0.45	6.0	125	0.41	6.0	195	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	180	0.45	6.0	105	0.41	6.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190616E-DR	**T9325**	1.6	210	0.50	6.0	125	0.45	6.0	195	0.50	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	185	0.50	6.0	110	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
HR断屑槽，适用于粗加工至重载粗加工，连续切削至间断切削。																				
SNMM 190616E-HR	**T8345**	1.6	60	0.60	9.0	35	0.54	9.0	55	0.60	9.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	110	0.60	9.0	65	0.54	9.0	100	0.60	9.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	85	0.60	9.0	50	0.54	9.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR	**T8345**	2.4	60	0.65	9.0	35	0.59	9.0	55	0.65	9.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	120	0.65	9.0	–	–	–	110	0.65	9.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	115	0.65	9.0	65	0.59	9.0	105	0.65	9.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	90	0.65	9.0	50	0.59	9.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR	**T8345**	1.6	60	0.60	13.0	35	0.54	13.0	55	0.60	13.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	100	0.60	13.0	60	0.54	13.0	95	0.60	13.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	85	0.60	13.0	50	0.54	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR	**6640**	2.4	80	0.65	13.0	45	0.59	13.0	75	0.65	13.0	–	–	–	–	–	–	–	–	–
	T8345	2.4	55	0.65	13.0	30	0.59	13.0	50	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	120	0.65	13.0	–	–	–	110	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	105	0.65	13.0	60	0.59	13.0	95	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	85	0.65	13.0	50	0.59	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	**T8345**	2.4	55	0.65	13.0	30	0.59	13.0	50	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	120	0.65	13.0	–	–	–	110	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	105	0.65	13.0	60	0.59	13.0	95	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	85	0.65	13.0	50	0.59	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250932E-HR	**T9325**	3.2	95	0.80	13.0	55	0.72	13.0	90	0.80	13.0	–	–	–	–	–	–	–	–	–

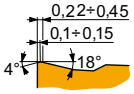
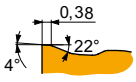
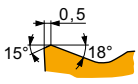
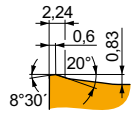
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
HR2断屑槽，适用于粗加工至重载粗加工，连续切削至间断切削。																				
SNMM 190616-HR2	T9315	1.6	115	0.65	8.9	–	–	–	105	0.65	8.9	–	–	–	–	–	–	–	–	–
	T9335	1.6	85	0.65	8.9	50	0.59	8.9	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624-HR2	T9315	2.4	105	0.85	8.9	–	–	–	95	0.85	8.9	–	–	–	–	–	–	–	–	–
	T9335	2.4	80	0.85	8.9	45	0.77	8.9	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250724-HR2	T9226	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	105	0.85	11.0	–	–	–	95	0.85	11.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250732-HR2	T9315	3.2	95	1.00	11.0	–	–	–	90	1.00	11.0	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2	T9226	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	105	0.85	11.0	–	–	–	95	0.85	11.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250932-HR2	T9315	3.2	95	1.00	11.0	–	–	–	90	1.00	11.0	–	–	–	–	–	–	–	–	–
	T9335	3.2	75	1.00	11.0	45	0.90	11.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
NR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SNMM 120408E-NR	T7325	0.8	185	0.40	3.0	140	0.36	3.0	–	–	–	–	–	–	60	0.28	2.4	–	–	–
	T7335	0.8	175	0.40	3.0	135	0.36	3.0	–	–	–	–	–	–	55	0.28	2.4	–	–	–
	T8330	0.8	160	0.40	3.0	95	0.36	3.0	150	0.40	3.0	–	–	–	40	0.28	2.4	–	–	–
	T8430	0.8	170	0.40	3.0	90	0.36	3.0	135	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
	T9325	0.8	205	0.40	3.0	120	0.36	3.0	190	0.40	3.0	–	–	–	45	0.28	2.4	–	–	–
																				
NR2断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SNMM 120408E-NR2	T7325	0.8	175	0.40	4.7	135	0.36	4.7	–	–	–	–	–	–	55	0.32	3.8	–	–	–
	T7335	0.8	170	0.40	4.7	130	0.36	4.7	–	–	–	–	–	–	55	0.32	3.8	–	–	–
	T8330	0.8	155	0.40	4.7	90	0.36	4.7	145	0.40	4.7	–	–	–	35	0.32	3.8	–	–	–
	T8430	0.8	165	0.40	4.7	90	0.36	4.7	135	0.40	4.7	–	–	–	35	0.32	3.8	–	–	–
	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	–	–	–
	T8330	1.2	160	0.45	4.7	95	0.41	4.7	150	0.45	4.7	–	–	–	40	0.36	3.8	–	–	–
	T8430	1.2	165	0.45	4.7	90	0.41	4.7	135	0.45	4.7	–	–	–	35	0.36	3.8	–	–	–
	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	T7325	1.2	170	0.45	6.0	130	0.41	6.0	–	–	–	–	–	–	55	0.36	4.8	–	–	–
	T7335	1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
	T8330	1.2	155	0.45	6.0	90	0.41	6.0	145	0.45	6.0	–	–	–	35	0.36	4.8	–	–	–
	T8430	1.2	165	0.45	6.0	90	0.41	6.0	135	0.45	6.0	–	–	–	35	0.36	4.8	–	–	–
	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	–	–	–
	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	–	–	–
	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	–	–	–
	T7335	1.6	160	0.50	8.0	120	0.45	8.0	–	–	–	–	–	–	50	0.40	6.4	–	–	–
	T8330	1.6	155	0.50	8.0	90	0.45	8.0	145	0.50	8.0	–	–	–	35	0.40	6.4	–	–	–
	T8430	1.6	155	0.50	8.0	85	0.45	8.0	130	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
	T9315	1.6	210	0.50	8.0	–	–	–	195	0.50	8.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190624E-NR2	T7325	2.4	155	0.80	8.0	120	0.72	8.0	–	–	–	–	–	–	50	0.56	6.4	–	–	–
	T7335	2.4	145	0.80	8.0	110	0.72	8.0	–	–	–	–	–	–	45	0.56	6.4	–	–	–
	T9325	2.4	165	0.80	8.0	95	0.72	8.0	155	0.80	8.0	–	–	–	35	0.56	6.4	–	–	–

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。

产品型号		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)
																				
NR2断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SNMM 250724E-NR2	**T7335**	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
	T8330	2.4	85	0.80	12.0	50	0.72	12.0	80	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
	T8430	2.4	85	0.80	12.0	45	0.72	12.0	70	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
	T9226	2.4	95	0.80	12.0	55	0.72	12.0	90	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
	T9315	2.4	120	0.80	12.0	–	–	–	110	0.80	12.0	–	–	–	–	–	–	–	–	–
	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	**T7325**	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
	T7335	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
	T9226	2.4	95	0.80	12.0	55	0.72	12.0	90	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
	T9315	2.4	120	0.80	12.0	–	–	–	110	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
																				
NRM断屑槽，具有正前角设计，适用于中粗加工至粗加工，连续至中等间断切削。																				
SNMM 250716-NRM	**T7325**	1.6	115	0.45	9.0	85	0.41	9.0	–	–	–	–	–	–	35	0.36	7.2	–	–	–
	T7335	1.6	110	0.45	9.0	85	0.41	9.0	–	–	–	–	–	–	35	0.36	7.2	–	–	–
	T9315	1.6	135	0.45	9.0	–	–	–	125	0.45	9.0	–	–	–	–	–	–	–	–	–
SNMM 250724-NRM	**T7325**	2.4	105	0.65	9.0	80	0.59	9.0	–	–	–	–	–	–	30	0.46	7.2	–	–	–
	T7335	2.4	100	0.65	9.0	75	0.59	9.0	–	–	–	–	–	–	30	0.46	7.2	–	–	–
	T9315	2.4	120	0.65	9.0	–	–	–	110	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	–	–	–
	T7335	2.4	95	0.70	9.0	70	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
	T9315	2.4	120	0.70	9.0	–	–	–	110	0.70	9.0	–	–	–	–	–	–	–	–	–
																				
OR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SNMM 120408E-OR	**T9315**	0.8	220	0.40	4.7	–	–	–	205	0.40	4.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	195	0.40	4.7	115	0.36	4.7	185	0.40	4.7	–	–	–	40	0.32	3.8	–	–	–
	T9335	0.8	175	0.40	4.7	105	0.36	4.7	–	–	–	–	–	–	35	0.32	3.8	–	–	–
SNMM 120412E-OR	**T9315**	1.2	225	0.45	4.7	–	–	–	210	0.45	4.7	–	–	–	–	–	–	–	–	–
	T9325	1.2	200	0.45	4.7	120	0.41	4.7	190	0.45	4.7	–	–	–	45	0.36	3.8	–	–	–
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	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.41	4.8	–	–	–
	T9335	0.8	170	0.40	6.0	100	0.36	6.0	–	–	–	–	–	–	35	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	–	–	–
	T9335	1.2	165	0.45	6.0	95	0.41	6.0	–	–	–	–	–	–	35	0.36	4.8	–	–	–
SNMM 150616E-OR	**T9315**	1.6	215	0.50	6.0	–	–	–	200	0.50	6.0	–	–	–	–	–	–	–	–	–
	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-OR	**T8330**	1.2	150	0.45	8.0	90	0.41	8.0	140	0.45	8.0	–	–	–	35	0.36	6.4	–	–	–
	T8430	1.2	150	0.45	8.0	80	0.41	8.0	125	0.45	8.0	–	–	–	30	0.36	6.4	–	–	–
	T9315	1.2	210	0.45	8.0	–	–	–	195	0.45	8.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	190	0.45	8.0	110	0.41	8.0	180	0.45	8.0	–	–	–	40	0.36	6.4	–	–	–
	T9335	1.2	165	0.45	8.0	95	0.41	8.0	–	–	–	–	–	–	35	0.36	6.4	–	–	–
SNMM 190616E-OR	**T8330**	1.6	155	0.50	8.0	90	0.45	8.0	145	0.50	8.0	–	–	–	35	0.40	6.4	–	–	–
	T8345	1.6	125	0.50	8.0	75	0.45	8.0	115	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
	T8430	1.6	155	0.50	8.0	85	0.45	8.0	130	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
	T9315	1.6	210	0.50	8.0	–	–	–	195	0.50	8.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
	T9335	1.6	160	0.50	8.0	95	0.45	8.0	–	–	–	–	–	–	35	0.40	6.4	–	–	–
SNMM 190624E-OR	**T9315**	2.4	180	0.80	8.0	–	–	–	170	0.80	8.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	165	0.80	8.0	95	0.72	8.0	155	0.80	8.0	–	–	–	35	0.56	6.4	–	–	–
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	–	–	–
	T9325	1.6	120	0.55	12.0	70	0.50	12.0	110	0.55	12.0	–	–	–	25	0.50	9.6	–	–	–

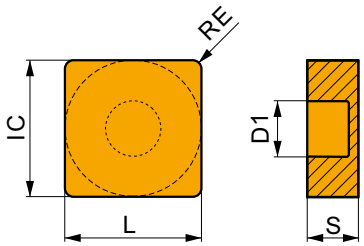
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
			P																	
OR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
SNMM 250724E-OR	**T8330**	2.4	80	1.00	12.0	45	0.90	12.0	75	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
	T8345	2.4	55	1.00	12.0	30	0.90	12.0	50	1.00	12.0	–	–	–	10	0.70	9.6	–	–	–
	T8430	2.4	80	1.00	12.0	45	0.90	12.0	65	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
	T9315	2.4	105	1.00	12.0	–	–	–	95	1.00	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	100	1.00	12.0	60	0.90	12.0	95	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
	T9335	2.4	80	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
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	–	–	–
	T9226	2.4	85	1.00	12.0	50	0.90	12.0	80	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
	T9315	2.4	105	1.00	12.0	–	–	–	95	1.00	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	100	1.00	12.0	60	0.90	12.0	95	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
	T9335	2.4	80	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
			S																	
OR1断屑槽，适用于中粗加工至重载粗加工，连续至断续切削。																				
SNMM 190616E-OR1	**T9325**	1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.35	6.4	–	–	–
	T9335	1.6	160	0.50	8.0	95	0.45	8.0	–	–	–	–	–	–	35	0.35	6.4	–	–	–
			P																	
SR断屑槽，适用于粗加工至重载粗加工，连续至断续切削。																				
SNMM 250724S-SR	**6640**	2.4	60	1.00	12.0	35	0.90	12.0	55	1.00	12.0	–	–	–	–	–	–	–	–	–
	T9226	2.4	70	1.00	12.0	40	0.90	12.0	65	1.00	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	80	1.00	12.0	45	0.90	12.0	75	1.00	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924S-SR	**T9335**	2.4	65	1.00	14.0	35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–
			S																	
断屑槽923，适用于中粗加工至重载粗加工，连续至重断续切削。																				
SNMM 190616S-923	**T8330**	1.6	125	0.65	8.9	75	0.59	8.9	115	0.65	8.9	–	–	–	30	0.52	7.1	–	–	–
	T8345	1.6	100	0.65	8.9	60	0.59	8.9	95	0.65	8.9	–	–	–	25	0.52	7.1	–	–	–
	T8430	1.6	125	0.65	8.9	65	0.59	8.9	100	0.65	8.9	–	–	–	25	0.52	7.1	–	–	–
	T9335	1.6	130	0.65	8.9	75	0.59	8.9	–	–	–	–	–	–	25	0.52	7.1	–	–	–
SNMM 250724S-923	**T8330**	2.4	80	0.85	11.0	45	0.77	11.0	75	0.85	11.0	–	–	–	20	0.60	8.8	–	–	–
	T8430	2.4	80	0.85	11.0	45	0.77	11.0	65	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
	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	–	–	–
	T8430	2.4	80	0.85	11.0	45	0.77	11.0	65	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
	T9226	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
	T9315	2.4	105	0.85	11.0	–	–	–	95	0.85	11.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	15	0.60	8.8	–	–	–
SNMM 250932S-923	**T9226**	3.2	80	1.00	11.0	45	0.90	11.0	75	1.00	11.0	–	–	–	15	0.70	8.8	–	–	–

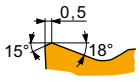
SNMX

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2512	25.400	9.17	25.40	12.00



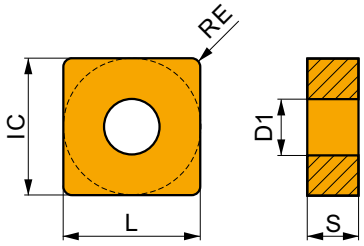
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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断屑槽，适用于粗加工至重载粗加工，连续至断续切削。																	
SNMX 251224S-SR	T8345	2.4	45	1.00	14.0	25	0.90	14.0	40	1.00	14.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	80	1.00	14.0	45	0.90	14.0	75	1.00	14.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	65	1.00	14.0	35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–

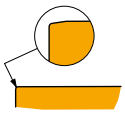
SNGA CER

PRAMET

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



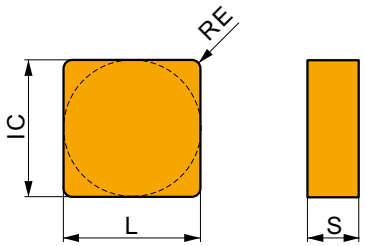
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			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	–	–	–	–	–	–	–	–	–

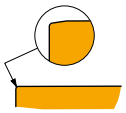
SNGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
0903	9.525	9.525	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。

产品型号		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															
			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	–	–	–	–	–	–	–	–	–

DSBN(RL) EXT

P M K N S H

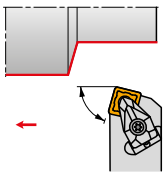
PRAMET

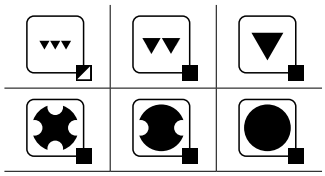
D

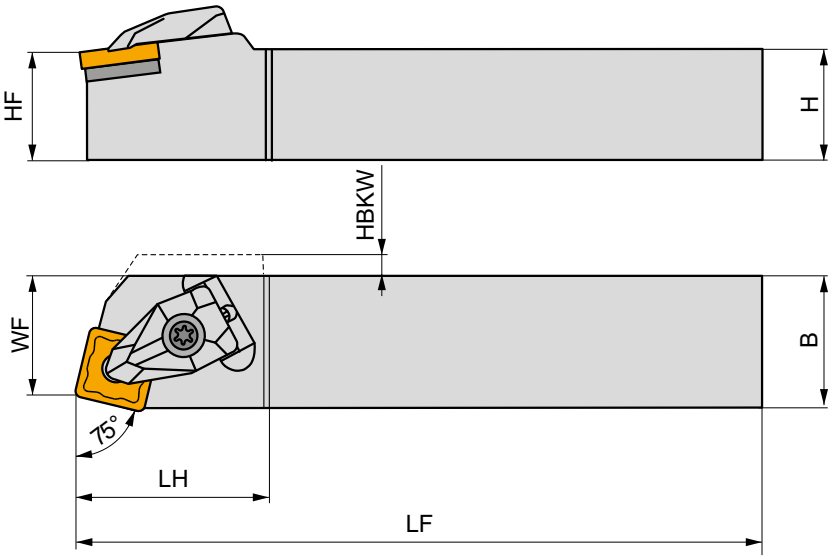


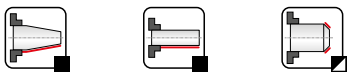
外圆用双重夹紧车刀杆，使用SN..刀片，主偏角为75°。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	HBKW (mm)	LAMS (°)	GAMO (°)	kg			
R	DSBNR 2020 K 12	20	20	20	17	125	34.2	2.5	-6	-6	0.43	GI029	DS12	AT003
	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	3.18	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	1.16	GI082	DS15	AT006
	DSBNL 3232 P 19	32	32	32	27	170	46.4	–	-6	-6	1.38	GI026	DS19	–
	DSBNL 4040 S 19	40	40	40	35	250	46.5	–	-6	-6	3.18	GI026	DS19	–

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

		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

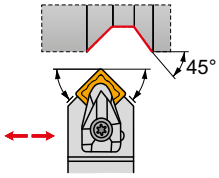
PRAMET

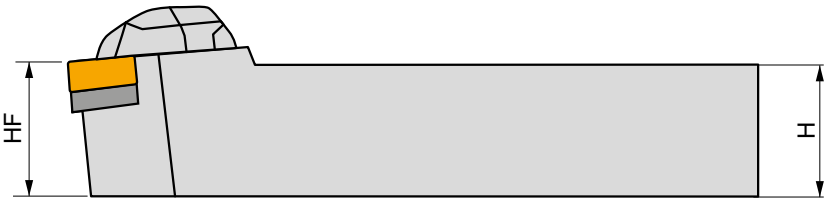
D

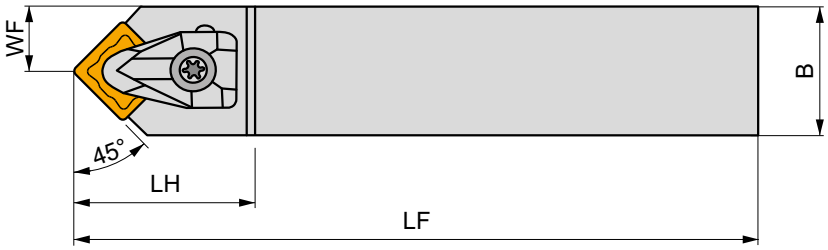


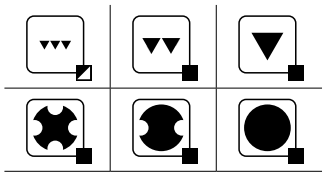
外圆用双重夹紧车刀杆，使用SN..刀片，主偏角为45°。

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。











	产品型号	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	1.36	GI026	DS19	–
	DSDNN 4040 S 25	40	40	40	21	250	57.2	-6	-6	3.13	GI027	DS25	–

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

		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

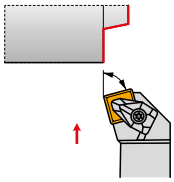
PRAMET

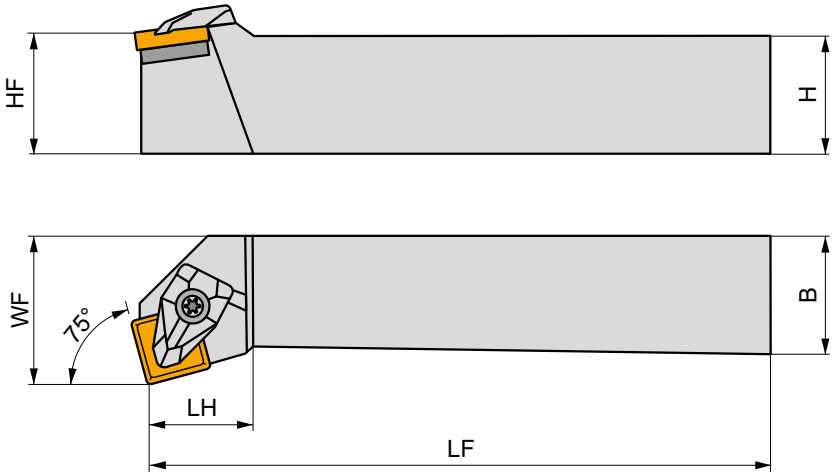
D

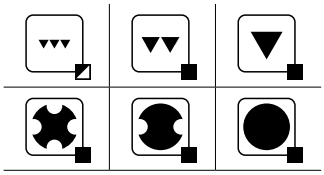


外圆用双重夹紧车刀杆，使用SN..刀片，主偏角为75°（端面）。

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。









	产品型号	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	0.79	GI029	DS12	AT003
	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
	DSKNL 3232 P 19	32	32	32	40	170	32.1	-6	-6	1.46	GI026	DS19	–

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

		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

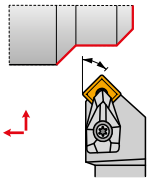
PRAMET

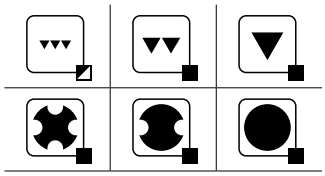
D

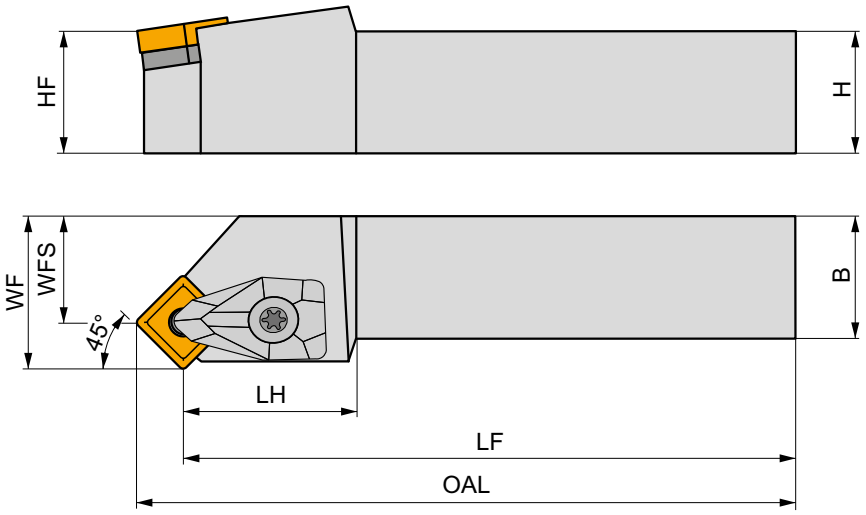


外圆用双重夹紧车刀杆，使用SN..刀片，主偏角为45°。

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。









	产品型号	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	-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	-8	1.48	GI026	DS19	–
	DSSNR 4040 S 19	40	40	40	50	37.5	250	262.5	37.7	0	-8	3.27	GI026	DS19	–
L	**DSSNL 2020 K 12**	20	20	20	25	16.7	125	133.3	27.5	0	-8	0.45	GI029	DS12	AT003
	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	-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	-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	–

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

		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

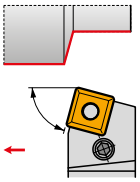
PRAMET

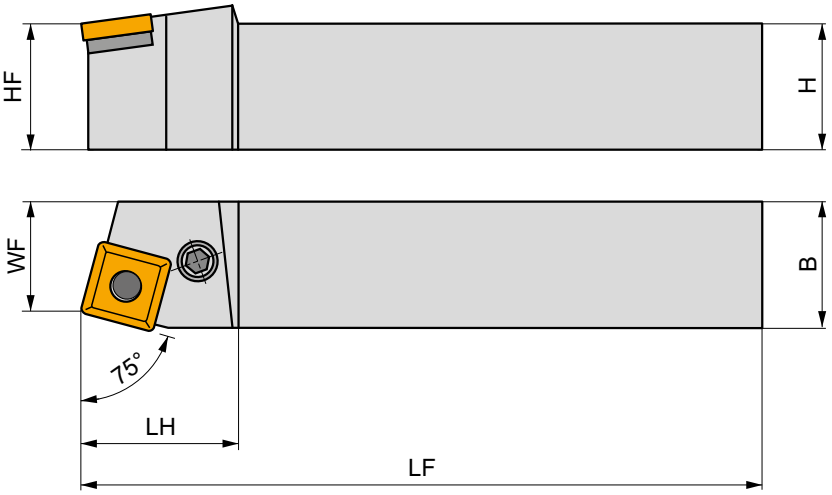
P

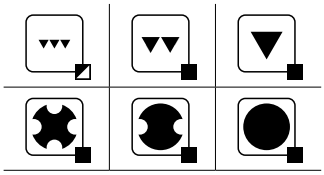


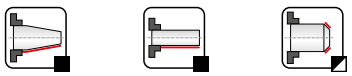
外圆用杠杆夹紧式车刀杆，使用SN..刀片，主偏角为75°。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PSBNR 2020 K 12	20	20	20	17	125	36	-6	-6	0.43	GI029	PS22
	PSBNR 2525 M 12	25	25	25	22	150	36	-6	-6	0.75	GI029	PS20
	PSBNR 3225 P 15	32	25	32	22	170	40	-6	-6	1.05	GI082	PS40
	PSBNR 3232 P 19	32	32	32	27	170	45	-6	-6	1.30	GI026	PS50
	PSBNR 4040 R 19	40	40	40	35	200	45	-6	-6	2.40	GI026	PS50
	PSBNR 4040 S 19	40	40	40	35	250	45	-6	-6	3.12	GI026	PS50
	PSBNR 4040 R 25	40	40	40	35	200	45	-6	-6	2.45	GI027	PS60
	PSBNR 4040 S 25	40	40	40	35	250	50	-6	-6	2.85	GI027	PS60
	PSBNR 4040 S 2509	40	40	40	35	250	50	-6	-6	2.50	GI040	PS70
	PSBNR 4040 S 2512-A	40	40	40	35	250	50	-6	-6	3.08	GI162	PS72
	PSBNR 5050 S 25	50	50	50	43	250	50	-6	-6	4.70	GI027	PS60
	PSBNR 5050 T 25	50	50	50	43	300	50	-6	-6	5.83	GI027	PS60
	PSBNR 5050 T 2509	50	50	50	43	300	50	-6	-6	5.50	GI040	PS70
	PSBNR 5050 T 2512-A	50	50	50	43	300	50	-6	-6	5.83	GI162	PS72
L	PSBNL 2020 K 12	20	20	20	17	125	36	-6	-6	0.42	GI029	PS22
	PSBNL 2525 M 12	25	25	25	22	150	36	-6	-6	0.75	GI029	PS20
	PSBNL 3225 P 15	32	25	32	22	170	40	-6	-6	1.05	GI082	PS40
	PSBNL 3232 P 19	32	32	32	27	170	45	-6	-6	1.36	GI026	PS50
	PSBNL 4040 R 19	40	40	40	35	200	45	-6	-6	2.50	GI026	PS50
	PSBNL 4040 S 19	40	40	40	35	250	45	-6	-6	3.13	GI026	PS50
	PSBNL 4040 R 25	40	40	40	35	200	45	-6	-6	2.45	GI027	PS60
	PSBNL 4040 S 25	40	40	40	35	250	50	-6	-6	3.10	GI027	PS60
	PSBNL 4040 S 2509	40	40	40	35	250	50	-6	-6	2.50	GI040	PS70
	PSBNL 4040 S 2512-A	40	40	40	35	250	50	-6	-6	3.11	GI162	PS72
	PSBNL 5050 S 25	50	50	50	43	250	50	-6	-6	4.70	GI027	PS60
	PSBNL 5050 T 25	50	50	50	43	300	50	-6	-6	5.84	GI027	PS60
	PSBNL 5050 T 2509	50	50	50	43	300	50	-6	-6	5.80	GI040	PS70

	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
L	**PSBNL 5050 T 2512-A**	50	50	50	43	300	50	-6	-6	5.82	GI162	PS72

GI026	SN.. 1906..
GI027	SN.. 2507..
GI029	SN.. 1204..
GI040	SN.. 2509..
GI082	SN.. 1506..
GI162	SN.. 2512..

				Nm					
PS20	SNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PS22	SNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXK 4
PS40	SNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4
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
PS72	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

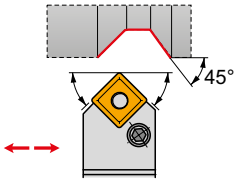
PRAMET

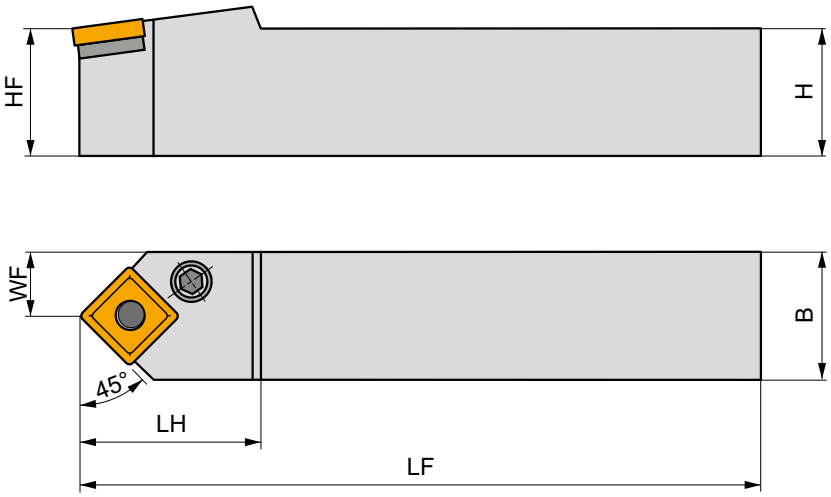
P

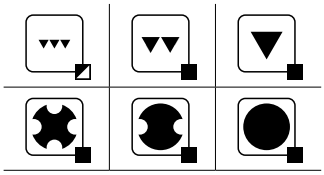


外圆用杠杆夹紧式车刀杆，使用SN..刀片，主偏角为45°。

外圆用中立杠杆夹紧式车刀杆，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。









	产品型号	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	36	-6	-6	0.42	GI029	PS22
	PSDNN 2525 M 12	25	25	25	12.5	150	36	-6	-6	0.68	GI029	PS20
	PSDNN 3232 P 15	32	32	32	16	170	40	-6	-6	1.32	GI082	PS40
	PSDNN 3232 P 19	32	32	32	16	170	45	-6	-6	1.25	GI026	PS50
	PSDNN 4040 S 19	40	40	40	20	250	45	-6	-6	3.05	GI026	PS50
	PSDNN 4040 S 25	40	40	40	20	250	50	-6	-6	3.02	GI027	PS60
	PSDNN 5050 T 25	50	50	50	25	300	50	-6	-6	5.65	GI027	PS60

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

				Nm					
PS20	SNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PS22	SNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXK 4
PS40	SNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4
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

PSKN(RL) EXT

P M K N S H

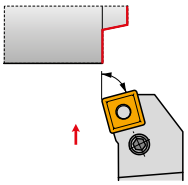
PRAMET

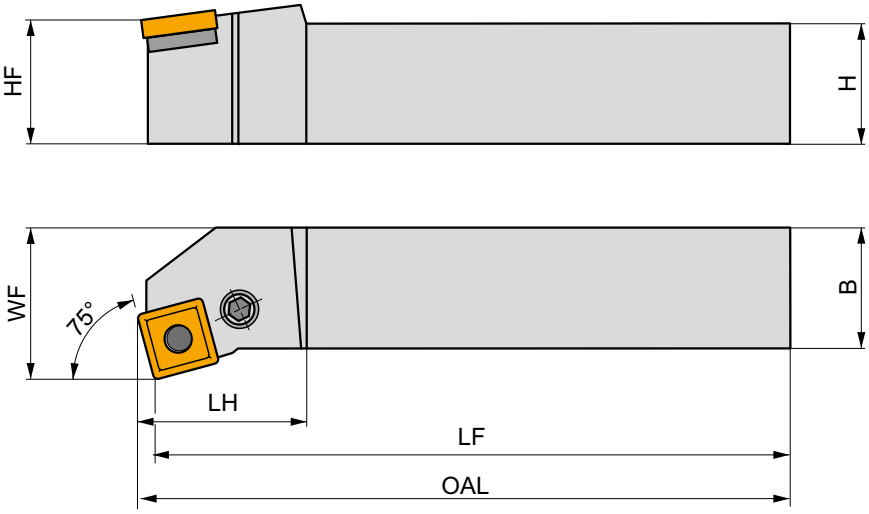
P

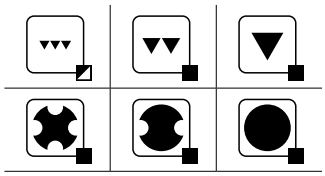


外圆用杠杆锁车削刀杆，使用SN..刀片，主偏角为75°（端面车削）。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	OAL (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PSKNR 2020 K 12**	20	20	20	25	125	128.1	36	-6	-6	0.43	GI029	PS22
	PSKNR 2525 M 12	25	25	25	32	150	153.1	36	-6	-6	0.79	GI029	PS20
	PSKNR 3225 P 15	32	25	32	32	170	173.9	40	-6	-6	0.40	GI082	PS40
	PSKNR 3232 P 19	32	32	32	40	170	174.6	45	-6	-6	1.40	GI026	PS50
	PSKNR 4040 S 19	40	40	40	50	250	254.6	45	-6	-6	3.25	GI026	PS50
	PSKNR 4040 S 25	40	40	40	50	250	256.5	50	-6	-6	3.40	GI027	PS60
	PSKNR 5050 T 25	50	50	50	60	300	306.5	50	-6	-6	6.05	GI027	PS60
	PSKNR 5050 T 2509	50	50	50	60	300	306.5	50	-6	-6	6.20	GI040	PS70
L	**PSKNL 2020 K 12**	20	20	20	25	125	128.1	36	-6	-6	0.43	GI029	PS22
	PSKNL 2525 M 12	25	25	25	32	150	153.1	36	-6	-6	0.79	GI029	PS20
	PSKNL 3225 P 15	32	25	32	32	170	173.9	40	-6	-6	1.05	GI082	PS40
	PSKNL 3232 P 19	32	32	32	40	170	174.6	45	-6	-6	1.40	GI026	PS50
	PSKNL 4040 S 19	40	40	40	50	250	254.6	45	-6	-6	3.26	GI026	PS50
	PSKNL 4040 S 25	40	40	40	50	250	256.5	50	-6	-6	3.40	GI027	PS60
	PSKNL 5050 T 25	50	50	50	60	300	306.5	50	-6	-6	6.00	GI027	PS60
	PSKNL 5050 T 2509	50	50	50	60	300	306.5	50	-6	-6	6.20	GI040	PS70

GI026	SN.. 1906..
GI027	SN.. 2507..
GI029	SN.. 1204..
GI040	SN.. 2509..
GI082	SN.. 1506..

				Nm					
PS20	SNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PS22	SNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXK 4
PS40	SNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4
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

PSSN(RL) EXT

P M K N S H

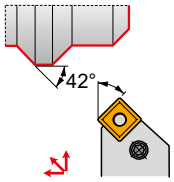
PRAMET

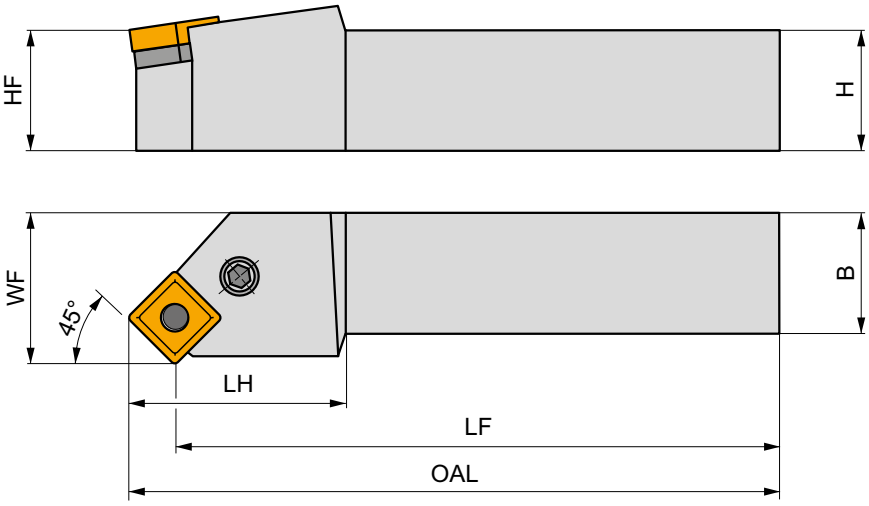
P

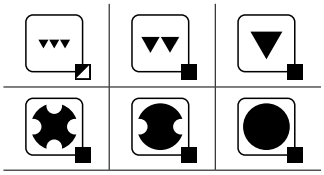


外圆用杠杆夹紧式车刀杆，使用SN..刀片，主偏角为45°。

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。









	产品型号	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	36	0	-8	0.41	GI029	PS22
	PSSNR 2525 M 12	25	25	25	32	150	158.3	36	0	-8	0.75	GI029	PS20
	PSSNR 3225 P 15	32	25	32	32	170	180.2	40	0	-8	1.13	GI082	PS40
	PSSNR 3232 P 19	32	32	32	40	170	182.5	45	0	-8	1.34	GI026	PS50
	PSSNR 4040 R 19	40	40	40	50	200	212.5	45	0	-8	2.50	GI026	PS50
	PSSNR 5050 T 25	50	50	50	60	300	316	50	0	-8	6.00	GI027	PS60
	PSSNR 5050 T 2509	50	50	50	60	300	316	50	0	-8	6.05	GI040	PS70
L	**PSSNL 2020 K 12**	20	20	20	25	125	133.3	36	0	-8	0.41	GI029	PS22
	PSSNL 2525 M 12	25	25	25	32	150	158.3	36	0	-8	0.67	GI029	PS20
	PSSNL 3225 P 15	32	25	32	32	170	180.2	40	0	-8	1.15	GI082	PS40
	PSSNL 3232 P 19	32	32	32	40	170	182.5	45	0	-8	1.44	GI026	PS50
	PSSNL 4040 R 19	40	40	40	50	200	212.5	45	0	-8	2.58	GI026	PS50
	PSSNL 5050 T 25	50	50	50	60	300	316	50	0	-8	6.00	GI027	PS60
	PSSNL 5050 T 2509	50	50	50	60	300	316	50	0	-8	6.08	GI040	PS70

GI026	SN.. 1906..
GI027	SN.. 2507..
GI029	SN.. 1204..
GI040	SN.. 2509..
GI082	SN.. 1506..

				Nm					
PS20	SNU 120312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PS22	SNU 120312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXK 4
PS40	SNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4
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

NEW

C.-DSDNN EXT

P M K N S H

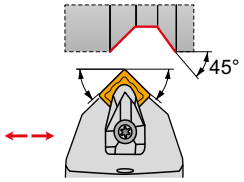
PRAMET

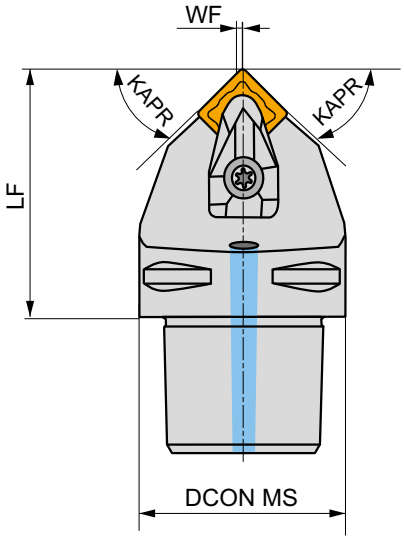
D

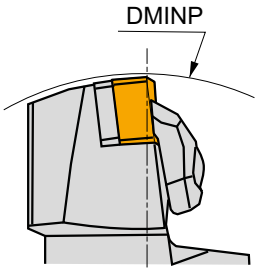


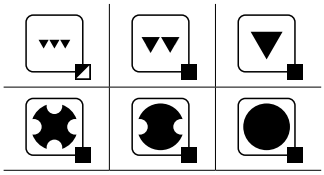
外圆用PSC快速更换式刀柄，双重夹紧，使用SN..刀片，主偏角为45°。

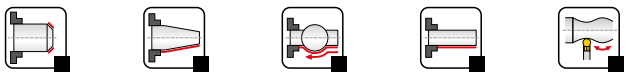
外圆用中置双重夹紧车刀杆，有内冷通道，主偏角为45°。使用SN..12或19尺寸的负前角刀片。适用于无阶梯外圆的轴向车削，仿形，锥面和倒角车削，可提供PSC(多边形柄联接)C4至C6刀柄。刀杆经过处理，使用寿命更长。











	产品型号	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	–

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

		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	–

NEW

C.-DSKN(RL) EXT

P M K N S H

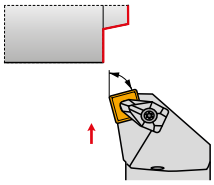
PRAMET

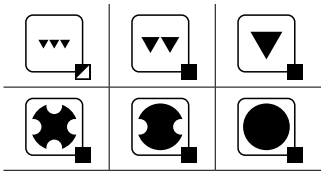
D

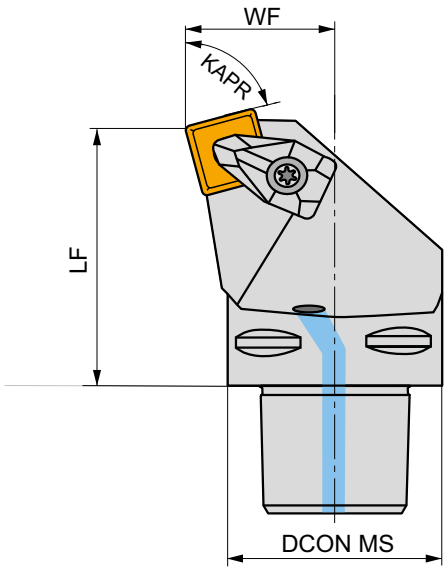


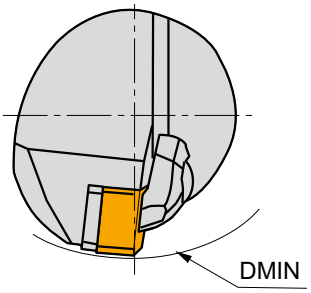
外圆用PSC快速更换式刀柄，双重夹紧，使用SN..刀片，主偏角为75°（端面）。

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。











	产品型号	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	–

NEW

C.-DSRN(RL) EXT

P M K N S H

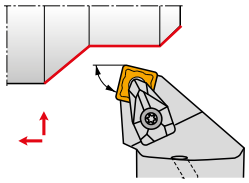
PRAMET

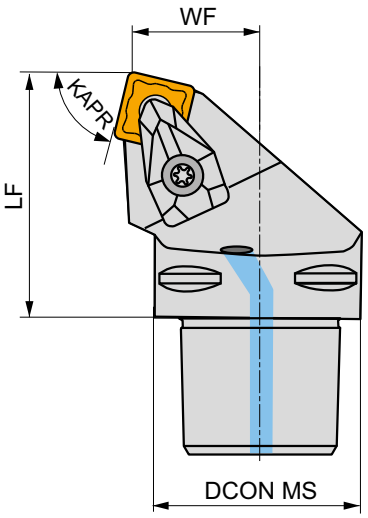
D

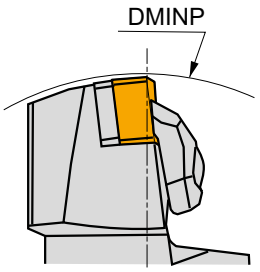


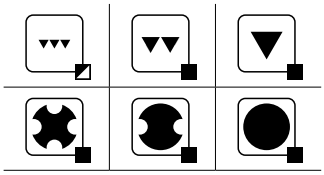
外圆用PSC快速更换式刀柄，双重夹紧，使用SN..刀片，主偏角为75°。

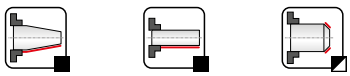
外圆用左/右手双重夹紧紧刀具，有内冷通道，主偏角为75°。使用SN..12或19尺寸的负前角刀片。适用于无阶梯外圆的轴向车削，锥面和倒角车削。可提供C4至C6刀柄。刀杆经过处理，使用寿命更长。











	产品型号	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
	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	✓	0.42	GI029	C-DS12-1	AT003
	C6-DSRNL-35065-19	63	190	35	65	75	-6	-6	✓	1.30	GI026	C-DS19	–

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

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	–

NEW

C.-DSSN(RL) EXT

P M K N S H

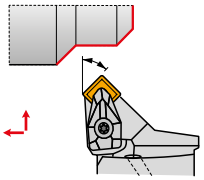
PRAMET

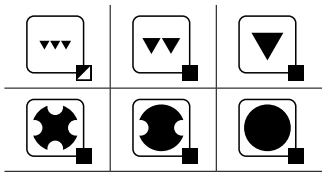
D

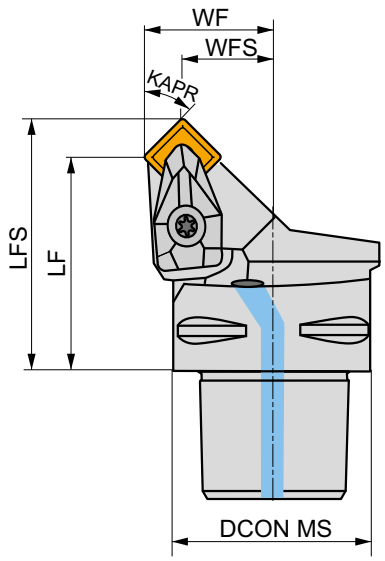


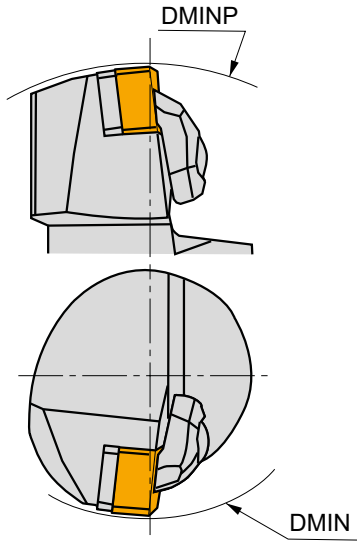
外圆用PSC快速更换式刀柄，双重夹紧，使用SN..刀片，主偏角为45°。

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。











	产品型号	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
R	**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
L	**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

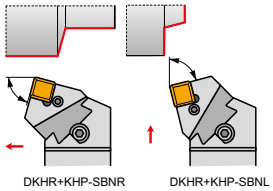
PRAMET

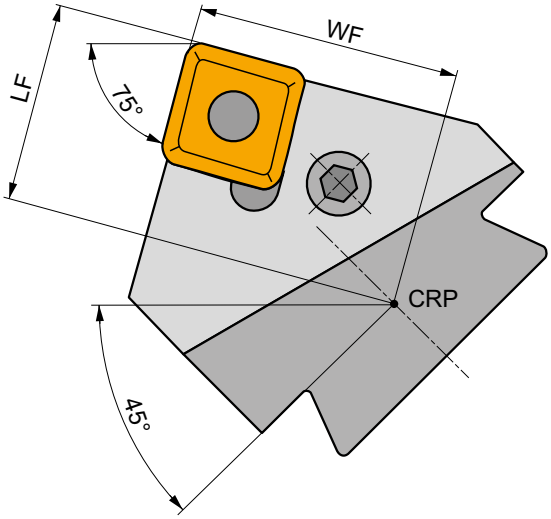
P

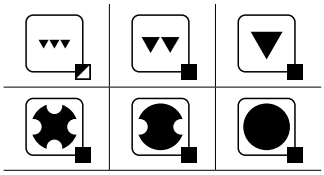


模块化KHP杠杆夹紧式车刀刀夹，使用SN..刀片，主偏角为75°。

燕尾形左/右手杠杆夹紧式车刀夹，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。









	产品型号	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
	KHP-SBNR 2512-A	47	36	-6	-6	1.71	GI162	PS72
L	**KHP-SBNL 19**	47	36	-6	-6	1.96	GI026	PS50
	KHP-SBNL 25	47	36	-6	-6	1.48	GI027	PS60
	KHP-SBNL 2509	47	36	-6	-6	1.46	GI040	PS70
	KHP-SBNL 2512-A	47	36	-6	-6	1.45	GI162	PS72

GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..
GI162	SN.. 2512..

				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
PS72	SNU 250624	PU 10-N	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5

KHP-SSN(RL)

P M K

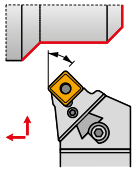
PRAMET

P

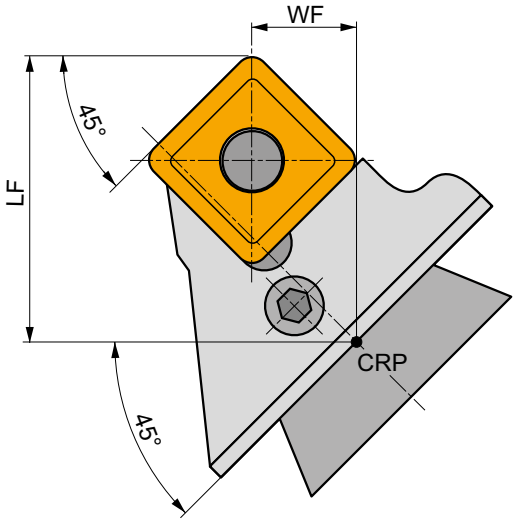


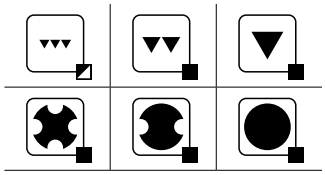
模块化KHP杠杆夹紧式车刀刀夹，使用SN..刀片，主偏角为45°

燕尾形左/右手杠杆夹紧式车刀夹，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







	产品型号	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-SSNR 19**	15	45	-6	-6	1.28	GI026	PS50
R	**KHP-SSNR 25**	15	45	-6	-6	0.98	GI027	PS60
L	**KHP-SSNL 19**	15	45	-6	-6	1.03	GI026	PS50
L	**KHP-SSNL 25**	15	45	-6	-6	1.30	GI027	PS60

GI026	SN.. 1906..
GI027	SN.. 2507..

				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

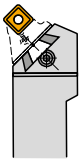
DKH(RL)

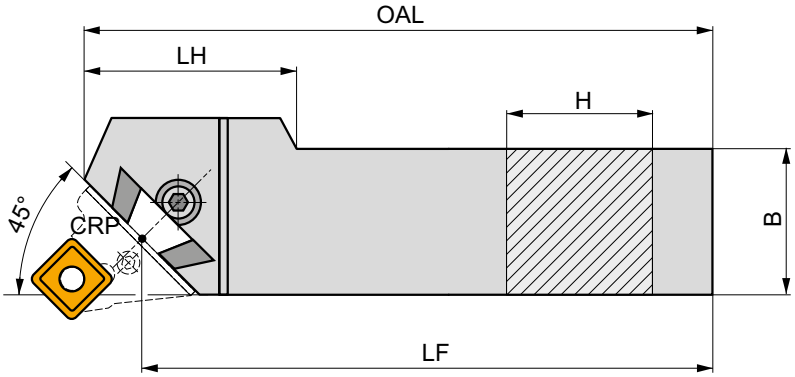
PRAMET

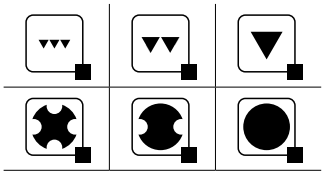


使用KHP/KHS重载车刀刀夹的外圆用刀柄

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。







	产品型号	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

PSKN(RL) INT

P M K N S H

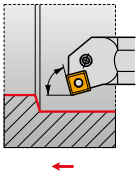
PRAMET

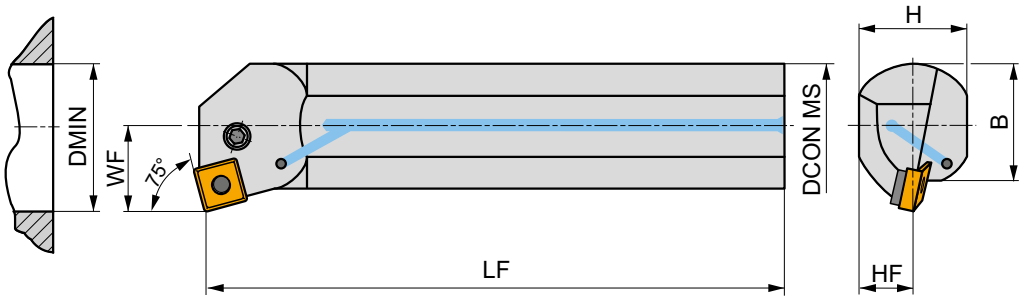
P

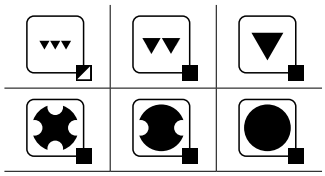


外圆用杠杆夹紧式镗杆，使用SN..刀片，主偏角为75°。

内孔用左/右手杠杆夹紧式镗杆，有内冷通道，主偏角为75°，使用SN..12、15和19刀片。内孔最小加工直径为Ø40mm。适用于内孔锥面，无阶梯孔的轴向车削，和倒角车削。可提供Ø32至Ø60mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A32S-PSKNR 12**	32	40	22	30	30	250	-12	-6	✓	1.50	GI029	PS21
	A40T-PSKNR 15	40	50	27	38	38	300	-12	-6	✓	2.90	GI082	PS41
	A50U-PSKNR 15	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI082	PS40
	A50U-PSKNR 19	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI026	PS50
	A60V-PSKNR 19	60	80	43	57	58.5	400	-12	-6	✓	8.70	GI026	PS50
L	**A32S-PSKNL 12**	32	40	22	30	30	250	-12	-6	✓	1.40	GI029	PS21
	A40T-PSKNL 15	40	50	27	38	38	300	-12	-6	✓	2.90	GI082	PS41
	A50U-PSKNL 15	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI082	PS40
	A50U-PSKNL 19	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI026	PS50

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

				Nm					
PS21	SNU 120312	PU 02	US 41	6.0	M 8x1	17	NT 05	MT 05	HXK 4
PS40	SNU 150312	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4
PS41	SNU 150312	PU 04	US 40	6.0	M 8x1	20.5	NT 07	MT 07	HXK 4
PS50	SNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5

TN

16/ 22/ 27/ 33

硬质合金刀片

TNMA



334

TNMG



335

TNMM



342

CER和CBN刀片

TNGA CER



343

TNGN CER



344

TNGA CBN



344

匹配正确的尺寸（示例）

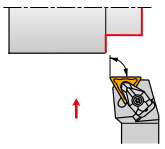
刀片	刀杆
TNMM 160412E-OR	DTFNR 2525 M 16

ISO 外圆车削

DTFN(RL) EXT

90°

TN..: 16, 22



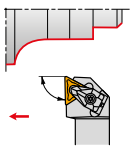
20×20 / 25×25

345 | 334 – 344

DTGN(RL) EXT

90°

TN..: 16, 22



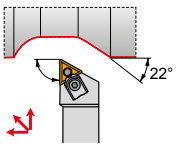
20×20 / 32×25

346 | 334 – 344

MTJN(RL) EXT

93°

TN..: 16, 22



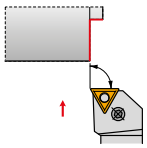
16×16 / 32×32

347 | 334 – 344

PTFN(RL) EXT

90°

TN..: 16, 22, 27



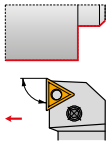
16×16 / 40×40

348 | 334 – 344

PTGN(RL) EXT

90°

TN..: 16, 22, 27



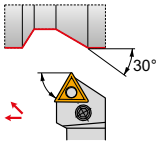
16×16 / 40×40

349 | 334 – 344

PTTN(RL) EXT

60°

TN..: 16, 22



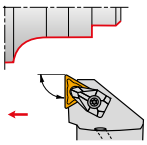
20×20 / 32×25

350 | 334 – 344

C.-DTJN(RL) EXT *NEW*

93°

TN..: 16



C4 / C5

351 | 334 – 344

TN

16/ 22/ 27/ 33

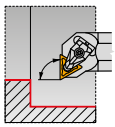
ISO内孔车削

DTFN(RL) INT

90°

TN..

16
22



ØDmin 32/50

352

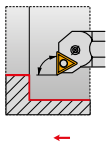
334 – 344

PTFN(RL) INT

90°

TN..

16
22



ØDmin 32/50

353

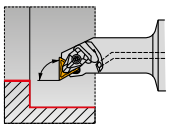
334 – 344

C.-DTFN(RL) INT NEW

91°

TN..

16



ØDmin 32

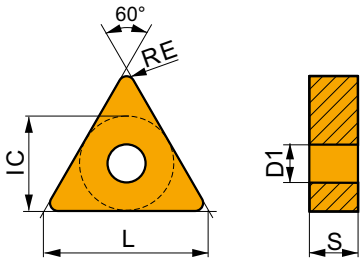
354

334 – 344

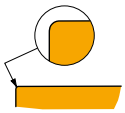
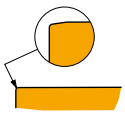
TNMA

PRAMET

	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



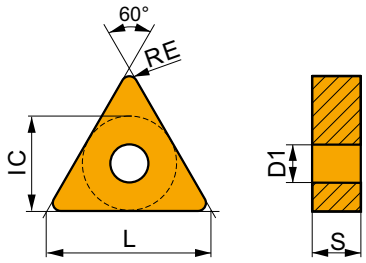
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
			E																	
适用于超精加工至中粗加工，连续至轻微断续切削。																				
TNMA 160404	**T5305**	0.4	–	–	–	–	–	–	220	0.10	1.5	–	–	–	–	–	–	45	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	190	0.10	1.5	–	–	–	–	–	–	40	0.15	1.0
TNMA 160408	**T5305**	0.8	–	–	–	–	–	–	205	0.20	1.5	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	180	0.20	1.5	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	90	0.20	1.5	–	–	–	–	–	–	20	0.15	1.0
TNMA 160412	**T5305**	1.2	–	–	–	–	–	–	215	0.20	1.5	–	–	–	–	–	–	45	0.15	1.0
	T5315	1.2	–	–	–	–	–	–	190	0.20	1.5	–	–	–	–	–	–	40	0.15	1.0
TNMA 220408	**T5305**	0.8	–	–	–	–	–	–	195	0.20	2.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	175	0.20	2.0	–	–	–	–	–	–	35	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	90	0.20	2.0	–	–	–	–	–	–	20	0.15	1.0
TNMA 220412	**T5305**	1.2	–	–	–	–	–	–	205	0.20	2.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.2	–	–	–	–	–	–	185	0.20	2.0	–	–	–	–	–	–	35	0.15	1.0
			S																	
适用于超精加工至中粗加工，连续至轻微断续切削。																				
TNMA 160408S	**T5305**	0.8	–	–	–	–	–	–	205	0.20	1.5	–	–	–	–	–	–	40	0.15	1.0

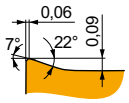
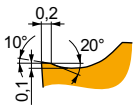
TNMG

PRAMET

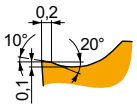
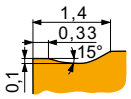
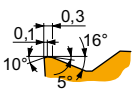
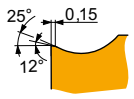
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76
2706	15.875	6.35	27.50	6.35
3309	19.050	7.94	33.00	9.525



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

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
FF断屑槽，具有大正前角设计，适用于超精加工，连续切削至轻微断续切削。																				
TNMG 160404E-FF	**T7325**	0.4	200	0.12	1.0	155	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	185	0.12	1.0	110	0.11	1.0	175	0.12	1.0	–	–	–	–	–	–	–	–	–
	T8330	0.4	175	0.12	1.0	105	0.11	1.0	165	0.12	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.4	210	0.12	1.0	115	0.11	1.0	175	0.12	1.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-FF	**T7325**	0.8	225	0.15	1.0	175	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	205	0.15	1.0	120	0.14	1.0	190	0.15	1.0	–	–	–	–	–	–	–	–	–
																				
FM断屑槽，具有正前角设计，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
TNMG 160404E-FM	**T7325**	0.4	160	0.20	1.7	120	0.18	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
	T7335	0.4	160	0.20	1.7	120	0.18	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
	T8315	0.4	150	0.20	1.7	90	0.18	1.7	140	0.20	1.7	–	–	–	35	0.14	1.4	–	–	–
	T8330	0.4	145	0.20	1.7	85	0.18	1.7	135	0.20	1.7	–	–	–	35	0.14	1.4	–	–	–
	T8430	0.4	165	0.20	1.7	90	0.18	1.7	135	0.20	1.7	–	–	–	35	0.14	1.4	–	–	–
	T9310	0.4	245	0.20	1.7	–	–	–	230	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9315	0.4	220	0.20	1.7	–	–	–	205	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	200	0.20	1.7	120	0.18	1.7	190	0.20	1.7	–	–	–	45	0.20	1.4	–	–	–
	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	–	–	–
	T7335	0.8	190	0.20	1.7	145	0.18	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
	T8315	0.8	180	0.20	1.7	105	0.18	1.7	170	0.20	1.7	–	–	–	45	0.16	1.4	–	–	–
	T8330	0.8	170	0.20	1.7	100	0.18	1.7	160	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
	T8430	0.8	195	0.20	1.7	105	0.18	1.7	160	0.20	1.7	–	–	–	40	0.16	1.4	–	–	–
	T9310	0.8	290	0.20	1.7	–	–	–	275	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9315	0.8	265	0.20	1.7	–	–	–	250	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	235	0.20	1.7	140	0.18	1.7	220	0.20	1.7	–	–	–	50	0.16	1.4	–	–	–
	TT310	0.8	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-FM	**T7325**	1.2	190	0.25	1.7	145	0.23	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
	T8330	1.2	165	0.25	1.7	95	0.23	1.7	155	0.25	1.7	–	–	–	40	0.18	1.4	–	–	–
	T8430	1.2	185	0.25	1.7	100	0.23	1.7	150	0.25	1.7	–	–	–	40	0.18	1.4	–	–	–
	T9310	1.2	280	0.25	1.7	–	–	–	265	0.25	1.7	–	–	–	–	–	–	–	–	–
	T9315	1.2	255	0.25	1.7	–	–	–	240	0.25	1.7	–	–	–	–	–	–	–	–	–
	T9325	1.2	225	0.25	1.7	135	0.23	1.7	210	0.25	1.7	–	–	–	50	0.18	1.4	–	–	–
TNMG 220404E-FM	**T8330**	0.4	145	0.20	1.7	85	0.18	1.7	135	0.20	1.7	–	–	–	35	0.20	1.4	–	–	–
	T8430	0.4	150	0.24	1.7	80	0.22	1.7	125	0.24	1.7	–	–	–	30	0.22	1.4	–	–	–
	T9315	0.4	220	0.20	1.7	–	–	–	205	0.20	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	200	0.20	1.7	120	0.18	1.7	190	0.20	1.7	–	–	–	45	0.20	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。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
TNMG 220408E-FM	**T8330**	0.8	■ 170	0.20	1.7	◪ 100	0.18	1.7	■ 160	0.20	1.7	–	–	–	◪ 40	0.16	1.4	–	–	–
	T8430	0.8	■ 195	0.20	1.7	◪ 105	0.18	1.7	◪ 160	0.20	1.7	–	–	–	◪ 40	0.16	1.4	–	–	–
	T9315	0.8	■ 265	0.20	1.7	–	–	–	◪ 250	0.20	1.7	–	–	–	–	–	–	–	–	–
	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-KR	**T5305**	0.8	◪ 220	0.35	3.0	–	–	–	■ 205	0.35	3.0	–	–	–	–	–	–	◪ 40	0.15	1.0
	T5315	0.8	◪ 200	0.35	3.0	–	–	–	■ 190	0.35	3.0	–	–	–	–	–	–	◪ 40	0.15	1.0
																				
TNMG 160404E-M	**T5315**	0.4	◪ 215	0.20	1.6	–	–	–	■ 200	0.20	1.6	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	0.4	■ 205	0.20	1.6	–	–	–	◪ 190	0.20	1.6	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	0.4	■ 180	0.20	1.6	–	–	–	◪ 170	0.20	1.6	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 155	0.20	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160408E-M	**T5305**	0.8	◪ 250	0.30	1.6	–	–	–	■ 235	0.30	1.6	–	–	–	–	–	–	◪ 50	0.15	1.0
	T5315	0.8	◪ 225	0.30	1.6	–	–	–	■ 210	0.30	1.6	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9310	0.8	■ 220	0.30	1.6	–	–	–	◪ 205	0.30	1.6	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	0.8	■ 205	0.30	1.6	–	–	–	◪ 190	0.30	1.6	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	0.8	■ 185	0.30	1.6	–	–	–	◪ 175	0.30	1.6	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 160	0.30	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-M	**T5315**	1.2	◪ 215	0.40	1.6	–	–	–	■ 200	0.40	1.6	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	1.2	■ 190	0.40	1.6	–	–	–	◪ 180	0.40	1.6	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	1.2	■ 170	0.40	1.6	–	–	–	◪ 160	0.40	1.6	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 145	0.40	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-M	**T5305**	0.8	◪ 245	0.30	2.1	–	–	–	■ 230	0.30	2.1	–	–	–	–	–	–	◪ 45	0.15	1.0
	T5315	0.8	◪ 215	0.30	2.1	–	–	–	■ 200	0.30	2.1	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9310	0.8	■ 215	0.30	2.1	–	–	–	◪ 200	0.30	2.1	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	0.8	■ 200	0.30	2.1	–	–	–	◪ 190	0.30	2.1	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	0.8	■ 180	0.30	2.1	–	–	–	◪ 170	0.30	2.1	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 155	0.30	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220412E-M	**T5315**	1.2	◪ 205	0.40	2.1	–	–	–	■ 190	0.40	2.1	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	1.2	■ 185	0.40	2.1	–	–	–	◪ 175	0.40	2.1	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	1.2	■ 165	0.40	2.1	–	–	–	◪ 155	0.40	2.1	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 140	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
TNMG 160404E-NF	**HF7**	0.4	–	–	–	◪ 90	0.14	1.4	◪ 140	0.15	1.4	◪ 450	0.18	1.4	–	–	–	–	–	–
	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	–	–	–
	T7325	0.4	◪ 170	0.18	1.4	■ 130	0.16	1.4	–	–	–	–	–	–	◪ 55	0.16	1.1	–	–	–
	T7335	0.4	◪ 165	0.18	1.4	■ 125	0.16	1.4	–	–	–	–	–	–	◪ 50	0.16	1.1	–	–	–
	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	–	–	–
	T8330	0.4	■ 155	0.17	1.4	■ 90	0.15	1.4	◪ 145	0.17	1.4	◪ 465	0.20	1.4	◪ 35	0.15	1.1	–	–	–
	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	–	–	–
	T9315	0.4	■ 255	0.15	1.4	–	–	–	◪ 240	0.15	1.4	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 215	0.18	1.4	■ 125	0.16	1.4	◪ 200	0.18	1.4	–	–	–	◪ 45	0.16	1.1	–	–	–

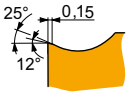
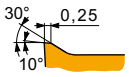
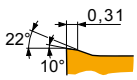
FM断屑槽，具有正前角设计，适用于精加工至中粗加工，连续切削至轻微断续切削。

KR断屑槽，适用于中粗加工至重载粗加工，连续至断续切削。

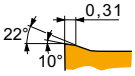
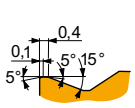
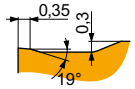
M断屑槽，适用于精加工至中粗加工，连续至断续切削。

NF断屑槽，具有大正前角设计，适用于超精加工至中度加工，连续切削。

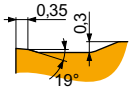
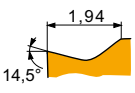
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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断屑槽，具有大正前角设计，适用于超精加工至中度加工，连续切削。																				
TNMG 160408E-NF	**HF7**	0.8	–	–	–	100	0.15	1.4	160	0.17	1.4	510	0.20	1.4	–	–	–	–	–	–
	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	–	–	–
	T7325	0.8	200	0.18	1.4	155	0.16	1.4	–	–	–	–	–	–	65	0.16	1.1	–	–	–
	T7335	0.8	195	0.18	1.4	150	0.16	1.4	–	–	–	–	–	–	60	0.16	1.1	–	–	–
	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	–	–	–
	T8330	0.8	180	0.18	1.4	105	0.16	1.4	170	0.18	1.4	540	0.22	1.4	45	0.16	1.1	–	–	–
	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	–	–	–
	T9315	0.8	290	0.17	1.4	–	–	–	275	0.17	1.4	–	–	–	–	–	–	–	–	–
	T9325	0.8	255	0.18	1.4	150	0.16	1.4	240	0.18	1.4	–	–	–	55	0.16	1.1	–	–	–
																				
NM断屑槽，具有大正前角设计，适用于连续切削中进行精细，中度和粗加工。																				
TNMG 160404E-NM	**T7325**	0.4	170	0.20	1.9	130	0.18	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
	T7335	0.4	160	0.20	1.9	120	0.18	1.9	–	–	–	–	–	–	50	0.20	1.5	–	–	–
	T8315	0.4	160	0.20	1.9	95	0.18	1.9	–	–	–	480	0.24	1.9	40	0.20	1.5	–	–	–
	T8330	0.4	145	0.20	1.9	85	0.18	1.9	–	–	–	435	0.24	1.9	35	0.20	1.5	–	–	–
	T8430	0.4	170	0.20	1.9	90	0.18	1.9	–	–	–	465	0.24	1.9	35	0.20	1.5	–	–	–
	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	–	–	–
	T7335	0.8	180	0.25	1.9	140	0.23	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
	T8315	0.8	175	0.25	1.9	105	0.23	1.9	–	–	–	525	0.30	1.9	40	0.20	1.5	–	–	–
	T8330	0.8	165	0.25	1.9	95	0.23	1.9	–	–	–	495	0.30	1.9	40	0.20	1.5	–	–	–
	T8430	0.8	185	0.25	1.9	100	0.23	1.9	–	–	–	510	0.30	1.9	40	0.20	1.5	–	–	–
	T9315	0.8	250	0.25	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	225	0.25	1.9	135	0.23	1.9	–	–	–	–	–	–	50	0.20	1.5	–	–	–
TNMG 220408E-NM	**T7325**	0.8	190	0.25	1.7	145	0.23	1.7	–	–	–	–	–	–	60	0.20	1.4	–	–	–
	T7335	0.8	185	0.25	1.7	140	0.23	1.7	–	–	–	–	–	–	60	0.20	1.4	–	–	–
	T8315	0.8	175	0.25	1.7	105	0.23	1.7	–	–	–	525	0.30	1.7	40	0.20	1.4	–	–	–
	T8330	0.8	165	0.25	1.7	95	0.23	1.7	–	–	–	495	0.30	1.7	40	0.20	1.4	–	–	–
	T8430	0.8	185	0.25	1.7	100	0.23	1.7	–	–	–	510	0.30	1.7	40	0.20	1.4	–	–	–
	T9315	0.8	255	0.25	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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	–	–	–
	T7335	1.2	180	0.30	2.1	140	0.27	2.1	–	–	–	–	–	–	55	0.24	1.7	–	–	–
	T9325	1.2	215	0.30	2.1	125	0.27	2.1	–	–	–	–	–	–	45	0.24	1.7	–	–	–
																				
NMR断屑槽，具有正前角设计，适用于中度至粗加工，连续切削。																				
TNMG 160404E-NMR	**T6310**	0.4	130	0.20	1.7	90	0.18	1.7	–	–	–	–	–	–	35	0.18	1.4	–	–	–
	T7325	0.4	145	0.20	1.7	110	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
	T7335	0.4	145	0.20	1.7	110	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
	T8330	0.4	130	0.20	1.7	75	0.18	1.7	–	–	–	–	–	–	30	0.18	1.4	–	–	–
	T8430	0.4	145	0.20	1.7	80	0.18	1.7	–	–	–	–	–	–	30	0.18	1.4	–	–	–
	T9315	0.4	200	0.20	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.4	180	0.20	1.7	105	0.18	1.7	–	–	–	–	–	–	40	0.18	1.4	–	–	–
TNMG 160408E-NMR	**T6310**	0.8	140	0.30	1.7	100	0.27	1.7	–	–	–	–	–	–	40	0.24	1.4	–	–	–
	T7325	0.8	155	0.30	1.7	120	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
	T7335	0.8	145	0.30	1.7	110	0.27	1.7	–	–	–	–	–	–	45	0.24	1.4	–	–	–
	T8330	0.8	140	0.30	1.7	80	0.27	1.7	–	–	–	–	–	–	35	0.24	1.4	–	–	–
	T8430	0.8	150	0.30	1.7	80	0.27	1.7	–	–	–	–	–	–	30	0.24	1.4	–	–	–
	T9315	0.8	205	0.30	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	185	0.30	1.7	110	0.27	1.7	–	–	–	–	–	–	40	0.24	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。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
NMR断屑槽，具有正前角设计，适用于中度至粗加工，连续切削。																				
TNMG 160412E-NMR	**T7325**	1.2	◪ 165	0.30	1.7	■ 125	0.27	1.7	–	–	–	–	–	–	■ 50	0.24	1.4	–	–	–
	T9315	1.2	■ 215	0.30	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 195	0.30	1.7	■ 115	0.27	1.7	–	–	–	–	–	–	◪ 40	0.24	1.4	–	–	–
TNMG 220408E-NMR	**T6310**	0.8	■ 135	0.30	2.1	■ 95	0.27	2.1	–	–	–	–	–	–	■ 40	0.24	1.7	–	–	–
	T7325	0.8	◪ 150	0.30	2.1	■ 115	0.27	2.1	–	–	–	–	–	–	■ 45	0.24	1.7	–	–	–
	T7335	0.8	◪ 145	0.30	2.1	■ 110	0.27	2.1	–	–	–	–	–	–	■ 45	0.24	1.7	–	–	–
	T8330	0.8	■ 135	0.30	2.1	■ 80	0.27	2.1	–	–	–	–	–	–	◪ 30	0.24	1.7	–	–	–
	T8430	0.8	■ 145	0.30	2.1	■ 80	0.27	2.1	–	–	–	–	–	–	◪ 30	0.24	1.7	–	–	–
	T9315	0.8	■ 200	0.30	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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	–	–	–
	T7325	1.2	◪ 160	0.30	2.1	■ 120	0.27	2.1	–	–	–	–	–	–	■ 50	0.24	1.7	–	–	–
	T9315	1.2	■ 210	0.30	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 190	0.30	2.1	■ 110	0.27	2.1	–	–	–	–	–	–	◪ 40	0.24	1.7	–	–	–
																				
R断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
TNMG 160408E-R	**T5305**	0.8	◪ 210	0.40	3.0	–	–	–	■ 195	0.40	3.0	–	–	–	–	–	–	◪ 40	0.15	1.0
	T5315	0.8	◪ 185	0.40	3.0	–	–	–	■ 175	0.40	3.0	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9310	0.8	■ 185	0.40	3.0	–	–	–	◪ 175	0.40	3.0	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9315	0.8	■ 165	0.40	3.0	–	–	–	◪ 155	0.40	3.0	–	–	–	–	–	–	◪ 30	0.15	1.0
	T9325	0.8	■ 150	0.40	3.0	–	–	–	◪ 140	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 130	0.40	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-R	**T5315**	1.2	◪ 195	0.40	3.0	–	–	–	■ 185	0.40	3.0	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9310	1.2	■ 195	0.40	3.0	–	–	–	◪ 185	0.40	3.0	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	1.2	■ 160	0.40	3.0	–	–	–	◪ 150	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 140	0.40	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-R	**T9315**	0.8	■ 165	0.40	4.0	–	–	–	◪ 155	0.40	4.0	–	–	–	–	–	–	◪ 30	0.15	1.0
	T9325	0.8	■ 145	0.40	4.0	–	–	–	◪ 135	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 125	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220412E-R	**T9310**	1.2	■ 185	0.40	4.0	–	–	–	◪ 175	0.40	4.0	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9315	1.2	■ 170	0.40	4.0	–	–	–	◪ 160	0.40	4.0	–	–	–	–	–	–	◪ 30	0.15	1.0
	T9325	1.2	■ 155	0.40	4.0	–	–	–	◪ 145	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220416E-R	**T9315**	1.6	■ 180	0.40	4.0	–	–	–	◪ 170	0.40	4.0	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	1.6	■ 165	0.40	4.0	–	–	–	◪ 155	0.40	4.0	–	–	–	–	–	–	–	–	–
																				
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
TNMG 160408E-RM	**T5305**	0.8	◪ 245	0.40	3.0	–	–	–	◪ 230	0.40	3.0	–	–	–	–	–	–	–	–	–
	T5315	0.8	◪ 215	0.40	3.0	–	–	–	◪ 200	0.40	3.0	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪ 155	0.40	3.0	◪ 120	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪ 145	0.40	3.0	◪ 110	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	0.8	■ 210	0.40	3.0	–	–	–	◪ 195	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 195	0.40	3.0	–	–	–	◪ 185	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 175	0.40	3.0	◪ 105	0.36	3.0	◪ 165	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 150	0.40	3.0	◪ 90	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–

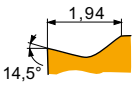
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
TNMG 160412E-RM	**T5305**	1.2	255	0.40	3.0	–	–	–	240	0.40	3.0	–	–	–	–	–	–	–	–	–
	T5315	1.2	225	0.40	3.0	–	–	–	210	0.40	3.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	165	0.40	3.0	125	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	1.2	145	0.40	3.0	85	0.36	3.0	135	0.40	3.0	–	–	–	–	–	–	–	–	–
	T8430	1.2	150	0.40	3.0	80	0.36	3.0	125	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	205	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	185	0.40	3.0	110	0.36	3.0	175	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	160	0.40	3.0	95	0.36	3.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-RM	**T5305**	0.8	235	0.40	4.0	–	–	–	220	0.40	4.0	–	–	–	–	–	–	–	–	–
	T5315	0.8	210	0.40	4.0	–	–	–	195	0.40	4.0	–	–	–	–	–	–	–	–	–
	T7325	0.8	150	0.40	4.0	115	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	140	0.40	4.0	105	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	0.8	200	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	190	0.40	4.0	–	–	–	180	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	170	0.40	4.0	100	0.36	4.0	160	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	145	0.40	4.0	85	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220412E-RM	**T5305**	1.2	245	0.40	4.0	–	–	–	230	0.40	4.0	–	–	–	–	–	–	–	–	–
	T5315	1.2	220	0.40	4.0	–	–	–	205	0.40	4.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	160	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	150	0.40	4.0	115	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	1.2	200	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	180	0.40	4.0	105	0.36	4.0	170	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	155	0.40	4.0	90	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220416E-RM	**T7325**	1.6	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	1.6	210	0.40	4.0	–	–	–	195	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	185	0.40	4.0	110	0.36	4.0	175	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	160	0.40	4.0	95	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 270612E-RM	**T7325**	1.2	110	0.40	6.0	85	0.36	6.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.2	120	0.40	6.0	70	0.36	6.0	110	0.40	6.0	–	–	–	–	–	–	–	–	–
TNMG 270616E-RM	**T7325**	1.6	115	0.40	6.0	85	0.36	6.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9226	1.6	115	0.40	6.0	65	0.36	6.0	105	0.40	6.0	–	–	–	–	–	–	–	–	–
	T9315	1.6	135	0.40	6.0	–	–	–	125	0.40	6.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	125	0.40	6.0	75	0.36	6.0	115	0.40	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	100	0.40	6.0	60	0.36	6.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 270624E-RM	**T7325**	2.4	115	0.50	6.0	85	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	2.4	120	0.50	6.0	70	0.45	6.0	110	0.50	6.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	95	0.50	6.0	55	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 270632E-RM	**T9335**	3.2	90	0.60	6.0	50	0.54	6.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 330924E-RM	**T9226**	2.4	100	0.50	10.0	60	0.45	10.0	95	0.50	10.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	90	0.50	10.0	50	0.45	10.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
SF断屑槽，具有正前角设计，适用于薄壁，连续切削进行超精加工。																				
TNMG 160404E-SF	**H07**	0.4	–	–	–	75	0.14	1.3	120	0.15	1.3	390	0.18	1.3	35	0.12	1.0	–	–	–
	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	0.15	1.0
	T7325	0.4	170	0.17	1.3	130	0.15	1.3	–	–	–	–	–	–	55	0.15	1.0	–	–	–
	T7335	0.4	165	0.17	1.3	125	0.15	1.3	–	–	–	–	–	–	50	0.15	1.0	–	–	–
	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	0.15	1.0
	T8330	0.4	150	0.15	1.3	90	0.14	1.3	140	0.15	1.3	450	0.18	1.3	35	0.12	1.0	30	0.15	1.0
	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	0.15	1.0
	T9315	0.4	245	0.15	1.3	–	–	–	230	0.15	1.3	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.4	210	0.17	1.3	125	0.15	1.3	195	0.17	1.3	–	–	–	45	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。

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		

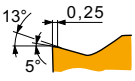




SF断屑槽，具有正前角设计，适用于薄壁，连续切削进行超精加工。

TNMG 160408E-SF	H07	0.8	–	–	–	85	0.15	1.3	140	0.17	1.3	445	0.20	1.3	45	0.14	1.0	–	–	–
	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	0.15	1.0
	T7325	0.8	200	0.17	1.3	155	0.15	1.3	–	–	–	–	–	–	65	0.15	1.0	–	–	–
	T7335	0.8	195	0.17	1.3	150	0.15	1.3	–	–	–	–	–	–	60	0.15	1.0	–	–	–
	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	0.15	1.0
	T8330	0.8	175	0.17	1.3	105	0.15	1.3	165	0.17	1.3	525	0.20	1.3	40	0.14	1.0	35	0.15	1.0
	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	0.15	1.0
	T9315	0.8	275	0.17	1.3	–	–	–	260	0.17	1.3	–	–	–	–	–	–	55	0.15	1.0
	T9325	0.8	250	0.17	1.3	150	0.15	1.3	235	0.17	1.3	–	–	–	55	0.15	1.0	–	–	–
TNMG 160412E-SF	T6310	1.2	160	0.30	1.3	115	0.27	1.3	125	0.30	1.3	480	0.36	1.3	45	0.21	1.0	30	0.15	1.0
	T7325	1.2	175	0.30	1.3	135	0.27	1.3	–	–	–	–	–	–	55	0.21	1.0	–	–	–
	T9325	1.2	205	0.30	1.3	120	0.27	1.3	190	0.30	1.3	–	–	–	45	0.21	1.0	–	–	–
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	0.15	1.0
	T7325	0.4	160	0.17	1.7	120	0.15	1.7	–	–	–	–	–	–	50	0.15	1.4	–	–	–
	T9325	0.4	205	0.17	1.7	120	0.15	1.7	190	0.17	1.7	–	–	–	45	0.15	1.4	–	–	–
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	0.15	1.0
	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	0.15	1.0
	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	0.15	1.0
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	1.0
	T7325	1.2	170	0.30	1.7	130	0.27	1.7	–	–	–	–	–	–	55	0.21	1.4	–	–	–
	T9325	1.2	205	0.30	1.7	120	0.27	1.7	190	0.30	1.7	–	–	–	45	0.21	1.4	–	–	–

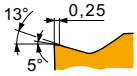
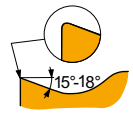
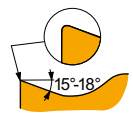




SM断屑槽，具有正前角设计，适用于中等加工，连续或间断进行切削。

TNMG 160404E-SM	T6310	0.4	135	0.22	1.7	95	0.20	1.7	105	0.22	1.7	405	0.26	1.7	40	0.20	1.4	25	0.15	1.0
	T7325	0.4	150	0.22	1.7	115	0.20	1.7	–	–	–	–	–	–	45	0.20	1.4	–	–	–
	T7335	0.4	145	0.22	1.7	110	0.20	1.7	–	–	–	–	–	–	45	0.20	1.4	–	–	–
	T8330	0.4	135	0.22	1.7	80	0.20	1.7	125	0.22	1.7	405	0.26	1.7	30	0.20	1.4	25	0.15	1.0
	T8430	0.4	145	0.22	1.7	80	0.20	1.7	120	0.22	1.7	405	0.26	1.7	30	0.20	1.4	25	0.15	1.0
	T9315	0.4	210	0.20	1.7	–	–	–	195	0.20	1.7	–	–	–	–	–	–	40	0.15	1.0
	T9325	0.4	185	0.22	1.7	110	0.20	1.7	175	0.22	1.7	–	–	–	40	0.20	1.4	–	–	–
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	0.15	1.0
	T7325	0.8	170	0.25	1.7	130	0.23	1.7	–	–	–	–	–	–	55	0.20	1.4	–	–	–
	T7335	0.8	165	0.25	1.7	125	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
	T8330	0.8	150	0.25	1.7	90	0.23	1.7	140	0.25	1.7	450	0.30	1.7	35	0.20	1.4	30	0.15	1.0
	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	0.15	1.0
	T9315	0.8	230	0.25	1.7	–	–	–	215	0.25	1.7	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.8	205	0.25	1.7	120	0.23	1.7	190	0.25	1.7	–	–	–	45	0.20	1.4	–	–	–
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	1.0
	T7325	1.2	170	0.30	1.7	130	0.27	1.7	–	–	–	–	–	–	55	0.24	1.4	–	–	–
	T7335	1.2	165	0.30	1.7	125	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
	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	130	0.24	1.7	90	0.22	1.7	100	0.24	1.7	390	0.29	1.7	35	0.22	1.4	25	0.15	1.0
	T7325	0.4	145	0.24	1.7	110	0.22	1.7	–	–	–	–	–	–	45	0.22	1.4	–	–	–
	T8330	0.4	130	0.24	1.7	75	0.22	1.7	120	0.24	1.7	390	0.29	1.7	30	0.22	1.4	25	0.15	1.0
	T8430	0.4	145	0.24	1.7	80	0.22	1.7	120	0.24	1.7	405	0.29	1.7	30	0.22	1.4	25	0.15	1.0
	T9325	0.4	175	0.24	1.7	105	0.22	1.7	165	0.24	1.7	–	–	–	35	0.22	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	0.15	1.0
	T7325	0.8	170	0.25	1.7	130	0.23	1.7	–	–	–	–	–	–	55	0.20	1.4	–	–	–
	T7335	0.8	165	0.25	1.7	125	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
	T8330	0.8	150	0.25	1.7	90	0.23	1.7	140	0.25	1.7	450	0.30	1.7	35	0.20	1.4	30	0.15	1.0
	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	0.15	1.0
	T9315	0.8	230	0.25	1.7	–	–	–	215	0.25	1.7	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.8	205	0.25	1.7	120	0.23	1.7	190	0.25	1.7	–	–	–	45	0.20	1.4	–	–	–

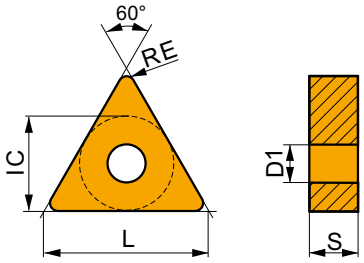
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
			SM断屑槽，具有正前角设计，适用于中等加工，连续或间断进行切削。																	
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	1.0
	T7325	1.2	◪ 170	0.30	1.7	■ 130	0.27	1.7	–	–	–	–	–	–	■ 55	0.24	1.4	–	–	–
	T7335	1.2	◪ 165	0.30	1.7	■ 125	0.27	1.7	–	–	–	–	–	–	■ 50	0.24	1.4	–	–	–
	T9315	1.2	■ 225	0.30	1.7	–	–	–	◪ 210	0.30	1.7	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	1.2	■ 205	0.30	1.7	■ 120	0.27	1.7	◪ 190	0.30	1.7	–	–	–	◪ 45	0.24	1.4	–	–	–
																				
			ER-SI断屑槽，具有正前角设计，右手设计，适用于超精加工至中粗加工，连续切削。																	
TNMG 160404ER-SI	**T7325**	0.4	◪ 190	0.20	1.5	■ 145	0.18	1.5	–	–	–	–	–	–	◪ 60	0.18	1.2	–	–	–
	T7335	0.4	◪ 180	0.20	1.5	■ 140	0.18	1.5	–	–	–	–	–	–	◪ 55	0.18	1.2	–	–	–
	T8315	0.4	◪ 175	0.20	1.5	■ 105	0.18	1.5	–	–	–	◪ 525	0.24	1.5	◪ 40	0.18	1.2	–	–	–
	T8330	0.4	■ 165	0.20	1.5	■ 95	0.18	1.5	–	–	–	◪ 495	0.24	1.5	◪ 40	0.18	1.2	–	–	–
	T8430	0.4	■ 185	0.20	1.5	■ 100	0.18	1.5	–	–	–	◪ 510	0.24	1.5	◪ 40	0.18	1.2	–	–	–
	T9325	0.4	■ 230	0.20	1.5	■ 135	0.18	1.5	–	–	–	–	–	–	◪ 50	0.18	1.2	–	–	–
	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	–	–	–
	T7335	0.8	◪ 180	0.35	1.5	■ 140	0.32	1.5	–	–	–	–	–	–	◪ 55	0.25	1.2	–	–	–
	T8315	0.8	◪ 175	0.35	1.5	■ 105	0.32	1.5	–	–	–	◪ 525	0.42	1.5	◪ 40	0.25	1.2	–	–	–
	T8330	0.8	■ 170	0.35	1.5	■ 100	0.32	1.5	–	–	–	◪ 510	0.42	1.5	◪ 40	0.25	1.2	–	–	–
	T8430	0.8	■ 180	0.35	1.5	■ 95	0.32	1.5	–	–	–	◪ 495	0.42	1.5	◪ 35	0.25	1.2	–	–	–
	T9325	0.8	■ 215	0.35	1.5	■ 125	0.32	1.5	–	–	–	–	–	–	◪ 45	0.25	1.2	–	–	–
	T9335	0.8	■ 190	0.35	1.5	■ 110	0.32	1.5	–	–	–	–	–	–	◪ 40	0.25	1.2	–	–	–
																				
			EL-SI断屑槽，具有正前角，左手设计，适用于超精加工至中粗加工，连续切削。																	
TNMG 160404EL-SI	**T7325**	0.4	◪ 190	0.20	1.5	■ 145	0.18	1.5	–	–	–	–	–	–	◪ 60	0.18	1.2	–	–	–
	T7335	0.4	◪ 180	0.20	1.5	■ 140	0.18	1.5	–	–	–	–	–	–	◪ 55	0.18	1.2	–	–	–
	T8315	0.4	◪ 175	0.20	1.5	■ 105	0.18	1.5	–	–	–	◪ 525	0.24	1.5	◪ 40	0.18	1.2	–	–	–
	T8330	0.4	■ 165	0.20	1.5	■ 95	0.18	1.5	–	–	–	◪ 495	0.24	1.5	◪ 40	0.18	1.2	–	–	–
	T8430	0.4	■ 185	0.20	1.5	■ 100	0.18	1.5	–	–	–	◪ 510	0.24	1.5	◪ 40	0.18	1.2	–	–	–
	T9325	0.4	■ 230	0.20	1.5	■ 135	0.18	1.5	–	–	–	–	–	–	◪ 50	0.18	1.2	–	–	–
	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	–	–	–
	T7335	0.8	◪ 180	0.35	1.5	■ 140	0.32	1.5	–	–	–	–	–	–	◪ 55	0.25	1.2	–	–	–
	T8315	0.8	◪ 175	0.35	1.5	■ 105	0.32	1.5	–	–	–	◪ 525	0.42	1.5	◪ 40	0.25	1.2	–	–	–
	T8330	0.8	■ 170	0.35	1.5	■ 100	0.32	1.5	–	–	–	◪ 510	0.42	1.5	◪ 40	0.25	1.2	–	–	–
	T8430	0.8	■ 180	0.35	1.5	■ 95	0.32	1.5	–	–	–	◪ 495	0.42	1.5	◪ 35	0.25	1.2	–	–	–
	T9325	0.8	■ 215	0.35	1.5	■ 125	0.32	1.5	–	–	–	–	–	–	◪ 45	0.25	1.2	–	–	–
	T9335	0.8	■ 190	0.35	1.5	■ 110	0.32	1.5	–	–	–	–	–	–	◪ 40	0.25	1.2	–	–	–

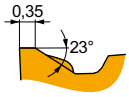
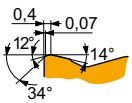
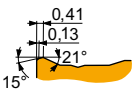
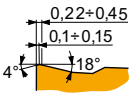
TNMM

PRAMET

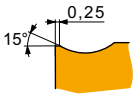
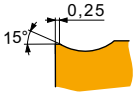
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76
2706	15.875	6.35	27.50	6.35



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

产品型号		RE (mm)	P vc (m/min)	P f (mm/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)
																				
			DR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
TNMM 160408E-DR	**T9325**	0.8	175	0.40	4.0	105	0.36	4.0	165	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMM 220408E-DR	**T9325**	0.8	175	0.40	4.0	105	0.36	4.0	165	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	155	0.40	4.0	90	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMM 220412E-DR	**T9315**	1.2	205	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	185	0.40	4.0	110	0.36	4.0	175	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	160	0.40	4.0	95	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMM 220416E-DR	**T9325**	1.6	195	0.40	4.0	115	0.36	4.0	185	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMM 270616E-DR	**T9325**	1.6	135	0.40	4.0	80	0.36	4.0	125	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	110	0.40	4.0	65	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
			HR断屑槽，适用于粗加工至重载粗加工，连续切削至间断切削。																	
TNMM 270616E-HR	**T9325**	1.6	90	0.60	7.0	50	0.54	7.0	85	0.60	7.0	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
																				
			NR2断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
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	**T7325**	0.8	145	0.40	4.0	110	0.36	4.0	–	–	–	–	–	–	45	0.28	3.2	–	–	–
	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	**T7325**	1.2	150	0.40	4.0	115	0.36	4.0	–	–	–	–	–	–	45	0.32	3.2	–	–	–
	T8330	1.2	135	0.40	4.0	80	0.36	4.0	125	0.40	4.0	–	–	–	30	0.32	3.2	–	–	–
	T8430	1.2	140	0.40	4.0	75	0.36	4.0	115	0.40	4.0	–	–	–	30	0.32	3.2	–	–	–
	T9325	1.2	170	0.40	4.0	100	0.36	4.0	160	0.40	4.0	–	–	–	35	0.32	3.2	–	–	–
																				
			OR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
TNMM 160408E-OR	**T9315**	0.8	185	0.40	3.0	–	–	–	175	0.40	3.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
TNMM 160412E-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 220408E-OR	**T9315**	0.8	180	0.40	4.0	–	–	–	170	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	160	0.40	4.0	95	0.36	4.0	150	0.40	4.0	–	–	–	35	0.32	3.2	–	–	–
	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	–	–	–
	T9335	1.2	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.32	2.4	–	–	–

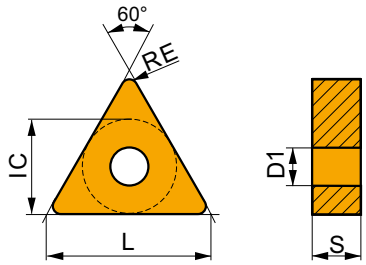
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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断屑槽，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断屑槽，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	–	–	–

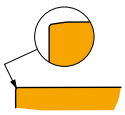
TNGA CER

PRAMET

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



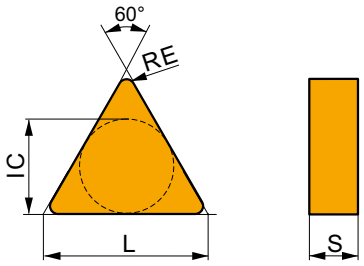
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
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	–	–	–	–	–	–	–	–	–

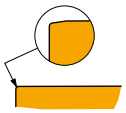
TNGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
1604	9.525	16.50	4.76
1607	9.525	16.50	7.94



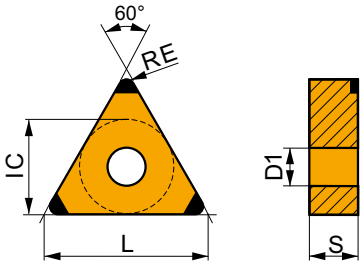
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 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	–	–	–	–	–	–	–	–	–

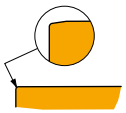
TNGA CBN

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。

产品型号		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 适用于精加工，连续切削。																	
TNGA 160408S01020C	TB310	0.8	–	–	–	–	–	–	450	0.15	0.6	–	–	–	115	0.11	0.5	95	0.15	1.0

DTFN(RL) EXT

P M K N S H

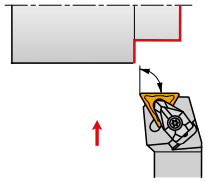
PRAMET

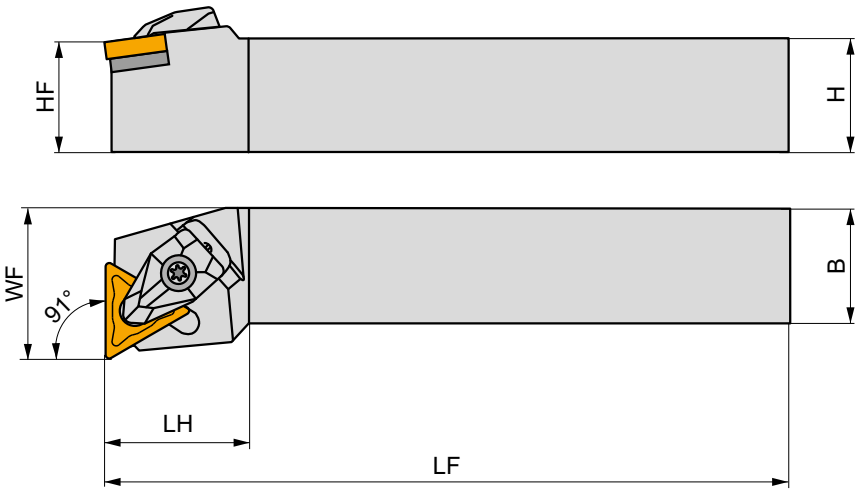
D

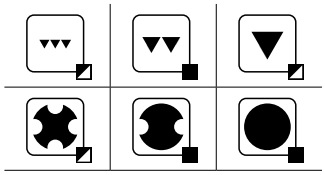


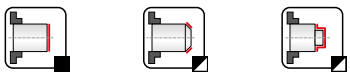
外圆用双重夹紧车刀杆，使用TN..刀片，主偏角为91°（端面）。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**DTFNR 2020 K 16**	20	20	20	25	125	23.6	-6	-6	0.43	GI024	DT16
	DTFNR 2525 M 16	25	25	25	32	150	23.6	-6	-6	0.77	GI024	DT16
	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
	DTFNL 2525 M 16	25	25	25	32	150	23.6	-6	-6	0.76	GI024	DT16
	DTFNL 2525 M 22	25	25	25	32	150	30.5	-6	-6	0.79	GI025	DT22

GI024	TN.. 1604..
GI025	TN.. 2204..

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

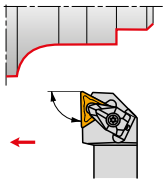
PRAMET

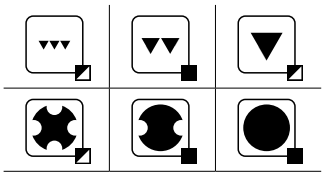
D

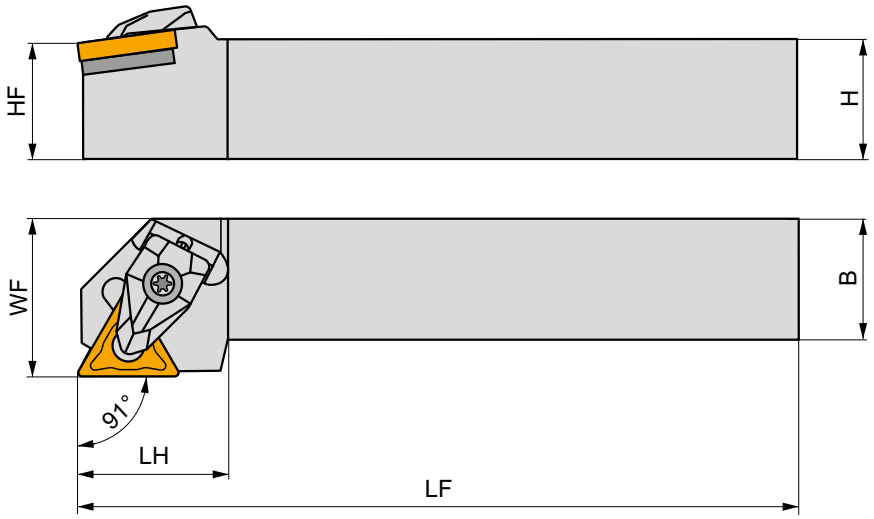


外圆用双重夹紧车刀杆，使用TN..刀片，主偏角为91°。

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。












	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**DTGNR 2020 K 16**	20	20	20	25	125	25.4	-6	-6	0.43	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	0.83	GI025	DT22
	DTGNR 3232 P 22	32	32	32	40	170	33.1	-6	-6	1.42	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
	DTGNL 3232 P 22	32	32	32	40	170	33.1	-6	-6	1.42	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

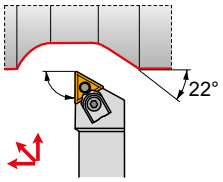
PRAMET

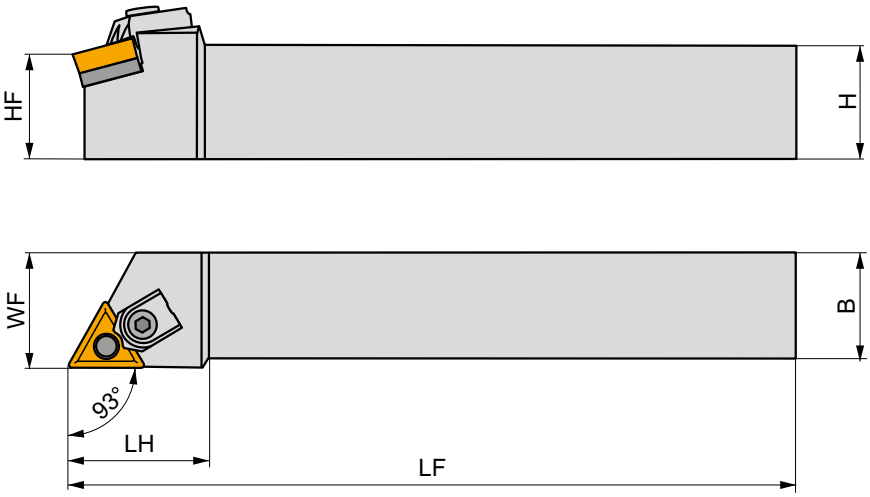
M

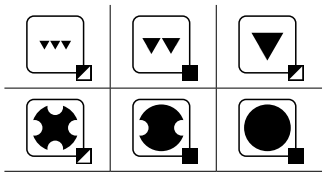


外圆用多重锁紧车刀杆，使用TN..刀片，主偏角为93°。

外圆用左/右手多钳式车刀杆，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。









	产品型号	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	-6	-6	0.42	GI024	MT16
	MTJNR 2525 M 16	25	25	25	32	150	34	-6	-6	0.73	GI024	MT16
	MTJNR 3232 P 22	32	32	32	40	175	42	-6	-6	1.37	GI025	MT22
L	**MTJNL 2020 K 16**	20	20	20	25	125	34	-6	-6	0.43	GI024	MT16
	MTJNL 2525 M 16	25	25	25	32	150	34	-6	-6	0.75	GI024	MT16
	MTJNL 3232 P 22	32	32	32	40	175	42	-6	-6	1.38	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 53	HS 94	HXK 5

PTFN(RL) EXT

P M K N S H

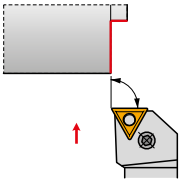
PRAMET

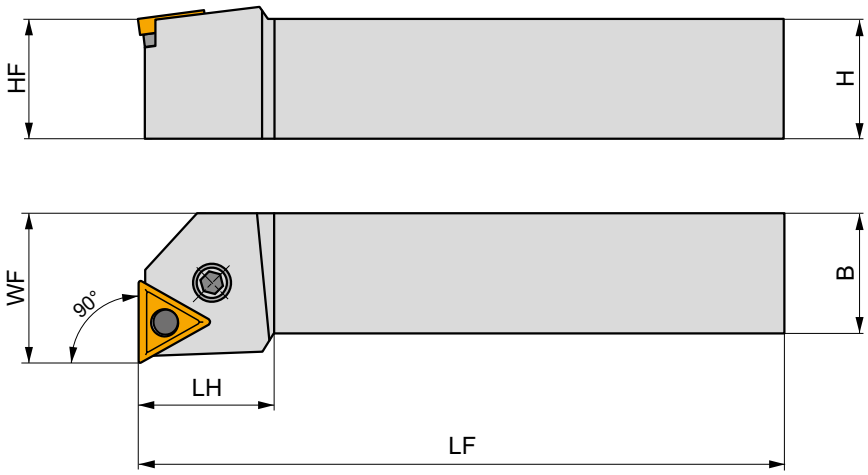
P

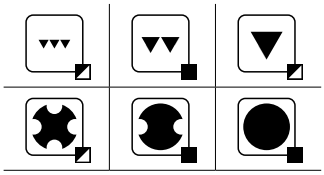


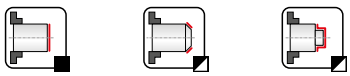
外圆用杠杆锁车削刀杆，使用TN..刀片，主偏角为90°（端面车削）。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PTFNR 1616 H 16**	16	16	16	20	100	32	-6	-6	0.23	GI024	PT11
	PTFNR 2020 K 16	20	20	20	25	125	32	-6	-6	0.44	GI024	PT10
	PTFNR 2525 M 16	25	25	25	32	150	32	-6	-6	0.76	GI024	PT10
	PTFNR 2525 M 22	25	25	25	32	150	36	-6	-6	0.79	GI025	PT20
	PTFNR 3225 P 22	32	25	32	32	170	36	-6	-6	1.05	GI025	PT20
	PTFNR 4040 R 27	40	40	40	50	200	40	-6	-6	2.55	GI077	PT40
L	**PTFNL 1616 H 16**	16	16	16	20	100	32	-6	-6	0.24	GI024	PT11
	PTFNL 2020 K 16	20	20	20	25	125	32	-6	-6	0.43	GI024	PT10
	PTFNL 2525 M 16	25	25	25	32	150	32	-6	-6	0.65	GI024	PT10
	PTFNL 2525 M 22	25	25	25	32	150	36	-6	-6	0.79	GI025	PT20
	PTFNL 3225 P 22	32	25	32	32	170	36	-6	-6	1.14	GI025	PT20
	PTFNL 4040 R 27	40	40	40	50	200	40	-6	-6	2.55	GI077	PT40

GI024	TN.. 1604..
GI025	TN.. 2204..
GI077	TN.. 2706..

				Nm					
PT10	TNU 160308	PU 01	US 34	5.0	M 6x0.75	19	NT 04	MT 04	HXK 3
PT11	TNU 160308	PU 01	US 46	5.0	M 6x0.75	13.2	NT 04	MT 04	HXK 3
PT20	TNU 220312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PT40	TNU 270416	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4

PTGN(RL) EXT

P M K N S H

PRAMET

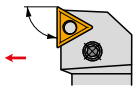
P

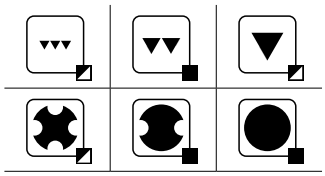


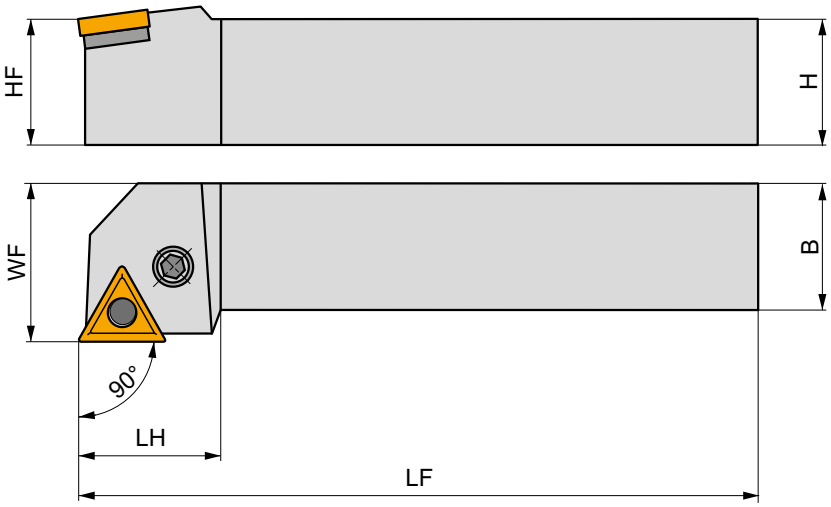
外圆用杠杆夹紧式车刀杆，使用TN..刀片，主偏角为90°。

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。











	产品型号	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	32	-6	-6	0.24	GI024	PT11
	PTGNR 2020 K 16	20	20	20	25	125	32	-6	-6	0.40	GI024	PT10
	PTGNR 2525 M 16	25	25	25	32	150	32	-6	-6	0.73	GI024	PT10
	PTGNR 2525 M 22	25	25	25	32	150	36	-6	-6	0.75	GI025	PT20
	PTGNR 3225 P 22	32	25	32	32	170	36	-6	-6	1.11	GI025	PT20
	PTGNR 3232 P 22	32	32	32	40	170	36	-6	-6	1.39	GI025	PT20
	PTGNR 4040 R 27	40	40	40	50	200	40	-6	-6	2.55	GI077	PT40
L	**PTGNL 1616 H 16**	16	16	16	20	100	32	-6	-6	0.25	GI024	PT11
	PTGNL 2020 K 16	20	20	20	25	125	32	-6	-6	0.40	GI024	PT10
	PTGNL 2525 M 16	25	25	25	32	150	32	-6	-6	0.77	GI024	PT10
	PTGNL 2525 M 22	25	25	25	32	150	36	-6	-6	0.79	GI025	PT20
	PTGNL 3225 P 22	32	25	32	32	170	36	-6	-6	1.11	GI025	PT20
	PTGNL 3232 P 22	32	32	32	40	170	36	-6	-6	1.40	GI025	PT20
	PTGNL 4040 R 27	40	40	40	50	200	40	-6	-6	2.40	GI077	PT40

GI024	TN.. 1604..
GI025	TN.. 2204..
GI077	TN.. 2706..

				Nm					
PT10	TNU 160308	PU 01	US 34	5.0	M 6x0.75	19	NT 04	MT 04	HXK 3
PT11	TNU 160308	PU 01	US 46	5.0	M 6x0.75	13.2	NT 04	MT 04	HXK 3
PT20	TNU 220312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PT40	TNU 270416	PU 04	US 36	6.0	M 8x1	26	NT 07	MT 07	HXK 4

PTTN(RL) EXT

P M K N S H

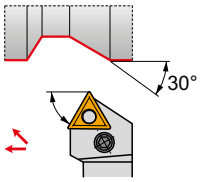
PRAMET

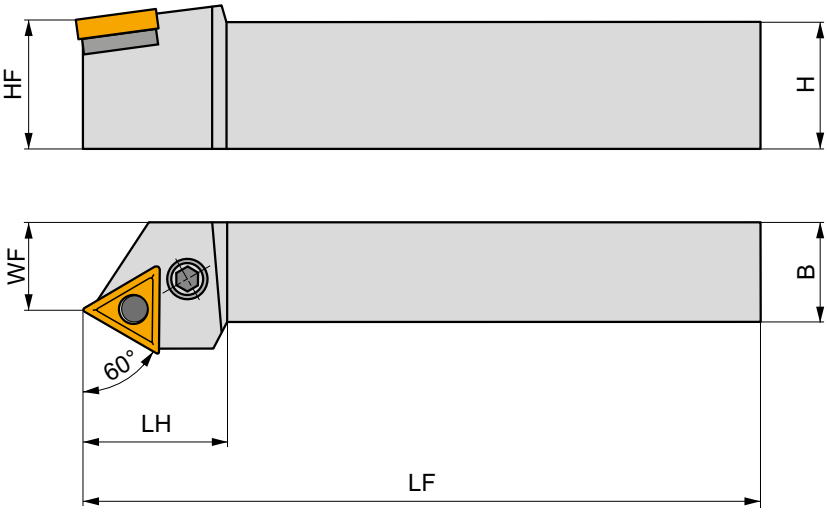
P

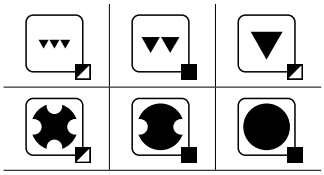
外圆用杠杆夹紧式车刀杆，使用TN..刀片，主偏角为60°。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PTTNR 2020 K 16**	20	20	20	17	125	32	-6	-6	0.43	GI024	PT10
	PTTNR 2525 M 16	25	25	25	22	150	32	-6	-6	0.63	GI024	PT10
	PTTNR 2525 M 22	25	25	25	22	150	36	-6	-6	0.73	GI025	PT20
	PTTNR 3225 P 22	32	25	32	22	170	36	-6	-6	1.07	GI025	PT20
L	**PTTNL 2020 K 16**	20	20	20	17	125	32	-6	-6	0.38	GI024	PT10
	PTTNL 3225 P 22	32	25	32	22	170	36	-6	-6	1.04	GI025	PT20

GI024	TN.. 1604..
GI025	TN.. 2204..

				Nm					
PT10	TNU 160308	PU 01	US 34	5.0	M 6x0.75	19	NT 04	MT 04	HXK 3
PT20	TNU 220312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4

NEW

C.-DTJN(RL) EXT

P M K N S H

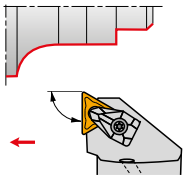
PRAMET

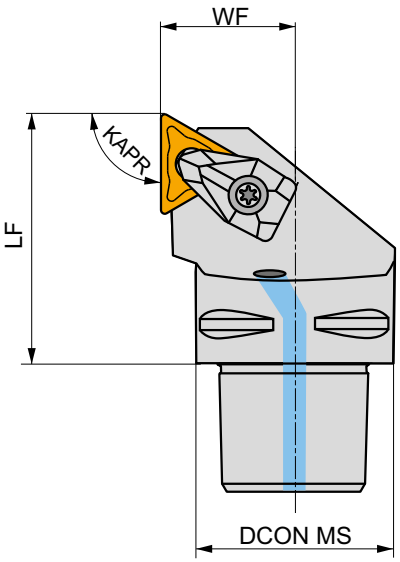
D

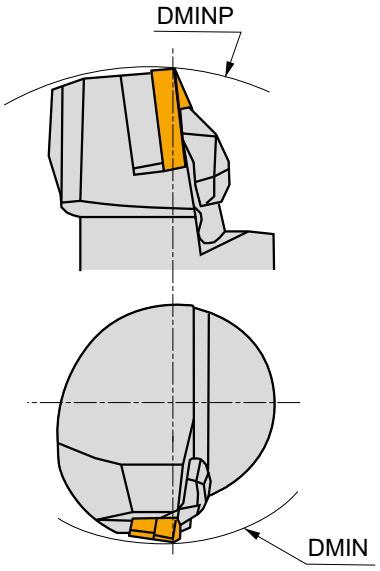


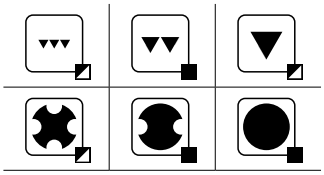
外圆用PSC快速更换式刀柄，双重夹紧，使用TN..刀片，主偏角为93°。

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。











	产品型号	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
	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	✓	0.44	GI024	C-DT16
	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

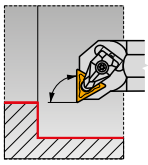
PRAMET

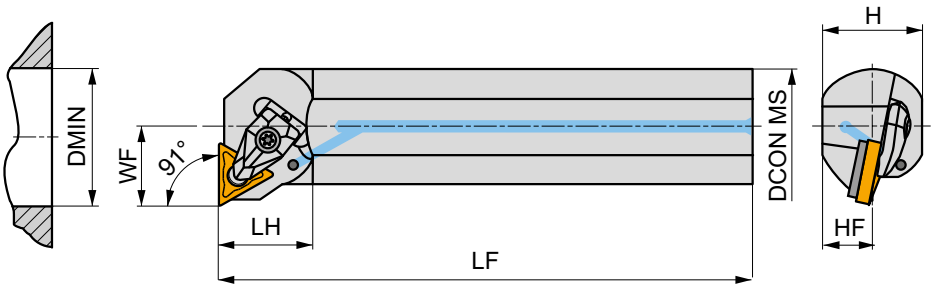
D

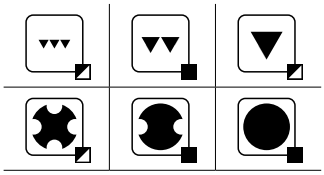


内孔用双重夹紧车刀杆，使用TN..刀片，主偏角为91°。

内孔用左/右手双重夹紧镗杆，有内冷通道，主偏角为91°，使用TN..16和22刀片。内孔最小加工直径为Ø32mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø25至Ø40mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	-12	-6	✓	0.96	GI024	DTI16
	A32T-DTFNR 16	32	40	22	30	15	300	33	-10	-6	✓	1.67	GI024	DTI16
	A40T-DTFNR 22	40	50	27	37	18.5	300	36	-13	-6	✓	2.58	GI025	DT22
L	**A25T-DTFNL 16**	25	32	17	23	11.5	300	32	-12	-6	✓	0.96	GI024	DTI16
	A32T-DTFNL 16	32	40	22	30	15	300	33	-10	-6	✓	1.67	GI024	DTI16
	A40T-DTFNL 22	40	50	27	37	18.5	300	36	-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

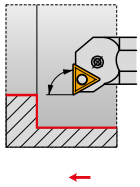
PRAMET

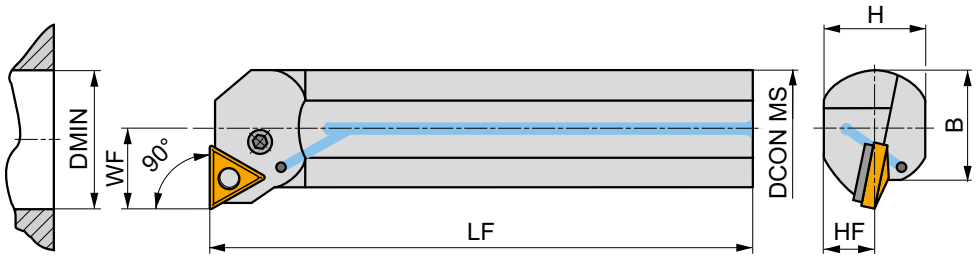
P

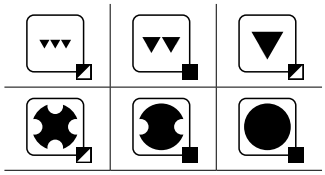


外圆用杠杆夹紧式车刀杆，使用TN..刀片，主偏角为90°。

内孔用左/右手杠杆夹紧式镗杆，有内冷通道，主偏角为90°，TN..16和22刀片。内孔最小加工直径为Ø32mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø25至Ø40mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A25R-PTFNR 16**	25	32	17	23	23	200	-12	-6	✓	0.74	GI024	PT11
	A32S-PTFNR 16	32	40	22	30	30	250	-12	-6	✓	1.49	GI024	PT10
	A40T-PTFNR 22	40	50	27	38	38	300	-12	-6	✓	2.58	GI025	PT20
L	**A25R-PTFNL 16**	25	32	17	23	23	200	-12	-6	✓	0.74	GI024	PT11
	A32S-PTFNL 16	32	40	22	30	30	250	-12	-6	✓	1.48	GI024	PT10
	A40T-PTFNL 22	40	50	27	38	38	300	-12	-6	✓	2.90	GI025	PT20

GI024	TN.. 1604..
GI025	TN.. 2204..

				Nm					
PT10	TNU 160308	PU 01	US 34	5.0	M 6x0.75	19	NT 04	MT 04	HXK 3
PT11	TNU 160308	PU 01	US 46	5.0	M 6x0.75	13.2	NT 04	MT 04	HXK 3
PT20	TNU 220312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4

NEW

C.-DTFN(RL) INT

P M K N S H

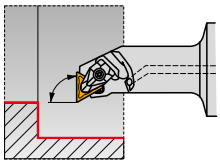
PRAMET

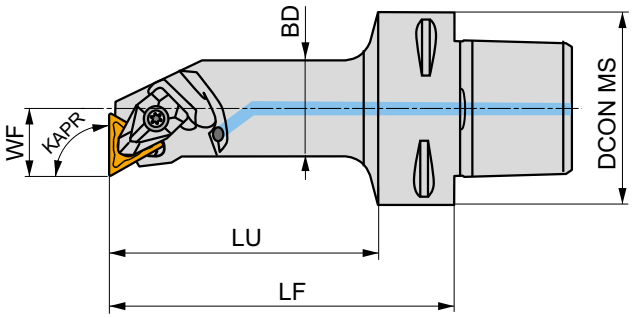
D

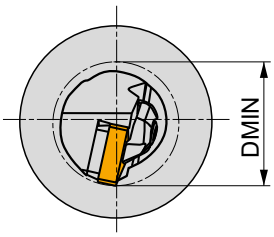


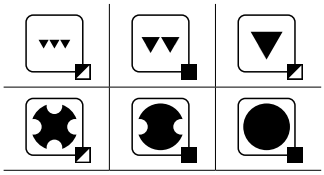
内孔用PSC快速更换式刀柄，双重夹紧，使用TN..刀片，主偏角为91°。

内孔用左/右手双重夹紧紧刀具，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。最小车削直径Ø32mm。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。











	产品型号	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 Nm	DTS 316-01	US 2004-T09P	FLAG T09P

VN 16

硬质合金刀片

VNMG



356

CER和CBN刀片

VNGA CER



359

VNGA CBN



359

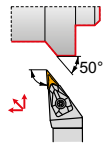
匹配正确的尺寸（示例）

刀片	刀杆
VNMG 160404E-SF	DVJNL 2020 K 16

ISO 外圆车削

DVJN(RL) EXT

93° | VN.. | 16

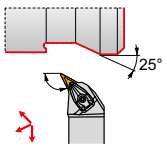


20×20 / 32×25

360 | 356 – 359

DVPN(RL) EXT

62°30′ | VN.. | 16

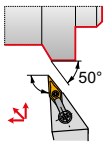


20×20 / 32×25

361 | 356 – 359

MVJN(RL) EXT

93° | VN.. | 16

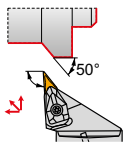


20×20 / 32×25

362 | 356 – 359

C.-DVJN(RL) EXT NEW

93° | VN.. | 16



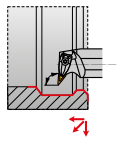
C4 / C6

363 | 356 – 359

ISO内孔车削

DVUN(RL) INT

VN.. | 16



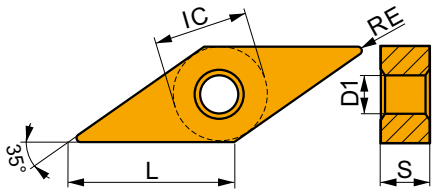
50

364 | 356 – 359

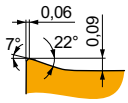
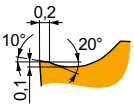
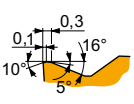
VNMG

PRAMET

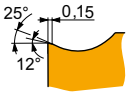
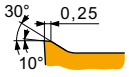
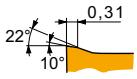
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



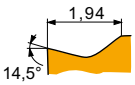
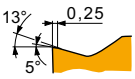
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
FF断屑槽，具有大正前角设计，适用于超精加工，连续切削至轻微断续切削。																				
VNMG 160404E-FF	**T7325**	0.4	◪ 165	0.12	1.0	■ 125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	◪ 150	0.12	1.0	■ 90	0.11	1.0	◪ 140	0.12	1.0	–	–	–	–	–	–	–	–	–
	T8330	0.4	■ 140	0.12	1.0	■ 80	0.11	1.0	◪ 130	0.12	1.0	–	–	–	–	–	–	–	–	–
	T8430	0.4	■ 175	0.12	1.0	■ 95	0.11	1.0	◪ 140	0.12	1.0	–	–	–	–	–	–	–	–	–
																				
FM断屑槽，具有正前角设计，适用于精加工至中粗加工，连续切削至轻微断续切削。																				
VNMG 160404E-FM	**T7325**	0.4	◪ 140	0.20	1.2	◪ 105	0.18	1.2	–	–	–	–	–	–	◪ 45	0.20	1.0	–	–	–
	T8330	0.4	■ 120	0.20	1.2	◪ 70	0.18	1.2	■ 110	0.20	1.2	–	–	–	◪ 30	0.14	1.0	–	–	–
	T8430	0.4	■ 135	0.20	1.2	◪ 75	0.18	1.2	◪ 110	0.20	1.2	–	–	–	◪ 25	0.14	1.0	–	–	–
	T9310	0.4	■ 210	0.20	1.2	–	–	–	◪ 195	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.4	■ 190	0.20	1.2	–	–	–	◪ 180	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 170	0.20	1.2	◪ 100	0.18	1.2	◪ 160	0.20	1.2	–	–	–	◪ 35	0.20	1.0	–	–	–
VNMG 160408E-FM	**T7325**	0.8	◪ 160	0.20	1.4	◪ 120	0.18	1.4	–	–	–	–	–	–	◪ 50	0.16	1.1	–	–	–
	T8330	0.8	■ 145	0.20	1.4	◪ 85	0.18	1.4	■ 135	0.20	1.4	–	–	–	◪ 35	0.16	1.1	–	–	–
	T8430	0.8	■ 165	0.20	1.4	◪ 90	0.18	1.4	◪ 135	0.20	1.4	–	–	–	◪ 35	0.16	1.1	–	–	–
	T9310	0.8	■ 245	0.20	1.4	–	–	–	◪ 230	0.20	1.4	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 220	0.20	1.4	–	–	–	◪ 205	0.20	1.4	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 200	0.20	1.4	◪ 120	0.18	1.4	◪ 190	0.20	1.4	–	–	–	◪ 45	0.16	1.1	–	–	–
VNMG 160412E-FM	**T7325**	1.2	◪ 165	0.22	1.4	◪ 125	0.20	1.4	–	–	–	–	–	–	◪ 50	0.18	1.1	–	–	–
	T8330	1.2	■ 150	0.22	1.4	◪ 90	0.20	1.4	■ 140	0.22	1.4	–	–	–	◪ 35	0.18	1.1	–	–	–
	T8430	1.2	■ 165	0.22	1.4	◪ 90	0.20	1.4	◪ 135	0.22	1.4	–	–	–	◪ 35	0.18	1.1	–	–	–
	T9315	1.2	■ 225	0.22	1.4	–	–	–	◪ 210	0.22	1.4	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 200	0.22	1.4	◪ 120	0.20	1.4	◪ 190	0.22	1.4	–	–	–	◪ 45	0.18	1.1	–	–	–
																				
M断屑槽，适用于精加工至中粗加工，连续至断续切削。																				
VNMG 160404E-M	**T5315**	0.4	◪ 180	0.20	1.2	–	–	–	■ 170	0.20	1.2	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9315	0.4	■ 170	0.20	1.2	–	–	–	◪ 160	0.20	1.2	–	–	–	–	–	–	◪ 30	0.15	1.0
	T9325	0.4	■ 155	0.20	1.2	–	–	–	◪ 145	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9335	0.4	■ 130	0.20	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG 160408E-M	**T5305**	0.8	◪ 205	0.30	1.4	–	–	–	■ 190	0.30	1.4	–	–	–	–	–	–	◪ 40	0.15	1.0
	T5315	0.8	◪ 185	0.30	1.4	–	–	–	■ 175	0.30	1.4	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9310	0.8	■ 185	0.30	1.4	–	–	–	◪ 175	0.30	1.4	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9315	0.8	■ 170	0.30	1.4	–	–	–	◪ 160	0.30	1.4	–	–	–	–	–	–	◪ 30	0.15	1.0
	T9325	0.8	■ 150	0.30	1.4	–	–	–	◪ 140	0.30	1.4	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 130	0.30	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
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。

产品型号		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断屑槽，具有大正前角设计，适用于超精加工至中度加工，连续切削。																	
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	–	–	–
	T7325	0.4	◪ 140	0.18	1.2	■ 105	0.16	1.2	–	–	–	–	–	–	◪ 45	0.16	1.0	–	–	–
	T7335	0.4	◪ 140	0.18	1.2	■ 105	0.16	1.2	–	–	–	–	–	–	◪ 45	0.16	1.0	–	–	–
	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	–	–	–
	T8330	0.4	■ 140	0.12	1.2	■ 80	0.11	1.2	◪ 130	0.12	1.2	◪ 420	0.14	1.2	◪ 35	0.11	1.0	–	–	–
	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	–	–	–
	T9315	0.4	■ 235	0.12	1.2	–	–	–	◪ 220	0.12	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 180	0.18	1.2	■ 105	0.16	1.2	◪ 170	0.18	1.2	–	–	–	◪ 40	0.16	1.0	–	–	–
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	–	–	–
	T7325	0.8	◪ 165	0.18	1.4	■ 125	0.16	1.4	–	–	–	–	–	–	◪ 50	0.16	1.1	–	–	–
	T7335	0.8	◪ 160	0.18	1.4	■ 120	0.16	1.4	–	–	–	–	–	–	◪ 50	0.16	1.1	–	–	–
	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	–	–	–
	T8330	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	–	–	–
	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	–	–	–
	T9315	0.8	■ 240	0.17	1.4	–	–	–	◪ 225	0.17	1.4	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 210	0.18	1.4	■ 125	0.16	1.4	◪ 195	0.18	1.4	–	–	–	◪ 45	0.16	1.1	–	–	–
																				
			NM断屑槽，具有大正前角设计，适用于连续切削的精细，中度和粗加工。																	
VNMG 160404E-NM	**T7325**	0.4	◪ 145	0.20	1.2	■ 110	0.18	1.2	–	–	–	–	–	–	■ 45	0.20	1.0	–	–	–
	T7335	0.4	◪ 140	0.20	1.2	■ 105	0.18	1.2	–	–	–	–	–	–	■ 45	0.20	1.0	–	–	–
	T8315	0.4	◪ 135	0.20	1.2	■ 80	0.18	1.2	–	–	–	◪ 405	0.24	1.2	◪ 30	0.20	1.0	–	–	–
	T8330	0.4	■ 125	0.20	1.2	■ 75	0.18	1.2	–	–	–	◪ 375	0.24	1.2	◪ 30	0.20	1.0	–	–	–
	T8430	0.4	■ 145	0.20	1.2	■ 80	0.18	1.2	–	–	–	◪ 405	0.24	1.2	◪ 30	0.20	1.0	–	–	–
	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	–	–	–
	T7335	0.8	◪ 155	0.25	1.4	■ 120	0.23	1.4	–	–	–	–	–	–	■ 50	0.20	1.1	–	–	–
	T8315	0.8	◪ 145	0.25	1.4	■ 85	0.23	1.4	–	–	–	◪ 435	0.30	1.4	◪ 35	0.20	1.1	–	–	–
	T8330	0.8	■ 140	0.25	1.4	■ 80	0.23	1.4	–	–	–	◪ 420	0.30	1.4	◪ 35	0.20	1.1	–	–	–
	T8430	0.8	■ 155	0.25	1.4	■ 85	0.23	1.4	–	–	–	◪ 435	0.30	1.4	◪ 30	0.20	1.1	–	–	–
	T9325	0.8	■ 190	0.25	1.4	■ 110	0.23	1.4	–	–	–	–	–	–	◪ 40	0.20	1.1	–	–	–
																				
			NMR断屑槽，具有正前角设计，适用于中度至粗加工，连续切削。																	
VNMG 160404E-NMR	**T7325**	0.4	◪ 125	0.20	1.2	■ 95	0.18	1.2	–	–	–	–	–	–	■ 40	0.18	1.0	–	–	–
	T7335	0.4	◪ 120	0.20	1.2	■ 90	0.18	1.2	–	–	–	–	–	–	■ 35	0.18	1.0	–	–	–
	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	–	–	–
	T7335	0.8	◪ 125	0.30	1.4	■ 95	0.27	1.4	–	–	–	–	–	–	■ 40	0.24	1.1	–	–	–
	T8430	0.8	■ 125	0.30	1.4	■ 65	0.27	1.4	–	–	–	–	–	–	◪ 25	0.24	1.1	–	–	–
	T9315	0.8	■ 170	0.30	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 150	0.30	1.4	■ 90	0.27	1.4	–	–	–	–	–	–	◪ 30	0.24	1.1	–	–	–
VNMG 160412E-NMR	**T7325**	1.2	◪ 140	0.30	1.4	■ 105	0.27	1.4	–	–	–	–	–	–	■ 45	0.24	1.1	–	–	–
	T8330	1.2	■ 120	0.30	1.4	■ 70	0.27	1.4	–	–	–	–	–	–	◪ 30	0.24	1.1	–	–	–
	T8430	1.2	■ 130	0.30	1.4	■ 70	0.27	1.4	–	–	–	–	–	–	◪ 25	0.24	1.1	–	–	–
	T9325	1.2	■ 160	0.30	1.4	■ 95	0.27	1.4	–	–	–	–	–	–	◪ 35	0.24	1.1	–	–	–

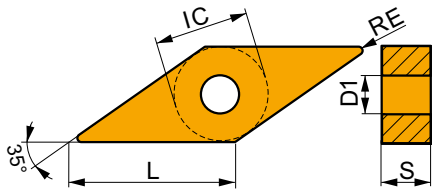
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		
																				
SF断屑槽，具有正前角设计，适用于超精加工和用于薄壁的连续切削加工。																				
VNMG 160404E-SF	**T6310**	0.4	■	135	0.12	1.2	■	95	0.11	1.2	■	105	0.12	1.2	◪	405	0.14	1.2	■	40	0.11	1.0	■	25	0.15	1.0
	T7325	0.4	◪	140	0.17	1.2	■	105	0.15	1.2		–	–	–		–	–	–	■	45	0.15	1.0		–	–	–
	T8315	0.4	◪	140	0.12	1.2	■	80	0.11	1.2	■	130	0.12	1.2	◪	420	0.14	1.2	◪	35	0.11	1.0	■	25	0.15	1.0
	T8330	0.4	■	135	0.12	1.2	■	80	0.11	1.2	■	125	0.12	1.2	◪	405	0.14	1.2	◪	30	0.11	1.0	◪	25	0.15	1.0
	T8430	0.4	■	165	0.12	1.2	■	90	0.11	1.2	◪	135	0.12	1.2	◪	450	0.14	1.2	◪	35	0.11	1.0	◪	25	0.15	1.0
	T9315	0.4	■	225	0.12	1.2		–	–	–	◪	210	0.12	1.2		–	–	–		–	–	–	◪	45	0.15	1.0
	T9325	0.4	■	175	0.17	1.2	■	105	0.15	1.2	◪	165	0.17	1.2		–	–	–	◪	35	0.15	1.0		–	–	–
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	0.15	1.0
	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	0.15	1.0
	T8330	0.8	■	145	0.17	1.4	■	85	0.15	1.4	■	135	0.17	1.4	◪	435	0.20	1.4	◪	35	0.14	1.1	◪	25	0.15	1.0
	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	0.15	1.0
	T9315	0.8	■	230	0.17	1.4		–	–	–	◪	215	0.17	1.4		–	–	–		–	–	–	◪	45	0.15	1.0
	T9325	0.8	■	205	0.17	1.4	■	120	0.15	1.4	◪	190	0.17	1.4		–	–	–	◪	45	0.15	1.1		–	–	–
VNMG 160412E-SF	**T6310**	1.2	■	145	0.20	1.4	■	100	0.18	1.4	■	115	0.20	1.4	◪	435	0.24	1.4	■	40	0.16	1.1	■	25	0.15	1.0
	T7325	1.2	◪	165	0.20	1.4	■	125	0.18	1.4		–	–	–		–	–	–	■	50	0.16	1.1		–	–	–
																				
SM断屑槽，具有正前角设计，适用于中等加工，连续或间断进行切削。																				
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	0.15	1.0
	T7325	0.4	◪	135	0.18	1.2	■	105	0.16	1.2		–	–	–		–	–	–	■	40	0.16	1.0		–	–	–
	T7335	0.4	◪	135	0.18	1.2	■	105	0.16	1.2		–	–	–		–	–	–	■	40	0.16	1.0		–	–	–
	T8330	0.4	■	120	0.18	1.2	■	70	0.16	1.2	■	110	0.18	1.2	◪	360	0.22	1.2	◪	30	0.16	1.0	◪	20	0.15	1.0
	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	0.15	1.0
	T9315	0.4	■	190	0.18	1.2		–	–	–	◪	180	0.18	1.2		–	–	–		–	–	–	◪	35	0.15	1.0
	T9325	0.4	■	170	0.18	1.2	■	100	0.16	1.2	◪	160	0.18	1.2		–	–	–	◪	35	0.16	1.0		–	–	–
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	0.15	1.0
	T7325	0.8	◪	145	0.25	1.4	■	110	0.23	1.4		–	–	–		–	–	–	■	45	0.20	1.1		–	–	–
	T8330	0.8	■	125	0.25	1.4	■	75	0.23	1.4	■	115	0.25	1.4	◪	375	0.30	1.4	◪	30	0.20	1.1	◪	25	0.15	1.0
	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	0.15	1.0
	T9315	0.8	■	195	0.25	1.4		–	–	–	◪	185	0.25	1.4		–	–	–		–	–	–	◪	35	0.15	1.0
	T9325	0.8	■	170	0.25	1.4	■	100	0.23	1.4	◪	160	0.25	1.4		–	–	–	◪	35	0.20	1.1		–	–	–
VNMG 160412E-SM	**T6310**	1.2	■	125	0.30	1.4	■	90	0.27	1.4	■	100	0.30	1.4	◪	375	0.36	1.4	■	35	0.24	1.1	◪	25	0.15	1.0

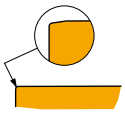
VNGA CER

PRAMET

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



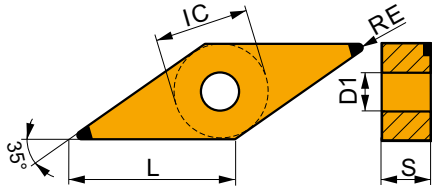
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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																	
			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	–	–	–	–	–	–	–	–	–

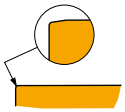
VNGA CBN

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。

产品型号		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																	
			适用于精加工，连续切削。																	
VNGA 160404S01020B	TB310	0.4	–	–	–	–	–	–	360	0.10	0.4	–	–	–	95	0.07	0.3	75	0.15	1.0
VNGA 160408S01020B	TB310	0.8	–	–	–	–	–	–	370	0.15	0.6	–	–	–	95	0.11	0.5	75	0.15	1.0

DVJN(RL) EXT

P M K N S H

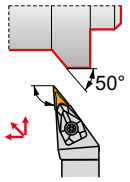
PRAMET

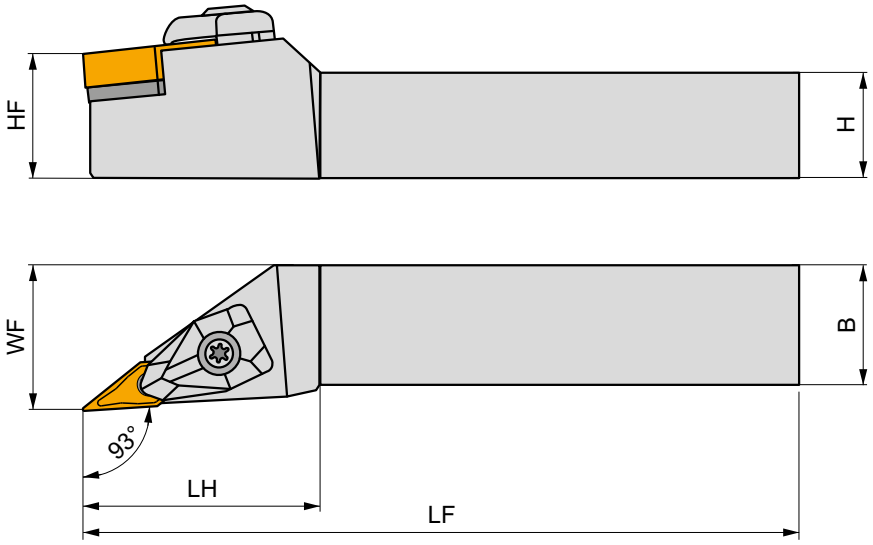
D

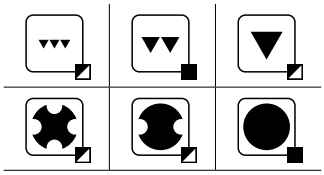


外圆用双重夹紧车刀杆，使用VN..刀片，主偏角为93°。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
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	0.75	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

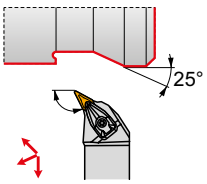
PRAMET

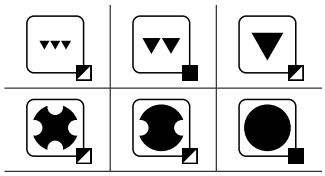
D

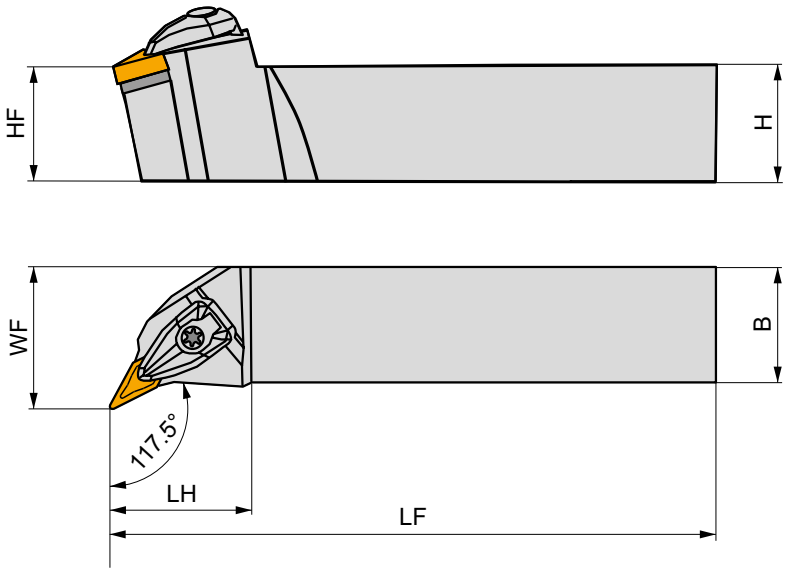


外圆用双重夹紧车刀杆，使用VN..刀片，切削角为117.5°。

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。









	产品型号	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
	DVPNR 3225 P 16	32	25	32	32	170	39.2	-13	-4	1.06	GI048	DV16
L	**DVPNL 2525 M 16**	25	25	25	32	150	39.2	-13	-4	0.74	GI048	DV16
	DVPNL 3225 P 16	32	25	32	32	170	39.2	-13	-4	1.06	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

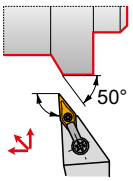
PRAMET

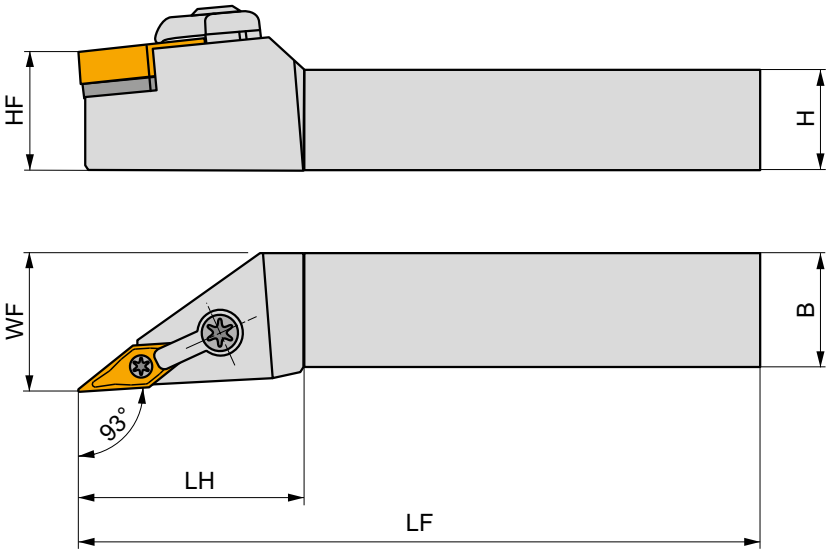
M

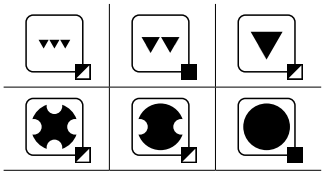


外圆用多重锁紧车刀杆，使用VN..刀片，主偏角为93°。

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。









	产品型号	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	-4.5	-13.5	0.40	GI048	MV2
	MVJNR 2525 M 16-A	25	25	25	32	150	41	-4.5	-13.5	0.70	GI048	MV2
	MVJNR 3225 P 16-A	32	25	32	32	170	41	-4.5	-13.5	0.98	GI048	MV2
L	MVJNL 2020 K 16-A	20	20	20	25	125	41	-4.5	-13.5	0.40	GI048	MV2
	MVJNL 2525 M 16-A	25	25	25	32	150	41	-4.5	-13.5	0.70	GI048	MV2
	MVJNL 3225 P 16-A	32	25	32	32	170	41	-4.5	-13.5	0.96	GI048	MV2

GI048	VN.. 1604..

MV2	UPC 22	MVN 160316	UP 0909-T09P	2.0	PS 6026-T09P	2.0	FLAG T09P

NEW

C.-DVJN(RL) EXT

P M K N S H

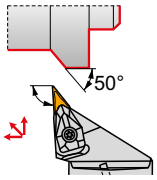
PRAMET

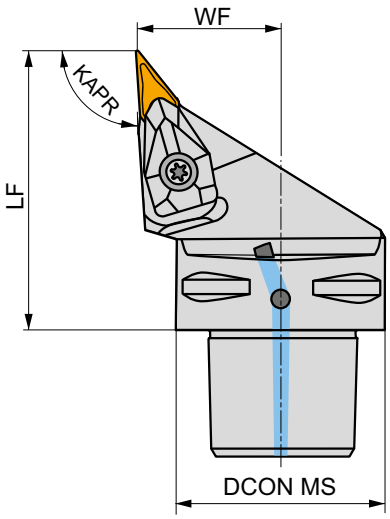
D

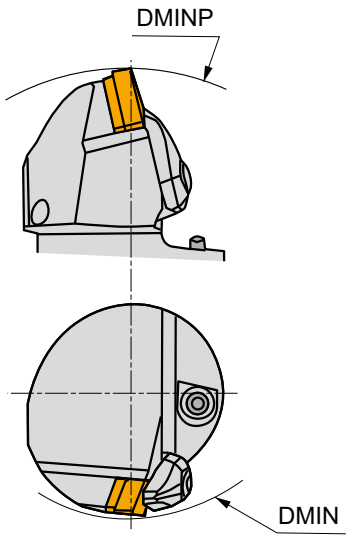


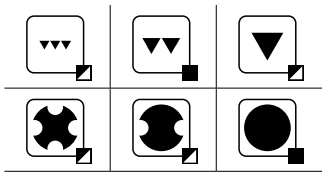
外圆用PSC快速更换式刀柄，双重夹紧，使用VN..刀片，主偏角为93°。

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。











	产品型号	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	✓	0.72	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

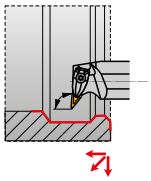
PRAMET

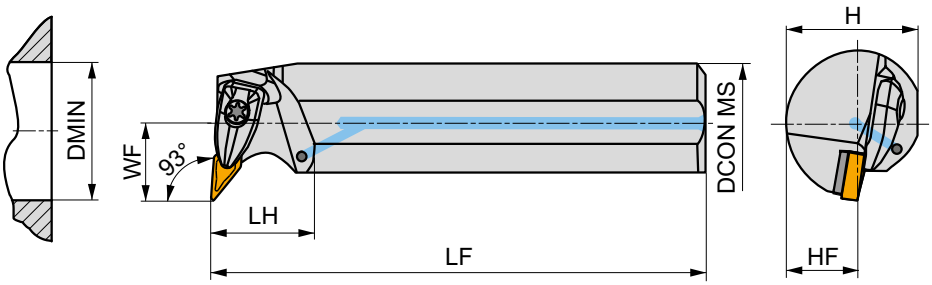
D

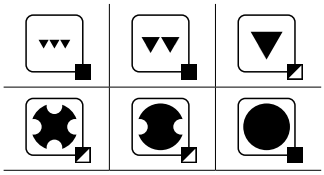


内孔用双重夹紧镗杆，使用VN..刀片，主偏角为93°。

内孔用左/右手双重夹紧具镗杆，有内冷通道，主偏角为93°，使用VN..16刀片。内孔最小加工直径为Ø50mm。适用于内孔锥面，有阶梯孔的轴向车削，仿形和倒角车削。仅适用于Ø40mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	-9	-6	✓	2.59	GI048	DV16
L	**A40T-DVUNL 16**	40	50	27	37	18.5	300	36	-9	-6	✓	2.59	GI048	DV16

GI048	VN.. 1604..

DV16	DCS 16V	3.0 Nm	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

WN

06/ 08/ 10/ 13

硬质合金刀片

WNMA



366

WNMG



366

WNMM



375

CER和CBN刀片

WNGA CBN



376

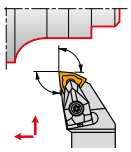
匹配正确的尺寸（示例）

刀片	刀杆
WNMA **08**0408	DWLNL 2020 K **08**

ISO 外圆车削

DWLN(RL) EXT

95°



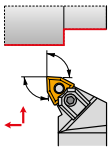
WN..: 06, 08, 10, 13

16×16 / 40×40

377 | 366 – 376

MWLN(RL) EXT

95°



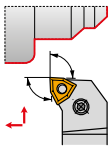
WN..: 08

25×25 / 40×40

379 | 366 – 376

PWLN(RL) EXT

95°



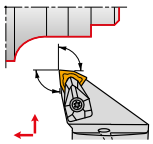
WN..: 06, 08

16×16 / 32×25

380 | 366 – 376

C.-DWLN(RL) EXT NEW

95°



WN..: 06, 08

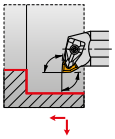
C4 / C6

381 | 366 – 376

ISO内孔车削

DWLN(RL) INT

95°



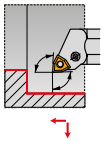
WN..: 06, 08

ØDmin: 32 / 63

382 | 366 – 376

PWLN(RL) INT

95°



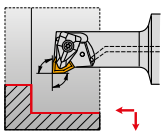
WN..: 06, 08

ØDmin: 20 / 80

383 | 366 – 376

C.-DWLN(RL) INT NEW

95°



WN..: 06, 08

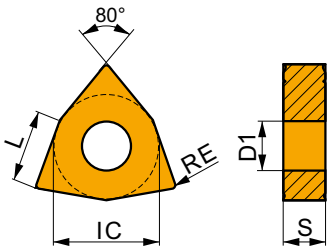
ØDmin: 27 / 33

385 | 366 – 376

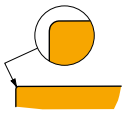
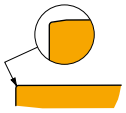
WNMA

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



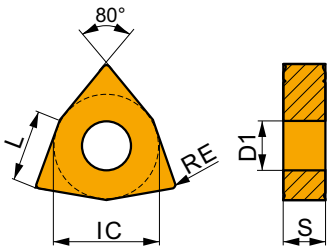
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
			E																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
WNMA 080404	**T5305**	0.4	–	–	–	–	–	–	235	0.10	4.0	–	–	–	–	–	–	50	0.15	1.0
	T5315	0.4	–	–	–	–	–	–	200	0.10	4.0	–	–	–	–	–	–	40	0.15	1.0
WNMA 080408	**T5305**	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	190	0.20	4.0	–	–	–	–	–	–	40	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.15	1.0
WNMA 080412	**T5305**	1.2	–	–	–	–	–	–	195	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.2	–	–	–	–	–	–	180	0.30	4.0	–	–	–	–	–	–	35	0.15	1.0
	T6310	1.2	–	–	–	–	–	–	95	0.30	4.0	–	–	–	–	–	–	20	0.15	1.0
			S																	
			适用于超精加工至中粗加工，连续至轻微断续切削。																	
WNMA 080408S	**T5305**	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.15	1.0

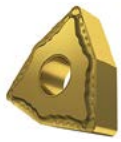
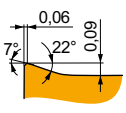
WNMG

PRAMET

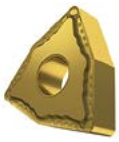
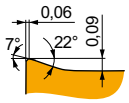
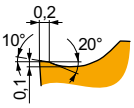
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
06T3	9.525	3.81	6.50	3.97
0804	12.700	5.16	8.70	4.76



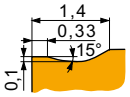
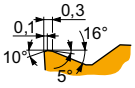
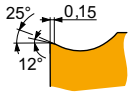
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
			U S																	
			FF断屑槽，具有大正前角设计，适用于超精加工，连续切削至轻微断续切削。																	
WNMG 060402E-FF	**T8315**	0.2	215	0.10	1.0	125	0.09	1.0	200	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	–	–	–	–	–	–	–	–	–

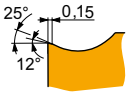
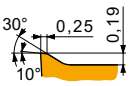
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
			U S																	
			FF断屑槽，具有大正前角设计，适用于超精加工，连续切削至轻微断续切削。																	
WNMG 080404E-FF	**T7325**	0.4	235	0.12	1.0	180	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.4	220	0.12	1.0	130	0.11	1.0	205	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-FF	**T7325**	0.8	265	0.15	1.0	205	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	245	0.15	1.0	145	0.14	1.0	230	0.15	1.0	–	–	–	–	–	–	–	–	–
			1 S																	
			FM断屑槽，具有正前角设计，适用于精加工至中粗加工，连续切削至轻微断续切削。																	
WNMG 060404E-FM	**T7325**	0.4	195	0.20	1.4	150	0.18	1.4	–	–	–	–	–	–	60	0.16	1.1	–	–	–
	T8315	0.4	180	0.20	1.4	105	0.18	1.4	170	0.20	1.4	–	–	–	45	0.14	1.1	–	–	–
	T8330	0.4	175	0.20	1.4	105	0.18	1.4	165	0.20	1.4	–	–	–	40	0.14	1.1	–	–	–
	T8430	0.4	195	0.20	1.4	105	0.18	1.4	160	0.20	1.4	–	–	–	40	0.14	1.1	–	–	–
	T9315	0.4	265	0.20	1.4	–	–	–	250	0.20	1.4	–	–	–	–	–	–	–	–	–
	T9325	0.4	240	0.20	1.4	140	0.18	1.4	225	0.20	1.4	–	–	–	50	0.16	1.1	–	–	–
	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	–	–	–
	T8330	0.8	205	0.20	1.4	120	0.18	1.4	190	0.20	1.4	–	–	–	50	0.14	1.1	–	–	–
	T8430	0.8	235	0.20	1.4	125	0.18	1.4	190	0.20	1.4	–	–	–	50	0.14	1.1	–	–	–
	T9315	0.8	315	0.20	1.4	–	–	–	295	0.20	1.4	–	–	–	–	–	–	–	–	–
	T9325	0.8	285	0.20	1.4	170	0.18	1.4	270	0.20	1.4	–	–	–	60	0.16	1.1	–	–	–
WNMG 060412E-FM	**T9315**	1.2	300	0.27	1.2	–	–	–	285	0.27	1.2	–	–	–	–	–	–	–	–	–
WNMG 06T304E-FM	**T7325**	0.4	195	0.20	1.4	150	0.18	1.4	–	–	–	–	–	–	60	0.16	1.1	–	–	–
	T8330	0.4	175	0.20	1.4	105	0.18	1.4	165	0.20	1.4	–	–	–	40	0.14	1.1	–	–	–
	T8430	0.4	195	0.20	1.4	105	0.18	1.4	160	0.20	1.4	–	–	–	40	0.14	1.1	–	–	–
	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	**T8330**	0.8	205	0.20	1.4	120	0.18	1.4	190	0.20	1.4	–	–	–	50	0.14	1.1	–	–	–
	T8430	0.8	235	0.20	1.4	125	0.18	1.4	190	0.20	1.4	–	–	–	50	0.14	1.1	–	–	–
	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	–	–	–
	T7335	0.4	180	0.20	1.9	140	0.18	1.9	–	–	–	–	–	–	55	0.16	1.5	–	–	–
	T8315	0.4	180	0.20	1.9	105	0.18	1.9	170	0.20	1.9	–	–	–	45	0.14	1.5	–	–	–
	T8330	0.4	165	0.20	1.9	95	0.18	1.9	155	0.20	1.9	–	–	–	40	0.14	1.5	–	–	–
	T8430	0.4	190	0.20	1.9	105	0.18	1.9	155	0.20	1.9	–	–	–	40	0.14	1.5	–	–	–
	T9310	0.4	285	0.20	1.9	–	–	–	270	0.20	1.9	–	–	–	–	–	–	–	–	–
	T9315	0.4	270	0.20	1.2	–	–	–	255	0.20	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.4	245	0.20	1.2	145	0.18	1.2	230	0.20	1.2	–	–	–	55	0.16	1.0	–	–	–
WNMG 080408E-FM	**T7325**	0.8	225	0.20	1.9	175	0.18	1.9	–	–	–	–	–	–	70	0.16	1.5	–	–	–
	T7335	0.8	215	0.20	1.9	165	0.18	1.9	–	–	–	–	–	–	65	0.16	1.5	–	–	–
	T8315	0.8	210	0.20	1.9	125	0.18	1.9	195	0.20	1.9	–	–	–	50	0.16	1.5	–	–	–
	T8330	0.8	195	0.20	1.9	115	0.18	1.9	185	0.20	1.9	–	–	–	45	0.16	1.5	–	–	–
	T8430	0.8	225	0.20	1.9	120	0.18	1.9	185	0.20	1.9	–	–	–	45	0.16	1.5	–	–	–
	T9310	0.8	335	0.20	1.9	–	–	–	315	0.20	1.9	–	–	–	–	–	–	–	–	–
	T9315	0.8	310	0.20	1.9	–	–	–	290	0.20	1.9	–	–	–	–	–	–	–	–	–
	T9325	0.8	280	0.20	1.9	165	0.18	1.9	265	0.20	1.9	–	–	–	60	0.16	1.5	–	–	–
WNMG 080412E-FM	**T7325**	1.2	220	0.27	1.9	170	0.24	1.9	–	–	–	–	–	–	70	0.19	1.5	–	–	–
	T7335	1.2	205	0.27	1.9	155	0.24	1.9	–	–	–	–	–	–	65	0.19	1.5	–	–	–
	T8330	1.2	190	0.27	1.9	110	0.24	1.9	180	0.27	1.9	–	–	–	45	0.19	1.5	–	–	–
	T8430	1.2	210	0.27	1.9	115	0.24	1.9	175	0.27	1.9	–	–	–	45	0.19	1.5	–	–	–
	T9310	1.2	310	0.27	1.9	–	–	–	290	0.27	1.9	–	–	–	–	–	–	–	–	–
	T9315	1.2	285	0.27	1.9	–	–	–	270	0.27	1.9	–	–	–	–	–	–	–	–	–
	T9325	1.2	255	0.27	1.9	150	0.24	1.9	240	0.27	1.9	–	–	–	55	0.19	1.5	–	–	–

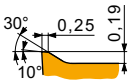
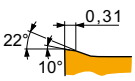
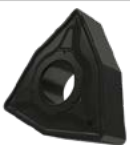
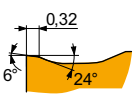
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
KR断屑槽，适用于中粗加工至重载粗加工，连续至断续切削。																				
WNMG 080408E-KR	**T5305**	0.8	255	0.35	3.5	–	–	–	240	0.35	3.5	–	–	–	–	–	–	50	0.15	1.0
	T5315	0.8	230	0.35	3.5	–	–	–	215	0.35	3.5	–	–	–	–	–	–	45	0.15	1.0
WNMG 080412E-KR	**T5305**	1.2	260	0.40	3.5	–	–	–	245	0.40	3.5	–	–	–	–	–	–	50	0.15	1.0
	T5315	1.2	235	0.40	3.5	–	–	–	220	0.40	3.5	–	–	–	–	–	–	45	0.15	1.0
																				
M断屑槽，适用于精加工至中粗加工，连续至断续切削。																				
WNMG 060404E-M	**T5315**	0.4	250	0.20	1.8	–	–	–	235	0.20	1.8	–	–	–	–	–	–	50	0.15	1.0
	T9315	0.4	240	0.20	1.8	–	–	–	225	0.20	1.8	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.4	215	0.20	1.8	–	–	–	200	0.20	1.8	–	–	–	–	–	–	–	–	–
	T9335	0.4	180	0.20	1.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 060408E-M	**T5315**	0.8	255	0.32	1.8	–	–	–	240	0.32	1.8	–	–	–	–	–	–	50	0.15	1.0
	T9310	0.8	250	0.32	1.8	–	–	–	235	0.32	1.8	–	–	–	–	–	–	50	0.15	1.0
	T9315	0.8	230	0.32	1.8	–	–	–	215	0.32	1.8	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.8	205	0.32	1.8	–	–	–	190	0.32	1.8	–	–	–	–	–	–	–	–	–
	T9335	0.8	180	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080404E-M	**T5315**	0.4	260	0.20	1.2	–	–	–	245	0.20	1.2	–	–	–	–	–	–	50	0.15	1.0
	T9315	0.4	235	0.20	2.1	–	–	–	220	0.20	2.1	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.4	210	0.20	2.1	–	–	–	195	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9335	0.4	180	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-M	**T5305**	0.8	280	0.32	2.1	–	–	–	265	0.32	2.1	–	–	–	–	–	–	55	0.15	1.0
	T5315	0.8	250	0.32	2.1	–	–	–	235	0.32	2.1	–	–	–	–	–	–	50	0.15	1.0
	T8330	0.8	155	0.32	2.1	–	–	–	145	0.32	2.1	–	–	–	–	–	–	30	0.15	1.0
	T8430	0.8	170	0.32	2.1	–	–	–	135	0.32	2.1	–	–	–	–	–	–	25	0.15	1.0
	T9310	0.8	245	0.32	2.1	–	–	–	230	0.32	2.1	–	–	–	–	–	–	45	0.15	1.0
	T9315	0.8	225	0.32	2.1	–	–	–	210	0.32	2.1	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.8	200	0.32	2.1	–	–	–	190	0.32	2.1	–	–	–	–	–	–	–	–	–
	T9335	0.8	180	0.32	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-M	**T5305**	1.2	275	0.40	2.1	–	–	–	260	0.40	2.1	–	–	–	–	–	–	55	0.15	1.0
	T5315	1.2	245	0.40	2.1	–	–	–	230	0.40	2.1	–	–	–	–	–	–	45	0.15	1.0
	T9310	1.2	235	0.40	2.1	–	–	–	220	0.40	2.1	–	–	–	–	–	–	45	0.15	1.0
	T9315	1.2	220	0.40	2.1	–	–	–	205	0.40	2.1	–	–	–	–	–	–	40	0.15	1.0
	T9325	1.2	195	0.40	2.1	–	–	–	185	0.40	2.1	–	–	–	–	–	–	–	–	–
	T9335	1.2	170	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
NF断屑槽，具有大正前角设计，适用于超精加工至中度加工，连续切削。																				
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	–	–	–
	T7325	0.4	215	0.18	0.8	165	0.16	0.8	–	–	–	–	–	–	65	0.16	0.6	–	–	–
	T7335	0.4	210	0.18	0.8	160	0.16	0.8	–	–	–	–	–	–	65	0.16	0.6	–	–	–
	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	–	–	–
	T8330	0.4	190	0.17	0.8	110	0.15	0.8	180	0.17	0.8	570	0.20	0.8	45	0.12	0.6	–	–	–
	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	–	–	–
	T9315	0.4	305	0.17	0.8	–	–	–	285	0.17	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.4	265	0.18	0.8	155	0.16	0.8	250	0.18	0.8	–	–	–	55	0.16	0.6	–	–	–
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	–	–	–
	T7325	0.8	245	0.19	1.0	190	0.17	1.0	–	–	–	–	–	–	75	0.15	0.8	–	–	–
	T8330	0.8	215	0.19	1.0	125	0.17	1.0	200	0.19	1.0	645	0.23	1.0	50	0.15	0.8	–	–	–
	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	–	–	–
	T9315	0.8	335	0.19	1.0	–	–	–	315	0.19	1.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	300	0.19	1.0	180	0.17	1.0	285	0.19	1.0	–	–	–	65	0.15	0.8	–	–	–

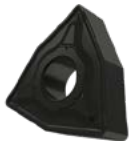
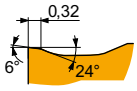
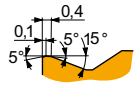
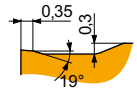
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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断屑槽，具有大正前角设计，适用于超精加工至中度加工，连续切削。																	
WNMG 080404E-NF	**HF7**	0.4	–	–	–	95	0.15	1.7	155	0.17	1.7	495	0.20	1.7	–	–	–	–	–	–
	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	–	–	–
	T7325	0.4	200	0.18	1.7	155	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–
	T7335	0.4	195	0.18	1.7	150	0.16	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
	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	–	–	–
	T8330	0.4	180	0.17	1.7	105	0.15	1.7	170	0.17	1.7	540	0.20	1.7	45	0.14	1.4	–	–	–
	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	–	–	–
	T9315	0.4	285	0.17	1.7	–	–	–	270	0.17	1.7	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–
	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	–	–	–
	T7325	0.8	235	0.19	1.7	180	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
	T7335	0.8	225	0.19	1.7	175	0.17	1.7	–	–	–	–	–	–	70	0.15	1.4	–	–	–
	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	–	–	–
	T8330	0.8	200	0.19	1.7	120	0.17	1.7	190	0.19	1.7	600	0.23	1.7	50	0.15	1.4	–	–	–
	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	–	–	–
	T9315	0.8	320	0.19	1.7	–	–	–	300	0.19	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	285	0.19	1.7	170	0.17	1.7	270	0.19	1.7	–	–	–	60	0.15	1.4	–	–	–
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	–	–	–
	T7325	1.2	205	0.30	2.1	155	0.27	2.1	–	–	–	–	–	–	65	0.21	1.7	–	–	–
	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	–	–	–
	T9315	1.2	275	0.30	2.1	–	–	–	260	0.30	2.1	–	–	–	–	–	–	–	–	–
	T9325	1.2	245	0.30	2.1	145	0.27	2.1	230	0.30	2.1	–	–	–	55	0.21	1.7	–	–	–
																				
			NM断屑槽，具有大正前角设计，适用于连续切削的精细，中度和粗加工。																	
WNMG 060404E-NM	**T7325**	0.4	200	0.20	1.8	155	0.18	1.8	–	–	–	–	–	–	65	0.16	1.4	–	–	–
	T7335	0.4	195	0.20	1.8	150	0.18	1.8	–	–	–	–	–	–	60	0.16	1.4	–	–	–
	T8315	0.4	185	0.20	1.8	110	0.18	1.8	–	–	–	555	0.24	1.8	45	0.16	1.4	–	–	–
	T8330	0.4	175	0.20	1.8	105	0.18	1.8	–	–	–	525	0.24	1.8	40	0.16	1.4	–	–	–
	T8430	0.4	185	0.25	1.8	100	0.23	1.8	–	–	–	510	0.30	1.8	40	0.20	1.4	–	–	–
	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	–	–	–
	T7335	0.8	215	0.25	1.8	165	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
	T8315	0.8	205	0.25	1.8	120	0.23	1.8	–	–	–	615	0.30	1.8	50	0.20	1.4	–	–	–
	T8330	0.8	195	0.25	1.8	115	0.23	1.8	–	–	–	585	0.30	1.8	45	0.20	1.4	–	–	–
	T8430	0.8	220	0.25	1.8	120	0.23	1.8	–	–	–	600	0.30	1.8	45	0.20	1.4	–	–	–
	T9315	0.8	290	0.25	1.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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	–	–	–
	T7335	1.2	220	0.30	1.2	170	0.27	1.2	–	–	–	–	–	–	70	0.24	1.0	–	–	–
	T9315	1.2	285	0.30	1.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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	–	–	–
	T7335	0.4	190	0.20	2.1	145	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
	T8315	0.4	180	0.20	2.1	105	0.18	2.1	–	–	–	540	0.24	2.1	45	0.16	1.7	–	–	–
	T8330	0.4	170	0.20	2.1	100	0.18	2.1	–	–	–	510	0.24	2.1	40	0.16	1.7	–	–	–
	T8430	0.4	180	0.25	2.1	95	0.23	2.1	–	–	–	495	0.30	2.1	35	0.20	1.7	–	–	–
	T9315	0.4	270	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.4	240	0.20	2.1	140	0.18	2.1	–	–	–	–	–	–	50	0.16	1.7	–	–	–

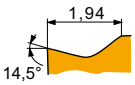
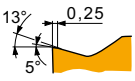
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
NM断屑槽，具有大正前角设计，适用于连续切削的精细，中度和粗加工。																				
WNMG 080408E-NM	**T7325**	0.8	215	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
	T7335	0.8	210	0.25	2.1	160	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
	T8315	0.8	205	0.25	2.1	120	0.23	2.1	–	–	–	615	0.30	2.1	50	0.20	1.7	–	–	–
	T8330	0.8	195	0.25	2.1	115	0.23	2.1	–	–	–	585	0.30	2.1	45	0.20	1.7	–	–	–
	T8430	0.8	210	0.25	2.1	115	0.23	2.1	–	–	–	585	0.30	2.1	45	0.20	1.7	–	–	–
	T9315	0.8	290	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	260	0.25	2.1	155	0.23	2.1	–	–	–	–	–	–	55	0.20	1.7	–	–	–
WNMG 080412E-NM	**T7325**	1.2	215	0.30	2.1	165	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
	T7335	1.2	210	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
	T8315	1.2	205	0.30	2.1	120	0.27	2.1	–	–	–	615	0.36	2.1	50	0.24	1.7	–	–	–
	T9325	1.2	255	0.30	2.1	150	0.27	2.1	–	–	–	–	–	–	55	0.24	1.7	–	–	–
																				
NMR断屑槽，具有正前角设计，适用于中度至粗加工，连续切削。																				
WNMG 060404E-NMR	**T6310**	0.4	145	0.25	1.6	100	0.23	1.6	–	–	–	–	–	–	40	0.20	1.3	–	–	–
	T7325	0.4	160	0.25	1.6	120	0.23	1.6	–	–	–	–	–	–	50	0.20	1.3	–	–	–
	T8430	0.4	145	0.31	1.6	80	0.28	1.6	–	–	–	–	–	–	30	0.25	1.3	–	–	–
	T9325	0.4	200	0.25	1.6	120	0.23	1.6	–	–	–	–	–	–	45	0.20	1.3	–	–	–
WNMG 060408E-NMR	**T6310**	0.8	155	0.35	1.6	110	0.32	1.6	–	–	–	–	–	–	45	0.25	1.3	–	–	–
	T7325	0.8	175	0.35	1.6	135	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
	T7335	0.8	170	0.35	1.6	130	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
	T9315	0.8	225	0.35	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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	–	–	–
	T7325	0.4	155	0.25	2.7	120	0.23	2.7	–	–	–	–	–	–	50	0.20	2.2	–	–	–
	T7335	0.4	150	0.25	2.7	115	0.23	2.7	–	–	–	–	–	–	45	0.20	2.2	–	–	–
	T8330	0.4	140	0.25	2.7	80	0.23	2.7	–	–	–	–	–	–	35	0.20	2.2	–	–	–
	T8430	0.4	140	0.31	2.7	75	0.28	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
	T9315	0.4	205	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.4	185	0.25	2.7	110	0.23	2.7	–	–	–	–	–	–	40	0.20	2.2	–	–	–
WNMG 080408E-NMR	**T6310**	0.8	150	0.35	2.7	105	0.32	2.7	–	–	–	–	–	–	45	0.25	2.2	–	–	–
	T7325	0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.25	2.2	–	–	–
	T7335	0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.25	2.2	–	–	–
	T8330	0.8	150	0.35	2.7	90	0.32	2.7	–	–	–	–	–	–	35	0.25	2.2	–	–	–
	T8430	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
	T9315	0.8	210	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	190	0.35	2.7	110	0.32	2.7	–	–	–	–	–	–	40	0.25	2.2	–	–	–
WNMG 080412E-NMR	**T6310**	1.2	150	0.40	2.7	105	0.36	2.7	–	–	–	–	–	–	45	0.28	2.2	–	–	–
	T7325	1.2	170	0.40	2.7	130	0.36	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
	T7335	1.2	160	0.40	2.7	120	0.36	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
	T8330	1.2	150	0.40	2.7	90	0.36	2.7	–	–	–	–	–	–	35	0.28	2.2	–	–	–
	T8430	1.2	155	0.40	2.7	85	0.36	2.7	–	–	–	–	–	–	30	0.28	2.2	–	–	–
	T9315	1.2	215	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.2	190	0.40	2.7	110	0.36	2.7	–	–	–	–	–	–	40	0.28	2.2	–	–	–
																				
NRM断屑槽，具有正前角设计，适用于中粗加工至粗加工，连续至中等间断切削。																				
WNMG 080404-NRM	**T7325**	0.4	155	0.25	2.7	120	0.23	2.7	–	–	–	–	–	–	50	0.18	2.2	–	–	–
	T7335	0.4	150	0.25	2.7	115	0.23	2.7	–	–	–	–	–	–	45	0.18	2.2	–	–	–
	T9315	0.4	205	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408-NRM	**T7325**	0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
	T7335	0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
	T9315	0.8	210	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

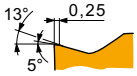
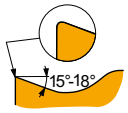
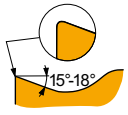
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
			NRM断屑槽，具有正前角设计，适用于中粗加工至粗加工，连续至中等间断切削。																	
WNMG 080412-NRM	T7325	1.2	◪ 170	0.40	2.7	■ 130	0.36	2.7	–	–	–	–	–	–	■ 55	0.28	2.2	–	–	–
	T7335	1.2	◪ 160	0.40	2.7	■ 120	0.36	2.7	–	–	–	–	–	–	■ 50	0.28	2.2	–	–	–
	T9315	1.2	■ 215	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
			R断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
WNMG 080408E-R	T5305	0.8	◪ 245	0.40	3.5	–	–	–	■ 230	0.40	3.5	–	–	–	–	–	–	◪ 45	0.15	1.0
	T5315	0.8	◪ 220	0.40	3.5	–	–	–	■ 205	0.40	3.5	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9310	0.8	■ 210	0.40	3.5	–	–	–	◪ 195	0.40	3.5	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	0.8	■ 195	0.40	3.5	–	–	–	◪ 185	0.40	3.5	–	–	–	–	–	–	◪ 35	0.15	1.0
	T9325	0.8	■ 175	0.40	3.5	–	–	–	◪ 165	0.40	3.5	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 155	0.40	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-R	T5305	1.2	◪ 250	0.45	3.5	–	–	–	■ 235	0.45	3.5	–	–	–	–	–	–	◪ 50	0.15	1.0
	T5315	1.2	◪ 225	0.45	3.5	–	–	–	■ 210	0.45	3.5	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9310	1.2	■ 215	0.45	3.5	–	–	–	◪ 200	0.45	3.5	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9315	1.2	■ 200	0.45	3.5	–	–	–	◪ 190	0.45	3.5	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	1.2	■ 180	0.45	3.5	–	–	–	◪ 170	0.45	3.5	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 155	0.45	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
			RM断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
WNMG 060412E-RM	T9310	1.2	■ 245	0.45	3.0	–	–	–	◪ 230	0.45	3.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 230	0.45	3.0	–	–	–	◪ 215	0.45	3.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 230	0.45	1.2	◪ 135	0.41	1.2	◪ 215	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM	T5305	0.8	◪ 275	0.40	4.0	–	–	–	◪ 260	0.40	4.0	–	–	–	–	–	–	–	–	–
	T5315	0.8	◪ 250	0.40	4.0	–	–	–	◪ 235	0.40	4.0	–	–	–	–	–	–	–	–	–
	T7325	0.8	◪ 180	0.40	4.0	◪ 140	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	◪ 165	0.40	4.0	◪ 125	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	◪ 165	0.40	4.0	◪ 95	0.36	4.0	◪ 155	0.40	4.0	–	–	–	–	–	–	–	–	–
	T8330	0.8	■ 155	0.40	4.0	◪ 90	0.36	4.0	◪ 145	0.40	4.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	■ 165	0.40	4.0	◪ 90	0.36	4.0	◪ 135	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9310	0.8	■ 240	0.40	4.0	–	–	–	◪ 225	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 220	0.40	4.0	–	–	–	◪ 205	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 200	0.40	4.0	◪ 120	0.36	4.0	◪ 190	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	■ 170	0.40	4.0	◪ 100	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-RM	T5305	1.2	◪ 280	0.45	4.0	–	–	–	◪ 265	0.45	4.0	–	–	–	–	–	–	–	–	–
	T5315	1.2	◪ 250	0.45	4.0	–	–	–	◪ 235	0.45	4.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	◪ 180	0.45	4.0	◪ 140	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	◪ 170	0.45	4.0	◪ 130	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	1.2	◪ 170	0.45	4.0	◪ 100	0.41	4.0	◪ 160	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9310	1.2	■ 240	0.45	4.0	–	–	–	◪ 225	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 220	0.45	4.0	–	–	–	◪ 205	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 200	0.45	4.0	◪ 120	0.41	4.0	◪ 190	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 175	0.45	4.0	◪ 105	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080416E-RM	T5305	1.6	◪ 280	0.50	4.0	–	–	–	◪ 265	0.50	4.0	–	–	–	–	–	–	–	–	–
	T5315	1.6	◪ 255	0.50	4.0	–	–	–	◪ 240	0.50	4.0	–	–	–	–	–	–	–	–	–
	T7335	1.6	◪ 175	0.50	4.0	◪ 135	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8430	1.6	■ 170	0.50	4.0	◪ 90	0.45	4.0	◪ 135	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9310	1.6	■ 240	0.50	4.0	–	–	–	◪ 225	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9315	1.6	■ 220	0.50	4.0	–	–	–	◪ 205	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	■ 205	0.50	4.0	◪ 120	0.45	4.0	◪ 190	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	■ 175	0.50	4.0	◪ 105	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–

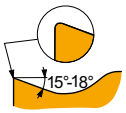
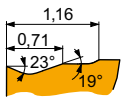
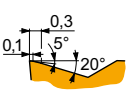
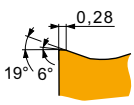
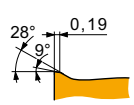
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		
																				
SF断屑槽，具有正前角设计，适用于超精加工和用于薄壁的连续切削加工。																				
WNMG 060404E-SF	**H07**	0.4	–	–	–	90	0.14	1.0	145	0.15	1.0	470	0.18	1.0	45	0.12	0.8	–	–	–
	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	0.15	1.0
	T7325	0.4	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
	T7335	0.4	200	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
	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	0.15	1.0
	T8330	0.4	180	0.15	1.0	105	0.14	1.0	170	0.15	1.0	540	0.18	1.0	45	0.12	0.8	35	0.15	1.0
	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	0.15	1.0
	T9325	0.4	255	0.17	1.0	150	0.15	1.0	240	0.17	1.0	–	–	–	55	0.15	0.8	–	–	–
WNMG 060408E-SF	**H07**	0.8	–	–	–	95	0.18	1.0	155	0.20	1.0	495	0.24	1.0	50	0.14	0.8	–	–	–
	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	0.15	1.0
	T7335	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
	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	0.15	1.0
	T8330	0.8	200	0.20	1.0	120	0.18	1.0	190	0.20	1.0	600	0.24	1.0	50	0.14	0.8	40	0.15	1.0
	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	0.15	1.0
	T9315	0.8	315	0.20	1.0	–	–	–	295	0.20	1.0	–	–	–	–	–	–	60	0.15	1.0
	T9325	0.8	280	0.20	1.0	165	0.18	1.0	265	0.20	1.0	–	–	–	60	0.16	0.8	–	–	–
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	–	–	–
	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	0.15	1.0
	T7325	0.4	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
	T7335	0.4	200	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
	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	0.15	1.0
	T8330	0.4	180	0.15	1.0	105	0.14	1.0	170	0.15	1.0	540	0.18	1.0	45	0.12	0.8	35	0.15	1.0
	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	0.15	1.0
	T9315	0.4	300	0.15	1.0	–	–	–	285	0.15	1.0	–	–	–	–	–	–	60	0.15	1.0
	T9325	0.4	255	0.17	1.0	150	0.15	1.0	240	0.17	1.0	–	–	–	55	0.15	0.8	–	–	–
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	–	–	–
	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	0.15	1.0
	T7325	0.8	230	0.20	1.0	175	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
	T7335	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
	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	0.15	1.0
	T8330	0.8	200	0.20	1.0	120	0.18	1.0	190	0.20	1.0	600	0.24	1.0	50	0.14	0.8	40	0.15	1.0
	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	0.15	1.0
	T9315	0.8	315	0.20	1.0	–	–	–	295	0.20	1.0	–	–	–	–	–	–	60	0.15	1.0
	T9325	0.8	280	0.20	1.0	165	0.18	1.0	265	0.20	1.0	–	–	–	60	0.16	0.8	–	–	–
WNMG 080412E-SF	**T7325**	1.2	220	0.25	1.5	170	0.23	1.5	–	–	–	–	–	–	70	0.18	1.2	–	–	–
																				
SM断屑槽，具有正前角设计，适用于中等加工，连续或间断进行切削。																				
WNMG 060404E-SM	**T7325**	0.4	180	0.22	1.7	140	0.20	1.7	–	–	–	–	–	–	55	0.20	1.4	–	–	–
	T7335	0.4	175	0.22	1.7	135	0.20	1.7	–	–	–	–	–	–	55	0.20	1.4	–	–	–
	T8330	0.4	155	0.22	1.7	90	0.20	1.7	145	0.22	1.7	465	0.26	1.7	35	0.20	1.4	30	0.15	1.0
	T8430	0.4	175	0.22	1.7	95	0.20	1.7	140	0.22	1.7	480	0.26	1.7	35	0.20	1.4	30	0.15	1.0
	T9315	0.4	250	0.20	1.7	–	–	–	235	0.20	1.7	–	–	–	–	–	–	50	0.15	1.0
	T9325	0.4	215	0.22	1.7	125	0.20	1.7	200	0.22	1.7	–	–	–	45	0.20	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	0.15	1.0
	T7325	0.8	200	0.25	1.7	155	0.23	1.7	–	–	–	–	–	–	65	0.20	1.4	–	–	–
	T7335	0.8	195	0.25	1.7	150	0.23	1.7	–	–	–	–	–	–	60	0.20	1.4	–	–	–
	T8330	0.8	175	0.25	1.7	105	0.23	1.7	165	0.25	1.7	525	0.30	1.7	40	0.20	1.4	35	0.15	1.0
	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	0.15	1.0
	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	–	–	–
	T8330	1.2	180	0.30	1.7	105	0.27	1.7	170	0.30	1.7	540	0.36	1.7	45	0.24	1.4	35	0.15	1.0
	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
	T9325	1.2	240	0.30	1.7	140	0.27	1.7	225	0.30	1.7	–	–	–	50	0.24	1.4	–	–	–

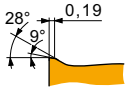
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
SM断屑槽，具有正前角设计，适用于中等加工，连续或间断进行切削。																				
WNMG 080404E-SM	**T6310**	0.4	■	155	0.22	2.0	■	110	0.20	2.0	■	125	0.22	2.0	◪	465	0.26	2.0	■	45	0.20	1.6	◪	30	0.15	1.0
	T7325	0.4	◪	175	0.22	2.0	■	135	0.20	2.0		–	–	–		–	–	–	■	55	0.20	1.6		–	–	–
	T7335	0.4	◪	170	0.22	2.0	■	130	0.20	2.0		–	–	–		–	–	–	■	55	0.20	1.6		–	–	–
	T8330	0.4	■	155	0.22	2.0	■	90	0.20	2.0	■	145	0.22	2.0	◪	465	0.26	2.0	◪	35	0.20	1.6	◪	30	0.15	1.0
	T8430	0.4	■	170	0.22	2.0	■	90	0.20	2.0	◪	135	0.22	2.0	◪	465	0.26	2.0	◪	35	0.20	1.6	◪	25	0.15	1.0
	T9315	0.4	■	245	0.20	2.0		–	–	–	◪	230	0.20	2.0		–	–	–		–	–	–	◪	45	0.15	1.0
	T9325	0.4	■	210	0.22	2.0	■	125	0.20	2.0	◪	195	0.22	2.0		–	–	–	◪	45	0.20	1.6		–	–	–
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	0.15	1.0
	T7325	0.8	◪	200	0.25	2.0	■	155	0.23	2.0		–	–	–		–	–	–	■	65	0.20	1.6		–	–	–
	T7335	0.8	◪	190	0.25	2.0	■	145	0.23	2.0		–	–	–		–	–	–	■	60	0.20	1.6		–	–	–
	T8330	0.8	■	175	0.25	2.0	■	105	0.23	2.0	■	165	0.25	2.0	◪	525	0.30	2.0	◪	40	0.20	1.6	◪	35	0.15	1.0
	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	0.15	1.0
	T9315	0.8	■	265	0.25	2.0		–	–	–	◪	250	0.25	2.0		–	–	–		–	–	–	◪	50	0.15	1.0
	T9325	0.8	■	235	0.25	2.0	■	140	0.23	2.0	◪	220	0.25	2.0		–	–	–	◪	50	0.20	1.6		–	–	–
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
	T7325	1.2	◪	195	0.30	2.0	■	150	0.27	2.0		–	–	–		–	–	–	■	60	0.24	1.6		–	–	–
	T7335	1.2	◪	190	0.30	2.0	■	145	0.27	2.0		–	–	–		–	–	–	■	60	0.24	1.6		–	–	–
	T8330	1.2	■	175	0.30	2.0	■	105	0.27	2.0	■	165	0.30	2.0	◪	525	0.36	2.0	◪	40	0.24	1.6	◪	35	0.15	1.0
	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
	T9315	1.2	■	260	0.30	2.0		–	–	–	◪	245	0.30	2.0		–	–	–		–	–	–	◪	50	0.15	1.0
	T9325	1.2	■	235	0.30	2.0	■	140	0.27	2.0	◪	220	0.30	2.0		–	–	–	◪	50	0.24	1.6		–	–	–
																				
ER-SI断屑槽，具有正前角设计，右手设计，适用于超精加工至中粗加工，连续切削。																				
WNMG 060404ER-SI	**T8330**	0.4	■	195	0.20	1.7	■	115	0.18	1.7		–	–	–	◪	585	0.24	1.7	◪	45	0.18	1.4		–	–	–
	T8430	0.4	■	225	0.20	1.7	■	120	0.18	1.7		–	–	–	◪	615	0.24	1.7	◪	45	0.18	1.4		–	–	–
	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		–	–	–
	T7335	0.4	◪	215	0.20	1.7	■	165	0.18	1.7		–	–	–		–	–	–	◪	65	0.18	1.4		–	–	–
	T8315	0.4	◪	205	0.20	1.7	■	120	0.18	1.7		–	–	–	◪	615	0.24	1.7	◪	50	0.18	1.4		–	–	–
	T8330	0.4	■	195	0.20	1.7	■	115	0.18	1.7		–	–	–	◪	585	0.24	1.7	◪	45	0.18	1.4		–	–	–
	T8430	0.4	■	225	0.20	1.7	■	120	0.18	1.7		–	–	–	◪	615	0.24	1.7	◪	45	0.18	1.4		–	–	–
	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		–	–	–
	T7335	0.8	◪	205	0.35	1.7	■	155	0.32	1.7		–	–	–		–	–	–	◪	65	0.25	1.4		–	–	–
	T8315	0.8	◪	205	0.35	1.7	■	120	0.32	1.7		–	–	–	◪	615	0.42	1.7	◪	50	0.25	1.4		–	–	–
	T8330	0.8	■	195	0.35	1.7	■	115	0.32	1.7		–	–	–	◪	585	0.42	1.7	◪	45	0.25	1.4		–	–	–
	T8430	0.8	■	210	0.35	1.7	■	115	0.32	1.7		–	–	–	◪	585	0.42	1.7	◪	45	0.25	1.4		–	–	–
	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		–	–	–
	T9325	1.2	■	265	0.35	1.7	■	155	0.32	1.7		–	–	–		–	–	–	◪	55	0.25	1.4		–	–	–
																				
EL-SI断屑槽，具有正前角，左手设计，适用于超精加工至中粗加工，连续切削。																				
WNMG 060404EL-SI	**T8330**	0.4	■	195	0.20	1.7	■	115	0.18	1.7		–	–	–	◪	585	0.24	1.7	◪	45	0.18	1.4		–	–	–
	T8430	0.4	■	225	0.20	1.7	■	120	0.18	1.7		–	–	–	◪	615	0.24	1.7	◪	45	0.18	1.4		–	–	–
	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		–	–	–
	T7335	0.4	◪	215	0.20	1.7	■	165	0.18	1.7		–	–	–		–	–	–	◪	65	0.18	1.4		–	–	–
	T8315	0.4	◪	205	0.20	1.7	■	120	0.18	1.7		–	–	–	◪	615	0.24	1.7	◪	50	0.18	1.4		–	–	–
	T8330	0.4	■	195	0.20	1.7	■	115	0.18	1.7		–	–	–	◪	585	0.24	1.7	◪	45	0.18	1.4		–	–	–
	T8430	0.4	■	225	0.20	1.7	■	120	0.18	1.7		–	–	–	◪	615	0.24	1.7	◪	45	0.18	1.4		–	–	–
	T9325	0.4	■	270	0.20	1.7	■	160	0.18	1.7		–	–	–		–	–	–	◪	60	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。

产品型号		RE	P			M			K			N			S			H		
			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)
		(mm)																		
			E																	
			EL-SI断屑槽，具有正前角，左手设计，适用于超精加工至中粗加工，连续切削。																	
WNMG 080408EL-SI	**T7325**	0.8	◪ 215	0.35	1.7	■ 165	0.32	1.7	–	–	–	–	–	–	◪ 65	0.25	1.4	–	–	–
	T7335	0.8	◪ 205	0.35	1.7	■ 155	0.32	1.7	–	–	–	–	–	–	◪ 65	0.25	1.4	–	–	–
	T8315	0.8	◪ 205	0.35	1.7	■ 120	0.32	1.7	–	–	–	◪ 615	0.42	1.7	◪ 50	0.25	1.4	–	–	–
	T8330	0.8	■ 195	0.35	1.7	■ 115	0.32	1.7	–	–	–	◪ 585	0.42	1.7	◪ 45	0.25	1.4	–	–	–
	T8430	0.8	■ 210	0.35	1.7	■ 115	0.32	1.7	–	–	–	◪ 585	0.42	1.7	◪ 45	0.25	1.4	–	–	–
	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	–	–	–
			W E																	
			W-F修光刃断屑槽，可提高进给量并改善表面光洁度，从而完成精细的精加工。																	
WNMG 060408W-F	**T9315**	0.8	■ 215	0.45	0.8	–	–	–	◪ 200	0.45	0.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 190	0.45	0.8	–	–	–	◪ 180	0.45	0.8	–	–	–	–	–	–	–	–	–
WNMG 080404W-F	**T9315**	0.4	■ 250	0.25	0.4	–	–	–	◪ 235	0.25	0.4	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 225	0.25	0.4	–	–	–	◪ 210	0.25	0.4	–	–	–	–	–	–	–	–	–
			W S																	
			W-M修光刃断屑槽，适用于中粗加工至粗加工，并提供更高的进给量并改善了表面光洁度。																	
WNMG 060408W-M	**T9310**	0.8	■ 220	0.45	1.2	–	–	–	◪ 205	0.45	1.2	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 205	0.45	1.2	–	–	–	◪ 190	0.45	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 190	0.45	1.2	–	–	–	◪ 180	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 060412W-M	**T5315**	1.2	◪ 235	0.55	1.2	–	–	–	◪ 220	0.55	1.2	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 205	0.55	1.2	–	–	–	◪ 190	0.55	1.2	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 180	0.55	1.2	–	–	–	◪ 170	0.55	1.2	–	–	–	–	–	–	–	–	–
WNMG 080408W-M	**T9315**	0.8	■ 200	0.45	1.5	–	–	–	◪ 190	0.45	1.5	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 185	0.45	1.5	–	–	–	◪ 175	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-M	**T9325**	1.2	■ 180	0.55	1.5	–	–	–	◪ 170	0.55	1.5	–	–	–	–	–	–	–	–	–
			W S																	
			W-MR修光刃断屑槽，适用于精加工至粗加工，并提供更高的进给量并改善了表面光洁度。																	
WNMG 060408W-MR	**T9315**	0.8	■ 205	0.45	1.2	–	–	–	◪ 190	0.45	1.2	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 190	0.45	1.2	◪ 110	0.41	1.2	◪ 180	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 080404W-MR	**T9315**	0.4	■ 200	0.30	1.5	–	–	–	◪ 190	0.30	1.5	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 180	0.30	1.5	◪ 105	0.27	1.5	◪ 170	0.30	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR	**T5315**	0.8	◪ 230	0.45	1.5	–	–	–	◪ 215	0.45	1.5	–	–	–	–	–	–	–	–	–
	T9310	0.8	■ 215	0.45	1.5	–	–	–	◪ 200	0.45	1.5	–	–	–	–	–	–	–	–	–
	T9315	0.8	■ 200	0.45	1.5	–	–	–	◪ 190	0.45	1.5	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 185	0.45	1.5	◪ 110	0.41	1.5	◪ 175	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-MR	**T5315**	1.2	◪ 230	0.55	1.5	–	–	–	◪ 215	0.55	1.5	–	–	–	–	–	–	–	–	–
	T9310	1.2	■ 210	0.55	1.5	–	–	–	◪ 195	0.55	1.5	–	–	–	–	–	–	–	–	–
	T9315	1.2	■ 200	0.55	1.5	–	–	–	◪ 190	0.55	1.5	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 180	0.55	1.5	◪ 105	0.50	1.5	◪ 170	0.55	1.5	–	–	–	–	–	–	–	–	–
			W S																	
			W-NM修光刃断屑槽，适用于精加工至粗加工，并提供更高的进给量并改善了表面光洁度。																	
WNMG 060408W-NM	**T7325**	0.8	◪ 220	0.25	1.8	◪ 170	0.23	1.8	–	–	–	–	–	–	◪ 70	0.20	1.4	–	–	–
	T7335	0.8	◪ 215	0.25	1.8	◪ 165	0.23	1.8	–	–	–	–	–	–	◪ 65	0.20	1.4	–	–	–
	T9315	0.8	■ 290	0.25	1.8	–	–	–	◪ 275	0.25	1.8	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 265	0.25	1.8	◪ 155	0.23	1.8	◪ 250	0.25	1.8	–	–	–	◪ 55	0.20	1.4	–	–	–

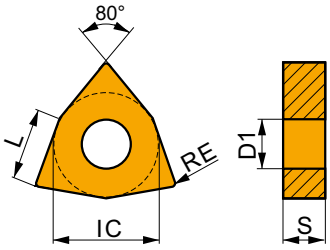
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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-NM修光刃断屑槽，适用于精加工至粗加工，并提供更高的进给量并改善了表面光洁度。																	
WNMG 080404W-NM	**T7325**	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
	T7335	0.4	190	0.20	2.1	145	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
	T9315	0.4	270	0.20	2.1	–	–	–	255	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9325	0.4	240	0.20	2.1	140	0.18	2.1	225	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
WNMG 080408W-NM	**T7325**	0.8	215	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
	T7335	0.8	210	0.25	2.1	160	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
	T9315	0.8	290	0.25	2.1	–	–	–	275	0.25	2.1	–	–	–	–	–	–	–	–	–
	T9325	0.8	260	0.25	2.1	155	0.23	2.1	245	0.25	2.1	–	–	–	55	0.20	1.7	–	–	–
WNMG 080412W-NM	**T7325**	1.2	215	0.30	2.1	165	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
	T7335	1.2	210	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
	T9315	1.2	285	0.30	2.1	–	–	–	270	0.30	2.1	–	–	–	–	–	–	–	–	–

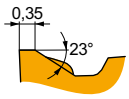
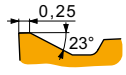
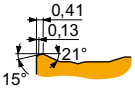
WNMM

PRAMET

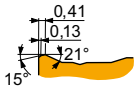
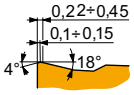
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76
1006	15.875	6.35	10.80	6.35
1306	19.050	7.94	13.00	6.35



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。

产品型号		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)
																				
			DR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
WNMM 100608E-DR	**T9325**	0.8	205	0.40	5.0	120	0.36	5.0	190	0.40	5.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	175	0.40	5.0	105	0.36	5.0	–	–	–	–	–	–	–	–	–	–	–	–
WNMM 130612E-DR	**T9325**	1.2	200	0.45	6.0	120	0.41	6.0	190	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	170	0.45	6.0	100	0.41	6.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
			NR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
WNMM 080408E-NR	**T7325**	0.8	175	0.40	3.0	135	0.36	3.0	–	–	–	–	–	–	55	0.28	2.4	–	–	–
	T8330	0.8	155	0.40	3.0	90	0.36	3.0	145	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
	T8430	0.8	165	0.40	3.0	90	0.36	3.0	135	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
	T9325	0.8	195	0.40	3.0	115	0.36	3.0	185	0.40	3.0	–	–	–	40	0.28	2.4	–	–	–
																				
			NR2断屑槽，适用于中粗加工至粗加工，连续至断续切削。																	
WNMM 080408E-NR2	**T7335**	0.8	160	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
	T9325	0.8	190	0.40	4.0	110	0.36	4.0	180	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–

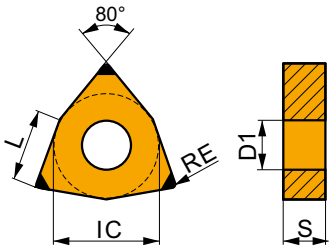
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
NR2断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
WNMM 080412E-NR2	**T7325**	1.2	175	0.45	4.0	135	0.41	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
	T9325	1.2	190	0.45	4.0	110	0.41	4.0	180	0.45	4.0	–	–	–	40	0.32	3.2	–	–	–
																				
OR断屑槽，适用于中粗加工至粗加工，连续至断续切削。																				
WNMM 080408E-OR	**T8330**	0.8	150	0.40	4.0	90	0.36	4.0	140	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
	T8430	0.8	155	0.40	4.0	85	0.36	4.0	130	0.40	4.0	–	–	–	30	0.28	3.2	–	–	–
	T9325	0.8	190	0.40	4.0	110	0.36	4.0	180	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
	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	–	–	–
	T9335	1.2	170	0.45	4.0	100	0.41	4.0	–	–	–	–	–	–	35	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	–	–	–

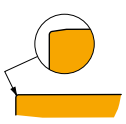
WNGA CBN

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。

产品型号		RE	P			M			K			N			S			H		
			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)
																				
适用于精加工，连续切削。																				
WNGA 080408S01020C	**TB310**	0.8	–	–	–	–	–	–	530	0.15	0.6	–	–	–	140	0.11	0.5	110	0.15	1.0
																				
适用于精加工，连续切削。																				
WNGA080408S01020WC	**TB310**	0.8	–	–	–	–	–	–	530	0.15	0.6	–	–	–	140	0.11	0.5	110	0.15	1.0

DWLN(RL) EXT

P M K N S H

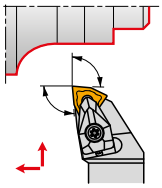
PRAMET

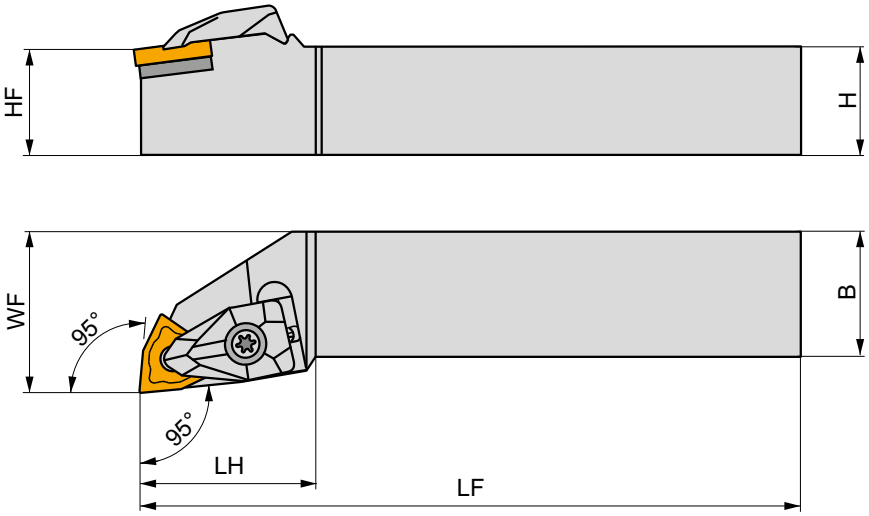
D

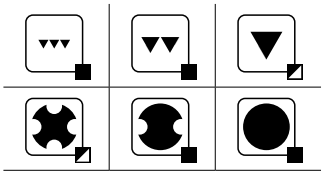


外圆用双重夹紧车刀杆，使用WN..刀片，主偏角为95°。

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。









	产品型号	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	-6	-6	0.75	GI072	DW08	AT004
	DWLNR 3225 P 08	32	25	32	32	170	35	-6	-6	1.01	GI072	DW08	AT004
	DWLNR 3225 P 10	32	25	32	32	170	38	-6	-6	1.06	GI166	DW10	–
	DWLNR 3232 P 13	32	32	32	40	170	40	-6	-6	1.44	GI167	DW13	–
	DWLNR 4040 S 13	40	40	40	50	250	41	-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	-6	-6	0.75	GI072	DW08	AT004
	DWLNL 3225 P 08	32	25	32	32	170	35	-6	-6	1.10	GI072	DW08	AT004
	DWLNL 3225 P 10	32	25	32	32	170	38	-6	-6	1.14	GI166	DW10	–
	DWLNL 3232 P 13	32	32	32	40	170	40	-6	-6	1.45	GI167	DW13	–
	DWLNL 4040 S 13	40	40	40	50	250	41	-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

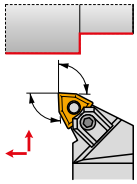
PRAMET

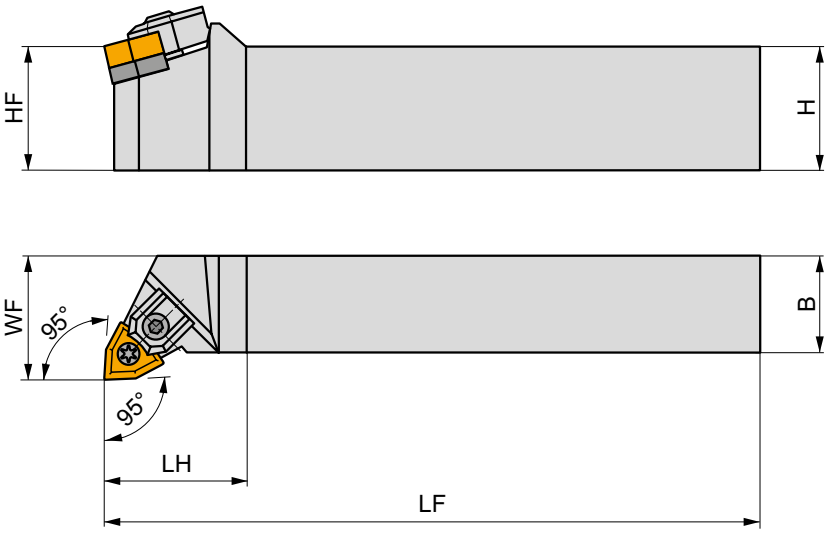
M

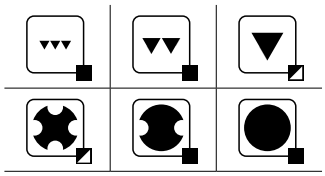


外圆用多重锁紧车刀杆，使用WN..刀片，主偏角为95°。

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。









	产品型号	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	32	-6	-6	0.73	GI072	MW1
	MWLNR 3225 P 08	32	25	32	32	170	32	-6	-6	1.30	GI072	MW1
	MWLNR 4040 R 08	40	40	40	50	200	32	-6	-6	2.50	GI072	MW1
L	**MWLNL 2525 M 08**	25	25	25	32	150	32	-6	-6	0.70	GI072	MW1
	MWLNL 3225 P 08	32	25	32	32	170	32	-6	-6	1.02	GI072	MW1
	MWLNL 4040 R 08	40	40	40	50	200	32	-6	-6	2.50	GI072	MW1

GI072	WN.. 0804..

MW1	UE 05	5.0 Nm	WNW 080412	UC 51	HS 0408	HXK 3

PWLN(RL) EXT

P M K N S H

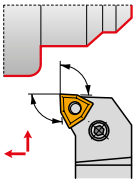
PRAMET

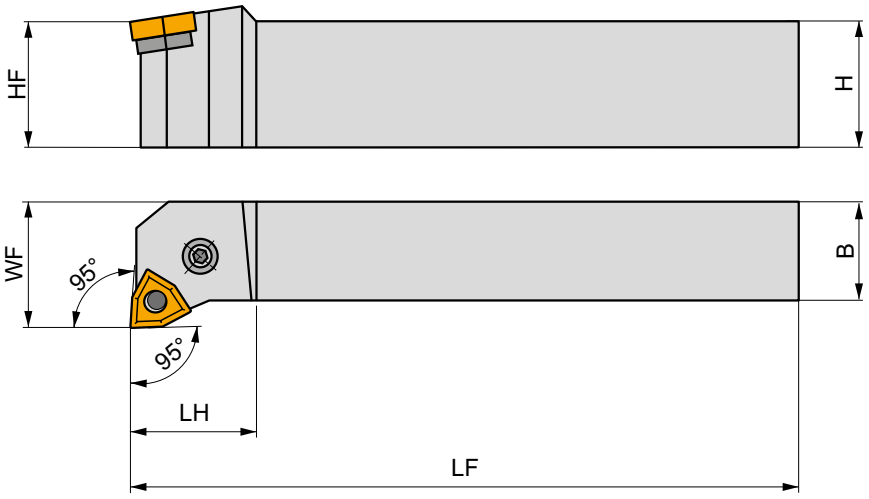
P

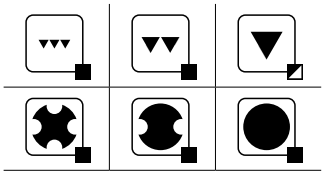


外圆用杠杆夹紧式车刀杆，使用WN..刀片，主偏角为95°。

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。









	产品型号	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PWLNR 1616 H 0604**	16	16	16	20	100	20	-6	-6	0.23	GI028	PW11
	PWLNR 2020 K 0604	20	20	20	25	125	20	-6	-6	0.40	GI028	PW10
	PWLNR 2525 M 0604	25	25	25	32	150	20	-6	-6	0.78	GI028	PW10
	PWLNR 2020 K 08	20	20	20	25	125	22	-6	-6	0.42	GI072	PW22
	PWLNR 2525 M 08	25	25	25	32	150	22	-6	-6	0.73	GI072	PW20
	PWLNR 3225 P 08	32	25	32	32	170	22	-6	-6	1.05	GI072	PW20
L	**PWLNL 1616 H 0604**	16	16	16	20	100	20	-6	-6	0.21	GI028	PW11
	PWLNL 2020 K 0604	20	20	20	25	125	20	-6	-6	0.40	GI028	PW10
	PWLNL 2525 M 0604	25	25	25	32	150	20	-6	-6	0.75	GI028	PW10
	PWLNL 2020 K 08	20	20	20	25	125	22	-6	-6	0.40	GI072	PW22
	PWLNL 2525 M 08	25	25	25	32	150	22	-6	-6	0.74	GI072	PW20
	PWLNL 3225 P 08	32	25	32	32	170	22	-6	-6	1.05	GI072	PW20

GI028	WN.. 0604..
GI072	WN.. 0804..

				Nm					
PW10	WNU 060308	PU 01	US 34	5.0	M 6x0.75	19	NT 04	MT 04	HXK 3
PW11	WNU 060308	PU 01	US 46	5.0	M 6x0.75	13.2	NT 04	MT 04	HXK 3
PW20	WNU 080312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PW22	WNU 080312	PU 02	US 42	6.0	M 8x1	21	NT 05	MT 05	HXK 4

NEW

C.-DWLN(RL) EXT

P M K N S H

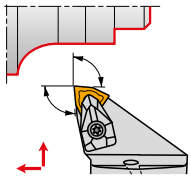
PRAMET

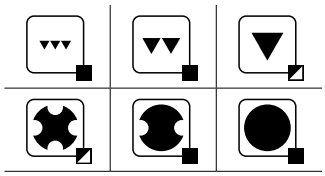
D

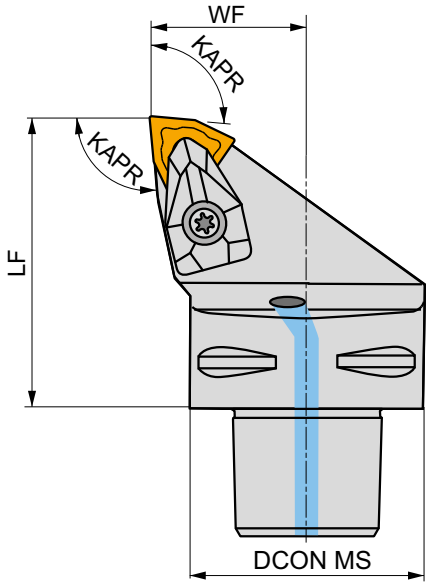


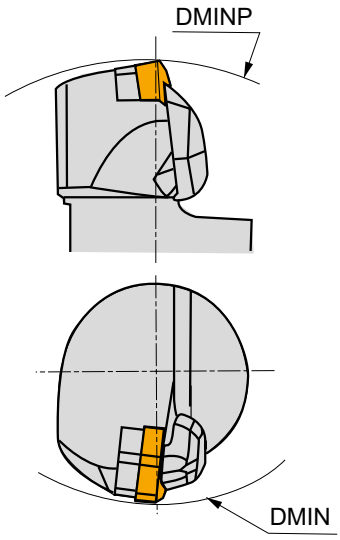
外圆用PSC快速更换式刀柄，双重夹紧，使用WN..刀片，主偏角为95°。

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。











	产品型号	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

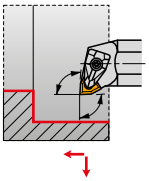
P M K N S H

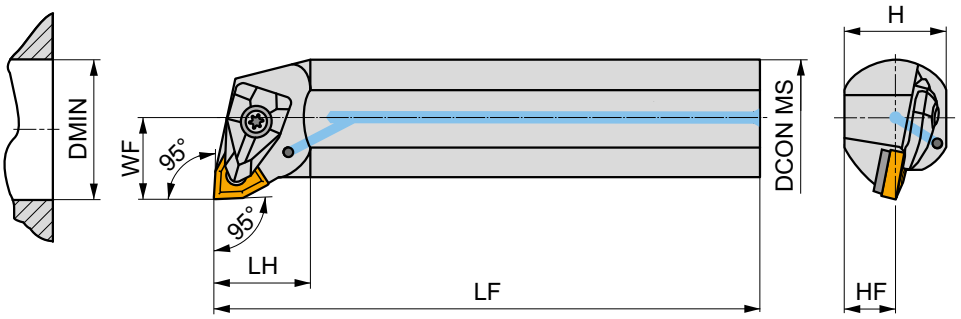
PRAMET D

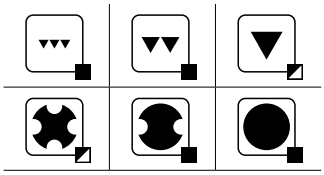


内孔用双重夹紧镗杆，使用WN..刀片，主偏角为95°。

内孔用左/右手双重夹紧具镗杆，有内冷通道，所有WN的主偏角为95°。06和08负前角刀片。内孔最小加工直径为Ø32mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø25至Ø50mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	-14	-6	✓	0.97	GI028	DW06
	A25T-DWLNR 08	25	33	17	23	11.5	300	31	-12	-6	✓	0.98	GI072	DWI08
	A32T-DWLNR 08	32	40	22	30	15	300	33	-10	-6	✓	1.71	GI072	DWI08
	A40T-DWLNR 08	40	50	27	37	18.5	300	36	-13	-6	✓	2.59	GI072	DW08
	A50U-DWLNR 08	50	63	35	47	23.5	350	39	-11	-6	✓	5.24	GI072	DW08
L	**A25T-DWLNL 06**	25	32	17	23	11.5	300	31	-14	-6	✓	0.97	GI028	DW06
	A25T-DWLNL 08	25	33	17	23	11.5	300	31	-12	-6	✓	0.98	GI072	DWI08
	A32T-DWLNL 08	32	40	22	30	15	300	33	-10	-6	✓	1.70	GI072	DWI08
	A40T-DWLNL 08	40	50	27	37	18.5	300	36	-13	-6	✓	2.59	GI072	DW08
	A50U-DWLNL 08	50	63	35	47	23.5	350	39	-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

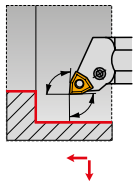
PRAMET

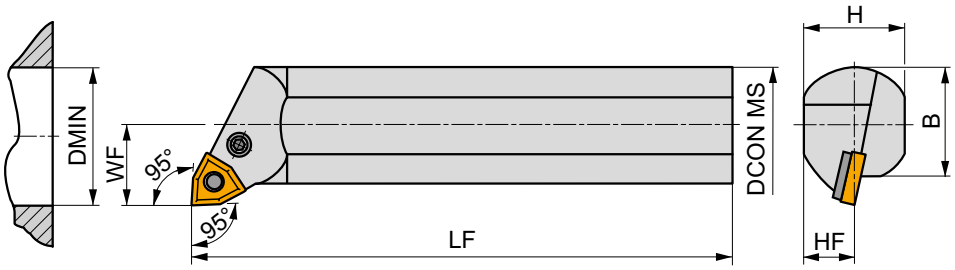
P

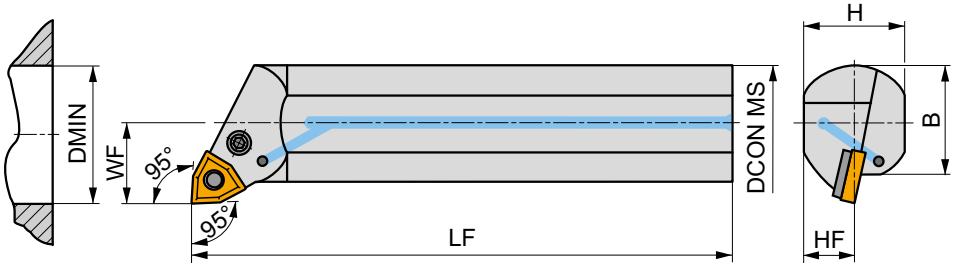


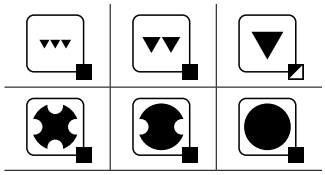
外圆用杠杆夹紧式镗杆，使用WN..刀片，主偏角为95°。

内孔用左/右手杠杆夹紧式镗杆，有内冷通道，主偏角为95°，使用WN..06和08刀片。内孔最小加工直径为Ø20mm。适用于内孔锥面，有阶梯孔的轴向车削，和倒角车削。可提供Ø16至Ø60mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16M-PWLNR 0604	16	20	11	15	15	150	-13.5	-6	✓	0.22	GI028	PW09
	A20Q-PWLNR 0604	20	27	13	18	18	180	-13.5	-6	✓	0.36	GI028	PW09
	S25T-PWLNR 0604	25	32	17	23	23	300	-12	-6	–	1.10	GI028	PW11
	A32S-PWLNR 0604	32	40	22	30	30	250	-12	-6	✓	1.30	GI028	PW11
	A25R-PWLNR 08	25	32	17	23	23	200	-12	-6	✓	0.66	GI072	PW25
	S25T-PWLNR 08	25	32	17	23	23	300	-12	-6	–	1.10	GI072	PW25
	A32S-PWLNR 08	32	40	22	30	30	250	-12	-6	✓	1.46	GI072	PW21
	S32U-PWLNR 08	32	40	22	30	30	350	-12	-6	–	2.09	GI072	PW21
	A40T-PWLNR 08	40	50	27	38	38	300	-12	-6	✓	2.40	GI072	PW20
	A50U-PWLNR 08	50	63	35	47	48.5	350	-12	-6	✓	4.88	GI072	PW20
	A60V-PWLNR 08	60	80	43	57	58.5	400	-12	-6	✓	8.10	GI072	PW20
L	A16M-PWLNL 0604	16	20	11	15	15	150	-13.5	-6	✓	0.22	GI028	PW09
	A20Q-PWLNL 0604	20	27	13	18	18	180	-13.5	-6	✓	0.36	GI028	PW09
	S25T-PWLNL 0604	25	32	17	23	23	300	-12	-6	–	0.98	GI028	PW11
	A32S-PWLNL 0604	32	40	22	30	30	250	-12	-6	✓	1.28	GI028	PW11
	A25R-PWLNL 08	25	32	17	23	23	200	-12	-6	✓	0.75	GI072	PW25
	S25T-PWLNL 08	25	32	17	23	23	300	-12	-6	–	1.01	GI072	PW25
	A32S-PWLNL 08	32	40	22	30	30	250	-12	-6	✓	1.47	GI072	PW21
	S32U-PWLNL 08	32	40	22	30	30	350	-12	-6	–	2.08	GI072	PW21
	A40T-PWLNL 08	40	50	27	38	38	300	-12	-6	✓	2.90	GI072	PW20
	A50U-PWLNL 08	50	63	35	47	48.5	350	-12	-6	✓	4.88	GI072	PW20
	A60V-PWLNL 08	60	80	43	57	58.5	400	-12	-6	✓	8.70	GI072	PW20

GI028	WN.. 0604..
GI072	WN.. 0804..

				Nm					
PW09	–	PU 3611-A	PS 0512-A	2.0	M 5	12	–	–	HXK 2
PW11	WNU 060308	PU 01	US 46	5.0	M 6x0.75	13.2	NT 04	MT 04	HXK 3
PW20	WNU 080312	PU 02	US 35	6.0	M 8x1	22.5	NT 05	MT 05	HXK 4
PW21	WNU 080312	PU 02	US 41	6.0	M 8x1	17	NT 05	MT 05	HXK 4
PW25	–	PU 32	US 46	5.0	M 6x0.75	13.2	–	–	HXK 3

NEW

C.-DWLN(RL) INT

P M K N S H

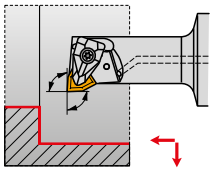
PRAMET

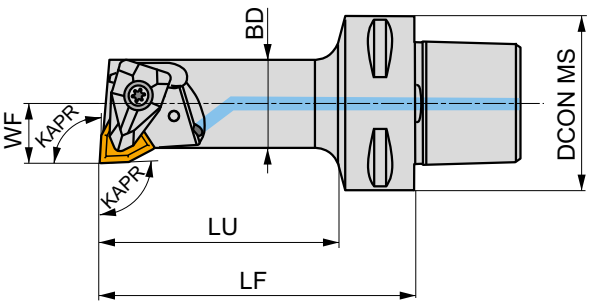
D

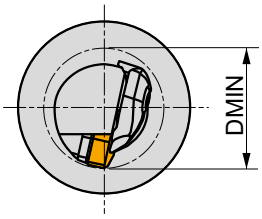


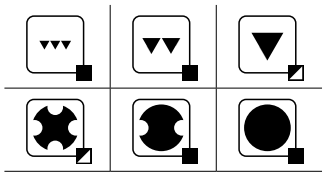
内孔用PSC快速更换式刀柄，双重夹紧，使用WN..刀片，主偏角为95°。

内孔用左/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刀片。适用于内孔锥面，和有阶梯孔的轴向车削，和倒角车削。最小内径Ø27mm。可提供C4的PSC刀柄。刀杆经过处理，使用寿命更长。











	产品型号	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
	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
	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

切断
和切槽



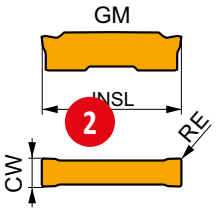
📖 6		WMG & ISO 13399
📖 10	ISO车削	说明
📖 18		导航工具
📖 57		正前角刀片
📖 219		负前角刀片
📖 386		**切断和切槽**
📖 482		螺纹车削
📖 528		内孔插槽
📖 536		通用技术信息

1 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

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]
4	5		U 6																	
10 GM断屑槽，适用于开槽和轴向车削，连续至断续切削。																				
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	–	–	–
7	T7325	9	220	0.10	0.8	170	0.09	0.8	–	–	–	–	–	–	70	0.08	0.6	–	–	–
G 00M02-GM	8 30	2	150	0.20	1.0	90	0.18	1.0	140	11 20	1.0	–	–	–	35	0.14	0.8	–	–	–
	T7325	0.2	175	0.20	1.0	135	0.18	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	–	–	–
	T7325	0.4	185	0.20	1.0	140	0.18	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	–	–	–
	T7325	0.4	170	0.25	1.2	130	0.23	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	–	–	–
	T7325	0.8	200	0.25	1.2	155	0.23	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	–	–	–
	T7325	0.8	190	0.30	1.2	145	0.27	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	–	–	–

GL5-D500M08-GM:T7325 订购时请使用完整的刀片规格代码！

涂层

包括冒号

ISO刀片代码

本页仅用于车削刀片信息的介绍 - 具体产品信息会有不同

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
8	涂层
9	刀尖半径 (mm)
10	槽型说明
11	刀片应用领域

1 GG.(RL) INT

P M K N S H 2

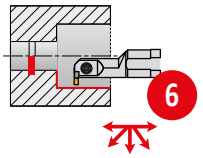
PRAMET 3 G



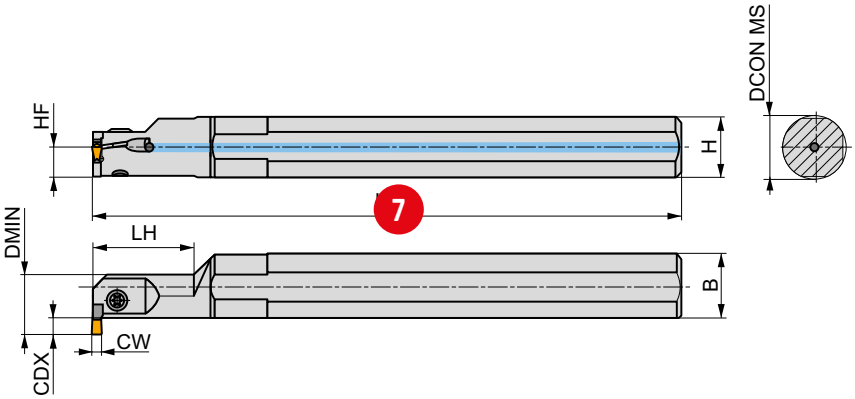
4

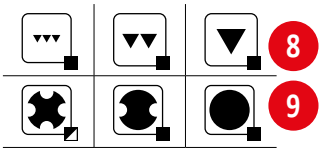
5

内孔沟槽镗杆，使用LCM..刀片。
内孔用左/右手开槽镗杆，开槽加工，使用用LCM.0313和0413刀片。内孔最小开槽直径为Ø16mm。
适用于内孔沟槽和仿形车削。可提供Ø16至Ø32mm的刀柄。刀杆经过处理，使用寿命更长。



6





8 9

10

	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	3.00	3	16	✓	0.26	GI143	GL06
	A16Q-GGER 0313-04	16	7.5	15	15.5	180	25	3.00	3	16	✓	0.26	GI190	GL06
	A20R-GGFR 0313	20	9	18	19	200	30	3.00	4.5	20	✓	0.36	GI143	GL06
	A20R-GGFR 0313-04	20	9	18	19	200	30	3.00	4.5	20	✓	0.39	GI190	GL06
	A25S-GGHR 0313	25	11.5	23	24	250	40	3.00	6.5	25	✓	0.78	GI143	GL06
	A25S-GG[illegible]3	25	11.5	23	24	250	40	4.00	6.5	25	✓	0.78	GI143	GL06
	A32T-GGHR 0413	32	15	30	31	300	50	4.00	9.5	32	✓	1.59	GI170	GL06
L	A16Q-GGEL 0313	16	7.5	15	15.5	180	25	3.00	3	16	✓	0.29	GI143	GL06
	A16Q-GGEL 0313-04	16	7.5	15	15.5	180	25	3.00	3	16	✓	0.28	GI190	GL06
	A20R-GGFL 0313	20	9	18	19	200	30	3.00	4.5	20	✓	0.38	GI143	GL06
	A20R-GGFL 0313-04	20	9	18	19	200	30	3.00	4.5	20	✓	0.38	GI190	GL06
	A25S-GGHL 0313	25	11.5	23	24	250	40	3.00	6.5	25	✓	0.81	GI143	GL06
	A25S-GGFL 0413	25	11.5	23	24	250	40	4.00	6.5	25	✓	0.82	GI170	GL06
	A32T-GGHL 0413	32	15	30	31	300	50	4.00	9.5	32	✓	1.59	GI170	GL06

11 12 13 14 15 16 17

	18
GI143	LCM. 0313..
GI170	LCM. 0413..
GI190	LCM. 0313…..-04

		Nm	19		
GL06	SR 85011-T15P	5.0	M 5	9	FLAG T15P

本页仅用于刀杆信息的介绍 - 具体产品信息会有不同。

切断和切槽刀杆 – 页面概览

图号	描述
1	切断和切槽刀杆的类型
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

图号	描述
11	刀具设计
12	刀杆代码
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	兼容刀片
19	备件

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.

切断和切槽 – 图标概览

通用图标

■	主要使用
◩	可以使用

▼▼▼	精加工 – 极佳的表面质量
▼▼	中等精度加工 – 良好的表面质量
▼	粗加工 – 无限制的表面粗糙度

●	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

车削操作

	仿形车削（多向加工）
	加工端面深槽及车槽（可扩槽加工）
	加工端面深槽
	加工外圆深槽
	端面仿形车削

	内孔沟槽
	内孔沟槽（可扩槽加工）
	切断加工
	加工端面浅槽及车槽（可扩槽加工）
	加工端面浅槽

	加工外圆浅槽
	管壁切断
	外圆车槽（可扩槽加工）

特点

	首选
	大悬伸

	应用广泛的多用途选项
	严重工况

	刃口圆弧倒棱
	刃口S型倒棱

其他

	螺钉的夹紧力矩 [Nm]

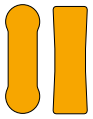
	内冷供应

GL. D NEW



406

LCMF 13



418

LCMF 16, LCMF 30



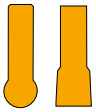
432

LCMF 20



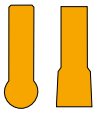
453

LCMR 13



419

LCMR 16, LCMR 30



435

LFMX



456

LFUX



464

TN R EXT



475

TN R INT



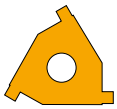
475

TN ZZ EXT



476

TN ZZ INT



477

X 61 NEW



468

X 61 R NEW



469

X 61 R-1 NEW



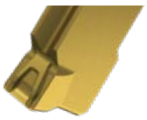
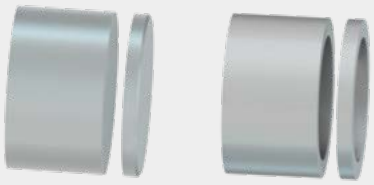
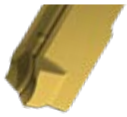
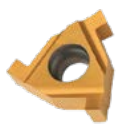
473

X 61-1 NEW



472

切断和切槽槽型 – 导航工具

		操作类型	刀片系列选择			
			首选		可选	
外圆		切槽	GL. D NEW		LCMF16, LCMF30	
			GM		F	
			406		432	
		切断加工	GL. D NEW		LFMX	
			PM		M2	
			407		457	
		端面切槽	LCMF13		LCMF16, LCMF30	
			F		F	
			418		432	
		仿形铣	GL. D NEW		LCMF16, LCMF30	
			MM		MP	
			406		433	
		卡簧槽加工	X61 NEW		TN ZZ EXT	
			469		476	
内孔		切槽	LCMF13			
			F			
			418			
		仿形铣	LCMF13			
			MP			
			419			
		卡簧槽加工	X61 NEW		TN ZZ INT	
			468		477	

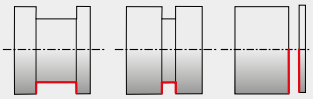
材质识别	应用范围	应用	进给	线速度	耐受不利工况	涂层	颜色	基材	冷却优势	材质说明
T9325	P15 - P35 M10 - M30 K15 - K35 S10 - S20	■ ■ ◪ ◪				MT-CVD		FGM	++	从技术角度来看，这是一种通用性极高的材质，在不利切削工况下具有较高的抗机械损伤能力，并保持出色的耐磨性。该材料的正确应用要求高线速度。
T7325	P15 - P35 M10 - M25 S10 - S25	◪ ■ ■				MT-CVD		FGM	+++	应用最广泛的车削材质之一。专门设计用于加工不锈钢。耐磨性与性能可靠性之间实现了最佳平衡。广泛应用于各类车削作业。
6640	P20 - P40 M20 - M35 K25 - K40	■ ■ ■				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。
T8330	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25 H15 - H25	■ ■ ■ ◪ ◪ ◪				PVD		submicron H	+++	通用切削材料，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。
G8330	P25 - P40 M20 - M35 K20 - K40 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。

基体	
H	WC-Co基体
submicron H	WC-Co基体, 细颗粒度 (< 1 µm)
FGM	功能梯度基

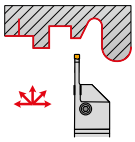
涂层	
MT-CVD	中温CVD涂层
PVD	物理涂层

切削液的优点	
+++	必须使用冷却剂
++	强烈建议使用冷却剂

外圆切槽和切断

GLSF(RL) EXT NEW

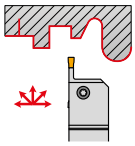


GL.D
GL2 GL3 GL4 GL5 GL6

■
20×20 25×25

410 406 – 408

GLSF(RL) EXT-G NEW

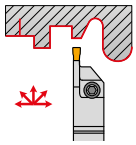


GL.D
GL2 GL3 GL4 GL5 GL6

■
20×20 25×25

412 406 – 408

GLSF(RL) EXT-S NEW

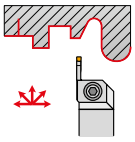


GL.D
GL2 GL3 GL4

■
12×12 16×16

413 406 – 408

GFK(RL) EXT

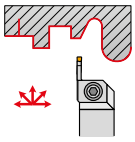


LCMF
0220

■
16×16 25×25

455 418 – 454

GFI(RL) EXT

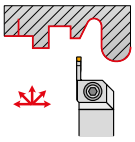


LCMF, LCMR
0316 0416 0516 0616 0830

■
16×16 32×25

437 418 – 454

GFM(RL) EXT

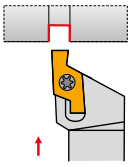


LCMF, LCMR
0316 0416 0516 0616 0830

■
20×20 32×25

439 418 – 454

P61 (RL) EXT NEW

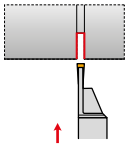


X61

■
16×16 25×25

470 468 – 469

XLCF(RL)

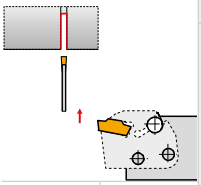


LFUX
03 04 05 06

■
16×12 32×25

465 464

XLCCN 25 BS + MS-EN

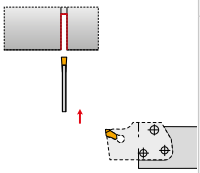


LCMF, LCMR
0316 0416 0516 0616

■
25×25 32×25

442, 443 418 – 454

XLCF(NRL) BS + MS-EN

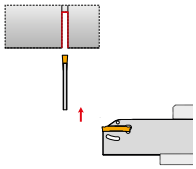


LFMX
1.50 1.60 2.00 2.20 3.10 4.10 5.10 6.35

■
12×12 32×25

461, 463 456 – 458

GLS B + DU, D NEW

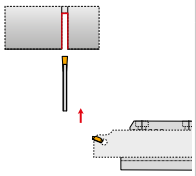


GL.D
GL2 GL3 GL4 GL5 GL6

■
20×20 32×29

414, 415 406 – 409

XLCCN B + DU, D

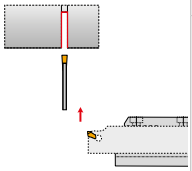


LCMF, LCMR
0316 0416 0516 0616

■
20×20 32×29

440, 441 418 – 454

XLCFN B + DU, D

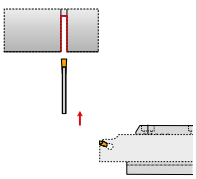


LFMX
1.50 1.60 2.00 2.20 3.10 4.10 5.10 6.35

■
20×20 40×36

459, 460 456 – 458

XLCFN B LFUX + DU, D

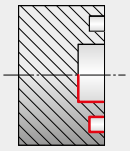


LFUX
03 04 05 06

■
20×20 40×40

466, 467 464

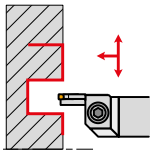
端面切槽



GFIL-L AXIAL

LCMF, LCMR

0313
0316



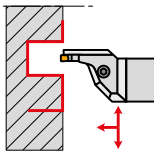
17-30
140-230

422, 444
418 – 454

GFIL-R AXIAL

LCMF, LCMR

0313
0316
0413
0416



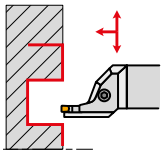
17-30
140-230

423, 445
418 – 454

GFIR-L AXIAL

LCMF, LCMR

0313
0316
0413
0416



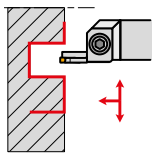
17-30
140-230

424, 446
418 – 454

GFIR-R AXIAL

LCMF, LCMR

0313
0316



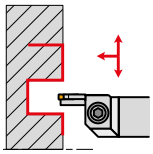
17-30
140-230

425, 447
418 – 454

GFML-L AXIAL

LCMF, LCMR

0413
0416



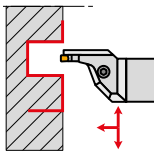
17-30
140-230

426, 448
418 – 454

GFML-R AXIAL

LCMF, LCMR

0413
0416



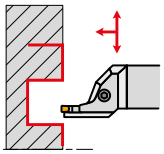
17-30
140-230

427, 449
418 – 454

GFMR-L AXIAL

LCMF, LCMR

0413
0416



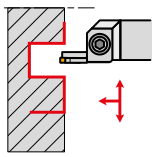
17-30
140-230

428, 450
418 – 454

GFMR-R AXIAL

LCMF, LCMR

0413
0416



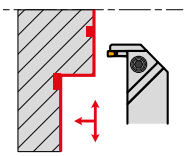
17-30
140-230

429, 451
418 – 454

GGI(RL)-90 AXIAL

LCMF, LCMR

0313
0316



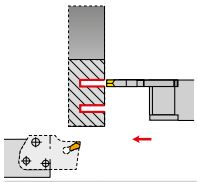
17-30
110-170

430, 452
418 – 454

XLXFL BS AXIAL + MS-EN

LFMX

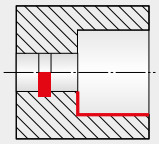
3.10

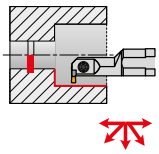


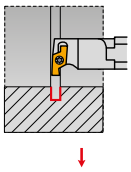
60-85
150-280

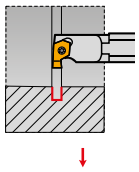
462, 463
456 – 458

内孔切槽



GG.(RL) INT		
		LCMF, LCMR
		0313 0413
ØDmin	16 32	
421		418 – 454

P61 (RL) INT NEW		
		X61
		
ØDmin	16 40	
471		468

P61S(RL)-1 INT NEW		
		X61-1
		
ØDmin	12.5	
474		472

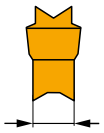
1	2		3	4	5	6	7		8
GL	3	–	D	300	G	02	L06	–	PM



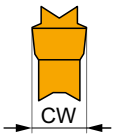
1	2	3	4
刀具组	腔尺寸	切削刃数	切削宽度 - CW

GL

1, 2, 3, 4, 5, 6



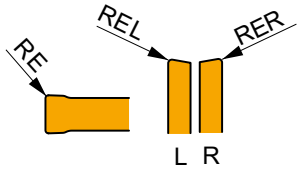
S	单刃
D	双刃



	CW
200	2.00
250	2.50
300	3.00
400	4.00
500	5.00
600	6.00

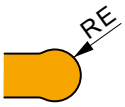
5	6	7	8
切削刃设计	刀尖半径	主偏角	断屑槽名称

G	精磨刀片
M	压铸刀片

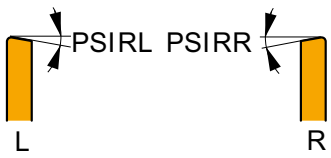


	RE, RER, REL (mm)
02	0.2
03	0.3
04	0.4
08	0.8

圆刃槽型



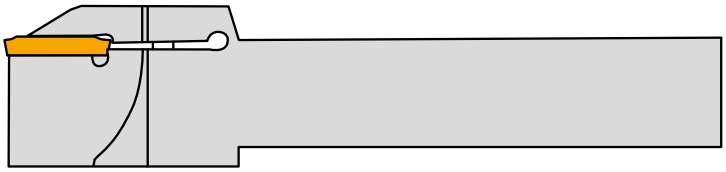
	RE (mm)
M0	RE = CW/2



	(°)
06	6
12	12

PM
PR
GM
MM

1	2		3	4	5	6	7		8		9	10	11
GL	3	–	S	2525	M	F	L	–	20	–	R	120	090

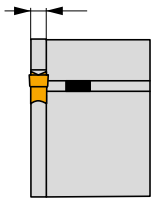


1 刀具组

GL

2 刀座尺寸

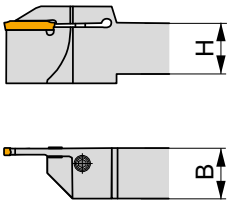
1, 2, 3, 4, 5, 6



3 刀柄类型

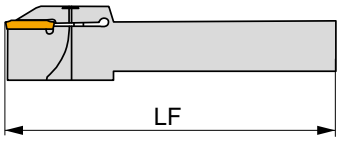
A	带内冷通道的钢制刀柄
S	钢制刀柄，无内冷通道

4 刀杆尺寸



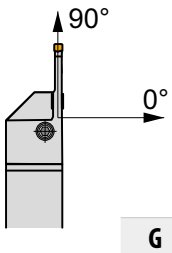
	H/B (mm)/ (mm)
1212 –	12/12
1616 –	16/16
2020 –	20/20
2525 –	25/25

5 刀杆总长 - LF



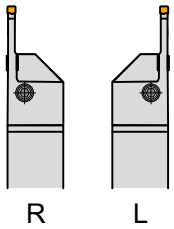
	LF (mm)
H	100
K	125
M	150
P	170

6 刀杆类型 – 主偏角

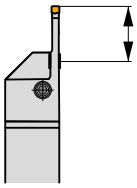


	(°)
G	0
F	90

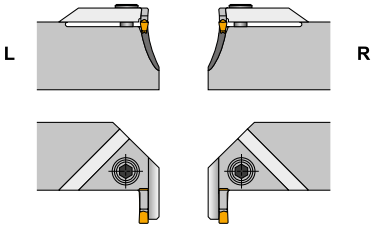
7 刀柄类别（右/左）



8 切削深度 最大值 - CDX

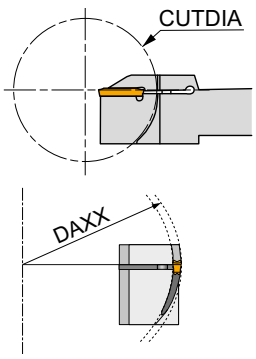


9 刀板曲率方向

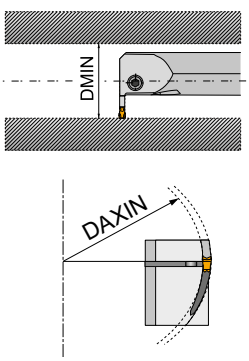


轴向车削的附加信息

10 最大直径



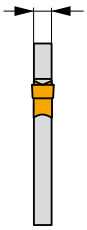
11 最小直径



1	2		3	4	5	6
GL	3	–	S	32	M	B



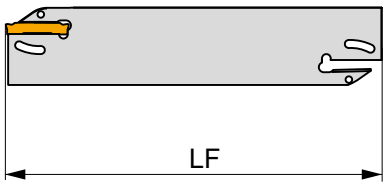
1	2	3
刀具组	刀座尺寸	刀柄类型
GL	1, 2, 3, 4, 5, 6	A 带内冷通道的钢制刀柄 S 钢制刀柄 , 无内冷通道



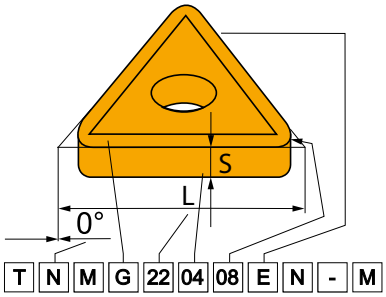
4	5	6
刀杆尺寸	刀板总长 - LF	刀杆类型
		B - 刀板



	H (mm)
26	26
32	32



	LF (mm)	LF (")
K	125	5.000"
M	150	6.000"



	1	2	3	4
ISO	T T	N N	U M	N G
ANSI	T T	N N	U 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

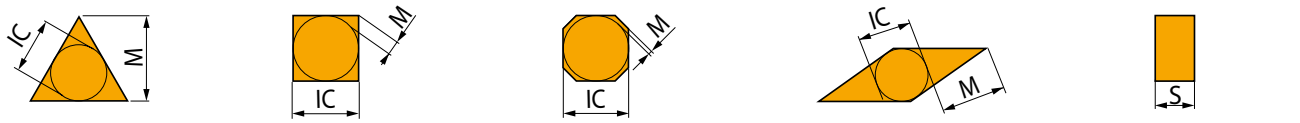
A 3°		B 5°	
C 7°		D 15°	
E 20°		F 25°	
G 30°		N 0°	
P 11°		O	非标

4 刀片类型

N	
R	
F	
A	
M	
G	
W	40° – 60°
T	
Q	
U	
B	70° – 90°
H	
C	
J	
X	非标

3 公差

	(mm)			(")		
	M (±)	S (±)	IC (±)	M (±)	S (±)	IC (±)
A	0.005	0.025	0.025	.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"

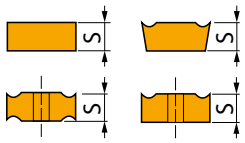


5	6	7	8	9		10
22	04	08			-	
22	04	08	E	N		M
5	6	7	8	9		10
4	3	2			-	
4	3	2	E	N		M

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"



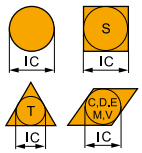
圆刀片

d = I.C.	
(")	00
(mm)	M0



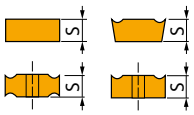
ANSI

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

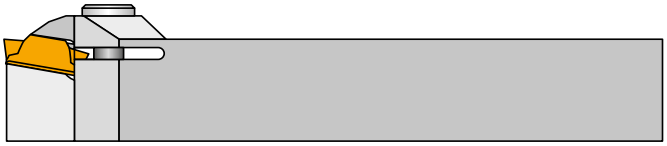
9 进给方向

R	进给 ←	N	进给 ← → 进给
L	→ 进给		

10 断屑槽类型

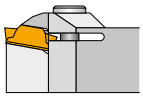
切断和切槽刀具 (外圆车削) – ISO代码名称

	1	2	3	4	5	6	7	8	9	10	11
ISO	G	F	I	L	25	25	M	0316	R	030	017
ANSI	1	2	3	4	5 & 6		7	8	9	10	11
	G	F	I	L	16		D	0316	R	1.18	.670

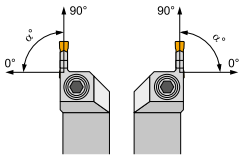


1 夹紧类型

G



2 刀杆类型 - 主偏角



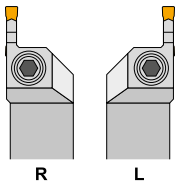
α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°

3 最大切削深度 – CDX

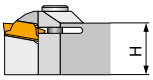


G = 2.0 × CW	N = 5.5 × CW
H = 2.5 × CW	O = 6.0 × CW
I = 3.0 × CW	P = 6.5 × CW
J = 3.5 × CW	Q = 7.0 × CW
K = 4.0 × CW	R = 7.5 × CW
L = 4.5 × CW	S = 8.0 × CW
M = 5.0 × CW	T = 8.5 × CW

4 刀柄类别 (右/左)

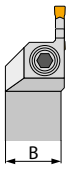


5 刀杆高度 (mm)



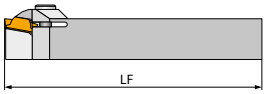
12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.

6 刀杆宽度 (mm)



12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.

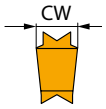
7 刀杆总长



	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



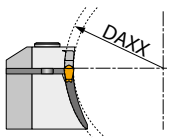
	CW (mm)	CW (")
02	2.0	.079"
03, 0313, 0316	3.0	.118"
04, 0413, 0416	4.0	.157"
05, 0516	5.0	.197"
06, 0616	6.0	.236"
08, 0830	8.0	.315"

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"

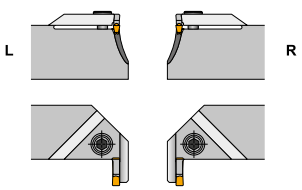
对于方刀杆, 数字为宽度和高度的1/16, 对于矩形刀杆, 第一个数字是宽度的1/8, 第二个数字是高度的1/4

10 最大直径 - 端面槽加工



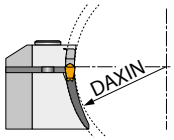
轴向车削的附加信息

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

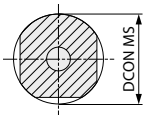
	1	2	3		4	5	6	7	8
ISO	A	25	S	–	G	G	H	L	0313
ANSI	A	16	S	–	G	G	H	L	0313



1 刀杆

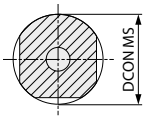
S	钢制刀柄
A	带冷却孔钢制刀柄

2 刀柄直径(公制)



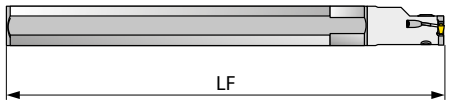
	DCON MS [mm]
12	12
16	16
20	20
25	25
32	32
40	40

2 刀柄直径(公制)



	DCON MS (")
08	.500"
10	.625"
12	.750"
16	1.000"
20	1.250"
24	1.500"

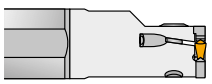
3 刀杆总长



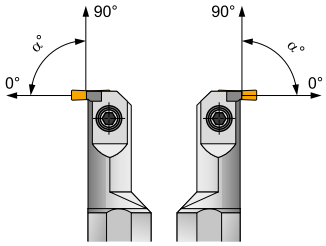
	LF [mm]	LF (")		LF [mm]	LF (")
M	150	6.000"	S	250	10.000"
P	170	6.250"	T	300	12.000"
Q	180	7.250"	U	350	14.000"
R	200	8.000"	V	400	15.750"

4 夹紧类型

G



5 刀杆类型 - 主偏角



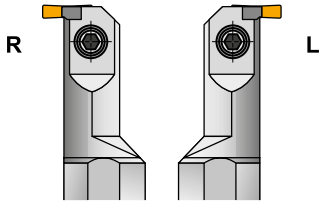
α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°

6 最大切削深度 – CDX

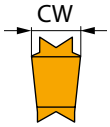


E = 1.0 × CW	J = 3.5 × CW
F = 1.5 × CW	K = 4.0 × CW
G = 2.0 × CW	L = 4.5 × CW
H = 2.5 × CW	M = 5.0 × CW
I = 3.0 × CW	N = 5.5 × CW
X = Special	

7 刀柄类别（右/左）



8 刀片宽度



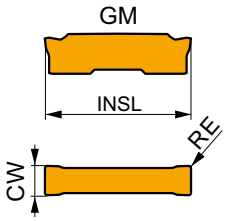
	CW [mm]
0313	3.0
0413	4.0

NEW

GL. D - GM

PRAMET

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

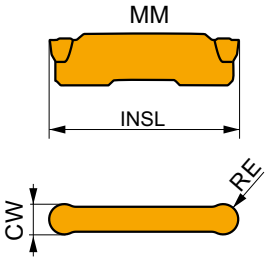
产品型号		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			U E																	
			GM断屑槽，适用于开槽和轴向车削，连续至断续切削。																	
GL2-D200M02-GM	**G8330**	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
	T7325	0.2	220	0.10	0.8	170	0.09	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	–	–	–
	T7325	0.2	175	0.20	1.0	135	0.18	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	–	–	–
	T7325	0.4	185	0.20	1.0	140	0.18	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	–	–	–
	T7325	0.4	170	0.25	1.2	130	0.23	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	–	–	–
	T7325	0.8	200	0.25	1.2	155	0.23	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	–	–	–
	T7325	0.8	190	0.30	1.2	145	0.27	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	–	–	–
	T7325	0.8	190	0.30	1.2	145	0.27	1.2	–	–	–	–	–	–	60	0.21	1.0	–	–	–

NEW

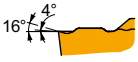
GL. D - MM

PRAMET

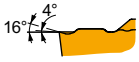
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0



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。

产品型号		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			U S																	
			MM断屑槽，球头外形，适用于仿形加工和轴向车削，连续至断续切削。																	
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	–	–	–
	T7325	1.0	285	0.10	1.0	220	0.09	1.0	–	–	–	–	–	–	90	0.08	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。

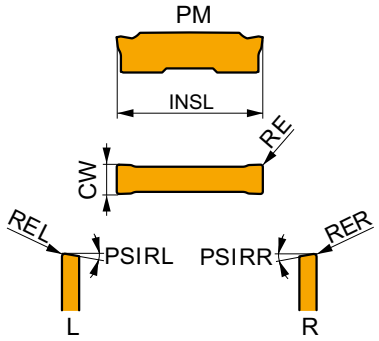
产品型号		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			U S																	
MM断屑槽，球头外形，适用于仿形加工和轴向车削，连续至断续切削。																				
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	–	–	–
	T7325	1.5	◪ 240	0.20	1.2	■ 185	0.18	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	–	–	–
	T7325	2.0	◪ 250	0.20	1.2	■ 195	0.18	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	–	–	–
	T7325	2.5	◪ 235	0.25	1.2	■ 180	0.23	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	–	–	–
	T7325	3.0	◪ 220	0.30	1.2	■ 170	0.27	1.2	–	–	–	–	–	–	◪ 70	0.21	1.0	–	–	–

NEW

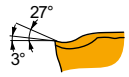
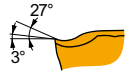
GL. D - PM

PRAMET

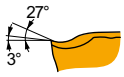
	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
250	2.55	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



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。

产品型号		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 (°)
			1		E											
PM断屑槽，是切断和开槽的首选，连续切削至轻微断续切削。																
GL2-D200M02-PM	G8330	0.2	■ 130	0.08	■ 75	0.07	◪ 120	0.08	–	–	◪ 30	0.06	–	–	–	–
	T7325	0.2	◪ 150	0.08	■ 115	0.07	–	–	–	–	◪ 45	0.06	–	–	–	–
GL3-D250G02-PM	G8330	0.2	■ 130	0.10	■ 75	0.09	◪ 120	0.10	–	–	◪ 30	0.07	–	–	–	–
GL3-D300M02-PM	G8330	0.2	■ 130	0.10	■ 75	0.09	◪ 120	0.10	–	–	◪ 30	0.07	–	–	–	–
	T7325	0.2	◪ 150	0.10	■ 115	0.09	–	–	–	–	◪ 45	0.07	–	–	–	–
GL4-D400M02-PM	G8330	0.2	■ 130	0.12	■ 75	0.11	◪ 120	0.12	–	–	◪ 30	0.10	–	–	–	–
	T7325	0.2	◪ 150	0.12	■ 115	0.11	–	–	–	–	◪ 45	0.10	–	–	–	–
GL5-D500M03-PM	G8330	0.3	■ 130	0.15	■ 75	0.14	◪ 120	0.15	–	–	◪ 30	0.12	–	–	–	–
GL6-D600M03-PM	G8330	0.3	■ 130	0.15	■ 75	0.14	◪ 120	0.15	–	–	◪ 30	0.12	–	–	–	–
																
R-PM右手断屑槽，是切断加工的首选，连续切削或打断切削。																
GL2-D200G02R06-PM	G8330	0.2	■ 130	0.08	■ 75	0.07	◪ 120	0.08	–	–	◪ 30	0.06	–	–	6	–
	T7325	0.2	◪ 150	0.08	■ 115	0.07	–	–	–	–	◪ 45	0.06	–	–	6	–
GL2-D200G02R12-PM	G8330	0.2	■ 130	0.08	■ 75	0.07	◪ 120	0.08	–	–	◪ 30	0.06	–	–	12	–
GL3-D300G02R06-PM	G8330	0.2	■ 130	0.10	■ 75	0.09	◪ 120	0.10	–	–	◪ 30	0.07	–	–	6	–
	T7325	0.2	◪ 150	0.10	■ 115	0.09	–	–	–	–	◪ 45	0.07	–	–	6	–
GL3-D300G02R12-PM	G8330	0.2	■ 130	0.10	■ 75	0.09	◪ 120	0.10	–	–	◪ 30	0.07	–	–	12	–
GL4-D400G02R06-PM	G8330	0.2	■ 130	0.12	■ 75	0.11	◪ 120	0.12	–	–	◪ 30	0.10	–	–	6	–
	T7325	0.2	◪ 150	0.12	■ 115	0.11	–	–	–	–	◪ 45	0.10	–	–	6	–
GL4-D400G02R12-PM	G8330	0.2	■ 130	0.12	■ 75	0.11	◪ 120	0.12	–	–	◪ 30	0.10	–	–	12	–

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。

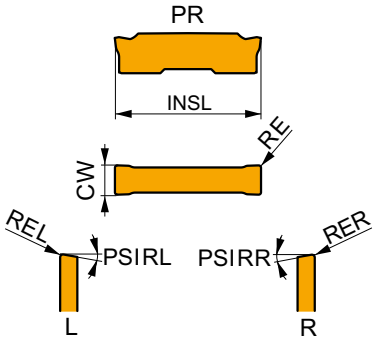
产品型号		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(°)	(°)
																
			E													
			L-PM左撇子断屑槽，是切断加工，连续切削至轻微断续切削的首选。													
GL2-D200G02L06-PM	G8330	0.2	130	0.08	75	0.07	120	0.08	–	–	30	0.06	–	–	–	6
	T7325	0.2	150	0.08	115	0.07	–	–	–	–	45	0.06	–	–	–	6
GL2-D200G02L12-PM	G8330	0.2	130	0.08	75	0.07	120	0.08	–	–	30	0.06	–	–	–	12
GL3-D300G02L06-PM	G8330	0.2	130	0.10	75	0.09	120	0.10	–	–	30	0.07	–	–	–	6
	T7325	0.2	150	0.10	115	0.09	–	–	–	–	45	0.07	–	–	–	6
GL3-D300G02L12-PM	G8330	0.2	130	0.10	75	0.09	120	0.10	–	–	30	0.07	–	–	–	12
GL4-D400G02L06-PM	G8330	0.2	130	0.12	75	0.11	120	0.12	–	–	30	0.10	–	–	–	6
	T7325	0.2	150	0.12	115	0.11	–	–	–	–	45	0.10	–	–	–	6
GL4-D400G02L12-PM	G8330	0.2	130	0.12	75	0.11	120	0.12	–	–	30	0.10	–	–	–	12

NEW

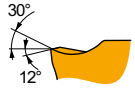
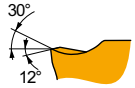
GL. D - PR

PRAMET

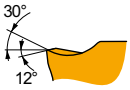
	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



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。

产品型号		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(°)	(°)
																
			U								S					
			PR断屑槽，是切断和开槽加工的首选，连续切削至间断切削。													
GL2-D200M02-PR	G8330	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
	T7325	0.2	150	0.10	115	0.09	–	–	–	–	–	–	–	–	–	–
GL3-D300M02-PR	G8330	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
	T7325	0.2	150	0.12	115	0.11	–	–	–	–	–	–	–	–	–	–
GL4-D400M02-PR	G8330	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
	T7325	0.2	150	0.15	115	0.14	–	–	–	–	–	–	–	–	–	–
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	–	–	–	–	–	–	–	–
																
			S													
			R-PR右撇子断屑槽，是切断加工的首选，连续切削或间断切削。													
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	–

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。

产品型号		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(°)	(°)
			S													
			L-PR左撇子断屑槽，是切断加工的首选，适用于连续切削至间断切削。													
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

NEW

GLSF(RL) EXT

P M K N S H

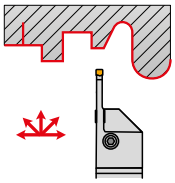
PRAMET

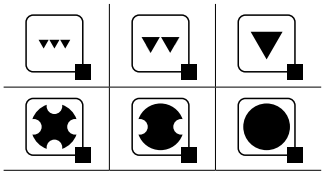
G

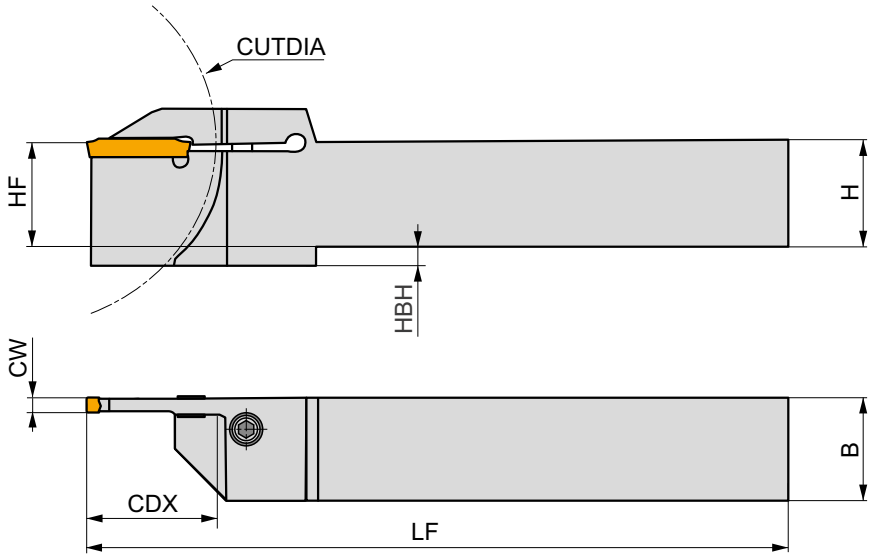


外圆用开槽和切断加工刀具，V-型刀片槽，顶部夹紧，使用GL刀片。

外圆用左/右手径向车刀杆，开槽加工。使用GL2、3、4、5或6的双面刀片。适用于径向开槽和切断应用，最大切削深度可达32mm的刀柄。可提供20x20或25x25mm的刀柄。加强的刀体设计，可延长刀具寿命并降低振动。









	产品型号	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	GL2-S2020KFR-20-80	20	–	20	20	125	2.00	20	80	0.38	GI334	GL11
	GL2-S2020KFR-24-80	20	5	20	20	125	2.00	24	80	0.36	GI334	GL11
	GL2-S2525MFR-20-80	25	–	25	25	150	2.00	20	80	0.68	GI334	GL11
	GL2-S2525MFR-24-80	25	–	25	25	150	2.00	24	80	0.64	GI334	GL11
	GL3-S2020KFR-20-80	20	–	20	20	125	3.00	20	80	0.38	GI335	GL11
	GL3-S2020KFR-24-80	20	5	20	20	125	3.00	24	80	0.36	GI335	GL11
	GL3-S2525MFR-20-80	25	–	25	25	150	3.00	20	80	0.68	GI335	GL11
	GL3-S2525MFR-24-80	25	–	25	25	150	3.00	24	80	0.65	GI335	GL11
	GL3-S2525PFR-32-80	25	5	25	25	170	3.00	32	80	0.72	GI335	GL11
	GL4-S2020KFR-20-80	20	–	20	20	125	4.00	20	80	0.38	GI336	GL11
	GL4-S2020KFR-24-80	20	5	20	20	125	4.00	24	80	0.37	GI336	GL11
	GL4-S2525MFR-20-80	25	–	25	25	150	4.00	20	80	0.68	GI336	GL11
	GL4-S2525MFR-24-80	25	–	25	25	150	4.00	24	80	0.65	GI336	GL11
	GL4-S2525PFR-32-80	25	5	25	25	170	4.00	32	80	0.78	GI336	GL11
	GL5-S2020KFR-20-80	20	–	20	20	125	5.00	20	80	0.38	GI337	GL11
	GL5-S2525MFR-20-80	25	–	25	25	150	5.00	20	80	0.68	GI337	GL11
	GL5-S2525PFR-32-100	25	5	25	25	170	5.00	32	100	0.75	GI337	GL11
	GL6-S2020KFR-20-80	20	–	20	20	125	6.00	20	80	0.39	GI338	GL11
	GL6-S2525MFR-20-80	25	–	25	25	150	6.00	20	80	0.68	GI338	GL11
	GL6-S2525PFR-32-100	25	5	25	25	170	6.00	32	100	0.75	GI338	GL11
L	GL2-S2020KFL-20-80	20	–	20	20	125	2.00	20	80	0.38	GI334	GL11
	GL2-S2020KFL-24-80	20	5	20	20	125	2.00	24	80	0.36	GI334	GL11
	GL2-S2525MFL-20-80	25	–	25	25	150	2.00	20	80	0.70	GI334	GL11
	GL2-S2525MFL-24-80	25	–	25	25	150	2.00	24	80	0.64	GI334	GL11
	GL3-S2020KFL-20-80	20	–	20	20	125	3.00	20	80	0.38	GI335	GL11
	GL3-S2020KFL-24-80	20	5	20	20	125	3.00	24	80	0.36	GI335	GL11
	GL3-S2525MFL-20-80	25	–	25	25	150	3.00	20	80	0.68	GI335	GL11

	产品型号	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
L	**GL3-S2525MFL-24-80**	25	–	25	25	150	3.00	24	80	0.65	GI335	GL11
	GL3-S2525PFL-32-80	25	5	25	25	170	3.00	32	80	0.78	GI335	GL11
	GL4-S2020KFL-20-80	20	–	20	20	125	4.00	20	80	0.38	GI336	GL11
	GL4-S2020KFL-24-80	20	5	20	20	125	4.00	24	80	0.37	GI336	GL11
	GL4-S2525MFL-20-80	25	–	25	25	150	4.00	20	80	0.68	GI336	GL11
	GL4-S2525MFL-24-80	25	–	25	25	150	4.00	24	80	0.65	GI336	GL11
	GL4-S2525PFL-32-80	25	5	25	25	170	4.00	32	80	0.72	GI336	GL11
	GL5-S2020KFL-20-80	20	–	20	20	125	5.00	20	80	0.38	GI337	GL11
	GL5-S2525MFL-20-80	25	–	25	25	150	5.00	20	80	0.71	GI337	GL11
	GL5-S2525PFL-32-100	25	5	25	25	170	5.00	32	100	0.75	GI337	GL11
	GL6-S2020KFL-20-80	20	–	20	20	125	6.00	20	80	0.39	GI338	GL11
	GL6-S2525MFL-20-80	25	–	25	25	150	6.00	20	80	0.71	GI338	GL11
	GL6-S2525PFL-32-100	25	5	25	25	170	6.00	32	100	0.75	GI338	GL11

GI334	GL2..
GI335	GL3..
GI336	GL4..
GI337	GL5..
GI338	GL6..

		Nm			
GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P

加工直径上的切深在xxx页

NEW

GLSF(RL) EXT-G

P M K N S H

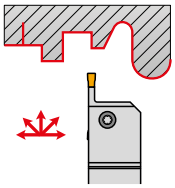
PRAMET

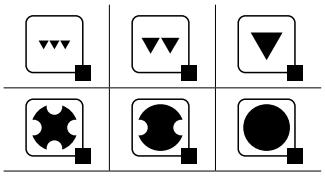
G

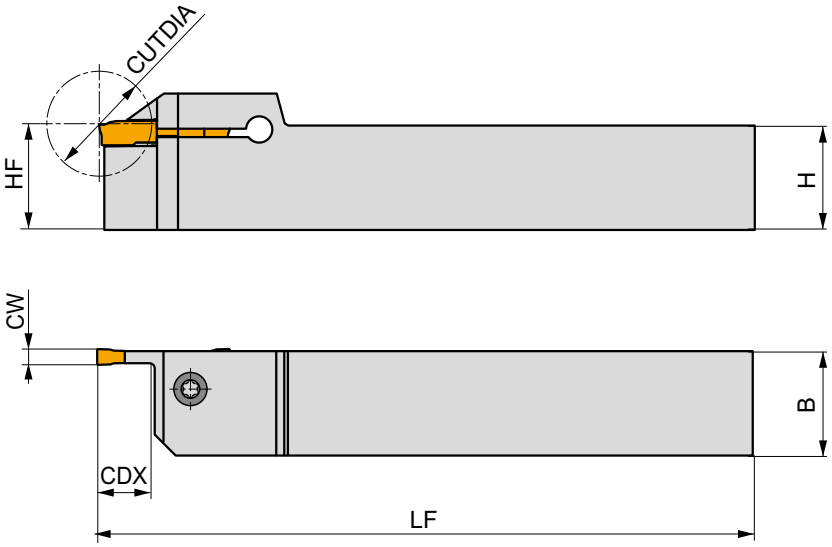


外圆用开槽和车削加工刀具，V-型刀片槽，顶部夹紧，使用GL刀片。

外圆用左/右手径向车刀杆，开槽加工。使用GL2、3、4、5或6型双面刀片。适用于径向开槽，轴向车削和仿形应用，最大切削深度可达12mm的刀柄。可提供20x20或25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	GL2-S2020KFR-10	20	20	20	125	2.00	10	20	0.38	GI334	GL11
	GL2-S2525MFR-10	25	25	25	150	2.00	10	20	0.69	GI334	GL11
	GL3-S2020KFR-10	20	20	20	125	3.00	10	20	0.36	GI335	GL11
	GL3-S2525MFR-10	25	25	25	150	3.00	10	20	0.69	GI335	GL11
	GL4-S2020KFR-12	20	20	20	125	4.00	12	24	0.37	GI336	GL11
	GL4-S2525MFR-12	25	25	25	150	4.00	12	24	0.69	GI336	GL11
	GL5-S2020KFR-12	20	20	20	125	5.00	12	24	0.36	GI337	GL11
	GL5-S2525MFR-12	25	25	25	150	5.00	12	24	0.70	GI337	GL11
	GL6-S2020KFR-12	20	20	20	125	6.00	12	24	0.36	GI338	GL11
	GL6-S2525MFR-12	25	25	25	150	6.00	12	24	0.68	GI338	GL11
L	GL2-S2020KFL-10	20	20	20	125	2.00	10	20	0.37	GI334	GL11
	GL2-S2525MFL-10	25	25	25	150	2.00	10	20	0.70	GI334	GL11
	GL3-S2020KFL-10	20	20	20	125	3.00	10	20	0.36	GI335	GL11
	GL3-S2525MFL-10	25	25	25	150	3.00	10	20	0.70	GI335	GL11
	GL4-S2020KFL-12	20	20	20	125	4.00	12	24	0.37	GI336	GL11
	GL4-S2525MFL-12	25	25	25	150	4.00	12	24	0.69	GI336	GL11
	GL5-S2020KFL-12	20	20	20	125	5.00	12	24	0.36	GI337	GL11
	GL5-S2525MFL-12	25	25	25	150	5.00	12	24	0.69	GI337	GL11
	GL6-S2020KFL-12	20	20	20	125	6.00	12	24	0.36	GI338	GL11
	GL6-S2525MFL-12	25	25	25	150	6.00	12	24	0.68	GI338	GL11

GI334	GL2..
GI335	GL3..
GI336	GL4..
GI337	GL5..
GI338	GL6..

		Nm			
GL11	US 5018-T20P	5.0	M 5	18.2	LKT20P

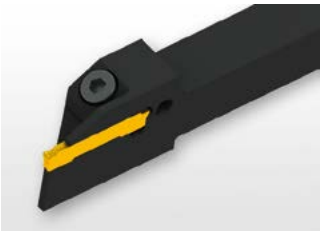
NEW

GLSF(RL) EXT-S

P M K N S H

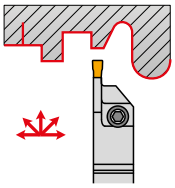
PRAMET

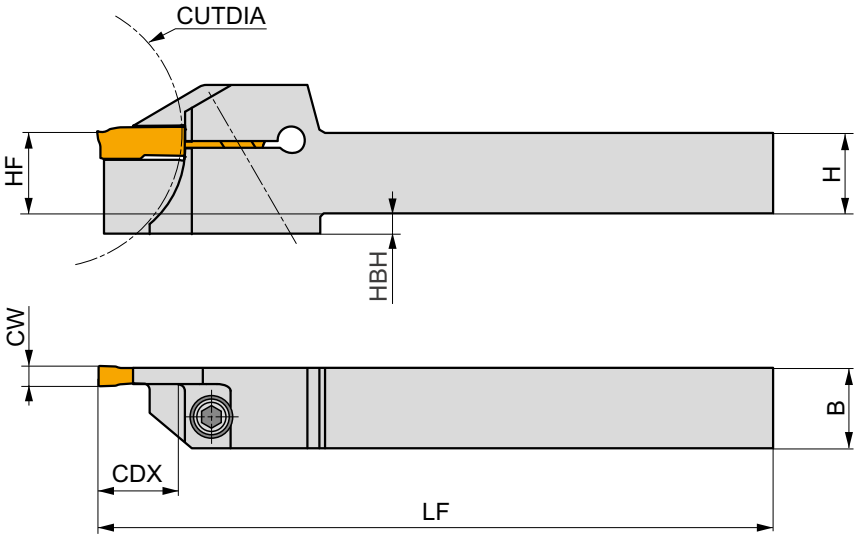
G

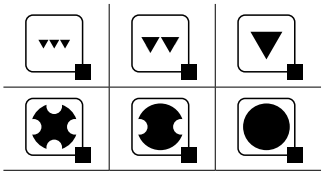


外圆用开槽和切断加工刀具，使用GL刀片的滑动刀架机构。

外圆用左/右手径向车刀杆。使用GL 2、3、4刀窝宽度的滑动刀架机构。适用于径向开槽，仿形和切断应用，最大切削深度可达16mm的刀柄。可提供12x12或16x16mm的刀柄。加强型刀杆设计，延长了刀具的使用寿命，降低了振动，易于夹紧。









	产品型号	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	**GL2-S1212HFR-12-40**	12	3	12	12	100	2.00	12	40	0.11	GI334	GL13
	GL2-S1616KFR-16-45	16	3	16	16	125	2.00	16	45	0.23	GI334	GL12
	GL3-S1212HFR-12-40	12	3	12	12	100	3.00	12	40	0.11	GI335	GL13
	GL3-S1616KFR-16-45	16	3	16	16	125	3.00	16	45	0.23	GI335	GL12
	GL4-S1616KFR-16-45	16	4	16	16	125	4.00	16	45	0.26	GI336	GL12
L	**GL2-S1212HFL-12-40**	12	3	12	12	100	2.00	12	40	0.11	GI334	GL13
	GL2-S1616KFL-16-45	16	3	16	16	125	2.00	16	45	0.23	GI334	GL12
	GL3-S1212HFL-12-40	12	3	12	12	100	3.00	12	40	0.11	GI335	GL13
	GL3-S1616KFL-16-45	16	3	16	16	125	3.00	16	45	0.23	GI335	GL12
	GL4-S1616KFL-16-45	16	4	16	16	125	4.00	16	45	0.24	GI336	GL12

GI334	GL2..
GI335	GL3..
GI336	GL4..

		Nm			
GL12	HS 0516	5.0	M 5	16	HXK 4
GL13	HS 0412	5.0	M 4	12	HXK 3

加工直径上的切深在416页

NEW

GLS B

P M K N S H

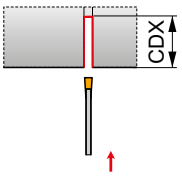
PRAMET

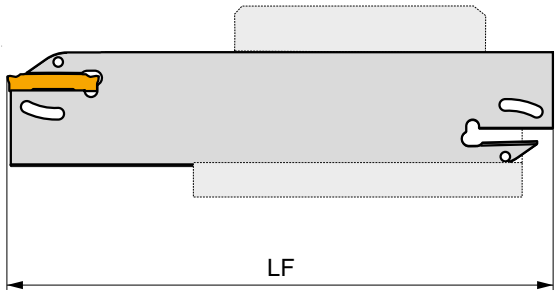
X

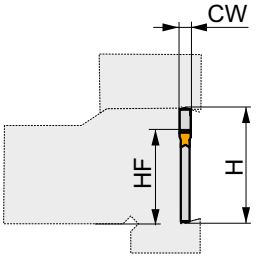


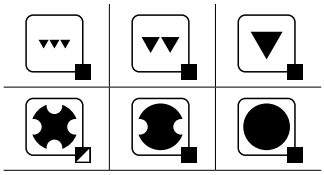
使用GL刀片，双头切断刀板

刀板用于切断应用，最大深度为60mm或Ø120mm的棒材。适用于双面刀片GL系列。高度分别为26和32mm。可以安装在DU Premet基础刀杆上。经过处理，使用寿命更长。











产品型号	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
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	0.16	GI335	KV2
GL4-S32MB	25	32	150	4.00	50	0.16	GI336	KV2
GL5-S32MB	25	32	150	5.00	60	0.16	GI337	KV2
GL6-S32MB	25	32	150	6.00	60	0.16	GI338	KV2

GI334	GL2..
GI335	GL3..
GI336	GL4..
GI337	GL5..
GI338	GL6..

KV2	KV 15x150

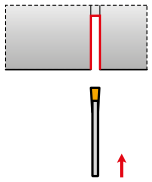
DU, D

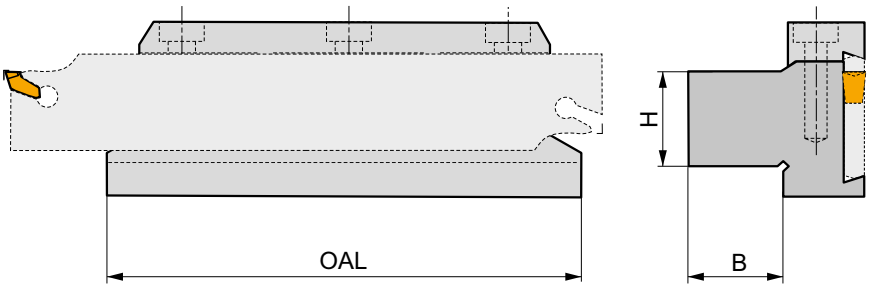
PRAMET

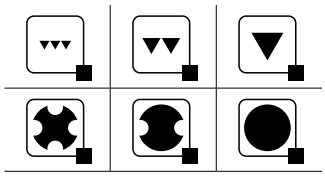


切断刀板的车刀座

刀座适合GL或XLC，切断刀板。可提供20x20至40x40mm的刀柄。刀杆经过处理，使用寿命更长。







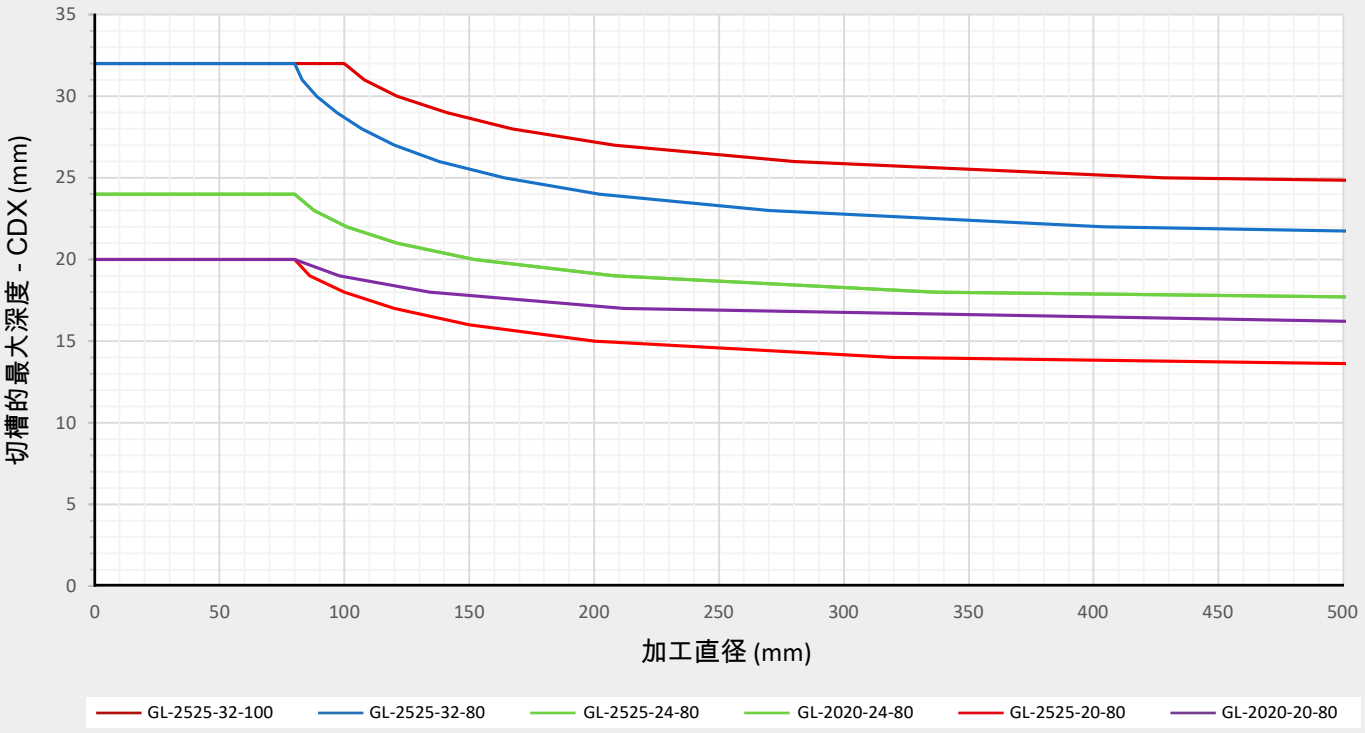
产品型号	H (mm)	B (mm)	OAL (mm)	kg		
26-DU 2020	20	20	90	0.70	GI007	ND2
26-D 2020	20	20	100	0.82	GI007	ND2
32-DU 2523	25	23	110	1.02	GI008	ND2
32-DU 2532	25	32	110	1.10	GI008	ND2
32-DU 3229	32	29	110	1.25	GI008	ND2
32-D 2530	25	30	115	1.30	GI008	ND2
45-DU 3229	32	29	110	1.50	GI009	ND7
45-DU 4036	40	36	110	2.05	GI009	ND7
47-D 4040	40	40	150	3.88	GI091	ND3

GI007	XLC.N 26..	GL.-S26.B
GI008	XLC.N 32..	GL.-S32.B
GI009	XLC.N 45..	–
GI091	XLC.N 47..	–

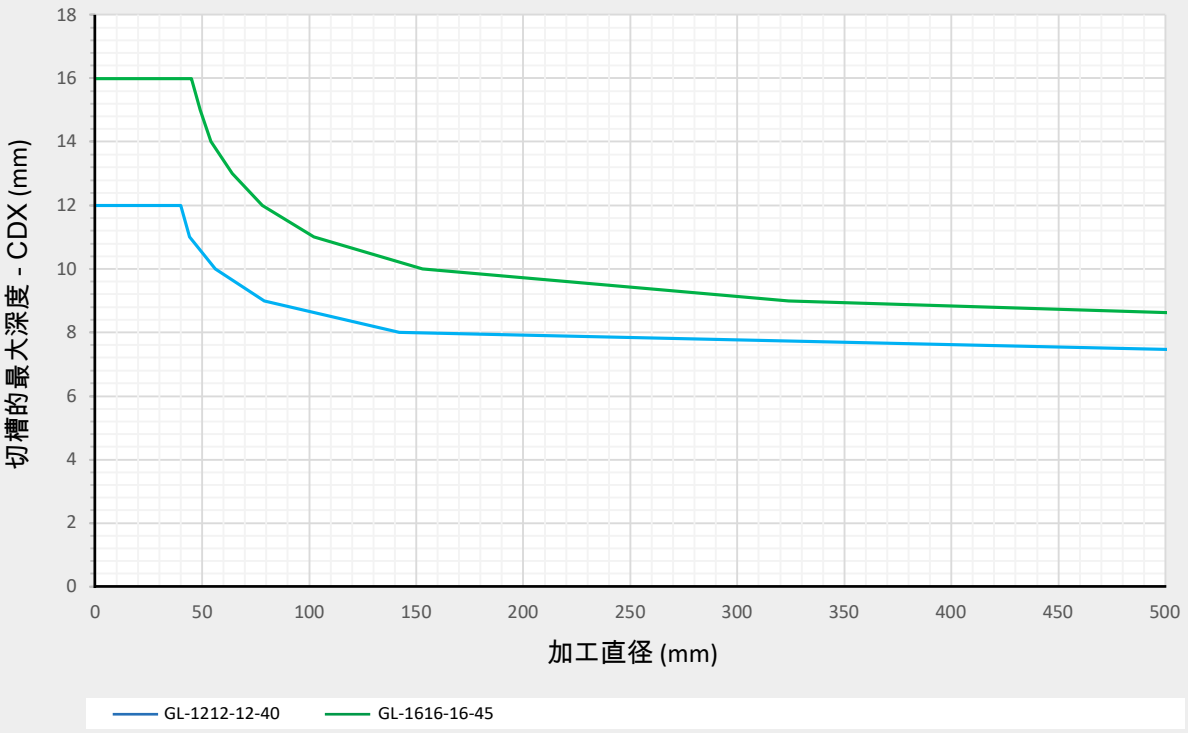
		Nm			
ND2	HS 0625	6.0	M 6	25	HXK 5
ND3	HS 1030	8.0	M 10	30	HXK 8
ND7	HS 0630	6.0	M 6	30	HXK 5

切削深度随加工直径变化

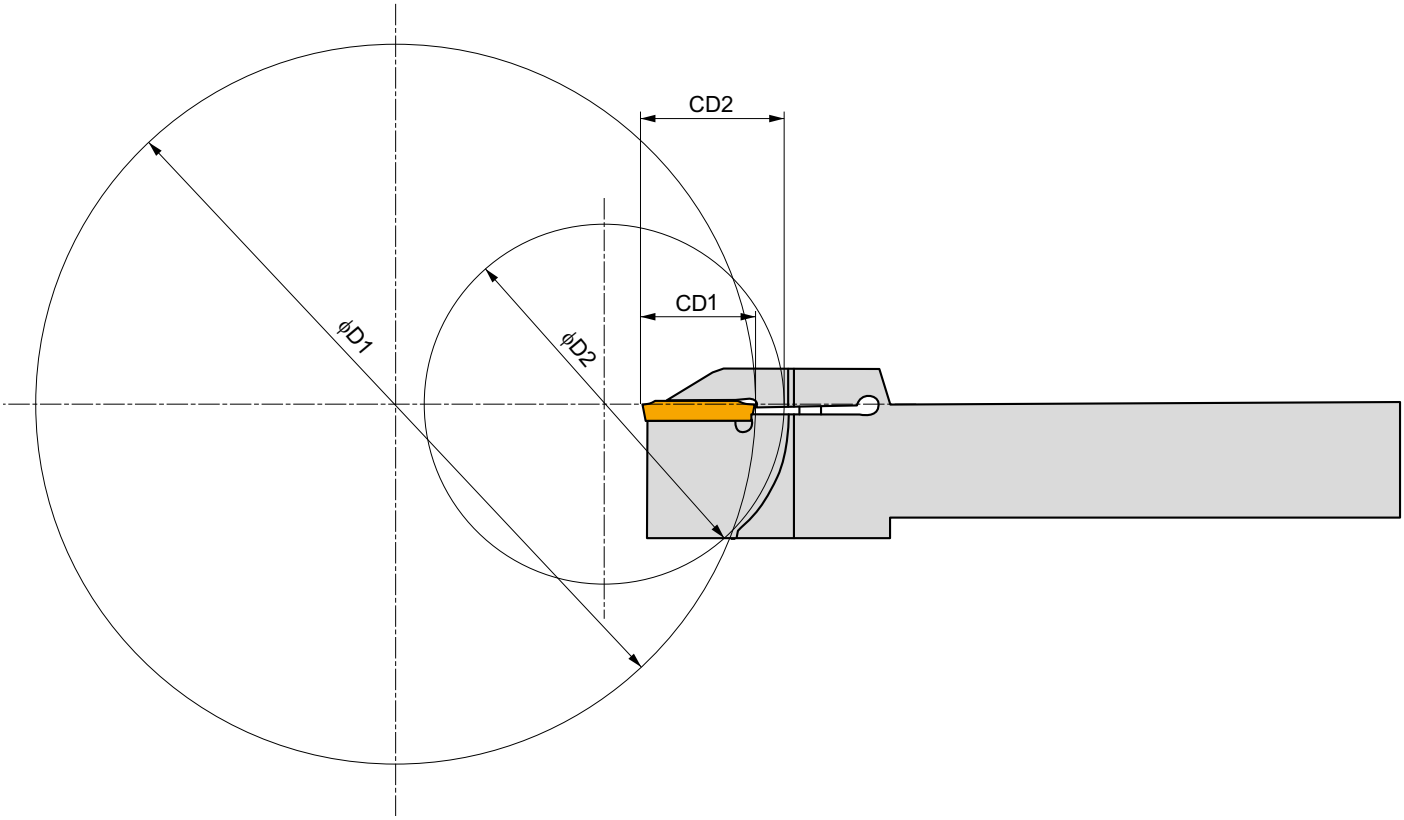
GLSF (RL) EXT



GLSF (RL) EXT-S



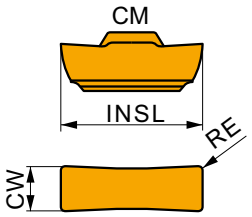
切削深度随加工直径变化



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。

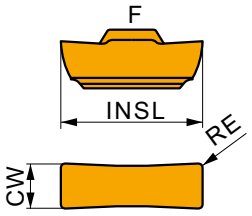
产品型号		RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
			E													
CM断屑槽，开槽的首选。																
LCMF 031304-CM	**T8330**	0.4	■ 130	0.11	◪ 75	0.10	◪ 120	0.11	–	–	–	–	–	–	–	–
LCMF 031304-CM-04	**T8330**[1)]	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	–	–	–	–	–	–	–	–

[1)] Insert for internal holder A16Q-GGERIL0313-04, A20R-GGFRIL0313-04.

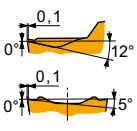
LCMF 13 - F

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。

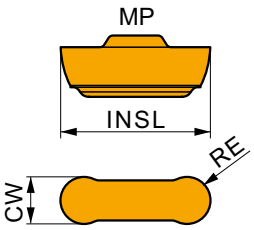
产品型号		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			U			S														
F断屑槽，车削的首选。																				
LCMF 031302-F	**T8330**	0.2	■ 195	0.10	0.3	◪ 115	0.09	0.3	◪ 185	0.10	0.3	–	–	–	–	–	–	–	–	–
LCMF 031302-F-04	**T8330**[1)]	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 031304-F-04	**T8330**[1)]	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	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 275	0.13	0.5	◪ 165	0.12	0.5	◪ 260	0.13	0.5	–	–	–	–	–	–	–	–	–

[1)] Insert for internal holder A16Q-GGERIL0313-04, A20R-GGFRIL0313-04.

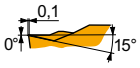
LCMF 13 - MP

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。

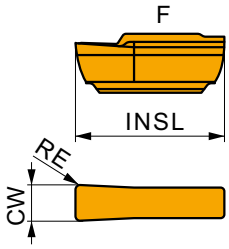
产品型号		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
MP断屑槽，适用于轴向车削和仿形，超精加工和精加工，连续至断续切削。																				
LCMF 0313MO-MP	**T8330**	1.5	■ 190	0.30	0.8	◪ 110	0.27	0.8	■ 180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMF 0313MO-MP-04	**T8330**[1)]	1.5	■ 190	0.30	0.8	◪ 110	0.27	0.8	■ 180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMF 0413MO-MP	**T8330**	2.0	■ 175	0.40	1.0	◪ 105	0.36	1.0	■ 165	0.40	1.0	–	–	–	–	–	–	–	–	–

[1)] Insert for internal holder A16Q-GGERIL0313-04, A20R-GGFRIL0313-04.

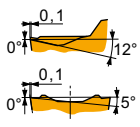
LCMR 13 - F

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

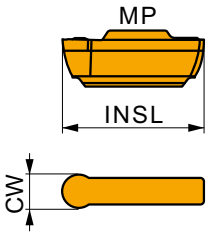


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

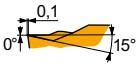
产品型号		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
F断屑槽，适用于开槽和车削，超精加工和精加工，连续切削至轻微断续切削。																				
LCMR 031304-F	**T8330**	0.4	■ 185	0.13	0.5	◪ 110	0.12	0.5	◪ 175	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMR 041304-F	**T8330**	0.4	■ 185	0.13	0.5	◪ 110	0.12	0.5	◪ 175	0.13	0.5	–	–	–	–	–	–	–	–	–

LCMR 13 - MP

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(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。

产品型号		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
LCMR 0313MO-MP	**T8330**	1.5	■	190	0.30	0.8	◪	110	0.27	0.8	■	180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMR 0413MO-MP	**T8330**	2.0	■	175	0.40	1.0	◪	105	0.36	1.0	■	165	0.40	1.0	–	–	–	–	–	–	–	–	–

MP断屑槽，适用于轴向车削和仿形加工，连续切削至间断切削。

GG.(RL) INT

P M K N S H

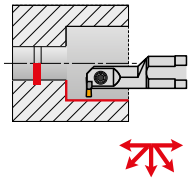
PRAMET

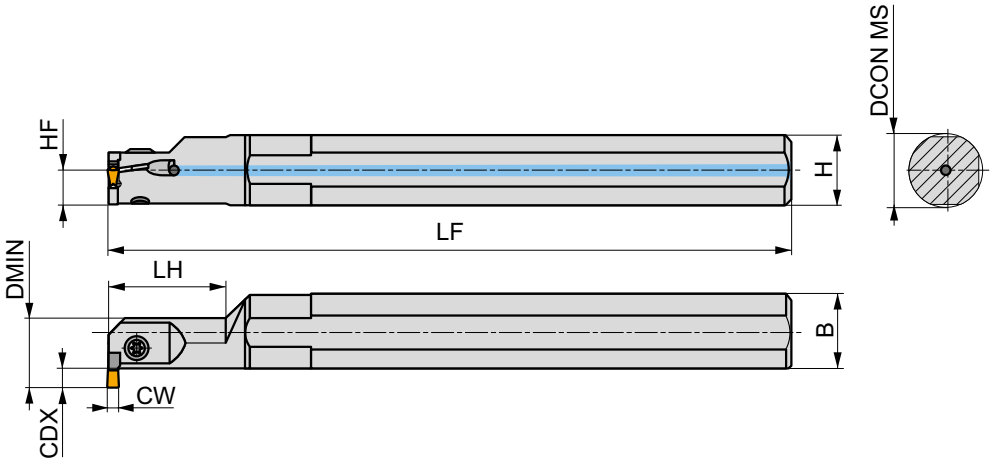
G

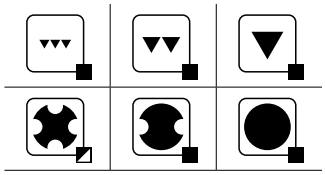


内孔沟槽镗杆，使用LCM..刀片。

内孔用左/右手开槽镗杆，开槽加工，使用用LCM.0313和0413刀片。内孔最小开槽直径为Ø16mm。适用于内孔沟槽和仿形车削。可提供Ø16至Ø32mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	3.00	3	16	✓	0.26	GI143	GL06
	A16Q-GGER 0313-04	16	7.5	15	15.5	180	25	3.00	3	16	✓	0.26	GI190	GL06
	A20R-GGFR 0313	20	9	18	19	200	30	3.00	4.5	20	✓	0.36	GI143	GL06
	A20R-GGFR 0313-04	20	9	18	19	200	30	3.00	4.5	20	✓	0.39	GI190	GL06
	A25S-GGHR 0313	25	11.5	23	24	250	40	3.00	6.5	25	✓	0.78	GI143	GL06
	A25S-GGFR 0413	25	11.5	23	24	250	40	4.00	6.5	25	✓	0.73	GI170	GL06
	A32T-GGHR 0413	32	15	30	31	300	50	4.00	9.5	32	✓	1.59	GI170	GL06
L	**A16Q-GGEL 0313**	16	7.5	15	15.5	180	25	3.00	3	16	✓	0.29	GI143	GL06
	A16Q-GGEL 0313-04	16	7.5	15	15.5	180	25	3.00	3	16	✓	0.28	GI190	GL06
	A20R-GGFL 0313	20	9	18	19	200	30	3.00	4.5	20	✓	0.38	GI143	GL06
	A20R-GGFL 0313-04	20	9	18	19	200	30	3.00	4.5	20	✓	0.38	GI190	GL06
	A25S-GGHL 0313	25	11.5	23	24	250	40	3.00	6.5	25	✓	0.81	GI143	GL06
	A25S-GGFL 0413	25	11.5	23	24	250	40	4.00	6.5	25	✓	0.82	GI170	GL06
	A32T-GGHL 0413	32	15	30	31	300	50	4.00	9.5	32	✓	1.59	GI170	GL06

GI143	LCM. 0313..
GI170	LCM. 0413..
GI190	LCM. 0313…..-04

		Nm			
GL06	SR 85011-T15P	5.0	M 5	9	FLAG T15P

GFIL-L AXIAL

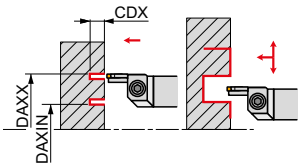
P M K N S H

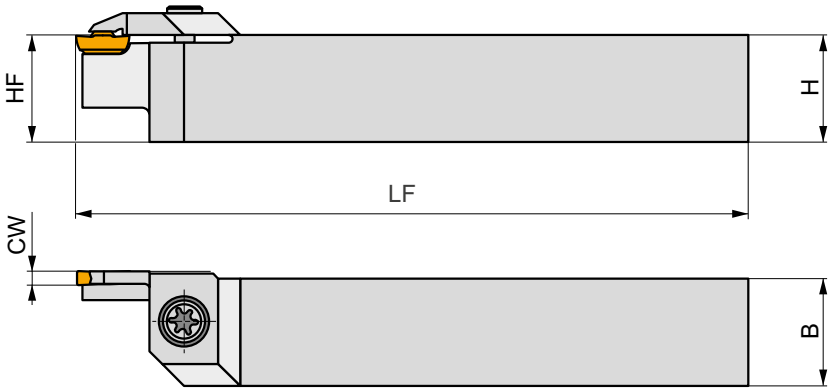
PRAMET G

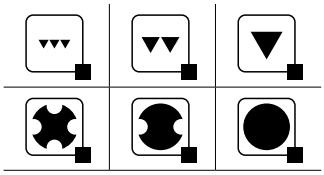


外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..03刀片。

外圆用左手轴向车刀杆，开槽加工，使用单面或双面LCM.0313或0316刀片。适用于Ø17至Ø170mm的端面开槽，轴向轮廓或扩宽，最大切削深度为9mm。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
L	**GFIL 2525 M 0313L 030017**	25	25	25	150	3.00	9	17	30	0.64	GI143	GL02
	GFIL 2525 M 0313L 039024	25	25	25	150	3.00	9	24	39	0.66	GI143	GL07
	GFIL 2525 M 0313L 050033	25	25	25	150	3.00	9	33	50	0.67	GI143	GL07
	GFIL 2525 M 0313L 060043	25	25	25	150	3.00	9	43	60	0.67	GI143	GL07
	GFIL 2525 M 0313L 076053	25	25	25	150	3.00	9	53	76	0.67	GI143	GL07
	GFIL 2525 M 0316L 100070	25	25	25	150	3.00	9	70	100	0.69	GI136	GL07
	GFIL 2525 M 0316L 130090	25	25	25	150	3.00	9	90	130	0.70	GI136	GL07
	GFIL 2525 M 0316L 170110	25	25	25	150	3.00	9	110	170	0.71	GI136	GL07

GI136	LCM. 0316..
GI143	LCM. 0313..

		Nm			
GL02	US 5015-T20P	5.0	M 5	15	FLAG T20P
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P

GFIL-R AXIAL

P M K N S H

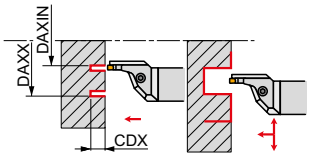
PRAMET

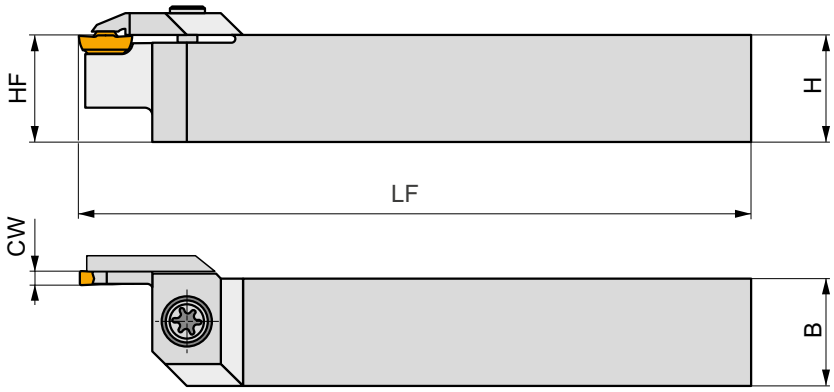
G

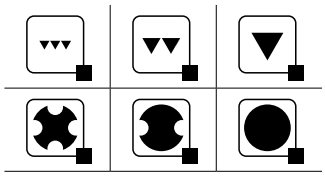


外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..03或04刀片。

外圆用左手轴向车刀杆，开槽加工，使用单面或双面LCM.0313、0316、0413或0416刀片。适用于Ø17至Ø230mm的端面开槽，轴向轮廓或槽的拓宽，最大切削深度为12mm。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
L	GFIL 2525 M 03R 030017-A	25	25	25	150	3.00	9	17	30	0.69	GI143	GL07
	GFIL 2525 M 03R 039024-A	25	25	25	150	3.00	9	24	39	0.69	GI143	GL07
	GFIL 2525 M 03R 050033-A	25	25	25	150	3.00	9	33	50	0.72	GI143	GL07
	GFIL 2525 M 03R 060043-A	25	25	25	150	3.00	9	43	60	0.69	GI143	GL07
	GFIL 2525 M 03R 076053-A	25	25	25	150	3.00	9	53	76	0.68	GI143	GL07
	GFIL 2525 M 03R 100070-A	25	25	25	150	3.00	9	70	100	0.79	GI136	GL08
	GFIL 2525 M 03R 130090-A	25	25	25	150	3.00	9	90	130	0.73	GI136	GL08
	GFIL 2525 M 03R 170110-A	25	25	25	150	3.00	9	110	170	0.76	GI136	GL08
	GFIL 2525 M 04R 030017-A	25	25	25	150	3.00	9	17	30	0.71	GI170	GL07
	GFIL 2525 M 04R 034021-A	25	25	25	150	4.00	9	21	34	0.69	GI170	GL07
	GFIL 2525 M 04R 040026-A	25	25	25	150	4.00	11	26	40	0.00	GI170	GL07
	GFIL 2525 M 04R 050032-A	25	25	25	150	4.00	11	32	50	0.68	GI170	GL07
	GFIL 2525 M 04R 060042-A	25	25	25	150	4.00	11	42	60	0.66	GI170	GL07
	GFIL 2525 M 04R 075052-A	25	25	25	150	4.00	11	52	75	0.67	GI170	GL07
	GFIL 2525 M 04R 100070-A	25	25	25	150	4.00	12	70	100	0.75	GI137	GL08
	GFIL 2525 M 04R 130090-A	25	25	25	150	4.00	12	90	130	0.75	GI137	GL08
	GFIL 2525 M 04R 170110-A	25	25	25	150	4.00	12	110	170	0.75	GI137	GL08
	GFIL 2525 M 04R 230140-A	25	25	25	150	4.00	12	140	230	0.78	GI137	GL08

GI136	LCM. 0316..
GI137	LCM. 0416..
GI143	LCM. 0313..
GI170	LCM. 0413..

		Nm				
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	–
GL08	US 6020-T25P	6.0	M 6	20.2	–	SDR T25P

GFIR-L AXIAL

P M K N S H

PRAMET

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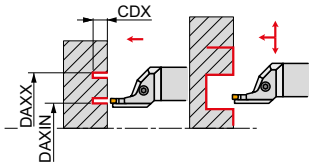
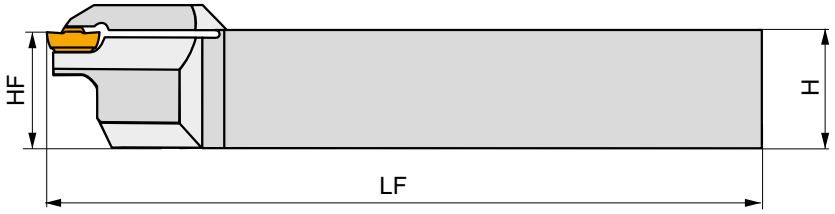
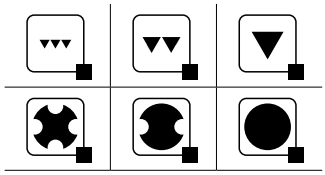
外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..03或04刀片。

外圆用右手轴向车刀杆，开槽加工，使用单面或双面LCM.0313、0316、0413或0416刀片。适用于Ø17至Ø230mm的端面开槽，轴向轮廓或槽的拓宽，最大切削深度为12mm的刀柄。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
R	GFIR 2525 M 03L 030017-A	25	25	25	150	3.00	9	17	30	0.65	GI143	GL07
	GFIR 2525 M 03L 039024-A	25	25	25	150	3.00	9	24	39	0.68	GI143	GL07
	GFIR 2525 M 03L 050033-A	25	25	25	150	3.00	9	33	50	0.65	GI143	GL07
	GFIR 2525 M 03L 060043-A	25	25	25	150	3.00	9	43	60	0.68	GI143	GL07
	GFIR 2525 M 03L 076053-A	25	25	25	150	3.00	9	53	76	0.69	GI143	GL07
	GFIR 2525 M 03L 100070-A	25	25	25	150	3.00	9	70	100	0.75	GI136	GL08
	GFIR 2525 M 03L 130090-A	25	25	25	150	3.00	9	90	130	0.76	GI136	GL08
	GFIR 2525 M 03L 170110-A	25	25	25	150	3.00	9	110	170	0.68	GI136	GL08
	GFIR 2525 M 04L 030017-A	25	25	25	150	3.00	9	17	30	0.68	GI170	GL07
	GFIR 2525 M 04L 034021-A	25	25	25	150	4.00	9	21	34	0.68	GI170	GL07
	GFIR 2525 M 04L 040026-A	25	25	25	150	4.00	11	26	40	0.68	GI170	GL07
	GFIR 2525 M 04L 050032-A	25	25	25	150	4.00	11	32	50	0.66	GI170	GL07
	GFIR 2525 M 04L 060042-A	25	25	25	150	4.00	11	42	60	0.69	GI170	GL07
	GFIR 2525 M 04L 075052-A	25	25	25	150	4.00	11	52	75	0.67	GI170	GL07
	GFIR 2525 M 04L 100070-A	25	25	25	150	4.00	12	70	100	0.72	GI137	GL08
	GFIR 2525 M 04L 130090-A	25	25	25	150	4.00	12	90	130	0.75	GI137	GL08
	GFIR 2525 M 04L 170110-A	25	25	25	150	4.00	12	110	170	0.72	GI137	GL08
	GFIR 2525 M 04L 230140-A	25	25	25	150	4.00	12	140	230	0.79	GI137	GL08

GI136	LCM. 0316..
GI137	LCM. 0416..
GI143	LCM. 0313..
GI170	LCM. 0413..

		Nm				
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	–
GL08	US 6020-T25P	6.0	M 6	20.2	–	SDR T25P

GFIR-R AXIAL

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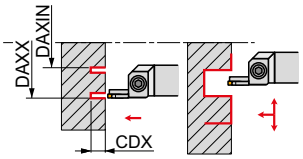
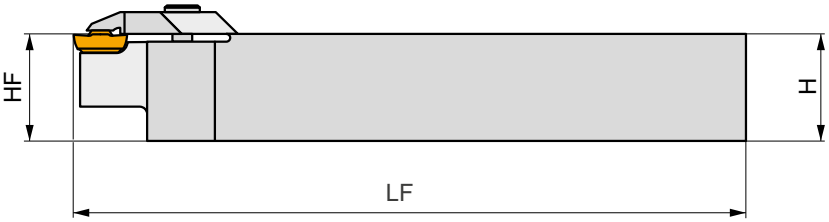
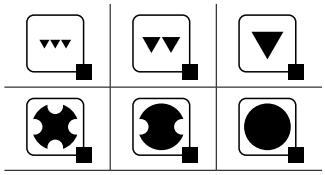
外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..03刀片。

外圆用右手轴向车刀杆，开槽加工，使用单面或双面LCM.0313或0316刀片。适用于Ø17至Ø170mm的端面开槽，轴向轮廓或槽的拓宽，最大切削深度为9mm的刀柄。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
R	**GFIR 2525 M 0313R 030017**	25	25	25	150	3.00	9	17	30	0.65	GI143	GL02
	GFIR 2525 M 0313R 039024	25	25	25	150	3.00	9	24	39	0.66	GI143	GL07
	GFIR 2525 M 0313R 050033	25	25	25	150	3.00	9	33	50	0.68	GI143	GL07
	GFIR 2525 M 0313R 060043	25	25	25	150	3.00	9	43	60	0.68	GI143	GL07
	GFIR 2525 M 0313R 076053	25	25	25	150	3.00	9	53	76	0.68	GI143	GL07
	GFIR 2525 M 0316R 100070	25	25	25	150	3.00	9	70	100	0.69	GI136	GL07
	GFIR 2525 M 0316R 130090	25	25	25	150	3.00	9	90	130	0.70	GI136	GL07
	GFIR 2525 M 0316R 170110	25	25	25	150	3.00	9	110	170	0.70	GI136	GL07

GI136	LCM. 0316..
GI143	LCM. 0313..

		Nm			
GL02	US 5015-T20P	5.0	M 5	15	FLAG T20P
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P

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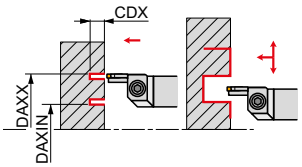
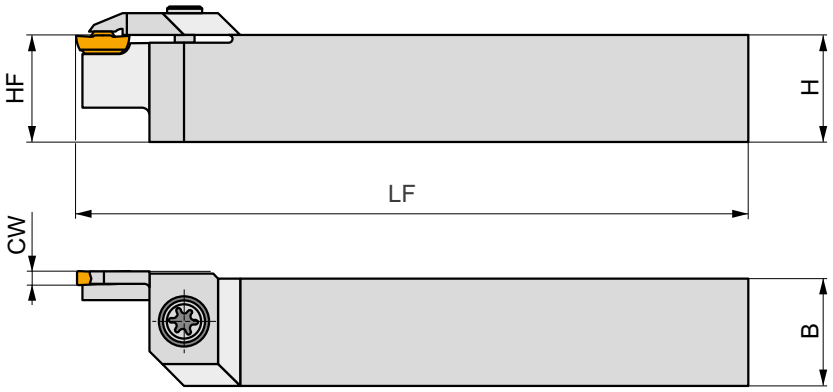
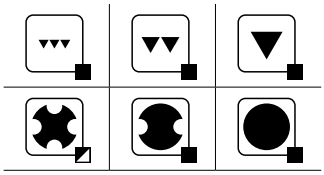
外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..04刀片。

外圆用左手轴向车刀杆，开槽加工，使用单面或双面LCM.0413或0416刀片。适用于Ø17至Ø230mm的深端面开槽，轴向轮廓或槽的拓宽，最大切削深度为20mm。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
L	**GFML 2525 M 0413L 030017**	25	25	25	150	4.00	20	17	30	0.62	GI170	GL02
	GFML 2525 M 0413L 034021	25	25	25	150	4.00	20	21	34	0.63	GI170	GL07
	GFML 2525 M 0413L 040026	25	25	25	150	4.00	20	26	40	0.65	GI170	GL07
	GFML 2525 M 0413L 050032	25	25	25	150	4.00	20	32	50	0.64	GI170	GL07
	GFML 2525 M 0413L 060042	25	25	25	150	4.00	20	42	60	0.65	GI170	GL07
	GFML 2525 M 0413L 075052	25	25	25	150	4.00	20	52	75	0.66	GI170	GL07
	GFML 2525 M 0416L 100070	25	25	25	150	4.00	20	70	100	0.66	GI137	GL07
	GFML 2525 M 0416L 130090	25	25	25	150	4.00	20	90	130	0.67	GI137	GL07
	GFML 2525 M 0416L 170110	25	25	25	150	4.00	20	110	170	0.67	GI137	GL07
	GFML 2525 M 0416L 230140	25	25	25	150	4.00	20	140	230	0.67	GI137	GL07

GI137	LCM. 0416..
GI170	LCM. 0413..

		Nm			
GL02	US 5015-T20P	5.0	M 5	15	FLAG T20P
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P

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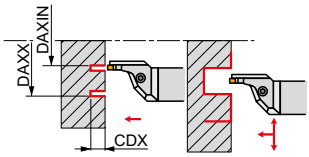
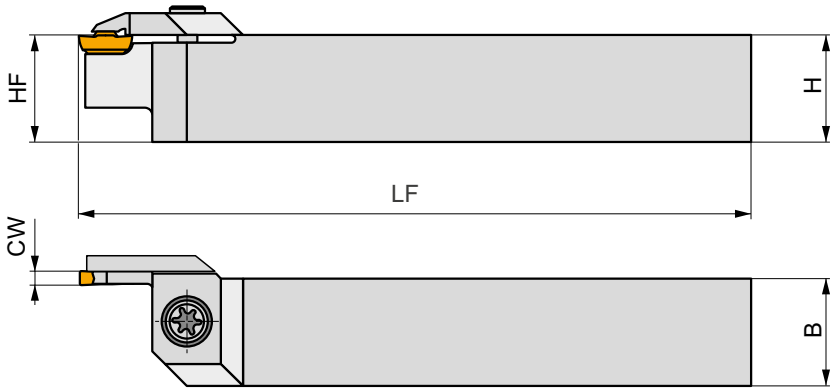
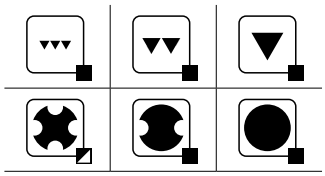
外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..04刀片。

外圆用左手轴向车刀杆，开槽加工，使用单面或双面LCM.0413或0416刀片。适用于Ø17至Ø230mm的深端面开槽，轴向轮廓或槽的拓宽，最大切削深度为20mm。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
L	**GFML 2525 M 0413R 030017**	25	25	25	150	4.00	20	17	30	0.68	GI170	GL07
	GFML 2525 M 0413R 034021	25	25	25	150	4.00	20	21	34	0.69	GI170	GL07
	GFML 2525 M 0413R 040026	25	25	25	150	4.00	20	26	40	0.69	GI170	GL07
	GFML 2525 M 0413R 050032	25	25	25	150	4.00	20	32	50	0.68	GI170	GL07
	GFML 2525 M 0413R 060042	25	25	25	150	4.00	20	42	60	0.69	GI170	GL07
	GFML 2525 M 0413R 075052	25	25	25	150	4.00	20	52	75	0.69	GI170	GL07
	GFML 2525 M 0416R 100070	25	25	25	150	4.00	20	70	100	0.80	GI137	GL08
	GFML 2525 M 0416R 130090	25	25	25	150	4.00	20	90	130	0.78	GI137	GL08
	GFML 2525 M 0416R 170110	25	25	25	150	4.00	20	110	170	0.78	GI137	GL08
	GFML 2525 M 0416R 230140	25	25	25	150	4.00	20	140	230	0.78	GI137	GL08

GI137	LCM. 0416..
GI170	LCM. 0413..

		Nm				
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	–
GL08	US 6020-T25P	6.0	M 6	20.2	–	SDR T25P

GFMR-L AXIAL

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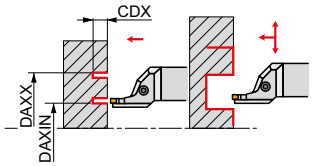
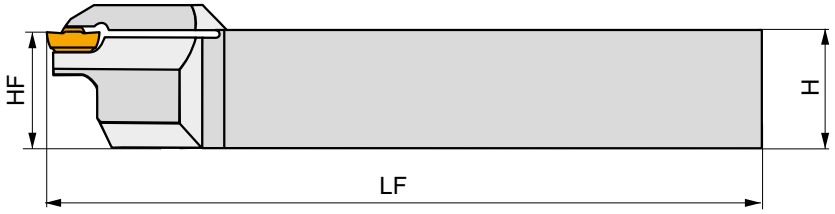
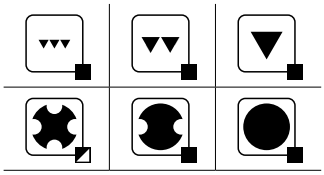
外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..04刀片。

外圆用右手轴向车刀杆，开槽加工，使用单面或双面LCM.0413或0416刀片。适用于Ø17至Ø230mm的深端面开槽，轴向轮廓或槽的拓宽，最大切削深度为20mm的刀柄。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
R	**GFMR 2525 M 0413L 030017**	25	25	25	150	4.00	20	17	30	0.70	GI170	GL07
	GFMR 2525 M 0413L 034021	25	25	25	150	4.00	20	21	34	0.66	GI170	GL07
	GFMR 2525 M 0413L 040026	25	25	25	150	4.00	20	26	40	0.66	GI170	GL07
	GFMR 2525 M 0413L 050032	25	25	25	150	4.00	20	32	50	0.68	GI170	GL07
	GFMR 2525 M 0413L 060042	25	25	25	150	4.00	20	42	60	0.66	GI170	GL07
	GFMR 2525 M 0413L 075052	25	25	25	150	4.00	20	52	75	0.69	GI170	GL07
	GFMR 2525 M 0416L 100070	25	25	25	150	4.00	20	70	100	0.88	GI137	GL08
	GFMR 2525 M 0416L 130090	25	25	25	150	4.00	20	90	130	0.78	GI137	GL08
	GFMR 2525 M 0416L 170110	25	25	25	150	4.00	20	110	170	0.81	GI137	GL08
	GFMR 2525 M 0416L 230140	25	25	25	150	4.00	20	140	230	0.78	GI137	GL08

GI137	LCM. 0416..
GI170	LCM. 0413..

		Nm				
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	–
GL08	US 6020-T25P	6.0	M 6	20.2	–	SDR T25P

GFMR-R AXIAL

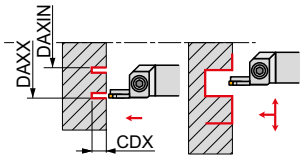
P M K N S H

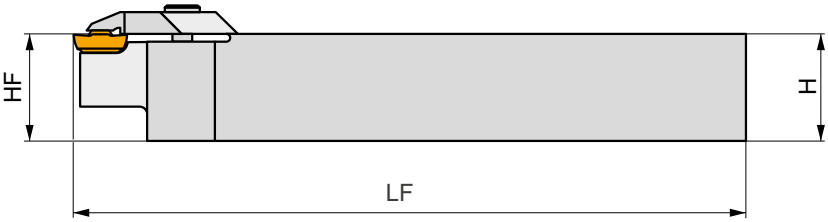
PRAMET G



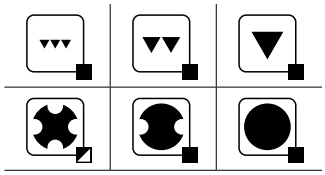
外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..04刀片。

外圆用右手轴向车刀杆，开槽加工，使用单面或双面LCM.0413或0416刀片。适用于Ø17至Ø230mm的深端面开槽，轴向轮廓或槽的拓宽，最大切削深度为20mm的刀柄。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg	GI	GL
R	**GFMR 2525 M 0413R 030017**	25	25	25	150	4.00	20	17	30	0.62	GI170	GL02
	GFMR 2525 M 0413R 034021	25	25	25	150	4.00	20	21	34	0.63	GI170	GL07
	GFMR 2525 M 0413R 040026	25	25	25	150	4.00	20	26	40	0.64	GI170	GL07
	GFMR 2525 M 0413R 050032	25	25	25	150	4.00	20	32	50	0.63	GI170	GL07
	GFMR 2525 M 0413R 060042	25	25	25	150	4.00	20	42	60	0.64	GI170	GL07
	GFMR 2525 M 0413R 075052	25	25	25	150	4.00	20	52	75	0.67	GI170	GL07
	GFMR 2525 M 0416R 100070	25	25	25	150	4.00	20	70	100	0.67	GI137	GL07
	GFMR 2525 M 0416R 130090	25	25	25	150	4.00	20	90	130	0.66	GI137	GL07
	GFMR 2525 M 0416R 170110	25	25	25	150	4.00	20	110	170	0.67	GI137	GL07
	GFMR 2525 M 0416R 230140	25	25	25	150	4.00	20	140	230	0.68	GI137	GL07

GI137	LCM. 0416..
GI170	LCM. 0413..

		Nm			
GL02	US 5015-T20P	5.0	M 5	15	FLAG T20P
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P

GGI(RL)-90 AXIAL

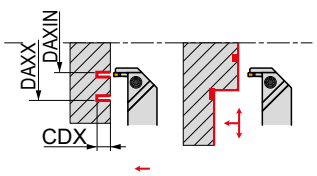
P M K N S H

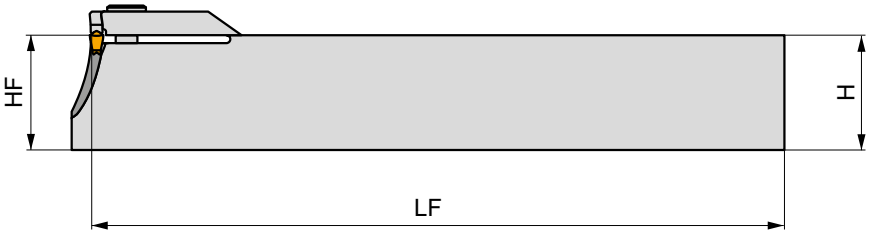
PRAMET G

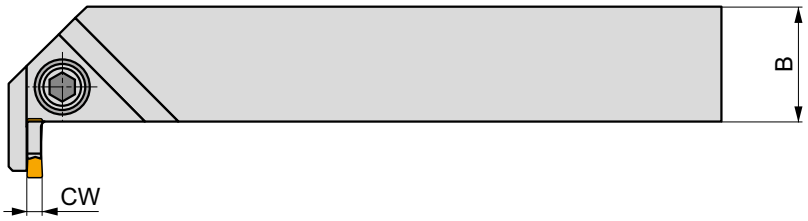


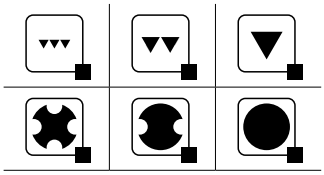
外圆用轴向90°拐角开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..03刀片。

外圆用左/右手轴向90°拐角车刀杆，开槽加工，使用单面或双面LCM.0313或0316刀片。适用于Ø17至Ø170mm的端面开槽，轴向轮廓或扩宽，最大切削深度为11mm。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。











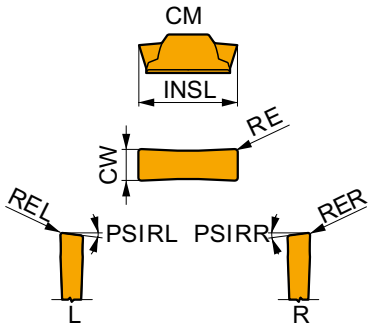
	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
R	GGIR 2525 M 03R 030017	25	25	25	150	3.00	9.5	17	30	0.75	GI143	GL01
	GGIR 2525 M 03R 039024	25	25	25	150	3.00	9.5	24	39	0.78	GI143	GL01
	GGIR 2525 M 03R 050033	25	25	25	150	3.00	11	33	50	0.75	GI143	GL01
	GGIR 2525 M 03R 060043	25	25	25	150	3.00	11	43	60	0.78	GI143	GL01
	GGIR 2525 M 03R 076053	25	25	25	150	3.00	11	53	76	0.75	GI143	GL01
	GGIR 2525 M 03R 100070	25	25	25	150	3.00	9	70	100	0.78	GI136	GL04
	GGIR 2525 M 03R 130090	25	25	25	150	3.00	9	90	130	0.73	GI136	GL04
	GGIR 2525 M 03R 170110	25	25	25	150	3.00	9	110	170	0.76	GI136	GL04
L	GGIL 2525 M 03L 030017	25	25	25	150	3.00	9.5	17	30	0.75	GI143	GL01
	GGIL 2525 M 03L 039024	25	25	25	150	3.00	9.5	24	39	0.25	GI143	GL01
	GGIL 2525 M 03L 050033	25	25	25	150	3.00	11	33	50	0.75	GI143	GL01
	GGIL 2525 M 03L 060043	25	25	25	150	3.00	11	43	60	0.75	GI143	GL01
	GGIL 2525 M 03L 076053	25	25	25	150	3.00	11	53	76	0.75	GI143	GL01
	GGIL 2525 M 03L 100070	25	25	25	150	3.00	9	70	100	0.77	GI136	GL04
	GGIL 2525 M 03L 130090	25	25	25	150	3.00	9	90	130	0.77	GI136	GL04
	GGIL 2525 M 03L 170110	25	25	25	150	3.00	9	110	170	0.76	GI136	GL04

GI136	LCM. 0316..
GI143	LCM. 0313..

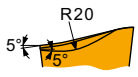
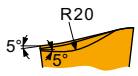
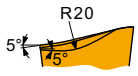
GL01	HS 0520C	5.0	M 5	20	HXK 4
GL04	HS 0620C	6.0	M 6	20	HXK 5

LCMF 16 - CM

	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



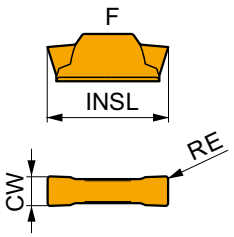
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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断屑槽，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断屑槽，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断屑槽，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

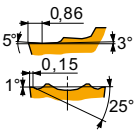
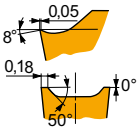
[1)] Toolholders have to be modified.

LCMF 16, LCMF 30 - F

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(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



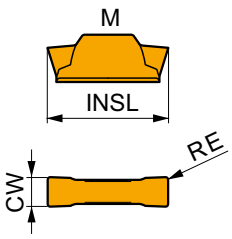
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
F断屑槽，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 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	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–	–
	T9325	0.8	270	0.17	1.0	160	0.15	1.0	255	0.17	1.0	–	–	–	–	–	–	–	–	–
																				
F断屑槽，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 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	–	–	–	–	–	–	–	–	–

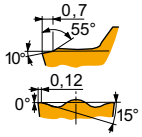
LCMF 16 - M

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



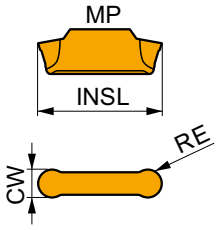
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			M断屑槽，适用于开槽和轴向车削，连续至断续切削。																	
LCMF 031602-M	**T8330**	0.2	■ 160	0.13	1.0	◪ 95	0.12	1.0	■ 150	0.13	1.0	–	–	–	–	–	–	◪ 30	0.15	1.0
LCMF 031604-M	**T8330**	0.4	■ 170	0.13	1.0	◪ 100	0.12	1.0	■ 160	0.13	1.0	–	–	–	–	–	–	◪ 30	0.15	1.0
LCMF 041604-M	**T8330**	0.4	■ 155	0.18	1.0	◪ 90	0.16	1.0	■ 145	0.18	1.0	–	–	–	–	–	–	◪ 30	0.15	1.0
	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	0.15	1.0
	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	0.15	1.0
	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	0.15	1.0
	T9325	0.8	■ 230	0.25	1.0	◪ 135	0.23	1.0	◪ 215	0.25	1.0	–	–	–	–	–	–	–	–	–

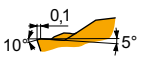
LCMF 16, LCMF 30 - MP

PRAMET

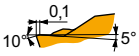
	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	17.5
0416	4.00	-0.05	0.05	17.6
0516	5.00	-0.05	0.05	18.3
0616	6.00	-0.05	0.05	18.5
0830	8.00	-0.05	0.05	30.9



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。

产品型号		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)
																				
			MP断屑槽，适用于轴向车削和仿形加工，连续切削至间断切削。																	
LCMF 0316MO-MP	**T8330**	1.5	■ 190	0.30	0.8	◪ 110	0.27	0.8	■ 180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMF 0416MO-MP	**T8330**	2.0	■ 175	0.40	1.0	◪ 105	0.36	1.0	■ 165	0.40	1.0	–	–	–	–	–	–	–	–	–
	T9325	2.0	■ 220	0.40	1.0	◪ 130	0.36	1.0	◪ 205	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMF 0516MO-MP	**T8330**	2.5	■ 170	0.45	1.0	◪ 100	0.41	1.0	■ 160	0.45	1.0	–	–	–	–	–	–	–	–	–
	T9325	2.5	■ 205	0.45	1.0	◪ 120	0.41	1.0	◪ 190	0.45	1.0	–	–	–	–	–	–	–	–	–

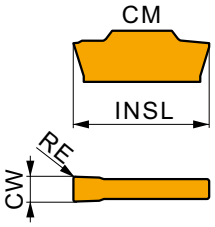
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
MP断屑槽，适用于轴向车削和仿形加工，连续切削至间断切削。																				
LCMF 0616MO-MP	**T8330**	3.0	■ 165	0.50	1.0	◪ 95	0.45	1.0	■ 155	0.50	1.0	–	–	–	–	–	–	–	–	–
	T9325	3.0	■ 200	0.50	1.0	◪ 120	0.45	1.0	◪ 190	0.50	1.0	–	–	–	–	–	–	–	–	–
LCMF 0830MO-MP	**T8330**	4.0	■ 150	0.60	1.2	◪ 90	0.54	1.2	■ 140	0.60	1.2	–	–	–	–	–	–	–	–	–

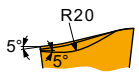
LCMR 16 - CM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4



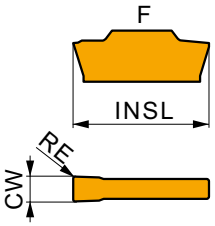
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P		M		K		N		S		H		PSIRR	PSIRL
			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)	(°)	(°)
																
CM断屑槽，是切断和开槽的首选，连续切削至轻微断续切削。																
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	–	–	–	–	–	–	–	–

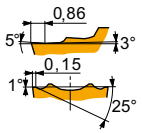
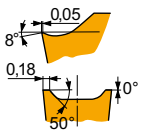
LCMR 16, LCMR 30 - F

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
0830	8.00	-0.05	0.05	30.0



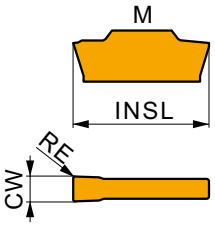
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			U		E															
F断屑槽，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 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	–	–	–	–	–	–	–	–	–
																				
			U		S															
F断屑槽，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 083008-F	**T8330**	0.8	■ 175	0.25	1.0	◪ 105	0.23	1.0	◪ 165	0.25	1.0	–	–	–	–	–	–	–	–	–

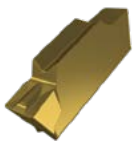
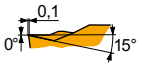
LCMR 16 - M

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



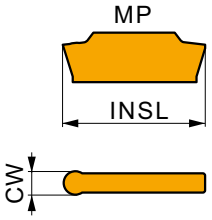
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																				
			E																	
M断屑槽，适用于开槽和轴向车削，连续至断续切削。																				
LCMR 031604-M	**T8330**	0.4	■ 170	0.13	1.0	◪ 100	0.12	1.0	■ 160	0.13	1.0	–	–	–	–	–	–	◪ 30	0.15	1.0
LCMR 041604-M	**T8330**	0.4	■ 155	0.18	1.0	◪ 90	0.16	1.0	■ 145	0.18	1.0	–	–	–	–	–	–	◪ 30	0.15	1.0
LCMR 051604-M	**T8330**	0.4	■ 150	0.20	1.0	◪ 90	0.18	1.0	■ 140	0.20	1.0	–	–	–	–	–	–	◪ 30	0.15	1.0
LCMR 061608-M	**T8330**	0.8	■ 175	0.25	1.0	◪ 105	0.23	1.0	■ 165	0.25	1.0	–	–	–	–	–	–	◪ 35	0.15	1.0

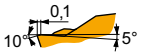
LCMR 16 - MP

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(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。

产品型号		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
MP断屑槽，适用于轴向车削和仿形加工，连续切削至间断切削。																				
LCMR 0316M0-MP	**T8330**	1.5	■ 190	0.30	0.8	◪ 110	0.27	0.8	■ 180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMR 0416M0-MP	**T8330**	2.0	■ 175	0.40	1.0	◪ 105	0.36	1.0	■ 165	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMR 0516M0-MP	**T8330**	2.5	■ 170	0.45	1.0	◪ 100	0.41	1.0	■ 160	0.45	1.0	–	–	–	–	–	–	–	–	–
LCMR 0616M0-MP	**T8330**	3.0	■ 165	0.50	1.0	◪ 95	0.45	1.0	■ 155	0.50	1.0	–	–	–	–	–	–	–	–	–

GFI(RL) EXT

P M K N S H

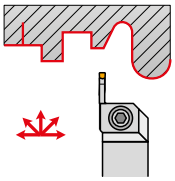
PRAMET

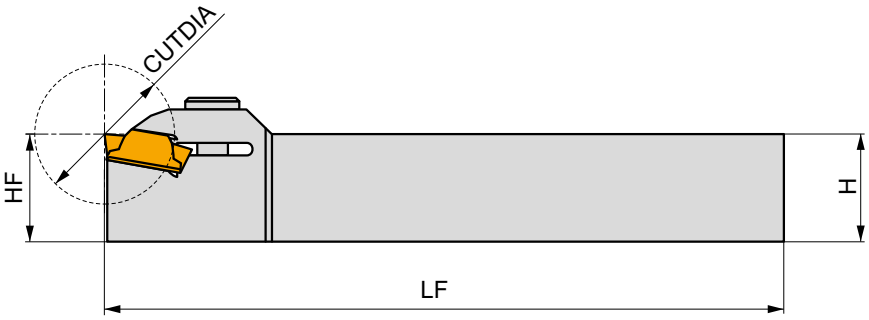
G

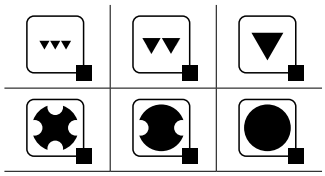


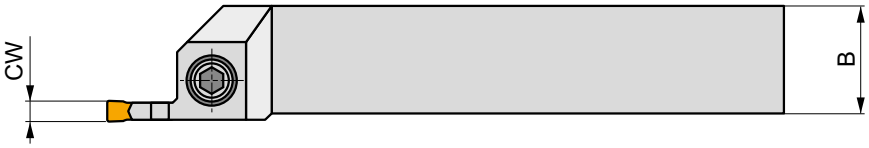
外圆用开槽和车削加工刀具，V-型刀片槽，顶部夹紧，使用LCM..刀片。

外圆用左/右手持车刀杆，开槽加工。使用LCM.　0316、0416、0516、0616和0830刀片。适用于最大材料尺寸在Ø48mm，进行开槽，仿形和轴向车削应用。可提供16x16至32x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	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	0.22	GI137	GL03
	GFIR 2020 K 04	20	20	20	125	4.00	24	0.38	GI137	GL04
	GFIR 2525 M 04	25	25	25	150	4.00	24	0.67	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	1.03	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	0.69	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	0.75	GI193	GL09
	GFIL 3225 P 08	32	32	25	170	8.00	48	1.03	GI193	GL09

GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..
GI193	LCM. 0830..

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

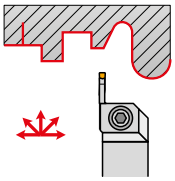
P M K N S H

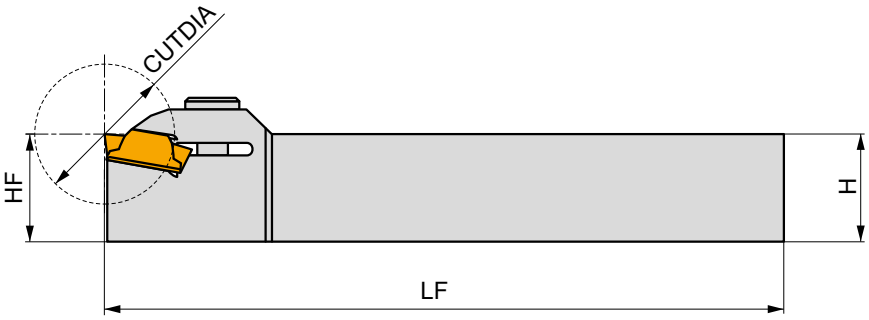
PRAMET G

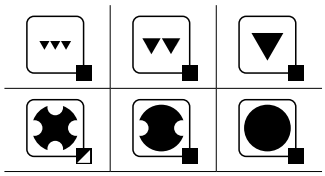


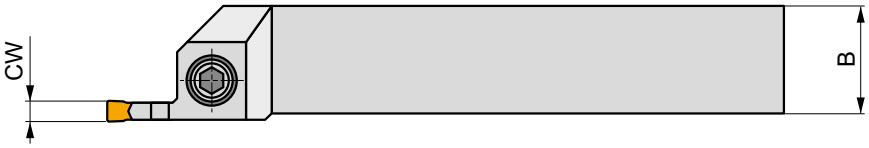
外圆用开槽和车削加工刀具，V-型刀片槽，顶部夹紧，使用LCM刀片。

外圆用左/右手持车刀杆，开槽加工。使用LCM 0316、0416、0516、0616和0830刀片。适用于材料尺寸范围在Ø30至Ø80mm，进行切断，开槽，仿形和轴向车削应用，可提供20x20至32x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	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	0.38	GI137	GL04
	GFMR 2525 M 0416	25	25	25	150	4.00	40	0.68	GI137	GL04
	GFMR 2525 M 0516	25	25	25	150	5.00	50	0.67	GI138	GL04
	GFMR 3225 P 0516	32	32	25	170	5.00	50	0.97	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	0.97	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	0.24	GI136	GL04
	GFML 2525 M 0316	25	25	25	150	3.00	30	0.70	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	0.69	GI137	GL04
	GFML 2525 M 0516	25	25	25	150	5.00	50	0.64	GI138	GL04
	GFML 3225 P 0516	32	32	25	170	5.00	50	0.97	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	0.99	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

XLCCN B

P M K N S H

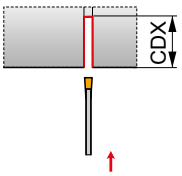
PRAMET

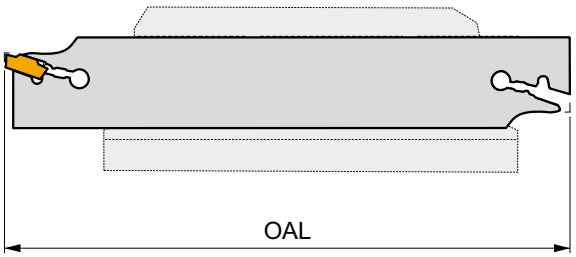
X

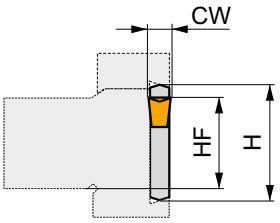
使用LCM刀片，双头切断刀板

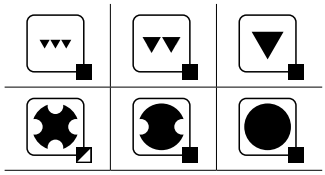
刀板用于切断应用，最大深度为60mm或Ø120mm的棒材。适用于单面或双面LCM.刀片。高度为26或32mm。可以安装在DU Premet基础刀杆上。经过处理，使用寿命更长。













	产品型号	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
N	**XLCCN 2602 J 0316**	21.4	26	110	3.00	35	0.09	GI136	KV1
	XLCCN 3202 M 0316	25	32	150	3.00	50	0.13	GI136	KV1
	XLCCN 3203 M 0416	25	32	150	4.00	50	0.15	GI137	KV1
	XLCCN 3204 M 0516	25	32	150	5.00	60	0.18	GI138	KV1
	XLCCN 3205 M 0616	25	32	150	6.00	60	0.17	GI139	KV1

GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..

KV1	KV 5x100

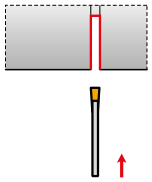
DU, D

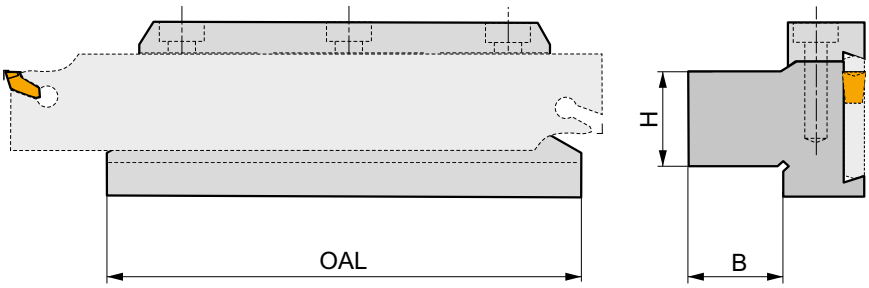
PRAMET

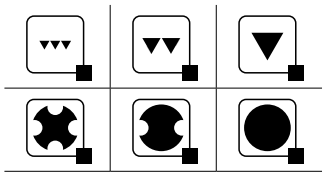


切断刀板的车刀座

刀座适合GL或XLC，切断刀板。可提供20x20至40x40mm的刀柄。刀杆经过处理，使用寿命更长。







产品型号	H (mm)	B (mm)	OAL (mm)	kg		
26-DU 2020	20	20	90	0.70	GI007	ND2
26-D 2020	20	20	100	0.82	GI007	ND2
32-DU 2523	25	23	110	1.02	GI008	ND2
32-DU 2532	25	32	110	1.10	GI008	ND2
32-DU 3229	32	29	110	1.25	GI008	ND2
32-D 2530	25	30	115	1.30	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	3.88	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

XLCCN 25 BS

P M K N S H

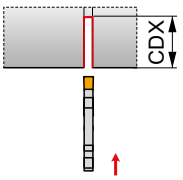
PRAMET

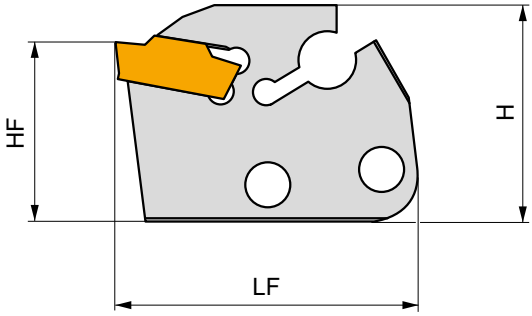
G

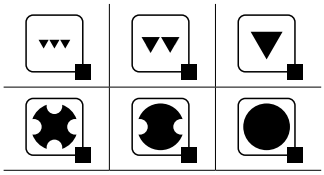


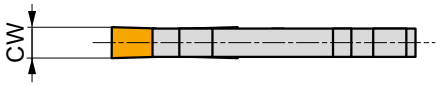
模块化MS-EN槽刀杆的径向开槽刀板，使用LCM..刀片。

模块化开槽刀板，开槽加工，使用单面或双面LCM. 0316、0416、0516或0616刀片。适用于开槽或切断（最大25mm的切削深度）应用。可以安装在MS-EN车刀杆上。刀板经处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
N	**XLCCN 250215-0316**	24	29	40	3.00	15	0.01	GI136	–
	XLCCN 250225-0316	24	29	50	3.00	25	0.02	GI136	–
	XLCCN 250315-0416	24	29	40	4.00	15	0.04	GI137	–
	XLCCN 250325-0416	24	29	50	4.00	25	0.04	GI137	–
	XLCCN 250425-0516	24	29	50	5.00	25	0.03	GI138	–
	XLCCN 250525-0616	24	29	50	6.00	25	0.04	GI139	–

GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..

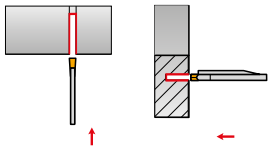
MS-EN

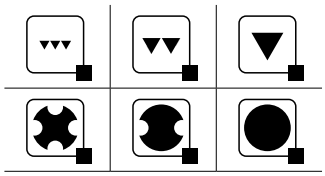
PRAMET

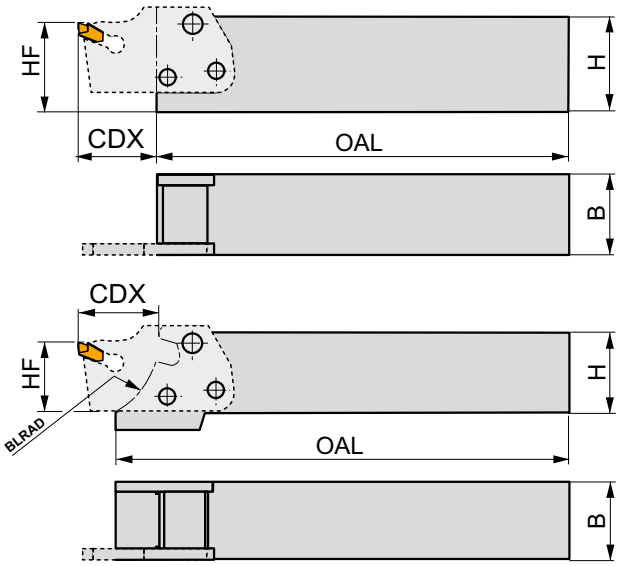


模块化车刀杆，使用XLCCN，XLCF（NRL）或XLXFL开槽刀板。

车刀杆用于安装XLC25BS，XLCF（NRL）BS，XLXFLBS端面开槽刀板。可提供可提供12x12至32x25mm的PSC刀柄。刀杆经过处理，使用寿命更长。







产品型号	HF (mm)	H (mm)	B (mm)	OAL (mm)	CDX (mm)	BLRAD (mm)	kg		
MS-EN-1212 F	12	12	12	75	15	–	0.13	GI006	ND4
MS-EN-1616 H	16	16	16	90	15	–	0.21	GI006	ND4
MS-EN-2020 K	20	20	20	115	15	–	0.23	GI003	ND5
MS-EN-2020 KS	20	20	20	129	15	25	0.42	GI060	ND5
MS-EN-2525 M	25	25	25	140	15	–	0.65	GI003	ND5
MS-EN-2525 MS	25	25	25	153	15	25	0.74	GI060	ND5
MS-EN-3225 P	32	32	25	160	15	–	0.95	GI003	ND5
MS-EN-3225 PS	32	32	25	174	15	25	1.00	GI060	ND5

GI003	XLC.. 25..15...	XLXFL 25…	XLC.. 25..25…
GI006	XLCF. 16..15…	XLCF. 16..20…	–
GI060	XLC.. 25..15…	XLC.. 25..25…	–

		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 T15P

ND4 =3 x US 4011-T15P; ND5=2 x US 45013-T20P

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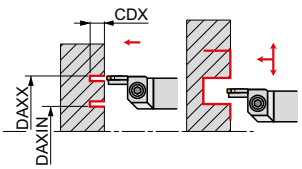
P M K N S H

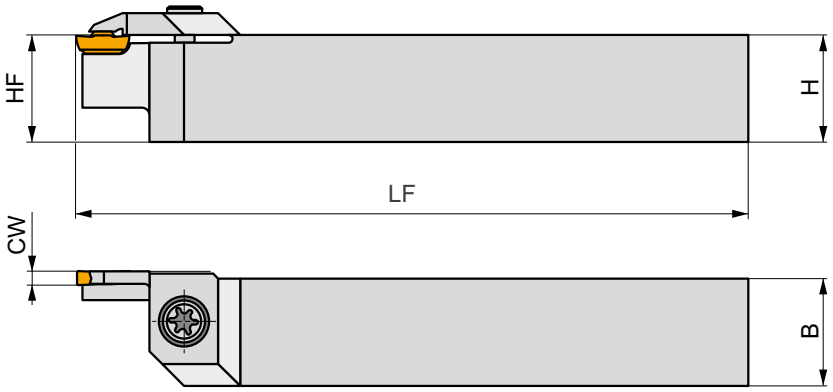
PRAMET G

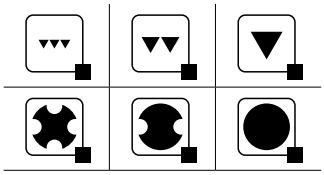


外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..03刀片。

外圆用左手轴向车刀杆，开槽加工，使用单面或双面LCM.0313或0316刀片。适用于Ø17至Ø170mm的端面开槽，轴向轮廓或扩宽，最大切削深度为9mm。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN	DAXX (mm)	kg		
L	**GFIL 2525 M 0313L 030017**	25	25	25	150	3.00	9	17	30	0.64	GI143	GL02
	GFIL 2525 M 0313L 039024	25	25	25	150	3.00	9	24	39	0.66	GI143	GL07
	GFIL 2525 M 0313L 050033	25	25	25	150	3.00	9	33	50	0.67	GI143	GL07
	GFIL 2525 M 0313L 060043	25	25	25	150	3.00	9	43	60	0.67	GI143	GL07
	GFIL 2525 M 0313L 076053	25	25	25	150	3.00	9	53	76	0.67	GI143	GL07
	GFIL 2525 M 0316L 100070	25	25	25	150	3.00	9	70	100	0.69	GI136	GL07
	GFIL 2525 M 0316L 130090	25	25	25	150	3.00	9	90	130	0.70	GI136	GL07
	GFIL 2525 M 0316L 170110	25	25	25	150	3.00	9	110	170	0.71	GI136	GL07

GI136	LCM. 0316..
GI143	LCM. 0313..

		Nm			
GL02	US 5015-T20P	5.0	M 5	15	FLAG T20P
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P

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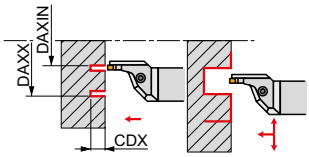
P M K N S H

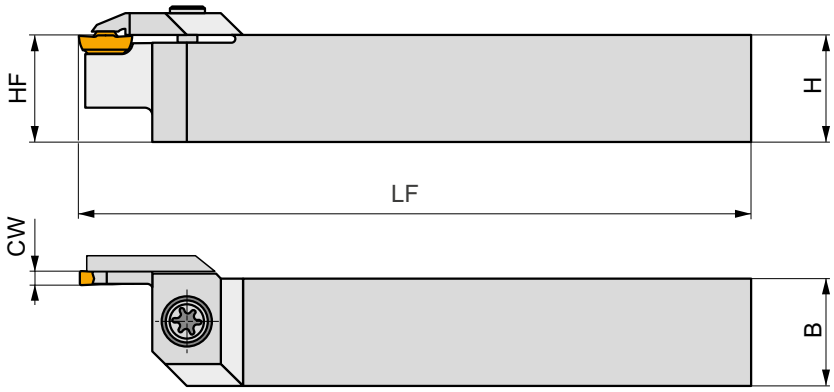
PRAMET G

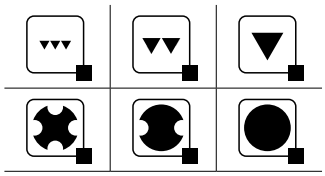


外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..03或04刀片。

外圆用左手轴向车刀杆，开槽加工，使用单面或双面LCM.0313、0316、0413或0416刀片。适用于Ø17至Ø230mm的端面开槽，轴向轮廓或槽的拓宽，最大切削深度为12mm。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN	DAXX (mm)	kg		
L	GFIL 2525 M 03R 030017-A	25	25	25	150	3.00	9	17	30	0.69	GI143	GL07
	GFIL 2525 M 03R 039024-A	25	25	25	150	3.00	9	24	39	0.69	GI143	GL07
	GFIL 2525 M 03R 050033-A	25	25	25	150	3.00	9	33	50	0.72	GI143	GL07
	GFIL 2525 M 03R 060043-A	25	25	25	150	3.00	9	43	60	0.69	GI143	GL07
	GFIL 2525 M 03R 076053-A	25	25	25	150	3.00	9	53	76	0.68	GI143	GL07
	GFIL 2525 M 03R 100070-A	25	25	25	150	3.00	9	70	100	0.79	GI136	GL08
	GFIL 2525 M 03R 130090-A	25	25	25	150	3.00	9	90	130	0.73	GI136	GL08
	GFIL 2525 M 03R 170110-A	25	25	25	150	3.00	9	110	170	0.76	GI136	GL08
	GFIL 2525 M 04R 030017-A	25	25	25	150	3.00	9	17	30	0.71	GI170	GL07
	GFIL 2525 M 04R 034021-A	25	25	25	150	4.00	9	21	34	0.69	GI170	GL07
	GFIL 2525 M 04R 040026-A	25	25	25	150	4.00	11	26	40	0.00	GI170	GL07
	GFIL 2525 M 04R 050032-A	25	25	25	150	4.00	11	32	50	0.68	GI170	GL07
	GFIL 2525 M 04R 060042-A	25	25	25	150	4.00	11	42	60	0.66	GI170	GL07
	GFIL 2525 M 04R 075052-A	25	25	25	150	4.00	11	52	75	0.67	GI170	GL07
	GFIL 2525 M 04R 100070-A	25	25	25	150	4.00	12	70	100	0.75	GI137	GL08
	GFIL 2525 M 04R 130090-A	25	25	25	150	4.00	12	90	130	0.75	GI137	GL08
	GFIL 2525 M 04R 170110-A	25	25	25	150	4.00	12	110	170	0.75	GI137	GL08
	GFIL 2525 M 04R 230140-A	25	25	25	150	4.00	12	140	230	0.78	GI137	GL08

GI136	LCM. 0316..
GI137	LCM. 0416..
GI143	LCM. 0313..
GI170	LCM. 0413..

		Nm				
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	–
GL08	US 6020-T25P	6.0	M 6	20.2	–	SDR T25P

GFIR-L AXIAL

P M K N S H

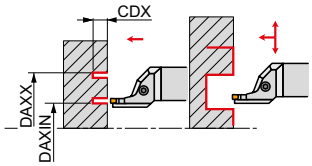
PRAMET

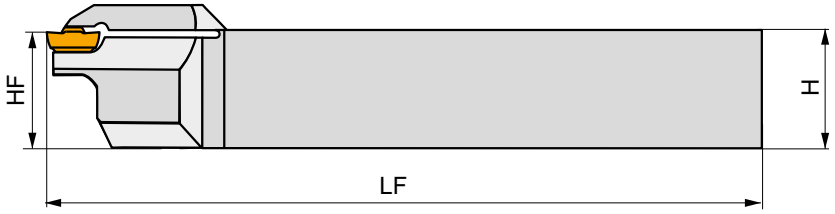
G



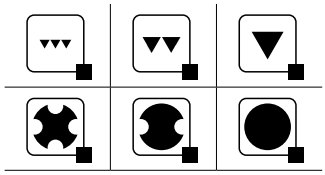
外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..03或04刀片。

外圆用右手轴向车刀杆，开槽加工，使用单面或双面LCM.0313、0316、0413或0416刀片。适用于Ø17至Ø230mm的端面开槽，轴向轮廓或槽的拓宽，最大切削深度为12mm的刀柄。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
R	GFIR 2525 M 03L 030017-A	25	25	25	150	3.00	9	17	30	0.65	GI143	GL07
	GFIR 2525 M 03L 039024-A	25	25	25	150	3.00	9	24	39	0.68	GI143	GL07
	GFIR 2525 M 03L 050033-A	25	25	25	150	3.00	9	33	50	0.65	GI143	GL07
	GFIR 2525 M 03L 060043-A	25	25	25	150	3.00	9	43	60	0.68	GI143	GL07
	GFIR 2525 M 03L 076053-A	25	25	25	150	3.00	9	53	76	0.69	GI143	GL07
	GFIR 2525 M 03L 100070-A	25	25	25	150	3.00	9	70	100	0.75	GI136	GL08
	GFIR 2525 M 03L 130090-A	25	25	25	150	3.00	9	90	130	0.76	GI136	GL08
	GFIR 2525 M 03L 170110-A	25	25	25	150	3.00	9	110	170	0.68	GI136	GL08
	GFIR 2525 M 04L 030017-A	25	25	25	150	3.00	9	17	30	0.68	GI170	GL07
	GFIR 2525 M 04L 034021-A	25	25	25	150	4.00	9	21	34	0.68	GI170	GL07
	GFIR 2525 M 04L 040026-A	25	25	25	150	4.00	11	26	40	0.68	GI170	GL07
	GFIR 2525 M 04L 050032-A	25	25	25	150	4.00	11	32	50	0.66	GI170	GL07
	GFIR 2525 M 04L 060042-A	25	25	25	150	4.00	11	42	60	0.69	GI170	GL07
	GFIR 2525 M 04L 075052-A	25	25	25	150	4.00	11	52	75	0.67	GI170	GL07
	GFIR 2525 M 04L 100070-A	25	25	25	150	4.00	12	70	100	0.72	GI137	GL08
	GFIR 2525 M 04L 130090-A	25	25	25	150	4.00	12	90	130	0.75	GI137	GL08
	GFIR 2525 M 04L 170110-A	25	25	25	150	4.00	12	110	170	0.72	GI137	GL08
	GFIR 2525 M 04L 230140-A	25	25	25	150	4.00	12	140	230	0.79	GI137	GL08

GI136	LCM. 0316..
GI137	LCM. 0416..
GI143	LCM. 0313..
GI170	LCM. 0413..

		Nm				
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	–
GL08	US 6020-T25P	6.0	M 6	20.2	–	SDR T25P

GFIR-R AXIAL

P M K N S H

PRAMET

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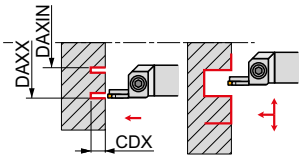
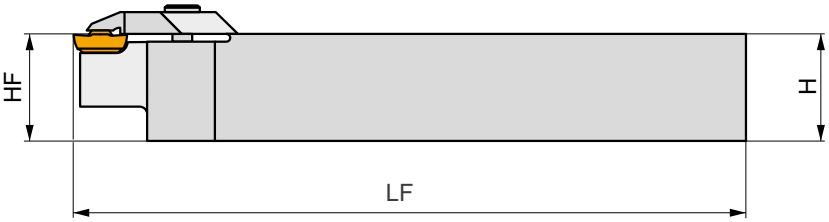
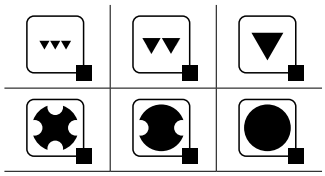
外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..03刀片。

外圆用右手轴向车刀杆，开槽加工，使用单面或双面LCM.0313或0316刀片。适用于Ø17至Ø170mm的端面开槽，轴向轮廓或槽的拓宽，最大切削深度为9mm的刀柄。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
R	**GFIR 2525 M 0313R 030017**	25	25	25	150	3.00	9	17	30	0.65	GI143	GL02
	GFIR 2525 M 0313R 039024	25	25	25	150	3.00	9	24	39	0.66	GI143	GL07
	GFIR 2525 M 0313R 050033	25	25	25	150	3.00	9	33	50	0.68	GI143	GL07
	GFIR 2525 M 0313R 060043	25	25	25	150	3.00	9	43	60	0.68	GI143	GL07
	GFIR 2525 M 0313R 076053	25	25	25	150	3.00	9	53	76	0.68	GI143	GL07
	GFIR 2525 M 0316R 100070	25	25	25	150	3.00	9	70	100	0.69	GI136	GL07
	GFIR 2525 M 0316R 130090	25	25	25	150	3.00	9	90	130	0.70	GI136	GL07
	GFIR 2525 M 0316R 170110	25	25	25	150	3.00	9	110	170	0.70	GI136	GL07

GI136	LCM. 0316..
GI143	LCM. 0313..

		Nm			
GL02	US 5015-T20P	5.0	M 5	15	FLAG T20P
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P

GFML-L AXIAL

P M K N S H

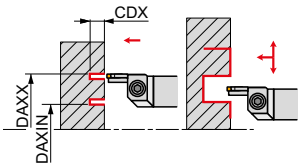
PRAMET

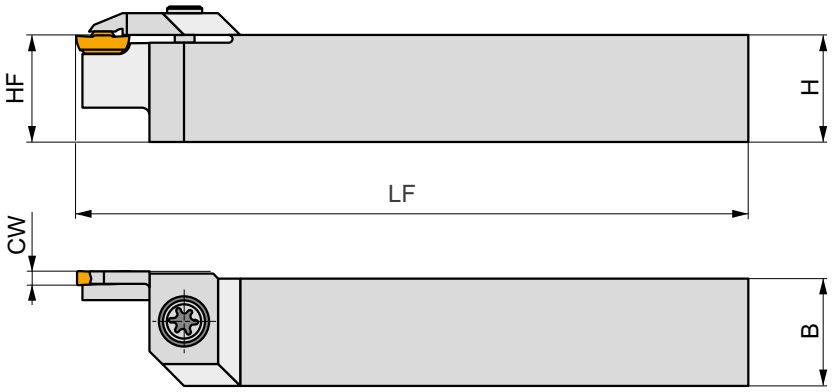
G

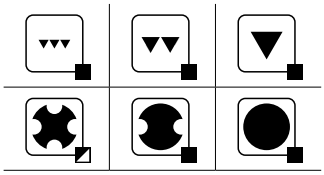


外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..04刀片。

外圆用左手轴向车刀杆，开槽加工，使用单面或双面LCM.0413或0416刀片。适用于Ø17至Ø230mm的深端面开槽，轴向轮廓或槽的拓宽，最大切削深度为20mm。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
L	**GFML 2525 M 0413L 030017**	25	25	25	150	4.00	20	17	30	0.62	GI170	GL02
	GFML 2525 M 0413L 034021	25	25	25	150	4.00	20	21	34	0.63	GI170	GL07
	GFML 2525 M 0413L 040026	25	25	25	150	4.00	20	26	40	0.65	GI170	GL07
	GFML 2525 M 0413L 050032	25	25	25	150	4.00	20	32	50	0.64	GI170	GL07
	GFML 2525 M 0413L 060042	25	25	25	150	4.00	20	42	60	0.65	GI170	GL07
	GFML 2525 M 0413L 075052	25	25	25	150	4.00	20	52	75	0.66	GI170	GL07
	GFML 2525 M 0416L 100070	25	25	25	150	4.00	20	70	100	0.66	GI137	GL07
	GFML 2525 M 0416L 130090	25	25	25	150	4.00	20	90	130	0.67	GI137	GL07
	GFML 2525 M 0416L 170110	25	25	25	150	4.00	20	110	170	0.67	GI137	GL07
	GFML 2525 M 0416L 230140	25	25	25	150	4.00	20	140	230	0.67	GI137	GL07

GI137	LCM. 0416..
GI170	LCM. 0413..

		Nm			
GL02	US 5015-T20P	5.0	M 5	15	FLAG T20P
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P

GFML-R AXIAL

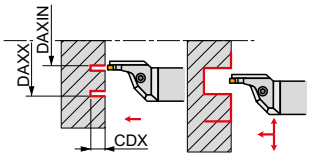
P M K N S H

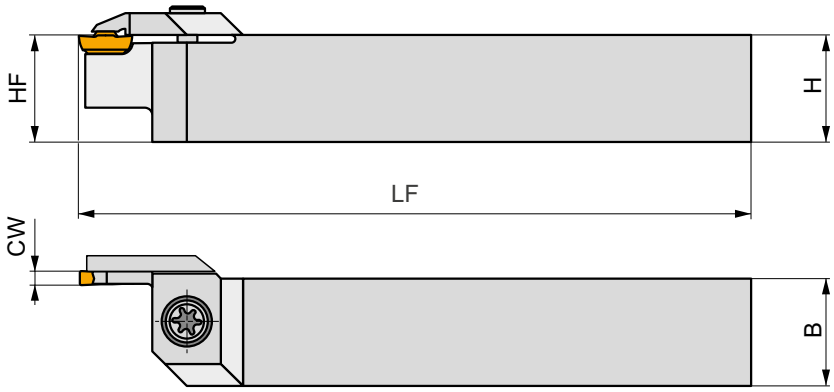
PRAMET G

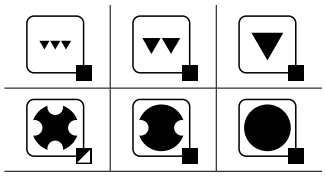


外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..04刀片。

外圆用左手轴向车刀杆，开槽加工，使用单面或双面LCM.0413或0416刀片。适用于Ø17至Ø230mm的深端面开槽，轴向轮廓或槽的拓宽，最大切削深度为20mm。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
L	**GFML 2525 M 0413R 030017**	25	25	25	150	4.00	20	17	30	0.68	GI170	GL07
	GFML 2525 M 0413R 034021	25	25	25	150	4.00	20	21	34	0.69	GI170	GL07
	GFML 2525 M 0413R 040026	25	25	25	150	4.00	20	26	40	0.69	GI170	GL07
	GFML 2525 M 0413R 050032	25	25	25	150	4.00	20	32	50	0.68	GI170	GL07
	GFML 2525 M 0413R 060042	25	25	25	150	4.00	20	42	60	0.69	GI170	GL07
	GFML 2525 M 0413R 075052	25	25	25	150	4.00	20	52	75	0.69	GI170	GL07
	GFML 2525 M 0416R 100070	25	25	25	150	4.00	20	70	100	0.80	GI137	GL08
	GFML 2525 M 0416R 130090	25	25	25	150	4.00	20	90	130	0.78	GI137	GL08
	GFML 2525 M 0416R 170110	25	25	25	150	4.00	20	110	170	0.78	GI137	GL08
	GFML 2525 M 0416R 230140	25	25	25	150	4.00	20	140	230	0.78	GI137	GL08

GI137	LCM. 0416..
GI170	LCM. 0413..

		Nm				
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	–
GL08	US 6020-T25P	6.0	M 6	20.2	–	SDR T25P

GFMR-L AXIAL

P M K N S H

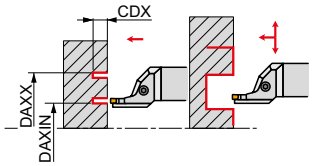
PRAMET

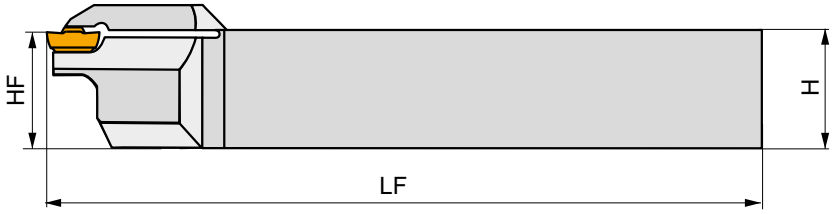
G



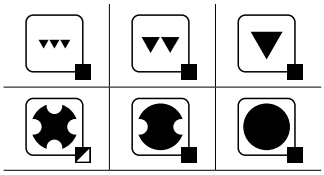
外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..04刀片。

外圆用右手轴向车刀杆，开槽加工，使用单面或双面LCM.0413或0416刀片。适用于Ø17至Ø230mm的深端面开槽，轴向轮廓或槽的拓宽，最大切削深度为20mm的刀柄。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
R	**GFMR 2525 M 0413L 030017**	25	25	25	150	4.00	20	17	30	0.70	GI170	GL07
	GFMR 2525 M 0413L 034021	25	25	25	150	4.00	20	21	34	0.66	GI170	GL07
	GFMR 2525 M 0413L 040026	25	25	25	150	4.00	20	26	40	0.66	GI170	GL07
	GFMR 2525 M 0413L 050032	25	25	25	150	4.00	20	32	50	0.68	GI170	GL07
	GFMR 2525 M 0413L 060042	25	25	25	150	4.00	20	42	60	0.66	GI170	GL07
	GFMR 2525 M 0413L 075052	25	25	25	150	4.00	20	52	75	0.69	GI170	GL07
	GFMR 2525 M 0416L 100070	25	25	25	150	4.00	20	70	100	0.88	GI137	GL08
	GFMR 2525 M 0416L 130090	25	25	25	150	4.00	20	90	130	0.78	GI137	GL08
	GFMR 2525 M 0416L 170110	25	25	25	150	4.00	20	110	170	0.81	GI137	GL08
	GFMR 2525 M 0416L 230140	25	25	25	150	4.00	20	140	230	0.78	GI137	GL08

GI137	LCM. 0416..
GI170	LCM. 0413..

		Nm				
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P	–
GL08	US 6020-T25P	6.0	M 6	20.2	–	SDR T25P

GFMR-R AXIAL

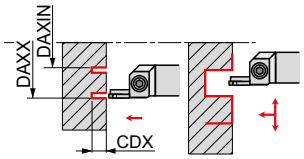
P M K N S H

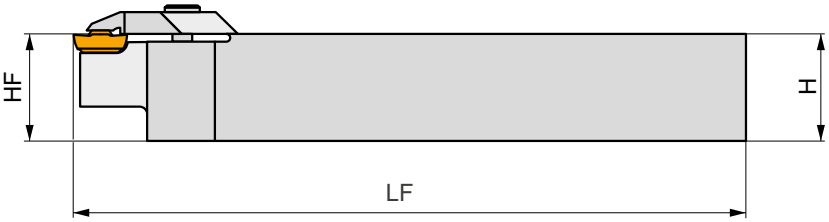
PRAMET G



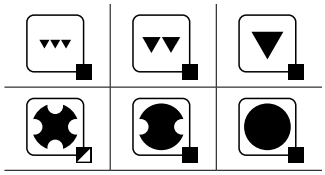
外圆用端面开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..04刀片。

外圆用右手轴向车刀杆，开槽加工，使用单面或双面LCM.0413或0416刀片。适用于Ø17至Ø230mm的深端面开槽，轴向轮廓或槽的拓宽，最大切削深度为20mm的刀柄。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
R	**GFMR 2525 M 0413R 030017**	25	25	25	150	4.00	20	17	30	0.62	GI170	GL02
	GFMR 2525 M 0413R 034021	25	25	25	150	4.00	20	21	34	0.63	GI170	GL07
	GFMR 2525 M 0413R 040026	25	25	25	150	4.00	20	26	40	0.64	GI170	GL07
	GFMR 2525 M 0413R 050032	25	25	25	150	4.00	20	32	50	0.63	GI170	GL07
	GFMR 2525 M 0413R 060042	25	25	25	150	4.00	20	42	60	0.64	GI170	GL07
	GFMR 2525 M 0413R 075052	25	25	25	150	4.00	20	52	75	0.67	GI170	GL07
	GFMR 2525 M 0416R 100070	25	25	25	150	4.00	20	70	100	0.67	GI137	GL07
	GFMR 2525 M 0416R 130090	25	25	25	150	4.00	20	90	130	0.66	GI137	GL07
	GFMR 2525 M 0416R 170110	25	25	25	150	4.00	20	110	170	0.67	GI137	GL07
	GFMR 2525 M 0416R 230140	25	25	25	150	4.00	20	140	230	0.68	GI137	GL07

GI137	LCM. 0416..
GI170	LCM. 0413..

		Nm			
GL02	US 5015-T20P	5.0	M 5	15	FLAG T20P
GL07	US 5018-T20P	5.0	M 5	18.2	FLAG T20P

GGI(RL)-90 AXIAL

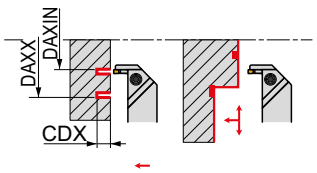
P M K N S H

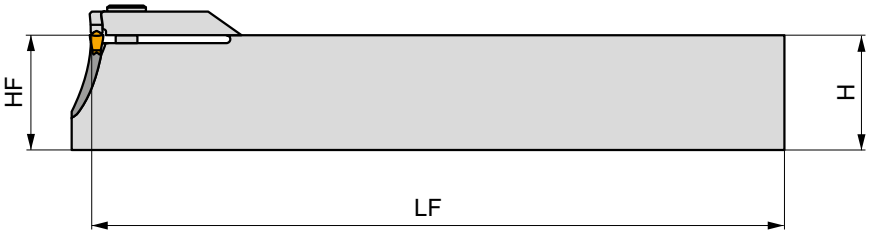
PRAMET G

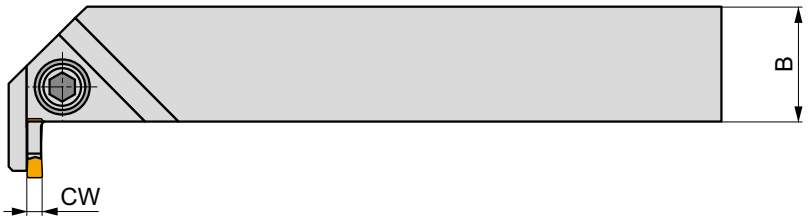


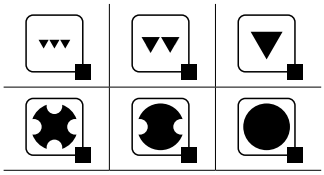
外圆用轴向90°拐角开槽车刀杆，V-型刀片槽，顶部夹紧，使用LCM..03刀片。

外圆用左/右手轴向90°拐角车刀杆，开槽加工，使用单面或双面LCM.0313或0316刀片。适用于Ø17至Ø170mm的端面开槽，轴向轮廓或扩宽，最大切削深度为11mm。可提供25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
R	**GGIR 2525 M 03R 030017**	25	25	25	150	3.00	9.5	17	30	0.75	GI143	GL01
	GGIR 2525 M 03R 039024	25	25	25	150	3.00	9.5	24	39	0.78	GI143	GL01
	GGIR 2525 M 03R 050033	25	25	25	150	3.00	11	33	50	0.75	GI143	GL01
	GGIR 2525 M 03R 060043	25	25	25	150	3.00	11	43	60	0.78	GI143	GL01
	GGIR 2525 M 03R 076053	25	25	25	150	3.00	11	53	76	0.75	GI143	GL01
	GGIR 2525 M 03R 100070	25	25	25	150	3.00	9	70	100	0.78	GI136	GL04
	GGIR 2525 M 03R 130090	25	25	25	150	3.00	9	90	130	0.73	GI136	GL04
	GGIR 2525 M 03R 170110	25	25	25	150	3.00	9	110	170	0.76	GI136	GL04
L	**GGIL 2525 M 03L 030017**	25	25	25	150	3.00	9.5	17	30	0.75	GI143	GL01
	GGIL 2525 M 03L 039024	25	25	25	150	3.00	9.5	24	39	0.25	GI143	GL01
	GGIL 2525 M 03L 050033	25	25	25	150	3.00	11	33	50	0.75	GI143	GL01
	GGIL 2525 M 03L 060043	25	25	25	150	3.00	11	43	60	0.75	GI143	GL01
	GGIL 2525 M 03L 076053	25	25	25	150	3.00	11	53	76	0.75	GI143	GL01
	GGIL 2525 M 03L 100070	25	25	25	150	3.00	9	70	100	0.77	GI136	GL04
	GGIL 2525 M 03L 130090	25	25	25	150	3.00	9	90	130	0.77	GI136	GL04
	GGIL 2525 M 03L 170110	25	25	25	150	3.00	9	110	170	0.76	GI136	GL04

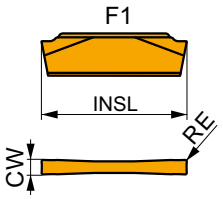
GI136	LCM. 0316..
GI143	LCM. 0313..

		Nm			
GL01	HS 0520C	5.0	M 5	20	HXK 4
GL04	HS 0620C	6.0	M 6	20	HXK 5

LCMF 20 - F1

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0220	2.00	-0.03	0.03	19.5



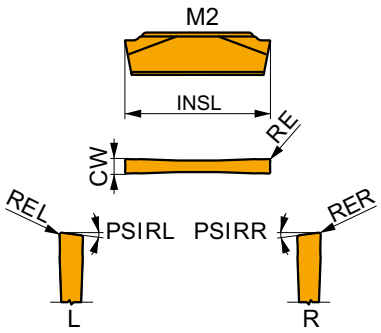
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(°)	(°)
	0,1 0° 12° 0,1 0° 5° U S															
	F1断屑槽，适用于切断和开槽加工，超精加工和精加工，连续切削至轻微断续切削。															
LCMF 022002-F1	**T8330**	0.2	■ 205	0.09	◪ 120	0.08	◪ 190	0.09	–	–	–	–	–	–	–	–

LCMF 20 - M2

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0220	2.00	-0.03	0.03	19.5

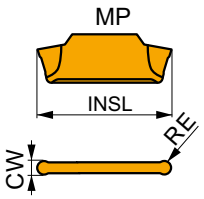


线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

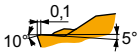
产品型号		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(°)	(°)
	0,05 8° 0,18 50° 0° U S															
	M2断屑槽，适用于切断和开槽加工，超精加工和精加工，连续至轻微断续切削。															
LCMF 022002-M2	**T8330**	0.2	■ 180	0.12	◪ 105	0.11	◪ 170	0.12	–	–	–	–	–	–	–	–
	0,05 8° 0,18 50° 0° U S															
	R-M2断屑槽，右手设计，适用于切断，连续切削至轻微断续切削。															
LCMF 022002R6-M2	**T8330**	0.2	■ 130	0.12	◪ 75	0.11	◪ 120	0.12	–	–	–	–	–	–	6	–
	0,05 8° 0,18 50° 0° U S															
	L-M2断屑槽，左手设计，适用于切断，连续切削至轻微断续切削。															
LCMF 022002L6-M2	**T8330**	0.2	■ 130	0.12	◪ 75	0.11	◪ 120	0.12	–	–	–	–	–	–	–	6

LCMF 20 - MP

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0220	2.00	-0.03	0.03	19.5



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

产品型号		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
MP断屑槽，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。																				
LCMF 0220MO-MP	**T8330**	1.0	■ 200	0.30	0.5	◪ 120	0.27	0.5	■ 190	0.30	0.5	–	–	–	–	–	–	–	–	–

GFK(RL) EXT

P M K N S H

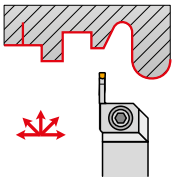
PRAMET

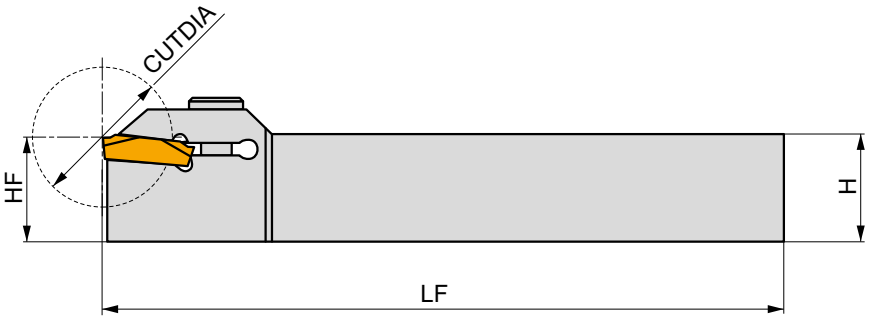
G

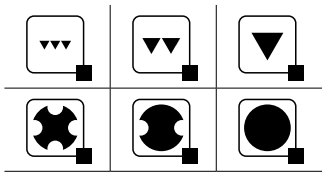


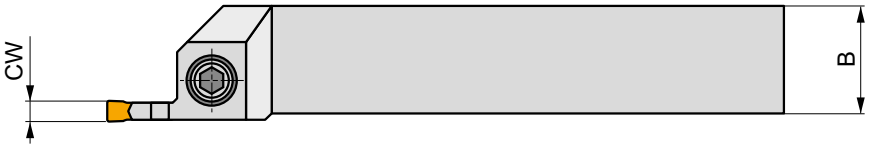
外圆用开槽和切断加工刀具，V-型刀片槽，顶部夹紧，使用LCMF 0220刀片。

外圆用左/右手持式车刀杆，开槽加工。使用LCMF 0220刀片。适用于最大切削深度为16mm，进行切断，开槽和仿形应用。可提供16x16至25x25mm的刀柄。刀杆经过处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CUTDIA (mm)	kg		
R	**GFKR 1616 H 02**	16	16	16	100	2.00	32	0.20	GI168	GL03
	GFKR 2020 K 02	20	20	20	125	2.00	32	0.38	GI168	GL04
	GFKR 2525 M 02	25	25	25	150	2.00	32	0.68	GI168	GL05
L	**GFKL 1616 H 02**	16	16	16	100	2.00	32	0.20	GI168	GL03
	GFKL 2020 K 02	20	20	20	125	2.00	32	0.38	GI168	GL04
	GFKL 2525 M 02	25	25	25	150	2.00	32	0.68	GI168	GL05

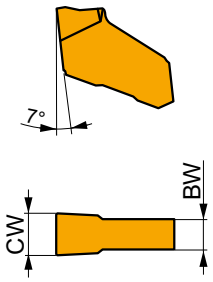
GI168	LCMF 0220..

		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

LFMX - F1

PRAMET

	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(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



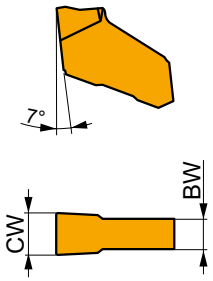
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P		M		K		N		S		H		PSIRR	PSIRL
			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)	(°)	(°)
			E													
			EN-F1断屑槽，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	–	–	–	–	–	–	–	–

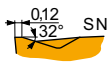
LFMX - F2

PRAMET

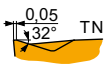
	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



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。

产品型号		RE	P		M		K		N		S		H		PSIRR	PSIRL
			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)	(°)	(°)
			U	S												
			SN-F2断屑槽，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	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–

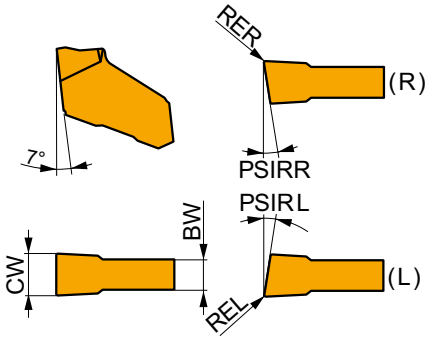
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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断屑槽，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	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–

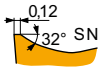
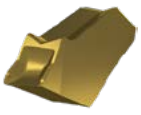
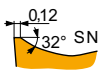
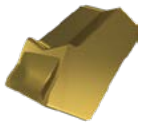
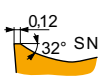
LFMX - M2

PRAMET

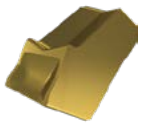
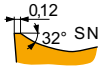
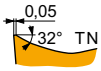
	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	BW (mm)
2.0	2.00	-0.03	0.03	1.60
2.2	2.20	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



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。

产品型号		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断屑槽，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	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–
	T8330	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
																
			SR-M2断屑槽，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	–
																
			SL-M2断屑槽，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

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。

产品型号		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(°)	(°)
																
SL-M2断屑槽，左手设计，适用于切断加工，连续切削至轻微断续切削。																
LFMX 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断屑槽，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	–	–	–	–	–	–	–	–
	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	–	–	–	–	–	–	–	–
	T8330	0.2	■ 130	0.15	◪ 75	0.14	◪ 120	0.15	–	–	–	–	–	–	–	–

XLCFN B

P M K N S H

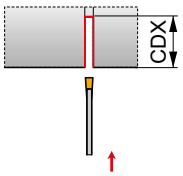
PRAMET

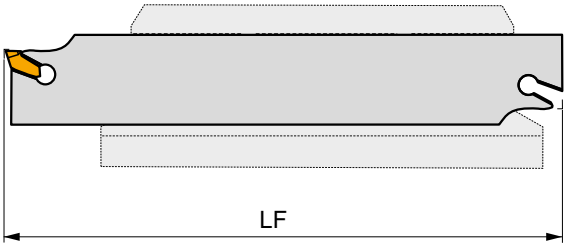
X

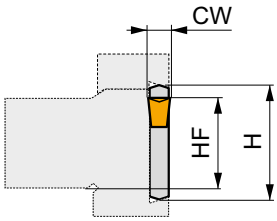


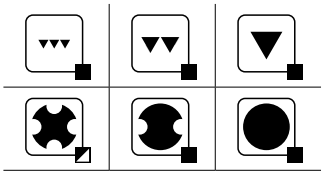
使用LFMX刀片，双头切断刀板

刀板用于切断应用，最大深度为80mm或Ø160mm的棒材。适用于单面LFMX刀片。高度为26、32或45mm。可以安装在DU Premet基础刀杆上。经过处理，使用寿命更长。











	产品型号	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
N	**XLCFN 2601 J 1.60**	21.4	26	110	1.50	15	0.03	GI132	KV
	XLCFN 2601 J 2.00	21.4	26	110	2.00	25	0.04	GI061	KV
	XLCFN 2602 J 3.00	21.4	26	110	3.10	37.5	0.05	GI001	KV
	XLCFN 2603 J 4.00	21.4	26	110	4.10	40	0.06	GI002	KV
	XLCFN 3201 M 1.60	25	32	150	1.50	15	0.06	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	0.11	GI002	KV
	XLCFN 3204 M 5.00	25	32	150	5.10	60	0.14	GI004	KV
	XLCFN 3205 M 6.35	25	32	150	6.35	60	0.17	GI005	KV
	XLCFN 4502 S 3.00	32	45	250	3.10	80	0.12	GI001	KV
	XLCFN 4503 S 4.00	32	45	250	4.10	80	0.19	GI002	KV
	XLCFN 4504 S 5.00	32	45	250	5.10	80	0.28	GI004	KV
	XLCFN 4505 S 6.35	32	45	250	6.35	80	0.40	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

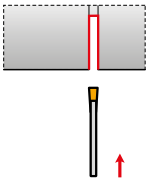
DU, D

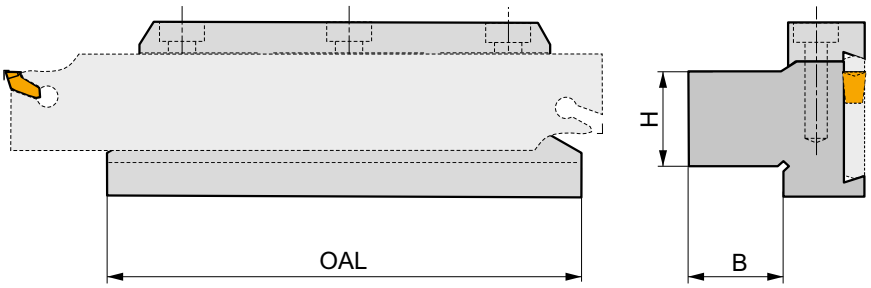
PRAMET

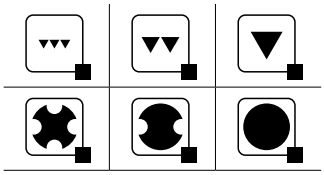


切断刀板的车刀座

刀座适合GL或XLC，切断刀板。可提供20x20至40x40mm的刀柄。刀杆经过处理，使用寿命更长。







	产品型号	H (mm)	B (mm)	OAL (mm)	kg		
	26-DU 2020	20	20	90	0.70	GI007	ND2
	26-D 2020	20	20	100	0.82	GI007	ND2
	32-DU 2523	25	23	110	1.02	GI008	ND2
	32-DU 2532	25	32	110	1.10	GI008	ND2
	32-DU 3229	32	29	110	1.25	GI008	ND2
	32-D 2530	25	30	115	1.30	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	3.88	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

XLCF(NRL) BS

P M K N S H

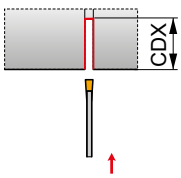
PRAMET

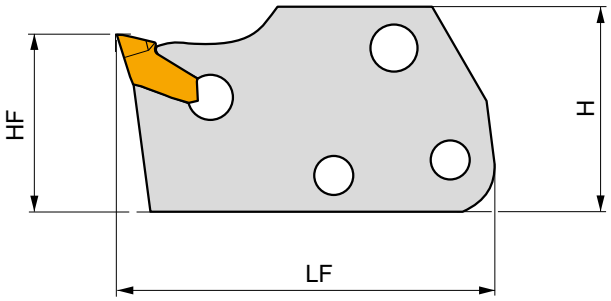
X



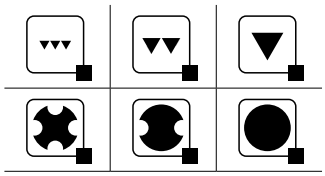
模块化MS-EN槽刀杆的径向开槽刀板，使用LFMX刀片，

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。











	产品型号	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
R	XLCFR 160115-1.60	12	25	35	1.50	15	0.01	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	0.01	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	0.01	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	0.02	GI001	KV
	XLCFN 250215-3.00	24	29	40	3.10	15	0.02	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	0.02	GI002	KV
	XLCFN 250325-4.00	24	29	50	4.10	25	0.03	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	0.04	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

XLXFL BS AXIAL

P M K N S H

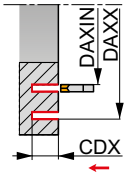
PRAMET

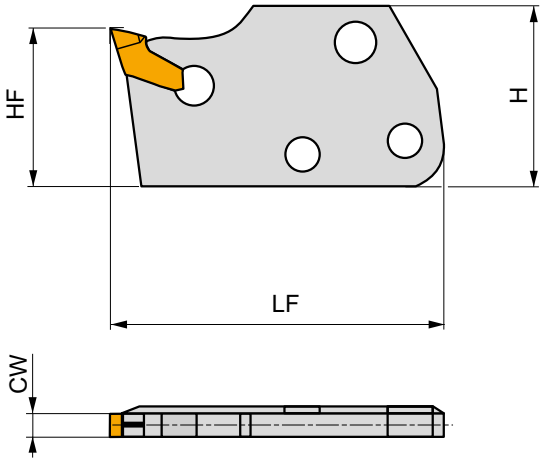
X

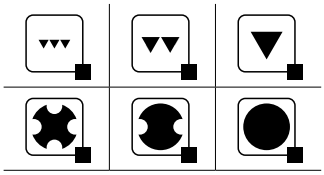
模块化MS-EN槽刀杆的端面开槽刀板，使用LFMX刀片。

模块化开槽刀板，开槽加工，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。













	产品型号	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	0.07	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

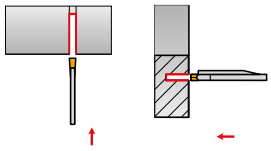
MS-EN

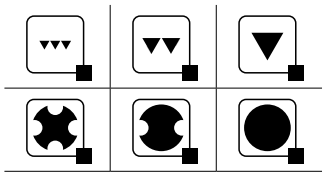
PRAMET

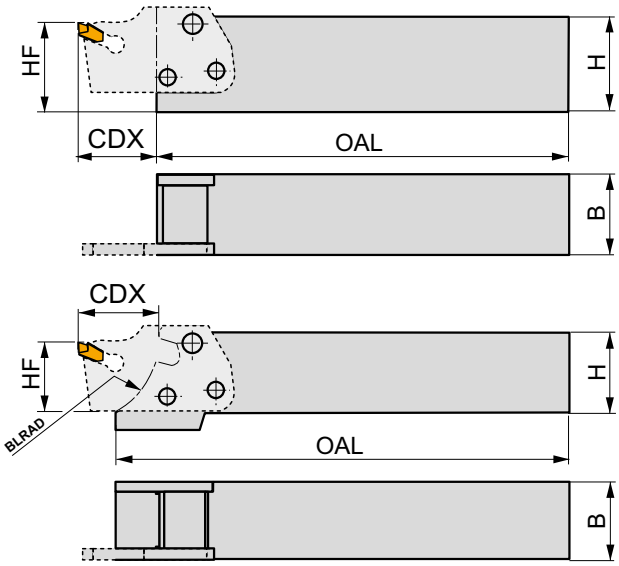


模块化车刀杆，使用XLCCN，XLCF（NRL）或XLXFL开槽刀板。

车刀杆用于安装XLC25BS，XLCF（NRL）BS，XLXFLBS端面开槽刀板。可提供可提供12x12至32x25mm的PSC刀柄。刀杆经过处理，使用寿命更长。







产品型号	HF (mm)	H (mm)	B (mm)	OAL (mm)	CDX (mm)	BLRAD (mm)	kg		
MS-EN-1212 F	12	12	12	75	15	–	0.13	GI006	ND4
MS-EN-1616 H	16	16	16	90	15	–	0.21	GI006	ND4
MS-EN-2020 K	20	20	20	115	15	–	0.23	GI003	ND5
MS-EN-2020 KS	20	20	20	129	15	25	0.42	GI060	ND5
MS-EN-2525 M	25	25	25	140	15	–	0.65	GI003	ND5
MS-EN-2525 MS	25	25	25	153	15	25	0.74	GI060	ND5
MS-EN-3225 P	32	32	25	160	15	–	0.95	GI003	ND5
MS-EN-3225 PS	32	32	25	174	15	25	1.00	GI060	ND5

GI003	XLC.. 25..15...	XLXFL 25…	XLC.. 25..25…
GI006	XLCF. 16..15…	XLCF. 16..20…	–
GI060	XLC.. 25..15…	XLC.. 25..25…	–

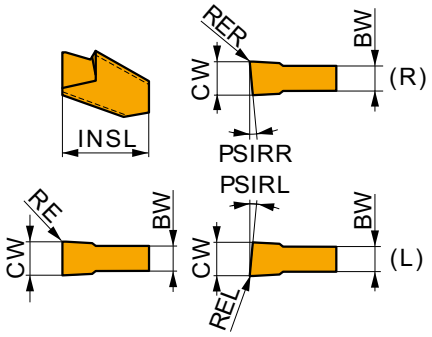
		Nm				Nm			
ND4	US 4011-T15P	3.5	M 4	10.6	–	–	–	–	FLAG T15P
ND5	US 45013-T20P	5.0	M 5	13	US 46017-T20P	5.0	M6	17	FLAG T15P

ND4 =3 x US 4011-T15P; ND5=2 x US 45013-T20P

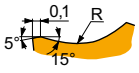
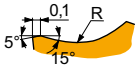
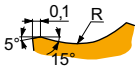
LFUX

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。

产品型号		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断屑槽，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	–	–	–	–	–	–	–	–
	T8330	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	–	–
LFUX 040802TN	**6640**	0.2	150	0.12	–	–	140	0.12	–	–	–	–	–	–	–	–
	T8330	0.2	130	0.12	–	–	120	0.12	–	–	–	–	–	–	–	–
LFUX 050802TN	**6640**	0.2	150	0.15	–	–	140	0.15	–	–	–	–	–	–	–	–
	T8330	0.2	130	0.15	–	–	120	0.15	–	–	–	–	–	–	–	–
LFUX 060802TN	**6640**	0.2	150	0.20	–	–	140	0.20	–	–	–	–	–	–	–	–
	T8330	0.2	130	0.20	–	–	120	0.20	–	–	–	–	–	–	–	–
																
TR断屑槽，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	–
	T8330	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	5	–
LFUX 040800TR	**6640**	0.2	150	0.12	–	–	140	0.12	–	–	–	–	–	–	5	–
	T8330	0.2	130	0.12	–	–	120	0.12	–	–	–	–	–	–	5	–
																
TL断屑槽，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
	T8330	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	–	5

XLCF(RL)

P M K N S H

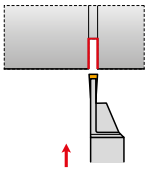
PRAMET

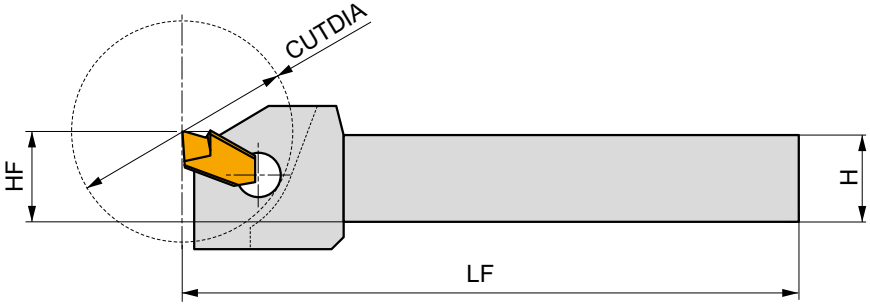
X

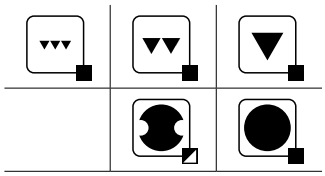


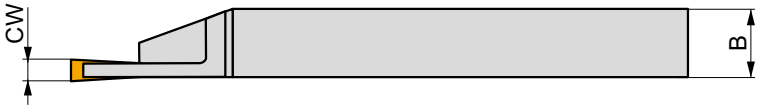
外圆用开槽和切断加工车刀杆，使用LFUX刀片

外圆用左/右手径向车刀杆，开槽加工。使用单面LFUX　0308、0408、0508或0608刀片。适用于最大Ø65mm的切断。可提供16x12至32x25mm的刀柄。刀杆经过处理，使用寿命更长。













	产品型号	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CUTDIA (mm)	kg		
R	**XLCFR 1612 H 03**	16	16	12	100	3.00	40	0.14	GI018	KV
	XLCFR 2016 K 03	20	20	16	130	3.00	50	0.30	GI018	KV
	XLCFR 2520 K 03	25	25	20	130	3.00	50	0.44	GI018	KV
	XLCFR 2016 K 04	20	20	16	130	4.00	50	0.30	GI019	KV
	XLCFR 2520 K 04	25	25	20	130	4.00	50	0.43	GI019	KV
	XLCFR 2520 K 05	25	25	20	130	5.00	50	0.45	GI020	KV
	XLCFR 3225 P 05	32	32	25	170	5.00	65	0.90	GI020	KV
	XLCFR 3225 P 06	32	32	25	170	6.00	65	0.91	GI021	KV
L	**XLCFL 1612 H 03**	16	16	12	100	3.00	40	0.15	GI018	KV
	XLCFL 2016 K 03	20	20	16	130	3.00	50	0.30	GI018	KV
	XLCFL 2520 K 03	25	25	20	130	3.00	50	0.47	GI018	KV
	XLCFL 2016 K 04	20	20	16	130	4.00	50	0.30	GI019	KV
	XLCFL 2520 K 04	25	25	20	130	4.00	50	0.46	GI019	KV
	XLCFL 2520 K 05	25	25	20	130	5.00	50	0.50	GI020	KV
	XLCFL 3225 P 05	32	32	25	170	5.00	65	0.95	GI020	KV
	XLCFL 3225 P 06	32	32	25	170	6.00	65	0.70	GI021	KV

GI018	LFUX 0308..
GI019	LFUX 0408..
GI020	LFUX 0508..
GI021	LFUX 0608..

KV	KV 5x70

XLCFN B LFUX

P M K N S H

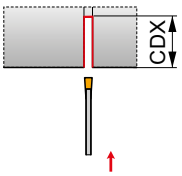
PRAMET

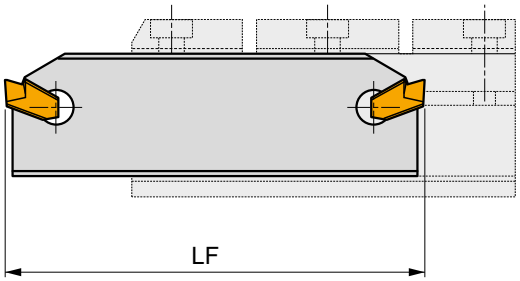
X

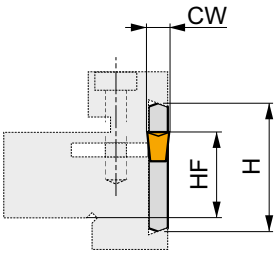


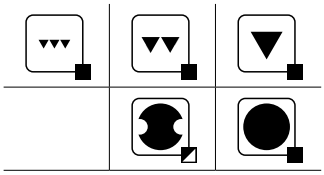
使用LFUX刀片，双头切断刀板

刀板用于切断应用，最大深度可达100mm或Ø200mm的棒材。适用于单面LFUX刀片。高度为26、32或47mm。可安装在DU,D Premet基础刀杆上。经过处理，使用寿命更长。











	产品型号	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	0.09	GI018	KV
	XLCFN 3203 M 04	25	32	150	4.10	50	0.11	GI019	KV
	XLCFN 3204 M 05	25	32	150	5.10	60	0.14	GI020	KV
	XLCFN 4704 S 05	38	47	270	5.10	100	0.47	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

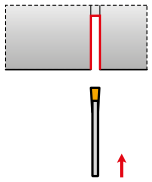
DU, D

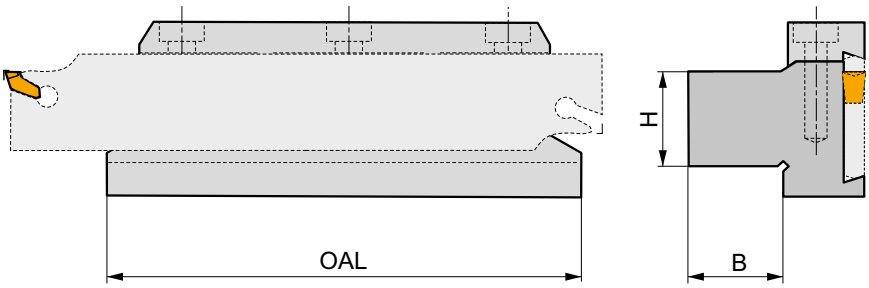
PRAMET

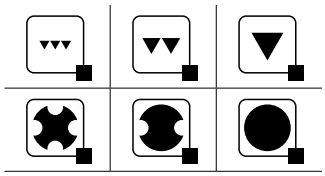


切断刀板的车刀座

刀座适合GL或XLC，切断刀板。可提供20x20至40x40mm的刀柄。刀杆经过处理，使用寿命更长。







产品型号	H (mm)	B (mm)	OAL (mm)	kg		
26-DU 2020	20	20	90	0.70	GI007	ND2
26-D 2020	20	20	100	0.82	GI007	ND2
32-DU 2523	25	23	110	1.02	GI008	ND2
32-DU 2532	25	32	110	1.10	GI008	ND2
32-DU 3229	32	29	110	1.25	GI008	ND2
32-D 2530	25	30	115	1.30	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	3.88	GI091	ND3

GI007	XLC.N 26..	GL.-S26.B
GI008	XLC.N 32..	GL.-S32.B
GI009	XLC.N 45..	–
GI091	XLC.N 47..	–

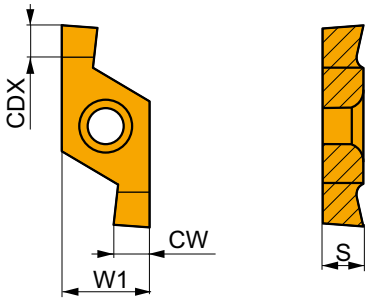
		Nm			
ND2	HS 0625	6.0	M 6	25	HXK 5
ND3	HS 1030	8.0	M 10	30	HXK 8
ND7	HS 0630	6.0	M 6	30	HXK 5

NEW

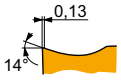
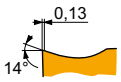
X 61

PRAMET

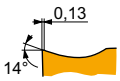
	W1	CWTOLL	CWTOLU	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33



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。

产品型号		RE	P		M		K		N		S		H		CW	CDX
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(mm)	(mm)
																
X 61-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
	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
	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
	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
	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
	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
	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
	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
	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
	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
	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
	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
	G8330	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.20	3
																
X 61-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
	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
	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
	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
	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
	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。

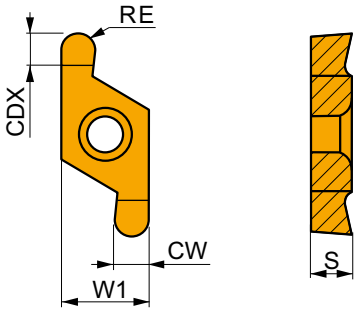
产品型号		RE	P				M				K				N				S				H				CW	CDX
			vc		f		vc		f		vc		f		vc		f		vc		f		vc		f			
		(mm)	(m/min)		(mm/rev)		(m/min)		(mm/rev)		(m/min)		(mm/rev)		(m/min)		(mm/rev)		(m/min)		(mm/rev)		(m/min)		(mm/rev)		(mm)	(mm)
			U S																									
			X 61-L外圆和内孔，左手断屑槽，适用于O形圈和卡簧槽加工，可连续切削。																									
X61 0602-150 L	**6640**	–	180		0.06		105		0.05		170		0.06		–		–		–		–		–		–		1.55	1.6
	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
	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
	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
	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
	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
	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
	G8330	–	105		0.12		60		0.11		95		0.12		–		–		–		–		–		–		3.20	3

NEW

X 61 R

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。

产品型号		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)
			U E																									
			X 61 R-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-R100 R	**6640**	1.0	170		0.06		100		0.05		160		0.06		–		–		–		–		–		–		2.09	3
	G8330	1.0	130		0.06		75		0.05		120		0.06		–		–		–		–		–		–		2.09	3
X61 0602-R150 R	**6640**	1.5	170		0.06		100		0.05		160		0.06		–		–		–		–		–		–		3.09	3
	G8330	1.5	130		0.06		75		0.05		120		0.06		–		–		–		–		–		–		3.09	3
			U E																									
			X 61 R-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-R100 L	**6640**	1.0	170		0.06		100		0.05		160		0.06		–		–		–		–		–		–		2.09	3
	G8330	1.0	130		0.06		75		0.05		120		0.06		–		–		–		–		–		–		2.09	3
X61 0602-R150 L	**6640**	1.5	170		0.06		100		0.05		160		0.06		–		–		–		–		–		–		3.09	3
	G8330	1.5	130		0.06		75		0.05		120		0.06		–		–		–		–		–		–		3.09	3

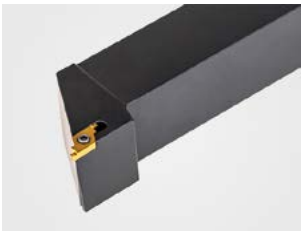
NEW

P61(RL) EXT

P M K N S

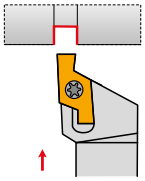
PRAMET

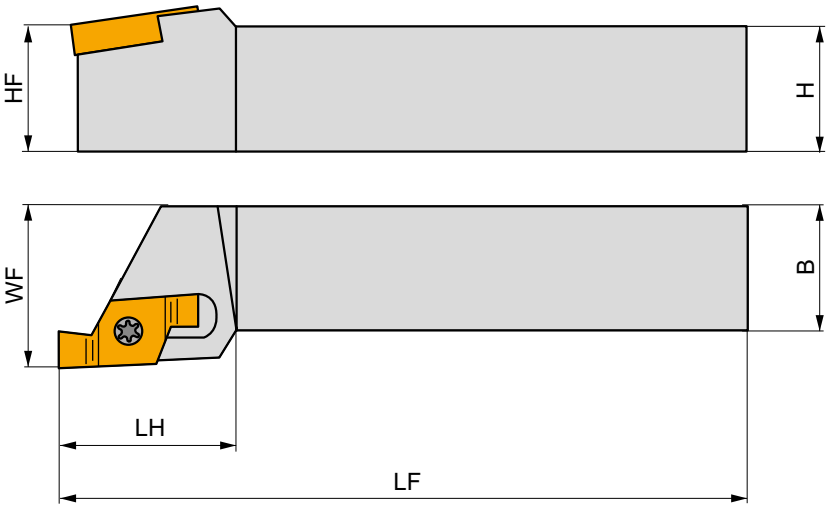
S

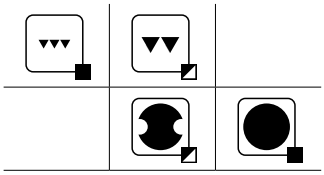


外圆用开槽车刀杆，使用X61卡簧槽和O型圈刀片

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。









	产品型号	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	kg		
R	P61.SFR-1616H-06	16	16	16	20	100	21	0.23	GI332	SV11
	P61.SFR-2020K-06	20	20	20	25	125	25	0.40	GI332	SV11
	P61.SFR-2525M-06	25	25	25	32	150	32	0.73	GI332	SV11
L	P61.SFL-1616H-06	16	16	16	20	100	21	0.23	GI332	SV11
	P61.SFL-2020K-06	20	20	20	25	125	25	0.42	GI332	SV11
	P61.SFL-2525M-06	25	25	25	32	150	32	0.73	GI332	SV11

GI332	X61 0602..

		Nm			
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

NEW

P61(RL) INT

P M K N S

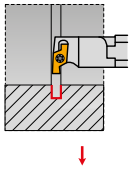
PRAMET

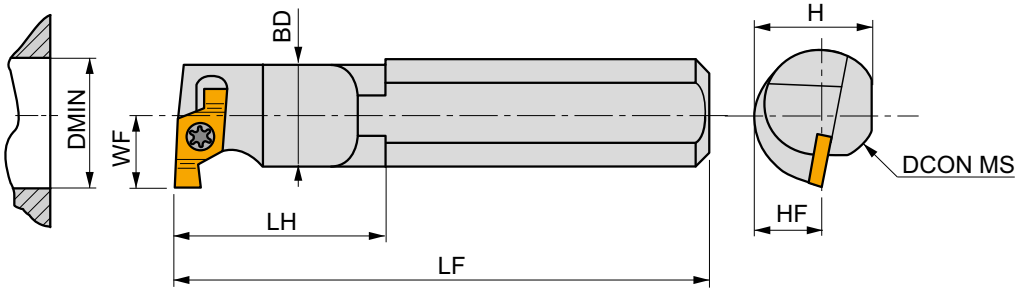
S

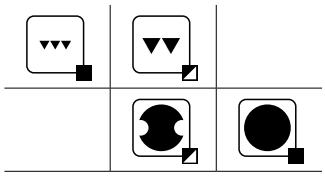


内孔用卡簧槽镗杆，使用X61刀片。

内孔用左/右手开槽镗杆，开槽加工，使用X61双面刀片。内孔最小开槽直径为Ø16mm。适用于内孔卡簧槽或O-形圈槽。可提供Ø12至Ø32mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	–	0.17	GI332	SV11
	P61.SGR-A-0016M-06	16	20	15	11	15	150	29	0	✓	0.21	GI332	SV11
	P61.SGR-A-0020P-06	20	25	19	13	18	170	29	0	✓	0.38	GI332	SV11
	P61.SGR-A-0025R-06	25	32	24	17	23	200	31	0	✓	0.70	GI332	SV11
	P61.SGR-A-0032T-06	32	40	31	22	30	300	49	0	✓	1.72	GI332	SV11
L	**P61.SGL-0012M-06**	12	16	11.5	9	11	150	22	0	–	0.17	GI332	SV11
	P61.SGL-A-0016M-06	16	20	15	11	15	150	29	0	✓	0.24	GI332	SV11
	P61.SGL-A-0020P-06	20	25	19	13	18	170	29	0	✓	0.40	GI332	SV11
	P61.SGL-A-0025R-06	25	32	24	17	23	200	31	0	✓	0.72	GI332	SV11
	P61.SGL-A-0032T-06	32	40	31	22	30	300	49	0	✓	1.72	GI332	SV11

GI332	X61 0602..

		Nm			
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

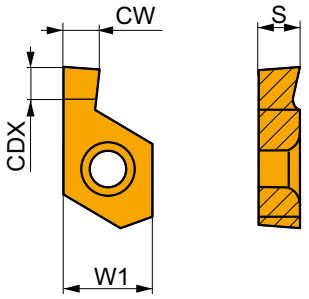
左手刀片安装到右手镗杆

NEW

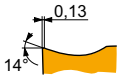
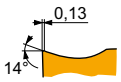
X 61-1

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。

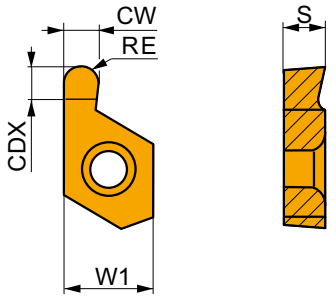
产品型号		RE	P		M		K		N		S		H		CW	CDX
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(mm)	(mm)
																
X 61-1-R内孔，右手设计，具有一个用于O形圈和卡簧槽加工的切削刃，可连续切削。																
X61 0602-080 R1	**6640**	–	195	0.06	115	0.05	185	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
																
X 61-1-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。																
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

NEW

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。

产品型号		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)
																
			U E													
			X 61 R-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-R050 R1	**6640**	0.5	■ 185	0.06	◪ 110	0.05	◪ 175	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
																
			U E													
			X 61 R-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。													
X61 0602-R050 L1	**6640**	0.5	■ 185	0.06	◪ 110	0.05	◪ 175	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

NEW

P61S(RL)-1 INT

P M K N S

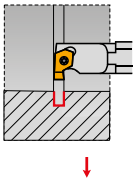
PRAMET

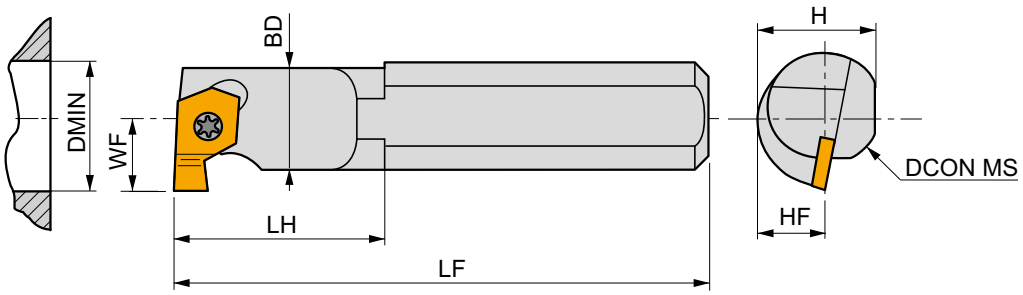
S

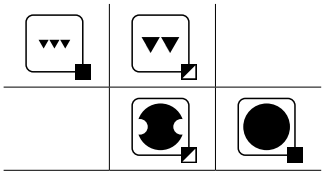


内孔用卡簧槽镗杆，使用X61-1刀片。

内孔用左/右手开槽镗杆，开槽加工，使用单面X61-1刀片。内孔最小开槽直径为Ø12.5mm。适用于内孔卡簧槽或O-形圈槽。可提供Ø10和Ø12mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	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	0.24	GI333	SV11
	P61.SGR-0012M-06/1	12	12.5	10	7.5	11	150	19	0	0.17	GI333	SV11
L	P61.SGL-0010M-06/1	10	12.5	10	7.5	9	150	19	0	0.13	GI333	SV11
	P61.SGL-0012M-06/1	12	12.5	10	7.5	11	150	19	0	0.17	GI333	SV11

GI333	X61 0602..-1

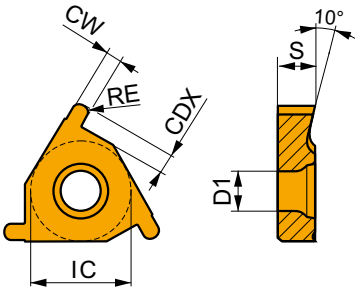
		Nm			
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

左手刀片安装到右手镗杆

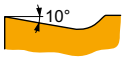
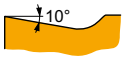
TN R EXT

PRAMET

	IC (mm)	D1 (mm)	S (mm)	CWTOLL (mm)	CWTOLU (mm)
16	9.525	3.90	3.58	0.00	0.05
22	12.700	4.90	4.70	0.00	0.05



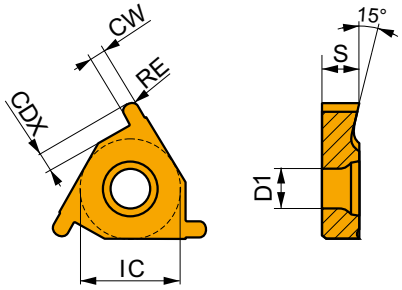
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
																
TN ER-R外圆，右手断屑槽，适用于O形圈和卡簧槽加工，连续切削。																
TN 16ER-R050	**T8330**	0.5	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.00	1.3
TN 16ER-R100	**T8330**	1.0	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	2.00	1.85
TN 22ER-R150	**T8330**	1.5	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	3.00	2.2
																
TN EL-R外圆，左手断屑槽，适用于O形圈和弹性挡圈凹槽加工，可连续切削。																
TN 16EL-R050	**T8330**	0.5	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.00	1.3
TN 16EL-R100	**T8330**	1.0	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	2.00	1.85
TN 22EL-R150	**T8330**	1.5	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	3.00	2.2

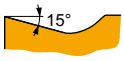
TN R INT

PRAMET

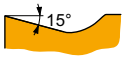
	IC (mm)	D1 (mm)	S (mm)	CWTOLL (mm)	CWTOLU (mm)
11	6.350	2.80	3.10	0.00	0.05
16	9.525	3.90	3.58	0.00	0.05
22	12.700	4.90	4.70	0.00	0.05



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。

产品型号		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)
																
TN NR-R内孔，右手断屑槽，适用于O形圈和卡簧槽加工，连续切削。																
TN 11NR-R050	**T8330**	0.5	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.00	1.3
TN 16NR-R100	**T8330**	1.0	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	2.00	1.85
TN 22NR-R150	**T8330**	1.5	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	3.00	2.2

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。

产品型号		RE	P		M		K		N		S		H		CW	CDX
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(mm)	(mm)
																

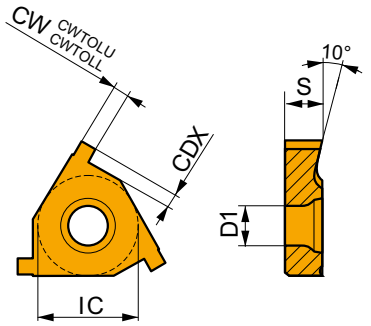
TN NL-R内孔，左手断屑槽，适用于O形圈和卡簧槽加工，并带有连续切削。

TN 11NL-R050	T8330	0.5	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.00	1.3
TN 16NL-R100	T8330	1.0	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	2.00	1.85
TN 22NL-R150	T8330	1.5	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	3.00	2.2

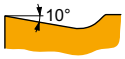
TN ZZ EXT

PRAMET

	IC (mm)	D1 (mm)	S (mm)
16	9.525	3.90	3.40
22	12.700	4.90	4.70

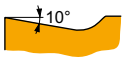


线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P		M		K		N		S		H		CW	CWTOLL	CWTOLU	CDX
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(mm)	(mm)	(mm)	(mm)
																		

TN ER-ZZ外圆，右手断屑槽，适用于O形圈和卡簧槽加工，并带有连续切削。

TN 16ER090ZZ	T8330	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	0.90	0.05	0.10	0.9
TN 16ER110ZZ	T8330	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	1.10	0.05	0.10	1.3
TN 16ER130ZZ	T8330	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	1.30	0.05	0.10	1.6
TN 16ER160ZZ	T8330	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	1.60	0.05	0.10	1.85
TN 16ER185ZZ	T8330	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	1.85	0.05	0.10	1.85
TN 16ER215ZZ	T8330	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	2.15	0.05	0.10	1.85
TN 16ER265ZZ	T8330	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	2.65	0.05	0.10	2.05
TN 22ER265ZZ	T8330	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	2.65	0.08	0.13	2.2
TN 22ER315ZZ	T8330	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	3.15	0.08	0.13	2.2
TN 22ER415ZZ	T8330	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	4.15	0.08	0.13	2.4

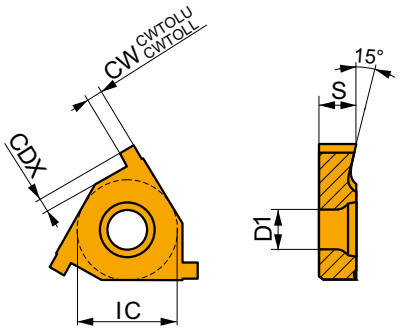
TN EL-ZZ外圆，左手断屑槽，适用于O形圈和弹性挡圈凹槽加工，可连续切削。

TN 16EL090ZZ	T8330	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	0.90	0.05	0.10	0.9
TN 16EL110ZZ	T8330	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.10	0.05	0.10	1.3
TN 16EL130ZZ	T8330	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.30	0.05	0.10	1.6
TN 16EL160ZZ	T8330	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.60	0.05	0.10	1.85
TN 16EL185ZZ	T8330	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.85	0.05	0.10	1.85
TN 16EL215ZZ	T8330	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	2.15	0.05	0.10	1.85
TN 16EL265ZZ	T8330	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	2.65	0.05	0.10	2.05
TN 22EL265ZZ	T8330	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	2.65	0.08	0.13	2.2
TN 22EL315ZZ	T8330	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	3.15	0.08	0.13	2.2
TN 22EL415ZZ	T8330	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	4.15	0.08	0.13	2.4

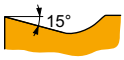
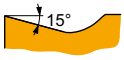
TN ZZ INT

PRAMET

	IC (mm)	D1 (mm)	S (mm)
11	6.350	2.80	3.00
16	9.525	3.90	3.40
22	12.700	4.90	4.70



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。

产品型号		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)	CDX (mm)
																		
			U E															
TN NR-ZZ内孔，右手断屑槽，适用于O形圈和卡簧槽加工，连续切削。																		
TN 11NR090ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	0.90	0.05	0.10	0.9
TN 11NR110ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.10	0.05	0.10	1.3
TN 16NR090ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	0.90	0.05	0.10	0.9
TN 16NR110ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.10	0.05	0.10	1.3
TN 16NR130ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.30	0.05	0.10	1.6
TN 16NR160ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.60	0.05	0.10	1.85
TN 16NR185ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.85	0.05	0.10	1.85
TN 16NR215ZZ	**T8330**	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	2.15	0.05	0.10	1.85
TN 16NR265ZZ	**T8330**	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	2.65	0.05	0.10	2.05
TN 22NR265ZZ	**T8330**	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	2.65	0.08	0.13	2.2
TN 22NR315ZZ	**T8330**	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	3.15	0.08	0.13	2.2
TN 22NR415ZZ	**T8330**	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	4.15	0.08	0.13	2.4
																		
			U E															
TN NL-ZZ内孔，左手断屑槽，适用于O形圈和卡簧槽加工，连续切削。																		
TN 11NL090ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	0.90	0.05	0.10	0.9
TN 11NL110ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.10	0.05	0.10	1.3
TN 16NL090ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	0.90	0.05	0.10	0.9
TN 16NL110ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.10	0.05	0.10	1.3
TN 16NL130ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.30	0.05	0.10	1.6
TN 16NL160ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.60	0.05	0.10	1.85
TN 16NL185ZZ	**T8330**	–	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	1.85	0.05	0.10	1.85
TN 16NL215ZZ	**T8330**	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	2.15	0.05	0.10	1.85
TN 16NL265ZZ	**T8330**	–	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	2.65	0.05	0.10	2.05
TN 22NL265ZZ	**T8330**	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	2.65	0.08	0.13	2.2
TN 22NL315ZZ	**T8330**	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	3.15	0.08	0.13	2.2
TN 22NL415ZZ	**T8330**	–	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	4.15	0.08	0.13	2.4

SE(RL)

P M K N S H

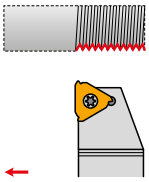
PRAMET

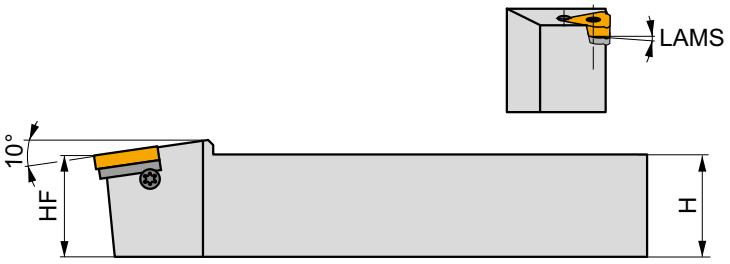
S

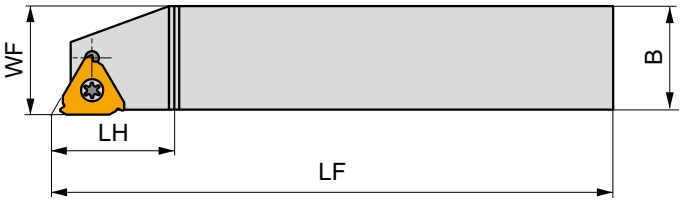


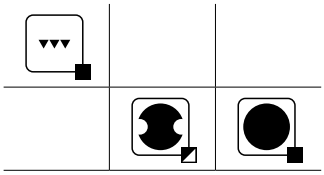
外圆螺纹用螺丝夹紧式车刀杆，使用TN16或22刀片。

左/右手螺丝锁车刀杆，外螺纹加工，使用TN16或22　ER/EL刀片。适用于公制或英制螺纹。也适用于浅槽。刀杆经过处理，使用寿命更长。











	产品型号	H (mm)	HF (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)		
R	**SER 2020 K 16**	20	20	20	20	125	22.5	–	GI068	Z12
	SER 2525 M 16	25	25	25	25	150	24	–	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	–	GI068	Z12
	SEL 3225 P 16	32	32	25	25	170	24.5	–	GI068	Z12
	SEL 2525 M 22-A	25	25	25	25	150	25.5	–	GI071	Z13
	SEL 3225 P 22-A	32	32	25	25	170	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	481
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	–	FLAG T20	–	481

SI(RL)

P M K N S H

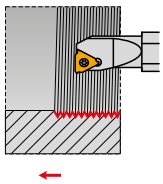
PRAMET

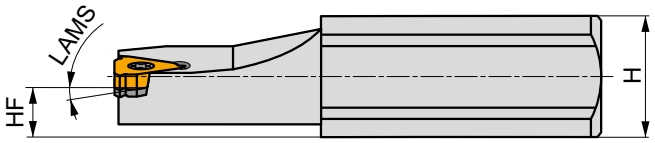
S

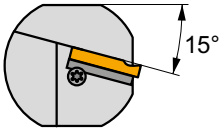


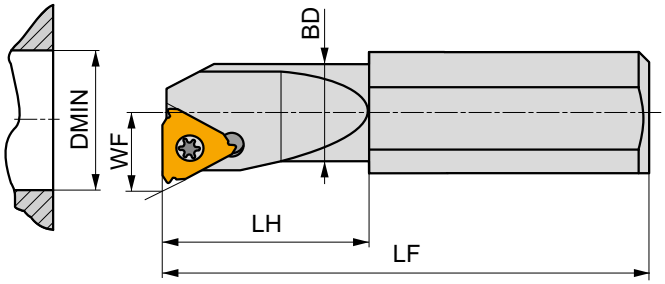
内孔螺纹用螺丝夹紧式车刀杆，使用TN11、16或22刀片。

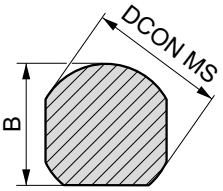
左/右手螺钉锁定镗杆，内螺纹加工，使用TN11、16或22ER/EL刀片。适用于公制或英制螺纹。最小内径Ø13mm。也适用于浅槽。可提供Ø16至Ø40mm的刀柄。刀杆经过处理，使用寿命更长。

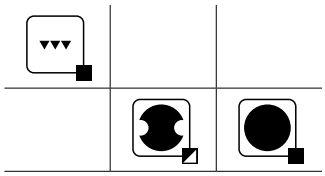














	产品型号	B (mm)	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)			
R	SIR 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25	0	–	GI085	Z11
	SIR 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25	1	–	GI085	Z11
	SIR 0013 M 11-0	14.5	16	16	13	9	14	7	150	32	0	–	GI085	Z11
	SIR 0013 M 11-1	14.5	16	16	13	9	14	7	150	32	1	–	GI085	Z11
	SIR 1416 N 16-0	14	16	22	17	11.4	14.5	7.5	160	–	0	–	GI022	Z9
	SIR 1416 N 16-1	14	16	22	17	11.4	14.5	7.5	160	–	1	–	GI022	Z9
	SIR 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.5	160	40	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	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	–	GI085	Z11
	SIL 0010 K 11-1	14.5	16	13	10	7.55	14	7	125	25	1	–	GI085	Z11
	SIL 0013 M 11-0	14.5	16	16	13	9	14	7	150	32	0	–	GI085	Z11
	SIL 0013 M 11-1	14.5	16	16	13	9	14	7	150	32	1	–	GI085	Z11
	SIL 1416 N 16-0	14	16	22	17	11.4	14.5	7.5	160	–	0	–	GI022	Z9
	SIL 1416 N 16-1	14	16	22	17	11.4	14.5	7.5	160	–	1	–	GI022	Z9
	SIL 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.5	160	40	2	✓	GI022	Z10
	SIL 1820 P 16	18.5	20	27	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	2	✓	GI076	Z14
	SIL 2532 S 22-A	30	32	36	32	21.65	25	12.5	250	–	–	–	GI076	Z13
	SIL 3240 T 22-A	38	40	48	40	25.85	32	16	300	–	–	–	GI076	Z13

GI022	TN 16NR..	TN 16NL..
GI076	TN 22NR..	TN 22NL..
GI085	TN 11NR..	TN 11NL..

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	481
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	–	FLAG T20	–	481
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

选择刀垫

螺旋角λ	正前角					负前角		于开槽刀片 TN16.. ... ZZ, TN22.. ... ZZ
	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	PE16ZZ
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	PI16ZZ
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	PE22ZZ
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	PI22ZZ
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*“.

螺纹
车削



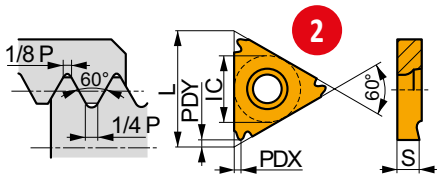
📖 6		WMG & ISO 13399
📖 10	ISO车削	说明
📖 18		导航工具
📖 57		正前角刀片
📖 219		负前角刀片
📖 386		切槽和切断
📖 482		**螺纹车削**
📖 528		内孔插槽
📖 536		通用技术信息

1 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

3



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]
4	5 15°		1 U E 6									
			10 TN M NR内孔，右手设计，适用于加工ISO公制螺纹，连续切削。									
TN 11NR050M	T8010	–	175	105	165	–	40	–	0.50	–	0.8	0.8
	T8030	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 7 75M	8	9	175	105	165	11	40	–	0.75	–	0.8	0.8
	T8030	–	160	95	150	480	40	–	0.75	–	0.8	0.8
TN 11NR100M	T8010	–	175	105	165	–	40	–	1.00	–	0.8	0.8
	T8030	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 11NR125M	T8010	–	175	105	165	–	40	–	1.25	–	0.8	0.8
	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
	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
	T8030	–	160	95	150	480	40	–	2.00	–	0.9	0.8
TN 16NR050M	T8010	–	175	105	165	–	40	–	0.50	–	0.8	0.8
	T8030	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 16NR075M	T8010	–	175	105	165	–	40	–	0.75	–	0.8	0.8
	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
	T8030	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16NR125M	T8010	–	175	105	165	–	40	–	1.25	–	0.8	0.8

TN 16NR075M:T8010 订购时请使用完整的刀片规格代码！

- 涂层
- 包括冒号
- ISO刀片代码

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
8	涂层
9	刀尖半径 (mm)
10	槽型说明
11	刀片应用领域

1 **SI(RL)**

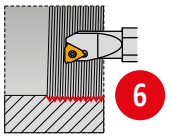
P M K N S H 2

PRAMET 3 S


4

内孔螺纹用螺丝夹紧式车刀杆，使用TN11、16或22刀片。
左/右手螺钉锁定镗杆，内螺纹加工，使用TN11、16或22NR/NL刀片。适用于公制或英制螺纹。最小内径Ø13mm。也适用于浅槽。可提供Ø16至Ø40mm的刀柄。刀杆经过处理，使用寿命更长。

5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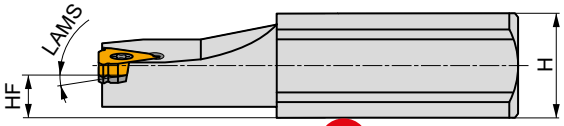

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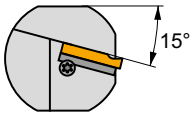
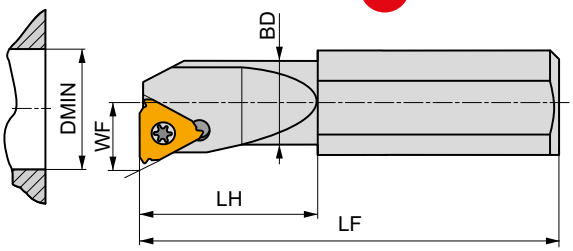
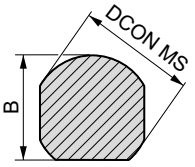
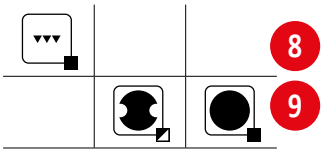







8 9


10

	Product	B [mm]	DCON MS [mm]	DMIN [mm]	BD [mm]	WF [mm]	H [mm]	HF [mm]	LF [mm]	LH [mm]	LAMS [°]	14	15	16
11 12 13 R	**SIR 0010 K 11-0**	14.5	16	13	10	7.45	14	7	125	25	0	–	GI085	Z11
	SIR 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25	1	–	GI085	Z11
	SIR 0013 M 11-0	14.5	16	16	13	9	14	7	150	32	0	–	GI085	Z11
	SIR 0013	14.5	16	16		9	14	7	150	32	1	–	GI085	Z11
	SIR 1416 N 16-0	14	16	22	17	11.4	14.5	7.5	160	–	0	–	GI022	Z9
	SIR 1416 N 16-1	14	16	22	17	11.4	14.5	7.5	160	–	1	–	GI022	Z9
	SIR 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.5	160	40	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	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

	17	
GI022	TN 16NR..	TN 16NL..
GI076	TN 22NR..	TN 22NL..
GI085	TN 11NR..	TN 11NL..

		Nm			18				
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

本页所示为车刀杆的典型页面–具体页面细节会有所不同。

图号	描述
1	螺纹车削刀杆的规格
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

图号	描述
10	产品应用
11	刀具设计
12	刀杆的ISO代码
13	刀杆的尺寸[mm]和角度[2] [°]
14	内冷式
15	兼容刀片组 [3]
16	备件组[3]、[4]
17	兼容刀片
18	备件

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.

螺纹车削 – 图标概览

通用图标

■	主要使用
◩	可以使用

▼▼▼	精加工 – 极佳的表面质量
▼▼	中等精度加工 – 良好的表面质量
▼	粗加工 – 无限制的表面粗糙度

●	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

	螺纹车削 - 外螺纹

	螺纹车削 - 内螺纹

涂层

	首选
	适用于韧性材料（长切屑）

	应用广泛的多用途选项
	刃口圆弧倒棱

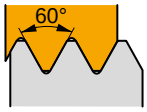
	锐利刃口

其他

	螺钉的夹紧力矩 [Nm]

	内冷供应

M
全牙型

TN M EXT NEW


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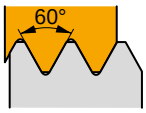

497

M
非全牙型

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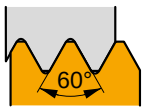

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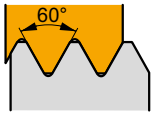

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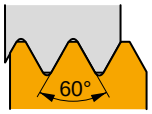

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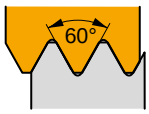

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MJ
全牙型

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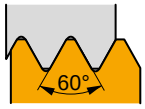

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UN
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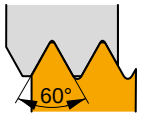

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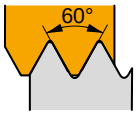

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UNJ
全牙型

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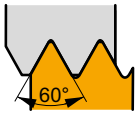

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W
全牙型

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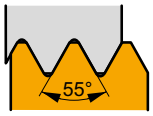

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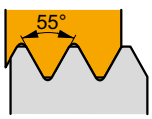

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W
非全牙型

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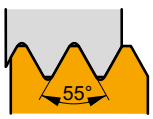

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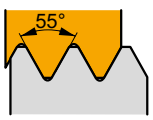

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BSPT
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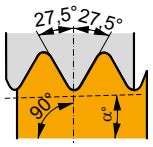

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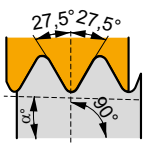

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NPT
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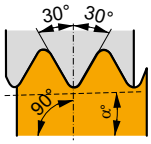

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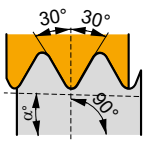

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TR
全牙型

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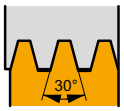

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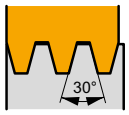

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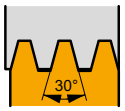

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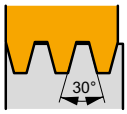

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ACME
全牙型

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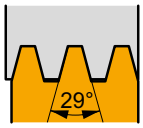

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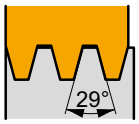

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STACME
全牙型

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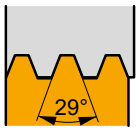

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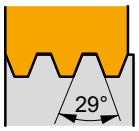

518

API RD
全牙型

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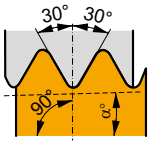

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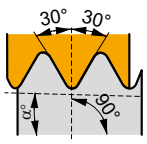

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RD
全牙型

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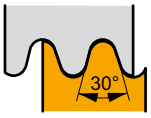

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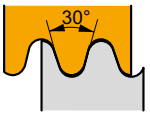


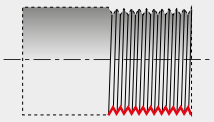
520

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
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 H15 - H25	■ ■ ■ ◪ ◪ ◪				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。
HF7	M10 - M20 K10 - K25 N10 - N25	◪ ■ ■				×		submicron H	+ +	无涂层材质，主要用于加工有色金属；也可用于其他加工材料（钢除外）。该材料可用于切削、铣削甚至钻孔。

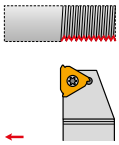
基体	
submicron H	细颗粒度（< 1µm）WC-Co基体

涂层	
PVD	低温物理气相沉积涂层

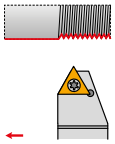
ISO螺纹车削 - 外螺纹



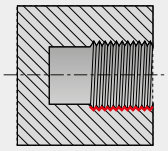
SE(RL)

	TN..
	16 22
■ 20×20 32×25	
522	459 – 521

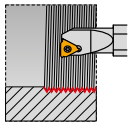
SE(RL)-S

	TN..
	22
■ 25×25 32×25	
523	459 – 521

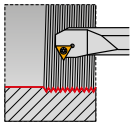
ISO螺纹车削 - 内螺纹



SI(RL)

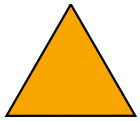
	TN..
	11 16 22
ØDmin 13 48	
524	459 – 521

SI(RL)-S

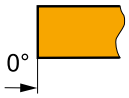
	TN..
	22
ØDmin 39 48	
526	459 – 521

	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

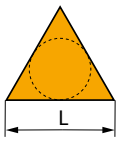
1 ISO代码 - 刀片

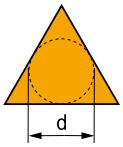
T	

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"

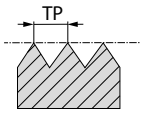
4 外圆 - 内孔

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

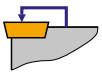
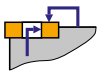
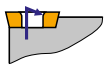
M	公制螺纹60°	TR	TR 30° ISO 2901/3–1977
MJ	SEA MA1370	UN	美制螺纹60° ISO 5864–1978
W	惠式螺纹55° ISO 228–1982	UNJ	SEA AS8879
RD	圆齿螺纹30°	ACME	ACME螺纹29° ANSI B1.5–1988
BSPT	ISO 228/1 35 21 1959 ISO 7/1	STACME	ASME/ANSI B1.8-1988
NPT	ANSI B1.1–1983	API RD	API

8 断屑槽类型

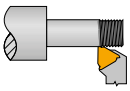
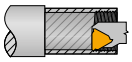
P1	压制
AL	用于有色金属

	1	2	3		4	5	6	7		8
ISO	**S**	**E**	**R**	–	**S**	**2525**	**M**	**16**	–	
ANSI	1	2	3		4	5	6	7		8
	S	E	R	–	S	16	D	16	–	

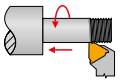
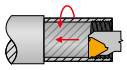
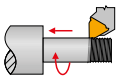
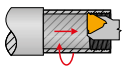
1 夹紧类型

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	

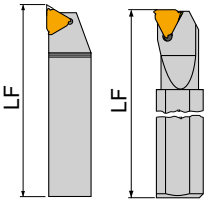
4 结构类型

–	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)



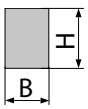
	LF (mm)
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300

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 (")



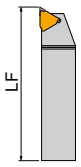
	B (")	H (")
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"

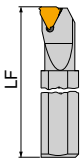


	DCON (")
08	.500"
10	.625"
12	.750"
16	1.000"
20	1.250"
24	1.500"

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"
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

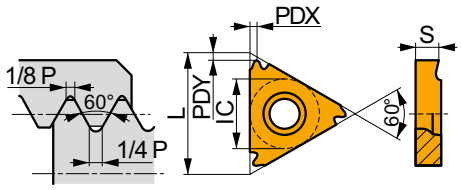
0	螺旋升角 λ = 0°
1	螺旋升角 λ = 1°
2	螺旋升角e λ = 2°

NEW

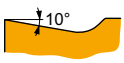
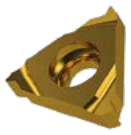
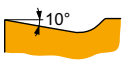
TN M EXT

PRAMET

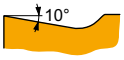
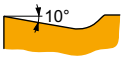
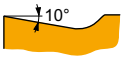
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



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。

产品型号		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
	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
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	0.75	–	0.8	0.8
TN 16ER080M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	0.80	–	0.6	0.8
	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
	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
	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
	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
	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
	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
	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
	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	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	3.50	–	2.5	1.8
	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
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	4.00	–	2.5	1.8
TN 22ER450M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	4.50	–	2.5	1.8
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	4.50	–	2.5	1.8
TN 22ER500M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	5.00	–	2.5	1.8
	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
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	1.00	–	0.8	0.8
TN 16EL125M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	1.25	–	0.8	0.8
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	1.25	–	0.8	0.8

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。

产品型号		RE	P		M		K		N		S		H		TP	TPI	PDX	PDY
			vc		vc		vc		vc		vc		vc					
		(mm)	(m/min)		(m/min)		(m/min)		(m/min)		(m/min)		(m/min)		(mm)		(mm)	(mm)
																		
TN M EL外圆，左手设计，适用于加工ISO公制螺纹，连续切削。																		
TN 16EL150M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	1.50	–	0.8	0.8
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	1.50	–	0.8	0.8
TN 16EL175M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	1.75	–	1.5	1.2
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	1.75	–	1.5	1.2
TN 16EL200M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	2.00	–	1.5	1.2
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	2.00	–	1.5	1.2
TN 16EL250M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	2.50	–	1.5	1.2
	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
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	3.00	–	1.5	1.2
TN 16EL350M	**T8030**[1)]	–	■	160	■	95	■	150	◪	480	◪	40		–	3.50	–	1.7	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
TN 22EL500M	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	5.00	–	2.5	1.8
																		
TN M-P1 ER压制外圆，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-AL ER外圆，右手设计，适用于加工ISO公制螺纹，连续切削。																		
TN 16ER050M-AL	**HF7**	–		–	◪	95		–	■	480		–		–	0.50	–	0.8	0.8
TN 16ER075M-AL	**HF7**	–		–	◪	95		–	■	480		–		–	0.75	–	0.8	0.8
TN 16ER080M-AL	**HF7**	–		–	◪	95		–	■	480		–		–	0.80	–	0.6	0.8
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 16ER175M-AL	**HF7**	–		–	◪	95		–	■	480		–		–	1.75	–	1.5	1.2
TN 16ER200M-AL	**HF7**	–		–	◪	95		–	■	480		–		–	2.00	–	1.5	1.2
TN 16ER250M-AL	**HF7**	–		–	◪	95		–	■	480		–		–	2.50	–	1.5	1.2
TN 16ER300M-AL	**HF7**	–		–	◪	95		–	■	480		–		–	3.00	–	1.5	1.2

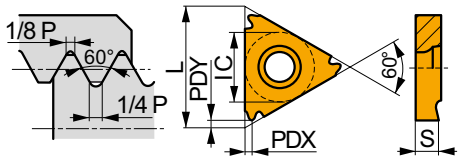
[1)] Toolholders have to be modified.

NEW

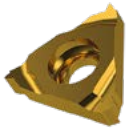
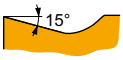
TN M INT

PRAMET

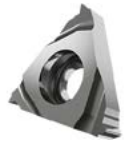
	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



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。

产品型号		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)
			1 Ü E															
TN M NR内孔，右手设计，适用于加工ISO公制螺纹，连续切削。																		
TN 11NR050M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	0.50	–	0.8	0.8
	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
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	0.75	–	0.8	0.8
TN 11NR100M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	1.00	–	0.8	0.8
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	1.00	–	0.8	0.8
TN 11NR125M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	1.25	–	0.8	0.8
	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
	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
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	2.00	–	0.9	0.8
TN 16NR050M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	0.50	–	0.8	0.8
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	0.50	–	0.8	0.8
TN 16NR075M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	0.75	–	0.8	0.8
	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
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	1.00	–	0.8	0.8
TN 16NR125M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	1.25	–	0.8	0.8
	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
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	1.50	–	0.8	0.8
TN 16NR175M	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	1.75	–	1.5	1.2
	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
	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
	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
	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	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	3.50	–	2.5	1.8
	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
	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
	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
	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。

产品型号		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	vc (m/min)	(mm)		(mm)	(mm)
												
TN M NL内孔，左手设计，适用于加工ISO公制螺纹，连续切削。												
TN 11NL050M	T8030	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 11NL075M	T8030	–	160	95	150	480	40	–	0.75	–	0.8	0.8
TN 11NL100M	T8030	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 11NL125M	T8030	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 11NL150M	T8010	–	175	105	165	–	40	–	1.50	–	0.8	0.8
	T8030	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 11NL200M	T8010	–	175	105	165	–	40	–	2.00	–	0.9	0.8
	T8030	–	160	95	150	480	40	–	2.00	–	0.9	0.8
TN 16NL050M	T8030	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 16NL075M	T8030	–	160	95	150	480	40	–	0.75	–	0.8	0.8
TN 16NL100M	T8010	–	175	105	165	–	40	–	1.00	–	0.8	0.8
	T8030	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16NL125M	T8010	–	175	105	165	–	40	–	1.25	–	0.8	0.8
	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
	T8030	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16NL175M	T8010	–	175	105	165	–	40	–	1.75	–	1.5	1.2
	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
	T8030	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16NL250M	T8010	–	175	105	165	–	40	–	2.50	–	1.5	1.2
	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
	T8030	–	160	95	150	480	40	–	3.00	–	1.5	1.2
TN 16NL350M	T8030[1)]	–	160	95	150	480	40	–	3.50	–	1.6	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
TN 22NL500M	T8030	–	160	95	150	480	40	–	5.00	–	2.5	1.8
												
TN M-P1 NR压制内孔，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 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 M-AL NR内孔，右手设计，适用于加工ISO公制螺纹，连续切削。												
TN 16NR050M-AL	HF7	–	–	95	–	480	–	–	0.50	–	0.8	0.8
TN 16NR075M-AL	HF7	–	–	95	–	480	–	–	0.75	–	0.8	0.8
TN 16NR100M-AL	HF7	–	–	95	–	480	–	–	1.00	–	0.8	0.8
TN 16NR125M-AL	HF7	–	–	95	–	480	–	–	1.25	–	0.8	0.8
TN 16NR150M-AL	HF7	–	–	95	–	480	–	–	1.50	–	0.8	0.8
TN 16NR175M-AL	HF7	–	–	95	–	480	–	–	1.75	–	1.5	1.2
TN 16NR200M-AL	HF7	–	–	95	–	480	–	–	2.00	–	1.5	1.2
TN 16NR250M-AL	HF7	–	–	95	–	480	–	–	2.50	–	1.5	1.2
TN 16NR300M-AL	HF7	–	–	95	–	480	–	–	3.00	–	1.5	1.2

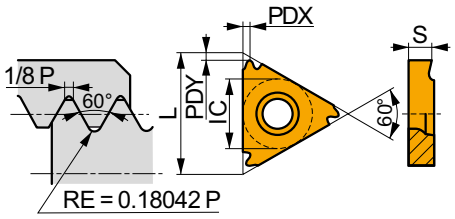
[1)] Toolholders have to be modified.

NEW

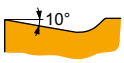
TN MJ EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



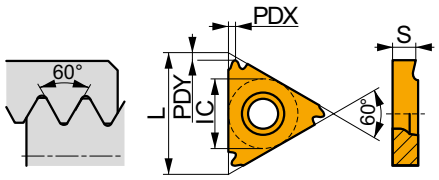
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
			1 U E									
			TN MJ ER外圆，右手设计，适用于加工“ J型”公制螺纹，连续切削。									
TN 16ER100MJ	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	1.00	–	0.8	0.8
TN 16ER150MJ	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	1.50	–	0.8	0.8

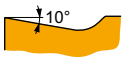
TN 60° PP EXT

PRAMET

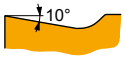
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



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。

产品型号		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)
			1 U E											
			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	**T8010**	–	■ 175	◪ 105	■ 165	–	◪ 40	–	0.50	1.50	16	48	0.8	0.6
	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
	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
	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
	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	3.50	5.00	5	7	2.5	1.8

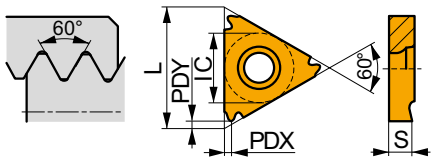
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 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
	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

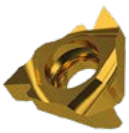
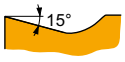
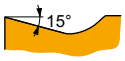
TN 60° PP INT

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



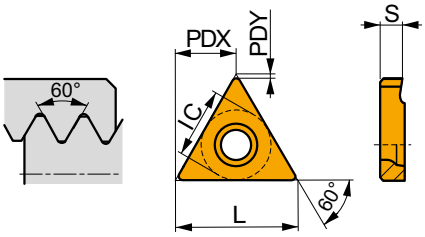
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	0.50	1.50	16	48	0.8	0.7
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	0.50	1.50	16	48	0.8	0.7
TN 16NRA60	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	0.50	1.50	16	48	0.8	0.7
	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
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	0.50	3.00	8	48	1.5	1.1
TN 16NRG60	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	1.75	3.00	8	14	1.5	1.1
	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
	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 16NLA60	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	0.50	1.50	16	48	0.8	0.7
TN 16NLAG60	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	0.50	3.00	8	48	1.5	1.1
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	0.50	3.00	8	48	1.5	1.1
TN 16NLG60	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	1.75	3.00	8	14	1.5	1.1
TN 22NLN60	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	3.50	5.00	5	7	2.5	1.8

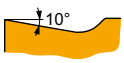
TN 60°-S PP EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



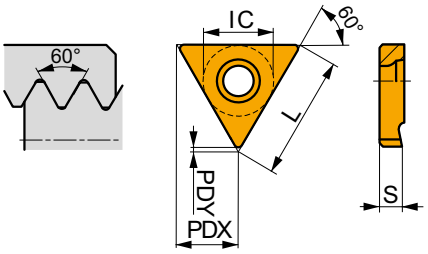
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
			1 Ü E											
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 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

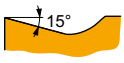
TN 60°-S PP INT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60

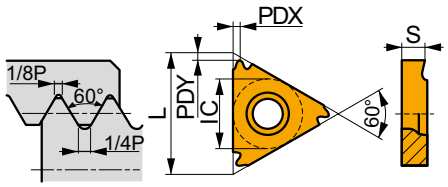


线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

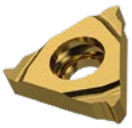
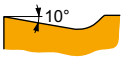
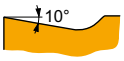
产品型号		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
			1 Ü E											
TN M60-S PP NN内孔，左手和右手设计，适用于加工公制和美标螺纹，连续切削。														
TN 22NN350-500M	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	3.50	5.00	5	7	11.0	0.2
TN 22NN550-800M	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	5.50	8.00	3	4.5	11.0	0.5

TN UN EXT

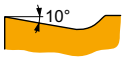
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



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。

产品型号		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 ER外圆，右手设计，适用于加工美标螺纹，连续切削。												
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
	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 16ER115UN	T8030	–	160	95	150	480	40	–	–	11.5	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
TN 22ER050UN	T8030	–	160	95	150	480	40	–	–	5.0	2.5	1.8
												
TN UN EL外圆，左手设计，适用于加工美标螺纹，连续切削。												
TN 16EL320UN	T8030	–	160	95	150	480	40	–	–	32.0	0.8	0.8
TN 16EL280UN	T8030	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16EL240UN	T8030	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16EL200UN	T8030	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16EL180UN	T8030	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16EL160UN	T8030	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16EL140UN	T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16EL120UN	T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16EL110UN	T8030	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16EL100UN	T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16EL090UN	T8030	–	160	95	150	480	40	–	–	9.0	1.5	1.2
TN 16EL080UN	T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22EL070UN	T8030	–	160	95	150	480	40	–	–	7.0	2.5	1.8
TN 22EL060UN	T8030	–	160	95	150	480	40	–	–	6.0	2.5	1.8
TN 22EL050UN	T8030	–	160	95	150	480	40	–	–	5.0	2.5	1.8

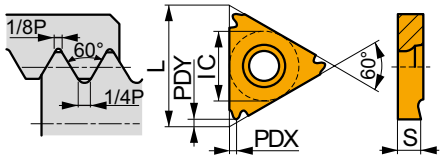
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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压制外圆，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 16ER080UN-P1	**T8030**	–	160	95	150	480	40	–	–	8.0	1.5	1.2

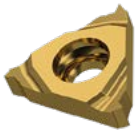
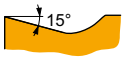
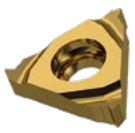
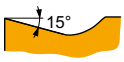
TN UN INT

PRAMET

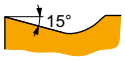
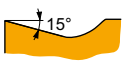
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



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。

产品型号		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 NR内孔，右手设计，适用于加工美标螺纹，连续切削。												
TN 16NR320UN	**T8030**	–	160	95	150	480	40	–	–	32.0	0.8	0.8
TN 16NR280UN	**T8030**	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16NR240UN	**T8030**	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16NR200UN	**T8010**	–	175	105	165	–	40	–	–	20.0	0.8	0.8
	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 16NR130UN	**T8030**	–	160	95	150	480	40	–	–	13.0	1.5	1.2
TN 16NR120UN	**T8010**	–	175	105	165	–	40	–	–	12.0	1.5	1.2
	T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NR115UN	**T8030**	–	160	95	150	480	40	–	–	11.5	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	**T8010**	–	175	105	165	–	40	–	–	8.0	1.5	1.2
	T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22NR070UN	**T8030**	–	160	95	150	480	40	–	–	7.0	2.5	1.8
TN 22NR060UN	**T8030**	–	160	95	150	480	40	–	–	6.0	2.5	1.8
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 16NL320UN	**T8030**	–	160	95	150	480	40	–	–	32.0	0.8	0.8

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。

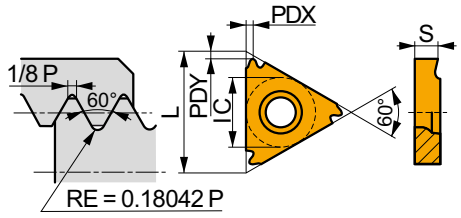
产品型号		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN UN NL内孔，左手设计，适用于加工美标螺纹，连续切削。												
TN 16NL280UN	T8030	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16NL240UN	T8030	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16NL200UN	T8030	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16NL180UN	T8030	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16NL160UN	T8030	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16NL140UN	T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NL120UN	T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NL110UN	T8030	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16NL100UN	T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NL080UN	T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22NL070UN	T8030	–	160	95	150	480	40	–	–	7.0	2.5	1.8
TN 22NL060UN	T8030	–	160	95	150	480	40	–	–	6.0	2.5	1.8
												
TN UN-P1 NR压制内孔，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 16NR080UN-P1	T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2

NEW

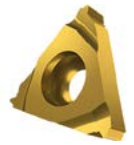
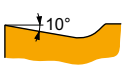
TN UNJ EXT

PRAMET

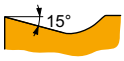
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



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。

产品型号		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 UNJ ER外圆，右手设计，适用于加工美标“ J型”螺纹，连续切削。												
TN 16ER320UNJ	T8030	–	160	95	150	480	40	–	–	32.0	0.8	0.8
TN 16ER280UNJ	T8030	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16ER240UNJ	T8030	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16ER200UNJ	T8030	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16ER180UNJ	T8030	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16ER160UNJ	T8030	–	160	95	150	480	40	–	–	16.0	1.5	1.2
TN 16ER120UNJ	T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2

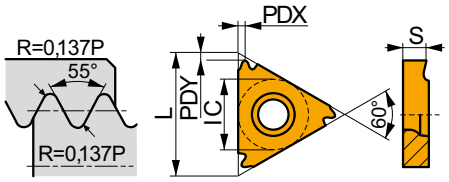
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 UNJ EL外圆，左手设计，适用于加工美标“ J型”螺纹，连续切削。									
TN 16EL320UNJ	**T8030**	–	160	95	150	480	40	–	–	32.0	0.8	0.8
TN 16EL280UNJ	**T8030**	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16EL240UNJ	**T8030**	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16EL200UNJ	**T8030**	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16EL180UNJ	**T8030**	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16EL160UNJ	**T8030**	–	160	95	150	480	40	–	–	16.0	1.5	1.2
TN 16EL120UNJ	**T8030**	–	160	95	150	480	40	–	–	12.0	1.5	1.2

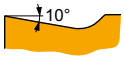
TN W EXT

PRAMET

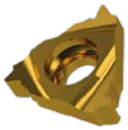
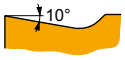
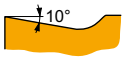
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



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。

产品型号		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 16ER260W	**T8030**	–	160	95	150	480	40	–	–	26.0	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
	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	**T8010**	–	175	105	165	–	40	–	–	14.0	1.5	1.2
	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
	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 16ER090W	**T8030**	–	160	95	150	480	40	–	–	9.0	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

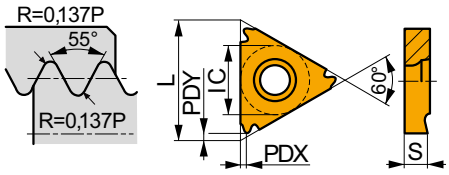
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 EL外圆，左手设计，适用于加工惠氏螺纹，连续切削。															
TN 16EL280W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	28.0	0.8	0.8
TN 16EL260W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	26.0	0.8	0.8
TN 16EL240W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	24.0	0.8	0.8
TN 16EL200W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	20.0	0.8	0.8
TN 16EL190W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	19.0	0.8	0.8
TN 16EL160W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	16.0	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 16EL090W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	9.0	1.5	1.2
TN 16EL080W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	8.0	1.5	1.2
TN 22EL070W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	7.0	2.5	1.8
TN 22EL060W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	6.0	2.5	1.8
TN 22EL050W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	5.0	2.5	1.7
																		
			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

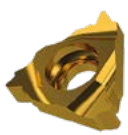
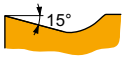
TN W INT

PRAMET

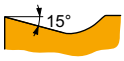
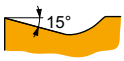
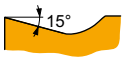
	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



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。

产品型号		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	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	–	19.0	0.8	0.8
	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
	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 16NR260W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	26.0	0.8	0.8
TN 16NR240W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	24.0	0.8	0.8
TN 16NR200W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	20.0	0.8	0.8

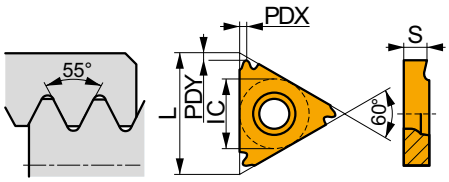
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 16NR190W	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	–	19.0	0.8	0.8
	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
	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
	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 22NR070W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	7.0	2.5	1.8
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 11NL190W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	19.0	0.8	0.8
TN 11NL140W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	14.0	0.9	0.7
TN 16NL280W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	28.0	0.8	0.8
TN 16NL260W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	26.0	0.8	0.8
TN 16NL240W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	24.0	0.8	0.8
TN 16NL200W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	20.0	0.8	0.8
TN 16NL190W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	19.0	0.8	0.8
TN 16NL160W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	16.0	0.8	0.8
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 16NL090W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	9.0	1.5	1.2
TN 16NL080W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	8.0	1.5	1.2
TN 22NL070W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	7.0	2.5	1.8
TN 22NL060W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	6.0	2.5	1.8
TN 22NL050W	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	5.0	2.5	1.7
																		
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

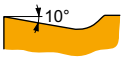
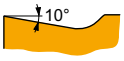
TN 55° PP EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71

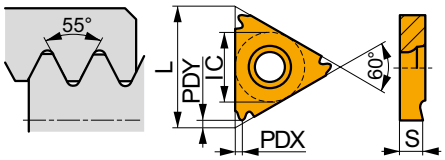


线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

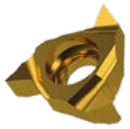
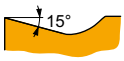
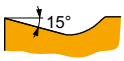
产品型号		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
			1 U E											
			TN W55 PP ER外圆，右手设计，适用于加工惠氏螺纹，连续切削。											
TN 16ERA55	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	1.50	16	48	0.8	0.6
TN 16ERAG55	**T8010**	–	■ 175	◪ 105	■ 165		–	◪ 40	–	0.50	3.00	8	48	1.5	1.1
	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
	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	3.50	5.00	5	7	2.5	1.8
														
			1 U E											
			TN W55 PP EL外圆，左手设计，适用于加工惠氏螺纹，连续切削。											
TN 16ELA55	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	0.50	1.50	16	48	0.8	0.6
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 55° PP INT

	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



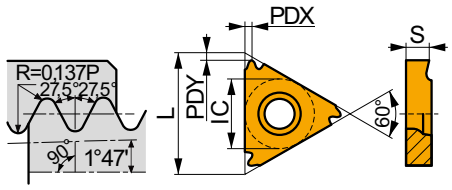
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 W55 PP NR内孔，右手设计，适用于加工惠氏螺纹，连续切削。																
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
	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 NL内孔，左手设计，适用于加工惠氏螺纹，连续切削。																
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 22NLN55	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40	–	3.50	5.00	5	7	2.5	1.8

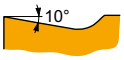
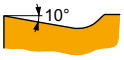
TN BSPT EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



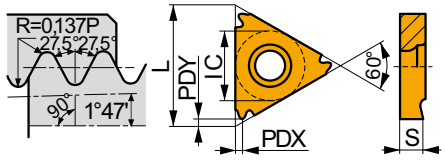
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
			1 U E									
TN BSPT ER外圆，右手设计，适用于加工BSPT螺纹，连续切削。												
TN 16ER280BSPT	**T8030**	–	160	95	150	480	40	–	–	28.0	0.8	0.8
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
			1 U E									
TN BSPT EL外圆，左手设计，适用于加工BSPT螺纹，连续切削。												
TN 16EL280BSPT	**T8030**	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16EL190BSPT	**T8030**	–	160	95	150	480	40	–	–	19.0	1.5	1.2
TN 16EL140BSPT	**T8030**	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16EL110BSPT	**T8030**	–	160	95	150	480	40	–	–	11.0	1.5	1.2

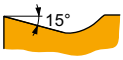
TN BSPT INT

PRAMET

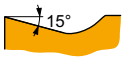
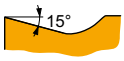
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



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。

产品型号		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)
			1 U E									
TN BSPT NR内孔，右手设计，适用于加工BSPT螺纹，连续切削。												
TN 16NR280BSPT	**T8030**	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16NR190BSPT	**T8030**	–	160	95	150	480	40	–	–	19.0	1.5	1.2

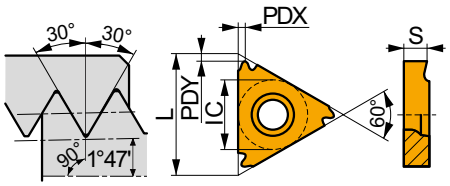
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 BSPT NL内孔，左手设计，适用于加工BSPT螺纹，连续切削。																		
TN 16NL280BSPT	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	28.0	0.8	0.8
TN 16NL190BSPT	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	19.0	1.5	1.2
TN 16NL140BSPT	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	14.0	1.5	1.2
TN 16NL110BSPT	**T8030**	–	■	160	■	95	■	150	◪	480	◪	40		–	–	11.0	1.5	1.2

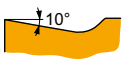
TN NPT EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



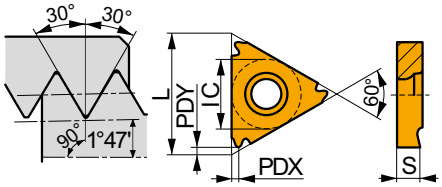
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 NPT ER外圆，右手设计，适用于加工NPT螺纹，连续切削。																		
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	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	–	14.0	1.5	1.1
	T8030	–	■	160	■	95	■	150	◪	480	◪	40		–	–	14.0	1.5	1.1
TN 16ER115NPT	**T8010**	–	■	175	◪	105	■	165		–	◪	40		–	–	11.5	1.5	1.1
	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

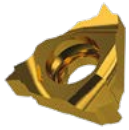
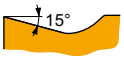
TN NPT INT

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



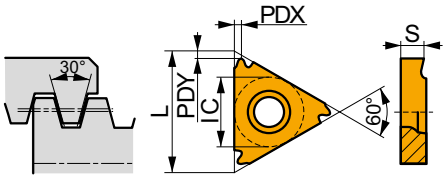
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
			1 U E									
TN NPT NR内孔，右手设计，适用于加工NPT螺纹，连续切削。												
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
	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
	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

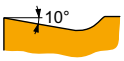
TN TR EXT

PRAMET

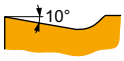
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



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。

产品型号		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)
			1 U E									
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

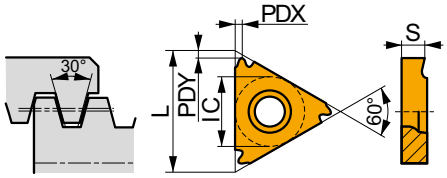
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
												
			1 U E									
			TN TR EL外圆，左手设计，适用于加工梯形螺纹，连续切削。									
TN 16EL150TR	**T8030**	–	160	95	150	480	40	–	1.50	–	0.8	0.9
TN 16EL200TR	**T8030**	–	160	95	150	480	40	–	2.00	–	1.5	1.3
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

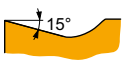
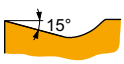
TN TR INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



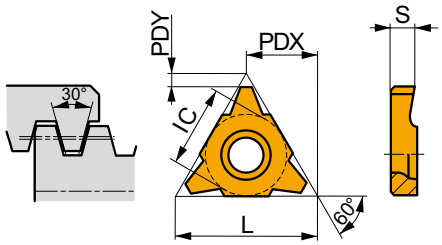
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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)
												
			1 U E									
			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
												
			1 U E									
			TN TR NL内孔，左手设计，适用于加工梯形螺纹，连续切削。									
TN 16NL150TR	**T8030**	–	160	95	150	480	40	–	1.50	–	0.8	0.9
TN 16NL200TR	**T8030**	–	160	95	150	480	40	–	2.00	–	1.5	1.3
TN 16NL300TR	**T8030**	–	160	95	150	480	40	–	3.00	–	1.6	1.3
TN 22NL400TR	**T8030**	–	160	95	150	480	40	–	4.00	–	2.2	1.8
TN 22NL500TR	**T8030**	–	160	95	150	480	40	–	5.00	–	2.2	1.8

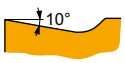
TN TR-S EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



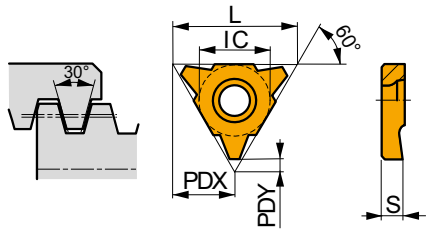
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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-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 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

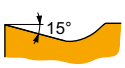
TN TR-S INT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



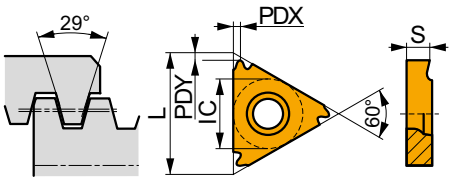
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 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 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

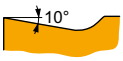
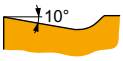
TN ACME EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



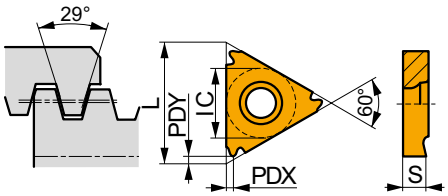
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 16ER120ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	12.0	1.5	1.3
TN 16ER100ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	10.0	1.5	1.3
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 EL外圆，左手设计，适用于加工ACME螺纹，连续切削。									
TN 16EL120ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	12.0	1.5	1.3
TN 16EL100ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	10.0	1.5	1.3
TN 16EL080ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	8.0	1.5	1.3
TN 22EL060ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	6.0	2.5	2.0
TN 22EL050ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	5.0	2.3	2.0

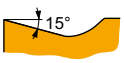
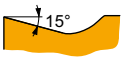
TN ACME INT

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。

产品型号		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 NR内孔，右手设计，适用于加工ACME螺纹，连续切削。									
TN 16NR120ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	12.0	1.5	1.3
TN 16NR100ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	10.0	1.5	1.3
TN 16NR080ACME	**T8030**[1)]	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	8.0	1.5	1.3
TN 22NR060ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	6.0	2.5	2.0
TN 22NR050ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	5.0	2.3	2.0
												
			TN ACME NL内孔，左手设计，适用于加工ACME螺纹，连续切削。									
TN 16NL120ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	12.0	1.5	1.3
TN 16NL100ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	10.0	1.5	1.3
TN 16NL080ACME	**T8030**[1)]	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	8.0	1.5	1.3
TN 22NL060ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	6.0	2.5	2.0
TN 22NL050ACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	5.0	2.3	2.0

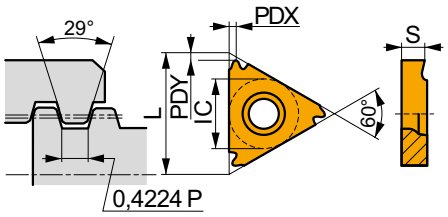
[1)] Toolholders have to be modified.

NEW

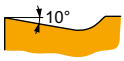
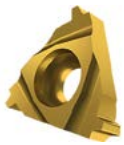
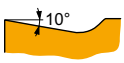
TN STACME EXT

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。

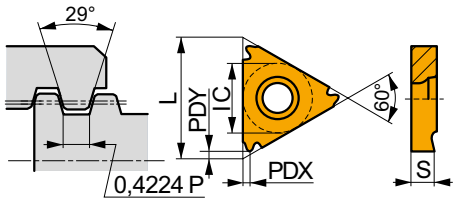
产品型号		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
			TN STACME ER右手外圆设计，适用于加工ACME短螺纹，连续切削。									
TN 16ER160STACME	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	16.0	0.8	0.8
TN 16ER120STACME	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	12.0	0.8	0.8
TN 16ER100STACME	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	10.0	1.5	1.3
TN 16ER080STACME	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	8.0	1.5	1.3
TN 16ER060STACME	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	6.0	1.4	1.3
												
			TN STACME EL外圆，左手设计，适用于加工ACME短螺纹，连续切削。									
TN 16EL160STACME	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	16.0	0.8	0.8
TN 16EL120STACME	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	12.0	0.8	0.8
TN 16EL100STACME	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	10.0	1.5	1.3
TN 16EL080STACME	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	8.0	1.5	1.3
TN 16EL060STACME	T8030	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	6.0	1.4	1.3

NEW

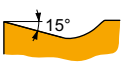
TN STACME INT

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。

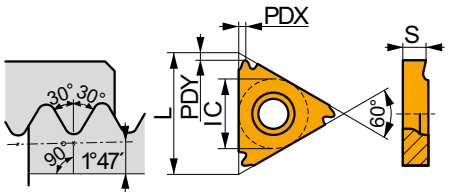
产品型号		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN STACME NR内孔，右手设计，适用于加工Stub ACMEE螺纹，连续切削。												
TN 16NR160STACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	16.0	0.8	0.8
TN 16NR120STACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	12.0	0.8	0.8
TN 16NR100STACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	10.0	1.5	1.3
TN 16NR080STACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	8.0	1.5	1.3
TN 16NR060STACME	**T8030**[1)]	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	6.0	1.3	1.3
												
TN STACME NL内孔，左手设计，适用于加工Stub ACME螺纹，连续切削。												
TN 16NL160STACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	16.0	0.8	0.8
TN 16NL120STACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	12.0	0.8	0.8
TN 16NL100STACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	10.0	1.5	1.3
TN 16NL080STACME	**T8030**	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	8.0	1.5	1.3
TN 16NL060STACME	**T8030**[1)]	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	6.0	1.3	1.3

[1)] Toolholders have to be modified.

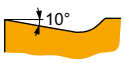
TN API RD EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



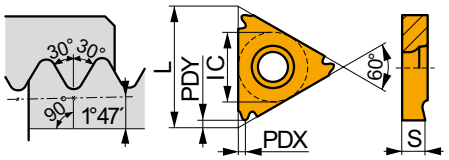
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 API ER外圆，右手设计，适用于加工API螺纹，连续切削。									
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

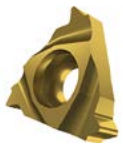
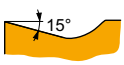
TN API RD INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



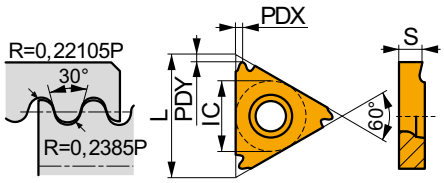
线速度(vc)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		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 API NR内孔，右手设计，适用于加工API螺纹，连续切削。									
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

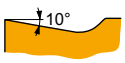
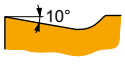
TN RD EXT

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。

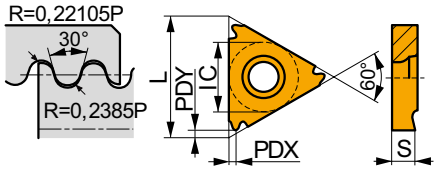
产品型号		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
			1 U E									
			TN RD ER外圆，右手设计，适用于加工公制圆螺纹，连续切削。									
TN 16ER100RD	**T8030**	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16ER080RD	**T8030**	–	160	95	150	480	40	–	–	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
												
			1 U E									
			TN RD EL外圆，左手设计，适用于加工公制圆螺纹，连续切削。									
TN 16EL100RD	**T8030**	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16EL080RD	**T8030**	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 16EL060RD	**T8030**[1)]	–	160	95	150	480	40	–	–	6.0	1.5	1.2
TN 22EL060RD	**T8030**	–	160	95	150	480	40	–	–	6.0	2.5	1.8

[1)] Toolholders have to be modified.

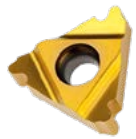
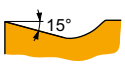
TN RD INT

PRAMET

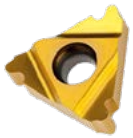
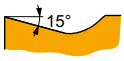
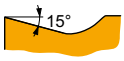
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



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。

产品型号		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)
												
			1 U E									
			TN RD NR内孔，右手设计，适用于加工公制圆螺纹，连续切削。									
TN 16NR100RD	**T8030**	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NR080RD	**T8030**	–	160	95	150	480	40	–	–	8.0	1.5	1.2

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。

产品型号		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 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 16NL100RD	**T8030**	–	■	160	■	95	■	150	◩	480	◩	40		–	–	10.0	1.5	1.2
TN 16NL080RD	**T8030**	–	■	160	■	95	■	150	◩	480	◩	40		–	–	8.0	1.5	1.2
TN 16NL060RD	**T8030**[1]	–	■	160	■	95	■	150	◩	480	◩	40		–	–	6.0	1.5	1.2
TN 22NL060RD	**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。

TN RD NL内孔，左手设计，适用于加工公制圆螺纹，连续切削。

[1] Toolholders have to be modified.

SE(RL)

P M K N S H

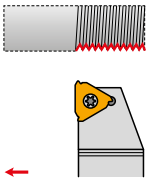
PRAMET

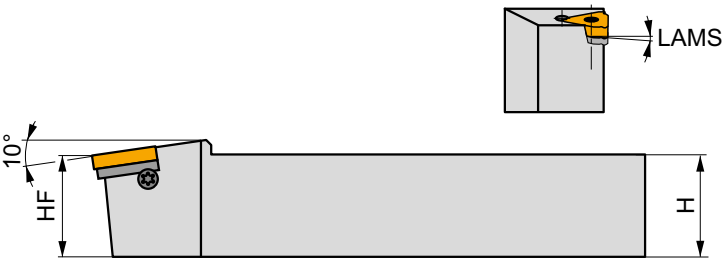
S

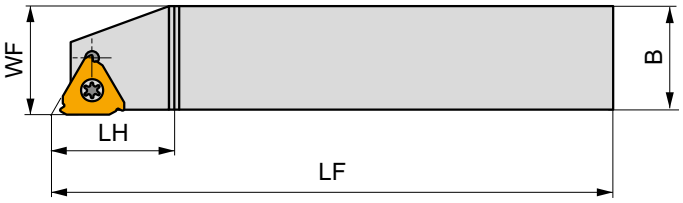


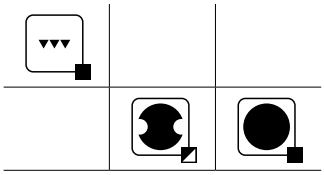
外圆螺纹用螺丝夹紧式车刀杆，使用TN16或22刀片。

左/右手螺丝锁车刀杆，外螺纹加工，使用TN16或22　ER/EL刀片。适用于公制或英制螺纹。也适用于浅槽。刀杆经过处理，使用寿命更长。











	产品型号	H (mm)	HF (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)		
R	**SER 2020 K 16**	20	20	20	20	125	22.5	–	GI068	Z12
	SER 2525 M 16	25	25	25	25	150	24	–	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	–	GI068	Z12
	SEL 3225 P 16	32	32	25	25	170	24.5	–	GI068	Z12
	SEL 2525 M 22-A	25	25	25	25	150	25.5	–	GI071	Z13
	SEL 3225 P 22-A	32	32	25	25	170	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	604
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	–	FLAG T20	–	604

SE(RL)-S

P M K N S H

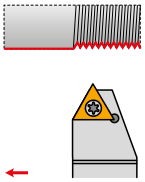
PRAMET

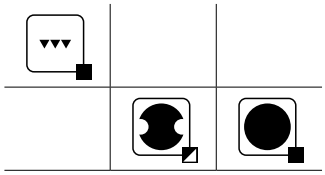
S

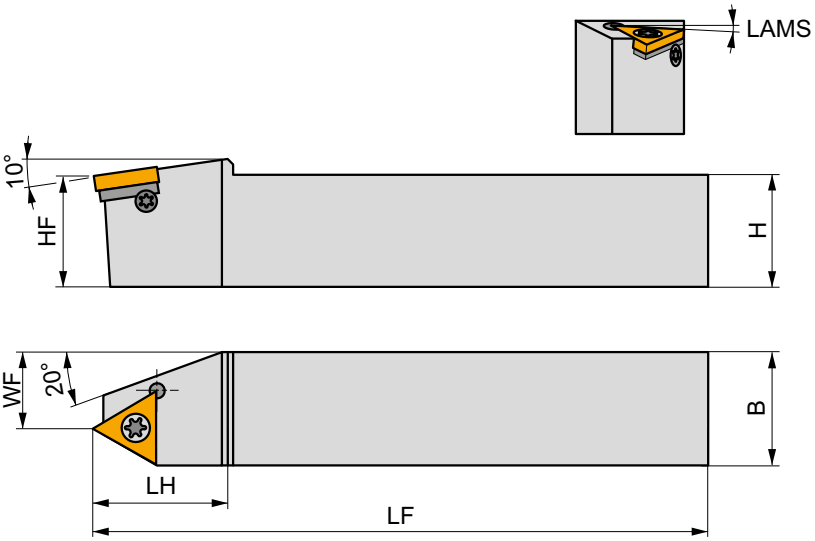


外圆螺纹用螺丝夹紧式车刀杆，使用TN22中等刀片。

左/右手螺钉锁定车刀杆，外圆用大螺纹加工，使用TN22EN刀片。适用于公制或英制螺纹。刀杆经过处理，使用寿命更长。









	产品型号	H (mm)	HF (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)		
R	**SER-S 2525 M 22-A**	25	25	25	14	150	30	–	GI086	Z15
	SER-S 3225 P 22-A	32	32	25	14	170	30	–	GI086	Z15
L	**SEL-S 2525 M 22-A**	25	25	25	14	150	30	–	GI086	Z15
	SEL-S 3225 P 22-A	32	32	25	14	170	30	–	GI086	Z15

GI086	TN 22EN..

Z15	US 4514A-T20	5.0 Nm	M 4.5	14	SP 0405	FLAG T20	604

SI(RL)

P M K N S H

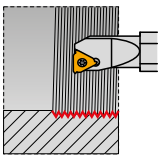
PRAMET

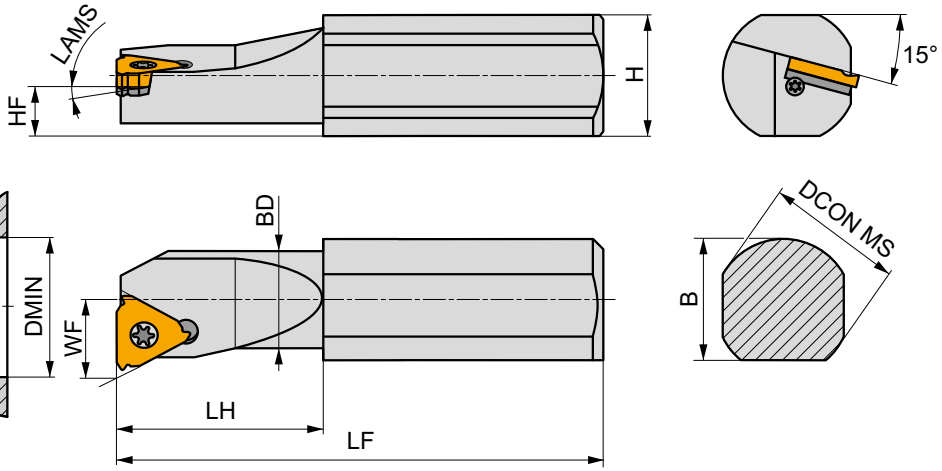
S

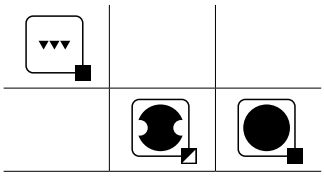


内孔螺纹用螺丝夹紧式车刀杆，使用TN11、16或22刀片。

左/右手螺钉锁定镗杆，内螺纹加工，使用TN11、16或22NR/NL刀片。适用于公制或英制螺纹。最小内径Ø13mm。也适用于浅槽。可提供Ø16至Ø40mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	B (mm)	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)			
R	SIR 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25	0	–	GI085	Z11
	SIR 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25	1	–	GI085	Z11
	SIR 0013 M 11-0	14.5	16	16	13	9	14	7	150	32	0	–	GI085	Z11
	SIR 0013 M 11-1	14.5	16	16	13	9	14	7	150	32	1	–	GI085	Z11
	SIR 1416 N 16-0	14	16	22	17	11.4	14.5	7.5	160	–	0	–	GI022	Z9
	SIR 1416 N 16-1	14	16	22	17	11.4	14.5	7.5	160	–	1	–	GI022	Z9
	SIR 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.5	160	40	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	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	–	GI085	Z11
	SIL 0010 K 11-1	14.5	16	13	10	7.55	14	7	125	25	1	–	GI085	Z11
	SIL 0013 M 11-0	14.5	16	16	13	9	14	7	150	32	0	–	GI085	Z11
	SIL 0013 M 11-1	14.5	16	16	13	9	14	7	150	32	1	–	GI085	Z11
	SIL 1416 N 16-0	14	16	22	17	11.4	14.5	7.5	160	–	0	–	GI022	Z9
	SIL 1416 N 16-1	14	16	22	17	11.4	14.5	7.5	160	–	1	–	GI022	Z9
	SIL 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.5	160	40	2	✓	GI022	Z10
	SIL 1820 P 16	18.5	20	27	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	2	✓	GI076	Z14
	SIL 2532 S 22-A	30	32	36	32	21.65	25	12.5	250	–	–	–	GI076	Z13
	SIL 3240 T 22-A	38	40	48	40	25.85	32	16	300	–	–	–	GI076	Z13

GI022	TN 16NR..	TN 16NL..
GI076	TN 22NR..	TN 22NL..
GI085	TN 11NR..	TN 11NL..

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	📖 604
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	–	FLAG T20	–	📖 604
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

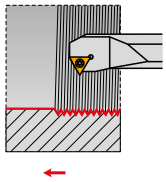
PRAMET

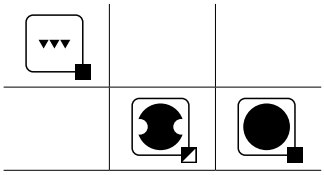
S

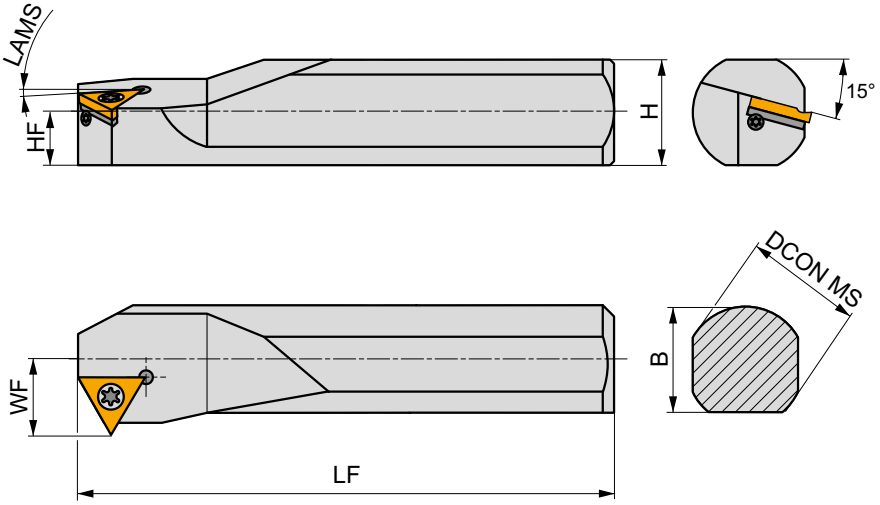


内孔螺纹用螺丝夹紧式车刀杆，使用TN22中等刀片。

左/右手螺钉锁定镗杆，内孔大螺纹加工，使用TN22NN刀片件。适用于公制或英制螺纹。最小加工内孔直径Ø39mm。可提供Ø32至Ø40mm的刀柄。刀杆经过处理，使用寿命更长。









	产品型号	B (mm)	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)		
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
L	**SIL-S 2532 S 22-A**	30	32	39	22.3	25	12.5	250	–	GI107	Z15
	SIL-S 3240 T 22-A	38	40	48	27	32	16	300	–	GI107	Z15

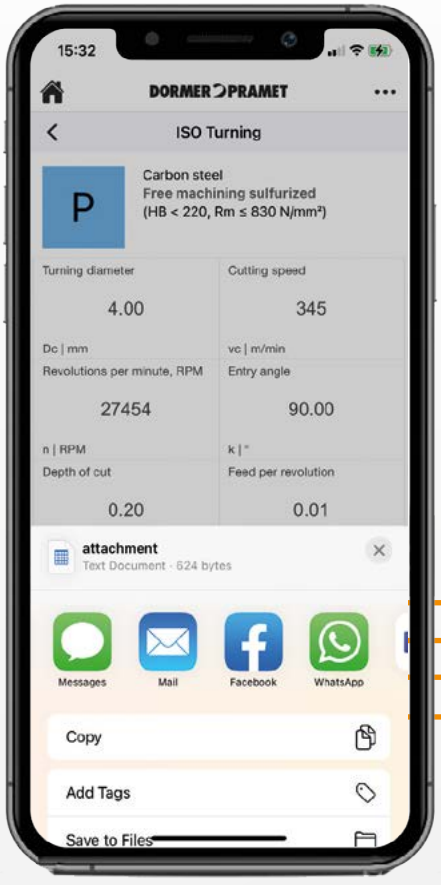
GI107	TN 22NN..

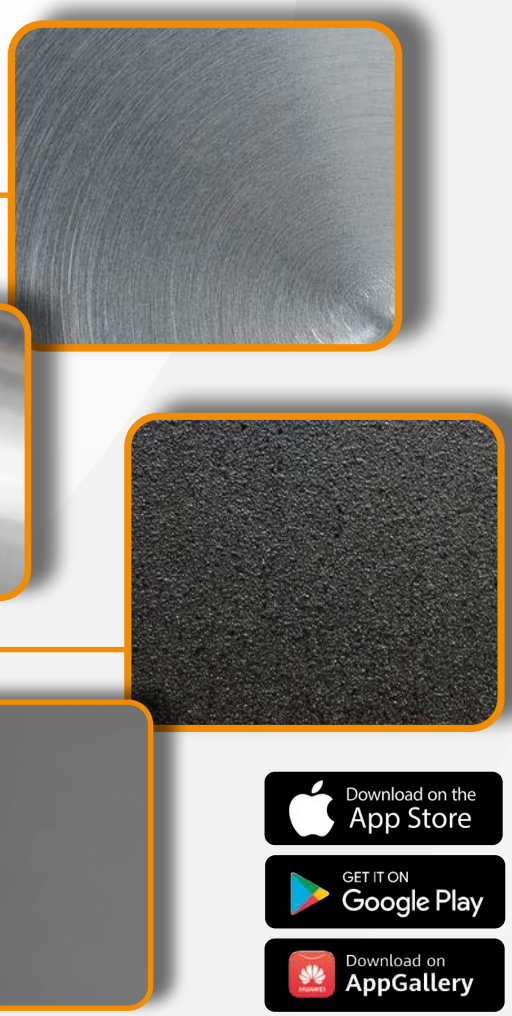
Z15	US 4514A-T20	5.0 Nm	M 4.5	14	SP 0405	FLAG T20	604

DORMER PRAMET

包含各种材料

我们的Calculator计算器应用程序涵盖所有材料，例如钢、不锈钢、铸铁、高温合金或有色金属等等。现在就去应用商店下载吧！ 简单可靠。





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内孔插槽



📖 6		WMG & ISO 13399
📖 10	ISO车削	说明
📖 18		导航工具
📖 57		正前角刀片
📖 219		负前角刀片
📖 386		切槽和切断
📖 482		螺纹车削
📖 528		内孔插槽
📖 536		通用技术信息

内孔插槽 – 图标概览

通用图标

■	主要使用	▼▼▼	精加工 – 极佳的表面质量	●	适用于稳定工况。
◪	可以使用	▼▼	中等精度加工 – 良好的表面质量	◖	适用于不稳定工况
		▼	粗加工 – 无限制的表面粗糙度	✱	适用于非常不稳定的工况

特点

	内部成形	U	应用广泛的多用途选项	F	锐利刃口

其他

Nm	螺钉的夹紧力矩 [Nm]		内冷式

内孔插槽刀片 – 导航工具

HZ



531

HZ-2



532

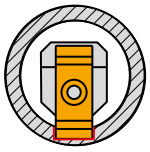
内孔插槽刀杆 – 导航工具

PHZ



	HZ
	03 04 05 06 08 10 12
Ø 9,5 Ø 24,7	
533	531

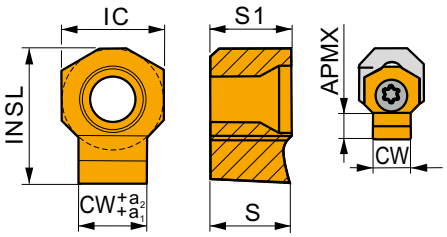
PHZ-2



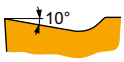
	HZ/2..
	14 16 18 20
Ø 44 Ø 58	
534	532

HZ

	IC	INSL	APMX	S	S1	CW
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)
0604-30	6.000	7.5	1.60	4.66	4.76	3.00
0604-40	6.000	8.0	2.50	4.66	4.76	4.00
0604-50	6.000	8.0	3.00	4.66	4.76	5.00
1006-60	10.000	13.5	4.20	6.25	6.35	6.00
1006-80	10.000	13.5	5.20	6.25	6.35	8.00
1309-100	13.000	18.5	6.20	9.40	9.53	10.00
1309-120	13.000	18.5	7.20	9.40	9.53	12.00



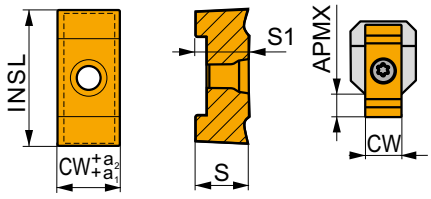
线速度(vc)和进给量(fz)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品型号		RE	P		M		K		N		S		H		CW	CWTOLL	CWTOLU
			vc	fz	vc	fz	vc	fz	vc	fz	vc	fz	vc	fz			
		(mm)	(m/min)	(mm/tooth)	(m/min)	(mm/tooth)	(m/min)	(mm/tooth)	(m/min)	(mm/tooth)	(m/min)	(mm/tooth)	(m/min)	(mm/tooth)	(mm)	(mm)	(mm)
			U	F													
			用于内孔插槽的正前角断屑槽（一个切削刃）。														
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	0.02
HZ 1006-80 P9	**333TN**	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	8.00	-0.05	-0.02
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	0.02
HZ 1309-100 P9	**333TN**	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	10.00	-0.05	-0.02
HZ 1309-120 C11	**333TN**	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	12.00	0.10	0.21
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

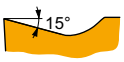
HZ-2

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。

产品型号		RE (mm)	P vc (m/min)	P fz (mm/tooth)	M vc (m/min)	M fz (mm/tooth)	K vc (m/min)	K fz (mm/tooth)	N vc (m/min)	N fz (mm/tooth)	S vc (m/min)	S fz (mm/tooth)	H vc (m/min)	H fz (mm/tooth)	CW (mm)	CWTOLL (mm)	CWTOLU (mm)
																	
			用于内孔插槽的正前角断屑槽（两个切削刃）。														
HZ/2 14-14 C11	**333TN**	–	50	0.10	30	0.09	45	0.10	–	–	–	–	–	–	14.00	0.10	0.21
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	0.21
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	0.21
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

PHZ

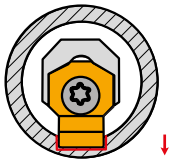
P M K N S H

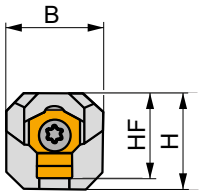
PRAMET

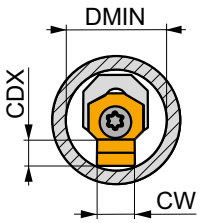
S

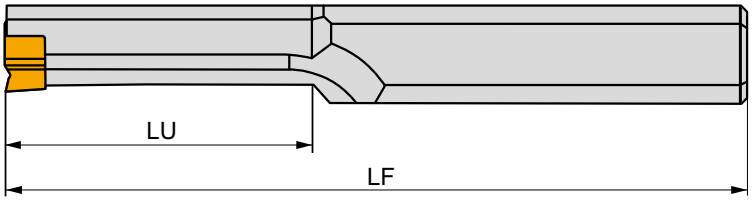


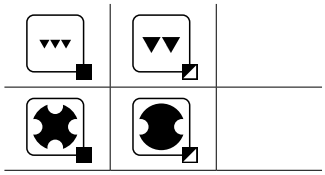
小直径内孔用插槽刀杆，使用单面HZ刀片。
内孔用车刀杆可插削最大12mm的宽度。最小孔径Ø9.5mm。刀杆经过处理，使用寿命更长。













	产品型号	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	0.17	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	–	–	–	0.19	GI240	SH21
	PHZ 1512-10	15.5	16.2	–	220	–	–	–	–	0.40	GI224	SH22
	PHZ 2014-13	20.6	21.5	–	250	–	–	–	–	0.65	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

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

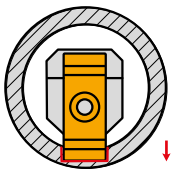
P M K N S H

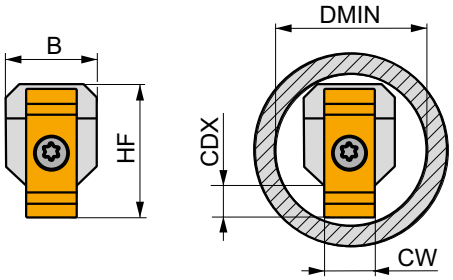
PRAMET

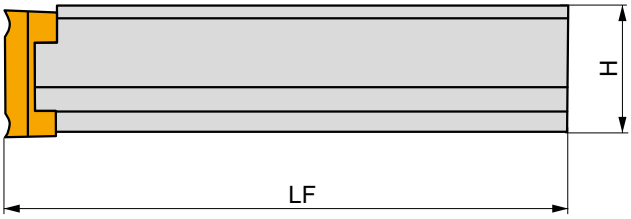
S

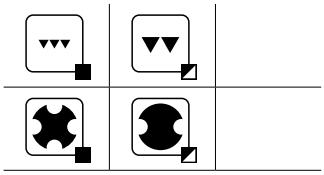


大直径内孔用插槽刀杆，使用双面HZ刀片。
内孔用刀具刀杆，可插削最大20mm的宽度。最小孔径Ø44mm。刀杆经过处理，使用寿命更长。











	产品型号	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	–	1.86	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

DORMER PRAMET

全天候支持

我们的技术支持团队随时随地帮助您解决技术问题，答复有关技术应用的咨询。请通过详细联络信息联系当地Dormer Pramet经销商。简单可靠。



通用
技术信息



📖 6		WMG & ISO 13399
📖 10	ISO车削	说明
📖 18		导航工具
📖 57		正前角刀片
📖 219		负前角刀片
📖 386		切槽和切断
📖 482		螺纹车削
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工件材料分组 (WMG)



关于DORMER PRAMET的工件材料分类

工件材料分组 (WMG) 用于支持简单和可靠地选择正确的切削刀具以及适合特定应用加工工况的初始值。
Dormer Pramet将工件材料分为六个不同的颜色组 ;

- 蓝色 : 钢和铸钢 (P组)
- 黄色 : 不锈钢 (M组)
- 红色 : 铸铁 (K组)
- 绿色 : 有色金属 (N组)
- 橙色 : 高温合金 (S组)
- 灰色 : 硬化材料 (H组)

上述各组再根据其结构和/或成分分为几个子组。例如 , P 组钢和铸钢分成四个子组 , 即 :

- P1 – 易切削钢
- P2 – 普通碳钢
- P3 – 合金钢
- P4 – 工具钢

最后 , 根据材料属性 (例如硬度和极限抗拉强度) 进行进一步分类。通过这种分类方式 , 可以为我们的客户提供一套完整的刀具推荐方案 , 包括线速度和进给量等初始值。
下页的表格中包含对每个工件材料分组的描述 , 以及适用于该分组的常用名称示例。

ISO组		子分组		WMG（加工材料组）		k_{vg}	材料示例（AISI、EN、DIN、ČSN、GB、SS、STN、BS、UNE、AFNOR、ASTM、GOST、UNS、UNI、...）
P	钢和铸钢（钢，合金含量 ≤ 10 %，硬度 < 45HRC）	P1	高速切削钢（可加工性更高的碳钢）	P1.1	易切削的硫化碳钢，硬度 < 240 HB	1.33	AISI **1108,** EN **15S22,** DIN **1.0723,** SS **1922,** ČSN **11120,** BS **210A15,** UNE **F.210F,** GB **Y15,** AFNOR **10F1,** GOST **A30,** UNI **CF10S20**
				P1.2	易切削的硫化和磷化碳钢，硬度 < 180HB	1.49	AISI **1211,** EN **11SMn30,** DIN **1.0715,** SS **1912,** ČSN **11109,** BS **230M7,** UNE **F.2111,** GB **Y15,** AFNOR **S250,** GOST **A40G,** UNI **CF9SMn28**
				P1.3	易切削的硫化/磷化和含铅碳钢，硬度 < 180HB	1.53	AISI **12L13,** EN **11SMnPb30,** DIN **1.0718,** SS **1914,** ČSN **12110,** BS **210M16,** UNE **F.2114,** GB **Y15Pb,** AFNOR **S250Pb,** GOST **AS35G2,** UNI **CF10SPb20**
		P2	普通碳钢（主要由铁和碳组成的钢）	P2.1	普通低碳钢，含 < 0.25%C，硬度 < 180 HB	1.14	AISI **1015,** EN **C15,** DIN **1.0401,** SS **1350,** ČSN **11301 ,** BS **080A15,** UNE **F.111,** GB **15,** AFNOR **C18RR,** GOST **St2ps,** UNI **Fe360**
				P2.2	普通中碳钢，含 < 0.55%C，硬度 < 240 HB	1.00	AISI **1030,** EN **C30,** DIN **1.0528,** SS **1550,** ČSN **12031,** BS **080M32,** UNE **F.1130,** GB **30,** AFNOR **AF50C30,** GOST **30G,** UNI **Fe590**
				P2.3	普通高碳钢，含 > 0.55%C，硬度 < 300 HB	0.89	AISI **1060,** EN **C60,** DIN **1.0601,** SS **1655,** ČSN **12061,** BS **080A62,** UNE **F513,** GB **60,** AFNOR **1C60,** GOST **60G,** UNI **C60**
		P3	合金钢（碳钢，合金含量 ≤ 10%）	P3.1	合金钢，硬度 < 180 HB	0.92	AISI **5015,** EN **16Mo3,** DIN **1.5415,** SS **2912,** ČSN **15020,** BS **1501-240,** UNE **F.2601,** GB **16Mo,** AFNOR **15D3,** GOST **15M,** UNI **16Mo3KW**
				P3.2	合金钢，硬度180 – 260 HB	0.74	AISI **4140,** EN **42CrMo4,** DIN **1.7225,** SS **2244,** ČSN **15142,** BS **708M40,** UNE **F.8232,** GB **42CrMo,** AFNOR **42CD4,** GOST **40ChFA,** UNI **42CrMo4**
				P3.3	合金钢，硬度260 – 360 HB	0.63	AISI **4140,** EN **42CrMo4,** DIN **1.7225,** SS **2244,** ČSN **15142,** BS **708M40,** UNE **F.8232,** GB **42CrMo,** AFNOR **42CD4,** GOST **40ChFA,** UNI **42CrMo4**
		P4	工具钢（特种合金钢，用于刀具、模具）	P4.1	工具钢，硬度 < 26 HRC	0.55	AISI **D2,** EN **X155CrVMo12-1,** DIN **1.2370,** SS **2736,** ČSN **19573,** BS **BD2,** UNE **F.520A,** GB **Cr12Mo1V1,** AFNOR **Z160CDV12,** GOST **Ch12MF,** UNI **X155CrVMo121KU**
				P4.2	工具钢，硬度26 – 39 HRC	0.47	AISI **D2,** EN **X155CrVMo12-1,** DIN **1.2370,** SS **2736,** ČSN **19573,** BS **BD2,** UNE **F.520A,** GB **Cr12Mo1V1,** AFNOR **Z160CDV12,** GOST **Ch12MF,** UNI **X155CrVMo121KU**
				P4.3	工具钢，硬度39 – 45 HRC	0.38	AISI **D2,** EN **X155CrVMo12-1,** DIN **1.2370,** SS **2736,** ČSN **19573,** BS **BD2,** UNE **F.520A,** GB **Cr12Mo1V1,** AFNOR **Z160CDV12,** GOST **Ch12MF,** UNI **X155CrVMo121KU**

ISO组		子分组		WMG（加工材料组）		k_{vG}	材料示例（AISI、EN、DIN、ČSN、GB、SS、STN、BS、UNE、AFNOR、ASTM、GOST、UNS、UNI、...）
M	不锈钢（耐腐蚀钢，铬含量 ≥ 11 %）	M1	铁素体不锈钢（直铬非淬透性合金）	M1.1	铁素体不锈钢，硬度 < 160 HB	1.22	AISI **S429,** EN **X7Cr14,** DIN **1.4001,** SS **2326,** BS **434S17,** UNE **F.3401,** AFNOR **Z8C12,** GOST **08Ch13,** UNI **X6CrTi12**
				M1.2	铁素体不锈钢，硬度160 – 220 HB	1.03	AISI **446,** EN **X10CrAl24,** DIN **1.4762,** SS **2322,** ČSN **17113,** BS **430S17,** UNE **F.3154,** GB **10Cr17,** AFNOR **Z10CAS24,** GOST **12Ch17,** UNI **X16Cr26**
		M2	马氏体不锈钢（直铬非淬透性合金）	M2.1	马氏体不锈钢，硬度 < 200 HB	1.08	AISI **430F,** EN **X14CrMoS17,** DIN **1.4104,** SS **2383,** ČSN **17140,** BS **410S21,** UNE **F.3117,** AFNOR **Z10CF17,** UNI **X10CrS17**
				M2.2	马氏体不锈钢，硬度200 – 280 HB	0.89	AISI **440C,** EN **X105CrMo17,** DIN **1.4125,** SS **2385,** ČSN **17023,** BS **425C11,** UNE **F.3402,** GB **102Cr17Mo,** AFNOR **Z100CD17,** GOST **95Ch18,** UNI **GX6CrNi 13 04**
				M2.3	马氏体不锈钢，硬度280 – 380 HB	0.75	AISI **420,** EN **X45Cr13,** DIN **1.4034,** ČSN **17029,** BS **425C11,** UNE **F.3405,** AFNOR **Z44C14,** GOST **20X17H12,** UNI **X30Cr13**
		M3	奥氏体不锈钢（铬镍和铬镍锰合金）	M3.1	奥氏体不锈钢，硬度 < 200 HB	1.00	AISI **304,** EN **X5CrNi18-12,** DIN **1.4303,** SS **2352,** ČSN **17249,** BS **305S17,** UNE **F.3513,** GB **10Cr18Ni12,** AFNOR **Z8CN18.12,** UNI **X7CrNi18 10**
				M3.2	奥氏体不锈钢，硬度200 – 260 HB	0.86	AISI **309,** EN **X15CrNiSi20-12,** DIN **1.4828,** ČSN **17251,** BS **309S24,** UNE **F.3312,** GB **1Cr23Ni13,** AFNOR **Z15CNS20.12,** GOST **20Ch20N14S2,** UNI **16CrNi23 14**
				M3.3	奥氏体不锈钢，硬度260 – 300 HB	0.77	AISI **5848,** EN **X45CrNiW18-9,** DIN **1.4873,** BS **331S40,** UNE **F.3211,** AFNOR **Z35CNWS14-4,** UNI **X45CrNiW 18 9**
		M4	超级奥氏体，双相或沉淀硬化不锈钢（奥氏体合金，含 > 20 % Ni，奥氏体-铁素体微结构或沉淀硬化）	M4.1	奥氏体-铁素体或高级奥氏体不锈钢，硬度 < 300 HB	0.75	AISI **329,** EN **X1-NiCrMoCU25-20-5,** DIN **1.4539,** SS **2562,** ČSN **17265,** BS **318S13,** UNE **F.3552,** GB **022Cr25NiMo2N,** AFNOR **Z1NCDU25.20**
				M4.2	沉淀硬化奥氏体不锈钢，硬度 300 – 380 HB	0.64	AISI **631 (17-7PH),** EN **X7CrNiAL17-7,** DIN **1.4568,** SS **2388,** ČSN **17465 ,** BS **301S13,** UNE **F.3217,** GB **07Cr17Ni7Al,** AFNOR **29CNA17-07,** GOST **09Ch17N7Ju1,** UNI **X53CrMnNiN21 9**

ISO组		子分组		WMG（加工材料组）		k_{vg}	材料示例（AISI、EN、DIN、ČSN、GB、SS、STN、BS、UNE、AFNOR、ASTM、GOST、UNS、UNI、...）
K	铸铁（铁和碳合金的铸件，碳含量 > 2 %）	K1	灰口铸铁（GG）（带片状石墨微观结构的铁碳铸件）	K1.1	铁素体或铁素体-珠光体灰口铸铁，硬度 < 180 HB	1.35	ASTM **A48 Grade 20 (F11401)**, EN-**JL-100**, DIN **GG-10 (0.6010)**, SS **0110**, STN **422410**, BS **Grade 150**, UNE **FG10**, GB **HAT 100**, AFNOR **Ft10D**, GOST **SC 10**, UNI **G10**
				K1.2	铁素体-珠光体或珠光体灰口铸铁，硬度 < 180 – 240 HB	1.00	ASTM **A48 Grade 30 (F12101)**, EN-**JL-1030**, DIN **GG-20 (0.6020)**, SS **0120**, STN **422420**, BS **Grade 220**, UNE **FG20**, GB **HT200**, AFNOR **Ft20D**, GOST **СЧ20**, UNI **G20**
				K1.3	珠光体灰口铸铁，硬度240 – 280 HB	0.75	ASTM **A48 Grade 50 (F13501)**, EN-**JL-1060**, DIN **GG-35 (0.6035)**, SS **0135**, STN **422435**, BS **Grade 350**, UNE **FG35**, GB **HAT300**, AFNOR **Ft35D**, GOST **SC35**, UNI **G35**
		K2	可锻铸铁（GTS/GTW）（经过热处理的具有无石墨微结构的铁碳铸件）	K2.1	铁素体可锻铸铁，硬度 < 160 HB	1.39	ASTM **A602 Grade M3210 (F20000)**, EN-**JM-1130**, DIN **GTS-35 (0.8135)**, SS **0815**, BS **B340/12**, UNE **Type A**, AFNOR **MN 35-10**, GOST **КЧ35-10**
				K2.2	铁素体或珠光体可锻铸铁，硬度160 – 200 HB	1.13	ASTM **A602 Grade M4504 (F20001)**, EN-**JM-1040**, DIN **GTS-50-05 (0.8045)**, BS **P50-05**, AFNOR **MB 45-7**
				K2.3	珠光体可锻铸铁，硬度200 – 240 HB	0.90	ASTM **A602 Grade M7002 (F20004)**, EN-**JM-1140**, DIN **GTS-45 (0.8145)**, SS **0854**, STN **422540**, BS **P 45-06**, UNE **Typ B**, AFNOR **MP 50-5**, GOST **КЧ45-7**, UNI **GMN 45**
		K3	延性铸铁（GGG）（具有韧性石墨微结构的铁碳铸件）	K3.1	铁素体延性（韧性/球墨）铸铁，硬度 < 180 HB	1.23	ASTM **A536 Grade 60-40-18 (F32800)**, EN-**JS-1030**, DIN **GGG-40 (0.7040)**, SS **0717**, STN **422304**, BS **420/12**, UNE **FGE 42-12**, GB **QT 400**, AFNOR **FGS 400-12**, GOST **ВЧ40**
				K3.2	铁素体或珠光体延性（韧性/球墨）铸铁，硬度180 – 220 HB	0.94	ASTM **A536 Grade 80-55-06 (F33800)**, EN-**JS-1050**, DIN **GGG-50 (0.7050)**, SS **0727**, STN **422305**, BS **500/7**, UNE **FGE 50-7**, GB **QT 500-7**, AFNOR **FGS 500-7**, GOST **ВЧ50**
				K3.3	珠光体延性（韧性/球墨）铸铁，硬度220 – 260 HB	0.76	ASTM **A536 Grade 100-70-03 (F34800)**, EN-**JS-1060**, DIN **GGG-60 (0.7060)**, SS **0732**, STN **422306**, BS **600/3**, UNE **FG70-2**, GB **QT 600-3**, AFNOR **FGS 600-3**, GOST **ВЧ60**
		K4	奥氏体或等温淬火延性铸铁（Ni-Resist/ADI）（带奥氏体或奥铁体微结构的铁碳合金铸件）	K4.1	奥氏体铸铁，硬度 < 180 HB	1.14	ASTM **A436 Type 1 (L-NiCuCr 15 6 2, F41000)**, EN-**JL-3011**, DIN **GGL-NiMn 13 7 (0.6652)**, SS **0523**, BS **Grade F1**, AFNOR **FGL-Ni13Mn7**, GOST **S-NiMn 13 7**
				K4.2	奥氏体铸铁，硬度180 – 240 HB	0.86	ASTM **A439 Type D-2B (S-NiCr 20 3, F43001)**, EN-**JS-3021**, DIN **GGG-NiMn 23 4**, SS **0776**, BS **Grade S2M**, AFNOR **FGS Ni23 Mn4**, GOST **ЧН19Х3Ш**
				K4.3	等温淬火延性铸铁，硬度240 – 280 HB	0.63	ASTM **A897 Grade 110-70-11**
				K4.4	等温淬火延性铸铁，硬度280 – 320 HB	0.54	ASTM **A897 Grade 125-80-10**, EN-**JS-1100**, DIN **GGG-90 (5.3400)**
				K4.5	等温淬火延性铸铁，硬度320 – 360 HB	0.45	ASTM **A897 Grade 2 (150-110-07)**, EN-**JS-1110**, DIN **GGG-100 (5.3403)**
		K5	蠕墨铸铁（CGI）（具有蠕墨结构的铁碳铸件）	K5.1	蠕墨铸铁，硬度 < 180 HB	1.29	ASTM **A842 Grade 300**, EN-**GJV-300**, DIN **GGV 30**, GOST **ЧВГ30**,
				K5.2	蠕墨铸铁，硬度180 – 220 HB	0.97	ASTM **A842 Grade 350**, EN-**GJV-350**, DIN **GGV 35 (5.2200)**, GOST **ЧВГ30**,
				K5.3	蠕墨铸铁，硬度220 – 260 HB	0.75	ASTM **A842 Grade 450**, EN-**GJV-450**, DIN **GGV 45**, GOST **ЧВГ45**,

ISO组		子分组		WMG（加工材料组）		k_{vG}	材料示例（AISI、EN、DIN、ČSN、GB、SS、STN、BS、UNE、AFNOR、ASTM、GOST、UNS、UNI、...）
N	有色金属（包括含铁量不高的合金的金属）	N1	锻铝	N1.1	纯铝和铝塑合金，硬度 < 60 HB	1.33	UNS **A91200**, EN **AL99.6**, DIN **3.0205**, SS **4010**, STN **424009**, BS **1C**, UNE **L-3001**, GB **L5**, AFNOR **A4**, GOST **АДС**, UNI **3567**
				N1.2	铝塑合金，硬度60 – 100 HB	1.00	UNS **A93004**, EN **AlMn0.5Mg0.5**, DIN **3.0505**, SS **4054**, STN **424432**, BS **N31**, UNE **L-3831**, GB **LF2**, AFNOR **A-M1**, GOST **АМц**, UNI **3568**
				N1.3	铝塑合金，硬度100 – 150 HB	0.67	UNS **A95083**, EN **AlMg4.5Mn0.7**, DIN **3.3547**, SS **4140**, STN **424415**, BS **N8**, UNE **L-3321**, GB **AlMg4.5Mn**, AFNOR **A-G4.5Mn**, GOST **Amg 4.5**, UNI **P-AlMg4.4**
		N2	铸铝	N2.1	铸铝合金，硬度 < 75 HB	0.67	UNS **A02080**, EN **AlCu4S**, BS **LM11**, STN **424331**, UNE **Al Si1Cu**, GOST **AMg5K**, UNI **G-AlSi7Mg**
				N2.2	铸铝合金，硬度75 – 90 HB	0.60	UNS **A02420**, EN **AlCu4Ni2Mg2**, SS **AlSi7MgFe**, BS **LM6**, STN **424519**, UNE **Al-7SiMg**, AFNOR **A-S7G**, GOST **АК7**, UNI **G-AlSi7Mg**
				N2.3	铸铝合金，硬度90 < 140 HB	0.43	UNS **A03360**, EN **G-ALCu4NiMg2**, SS **ALSi10Mg**, STN **424336**, BS **LM 30**, AFNOR **A-S10G**, UNI **G-AlSi9Mg**
		N3	铜或铜合金	N3.1	易切削铜合金材料，机械加工性能出色	0.70	UNS **C14700**, EN **CuPb1P**, DIN **2.1498**, STN **423214**, BS **C111**, AFNOR **CuZn35Pb2**, GOST **L63-3**, UNI **CuS(P0.01)**
				N3.2	短切屑铜合金，机械加工性能良好至中等	0.41	UNS **C81540**, EN **CuNi2SiCr**, DIN **2.0857**, STN **423220**, BS **NS113**, UNE **CuSn12**, AFNOR **CuZn40**, GOST **Л60**, UNI **P-CuZn-40**
				N3.3	电解铜和长切屑铜合金，机械加工性能中等至较差	0.21	UNS **C10100**, EN **CuAg0.1**, DIN **2.1203**, SS **5010**, UNE **CUSi3Mn1**, AFNOR **Cu-C2**, GOST **М1f**, UNI **Cu-OF**
		N4	聚合物（合成或半合成材料）	N4.1	热塑性聚合物	0.70	ABS, Acryl, Duraplast, Elastomer, EP, Epoxid, FEP, Fluor, Gummi, Kautschuk, Latex, MF, MPF, PA, PAI, PC, PE, PEEK, PEI, PES, PET, PF, Phenolharze, PI, PMMA, Polyamide, Polyester, Polyolefine, Polysulfon, POM, PP, PPE, PPS, PS, PSU, PTFE, PU, PUR, PVDF, SAN, SI, Styrol, UF, Ureol
				N4.2	热固性聚合物	0.27	Aramid, Epoxy, Fluoropolymer, Mehacrylate, Melamine, Phenolic, Polyester, Polyimide, Polymethacrylimide, Polyurethane
				N4.3	增强型聚合物或复合材料	0.29	CFK, GFK, GMT, Honeycomb, Kevlar, LFT, Organo, SMC
		N5	石墨	N5.1		1.0	CGM-1, CM-00, GM-10, GM-11, GR030, GR030PI, GR060, GR060PI, GR125, MC-01, MC-01RO, MC-03, MC-03M, IG11, IG-15, IG-32, IG-43, IG-45, IG-70, ISEM-1, ISEM-2, ISEM-3, R8340, R8500X, Technograph 15, Technograph 30, ISO-63, EDM C-3, EDM1, EDM3, ISO-90, ISO-93, ISO-95, R8510, R8650,

ISO组		子分组		WMG（加工材料组）		k_{vg}	材料示例（AISI、EN、DIN、ČSN、GB、SS、STN、BS、UNE、AFNOR、ASTM、GOST、UNS、UNI、...）
S	高温合金（高温强度和耐腐蚀性能超过不锈钢的高温合金）	S1	钛或钛合金	S1.1	钛或钛合金，硬度 < 200 HB	1.94	UNS **R50250 (Grade 1)**, EN **Ti 99.6**, DIN **3.7035**, BS **TA.2**, UNE **Ti-Po2**, AFNOR **T-40**, GOST **BT1-00**, AISI **R50250, 3.7025, T35, 2TA1, R50400, 3.7035, 2TA2,**
				S1.2	钛合金，硬度200 – 280 HB	1.72	UNS **R56404 (Grade 29)**, EN **Ti2Cu**, DIN **3.7124**, BS **TA.21**, UNE **Ti-P11**, AFNOR **T-U2** , AISI **TA6V, Ti-6Al-4V, Ti 10.2.3, Ti5553**
				S1.3	钛合金，硬度280 – 360 HB	1.44	UNS **R54250 (Grade 38)**, EN **TiAl6V4**, DIN **3.7165**, ČSN **TiAl6VELI**, BS **TA. 13**, UNE **Ti-P63**, AFNOR **T-A6V**, GOST **BT6**, AISI **TA6V, Ti-6Al-4V, Ti 10.2.3, Ti5553**
		S2	铁基高温合金	S2.1	高温铁基合金，硬度 < 200 HB	1.33	UNS **N08801 (Incoloy 801)**, EN **X8 NiCrAlTi31-21**, DIN **1.4959**, BS **NA 15**, AFNOR **Z8NC33-21**, AISI **A-286, Discaloy, Haynes 556, Iconel 909, Greek Ascolloy**
				S2.2	高温铁基合金，硬度200 – 280 HB	1.17	UNS **N19907**, EN **X6NiCrTiMoVB25-15-2**, DIN **1.4980**, SS **2570**, BS **HR52**, AFNOR **Z6NCTDV25.15B**, GOST **36HXTЮ**, AISI **A-286, Discaloy, Haynes 556, Iconel 909, Greek Ascolloy**
		S3	镍基高温合金	S3.1	高温镍基合金，硬度 < 280 HB	1.00	UNS **A09706 (Inconel 706)**, EN **NiCr25FeAl**, DIN **2.4856**, BS **HR 6**, ČSN **Inconel 625**, UNE **F.3313**, GB **1Cr16Ni35**, AFNOR **NC22FeDNB**, GOST **XH38BT**, AISI **Inconel 718, 706 Waspalloy, Udimet 720, Inconel 625**
				S3.2	高温镍基合金，硬度280 – 360 HB	0.83	UNS **N07001**, EN **NiCr20Co13Mo4Ti3Al**, DIN **2.4654**, BS **HR 2**, ČSN **Waspaloy**, AFNOR **NCKD 20ATV**, GOST **XH80TБЮ**, AISI **Inconel 718, 706 Waspalloy, Udimet 720, Inconel 625**
		S4	钴基高温合金	S4.1	高温钴基合金，硬度 < 240 HB	0.78	UNS **R30016 (Stellite 6b)**, EN **CoCr20W15Ni**, DIN **2.4964**, AFNOR **KC 20 WN**, GOST **ЛК52**, AISI **Haynes 25, Stellite 21, 31**
				S4.2	高温钴基合金，硬度240 – 320 HB	0.67	UNS **R30016 (Stellite 6b)**, EN **CoCr20W15Ni**, DIN **2.4964**, AFNOR **KC 20 WN**, GOST **ЛК52**, AISI **Haynes 25, Stellite 21, 31**

ISO组		子分组		WMG（加工材料组）		k_{vG}	材料示例（AISI、EN、DIN、ČSN、GB、SS、STN、BS、UNE、AFNOR、ASTM、GOST、UNS、UNI、...）
H	硬化材料（硬度 > 45 HRC的任何工程金属）	**H1**	冷硬铸铁	**H1.1**	冷硬铸铁，硬度 < 440 HB	**1.52**	UNS **F45001,** EN-**GJS-1050-6,** DIN **5.3406,** SS **0512,** BS **Grade 2A**
		H2	硬化铸铁	**H2.1**	硬化铸铁，硬度 < 55 HRC	**0.90**	UNS **F45003,** EN-**GJS-1400-1,** DIN **5.3405,** SS **0457,** BS **Grade 3D**
				H2.2	硬化铸铁，硬度 > 55 HRC	**0.77**	UNS **F45003,** EN **G-X260NiCr4-2,** DIN **0.9620,** SS **0466,** BS **Grade S**
		H3	硬化钢 < 55 HRC	**H3.1**	硬化钢，硬度 < 51 HRC	**1.00**	AISI **4135,** EN **34CrMo4,** DIN **1.7220,** SS **2234,** STN **415131,** BS **198,** UNE **F.1250,** GB **35CrMo,** AFNOR **35CD4,** GOST **AC38ХГМ,** UNI **35CrMo4KB**
				H3.2	硬化钢，硬度51 – 55 HRC	**0.82**	AISI **4135,** EN **34CrMo4,** DIN **1.7220,** SS **2234,** STN **415131,** BS **198,** UNE **F.1250,** GB **35CrMo,** AFNOR **35CD4,** GOST **AC38ХГМ,** UNI **35CrMo4KB**
		H4	淬硬钢 > 55 HRC	**H4.1**	硬化钢，硬度55 – 59 HRC	**0.64**	UNS **T31501,** EN **100MnCrW4,** DIN **1.2510,** SS **2140,** STN **419413,** BS **BO1,** UNE **F.5220,** GB **9CrWMn,** AFNOR **90MWCrV5,** GOST **9ХВГ,** UNI **95MNWCr5KU**
				H4.2	硬化钢，硬度 > 59 HRC	**0.54**	UNS **T31501,** EN **100MnCrW4,** DIN **1.2510,** SS **2140,** STN **419413,** BS **BO1,** UNE **F.5220,** GB **9CrWMn,** AFNOR **90MWCrV5,** GOST **9ХВГ,** UNI **95MNWCr5KU**

用于C_{VcO}特定操作类型的修正系数

X.V	FF			F			M			R			HR		
a_p	0.5			1.5			2.5			5.0			12.0		
	I	II	III	I	II	III	I	II	III	I	II	III	I	II	III
f	0.05	0.08	0.10	0.10	0.15	0.20	0.20	0.30	0.40	0.40	0.60	0.80	0.80	1.00	1.30
用于超精加工的断屑槽（FF、FF2…）	1.15	1.00	0.95	0.85	0.80	–	–	–	–	–	–	–	–	–	–
用于精加工的断屑槽（NF、SF..）	–	–	1.20	1.05	1.00	1.05	1.00	0.90	–	–	–	–	–	–	–
用于中等精度加工的断屑槽（FM、M、NM、NMR、SM…）	–	–	–	–	–	1.15	1.10	1.00	0.95	0.85	–	–	–	–	–
用于粗加工的断屑槽（RM、NRM、NR、R…）	–	–	–	–	–	–	–	–	1.25	1.10	1.00	0.95	0.65	–	–
用于45分钟持续粗加工的断屑槽（HR、HR2、NR2、OR…）	–	–	–	–	–	–	–	–	–	1.25	1.20	1.15	1.05	1.00	0.95

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}

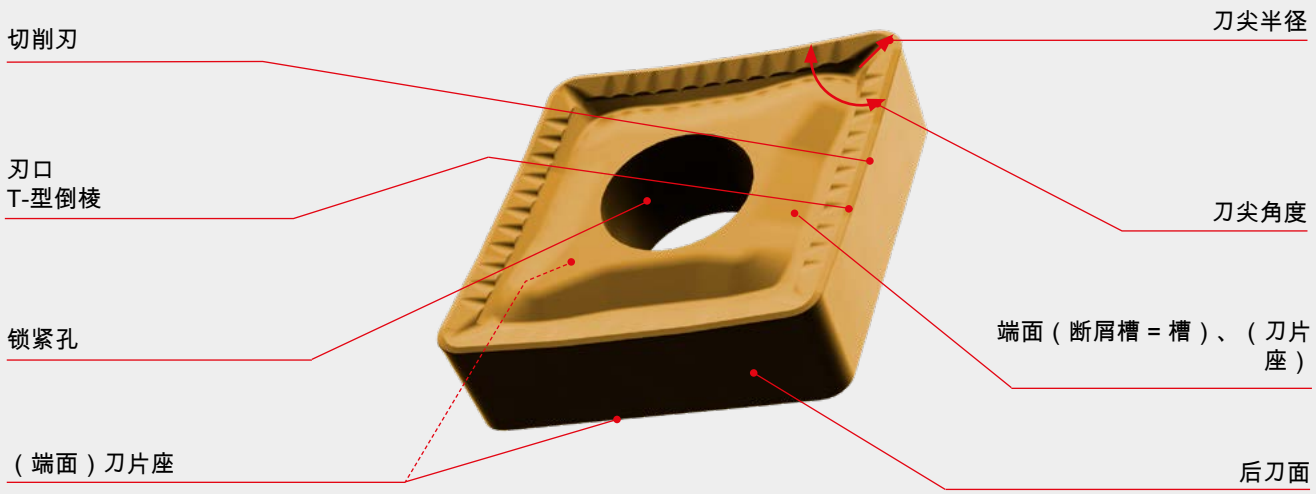
加工环境	C_{VcA}
加工材料的状况（由于锻造或铸造形成的硬皮）	0.70
内圆车削	0.75
切断和径向切槽	0.88
端面切槽	0.80
断续切削	0.80
不稳定的加工工况	0.85
普通加工工况	1.00
稳定加工工况	1.20

计算校正线速度v_{cC}

$$v_{cC} = v_c \cdot k_{vG} \cdot C_{VcO} \cdot C_{VcT} \cdot C_{VcA}$$

k_{vG} – 所用材料的系数
v_c – 从目录页中查询到的开始速度

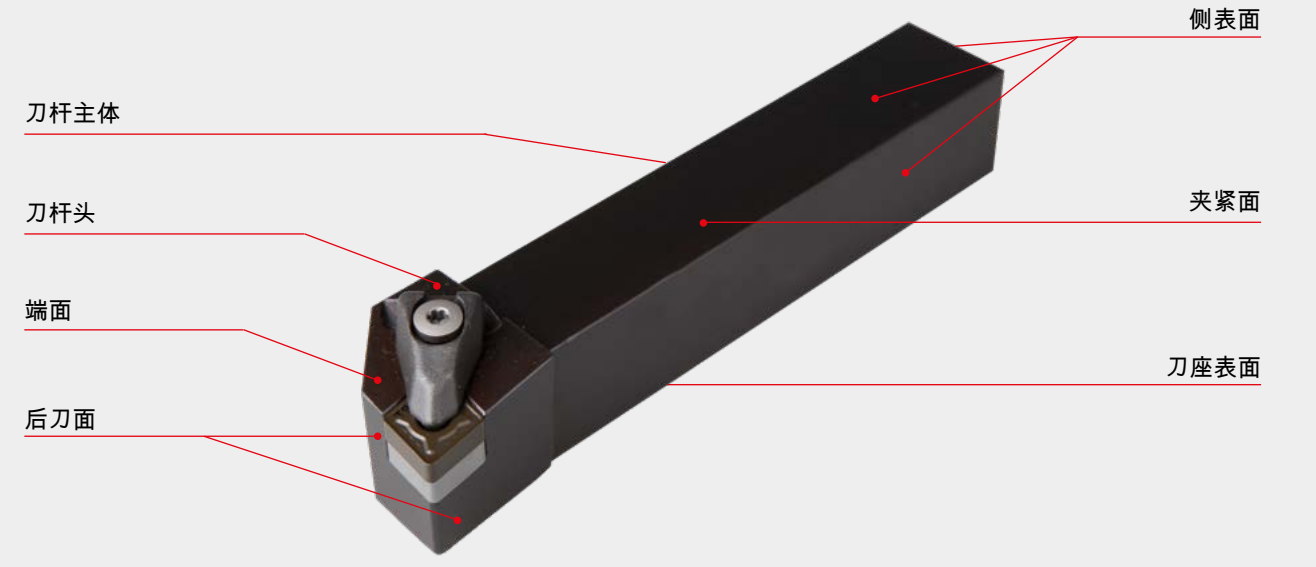
刀片部分



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

- 端面
- 后刀面

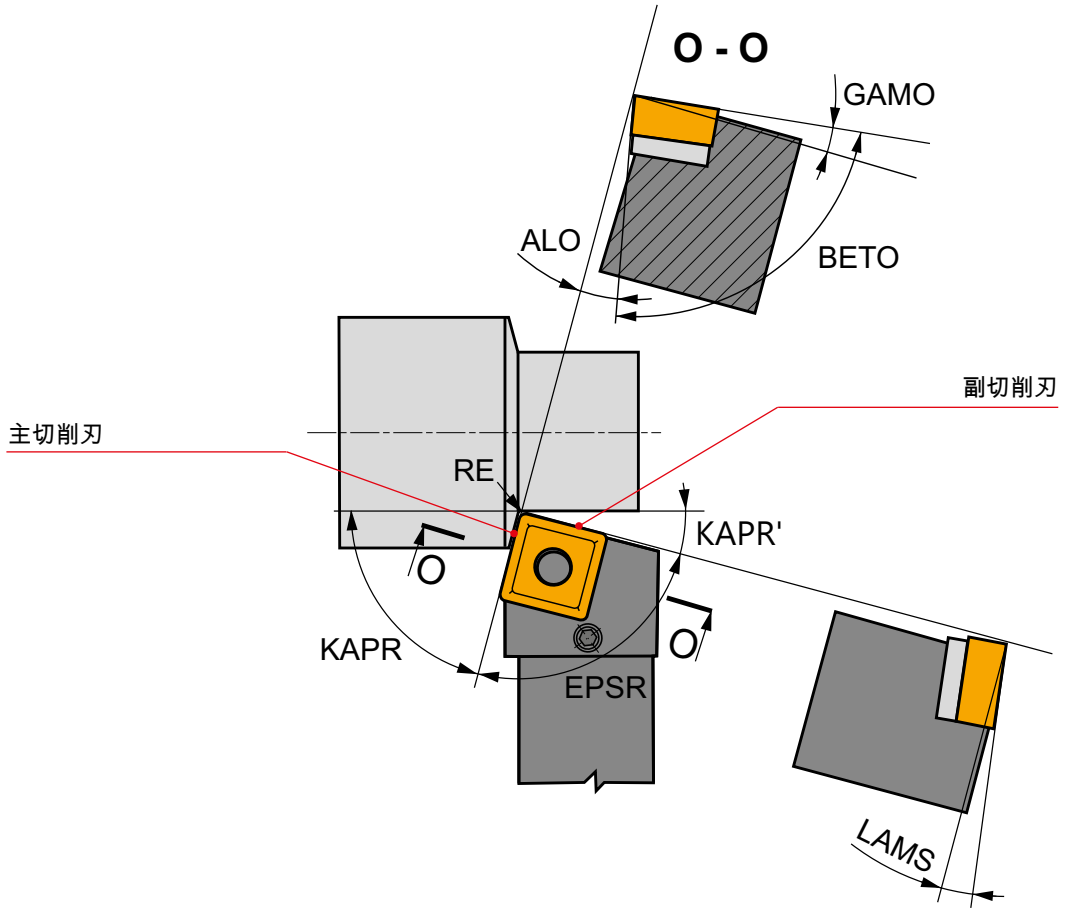
刀杆头也包含夹紧机构，刀片插入夹紧机构中。
可能从端面侧（径向刀片）或从后刀面侧（切向刀片）插入
备注：刀头类型包括：
- 直型 – 允许双向车削
- 侧型 – 左右设计不同
- 弯型 – 左右设计不同（当车削更复杂的表面时能够更好地接近工件）

2) 刀头，带有：

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

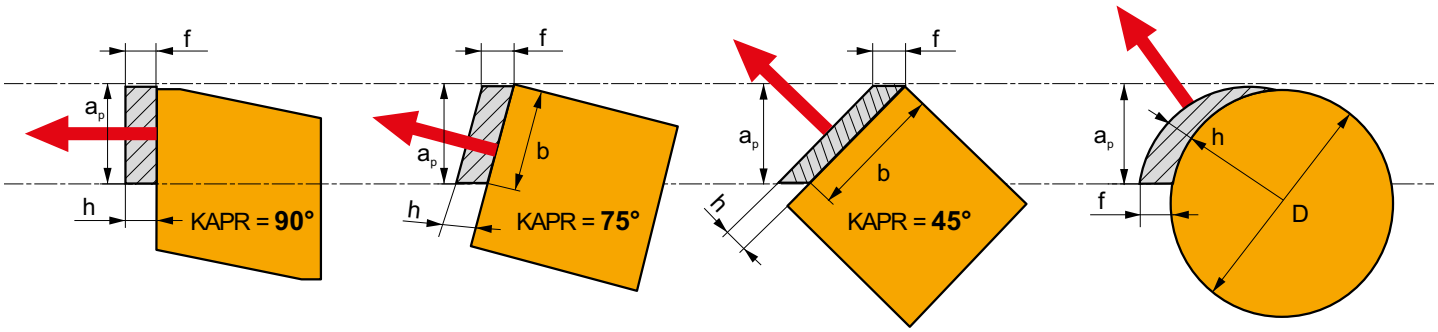
a) 刀具坐标系统（固定），用于在设计、生产和检查时确定切削刃槽型。在此系统内定义的所有角度都称为刀具切削角度。按照刀片形状用ISO标准定义的所有角度均属于此分组。



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。

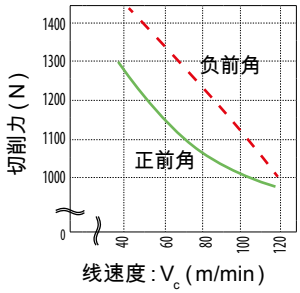
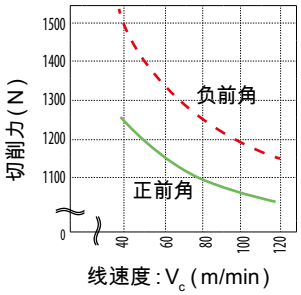
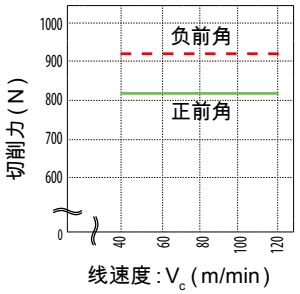
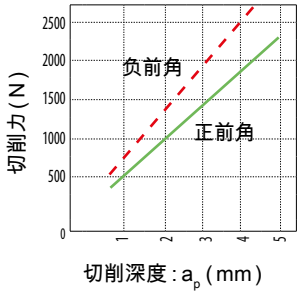
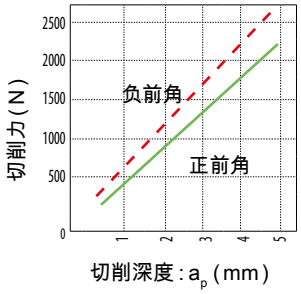
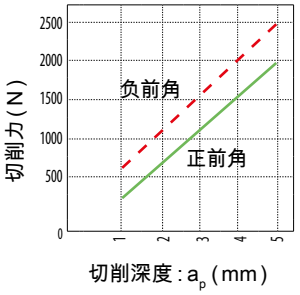
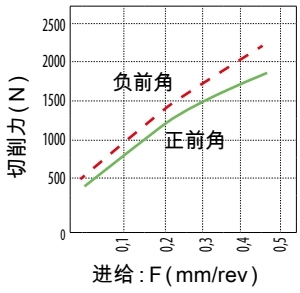
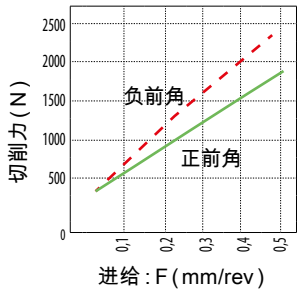
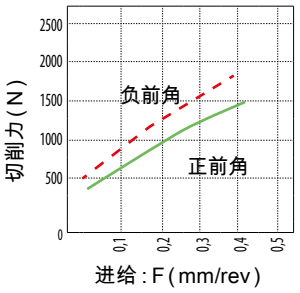
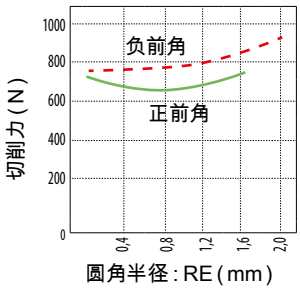
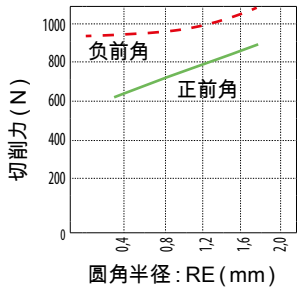
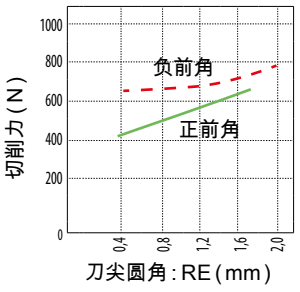
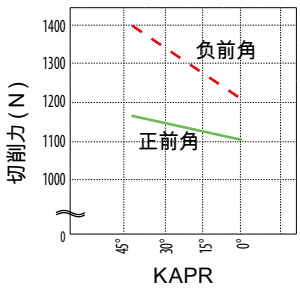
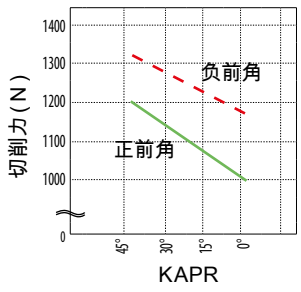
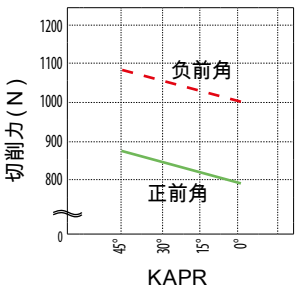
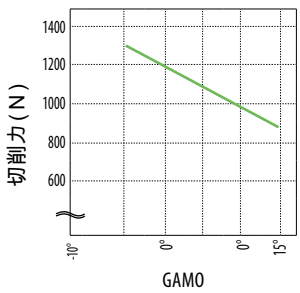
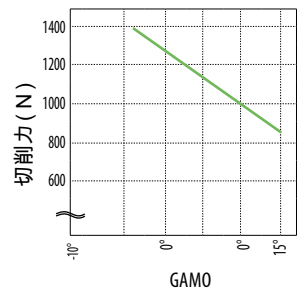
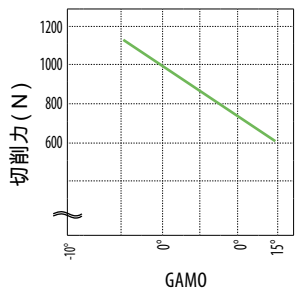
隙角ALO影响着后刀面与加工面之间的摩擦值。加大隙角ALO可减少摩擦，并能因此减少后刀面磨损。
楔角 BETO为刀片夹角。加大角度BETO可提高切削刃的强度（抗冲击强度），但也会增加切削阻力。
主切削刃的倾斜角LAMS – 决定着切削刃和工件间的第一接触点，对于断续切削非常重要。如果LAMS为正，接触点靠近刀尖。如果LAMS为负，则第一接触点远离刀尖，因此会影响切削刃抵抗机械应力的能力。此外，LAMS还影响着排屑的方向。如果LAMS为负，排屑方向朝向已加工表面。而如果LAMS为正，排屑方向背向已加工表面。
主切削刃的主偏角 KAPR对切削力大小和切屑的截面形状有重要影响。在给定进给f和切削深度a_p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。



$h = f$ | $h = 0{,}96\,f$ | $h = 0{,}71\,f$ | $h = 0 \div f$

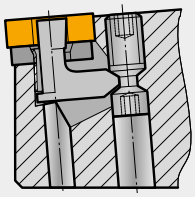
参数	变化	后刀面摩擦	月牙洼磨损形成	塑性变形的趋势	抵抗不利工况的能力	表面	切削力	振动趋势	中等切削温度	切屑形成
主偏角	小于或大于90°	稍微降低	稍微降低	稍微降低	稍微改善	效果未证实	稍微升高	升高	降低	切屑更薄、更宽（b/h改变）
小切削刃角	降低	稍微降低	效果未证实	稍微升高	微小改善	改善（特定条件下）	稍微升高	升高	微小升高	显著影响
刀尖角度	升高	效果未证实	效果未证实	减少	改善	效果未证实	效果未证实（-）	稍微升高	微小升高	显著影响
刀尖半径	升高	减少（至特定水平）	减少（至特定水平）	减少	改善	改善（特定条件下）	增加（至特定水平）	升高	稍微升高	更温和（大部分情况下 – 取决于断屑槽）
侧面角	正前角更大	减少	效果未证实	微小减少	稍微变差	改善（特定条件下）	稍微降低	稍微降低	稍微降低	效果未证实
端面角度	正前角更大	微小降低	减少	稍微降低	稍微变差	效果未证实（+）	稍微降低	减少	降低	切屑的压缩程度较低，但被进一步推到切削刃处
主偏角	正前角	效果未证实	稍微降低	稍微降低	稍微变差	效果未证实（+）	稍微降低	稍微降低	稍微降低	使切屑从工件上排出
倒棱宽度	更宽	稍微升高	稍微升高	稍微升高	稍微改善	效果未证实（+）	升高	升高	更高	切屑的压缩程度较高，但压缩面积更大
倒棱角度（工作角度）	正前角	微小降低	稍微降低	稍微降低	稍微变差	效果未证实（+）	减少	减少	稍微降低	切屑压缩程度较低

影响切削力的因素和影响方式

工况	碳钢（HB230）	不锈钢（HB145）	灰口铸铁（HB130）
线速度和切削力 f = 0.2 mm/rev a_p = 2 mm KAPR 90° RE 0.4			
切削深度和切削力 V_c = 100 m/min a_p = 0.2 mm/rev KAPR 90° RE 0.4			
切削进给和切削力 V_c = 100 m/min a_p = 2 mm KAPR 90° RE 0.4			
刀尖圆角和切削力 V_c = 100 m/min f = 0.2 mm/rev a_p = 1.2 mm KAPR 90°			
主偏角 V_c = 100 m/min f = 0.2 mm/rev a_p = 2 mm KAPR 45°、60°、75°、90° （x轴上的值） RE 0.4			
前角和切削力 V_c = 100 m/min f = 0.2 mm/rev a_p = 2 mm KAPR 90° RE 0.4			

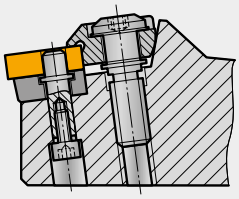
根据夹紧技术选择刀杆

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。



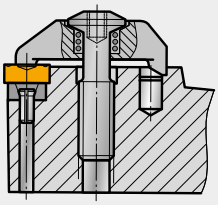
ISO P

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。



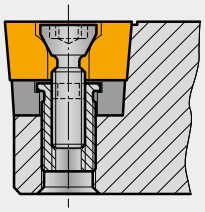
ISO M

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。



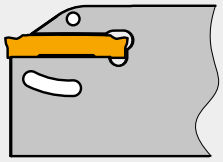
ISO C

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。



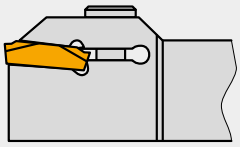
ISO S

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 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。

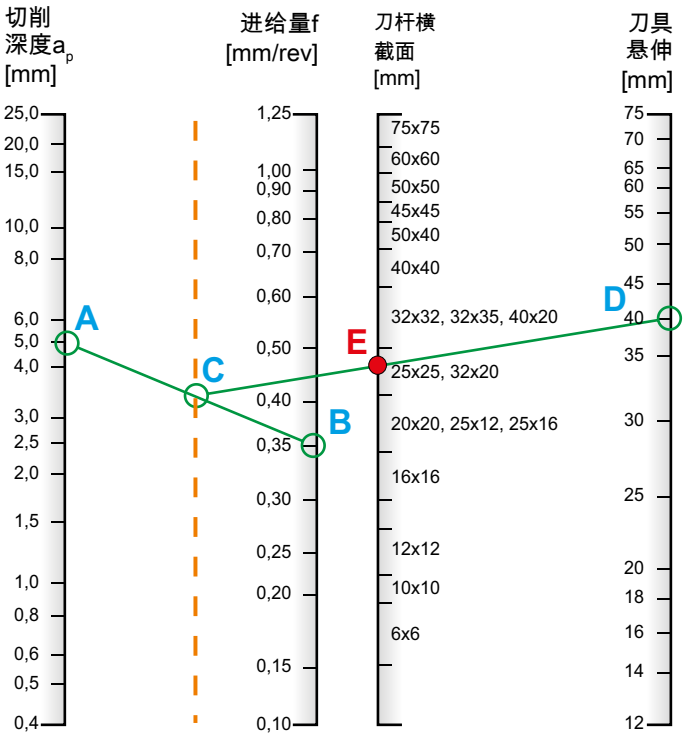


ISO G

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。

参考方形切削刀具

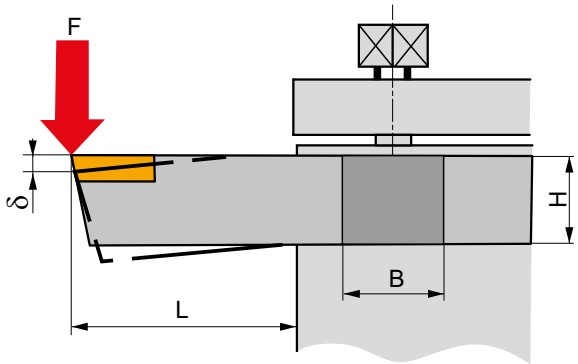
外圆切削刀具 (方形截面)

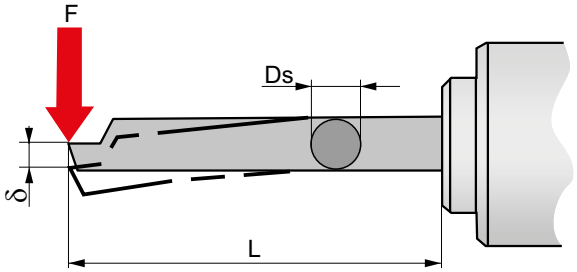


遗憾的是 , 由于内圆车削会产生切屑 , 情况相对更加复杂 , 我们无法为您提供用于选择内圆车削刀具直径的类似图表。在这种情况下 , 由于悬伸更大 , 应选择直径尽可能最大的刀杆 , 但如果刀杆直径接近要加工的孔径 , 可能出现排屑问题。切屑通常会积聚在孔壁和刀杆体之间 , 从而损坏正在形成的表面。

一般而言 , 如果使用带钢制刀体的刀具 , 悬伸不应超过4xD , 如果使用带有硬质合金或重金属刀体的刀具 , 最大悬伸应为6ḳD。对于这两种刀具 , 刀具夹紧部分应至少为3ḳD。

根据夹紧方式和工艺限制 , 选择尽可能最大的横截面。





弯曲应力

$$\sigma_{(MPa)} = \frac{6.F.L}{B.H^2}$$

刀杆偏转量

$$\delta_{(mm)} = \frac{4.F.L^3}{E.B.H^3}$$

弯曲应力

$$\sigma_{(MPa)} = \frac{32.F.L}{\pi.D_s^3}$$

刀架偏转刀杆

$$\delta_{(mm)} = \frac{64.F.L^3}{3.\pi.E.D_s^3}$$

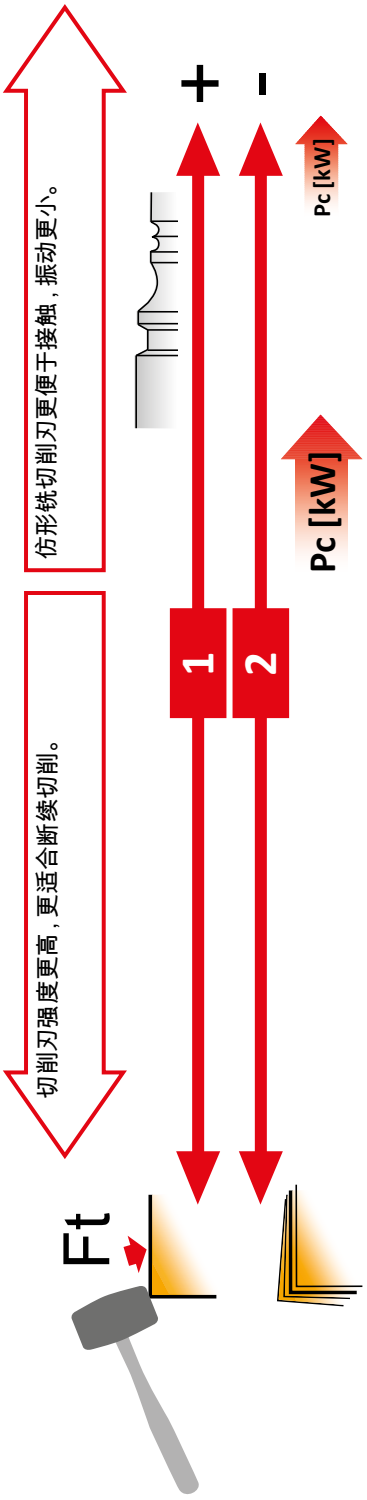
σ	刀体中的弯曲应力[MPa]
F	切削力[N]
L	刀具悬伸[mm]
B	刀体宽度[mm]
H	刀体高度[mm]
Ds	刀体直径[mm]
E	刀体材料弹性模量[MPa]

材料	MPa [N/mm²]	[kgf/mm²]
钢	210.000	21.000
硬质合金	560.000 – 620.00	56.000 – 62.00

悬伸减少50% , 偏移减少88%。
横截面增加1/3 , 弯曲度减少68%。

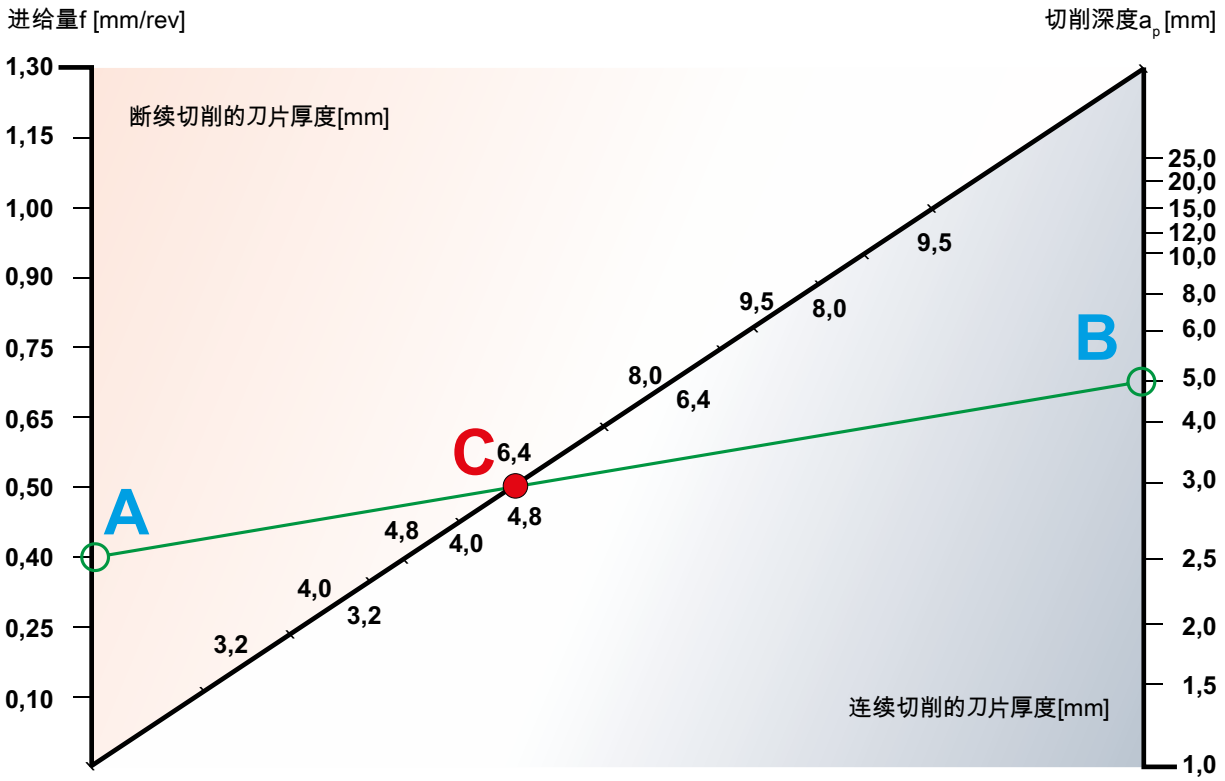
选择刀片的形状和尺寸

选择优先级	刀片形状		球头角度	刀片规格		切削刃最大长度 L_{max}			粗加工	轻型粗加工	精加工	廓形车削	端面车削	通用应用	振动趋势	硬质材料	断续切削
				ISO	ANSI		(mm)	(″)									
		V	35°	11	2	0.25L	2.80	.110″									
				13			3.30	.130″			■	■		◪	■		
				16	3		4.20	.165″									
		D	55°	07	2	0.25L	2.00	.078″									
				11	3		2.90	.114″		■	■	■	◪	■	■		
				15	4		3.90	.153″									
		T	60°	11	2	0.33L	3.60	.141″									
				16	3		5.50	.216″	◪	■	■	◪	◪	◪	■	◪	
				22	4		7.30	.287″									
				27	5		9.10	.358″									
		W	80°	06	3	0.50L	3.30	.129″	◪	■	■	◪	■	◪	◪	◪	◪
				08	4		4.40	.173″									
		C	80°	06	2	0.66L	4.20	.165″									
				09	3		6.40	.251″									
				12	4		8.50	.334″	■	■	◪	◪	■	■	◪	■	■
				16	5		10.60	.417″									
				19	6		12.70	.500″									
				25	8		16.50	.649″									
		S	90°	09	3	0.66L	6.30	.248″									
				12	4		8.40	.330″									
				15	5		10.40	.409″	■	◪			■			■	■
				19	6		12.60	.496″									
				25	8		16.80	.661″									
		C	100°	12	4	0.66L	8.50	.334″									
				19	6		12.70	.500″	■				■			■	■
				25	8		16.50	.649″									
		R		06		0.40D	2.40	.094″									
				08			3.20	.125″									
				10			4.00	.157″									
				12			4.80	.188″									
				15			6.00	.236″	■				◪	◪		■	■
				16			6.40	.251″									
				19			7.60	.299″									
				20			8.00	.315″									
				25			10.00	.393″									
				32			12.80	.503″									



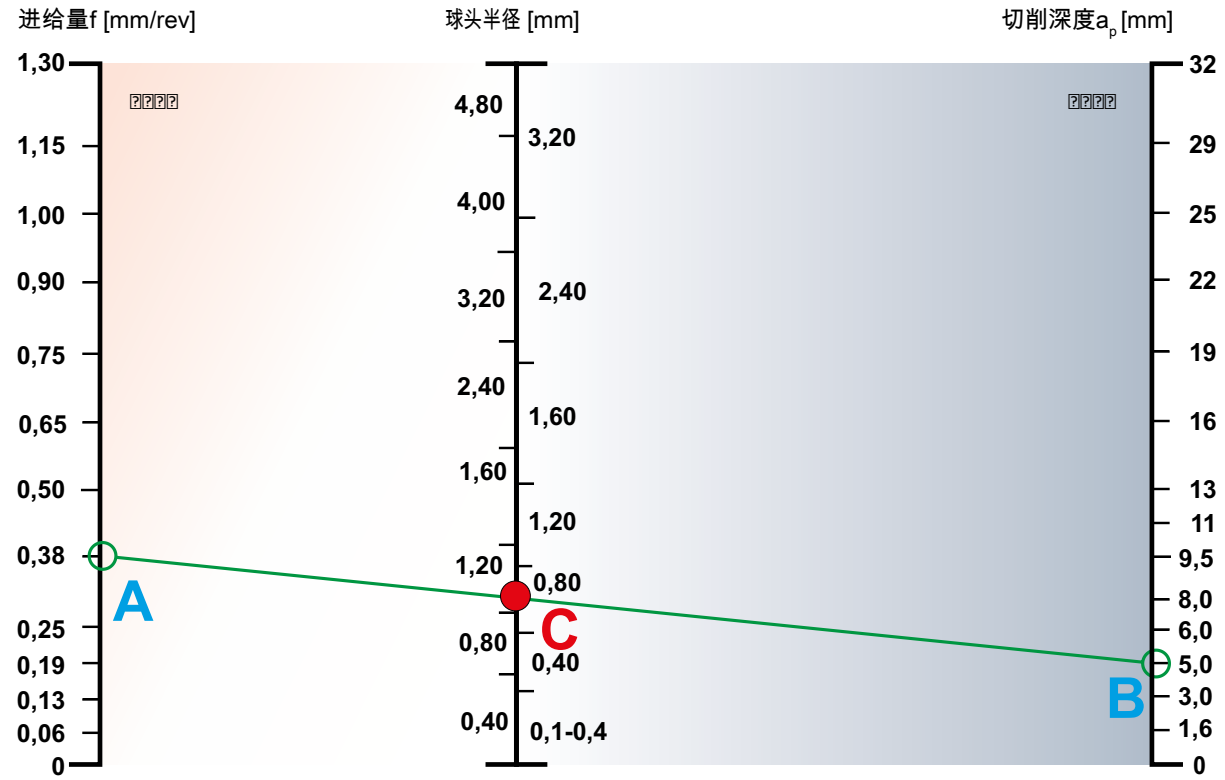
选择最佳刀片厚度

根据实践，我们建议仅在断续切削和最大刀片载荷下执行此操作。



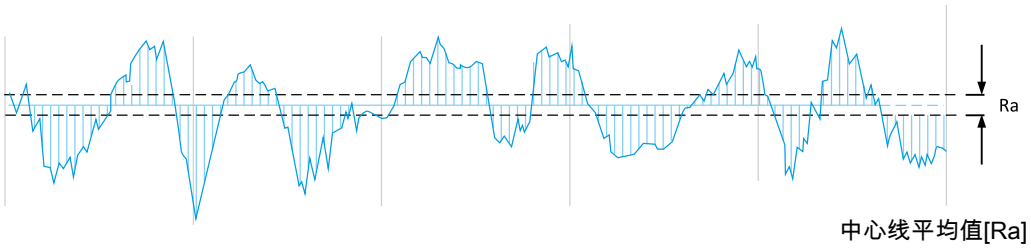
选择刀片的球头半径

根据实践，我们建议仅在断续切削和最大刀片载荷下执行此操作。



刀尖半径以及进给量和小主偏角，都是决定加工表面粗糙度的主要标准。被加工材料的属性和类型，包括切削环境，显然都有显著的影响。

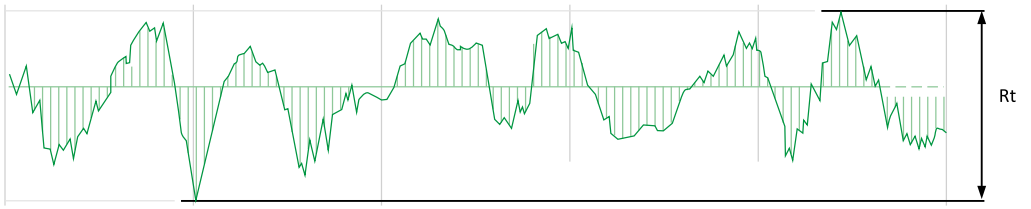
在本章节的开始部分，我们介绍了工程实践中普遍规定的主要粗糙度参数。



中心线平均值[Ra]

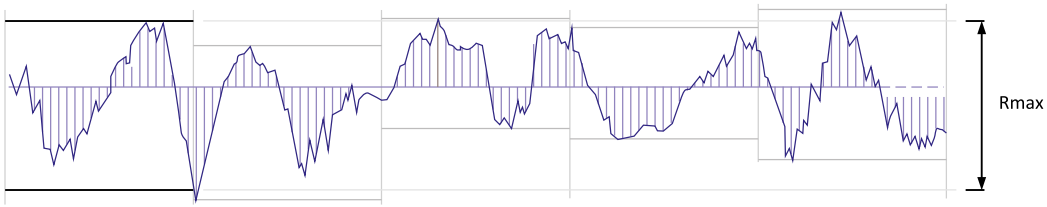
Ra – 平均粗糙度
Ra也称为算术平均值（AA）或中心线平均值（CLA），是在粗糙度廓形及其平均线间区域中的平均粗糙度。在图中，Ra是粗糙度廓形及其中心线间的区域除以评估长度。评估长度通常为5个样本长度，每个样本长度等于一个切削长度。如图所示。

Ra是目前最常用的表面光洁度参数，并且，即使在没有参数标注的情况下，也是量化部件的一个不错的起点（需要表面光洁度）。尽管Ra很常用，但并不足以完全表征工件表面的粗糙度。根据应用的不同，粗糙度相同的表面，性能也可能大不相同。下面我们看看用其他三种方式来分析的相同的表面粗糙度：



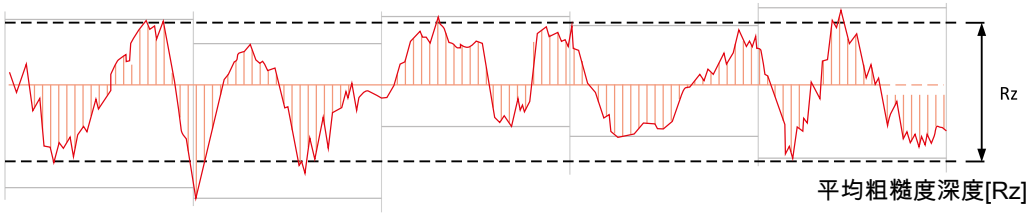
粗糙度廓形的总高度[Rt]

Rt – 粗糙度廓形的总高度
在最下面的图中可以看到，总高度是指评估长度内波峰高度与波谷深度的差值。



最大单一粗糙度深度[Rmax]

Rmax – 在整个切削长度上，波峰与波谷之间的最大距离定义也许不同，但意思一样，Rmax是指在其中一个样品长度测得的最大单一粗糙度深度。Rmax对划痕和毛刺等异常表面情况尤为敏感，而这些异常在Ra等依赖于平均值的衡量标准中可能表现并不明显。



平均粗糙度深度[Rz]

Rz – 平均粗糙度深度
在欧洲，特别是在德国，通常更多地采用Rz，而不是Ra。与从中心线测量的Ra不同，Rz是在五个样本长度内测得的5个最大波峰与波谷的差值平均值。与Ra对一些极端情况相对不敏感不同，Rz对此非常敏感，因为其作用便是用来衡量极端情况的。

表面粗糙度等级：“N”编号

N编号是技术图纸中常用来描述表面光洁度的数字。过去使用的三角形符号无法具体地描述正确的表面光洁度。

与三角形符号的关系

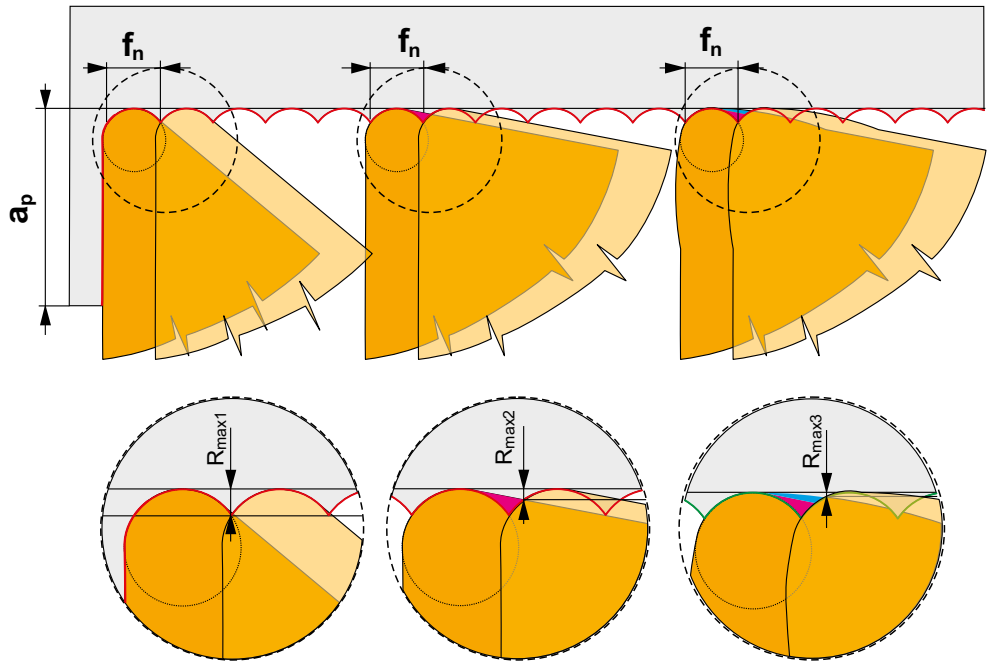
算术 平均粗糙度 **Ra [µm]**	最大高度 粗糙度 **Rz [µm]**	十点平均 粗糙度 **RzJIS [µm]**	粗糙度 等级	备注： （与三角形符号的关系）
0.025	0.1	0.1	N1	VVVV
0.05	0.2	0.2	N2	
0.1	0.4	0.4	N3	
0.2	0.8	0.8	N4	
0.4	1.6	1.6	N5	VVV
0.8	3.2	3.2	N6	
1.6	6.3	6.3	N7	
3.2	12.5	12.5	N8	VV
6.3	25	25	N9	
12.5	50	50	N10	V
25	100	100	N11	

备注：在1994年修订版中，表面修整的标志（三角形和波形符号）已从JIS标准中删除。

如果没有可用的电子设备，可以使用市售的“RugoTest”目视检查表面光洁度。但请注意，这种检查只能作为指导，而非衡量标准



下文表格中规定的粗糙度值R_z和R_a适用于副偏角更大的车刀$KAPR'$，即基本形状为**T...**、**S...**、**D....**、**K...**、**V...**的刀片。如果使用形状为**C ...**、**W ...**的刀片，特别是修光刃刀片（即调节角度$KAPR = 90° - 95°$），获得的表面粗糙度值R_a通常比表中数值低。这是由于副偏角$KAPR'$值较小造成的。从后面图17的比较中可以明显看出，在这种情况下，粗糙区域被切除，理论最大粗糙区域减小到$R_{max3} < R_{max2} < R_{max}$1。



车削的表面质量 R_{max}

$$R_{max} = \frac{f^2}{8.RE} \cdot 1000$$

f ⇨	RE 半径																		
	0.1	0.2	0.4	0.5	0.8	1.0	1.2	1.5	1.6	2.0	2.4	2.5	3.0	3.2	3.5	4.0	5.0	6.0	8.0
	表面 R_{max} (µm)																		
0.05	3.13	1.56	0.78	0.63	0.39	0.31	0.26	0.21	0.20	0.16	0.13	0.13	0.10	0.10	0.09	0.08	0.06	0.05	0.04
0.07	6.1	3.06	1.53	1.23	0.77	0.61	0.51	0.41	0.38	0.31	0.26	0.25	0.20	0.19	0.18	0.15	0.12	0.10	0.08
0.08	8.0	4.0	2.00	1.60	1.00	0.80	0.67	0.53	0.50	0.40	0.33	0.32	0.27	0.25	0.23	0.20	0.16	0.13	0.10
0.10		6.3	3.13	2.50	1.56	1.25	1.04	0.83	0.78	0.63	0.52	0.50	0.42	0.39	0.36	0.31	0.25	0.21	0.16
0.12		9.0	4.50	3.60	2.25	1.80	1.50	1.20	1.13	0.90	0.75	0.72	0.60	0.56	0.51	0.45	0.36	0.30	0.23
0.15		14	7.0	5.6	3.52	2.81	2.34	1.88	1.76	1.41	1.17	1.13	0.94	0.88	0.80	0.70	0.56	0.47	0.35
0.16		16	8.0	6.4	4.00	3.20	2.67	2.13	2.00	1.60	1.33	1.28	1.07	1.00	0.91	0.80	0.64	0.53	0.40
0.18		20	10.1	8.1	5.1	4.05	3.38	2.70	2.53	2.03	1.69	1.62	1.35	1.27	1.16	1.01	0.81	0.68	0.51
0.20			13	10.0	6.3	5.0	4.17	3.33	3.13	2.50	2.08	2.00	1.67	1.56	1.43	1.25	1.00	0.83	0.63
0.22			15	12.1	7.6	6.1	5.0	4.03	3.78	3.03	2.52	2.42	2.02	1.89	1.73	1.51	1.21	1.01	0.76
0.25			20	16	9.8	7.8	6.5	5.2	4.88	3.91	3.26	3.13	2.60	2.44	2.23	1.95	1.56	1.30	0.98
0.27			23	18	11.4	9.1	7.6	6.1	5.7	4.56	3.80	3.65	3.04	2.85	2.60	2.28	1.82	1.52	1.14
0.30			28	23	14	11.3	9.4	7.5	7.0	5.6	4.69	4.50	3.75	3.52	3.21	2.81	2.25	1.88	1.41
0.32			32	26	16	13	10.7	8.5	8.0	6.4	5.3	5.1	4.27	4.00	3.66	3.20	2.56	2.13	1.60
0.35			38	31	19	15	13	10.2	9.6	7.7	6.4	6.1	5.1	4.79	4.38	3.83	3.06	2.55	1.91
0.37			43	34	21	17	14	11.4	10.7	8.6	7.1	6.8	5.7	5.3	4.89	4.28	3.42	2.85	2.14
0.40				40	25	20	17	13	13	10.0	8.3	8.0	6.7	6.3	5.7	5.0	4.00	3.33	2.50
0.45				51	32	25	21	17	16	13	10.5	10.1	8.4	7.9	7.2	6.3	5.1	4.22	3.16
0.50					39	31	26	21	20	16	13	13	10.4	9.8	8.9	7.8	6.3	5.2	3.91
0.55					47	38	32	25	24	19	16	15	13	11.8	10.8	9.5	7.6	6.3	4.73
0.60					56	45	38	30	28	23	19	18	15	14	13	11.3	9.0	7.5	5.6
0.65					66	53	44	35	33	26	22	21	18	17	15	13	10.6	8.8	6.6
0.70					77	61	51	41	38	31	26	25	20	19	18	15	12.3	10.2	7.7
0.75					88	70	59	47	44	35	29	28	23	22	20	18	14	11.7	8.8
0.80						80	67	53	50	40	33	32	27	25	23	20	16	13	10.0
0.85						90	75	60	56	45	38	36	30	28	26	23	18	15	11.3
0.90						101	84	68	63	51	42	41	34	32	29	25	20	17	13
0.95						113	94	75	71	56	47	45	38	35	32	28	23	19	14
1.00							104	83	78	63	52	50	42	39	36	31	25	21	16
1.20								120	113	90	75	72	60	56	51	45	36	30	23
1.30								141	132	106	88	85	70	66	60	53	42	35	26
1.40								163	153	123	102	98	82	77	70	61	49	41	31
1.50									176	141	117	113	94	88	80	70	56	47	35
1.60										160	133	128	107	100	91	80	64	53	40
1.70										181	151	145	120	113	103	90	72	60	45
1.80										203	169	162	135	127	116	101	81	68	51
1.90										226	188	181	150	141	129	113	90	75	56
2.00											208	200	167	156	143	125	100	83	63
2.20											252	242	202	189	173	151	121	101	76
2.50													260	244	223	195	156	130	98

难断屑的风险

车削的表面质量 R_a

$$R_a = 43{,}9 \frac{f^{1{,}88}}{RE^{0{,}97}}$$

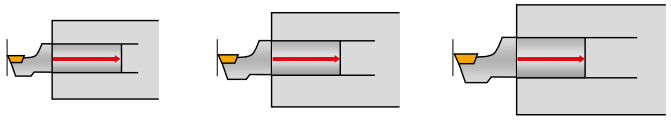
f ⇨	RE 半径																		
	0.1	0.2	0.4	0.5	0.8	1.0	1.2	1.5	1.6	2.0	2.4	2.5	3.0	3.2	3.5	4.0	5.0	6.0	8.0
	表面 R_a (µm)																		
0.05	1.47	0.75	0.38	0.31	0.20	0.16	0.13	0.11	0.10	0.08	0.07	0.06	0.05	0.05	0.05	0.04	0.03	0.03	0.02
0.07	2.76	1.41	0.72	0.58	0.37	0.30	0.25	0.20	0.19	0.15	0.13	0.12	0.10	0.10	0.09	0.08	0.06	0.05	0.04
0.08	3.55	1.81	0.93	0.75	0.47	0.38	0.32	0.26	0.24	0.19	0.16	0.16	0.13	0.12	0.11	0.10	0.08	0.07	0.05
0.10		2.76	1.41	1.13	0.72	0.58	0.48	0.39	0.37	0.30	0.25	0.24	0.20	0.19	0.17	0.15	0.12	0.10	0.08
0.12		3.88	1.98	1.60	1.01	0.82	0.68	0.55	0.52	0.42	0.35	0.34	0.28	0.26	0.24	0.21	0.17	0.14	0.11
0.15		5.9	3.02	2.43	1.54	1.24	1.04	0.84	0.79	0.63	0.53	0.51	0.43	0.40	0.37	0.32	0.26	0.22	0.17
0.16		6.7	3.41	2.74	1.74	1.40	1.17	0.94	0.89	0.71	0.60	0.58	0.48	0.45	0.42	0.36	0.29	0.25	0.19
0.18		8.3	4.25	3.42	2.17	1.75	1.46	1.18	1.11	0.89	0.75	0.72	0.60	0.57	0.52	0.46	0.37	0.31	0.23
0.20			5.2	4.17	2.64	2.13	1.78	1.44	1.35	1.09	0.91	0.88	0.73	0.69	0.63	0.56	0.45	0.37	0.28
0.22			6.2	4.99	3.16	2.55	2.14	1.72	1.62	1.30	1.09	1.05	0.88	0.82	0.76	0.66	0.53	0.45	0.34
0.25			7.9	6.3	4.02	3.24	2.72	2.19	2.05	1.65	1.39	1.33	1.12	1.05	0.96	0.84	0.68	0.57	0.43
0.27			9.1	7.3	4.65	3.74	3.14	2.53	2.37	1.91	1.60	1.54	1.29	1.21	1.11	0.98	0.79	0.66	0.50
0.30			11.1	8.9	5.7	4.57	3.83	3.08	2.89	2.33	1.95	1.88	1.57	1.48	1.35	1.19	0.96	0.80	0.61
0.32			13	10.1	6.4	5.2	4.32	3.48	3.27	2.63	2.20	2.12	1.78	1.67	1.53	1.34	1.08	0.91	0.69
0.35			15	11.9	7.6	6.1	5.1	4.12	3.87	3.11	2.61	2.51	2.10	1.97	1.81	1.59	1.28	1.07	0.81
0.37			16	13	8.4	6.8	5.7	4.57	4.29	3.46	2.90	2.78	2.33	2.19	2.01	1.76	1.42	1.19	0.90
0.40				15	9.7	7.8	6.6	5.3	4.97	4.00	3.35	3.22	2.70	2.54	2.33	2.04	1.65	1.38	1.04
0.45				19	12.1	9.8	8.2	6.6	6.2	4.99	4.19	4.02	3.37	3.17	2.90	2.55	2.05	1.72	1.30
0.50					15	11.9	10.0	8.0	7.6	6.1	5.1	4.90	4.11	3.86	3.54	3.11	2.50	2.10	1.59
0.55					18	14	12.0	9.6	9.0	7.3	6.1	5.9	4.92	4.62	4.23	3.72	2.99	2.51	1.90
0.60					21	17	14	11.3	10.7	8.6	7.2	6.9	5.8	5.4	4.98	4.38	3.53	2.96	2.24
0.65					24	20	16	13	12.4	10.0	8.4	8.0	6.7	6.3	5.8	5.1	4.10	3.44	2.60
0.70					28	22	19	15	14	11.5	9.6	9.2	7.7	7.3	6.7	5.9	4.71	3.95	2.99
0.75					32	26	21	17	16	13	10.9	10.5	8.8	8.3	7.6	6.7	5.4	4.50	3.40
0.80						29	24	19	18	15	12.3	11.9	9.9	9.3	8.6	7.5	6.1	5.1	3.84
0.85						32	27	22	21	17	14	13	11.1	10.5	9.6	8.4	6.8	5.7	4.30
0.90						36	30	24	23	18	15	15	12.4	11.7	10.7	9.4	7.6	6.3	4.79
0.95						40	33	27	25	20	17	16	14	13	11.8	10.4	8.4	7.0	5.3
1.00							37	30	28	22	19	18	15	14	13	11.4	9.2	7.7	5.8
1.20								42	39	32	26	25	21	20	18	16	13	10.9	8.2
1.30								49	46	37	31	30	25	23	21	19	15	13	9.6
1.40								56	52	42	35	34	28	27	25	22	17	15	11.0
1.50									60	48	40	39	32	30	28	25	20	17	13
1.60										54	45	44	37	34	32	28	22	19	14
1.70										61	51	49	41	39	35	31	25	21	16
1.80										68	57	54	46	43	39	35	28	23	18
1.90										75	63	60	51	47	44	38	31	26	20
2.00											69	66	56	52	48	42	34	28	21
2.20											83	79	67	63	57	50	41	34	26
2.50													85	80	73	64	52	43	33

难断屑的风险

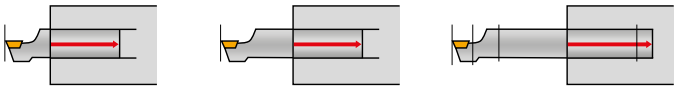




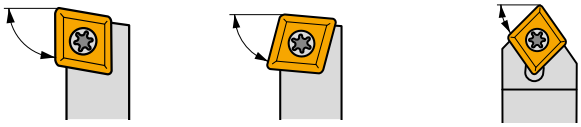
切屑的硬度 – 必须特别注意是否能够正确产生切屑，即切屑必须能够容易从切削点排除，同时塑性变形保持在最小，即切削力最低。



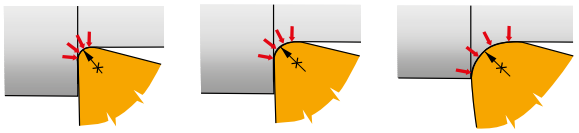
刀体横截面（刚性夹紧）– 夹紧装置本身的刚性很重要。因此，我们建议，选择刀体可夹紧横截面尽可能最大的切削刀具。我们也推荐使用单体刀具（PSC）。



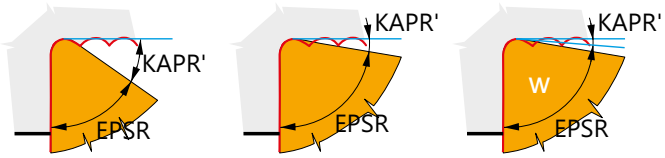
悬伸（刚性夹紧）– 刀具悬伸，或夹紧装置本身的刚度，也非常重要。因此，我们建议让悬伸保持在最小。



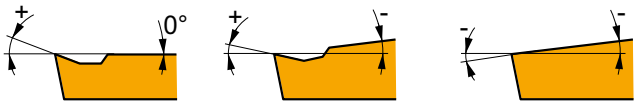
主偏角 – 理想情况下，刀具调节角度应接近90°，即切削力应尽可能与机床心轴的轴线垂直。



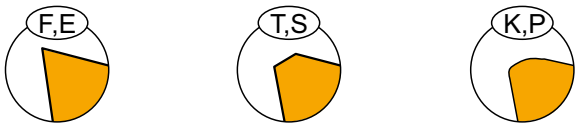
刀尖半径 – 如果有振动风险，我们建议选择刀尖半径尽可能小的刀片。



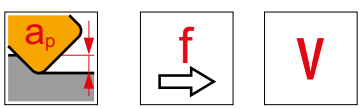
刀尖角度和副偏角 – 这种情况下建议选择刀尖角度尽可能小的刀片，即V（35°）、D或K（55°）或者T（60°）形刀片。不建议选择C形、W形或者修光刃刀片。请注意，这条原则并非总是适用（如果还可能发生扭转振动，使用这些刀片还是有一定好处的）。



槽型 – 当车削薄壁和细长零件时，建议选择具有正前角槽型的正前角刀片，然后选择具有正前角槽型的负角刀片，只有在没有其他选择时，才选择具有0°到负前角槽型的负角刀片。



刃口槽型（切削刃处理类型）– 为了减少振动风险，必须选择切削刃尽可能锋利的刀片。如果使用带倒棱的刀片，倒棱应尽可能窄并且尽可能为正前角槽型。确保刀具产生的切削阻力最小是非常重要的。



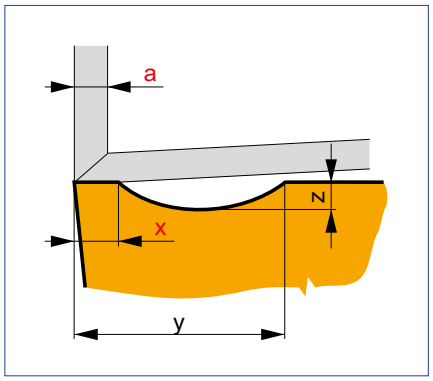
切削工况：
1）选择切削深度时，务必确保切削深度比刀尖半径大。
2）选择进给量时，要考虑切削阻力会随切屑厚度减小而增大，换言之，不要使用极低进给量（小于0.1 mm）。
3）如果存在振动，可以改变线速度（升高/降低），因为振动与机床固有频率相关。
备注：减小切削深度（不小于半径）和增加进给量通常都有好处。



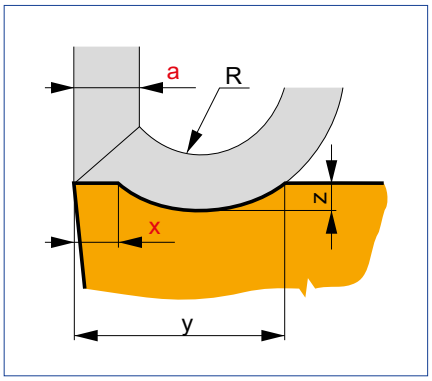
不要使用已磨损的刀片 – 后刀面磨损会导致切削力增加，进而带来振动风险。如果刀具夹紧情况允许，将切削刃移动到轴线上方（外圆车削应用中），与轴线距离约为直径的2%。

选择断屑槽

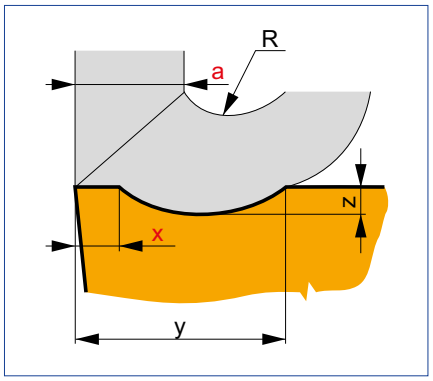
切屑的形状取决于几个因素 – 加工材料的特性及材料强度、韧性及其微观结构；刀片材质的特性，特别是摩擦特性（前刀面）；切削刃的槽型、切削工况和断屑槽的类型，还有机床的静态和动态特性。在切削过程中，所有这些因素几乎同时作用，决定着切屑的形状（剪切动作、切屑流或卷曲切屑 – 切屑可能聚集在加工区域并发生堵塞）。每个断屑槽都在限定的进给和切削深度范围内工作。确保断屑槽正常工作的最小进给量取决于倒棱宽度“x”及其角度。最大进给量取决于从切削刃到断屑槽端部的距离y以及断屑槽深度z.



如果切削层厚度“a”（主偏角KAPR = 90°，与进给量相等）明显小于倒棱“x”，切屑仅与倒角接触，无法进入断屑槽，因此无法被切碎（见图）。

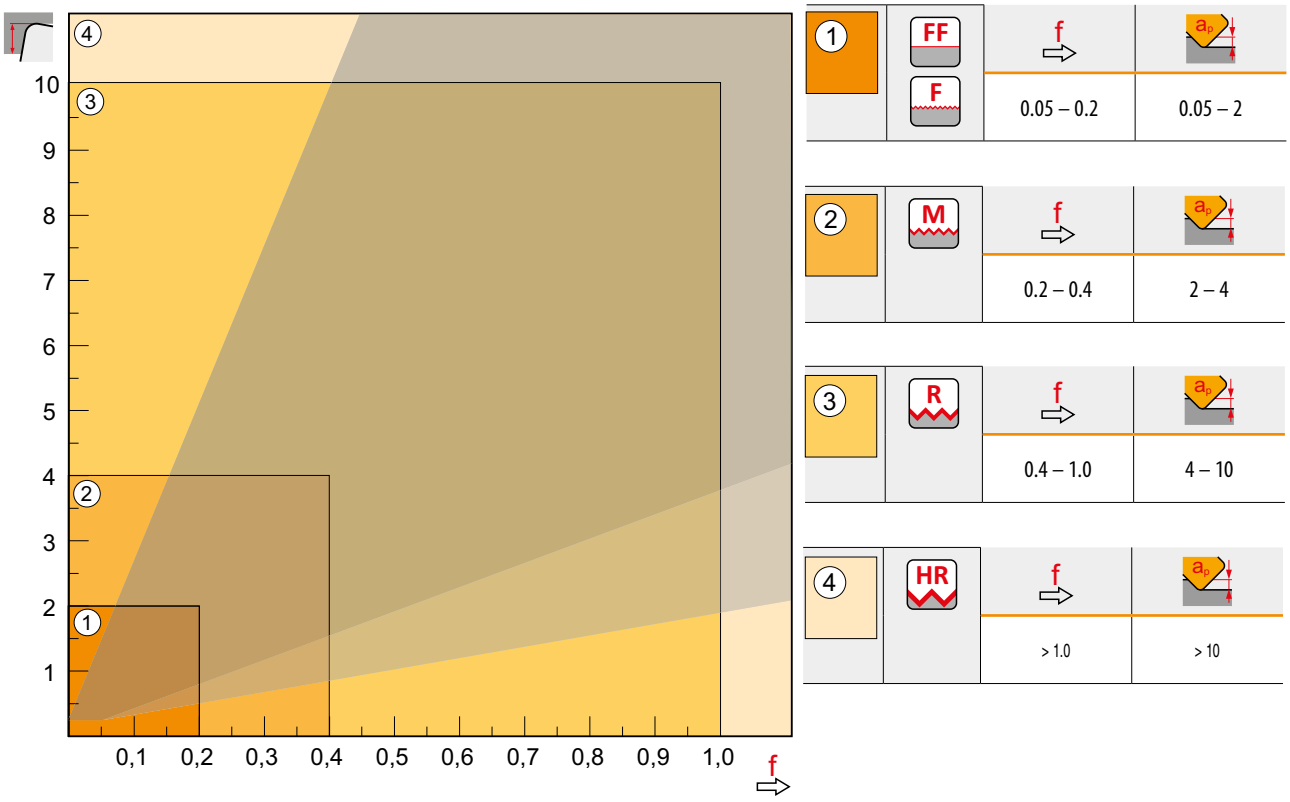


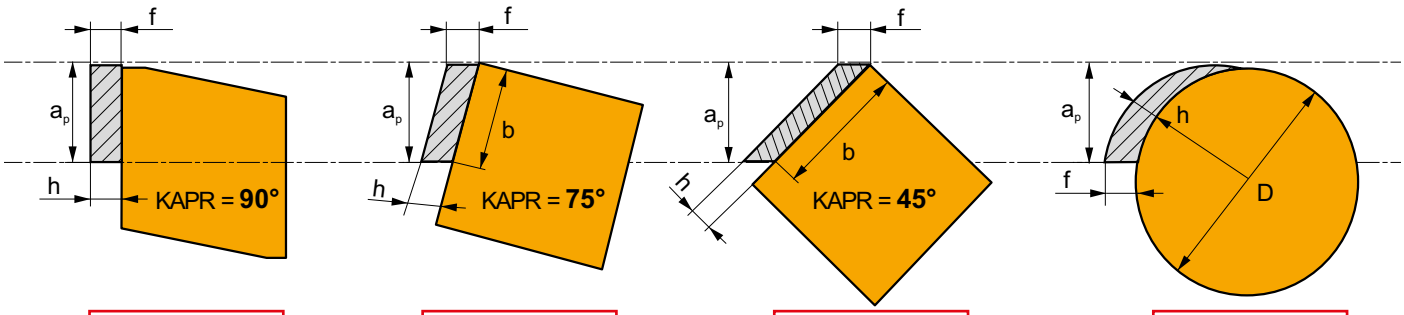
如果进给量“f”更大（厚度大于“a”的深度，并且x < a（f），切屑进入断屑槽，并以特定的半径R弯曲（见图）。



如果x远远小于a（见图），说明切屑过度变形（切屑被挤压）。如果切屑没有进入断屑槽，将不会被切碎。

所有断屑槽都在限定的切削工况范围内起作用。因此，断屑区域显示为连续的范围，以便定义最常用的切屑深度与进给量组合（见下图）。断屑槽应用范围也会重叠。





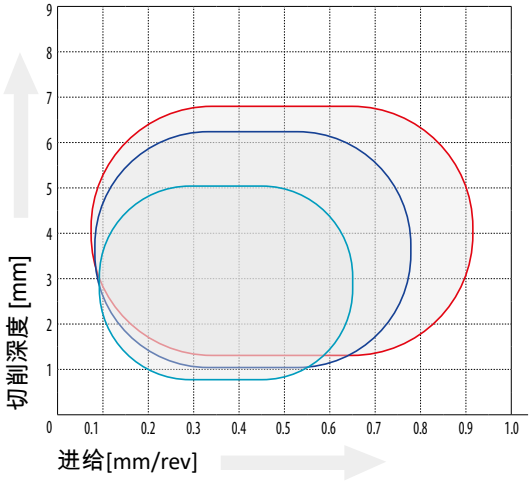
$h = f$ | $h = 0.96 \cdot f$ | $h = 0.71 \cdot f$ | $h = 0 - f$

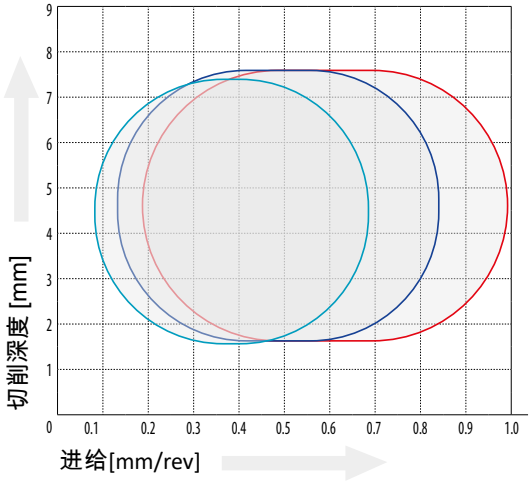
切削深度和进给量的最佳组合因材料不同而异。下表列出了最佳比率 (b (切屑宽度) 与h (切屑厚度) 之比) 的范围。接近90°的调节角度实际上是切割深度与进给量的比值。见图。

		min b/h	max b/h	
P		5	15	
M		8	12	
K		3	30	
N		9	11	
S	方形切屑 b=h	8	12	条形切屑 b/h > 30
H		5	20	

从表中可知 , 在选择切削工况时 , 应避免方形切屑 , 即切屑宽度与厚度接近的切屑 ; 而条形切屑代表高切削深度与低进给量的组合。
如上表所示 , 有色金属合金的切屑最容易出问题 , 特别是含有低硅成分或不含低硅成分的铝合金。其次是高温合金和不锈钢 (特别是奥氏体不锈钢和精炼钢) 。最后是钢 , 而最好的加工材料是硬化材料和铸铁。

还请谨记，如果增加切削刃长度（刀片尺寸），切屑形成图会向更高的切削深度略微（向上）移动，而增加半径则会向更高进给量（向右）移动。





- 刀片内切圆直径IC = 19.050 [mm]
- 刀片内切圆直径IC = 15.875 [mm]
- 刀片内切圆直径IC = 12.700 [mm]

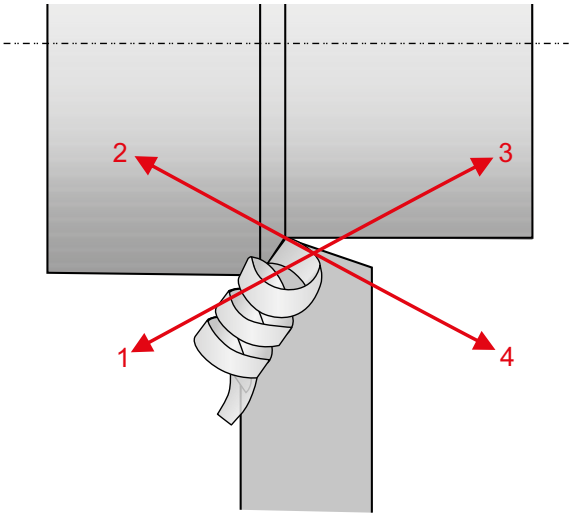
- 刀尖半径RE = 1.6 [mm]
- 刀尖半径RE = 1.2 [mm]
- 刀尖半径RE = 0.8 [mm]

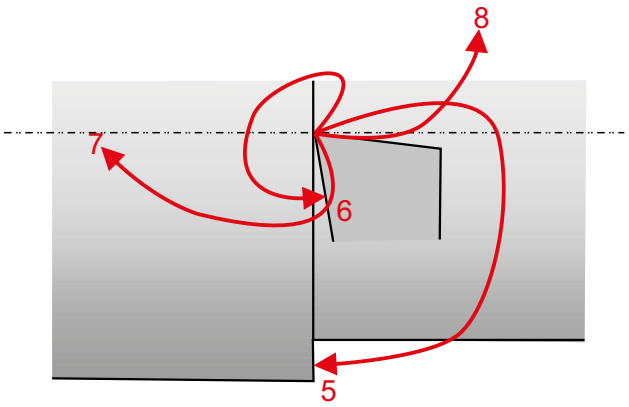
除了切屑形状之外，排屑方向也很重要。下图显示了排屑的基本方向：

1 – 从工件进给方向排出，
2 – 向工件进给方向排出，
3 – 向工件进给方向反向排出，
4 – 从工件进给方向反向排出，

显然不能选择可能导致损坏或划伤加工表面的方向。

5 – 在切削区域表面破碎，
6 – 在刀具侧面破碎，
5 – 在正在加工的表面破碎，
5 – 在已加工的表面破碎，





下面的章节中明确规定了我们在结构分组中为您提供的所有槽型。这些表格能够帮助您作出最佳且更准确的选择。

正前角刀片 夹紧机构名称ISO S	📖
371 (RCMT)	565
372 (RCMT)	565
...W	565
AL	565
DR4 (SCMT)	566
FF	566
FF2	566
FM	566
FM (RCMT)	567
FM2	567
NF1	567
NF2	567
OR (SCMT)	568
RF	568
RM	568
RM3	568
SF2	569
SF3	569
SI	569
SR (SCMT)	569
UR (RCMT)	570
UR	570
W-FM	570
W-UR	570
46	571
47	571
48	571
61	571
.PUN	572

正前角刀片 夹紧机构名称ISO P、M、D	📖
31 (RCMX)	573
321 (RCMX)	573
331 (RCMX)	573
361 (RCMX)	573
RF1 (RCMX)	574
RM1 (RCMX)	574
RM2 (RCM.)	574
RR2 (RCM.)	574

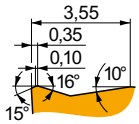
负前角刀片 夹紧机构名称ISO P、M、D	📖
000 (LNUX)	575
002 (LNUX)	575
003 (LNUX)	575
08 (RNMG)	575
81 (RNMG)	576
432 (LNMX)	576
923	576
...A	576
DR	577
FF	577
FM	577
HR	577
HR2	578
KR	578
M	578
NF	578
NM	579
NMR	579
NR	579
NRM	579
NR2	580
OR	580
OR1	580
R	580
RM	581
SF	581
SI	581
SM	581
SR	582
W-MR	582
W-F	582
W-M	582
W-NM	583

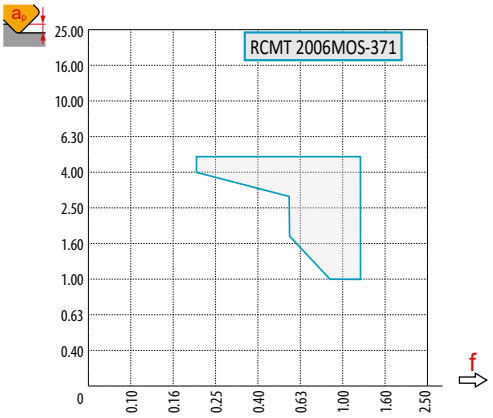
负前角刀片 夹紧机构名称ISO C	📖
22	584
32	584
72	584
73	584
74	585

切削的槽型 切槽刀片 夹紧机构名称ISO X和G	📖
GM (GL.D)	586
MM (GL.D)	586
PM (GL. D)	586
PR (GL. D)	586
13 CM (LCMF)	587
13 F (LCM.)	587
13 MP (LCM.)	587
16 CM (LCM.)	587
16 F (LCM.)	588
16 M (LCM.)	588
16 MP (LCM.)	588
20 F1 (LCMF)	588
20 M2 (LCMF)	589
30 F (LCM.)	589
F1 (LFMX)	589
F2 (LFMX)	589
M2 (LFMX)	590
LFUX	590
TN. EXT	591
TN. INT	591
X61	591
X61 R	591

371 (RCMT)







P	M	K	N	S	H
■		■			

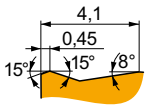
f ⇨ 0.20 – 1.20

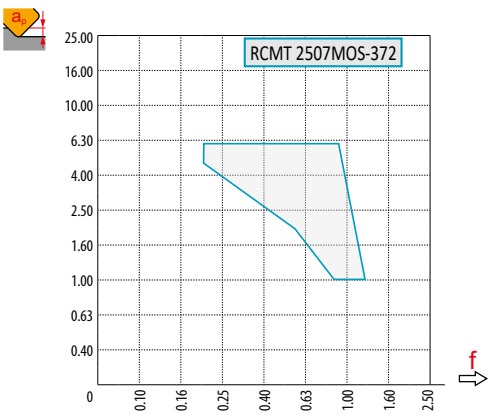
a_p 1.0 – 5.0

RCMT

372 (RCMT)







P	M	K	N	S	H
■		■			

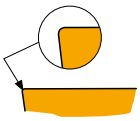
f ⇨ 0.20 – 1.20

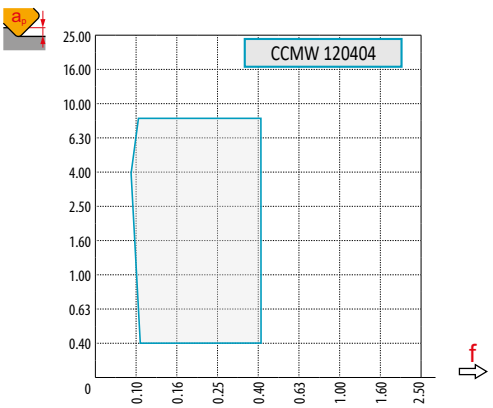
a_p 1.0 – 6.0

RCMT

...W







P	M	K	N	S	H
		■			◪

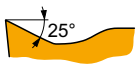
f ⇨ 0.05 – 0.60

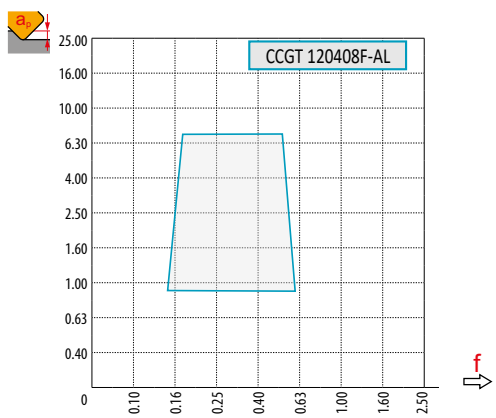
a_p 0.4 – 8.4

CCMW, DCMW, SCMW, RCMW, TCMW, VCMW

AL







P	M	K	N	S	H
			■	◪	

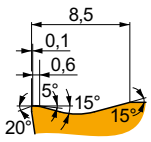
f ⇨ 0.05 – 0.60

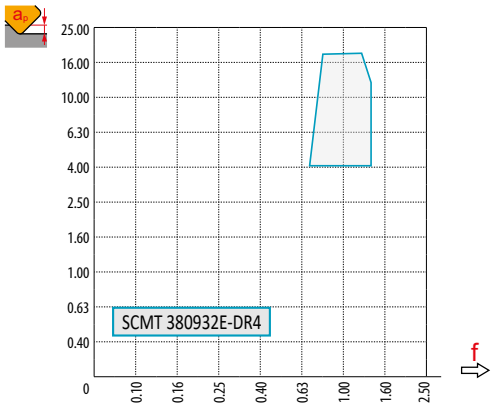
a_p 0.2 – 7.0

CCGT, DCGT, SCGT, RCGT, TCGT, VCGT, WCGT

DR4 (SCMT)



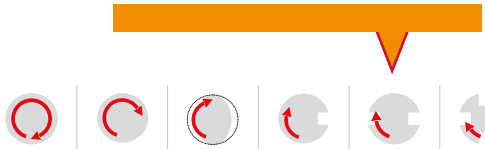




P	M	K	N	S	H
■	◪	■			

f ⇨ 0.70 – 1.40

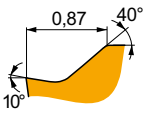
a_p 4.0 – 18.0

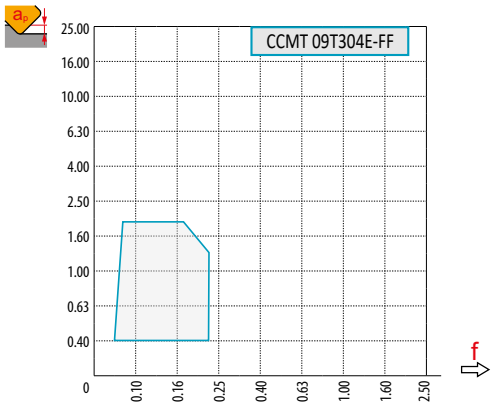


SCMT

FF



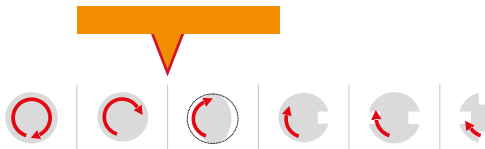




P	M	K	N	S	H
■	◪				

f ⇨ 0.05 – 0.23

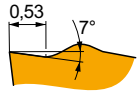
a_p 0.2 – 2.0

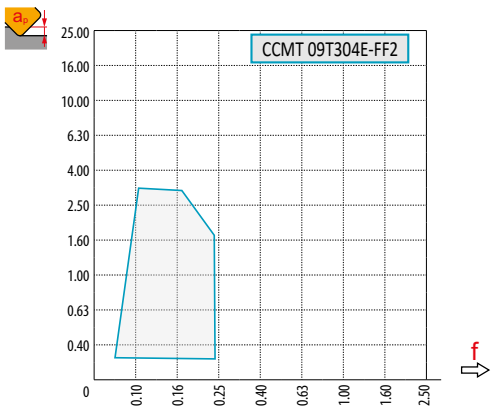


CCMT, DCMT

FF2



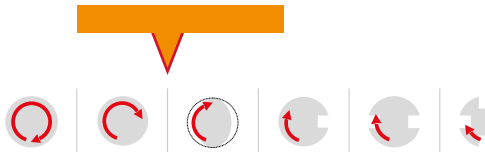




P	M	K	N	S	H
■		■			

f ⇨ 0.02 – 0.28

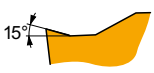
a_p 0.20 – 3.0

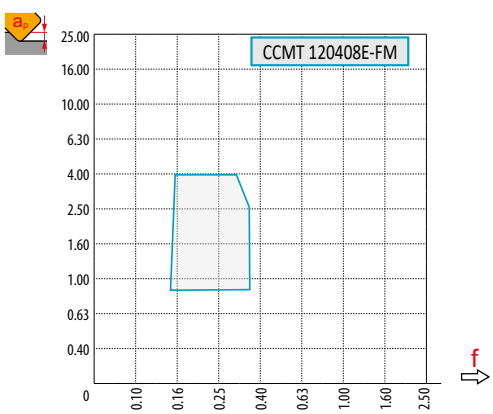


CCMT, CCGT, DCGT, DCMT, SCMT, TCGT, TCMT, VBMT, VCGT, VCGX, WCGT

FM







P	M	K	N	S	H
■	■	◪	◪		

f ⇨ 0.05 – 0.45

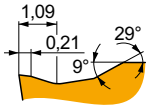
a_p 0.2 – 4.0

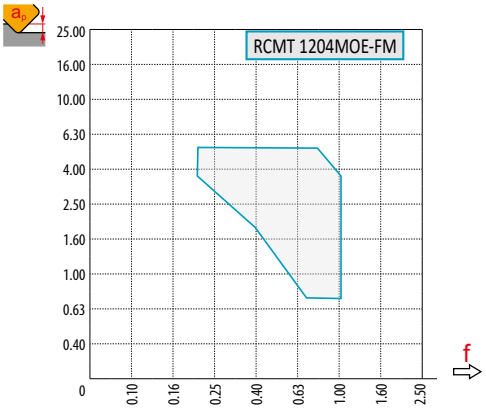


CCMT, DCMT, SCMT, TCMT, VBMT, WCMT

FM (RCMT)







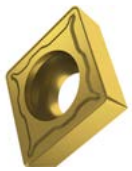
P	M	K	N	S	H
■	■	◪	◪		

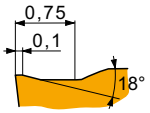
f ⇨ 0.10 – 1.0

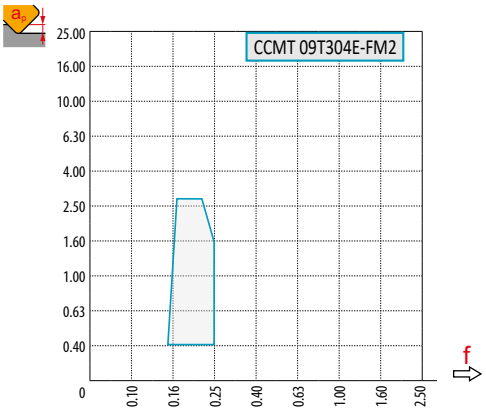
a_p 0.3 – 5.0

RCMT

FM2







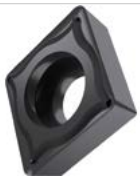
P	M	K	N	S	H
■	◪	■			

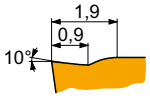
f ⇨ 0.04 – 0.4

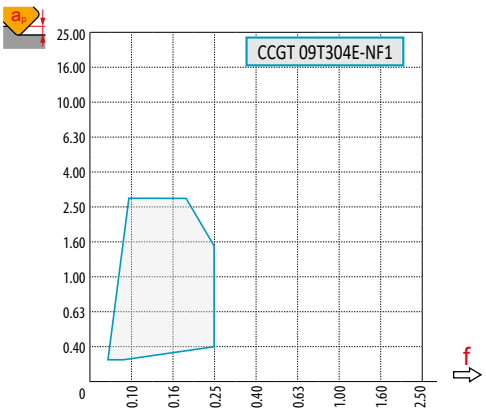
a_p 0.2 – 4.0

CCMT, DCMT, ECMT, SCMT, TCMT, VBMT, VCGT

NF1







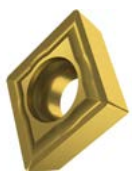
P	M	K	N	S	H
■	■		◪	■	◪

f ⇨ 0.04 – 0.35

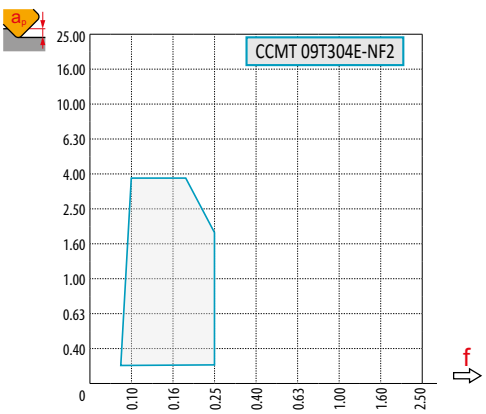
a_p 0.3 – 3.5

CCGT, DCGT, SCGT, TCGT

NF2







P	M	K	N	S	H
◪	■	◪	◪	■	

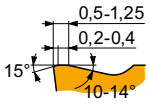
f ⇨ 0.05 – 0.45

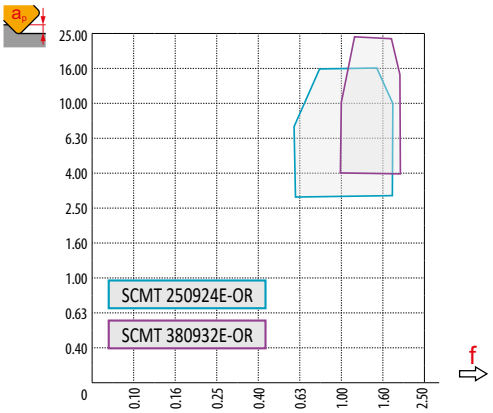
a_p 0.2 – 4.0

CCMT, EPMT, SCMT, TCMT, VCGT

OR (SCMT)







P	M	K	N	S	H
■	■	■		◪	

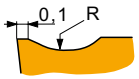
f ⇨ 0.60 – 2.00

a_p 3.0 – 24.0

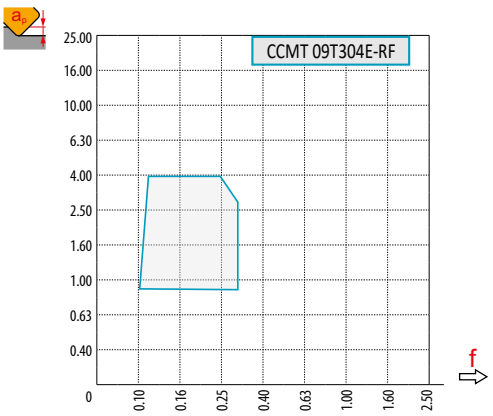
SCMT

RF





I.C.	R
6,35	1,0
9,525	1,5
12,7	2,5



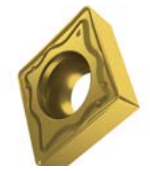
P	M	K	N	S	H
■	◪	■			◪

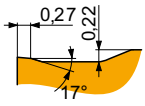
f ⇨ 0.10 – 0.60

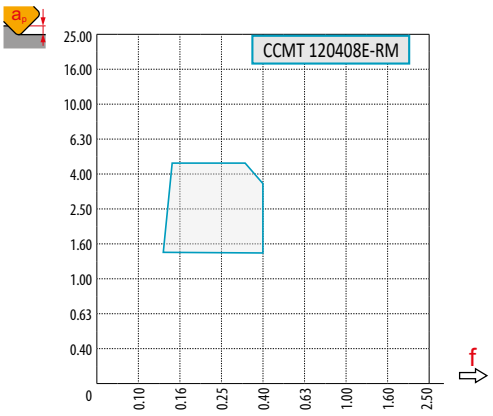
a_p 0.8 – 8.0

CCMT, DCMT, SCMT, TCMT, WCMT

RM







P	M	K	N	S	H
■	■	■		◪	◪

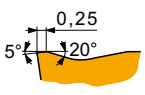
f ⇨ 0.10 – 0.50

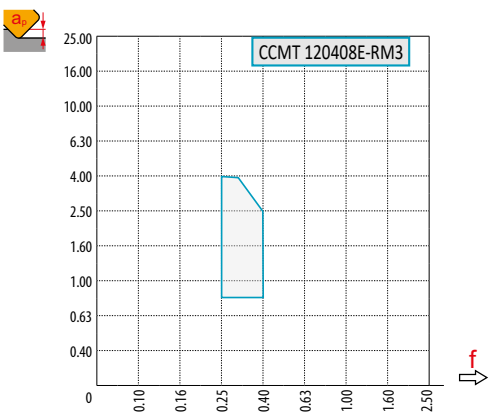
a_p 0.8 – 4.5

CCMT, DCMT, SCMT, TCMT, VBMT

RM3







P	M	K	N	S	H
■	◪	■			◪

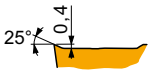
f ⇨ 0.15 – 0.90

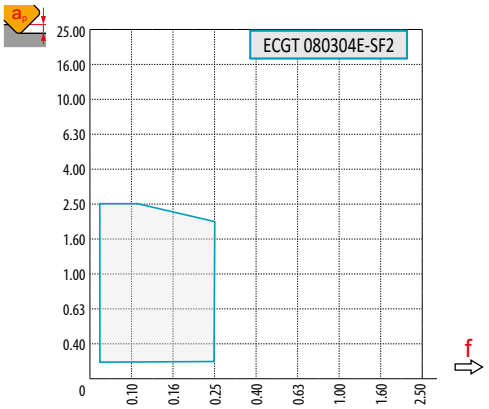
a_p 0.4 – 6.00

CCMT, SCMT, TCMT, RCMT

SF2







P	M	K	N	S	H
◪	■		◪	■	

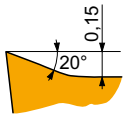
f ⇨ 0.02 – 0.28

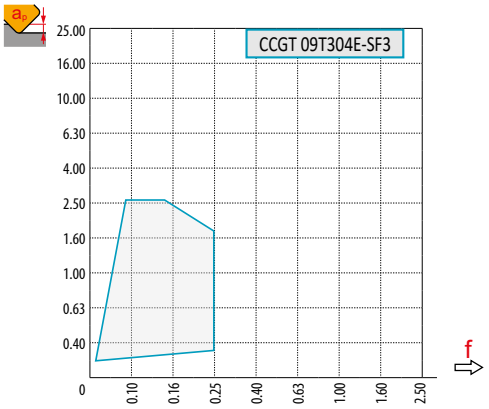
a_p 0.1 – 2.5

ECGT, VCGT

SF3







P	M	K	N	S	H
◪	■	◪	■	■	◪

f ⇨ 0.02 – 0.35

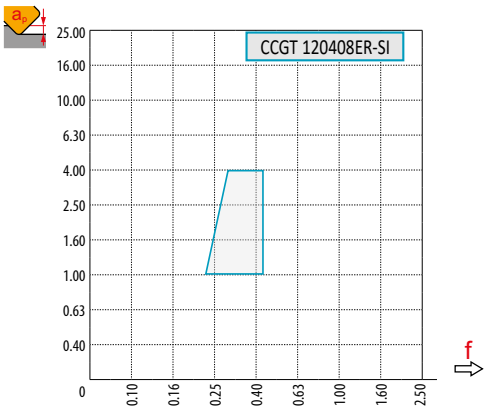
a_p 0.2 – 4.00

CCGT, DCGT, ECGT, SCGT, TCGT, VCGT

SI







P	M	K	N	S	H
■	■	◪		■	

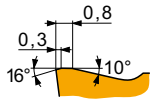
f ⇨ 0.08 – 0.45

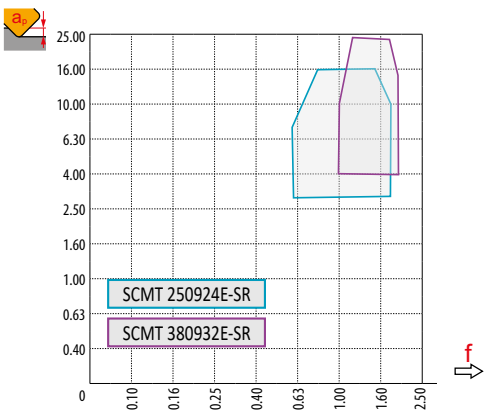
a_p 0.4 – 4.0

CCGT, TCGT

SR (SCMT)







P	M	K	N	S	H
■	■	■			

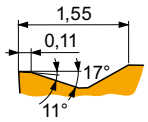
f ⇨ 0.60 – 2.0

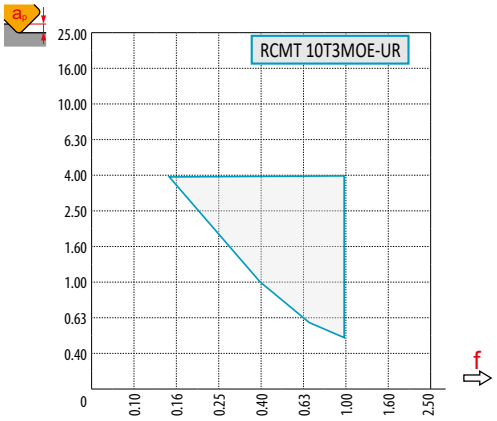
a_p 3.0 – 24.0

SCMT

UR (RCMT)







P	M	K	N	S	H
■	◪	■			

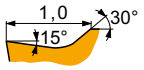
f ⇨ 0.15 – 1.00

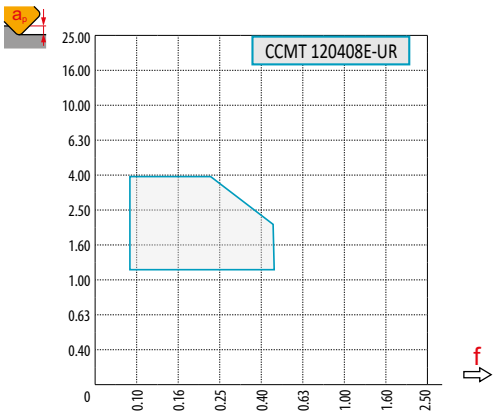
a_p 0.5 – 5.0

RCMT

UR







P	M	K	N	S	H
■	◪	■			

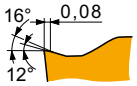
f ⇨ 0.10 – 0.40

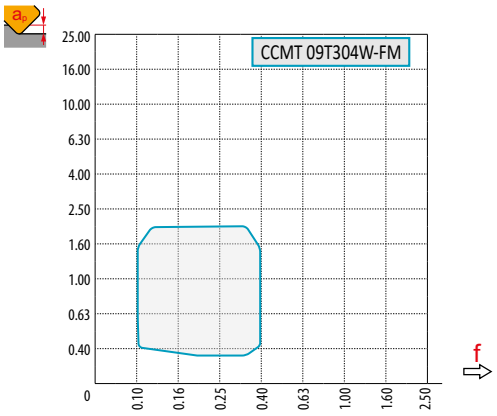
a_p 1.0 – 4.0

CCMT, DCMT, RCMT, SCMT, TCMT, VCMT, VBMT, WCMT

W-FM







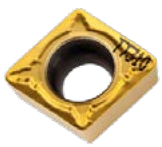
P	M	K	N	S	H
■	■	■			

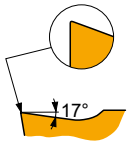
f ⇨ 0.1 – 0.4

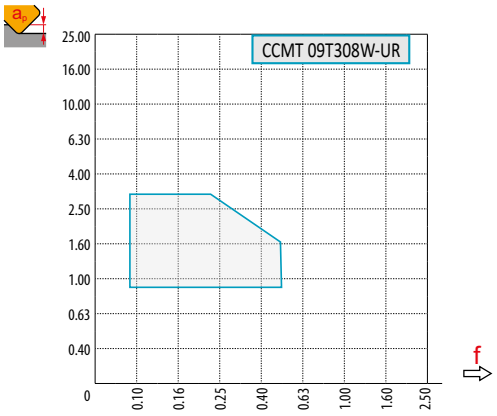
a_p 0.3 – 3.0

CCMT, DCMX

W-UR







P	M	K	N	S	H
■	◪	■			

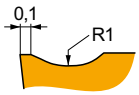
f ⇨ 0.08 – 0.5

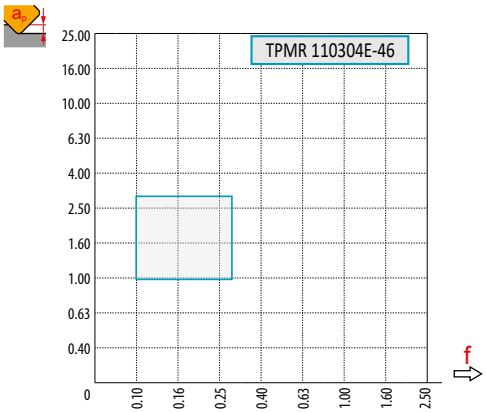
a_p 0.4 – 3.0

CCMT

46







P	M	K	N	S	H
■	◪	■			

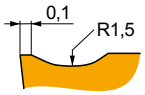
f ⇨ 0.10 – 0.30

a_p 1.0 – 3.0

SPMR, TPMR

47







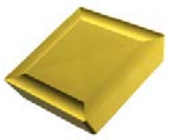
P	M	K	N	S	H
■	◪	■			

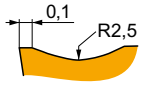
f ⇨ 0.10 – 0.40

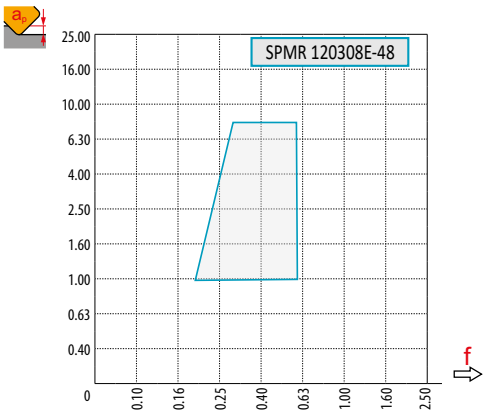
a_p 0.8 – 4.0

TPMR

48







P	M	K	N	S	H
■	◪	■			

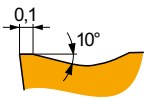
f ⇨ 0.20 – 0.60

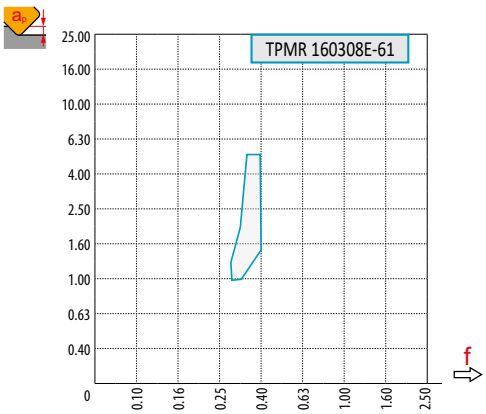
a_p 1.0 – 8.0

SPMR

61







P	M	K	N	S	H
■	◪	■			

f ⇨ 0.30 – 0.40

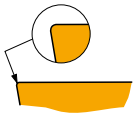
a_p 1.0 – 5.3

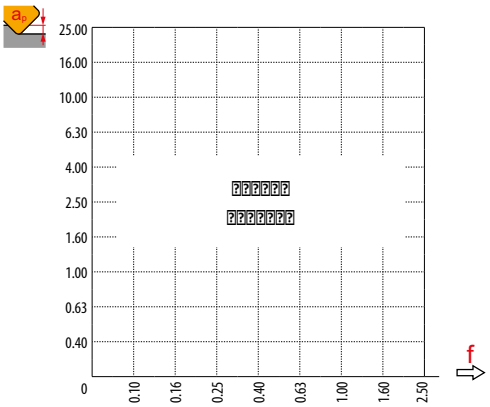
TPMR

正前角刀片切削槽型 – 夹紧机构名称ISO C

.PUN







P	M	K	N	S	H
◪		■			◪

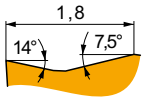
f ⇨	0.10 – 0.60
a_p	0.4 – 1.5

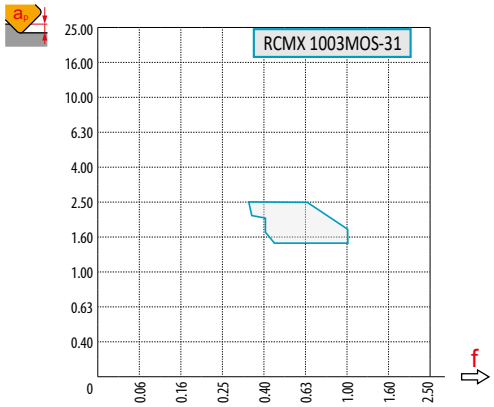


TPUN, SPUN

31 (RCMX)







P	M	K	N	S	H
■	◪	■			

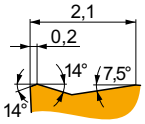
f ⇨ 0.40 – 1.00

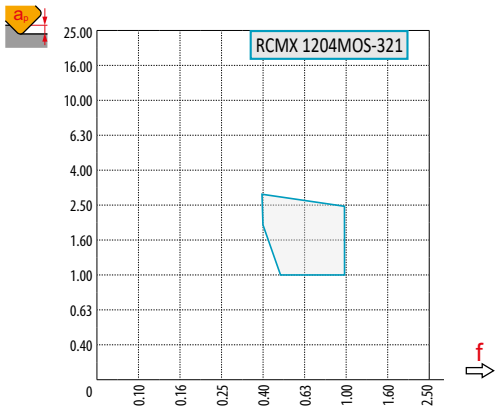
a_p 1.5 – 2.5

RCMX

321 (RCMX)







P	M	K	N	S	H
■		■			

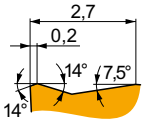
f ⇨ 0.40 – 1.00

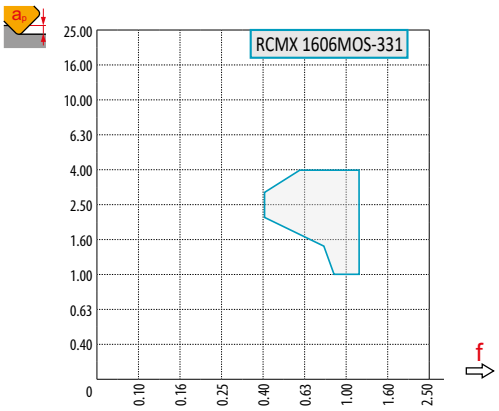
a_p 1.0 – 3.0

RCMX

331 (RCMX)







P	M	K	N	S	H
■		■			

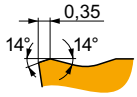
f ⇨ 0.40 – 1.20

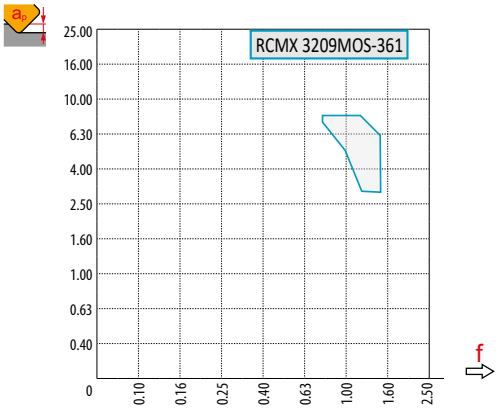
a_p 1.0 – 4.0

RCMX

361 (RCMX)







P	M	K	N	S	H
■		■			

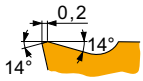
f ⇨ 0.80 – 1.50

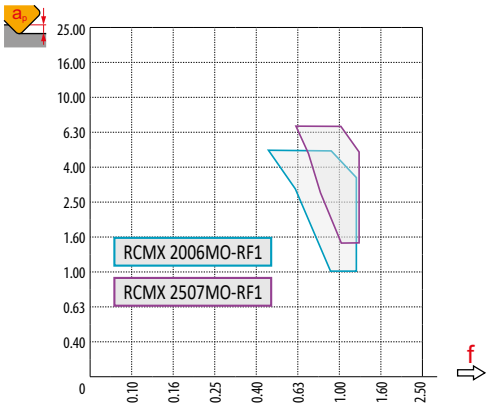
a_p 3.0 – 8.0

RCMX

RF1 (RCMX)







P	M	K	N	S	H
■		◪			

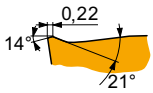
f ⇨ 0.45 (0.60) – 1.20 (1.25)

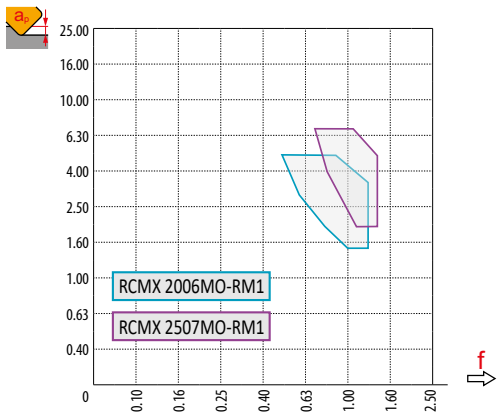
a_p 1.0 (1.5) – 5.0 (7.0)

RCMX 20, RCMX 25

RM1 (RCMX)







P	M	K	N	S	H
■		◪			

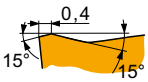
f ⇨ 0.50 (0.70) – 1.30 (1.40)

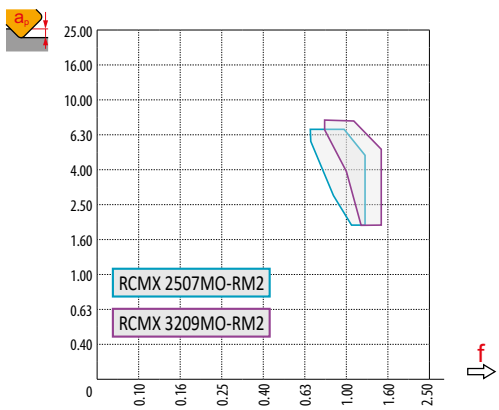
a_p 1.5 (2.0) – 5.0 (8.0)

RCMX 20, RCMX 25

RM2 (RCM.)







P	M	K	N	S	H
■		◪			

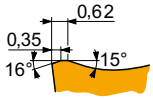
f ⇨ 0.70 (0.80) – 1.30 (1.50)

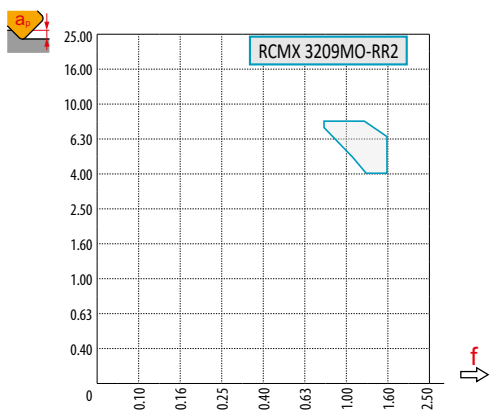
a_p 2.0 – 7.0 (8.0)

RCMX 25, RCMX 32

RR2 (RCM.)







P	M	K	N	S	H
■		■			◪

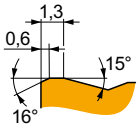
f ⇨ 0.80 – 1.60

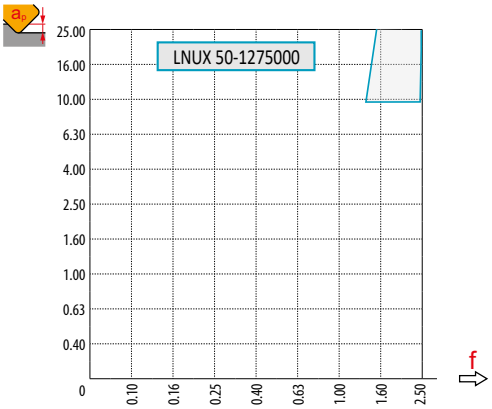
a_p 4.0 – 8.0

RCMX 32

000 (LNUX)







P	M	K	N	S	H
■		■			

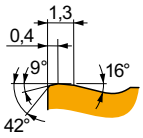
f ⇨ 1.20 – 2.50

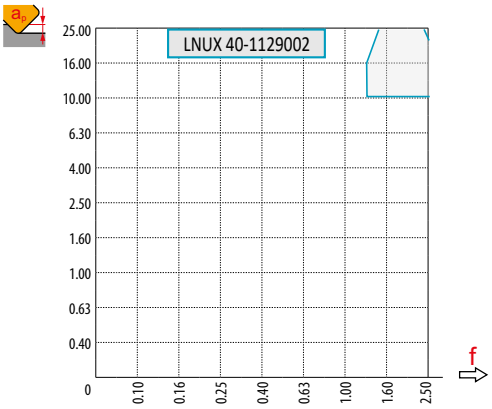
a_p 10.0 – 36.0

LNUX 50

002 (LNUX)







P	M	K	N	S	H
■		■			

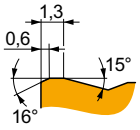
f ⇨ 1.30 – 2.60

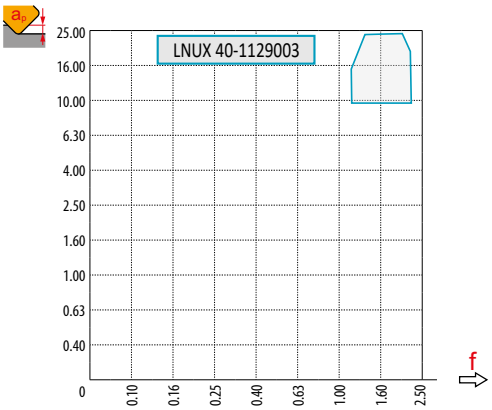
a_p 10.0 – 27.0

LNUX 40

003 (LNUX)







P	M	K	N	S	H
■		■			

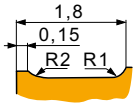
f ⇨ 1.20 – 2.50

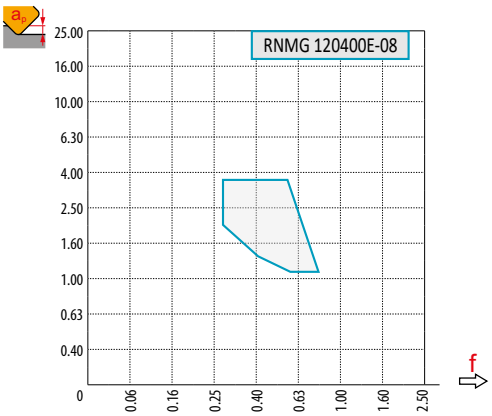
a_p 10.0 – 27.0

LNUX 40

08 (RNMG)







P	M	K	N	S	H
◪		◪			◪

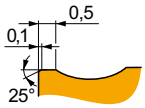
f ⇨ 0.30 – 0.80

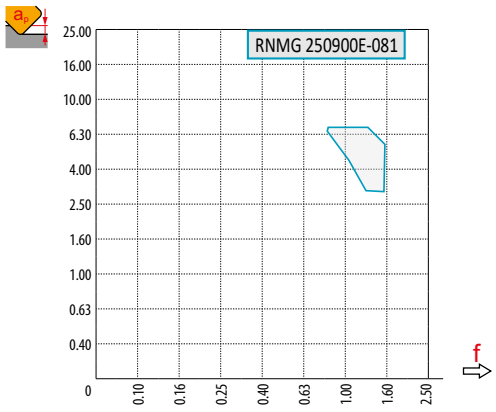
a_p 1.0 – 4.0

RNMG

81 (RNMG)







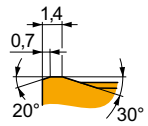
P	M	K	N	S	H
■		■			■

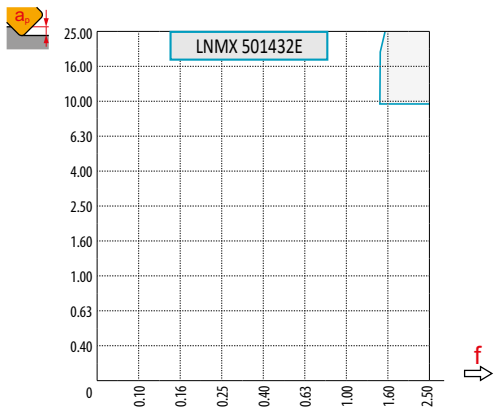
f	0.80 – 1.20
a_p	3.0 – 7.0

RNMG

432 (LNMX)







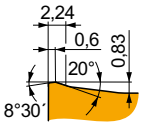
P	M	K	N	S	H
■		■			

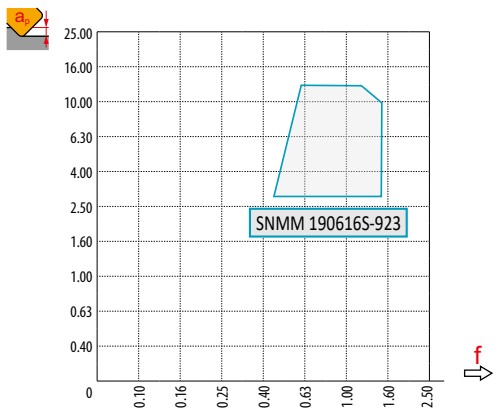
f	1.50 – 2.60
a_p	10.0 – 35.0

LNMX 50

923





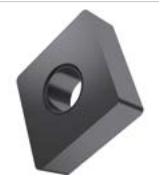


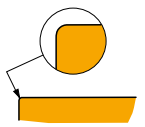
P	M	K	N	S	H
■	■			■	

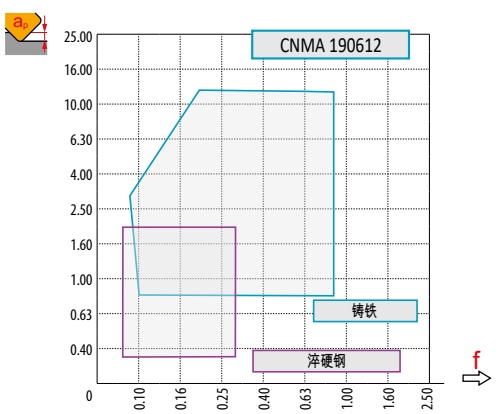
f	0.45 – 1.50
a_p	3.0 – 16.0

CNMM, SNMM

...A







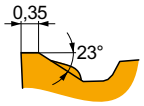
P	M	K	N	S	H
		■			■

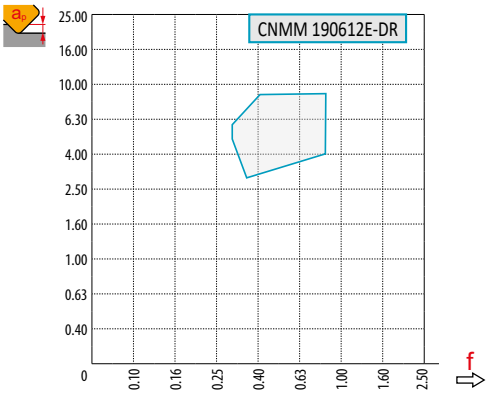
f	0.10 – 1.10
a_p	0.8 – 12.7

CNMA, DNMA, SNMA, TNMA, WNMA

DR



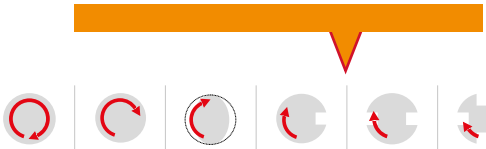




P	M	K	N	S	H
■	◪	◪			

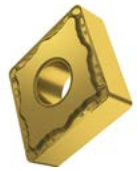
f ⇨ 0.30 – 0.85

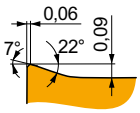
a_p 2.5 – 9.0

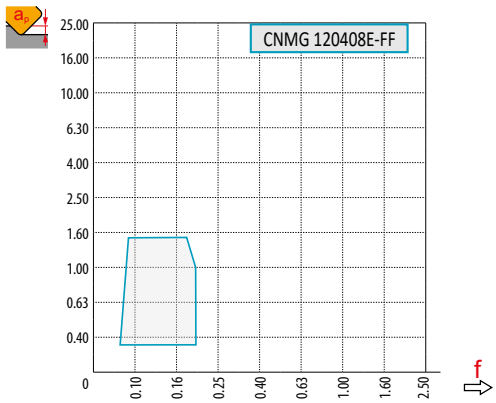


CNMM, DNMM, SNMM, TNMM, WNMM

FF



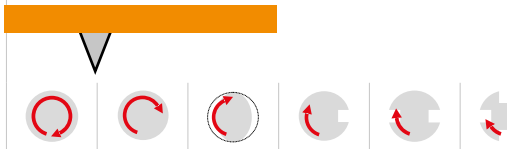




P	M	K	N	S	H
■	■	◪			

f ⇨ 0.06 – 0.25

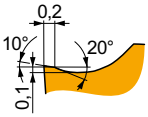
a_p 0.2 – 1.6

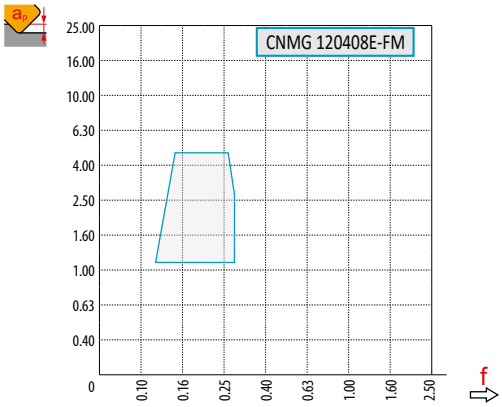


CNMG, DNMG, TNMG, VNMG, WNMG

FM



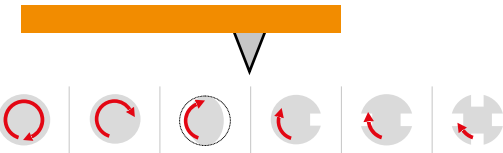




P	M	K	N	S	H
■	◪	■		◪	

f ⇨ 0.1 – 0.5

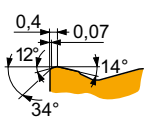
a_p 0.4 – 5.0

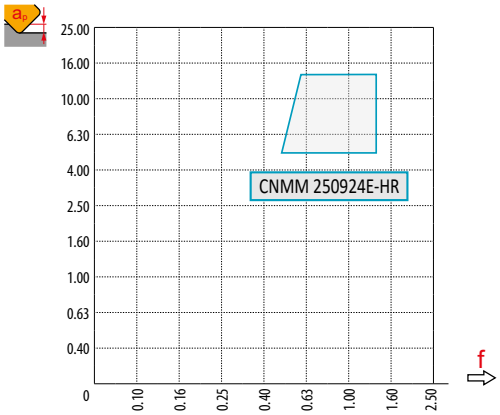


CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

HR







P	M	K	N	S	H
■	◪	■			

f ⇨ 0.50 – 1.40

a_p 5.0 – 14.0

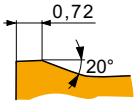


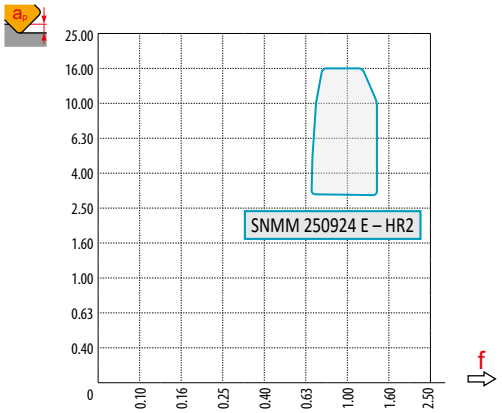


CNMM, SNMM, TNMM

HR2







P	M	K	N	S	H
■	◪	■			

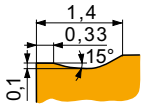
f ⇨ 0.5 – 1.4

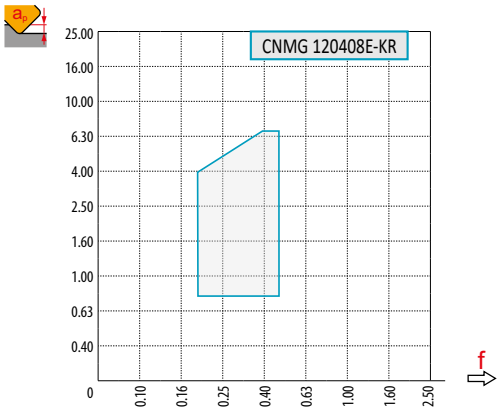
a_p 3.0 – 16.0

CNMM, SNMM

KR







P	M	K	N	S	H
■		■			◪

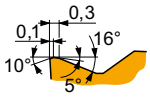
f ⇨ 0.2 – 0.7

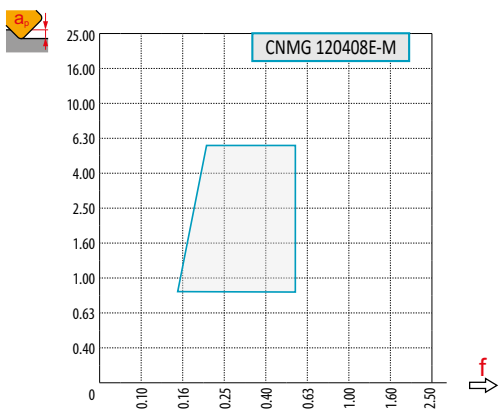
a_p 0.4 – 7

CNMG, SNMG, TNMG, WNMG

M







P	M	K	N	S	H
■		■			◪

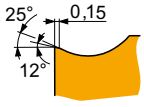
f ⇨ 0.17 – 0.80

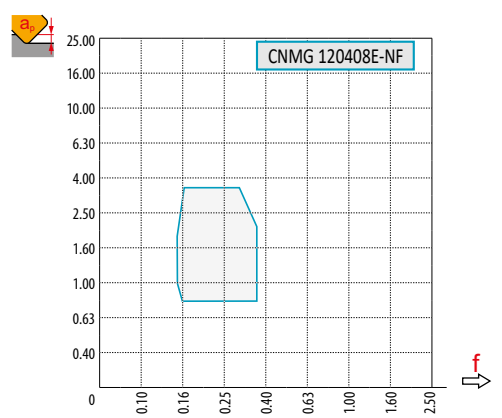
a_p 0.8 – 8.0

CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

NF







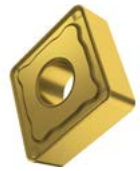
P	M	K	N	S	H
■	■	◪	◪	◪	

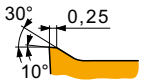
f ⇨ 0.1 – 0.35

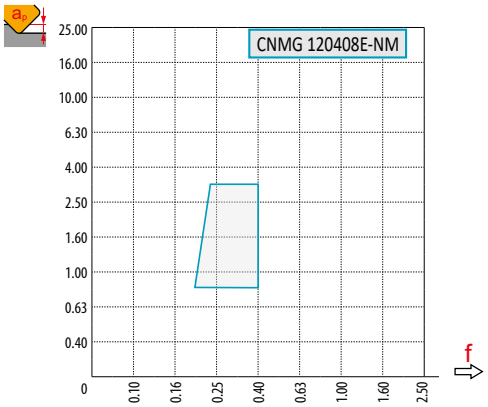
a_p 0.4 – 4.0

CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

NM







P	M	K	N	S	H
■	■		◪	■	

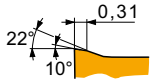
f ⇨ 0.15 – 0.55

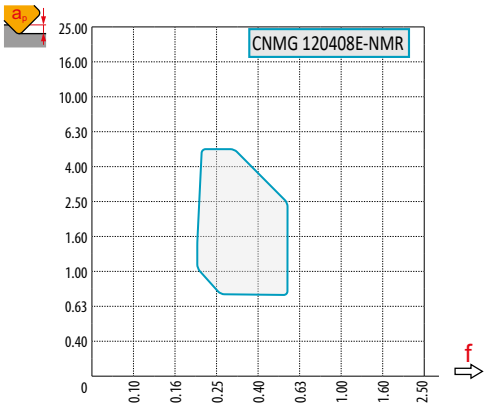
a_p 0.5 – 8.0

CNMG, DNMG, TNMG, VNMG, WNMG

NMR







P	M	K	N	S	H
■	■			■	

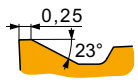
f ⇨ 0.18 – 0.70

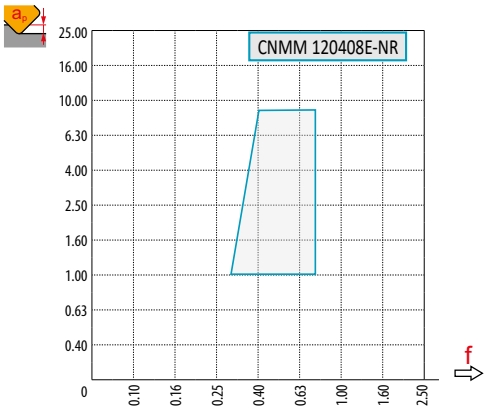
a_p 0.4 – 8.0

CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

NR







P	M	K	N	S	H
■	■	◪		◪	

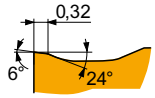
f ⇨ 0.25 – 0.80

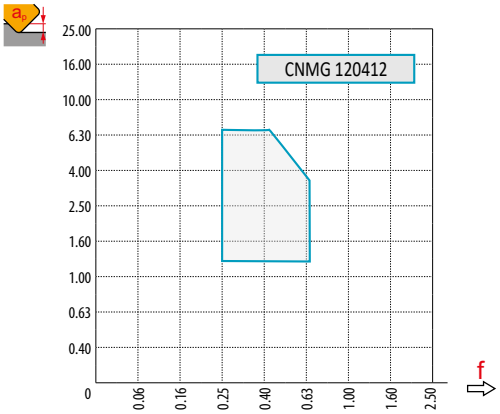
a_p 1.0 – 9.0

CNMM, DNMM, SNMM, TNMM, WNMM

NRM







P	M	K	N	S	H
■	■			■	

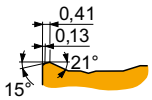
f ⇨ 0.23 – 1.0

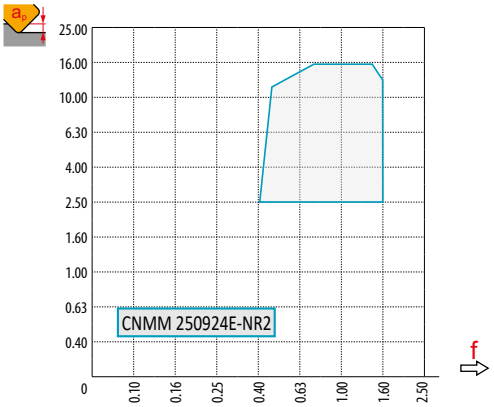
a_p 0.8 – 16.0

CNMG, CNMM, SNMG, SNMM

NR2







P	M	K	N	S	H
■	■	◪		◪	

f ⇨ 0.2 – 1.6

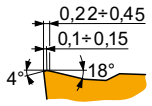
a_p 1.0 – 16.0

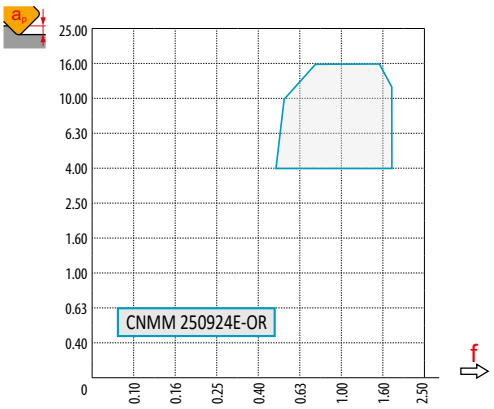


CNMM, DNMM, SNMM, TNMM, WNMM

OR







P	M	K	N	S	H
■	◪	■		◪	

f ⇨ 0.25 – 1.70

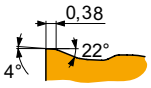
a_p 2.0 – 16.0

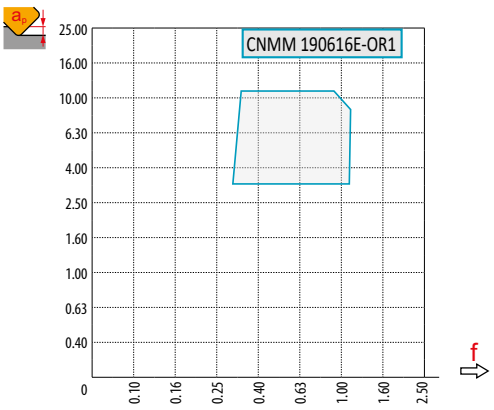


CNMM, DNMM, SNMM, TNMM, WNMM, SCMT

OR1







P	M	K	N	S	H
■	◪	◪		◪	

f ⇨ 0.3 – 1.0

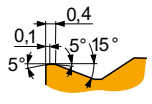
a_p 3.0 – 11.0

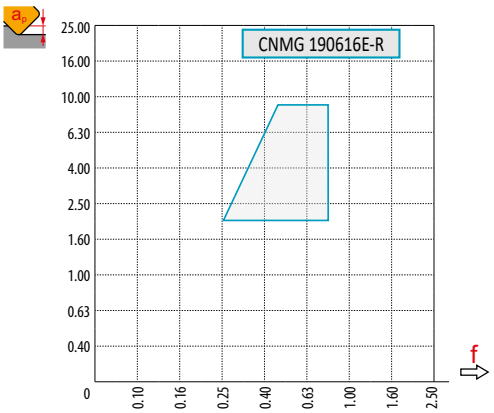


CNMM, SNMM

R







P	M	K	N	S	H
■		■			◪

f ⇨ 0.25 – 0.80

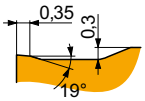
a_p 2.0 – 9.0

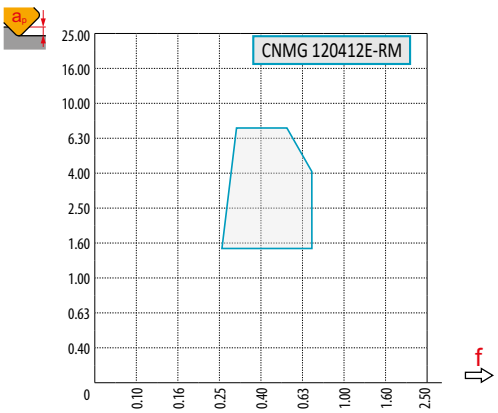


CNMG, DNMG, SNMG, TNMG, WNMG

RM







P	M	K	N	S	H
■	◪	◪			

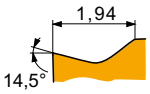
f ⇨ 0.20 – 1.20

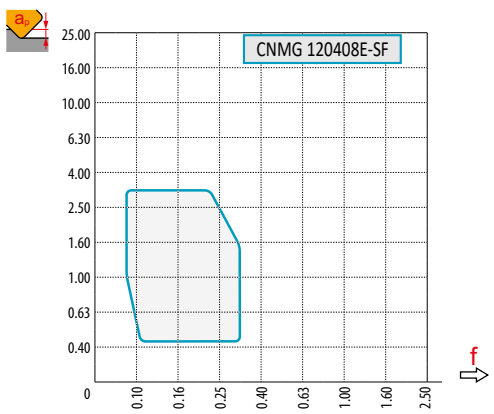
a_p 1.0 – 15.0

CNMG. DNMG, SNMG, TNMG, WNMG

SF







P	M	K	N	S	H
■	■	■	◪	■	■

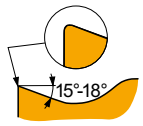
f ⇨ 0.08 – 0.35

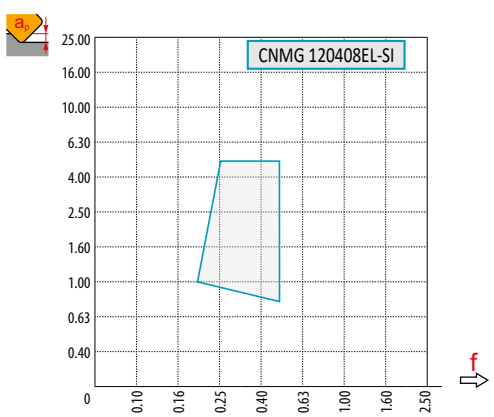
a_p 0.2 – 3.5

CNGG, CNMG, DNMG,
SNMG, TNMG, VNMG, WNMG

SI







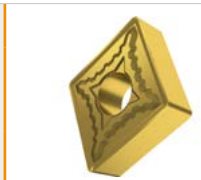
P	M	K	N	S	H
■	■		◪	◪	

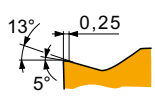
f ⇨ 0.20 – 0.50

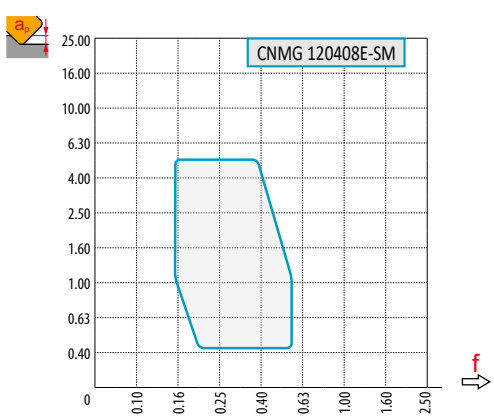
a_p 0.4 – 5.0

CNMG, DNMG, TNMG, WNMG

SM







P	M	K	N	S	H
■	■	■	◪	■	◪

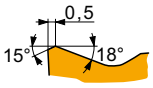
f ⇨ 0.15 – 0.55

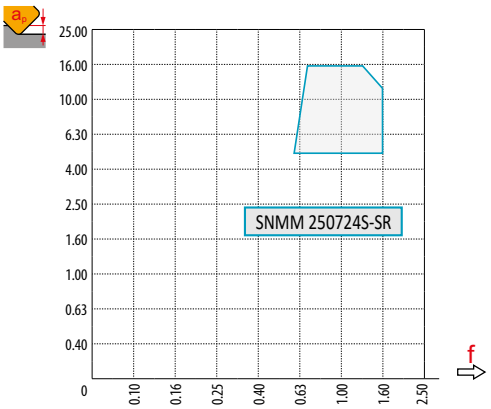
a_p 0.4 – 6.0

CNMG, DNMG, SNMG, TNMG, VNMG, WNMG

SR







P	M	K	N	S	H
■	◪	■			

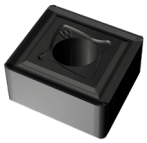
f ⇨ 0.70 – 1.60

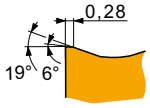
a_p 5.0 – 16.0

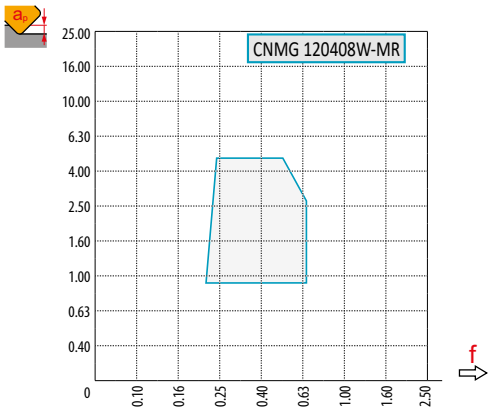


SNMM, SNMX

W–MR







P	M	K	N	S	H
■	◪	◪			

f ⇨ 0.2 – 0.75

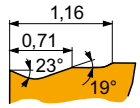
a_p 0.5 – 5.0

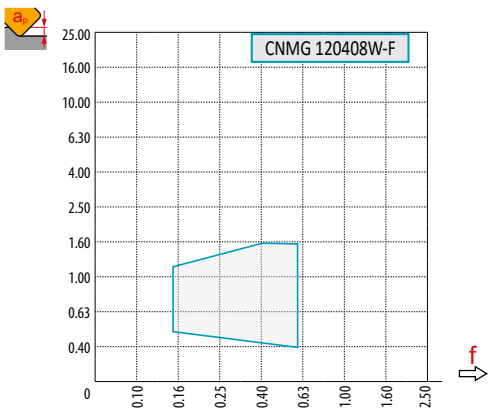


CNMG, WNMG, DNMG

W–F



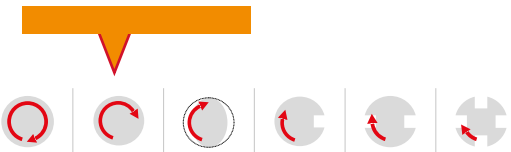




P	M	K	N	S	H
■		■			

f ⇨ 0.10 – 0.60

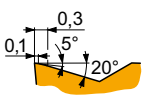
a_p 0.4 – 1.6

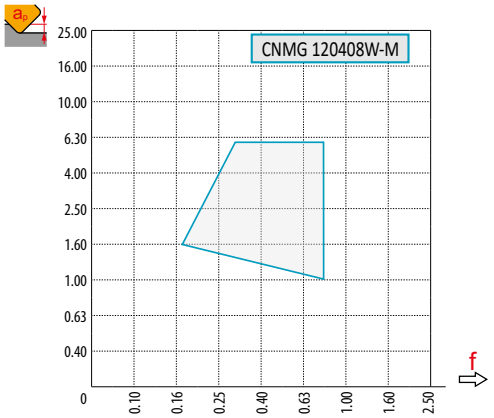


CNMG, WNMG

W–M



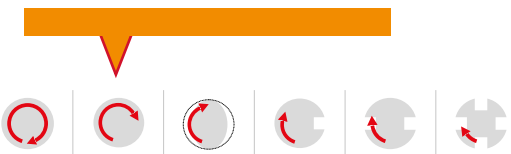




P	M	K	N	S	H
■		◪			

f ⇨ 0.15 – 1.00

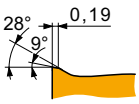
a_p 0.8 – 4.0

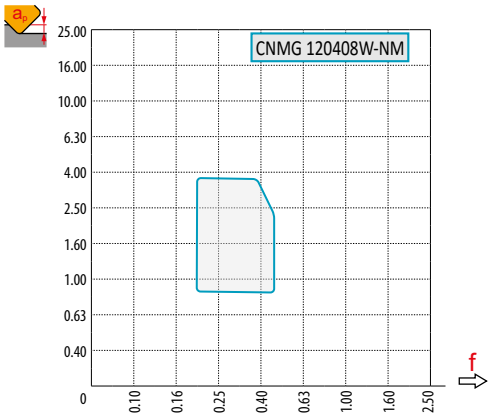


CNMG, WNMG

W-NM

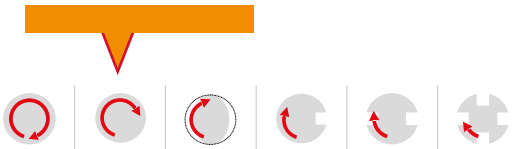






P	M	K	N	S	H
■	◪	◪		◪	

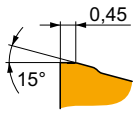
f ⇨	0.15 – 0.55
a_p	0.5 – 3.5

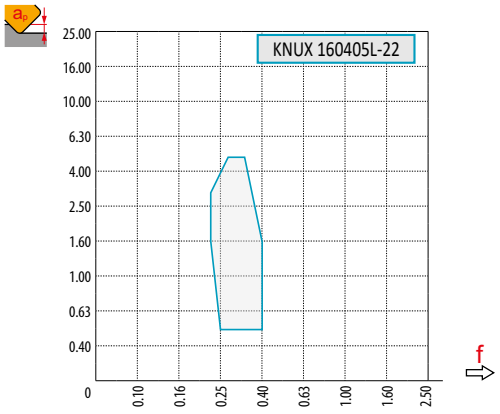


CNMG, DNMX, WNMG

22



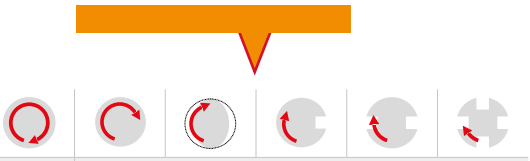


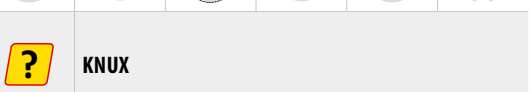


P	M	K	N	S	H
■	◪	◪			

f ⇨ 0.23 – 0.55

a_p 0.50 – 4.80

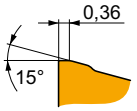


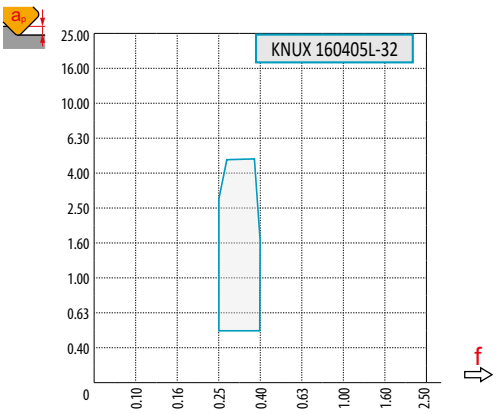


? **KNUX**

32



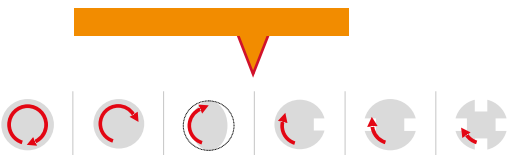




P	M	K	N	S	H
■	◪	◪			

f ⇨ 0.25 – 0.6

a_p 0.50 – 4.80

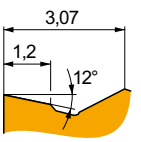


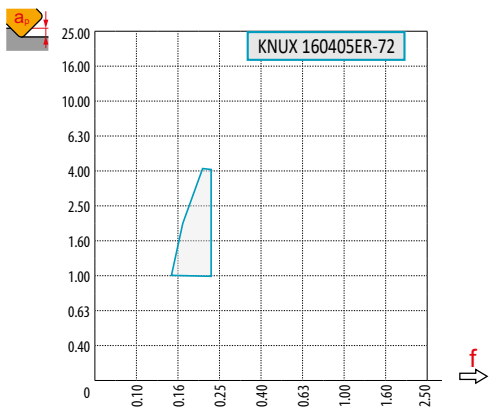


? **KNUX**

72





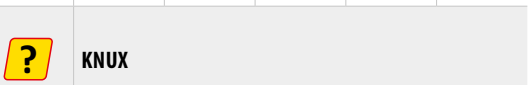


P	M	K	N	S	H
■	◪	■		◪	

f ⇨ 0.15 – 0.23

a_p 1.0 – 4.0

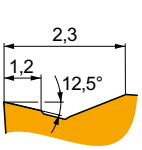


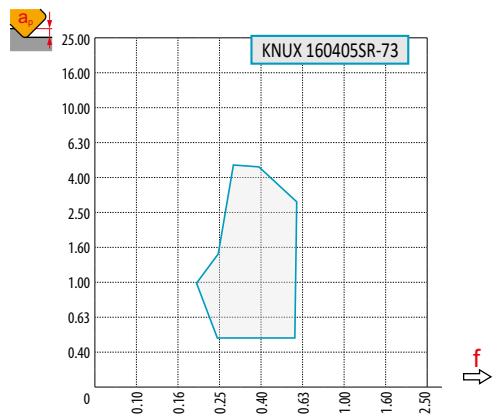


? **KNUX**

73







P	M	K	N	S	H
■	◪	■		◪	

f ⇨ 0.20 – 0.60

a_p 0.5 – 4.8



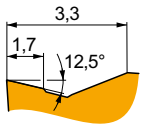


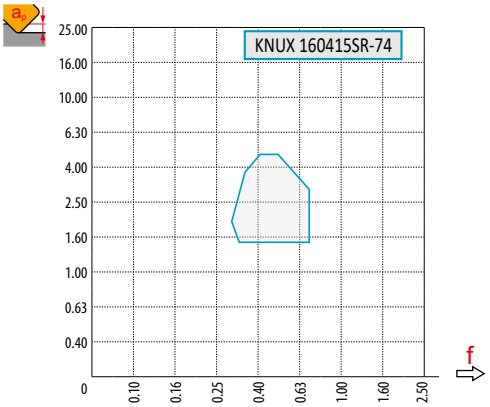
? **KNUX**

负前角刀片切削槽型 – 夹紧机构名称ISO C

74

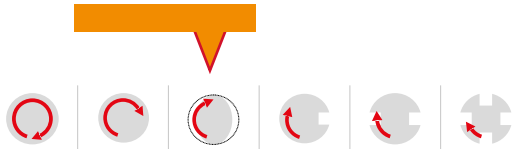






P	M	K	N	S	H
■	◪	■		◪	

f	0.30 – 0.7
a_p	1.5 – 4.8

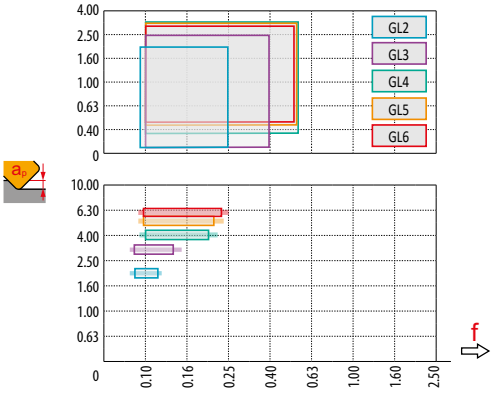


KNUX

GM (GL.D) NEW

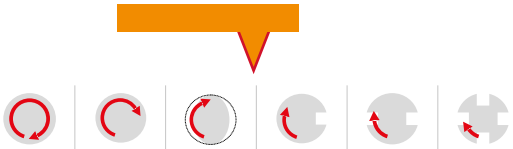






P	M	K	N	S	H
■	■	◪		◪	

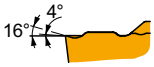
参见示意图

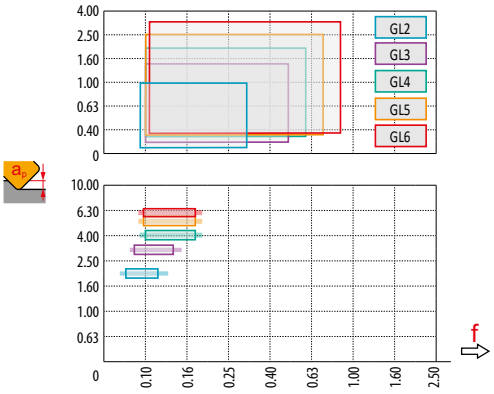


GL. D

MM (GL.D) NEW

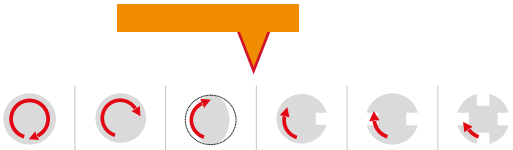






P	M	K	N	S	H
■	■	■		◪	

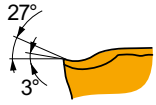
参见示意图

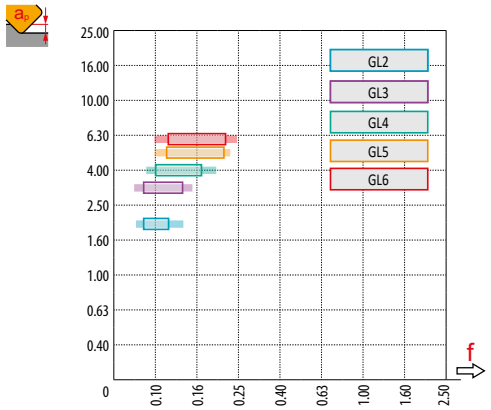


GL. D

PM (GL. D) NEW

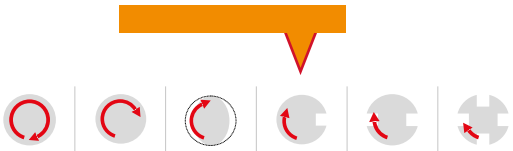






P	M	K	N	S	H
■	■	◪		◪	

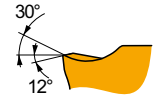
参见示意图

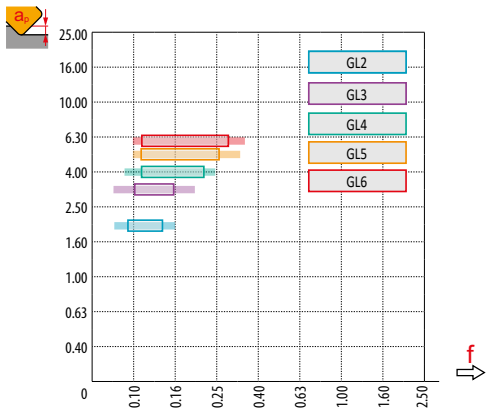


GL. D

PR (GL. D) NEW

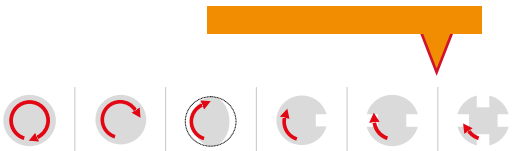






P	M	K	N	S	H
■	◪	■			

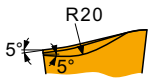
参见示意图

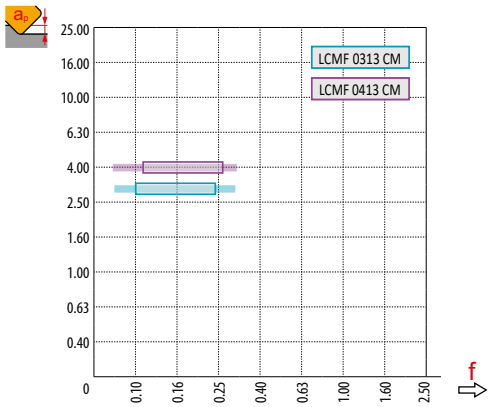


GL. D

13 CM (LCMF)







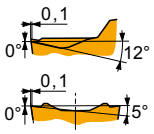
P M K N S H

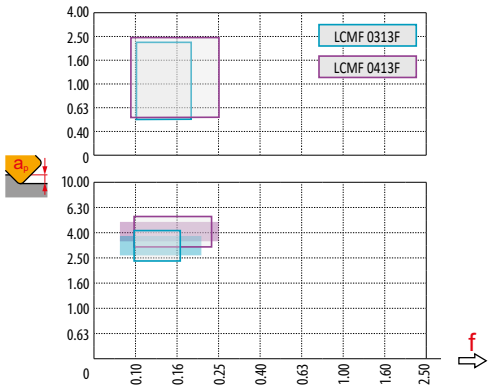
参见示意图

LCMF 13 CM

13 F (LCM.)







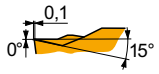
P M K N S H

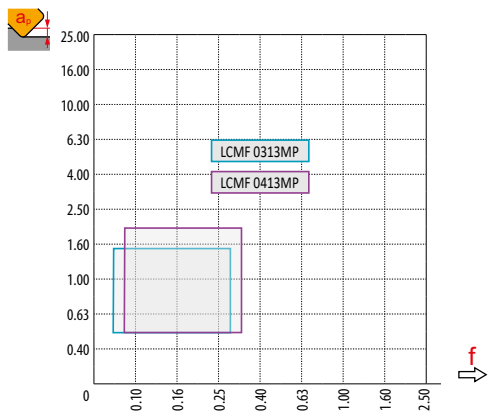
参见示意图

LCMF 13 F, LCMR 13 F

13 MP (LCM.)







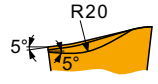
P M K N S H

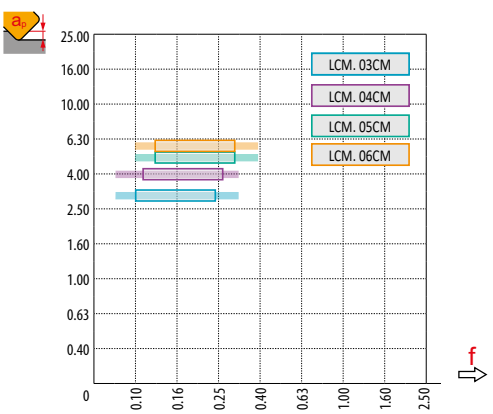
参见示意图

LCMF 13 MP, LCMR 13 MP

16 CM (LCM.)







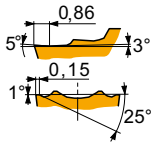
P M K N S H

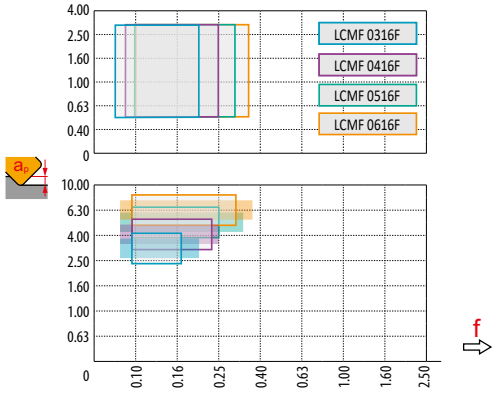
参见示意图

LCMF 16 CM, LCMR 16 CM

16 F (LCM.)







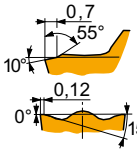
P	M	K	N	S	H
■		◪			

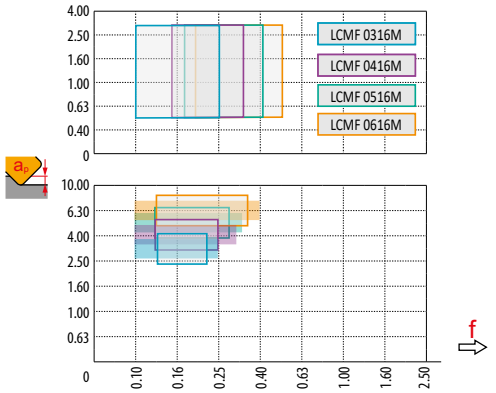
参见示意图

LCMF 16 F, LCMR 16 F

16 M (LCM.)







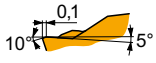
P	M	K	N	S	H
■		■			◪

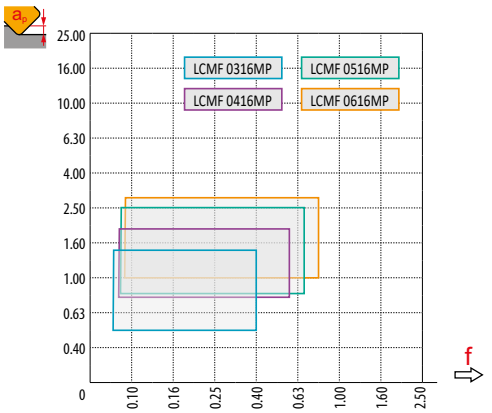
参见示意图

LCMF 16 M, LCMR 16 M

16 MP (LCM.)







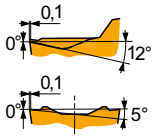
P	M	K	N	S	H
■		■			

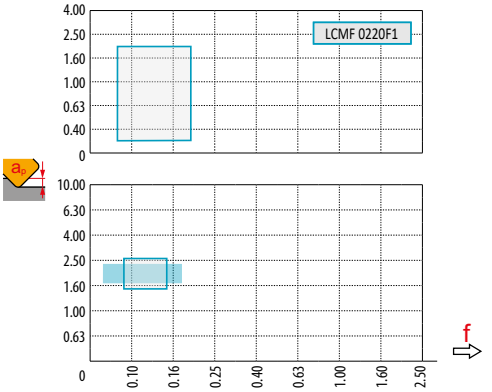
参见示意图

LCMF 16 MP, LCMR 16 MP

20 F1 (LCMF)







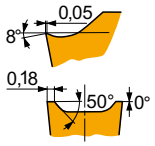
P	M	K	N	S	H
■	◪	◪			

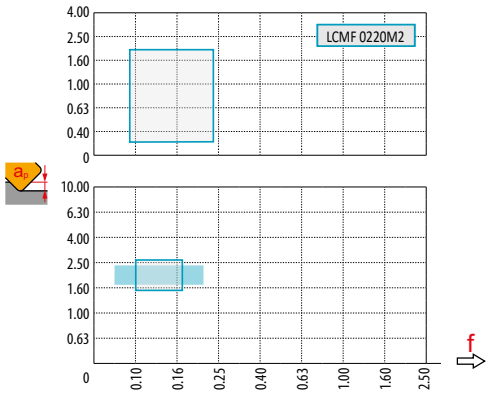
参见示意图

LCMF

20 M2 (LCMF)



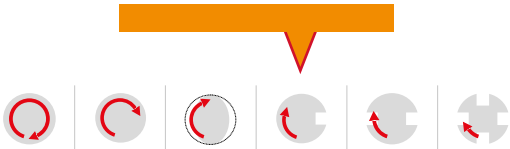




P	M	K	N	S	H
■	◪	◪			

f ⇨ 0.09 – 0.23

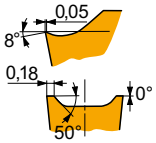
a_p 0.3 – 1.5

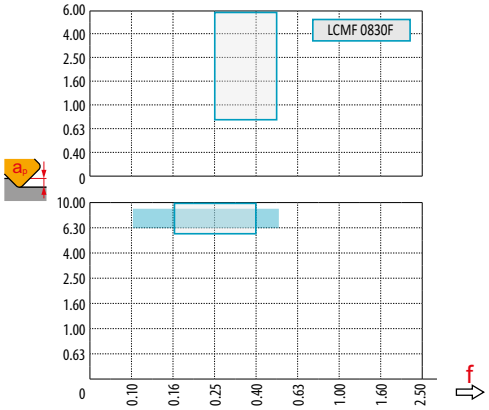


LCMF

30 F (LCM.)



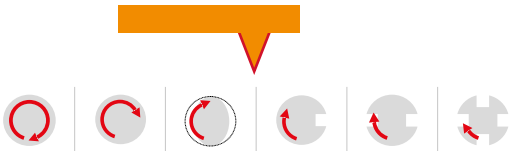




P	M	K	N	S	H
■		◪			

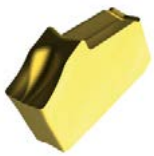
f ⇨ 0.1 – 0.5

a_p 0.8 – 6.0

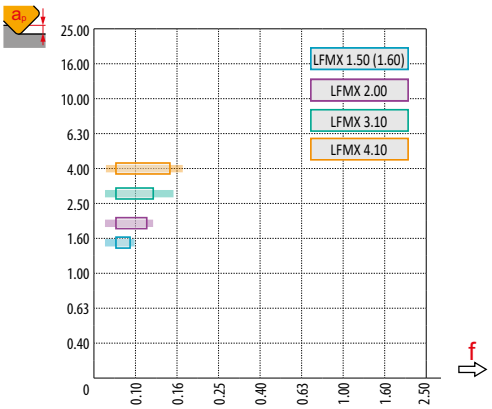


LCMF 30 F, LCMR 30 F

F1 (LFMX)



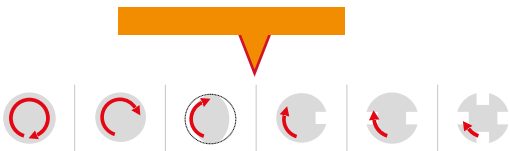




P	M	K	N	S	H
■	◪	■			

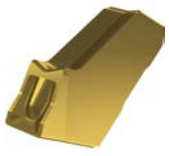
f ⇨ 参见示意图

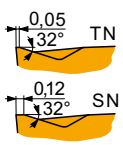
a_p

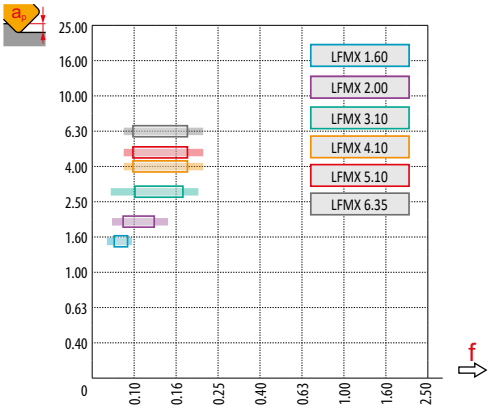


LFMX

F2 (LFMX)



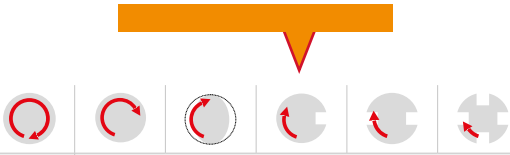




P	M	K	N	S	H
■	◪	■			

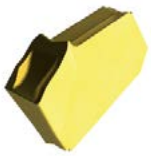
f ⇨ 参见示意图

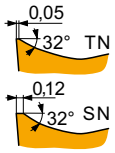
a_p

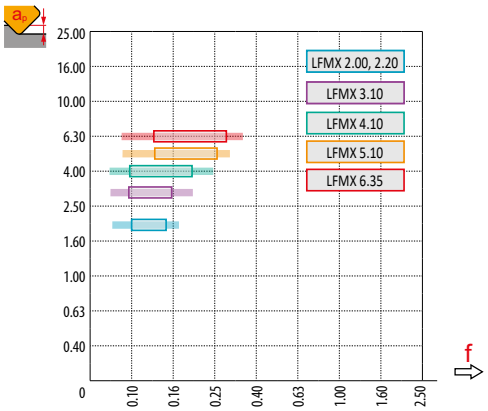


LFMX

M2 (LFMX)

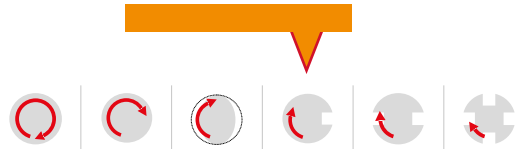






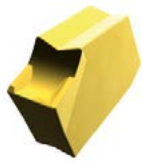
P	M	K	N	S	H
■	◪	◪			

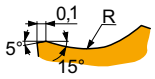
f
a_p
参见示意图

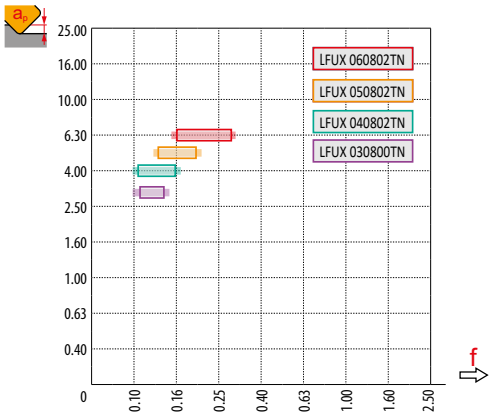


?
LFMX

LFUX

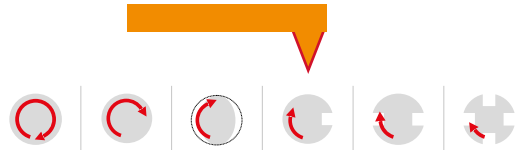






P	M	K	N	S	H
■		■			

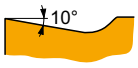
f
a_p
参见示意图

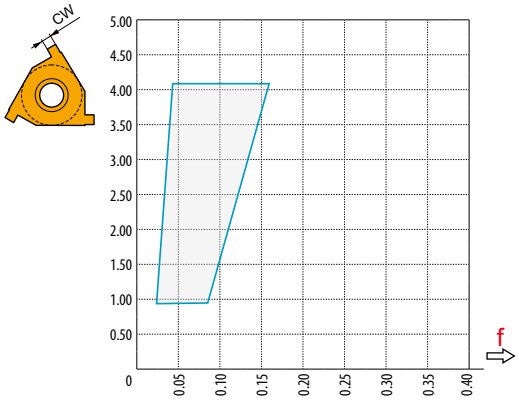


?
LFUX

TN. EXT



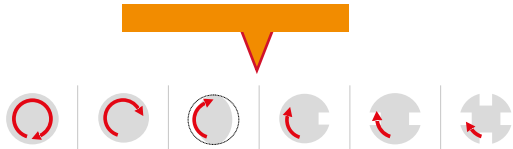




P	M	K	N	S	H
■	◪	◪			

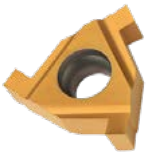
f ⇨ CW

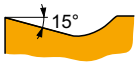
参见示意图

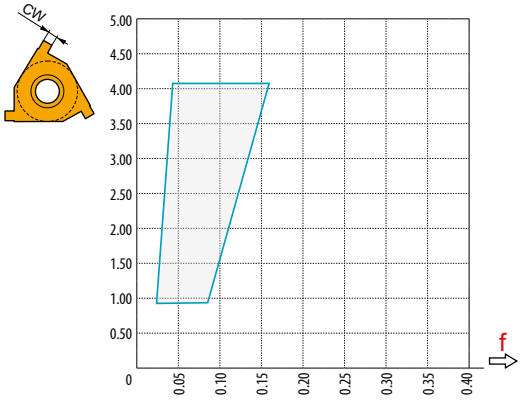


TN R EXT; TN ZZ EXT

TN. INT



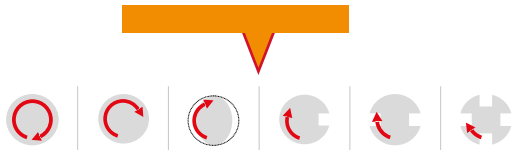




P	M	K	N	S	H
■	◪	◪			

f ⇨ CW

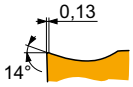
参见示意图

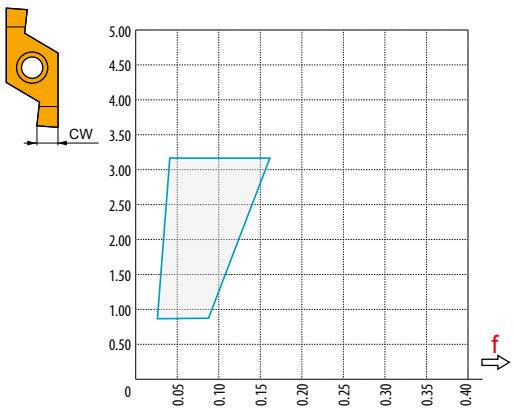


TN R INT; TN ZZ INT

X61 NEW



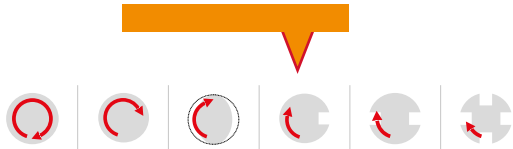




P	M	K	N	S	H
■	◪	◪			

f ⇨ CW

参见示意图

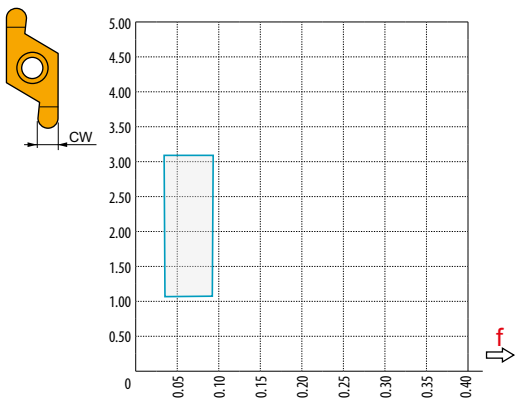


X61; X61-1

X61 R NEW



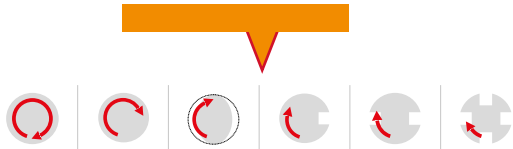




P	M	K	N	S	H
■	◪	◪			

f ⇨ CW

参见示意图



X61 R; X61 R-1

T	9	3	1	5
加工方式	涂层 / 材质	升级序号	ISO 范围	

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

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
T9226	P15 - P35 M10 - M30 K15 - K35 S15 - S25	■ ■ ◪ □				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。
T9310	P01 - P15 K05 - K20 H10 - H20	■ ◪ ◪				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。
T9315	P05 - P25 K05 - K25 H10 - H20	■ ◪ ◪				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。得益于出色的平衡属性，该材质是许多车削操作的首选。不适合低线速度操作。
T9316	P10 - P20 M05 - M15 K10 - K30 H15 - H25	■ ◪ ■ ◪				MT-CVD		FGM	+ + +	设计用于铁路产品加工，是具有出色耐磨特性的多用途材质。不适合较低和较高的线速度。
T9325	P15 - P35 M10 - M30 K15 - K35 S10 - S20	■ ■ ◪ ◪				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。
T9335	P20 - P45 M15 - M40 S15 - S25	■ ■ ◪				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。
T7325	P15 - P35 M10 - M25 S10 - S25	◪ ■ ■				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。
T7335	P20 - P40 M20 - M40 S15 - S25	◪ ■ ■				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。
T5305	P05 - P15 K01 - K15 H05 - H15	◪ ■ ◪				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。
T5315	P10 - P25 K10 - K25 H15 - H25	◪ ■ ◪				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。
6640	P20 - P40 M20 - M35 K25 - K40	■ ■ ■				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。

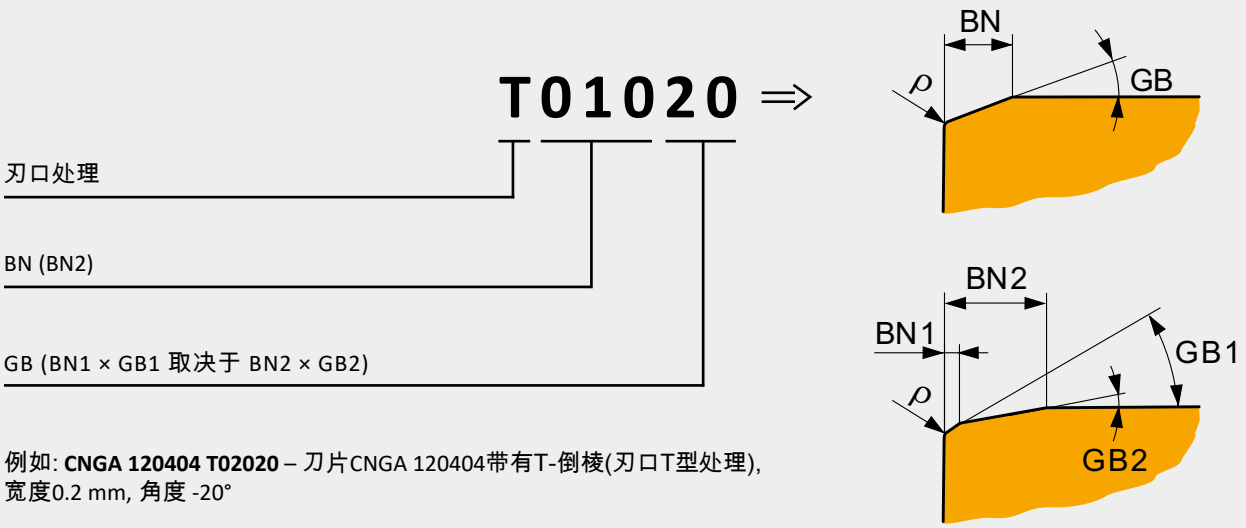
材质识别	应用范围	应用	进给	线速度	耐受不利工况	涂层	颜色	基材	冷却优势	材质说明
G8330	P25 - P40 M20 - M35 K20 - K40 S15 - S25	■ ■ ■ ◪	▰▰▰▰	▰▰▱▱	▰▰▰▰	PVD		submicron H	+ + +	通用切削材质，用于切槽和切断操作。该材质的特点是具有卓越的可靠性和通用性。为适应大多数工件材料的加工工况而开发。
T0315	N05 - N20	■	▰▰▱▱	▰▰▰▱	▰▰▰▱	PVD		submicron H	+ +	亚微细颗粒度材质，用于车削有色金属及其合金，兼具耐磨性与韧性。其独特涂层具有出色的摩擦特性。
T6310	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
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。
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。
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。
T8430 NEW	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。
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。

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
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

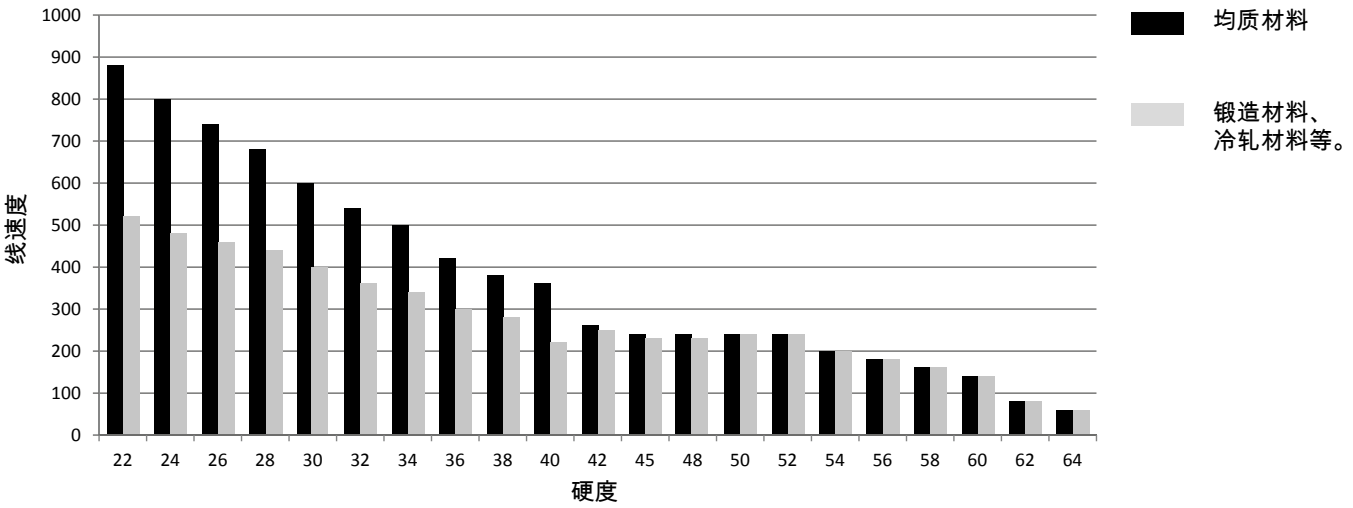
切削液的优点	
+ + +	必须使用冷却剂
+ +	强烈建议使用冷却剂
+	建议使用冷却剂
+ / –	选择使用冷却剂
– -	不使用冷却剂
–	不建议使用冷却剂



陶瓷是一种具有最高热稳定性的材料。
不过，在实际应用中，必须根据加工材料的硬度和其他特性降低线速度。

为便于说明，本文列出了用于精加工车削的圆刀片的具体示例。

线速度 **RNGN (a_p = 1.5 mm)**



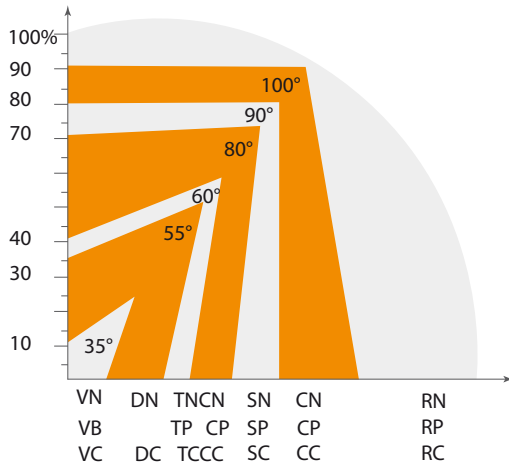
下表列出了在选择最终线速度时必须考虑的多个参数。

刀尖圆角RE [mm]	**0.4**	**0.8**	**1.2**	**1.6**	**2.4**	**3**
v_c降低	20 %	16 %	12 %	10 %	5 %	2 %
主偏角	**90°**	**75°**	**60°**	**45°**	**30°**	**< 15°**
v_c降低	0 %	5 %	8 %	12 %	15 %	18 %
刀片形状	**V**	**D**	**T**	**C, W**	**S**	**R**
刀尖角度	35°	55°	60°	80°	90°	–
v_c降低	17 %	12 %	10 %	6 %	4 %	0 %
切深 a_p [mm]	**<1.4**	**3**	**6**	**10**	**13**	**20**
v_c降低	5 %	8 %	13 %	16 %	18 %	20 %

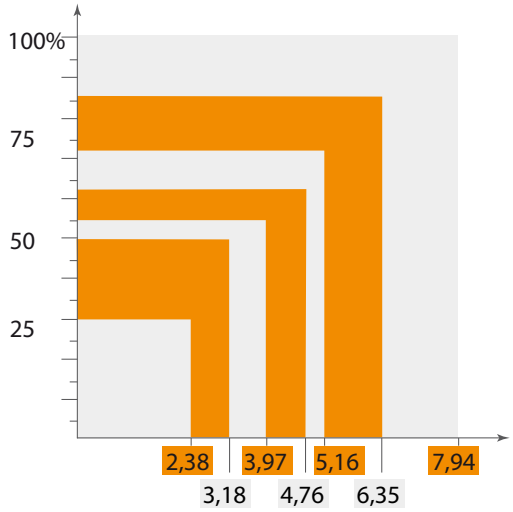
如前所述，陶瓷是一种具有最大耐磨性的材料，不过，同时也是其中一种韧性最低的材料。

因此，在选择合适的刀片时必须考虑刚度以及其他限制条件。

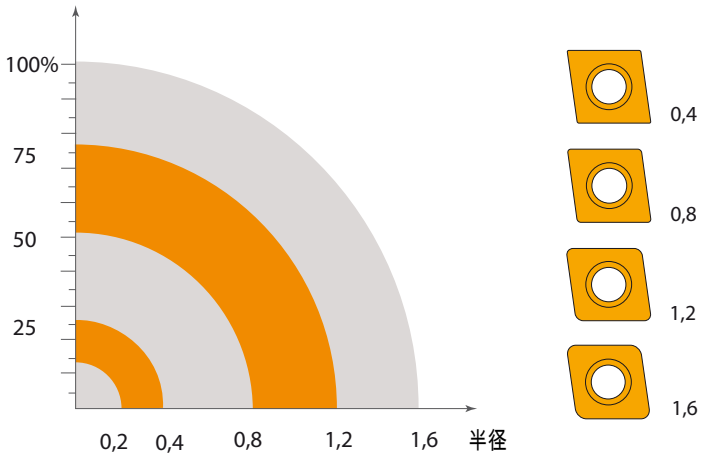
刚度与刀片形状的关系



刚度与刀片厚度的关系

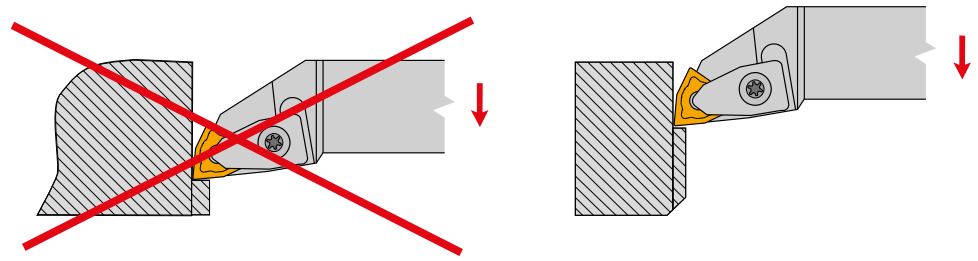


刚度与刀片形状的关系

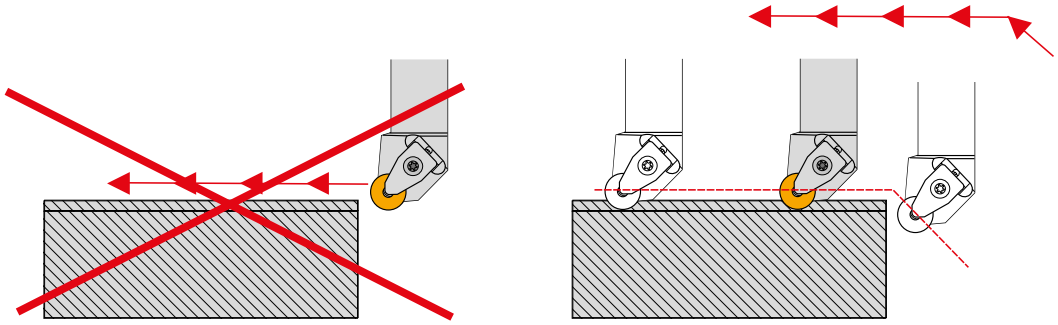


最后，本目录为实际应用给出了一些实用性建议：

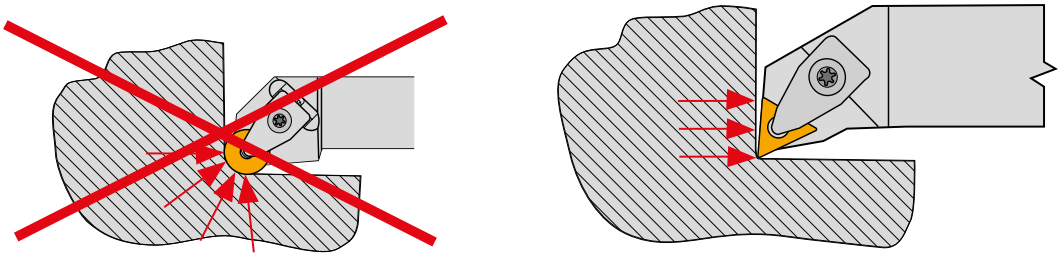
1) 刀具切出处的毛刺可导致切削刃崩裂，进而损坏整个刀片。因此，必须首先使切出成斜角，以消除毛刺。



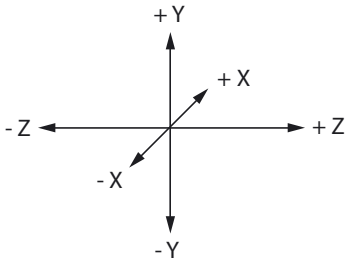
2) 建议修改标准程序 (切入材料)，这可延缓工件边缘毛刺的形成，从而延长切削刃的耐久性，此外还无需对工件边缘进行倒角操作。

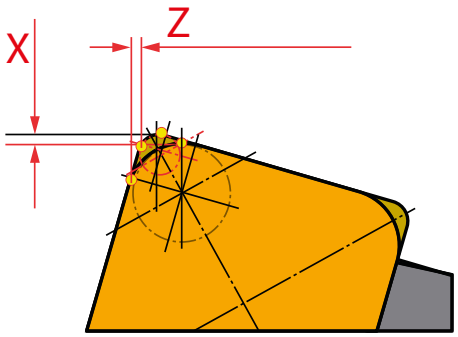


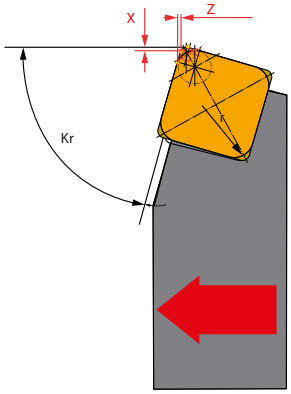
3) 如存在因刀具振动导致问题的风险，则适合使用具有较小半径的刀片，以消除径向力。



更改 (修正) 所用刀片的圆角:







注意 – 数据仅对图片中的右手刀杆有效 , 对于其它的内孔刀杆 , 左手刀杆 , 必须+/–调整数据。(调整X/Z的值)

刀柄		坐标	半径 0,5	半径 1,0	半径 1,5				
外圆刀片	CKJNR/L	x	0.443	0.000	-0.433				
		z	-0.050	0.000	0.050				

刀柄		坐标	半径 02	半径 04	半径 08	半径 12	半径 16	半径 24	半径 32
外圆刀片	DCLNR/L	x	0.060	0.040	0.000	-0.040	-0.080	-0.160	-0.240
		z	-0.062	-0.042	0.000	0.042	0.083	0.166	0.249
	DDJNR/L	x	0.516	0.347	0.000	-0.329	-0.667	-1.343	-2.019
		z	-0.056	-0.041	0.000	0.022	0.054	0.117	0.180
	DSBNR/L	x	0.252	0.170	0.000	-0.158	-0.322	-0.649	-0.977
		z	0.422	0.280	0.000	-0.285	-0.568	-1.134	-1.700
	DSDNN	x	0.000	0.000	0.000	0.000	0.000	0.000	0.000
		z	0.247	0.165	0.000	-0.165	-0.33	-0.659	-0.989
	DSKNR/L	x	0.134	0.089	0.000	-0.089	-0.178	-0.358	-0.537
		z	-0.167	-0.111	0.000	0.111	0.222	0.444	0.667
	DSSNR/L	x	0.000	0.000	0.000	0.000	0.000	0.000	0.000
		z	0.245	0.162	0.000	-0.167	-0.322	-0.662	-0.992
	DTFNR/L	x	0.426	0.284	0.000	-0.284	-0.569	-1.137	-1.705
		z	0.029	0.019	0.000	-0.019	-0.04	-0.078	-0.117
	DTGNR/L	x	0.437	0.294	0.000	-0.277	-0.562	-1.133	-1.703
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	DVJNR/L	x	0.063	0.042	0.000	-0.042	-0.084	-0.169	-0.253
		z	1.234	0.823	0.000	-0.823	-1.646	-3.291	-4.937
	DVPNR/L	x	0.79	0.527	0.000	-0.527	-1.054	-2.108	-3.161
		z	0.834	0.554	0.000	-0.554	-1.109	-2.217	-3.326
	DWLNR/L	x	0.061	0.044	0.000	-0.026	-0.061	-0.131	-0.200
		z	-0.063	-0.045	0.000	0.027	0.062	0.134	0.206

更改 (修正) 所用刀片的圆角

刀柄		坐标	半径 02	半径 04	半径 08	半径 12	半径 16	半径 24	半径 32
内孔刀片	DCLNR/L	x	-0.053	-0.035	0.000	0.035	0.070	0.140	0.210
		z	-0.060	-0.040	0.000	0.040	0.080	0.159	0.239
	DDUNR/L	x	-0.512	-0.341	0.000	0.0341	0.683	1.365	2.047
		z	-0.073	-0.049	0.000	0.049	0.097	0.195	0.292
	DTFNR/L	x	-0.425	-0.289	0.000	0.254	0.526	1.069	1.613
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	DVUNR/L	x	1.254	-0.836	0.000	0.836	1.671	3.343	5.014
		z	-0.129	-0.086	0.000	0.086	0.172	0.344	0.516
	DWLNR/L	x	-0.053	-0.035	0.000	0.035	0.07	0.14	0.21
		z	-0.06	-0.04	0.000	0.04	0.08	0.159	0.239
外圆刀片	MTJNR/L	x	0.437	0.294	0.000	-0.277	-0.562	-1.133	-1.703
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	MVJNR/L	x	1.263	0.847	0.000	-0.819	-1.651	-3.317	-4.982
		z	-0.075	-0.055	0.000	0.025	0.065	0.146	0.226
	MWLNR/L	x	0.609	0.044	0.000	-0.026	-0.061	-0.131	-0.200
		z	-0.063	-0.045	0.000	0.027	0.062	0.134	0.206
	PCBNR/L	x	0.045	0.033	0.000	-0.016	-0.040	-0.088	-0.137
		z	0.128	0.083	0.000	-0.096	-0.185	-0.364	-0.543
	PCKNR/L	x	0.171	0.115	0.000	-0.110	-0.223	-0.448	-0.672
		z	0.685	0.457	0.000	-0.457	-0.914	-1.827	-2.741
	PCLNR/L	x	0.061	0.044	0.000	-0.026	-0.061	-0.131	-0.200
		z	-0.063	-0.045	0.000	0.027	0.062	0.134	0.206
	PDJNR/L	x	0.516	0.347	0.000	-0.329	-0.667	-1.343	-2.019
		z	-0.056	-0.041	0.000	0.022	0.054	0.117	0.180
	PDNNR/L	x	0.699	0.469	0.000	-0.453	-0.915	-1.837	-2.759
		z	0.524	0.348	0.000	-0.357	-0.710	-1.415	-2.120
	PDXNR/L	x	0.453	0.305	0.000	-0.288	-0.584	-1.177	-1.770
		z	-0.156	-0.107	0.000	0.088	0.185	0.380	0.575
	PLBNR/L	x	0.137	0.094	0.000	-0.078	-0.163	-0.335	-0.507
		z	0.153	0.100	0.000	-0.110	-0.220	-0.433	-0.646
	PSBNR/L	x	0.137	0.094	0.000	-0.078	-0.163	-0.335	-0.507
		z	0.153	0.100	0.000	-0.110	-0.220	-0.433	-0.646
	PSDNN	x	0.252	0.170	0.000	-0.158	-0.322	-0.649	-0.977
		z	0.422	0.280	0.000	-0.285	-0.568	-1.134	-1.699
	PSKNR/L	x	0.140	0.094	0.000	-0.090	-0.152	-0.366	-0.550
		z	0.574	0.383	0.000	-0.384	-0.767	-1.533	-2.300
	PSSNR/L	x	0.246	0.164	0.000	-0.164	-0.328	-0.656	-0.983
		z	0.424	0.283	0.000	-0.283	-0.566	-1.131	-1.697
	PTFNR/L	x	0.000	0.000	0.000	0.000	0.000	0.000	0.000
		z	-0.411	-0.243	0.000	0.429	0.765	1.437	2.110
	PTGNR/L	x	0.437	0.294	0.000	-0.277	-0.562	-1.133	-1.703
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	PTTNR/L	x	0.601	0.403	0.000	-0.389	-0.784	-1.575	-2.367
		z	0.519	0.345	0.000	-0.354	-0.703	-1.401	-2.099
	PWLNR/L	x	0.609	0.044	0.000	-0.026	-0.061	-0.131	-0.200
		z	-0.063	-0.045	0.000	0.027	0.062	0.134	0.206
内孔刀片	PCLNR/L	x	-0.061	-0.046	0.000	0.012	0.040	0.098	0.156
		z	-0.062	-0.047	0.000	0.015	0.046	0.160	0.169
	PDUNR/L	x	-0.500	-0.339	0.000	0.305	0.627	1.271	1.915
		z	-0.052	-0.040	0.000	0.006	0.029	0.076	0.122
	PSKNR/L	x	-0.153	-0.097	0.000	0.063	0.143	0.303	0.463
		z	0.137	0.098	0.000	-0.124	-0.234	-0.456	-0.677
	PTFNR/L	x	-0.425	-0.289	0.000	0.254	0.526	1.069	1.613
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	PWLNR/L	x	-0.060	-0.046	0.000	0.012	0.043	0.098	0.156
		z	-0.065	-0.049	0.000	0.012	0.040	0.105	0.166

刀柄		坐标	半径 02	半径 04	半径 08	半径 12	半径 16	半径 24	半径 32
外圆刀片	SCACR/L	x	0.115	0.077	0.000	-0.077	-0.153	-0.307	-0.460
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	SCBCR/L	x	0.042	0.028	0.000	-0.028	-0.055	-0.111	-0.166
		z	0.130	0.087	0.000	-0.087	-0.174	-0.347	-0.521
	SCDCR/L	x	0.000	0.000	0.000	0.000	0.000	0.000	0.000
		z	-0.279	-0.186	0.000	0.186	0.372	0.745	1.117
	SCFCR/L	x	0.000	0.000	0.000	0.000	0.000	0.000	0.000
		z	-0.124	-0.083	0.000	0.083	0.166	0.331	0.497
	SCLCR/L	x	0.060	0.040	0.000	-0.040	-0.080	-0.160	-0.240
		z	-0.062	-0.042	0.000	0.042	0.083	0.166	0.249
	SDJCR/L	x	0.520	0.346	0.000	-0.346	-0.693	-1.386	-2.078
		z	-0.060	-0.040	0.000	0.040	0.080	0.161	0.241
	SDNCN	x	0.699	0.466	0.000	-0.466	-0.933	-1.865	-2.798
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	SEGCR/L	x	0.000	0.000	0.000	0.000	0.000	0.000	0.000
		z	-0.182	-0.121	0.000	0.121	0.243	0.485	0.728
	SSBCR/L	x	0.135	0.090	0.000	-0.090	-0.180	-0.360	-0.539
		z	0.155	0.104	0.000	-0.104	-0.207	-0.414	-0.621
	SSDCN	x	0.249	0.166	0.000	-0.166	-0.331	-0.663	-0.994
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	SSKCR/L	x	-0.376	-0.517	0.000	-1.083	-1.366	-1.931	-2.497
		z	-0.135	-0.090	0.000	0.090	0.180	0.360	0.539
	STCFR/L	x	0.000	0.000	0.000	0.000	0.000	0.000	0.000
		z	–	–	0.000	–	–	–	–
	STJCR/L	x	0.406	0.271	0.000	-0.271	-0.542	-1.084	-1.626
		z	-0.054	-0.036	0.000	0.036	0.071	0.143	-0.214
	SVACR/L	x	00 / 0	01 / – 0.107	–	–	–	–	–
		z	00 / 0	01 / – 0.107	–	–	–	–	–
	SVGCR/L	x	0.000	0.000	0.000	0.000	0.000	0.000	0.000
		z	-1.303	-0.869	0.000	0.869	1.737	3.475	5.212
	SVHBR/L	x	1.034	0.690	0.000	-0.690	-1.379	-2.759	-4.138
		z	-0.544	-0.363	0.000	0.363	0.726	1.452	2.178
	SVHCR/L	x	1.034	0.690	0.000	-0.690	-1.379	-2.759	-4.138
		z	-0.544	-0.363	0.000	0.363	0.726	1.452	2.178
	SVJBR/L	x	1.269	0.846	0.000	-0.846	-1.692	-3.384	-5.076
		z	-0.099	-0.066	0.000	0.066	0.132	0.263	0.395
	SVJCR/L	x	1.269	0.846	0.000	-0.846	-1.692	-3.384	-5.076
		z	-0.099	-0.066	0.000	0.066	0.132	0.263	0.395
	SVPBR/L	x	0.811	0.541	0.000	-0.541	-1.081	-2.162	-3.244
		z	-0.811	-0.541	0.000	0.541	1.081	2.162	3.244
	SVPCR/L	x	0.811	0.541	0.000	-0.541	-1.081	-2.162	-3.244
		z	-0.811	-0.541	0.000	0.541	1.081	2.162	3.244
	SVVBN	x	1.395	0.930	0.000	-0.930	-1.860	-3.721	-5.581
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	SVVCN	x	1.395	0.930	0.000	-0.930	-1.860	-3.721	-5.581
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	SVXBR/L	x	1.201	0.801	0.000	-0.080	-1.601	-3.202	-4.804
		z	-0.259	-0.173	0.000	0.173	0.345	0.691	1.036
	SVXCR/L	x	1.201	0.801	0.000	-0.080	-1.601	-3.202	-4.804
		z	-0.259	-0.173	0.000	0.173	0.345	0.691	1.036
	SWLCR/L	x	0.060	0.040	0.000	-0.040	-0.080	-0.160	-0.240
		z	-0.060	-0.040	0.000	0.040	0.080	0.160	0.240

更改 (修正) 所用刀片的圆角

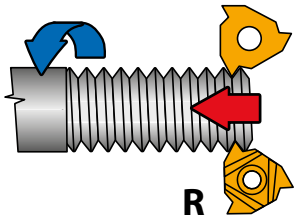
刀柄		坐标	半径 02	半径 04	半径 08	半径 12	半径 16	半径 24	半径 32
内孔刀片	SCFCR/L	x	-0.420	-0.280	0.000	0.280	0.560	1.121	1.681
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	SCKCR/L	x	-0.040	-0.027	0.000	0.027	0.054	0.108	0.161
		z	0.130	0.087	0.000	-0.087	-0.174	-0.348	0.521
	SCLCR/L	x	-0.058	-0.039	0.000	0.039	0.078	0.155	0.233
		z	-0.062	-0.042	0.000	0.042	0.083	0.166	0.249
	SCXCR/L	x	-0.178	-0.119	0.000	0.119	0.237	0.474	0.711
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	SDQCR/L	x	-0.309	-0.194	0.000	0.206	0.412	0.825	1.237
		z	-0.310	-0.206	0.000	0.268	0.499	0.961	1.423
	SDUCR/L	x	-0.504	-0.336	0.000	0.336	0.672	1.344	2.016
		z	-0.059	-0.039	0.000	0.041	0.082	0.162	0.242
	SDZCR/L	x	-0.520	-0.346	0.000	0.346	0.693	0.139	2.078
		z	0.059	0.039	0.000	-0.041	-0.082	-0.162	-0.242
	SELPR/L	x	-0.126	-0.084	0.000	0.084	0.168	0.337	0.051
		z	-0.066	-0.044	0.000	0.044	0.088	0.176	0.264
	SEUCR/L	x	-0.149	-0.099	0.000	0.099	0.199	0.397	0.596
		z	-0.041	-0.027	0.000	0.027	0.053	0.107	0.160
	SEUPR/L	x	-0.148	-0.099	0.000	0.099	0.198	0.396	0.593
		z	-0.040	-0.027	0.000	0.027	0.053	0.107	0.160
	SEXPR/L	x	-0.384	-0.256	0.000	0.256	0.512	1.024	1.537
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	SSSCR/L	x	-0.249	-0.166	0.000	0.166	0.331	0.663	0.994
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	STFCR/L	x	-0.433	-0.289	0.000	0.289	0.577	1.154	1.731
		z	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	SVLCR/L	x	-1.243	-0.828	0.000	0.828	1.657	3.314	4.971
		z	0.239	0.692	0.000	-0.108	-0.215	-0.430	-0.645
	SVQBR/L	x	-1.027	-0.684	0.000	0.690	1.369	2.738	4.106
		z	-0.545	-0.363	0.000	0.363	0.726	1.452	2.178
	SVQCR/L	x	-1.027	-0.684	0.000	0.690	1.369	2.738	4.106
		z	-0.545	-0.363	0.000	0.363	0.726	1.452	2.178
	SVUBR/L	x	-1.259	-0.840	0.000	0.840	1.679	3.358	5.037
		z	0.099	-0.066	0.000	0.066	0.132	0.263	0.395
	SVUCR/L	x	-1.259	-0.840	0.000	0.840	1.679	3.358	5.037
		z	0.099	-0.066	0.000	0.066	0.132	0.263	0.395
	SVXCR/L	x	-0.917	-0.611	0.000	0.611	1.222	2.445	3.667
		z	-0.696	-0.464	0.000	0.464	0.928	1.856	2.783
	SWLCR/L	x	-0.060	-0.039	0.000	0.039	0.079	0.158	0.237
		z	-0.060	-0.040	0.000	0.040	0.080	0.160	0.240
	SWUCR/L	x	-0.080	-0.053	0.000	0.053	0.107	0.213	0.319
		z	-0.034	-0.024	0.000	0.024	0.049	0.098	0.146

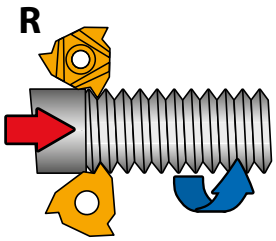
注意 – 数据仅对图片中的右手刀杆有效 , 对于其它的内孔刀杆 , 左手刀杆 , 必须+/–调整数据。(调整X/Z的值)

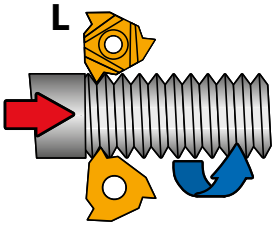
螺纹加工

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。

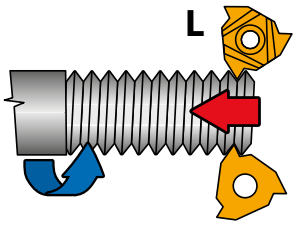
外螺纹，右旋

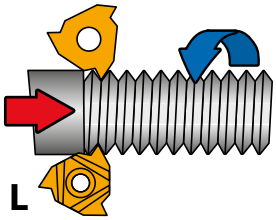


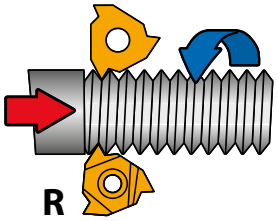




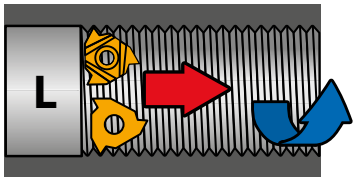
外螺纹，左旋

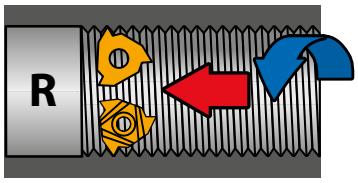




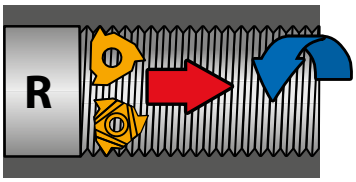


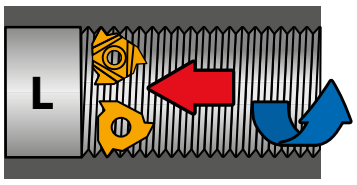
内螺纹，右旋





内螺纹，左旋





■ 工件移动　■ 刀具移动　L / R 设计刀片

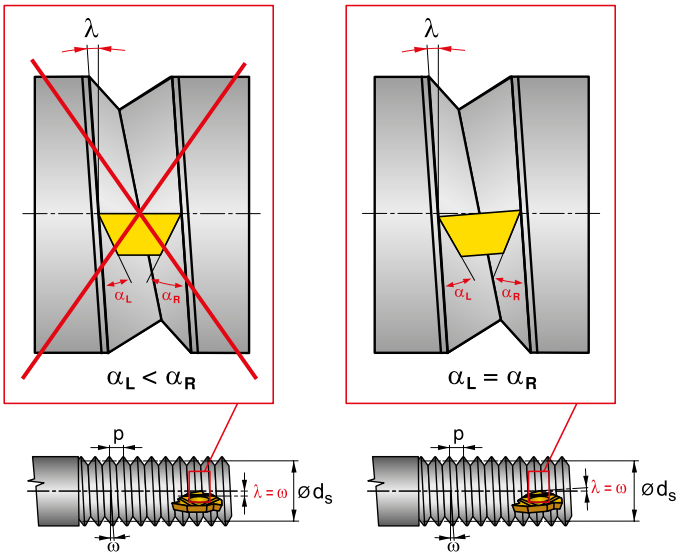
螺旋角可以通过下面的公式来计算

$$tg\,\omega = \frac{p}{d_s \cdot \pi}$$

ω 螺旋角 [°]

p 螺距 [mm]

d_s 螺纹中径 [mm]



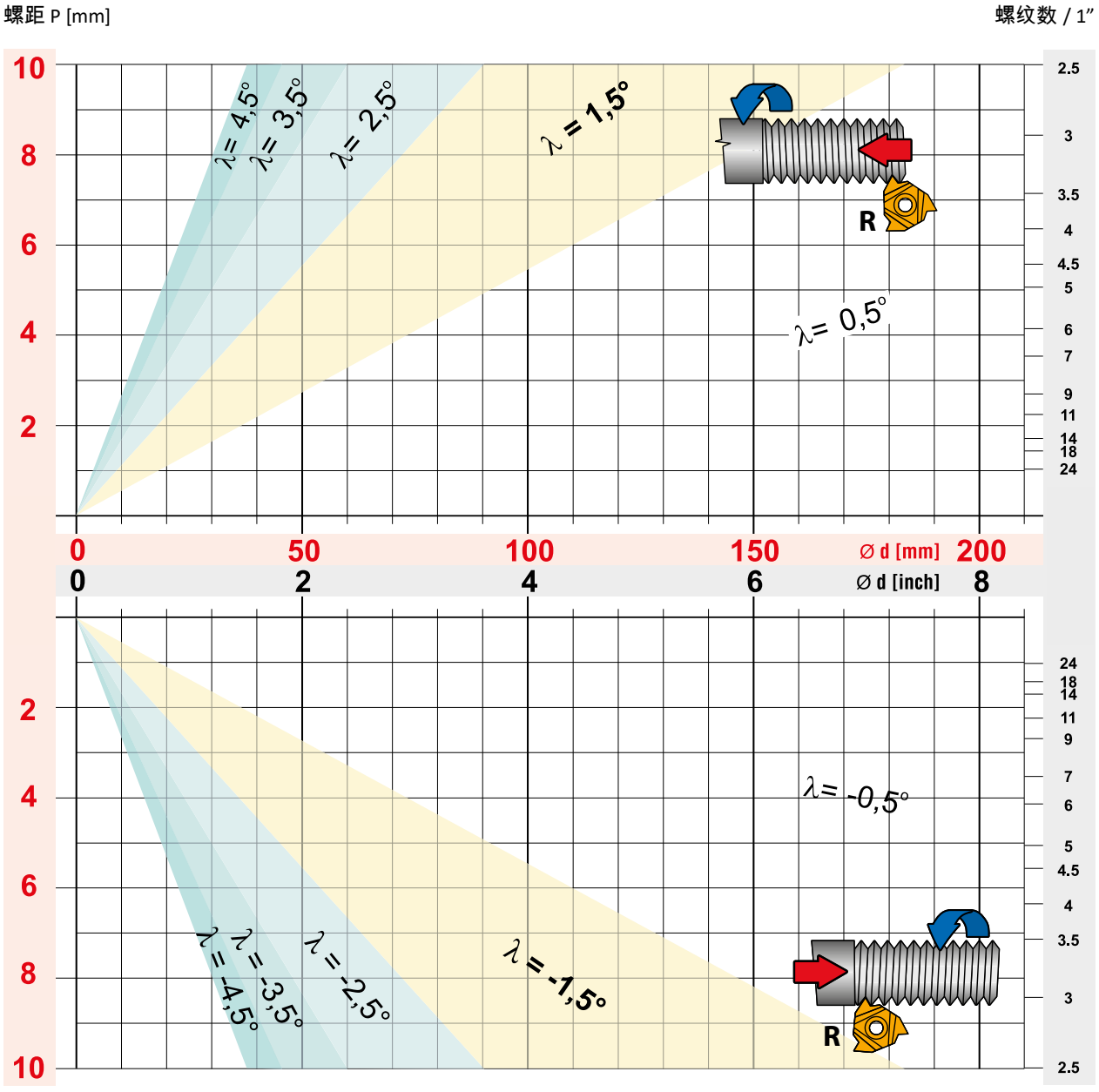
为加工出正确的螺纹牙型和确保刀片均匀磨损，切削刃螺旋角应该等于螺纹导程角。
通常，刀柄螺旋角 λ = 1.5°。可以通过更换刀垫选择不同的螺旋角。
使用下图或表选择正确的刀垫。表和图。

选择刀垫

螺旋角 λ	正前角					负前角		于开槽刀片 TN16.. ... ZZ, TN22.. ... ZZ
	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	PE16ZZ
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	PI16ZZ
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	PE22ZZ
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	PI22ZZ
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*“.

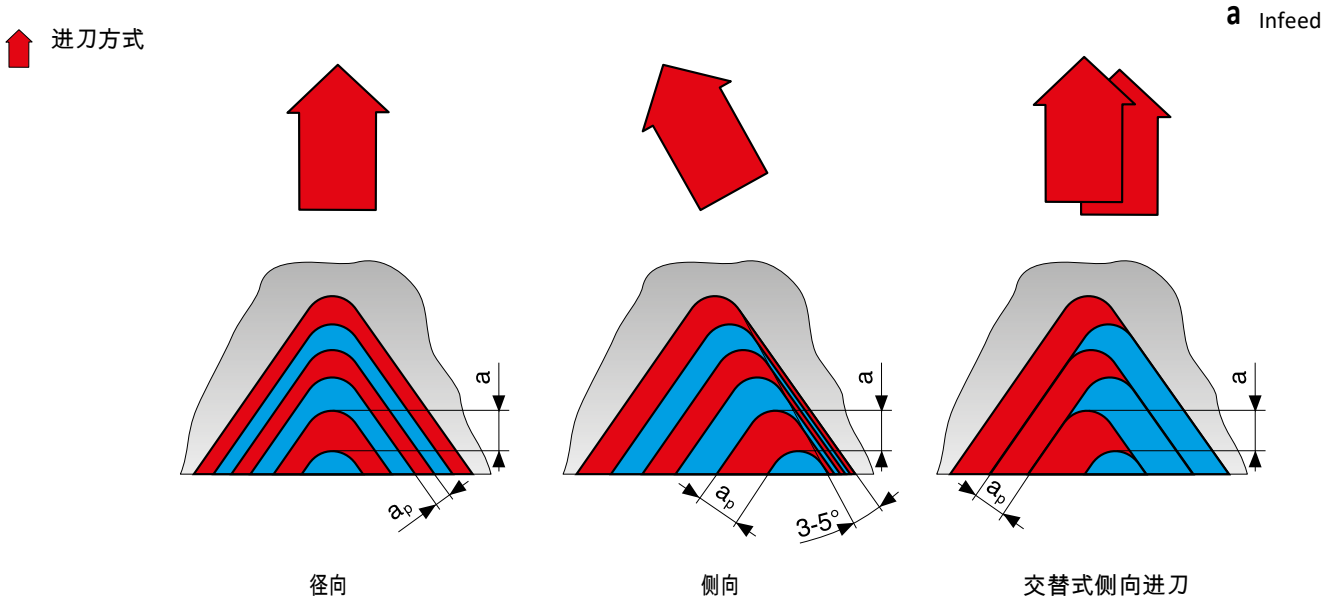
刀垫选择



工件移动　　刀具移动　　L / R 设计刀片

进刀方式和深度

为保证良好的切屑控制，进刀方式的选择对于长切屑材料来说是最重要的。



径向　　侧向　　交替式侧向进刀

该选择取决于机床类型、待加工材料和螺距。
径向进刀 – 简单，最常用。进给与工件旋转轴垂直。良好的切屑成形，均匀的切削刃磨损。适用于小螺距螺纹 (***p*** <1.5 mm) 加工。较高进给存在振动危险。首选用于加工淬火材料 (例如，奥氏体不锈钢、低碳钢)。
侧向进刀 – 减少切削刃热应力，从而减小磨损。良好的切屑控制。适用于车削螺距 ***p*** > 1.5 mm 的螺纹。偏差为 3-5° 的侧向进刀可消除螺纹牙侧的摩擦。
交替式侧向进刀 – 推荐用于大螺距和切屑成形不佳的材料。刀具寿命长。用于 CNC 机床，对于 CNC 编程有更高要求。

进刀方式和走刀次数取决于螺距。表格中给出的是基本推荐值并能应用于所有的槽型。如果发生刀片崩刃，应该增加步数。进刀深度应该不低于 0.05 mm/步。在奥氏体和软钢件上，每次走刀的进刀深度应该大于 0.08 mm。

圆柱管螺纹形状与W完全一致 (WHITWORTH 55°)

螺纹规格	螺纹数 / 1″	螺距 [mm]	螺纹中径 [mm]	螺纹底径 [mm]	螺纹刀片标记
G 1/16″	28	0,907	7.723	6.561	TN xxxx280W
G 1/8″			9.728	8.566	
G 1/4″	19	1,337	13.157	11.445	TN xxxx190W
G 3/8″			16.662	14.950	
G 1/2″	14	1,814	20.955	18.631	TN xxxx140W
G 5/8″			22.911	20.587	
G 3/4″			26.441	24.117	
G 7/8″			30.201	27.877	
G 1″	11	2,309	33.249	30.291	TN xxxx110W
G1 1/8″			37.897	34.939	
G1 1/4″			41.910	38.952	
G1 1/2″			47.803	44.845	
G1 3/4″			53.746	50.788	
G 2″			59.614	56.656	
G2 1/4″			65.710	62.752	
G2 1/2″			75.184	72.226	
G2 3/4″			81.534	78.576	
G3″			87.884	84.926	
G3 1/2″			100.330	97.372	
G4″			113.030	110.072	
G4 1/2″			125.730	122.772	
G5″			138.430	135.472	
G5 1/2″			151.130	148.172	
G6″			163.830	160.872	

举例：右手外圆的管螺纹 1 ½″ 规格可选用刀片 TN 16ER110W; 8030

M – 公制 60° – 外螺纹

走刀次数	随着螺距增大成比例降低线速度														
	总进刀深度 [mm]														
	6.0	**5.5**	**5.0**	**4.5**	**4.0**	**3.5**	**3.0**	**2.5**	**2.0**	**1.75**	**1.5**	**1.25**	**1.0**	**0.75**	**0.50**
1	0.46	0.43	0.41	0.37	0.34	0.34	0.28	0.27	0.24	0.22	0.22	0.21	0.18	0.16	0.11
2	0.43	0.40	0.39	0.34	0.32	0.31	0.26	0.24	0.22	0.20	0.20	0.17	0.16	0.14	0.09
3	0.35	0.32	0.32	0.28	0.25	0.25	0.21	0.20	0.18	0.17	0.17	0.14	0.12	0.11	0.07
4	0.30	0.28	0.27	0.24	0.22	0.21	0.18	0.17	0.16	0.14	0.14	0.11	0.11	0.07	0.06
5	0.29	0.26	0.24	0.22	0.20	0.18	0.16	0.15	0.14	0.12	0.12	0.10	0.08		
6	0.26	0.24	0.24	0.22	0.18	0.18	0.15	0.15	0.12	0.10	0.08	0.08			
7	0.24	0.21	0.22	0.20	0.17	0.16	0.14	0.12	0.11	0.10					
8	0.23	0.20	0.20	0.18	0.15	0.15	0.13	0.11	0.08	0.08					
9	0.22	0.19	0.19	0.17	0.14	0.14	0.12	0.11							
10	0.19	0.18	0.18	0.16	0.13	0.12	0.11	0.08							
11	0.18	0.17	0.16	0.14	0.12	0.11	0.10								
12	0.16	0.15	0.15	0.13	0.12	0.08	0.08								
13	0.15	0.14	0.12	0.12	0.11										
14	0.13	0.13	0.10	0.10	0.08										
15	0.13	0.12													
16	0.10	0.10													
总进刀深度	**3.83**	**3.52**	**3.19**	**2.87**	**2.53**	**2.23**	**1.92**	**1.60**	**1.25**	**1.13**	**0.93**	**0.81**	**0.65**	**0.48**	**0.33**

M – 公制 60° – 内螺纹

走刀次数	随着螺距增大成比例降低切削速度														
	总进刀深度 [mm]														
	6.0	**5.5**	**5.0**	**4.5**	**4.0**	**3.5**	**3.0**	**2.5**	**2.0**	**1.75**	**1.5**	**1.25**	**1.0**	**0.75**	**0.50**
1	0.46	0.43	0.42	0.37	0.34	0.32	0.28	0.26	0.23	0.22	0.20	0.17	0.17	0.16	0.10
2	0.43	0.40	0.40	0.34	0.31	0.30	0.26	0.25	0.21	0.20	0.18	0.17	0.15	0.13	0.08
3	0.35	0.33	0.32	0.28	0.24	0.24	0.21	0.18	0.17	0.15	0.15	0.14	0.11	0.10	0.07
4	0.30	0.26	0.26	0.23	0.21	0.19	0.16	0.15	0.15	0.13	0.13	0.10	0.09	0.07	0.06
5	0.26	0.22	0.22	0.21	0.18	0.17	0.14	0.13	0.12	0.10	0.11	0.09	0.08		
6	0.22	0.20	0.20	0.19	0.15	0.15	0.13	0.12	0.11	0.09	0.08	0.08			
7	0.20	0.18	0.17	0.16	0.14	0.14	0.12	0.11	0.10	0.08					
8	0.19	0.17	0.16	0.15	0.13	0.13	0.11	0.10	0.08	0.08					
9	0.18	0.16	0.16	0.14	0.12	0.12	0.10	0.10							
10	0.16	0.15	0.15	0.13	0.12	0.11	0.10	0.08							
11	0.15	0.14	0.14	0.12	0.11	0.10	0.09								
12	0.15	0.14	0.14	0.12	0.10	0.08	0.08								
13	0.14	0.13	0.12	0.11	0.10										
14	0.13	0.12	0.10	0.10	0.08										
15	0.12	0.12													
16	0.10	0.10													
总进刀线速度	**3.54**	**3.25**	**2.96**	**2.65**	**2.33**	**2.05**	**1.78**	**1.48**	**1.17**	**1.05**	**0.85**	**0.75**	**0.60**	**0.46**	**0.31**

W – 惠氏标准螺纹 55° – 外螺纹

走刀次数	随着螺距增大成比例降低线速度																
	螺距 [每英寸螺纹数]																
	4	4.5	5	6	7	8	9	10	11	12	14	16	18	19	20	26	28
1	0.49	0.46	0.45	0.38	0.37	0.32	0.30	0.29	0.28	0.28	0.24	0.24	0.23	0.22	0.21	0.19	0.18
2	0.46	0.43	0.43	0.36	0.35	0.30	0.28	0.27	0.26	0.26	0.22	0.22	0.22	0.22	0.21	0.18	0.17
3	0.38	0.38	0.38	0.30	0.29	0.24	0.23	0.22	0.22	0.22	0.18	0.19	0.19	0.18	0.17	0.15	0.14
4	0.36	0.33	0.32	0.26	0.25	0.21	0.20	0.19	0.19	0.18	0.15	0.16	0.16	0.14	0.14	0.12	0.12
5	0.34	0.29	0.28	0.22	0.22	0.19	0.18	0.17	0.16	0.16	0.13	0.13	0.13	0.12	0.11	0.08	0.08
6	0.31	0.25	0.25	0.21	0.19	0.17	0.15	0.15	0.14	0.14	0.11	0.11	0.08	0.08	0.08		
7	0.29	0.24	0.22	0.19	0.18	0.15	0.14	0.14	0.13	0.13	0.09	0.08					
8	0.27	0.22	0.20	0.17	0.16	0.14	0.13	0.13	0.12	0.08	0.08						
9	0.24	0.20	0.19	0.16	0.15	0.13	0.12	0.12	0.08								
10	0.22	0.18	0.18	0.15	0.14	0.12	0.12	0.08									
11	0.20	0.17	0.17	0.14	0.12	0.12	0.08										
12	0.19	0.16	0.15	0.14	0.08	0.08											
13	0.17	0.15	0.12	0.12													
14	0.15	0.14	0.10	0.10													
15	0.12	0.12															
16	0.10	0.10															
总进刀深度	4.29	3.82	3.44	2.90	2.50	2.17	1.93	1.76	1.58	1.45	1.20	1.13	1.01	0.96	0.92	0.72	0.69

UN 60° – 外螺纹

走刀次数	随着螺距增大成比例降低切削速度																	
	螺距 [每英寸螺纹数]																	
	4	4.5	5	6	7	8	9	10	11	12	13	14	16	18	20	24	28	32
1	0.47	0.45	0.43	0.36	0.35	0.30	0.28	0.27	0.27	0.27	0.25	0.23	0.22	0.23	0.20	0.19	0.17	0.17
2	0.44	0.41	0.40	0.34	0.33	0.28	0.26	0.26	0.25	0.26	0.24	0.22	0.21	0.21	0.19	0.17	0.15	0.15
3	0.40	0.39	0.36	0.27	0.26	0.25	0.21	0.20	0.20	0.20	0.18	0.17	0.16	0.16	0.15	0.14	0.11	0.13
4	0.36	0.31	0.31	0.23	0.22	0.21	0.20	0.17	0.19	0.18	0.17	0.15	0.14	0.14	0.12	0.12	0.09	0.08
5	0.32	0.26	0.26	0.22	0.21	0.18	0.17	0.16	0.16	0.15	0.14	0.13	0.13	0.12	0.10	0.08	0.08	
6	0.27	0.23	0.23	0.20	0.19	0.16	0.15	0.15	0.14	0.13	0.12	0.11	0.11	0.08	0.08			
7	0.25	0.21	0.20	0.18	0.17	0.14	0.14	0.14	0.12	0.12	0.11	0.10	0.08					
8	0.23	0.20	0.19	0.16	0.15	0.13	0.12	0.12	0.11	0.08	0.08	0.08						
9	0.22	0.18	0.19	0.15	0.14	0.12	0.12	0.11	0.08									
10	0.21	0.17	0.18	0.14	0.12	0.12	0.11	0.08										
11	0.19	0.16	0.17	0.13	0.11	0.11	0.08											
12	0.18	0.15	0.15	0.12	0.08	0.08												
13	0.16	0.14	0.12	0.11														
14	0.15	0.14	0.10	0.10														
15	0.12	0.12																
16	0.10	0.10																
总进刀线速度	**4.07**	**3.62**	**3.29**	**2.71**	**2.33**	**2.08**	**1.84**	**1.66**	**1.52**	**1.39**	**1.29**	**1.19**	**1.05**	**0.94**	**0.84**	**0.70**	**0.60**	**0.53**

进刀深度

UN 60° – 内螺纹

走刀次数	随着螺距增大成比例降低切削速度																	
	螺距 [每英寸螺纹数]																	
	4	**4.5**	**5**	**6**	**7**	**8**	**9**	**10**	**11**	**12**	**13**	**14**	**16**	**18**	**20**	**24**	**28**	**32**
1	0.44	0.41	0.42	0.35	0.34	0.30	0.28	0.27	0.27	0.27	0.25	0.23	0.22	0.23	0.20	0.18	0.17	0.17
2	0.41	0.38	0.38	0.33	0.32	0.28	0.26	0.25	0.23	0.23	0.20	0.18	0.18	0.17	0.16	0.15	0.14	0.14
3	0.39	0.34	0.33	0.25	0.24	0.22	0.19	0.18	0.18	0.18	0.15	0.14	0.14	0.14	0.13	0.13	0.09	0.10
4	0.33	0.28	0.27	0.21	0.21	0.18	0.16	0.15	0.15	0.15	0.13	0.13	0.12	0.12	0.10	0.10	0.08	0.08
5	0.28	0.23	0.23	0.18	0.17	0.15	0.14	0.13	0.13	0.13	0.12	0.11	0.10	0.10	0.09	0.08	0.08	
6	0.24	0.20	0.20	0.16	0.15	0.13	0.13	0.12	0.11	0.11	0.11	0.10	0.09	0.08	0.08			
7	0.22	0.19	0.18	0.15	0.14	0.12	0.12	0.11	0.11	0.10	0.10	0.09	0.08					
8	0.21	0.18	0.17	0.14	0.13	0.11	0.11	0.10	0.10	0.08	0.08	0.08						
9	0.20	0.17	0.16	0.13	0.12	0.11	0.10	0.10	0.08									
10	0.18	0.16	0.15	0.12	0.12	0.10	0.09	0.08										
11	0.17	0.15	0.14	0.12	0.11	0.10	0.08											
12	0.16	0.14	0.14	0.11	0.08	0.08												
13	0.15	0.14	0.12	0.11														
14	0.14	0.13	0.10	0.10														
15	0.12	0.12																
16	0.10	0.10																
总进刀线速度	**3.74**	**3.32**	**2.99**	**2.46**	**2.13**	**1.88**	**1.66**	**1.49**	**1.36**	**1.25**	**1.14**	**1.06**	**0.93**	**0.84**	**0.76**	**0.64**	**0.56**	**0.49**

NPT 60° – 内螺纹和外螺纹

走刀次数	随着螺距增大成比例降低线速度				
	螺距 [每英寸螺纹数]				
	8	**11.5**	**14**	**18**	**27**
1	0.28	0.25	0.24	0.22	0.19
2	0.25	0.22	0.22	0.18	0.15
3	0.22	0.18	0.17	0.15	0.13
4	0.19	0.16	0.15	0.14	0.11
5	0.18	0.16	0.14	0.13	0.09
6	0.18	0.14	0.13	0.12	0.08
7	0.17	0.14	0.12	0.10	
8	0.17	0.12	0.10	0.08	
9	0.16	0.12	0.10		
10	0.16	0.10	0.08		
11	0.14	0.09			
12	0.13	0.08			
13	0.12				
14	0.11				
15	0.08				
总进刀深度	**2.54**	**1.76**	**1.45**	**1.12**	**0.75**

RD – RD 30° – 外螺纹

走刀次数	随着螺距增大成比例降低线速度			
	螺距 [每英寸螺纹数]			
	4	**6**	**8**	**10**
1	0.44	0.33	0.29	0.26
2	0.40	0.29	0.26	0.25
3	0.34	0.25	0.21	0.23
4	0.32	0.23	0.19	0.20
5	0.28	0.20	0.18	0.16
6	0.26	0.18	0.16	0.12
7	0.24	0.16	0.14	0.10
8	0.22	0.15	0.12	0.08
9	0.20	0.14	0.10	
10	0.19	0.12	0.08	
11	0.17	0.10		
12	0.15	0.08		
13	0.12			
14	0.10			
总进刀深度	**3.43**	**2.23**	**1.73**	**1.40**

RD – RD 30° – 内螺纹

走刀次数	随着螺距增大成比例降低切削速度			
	螺距 [每英寸螺纹数]			
	4	**6**	**8**	**10**
1	0.46	0.38	0.26	0.27
2	0.43	0.34	0.22	0.26
3	0.40	0.30	0.21	0.25
4	0.35	0.25	0.19	0.22
5	0.30	0.21	0.18	0.18
6	0.26	0.19	0.16	0.13
7	0.24	0.17	0.14	0.10
8	0.22	0.16	0.12	0.08
9	0.20	0.14	0.10	
10	0.19	0.12	0.08	
11	0.17	0.10		
12	0.15	0.08		
13	0.12			
14	0.10			
总进刀线速度	**3.59**	**2.44**	**1.66**	**1.49**

TR 30°– 外螺纹

走刀次数	随着螺距增大成比例降低线速度											
	总进刀深度 [mm]											
	14,0	**12,0**	**10,0**	**9,0**	**8,0**	**7,0**	**6,0**	**5,0**	**4,0**	**3,0**	**2,0**	**1,5**
1	0.40	0.38	0.38	0.38	0.37	0.37	0.37	0.34	0.31	0.27	0.25	0.23
2	0.37	0.36	0.36	0.35	0.35	0.34	0.35	0.33	0.28	0.25	0.24	0.22
3	0.36	0.34	0.34	0.34	0.34	0.33	0.32	0.27	0.24	0.21	0.20	0.18
4	0.36	0.34	0.34	0.33	0.33	0.31	0.29	0.25	0.20	0.17	0.17	0.14
5	0.35	0.32	0.32	0.31	0.31	0.29	0.27	0.23	0.19	0.15	0.14	0.12
6	0.35	0.32	0.32	0.30	0.29	0.26	0.25	0.21	0.18	0.13	0.13	0.08
7	0.34	0.30	0.31	0.29	0.28	0.26	0.23	0.20	0.16	0.13	0.11	
8	0.34	0.30	0.29	0.28	0.27	0.26	0.22	0.20	0.15	0.12	0.09	
9	0.34	0.30	0.28	0.26	0.25	0.24	0.22	0.18	0.15	0.12		
10	0.33	0.29	0.27	0.25	0.24	0.23	0.20	0.16	0.15	0.10		
11	0.33	0.29	0.25	0.24	0.23	0.22	0.18	0.15	0.14	0.10		
12	0.32	0.29	0.24	0.23	0.21	0.22	0.17	0.14	0.13	0.08		
13	0.32	0.28	0.23	0.22	0.20	0.20	0.17	0.13	0.10			
14	0.31	0.27	0.22	0.21	0.19	0.19	0.16	0.10				
15	0.31	0.25	0.22	0.21	0.19	0.17	0.14					
16	0.30	0.25	0.20	0.19	0.18	0.16	0.12					
17	0.30	0.24	0.19	0.18	0.17	0.12						
18	0.29	0.22	0.18	0.16	0.15							
19	0.28	0.20	0.17	0.15	0.13							
20	0.27	0.20	0.16	0.15								
21	0.23	0.19	0.15	0.13								
22	0.23	0.18	0.15									
23	0.21	0.17	0.13									
24	0.19	0.16										
25	0.17	0.15										
26	0.16	0.13										
27	0.16											
28	0.15											
29	0.13											
总进刀深度	**8.2**	**6.72**	**5.7**	**5.16**	**4.68**	**4.17**	**3.66**	**2.89**	**2.38**	**1.83**	**1.33**	**0.97**

TR – TR 30° – 内螺纹

走刀次数	随着螺距增大成比例降低线速度											
	总进刀深度 [mm]											
	14,0	**12,0**	**10,0**	**9,0**	**8,0**	**7,0**	**6,0**	**5,0**	**4,0**	**3,0**	**2,0**	**1,5**
1	0.40	0.38	0.38	0.38	0.37	0.37	0.37	0.34	0.31	0.27	0.25	0.23
2	0.37	0.36	0.36	0.35	0.35	0.34	0.34	0.33	0.28	0.25	0.24	0.22
3	0.36	0.34	0.34	0.34	0.34	0.33	0.32	0.27	0.24	0.22	0.21	0.19
4	0.36	0.34	0.34	0.33	0.33	0.31	0.29	0.25	0.20	0.17	0.17	0.14
5	0.35	0.32	0.32	0.31	0.31	0.29	0.27	0.23	0.19	0.15	0.14	0.12
6	0.35	0.32	0.32	0.31	0.29	0.26	0.25	0.21	0.18	0.14	0.13	0.08
7	0.34	0.30	0.31	0.29	0.28	0.26	0.23	0.20	0.16	0.13	0.11	
8	0.34	0.30	0.29	0.29	0.27	0.26	0.22	0.20	0.15	0.12	0.09	
9	0.34	0.30	0.28	0.26	0.25	0.24	0.22	0.18	0.15	0.12		
10	0.33	0.29	0.27	0.25	0.24	0.23	0.20	0.16	0.15	0.10		
11	0.33	0.29	0.25	0.24	0.23	0.22	0.18	0.15	0.14	0.10		
12	0.32	0.28	0.24	0.23	0.21	0.22	0.17	0.14	0.13	0.08		
13	0.32	0.28	0.23	0.22	0.20	0.20	0.17	0.13	0.10			
14	0.31	0.27	0.22	0.21	0.19	0.19	0.16	0.10				
15	0.31	0.25	0.22	0.21	0.19	0.17	0.14					
16	0.30	0.25	0.20	0.20	0.18	0.16	0.12					
17	0.30	0.24	0.19	0.18	0.17	0.12						
18	0.29	0.22	0.18	0.16	0.15							
19	0.28	0.20	0.17	0.15	0.13							
20	0.27	0.20	0.16	0.15								
21	0.27	0.19	0.15	0.13								
22	0.23	0.18	0.15									
23	0.23	0.17	0.13									
24	0.21	0.16										
25	0.19	0.15										
26	0.17	0.13										
27	0.16											
28	0.16											
29	0.15											
30	0.13											
总进刀深度	**8.47**	**6.71**	**5.7**	**5.19**	**4.68**	**4.17**	**3.65**	**2.89**	**2.38**	**1.85**	**1.34**	**0.98**

BSPT 55° – 内螺纹和外螺纹

走刀次数	随着螺距增大成比例降低线速度			
	螺距 [每英寸螺纹数]			
	11	**14**	**19**	**28**
1	0.22	0.19	0.19	0.15
2	0.21	0.18	0.18	0.14
3	0.20	0.17	0.17	0.13
4	0.19	0.16	0.15	0.12
5	0.18	0.15	0.13	0.08
6	0.16	0.14	0.08	
7	0.15	0.12		
8	0.13	0.08		
9	0.08			
总进刀深度	**1.52**	**1.19**	**0.90**	**0.62**

ACME 29° – 外螺纹

走刀次数	随着螺距增大成比例降低线速度							
	螺距 [每英寸螺纹数]							
	4	**5**	**6**	**8**	**10**	**12**	**14**	**16**
1	0.37	0.34	0.32	0.29	0.27	0.25	0.22	0.23
2	0.34	0.32	0.28	0.25	0.23	0.22	0.20	0.21
3	0.30	0.25	0.23	0.21	0.20	0.17	0.18	0.18
4	0.27	0.23	0.21	0.17	0.18	0.14	0.15	0.14
5	0.25	0.22	0.18	0.15	0.14	0.13	0.13	0.12
6	0.24	0.20	0.18	0.13	0.12	0.12	0.11	0.08
7	0.21	0.19	0.16	0.13	0.12	0.10	0.08	
8	0.20	0.19	0.16	0.12	0.11	0.09		
9	0.20	0.18	0.16	0.12	0.11			
10	0.18	0.16	0.15	0.11	0.09			
11	0.17	0.15	0.14	0.11				
12	0.16	0.14	0.13	0.09				
13	0.16	0.13	0.11					
14	0.15	0.11						
15	0.14							
16	0.12							
总进刀深度	**3.46**	**2.83**	**2.41**	**1.88**	**1.57**	**1.22**	**1.07**	**0.96**

ACME 29° – 内螺纹

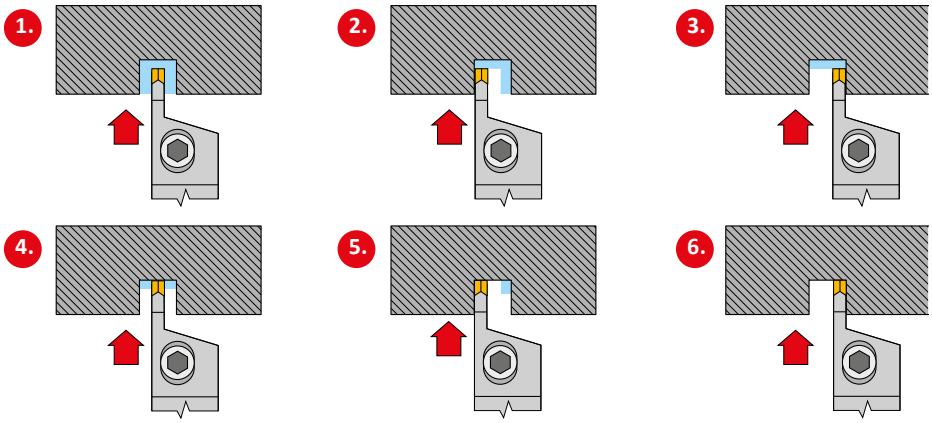
走刀次数	随着螺距增大成比例降低切削速度							
	螺距 [每英寸螺纹数]							
	4	**5**	**6**	**8**	**10**	**12**	**14**	**16**
1	0.37	0.34	0.32	0.29	0.27	0.25	0.22	0.23
2	0.33	0.31	0.27	0.25	0.23	0.22	0.20	0.21
3	0.30	0.25	0.23	0.21	0.20	0.17	0.18	0.17
4	0.27	0.23	0.20	0.17	0.18	0.15	0.15	0.14
5	0.25	0.22	0.18	0.15	0.15	0.13	0.13	0.12
6	0.23	0.20	0.18	0.14	0.12	0.12	0.11	0.08
7	0.21	0.19	0.16	0.13	0.12	0.10	0.08	
8	0.20	0.19	0.15	0.12	0.11	0.09		
9	0.20	0.17	0.15	0.12	0.11			
10	0.18	0.16	0.15	0.12	0.09			
11	0.17	0.15	0.14	0.11				
12	0.16	0.14	0.13	0.09				
13	0.16	0.13	0.11					
14	0.15	0.11						
15	0.14							
16	0.12							
总进刀线速度	**3.44**	**2.78**	**2.38**	**1.90**	**1.59**	**1.23**	**1.07**	**0.95**

切槽、切槽加工和仿形车削。

Pramet为径向和轴向 (端面切槽) 车削浅槽及深槽提供各种工具。圆形/仿形车削也可以通过侧切削实现。

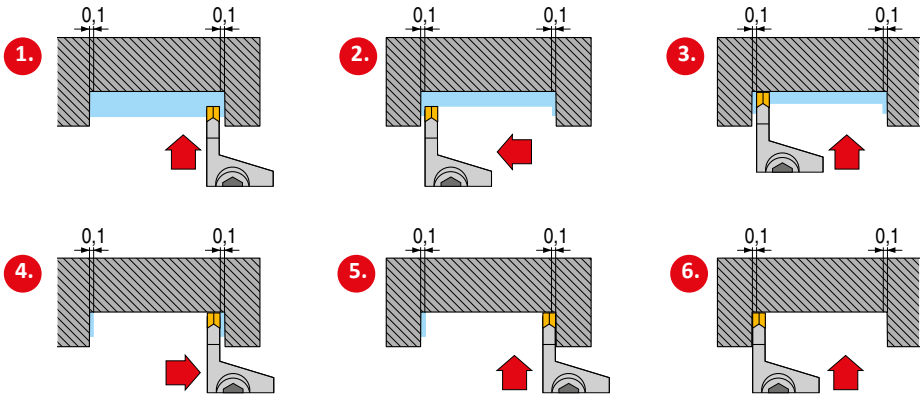
实际使用推荐 :

车削凹槽的步骤 (加深和加宽) 如下图所示。

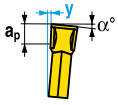


备注 : 使用GM或LCMF及F断屑槽的GL型刀片 , 可以实现一个平整的表面。外侧径向槽通道应与中心通道以刀片刀尖圆角的两倍重叠。

在加工宽槽时 , 按照下图所示步骤进行。

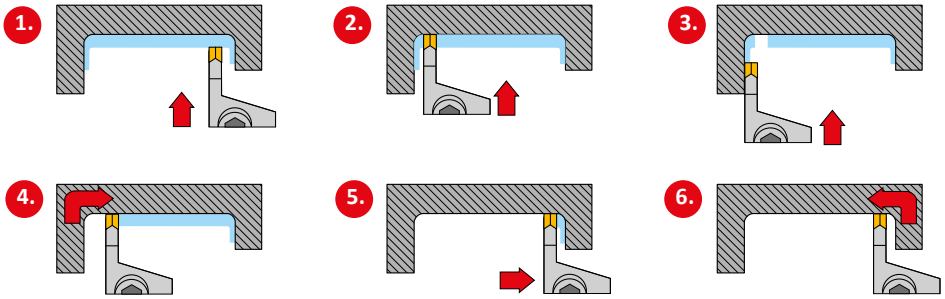


备注 : 使用带M断屑槽的LCMF刀片。必须考虑刀具的变形“*y*” :

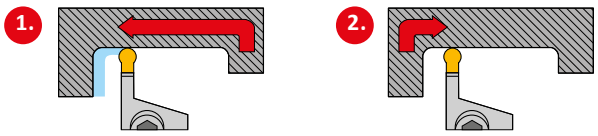


– 如果*f* =0.15 mm/rev ; a_p = 3 mm ***y = 0.07 mm***
– 如果*f* =0.25 mm/rev ; a_p = 3 mm ***y = 0.08 mm***
– 如果*f* =0.35 mm/rev ; a_p = 3 mm ***y = 0.10 mm***

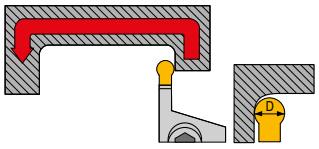
使用侧向车削扩大或加深轮廓时，按照下图所示步骤进行。



轮廓粗加工 (带圆切削刃的刀片)



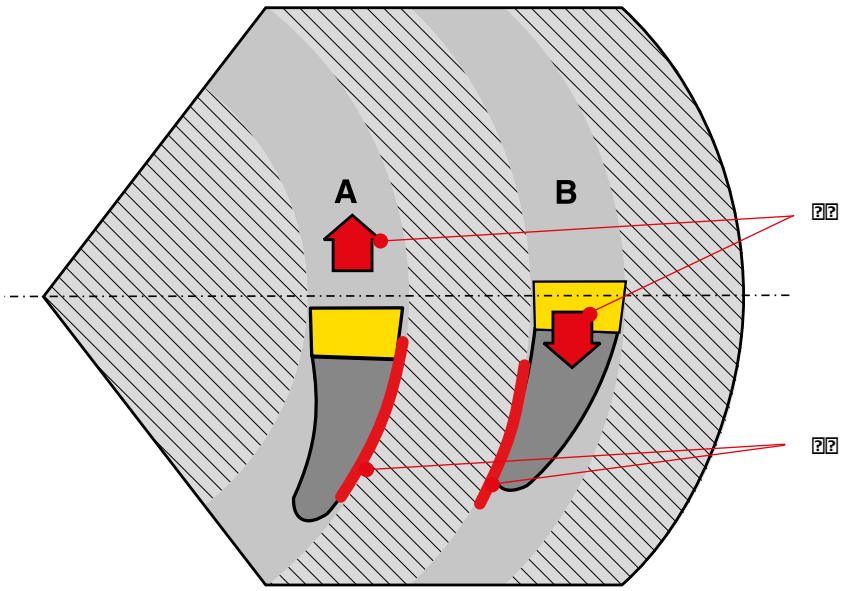
轮廓精加工 (带圆切削刃的刀片)



D (mm)	a_p (mm)
3	0.15
4	0.20
5	0.22
6	0.25
8	0.40

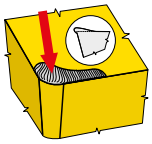
使用带圆形切削刃的可转位刀片进行仿形车削时，最大切削深度为刀片直径的50%
选择横截面最大且刀具悬伸最小的刀杆，以消除振动。
刀片的纵轴必须与工件旋转轴（在径向凹槽上）垂直。
切削刃必须在中心线上，公差为+ – 0.1 mm
冷却剂必须直接作用在切削刃上以及刀片切削刃下方的刀杆支撑区域，冷却剂量应足够确保刀片冷却。
进行端面切槽时，必须选择直径范围与待加工槽正确匹配的刀杆。刀具必须与工件的旋转轴平行（垂直于槽端面），否则在加工过程中有摩擦槽壁的风险。
如果刀具与槽的外壁发生摩擦，可能需要将切削刃升高至中心线以上（参见图29中的示例A）。

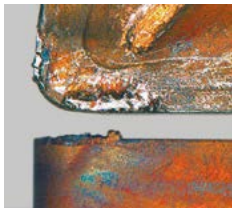
进行端面切槽时，刀具必须与工件端面完全垂直，否则刀具侧面将与加工的槽产生摩擦。



直接在切削刃上使用足量的高效冷却剂非常重要。冷却作用能够降低切削刃的温度，进而降低刀杆下部的温度。

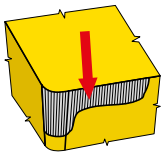
积屑瘤

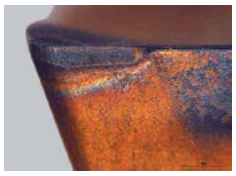




		无影响
(MT)CVD PVD	++	任何涂层(减振是决定因素)
f	↑	更高的进给意味着更小的积屑瘤范围
v	↓↑	改变线速度(通常增加)
a_p		无影响
	↓↑	选用更锋利槽型(当前角超过40°时不会产生积屑瘤)
	-	选用具有更有效的抗粘属性的冷却液(或者根本不用冷却液)

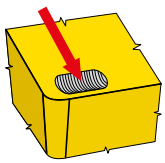
后刀面磨损

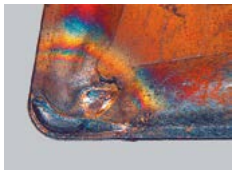




	↑	使用更耐磨材质(H)
(MT)CVD PVD	++	任何涂层(取决于硬度 - TiC,TiCN)
f	↑	增加进给(尤其是磨损小于0,1mm的情况下)
v	↓	降低线速度
	↑	无影响
a_p	+	最重要的是增加后角
	+	选用冷却液或增加冷却液的密度

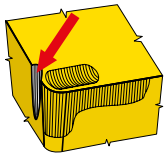
月牙洼磨损

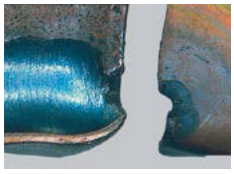




	↑	选用更耐磨材质(S)
(MT)CVD PVD	++	任何涂层(取决于耐热性能 - αAl_2O_3)
f	↑	进给对凹槽的形状和位置有影响
v	↓	降低线速度
a_p	↓	最小的影响
	↑	选用更锋利的切削槽
	++	使用冷却液或增加冷却液密度

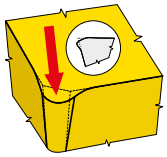
副切削刃上的氧化沟

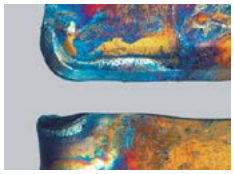




	↑	选用更耐磨材质(S)
(MT)CVD PVD	++	任何涂层(取决于耐氧化性能- αAl_2O_3)
f	↓	进给对凹槽的形状和位置有影响
V	↓	降低线速度
a_p	↓	最小的影响
	↑	选用更锋利的断屑槽
	++	使用冷却液或增加冷却液密度

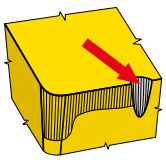
塑性变形

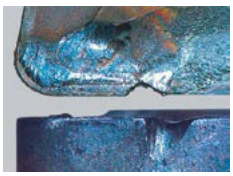




	↑	选用更耐磨的材质(取决于含Co量)
(MT)CVD PVD	+	任何涂层(取决于摩擦系数)
f	↓	降低进给率
V	↓	降低线速度
a_p	↓	最小的影响
	↑	选用更锋利的断屑槽
	++	使用冷却液或增加冷却液密度

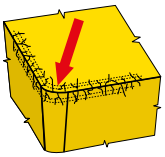
侧刃沟槽磨损

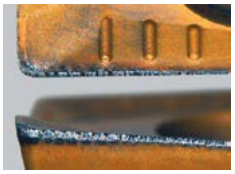




	↑ ↓	取决于磨损类型(磨损 - 使用更耐磨的基材;崩口 - 使用更韧性的基材)
(MT)CVD PVD	++	CVD 涂层 (取决于耐氧化性- αAl_2O_3)
f	↓	进给对强度有影响, 但是比线速度影响小
V	↓	降低线速度
a_p	↑↓	选用不等切深
	↓	选用钝的槽型
	+	使用冷却液或增加冷却液密度
		选用更小主偏角的刀具

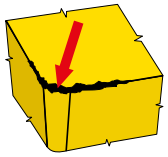
热裂纹

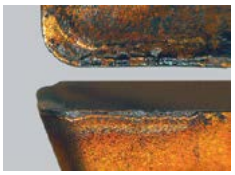




	↓	(H)颗粒基体影响大
(MT)CVD / PVD	++	推荐PVD涂层
f	↓	进给对强度有影响, 但是小于线速度的影响
v	↓	更低的进给意味着更低的温度
a_p		无影响
	↓	选用钝的槽型
	---	不推荐使用冷却液(可以使用压缩空气以去除铁屑)

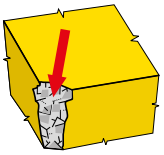
刃口脆裂





	↓	(H)颗粒基体影响大
(MT)CVD / PVD	+	推荐PVD涂层
f	↓	良好的断屑及其重要
v	↑↓	可能是由于断屑和振动问题
a_p	↓	降低切削负载(对于长悬伸工况来说很重要)
	↓	选用钝的槽型
		冷却液无影响
		选用更好的工况, 降低切入的进给

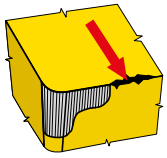
刀片崩损





	↓	(H)颗粒基体影响大
(MT)CVD / PVD	+	推荐PVD涂层
f	↓	降低切削力
v	↑↓	可能是由于断屑和振动问题
a_p	↓	降低切削力
	↓	选用钝的槽型
		对冷却液无影响
		选用更好的工况

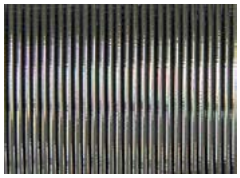
刃口剥落





	↓	(H)颗粒基体影响大
	+	推荐PVD涂层
	↑↓	良好的断屑极其重要
	↑↓	可能是由于断屑和振动问题
	↑↓	良好的断屑极其重要
	↓	选用钝的槽型
		冷却液无影响
		问题产生于断屑差, 铁屑去除问题

表面质量差



问题描述和原因：

原因很明显，取决于工件材料、切削工况 (进给量和线速度)、切削刃状态、伸出和磨损形式、机床-刀具-工件的状况和刚度。

- 选错刀具
- 错误的切屑厚度
- 错误的线速度
- 需要冷却液
- 高进给率

问题与对策：

- 使用修光刃刀片
- 使用具有正确槽型的刀片
- 降低进给率
- 改变 (通常增加) 切削速度
- 使用冷却液
- 提高刀体与工件的稳定性。
- 改变切屑横截面
- 选择一种切削更轻快的断屑槽
- 增大刀尖半径

振动



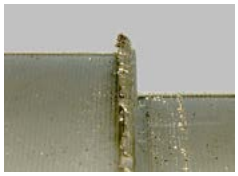
问题描述和原因：

该问题出现非常频繁。主要原因是工件或刀具不平衡、工件的纯稳定、高切削力、刀具悬伸。

问题与对策：

- 提高刀体与工件的稳定性。
- 降低切削深度
- 将刀具悬伸减至最小
- 降低线速度
- 使用主偏角更小的刀具
- 降低切屑横截面
- 使用切削阻力小的刀具
- 提高进给率
- 选择一种切削更轻快的断屑槽
- 增大刀尖半径

毛刺



问题描述和原因：

通常出现在软钢和塑性材料的加工中。

问题与对策：

- 使用具有锋利切削刃的刀片
- 使用具有正前角槽型的刀片
- 使用主偏角更小的刀具

工件的尺寸和 形状误差



问题描述和原因：

取决于许多因素。

问题与对策：

- – 使用耐磨刀片
- – 提高刀具和工件的稳定性 , 减小刀具悬伸
- – 使用具有合适加工余量的工件

不可接受的切屑控制



问题描述和原因：

合适的切屑形状对于刀具耐久性 (寿命) 等是重要的指标之一。工件材料、进给量、切深、合适的切削槽型 (断屑槽) 都影响正确的切屑成形。长切屑无法接受，但也不期望出现太短的切屑 (压碎)，因为这意味着切削刃过载且会导致振动。

问题与对策：

- 改变进给量和切削深度
- 使用更合适的切削槽型
- 改变切削工况

检查刀片座状况

在需要夹紧新的刀片或改变切削刃 (刀片的旋向) 以净化刀片座之前，检查刀片座状况或刀垫和楔块的状况 (特别是刀片刀尖下方的损坏情况)。

夹紧部件的检查和维护

检查夹紧部件 – 夹紧杠杆、螺钉、楔块、夹子。只使用完好无损的部件，只使用原装部件 – 可以在样本中找到相关信息。定期润滑螺纹和螺钉的结合表面，如用耐热润滑剂 (Molyko G) 等。在进行安装和解体时，只使用我们在样本中规定的或制造商推荐的螺丝刀和扳手。注意正确拧紧 (成比例)，建议使用扭矩扳手。

检查拧紧情况

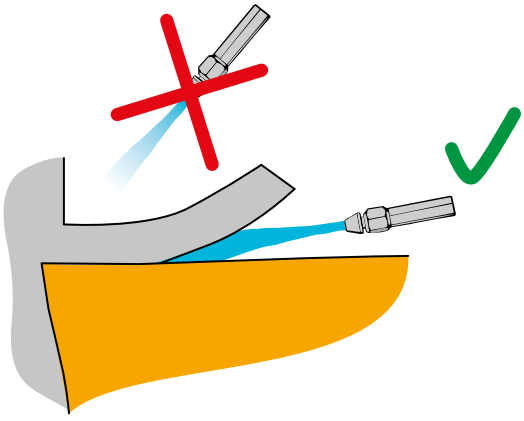
拧紧时 , 检查刀片在整个结合表面上的安装以及在径向与轴向的安装。刀片和刀体必须总是保持清洁 , 不得有损坏。

切削液的作用



加工材料– 工件材料切削性能越差，切削环境的影响越大。
切削等级 – 韧度（钴含量）越高，切削环境的影响越大。冷却不仅仅建议用于高速加工，即对CBN和陶瓷刀具使用。
进给 – 进给量越大，切削液对刀具寿命的影响越大。
线速度（尤其是对于机加工材料） – 线速度越高，切削液的冷却效果越重要，反之，线速度越低，切削液的润滑作用越重要。
切削液供给也是显著影响切削过程的经济性和生产率的一项标准。

在理想情况下，切削液可以供应到刀具的前刀面和后刀面。后刀面的切削液供应只影响刀具寿命。而供应给前刀面的切削液在某些情况下有助于形成切屑（特别是在高压冷却时）。如果只能选择一种供应方式，可以通过磨损类型确定。如果后刀面磨损，尝试从下面供应切削液，即，作用于后刀面。如果形成了一个月牙洼，则切削液应作用于前刀面（在切屑下方而非其根部供应）。



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 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
PS 6026-709P	SRD T09P	2

夹紧螺钉

螺钉名称	螺丝刀	扭矩 (Nm)*
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
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

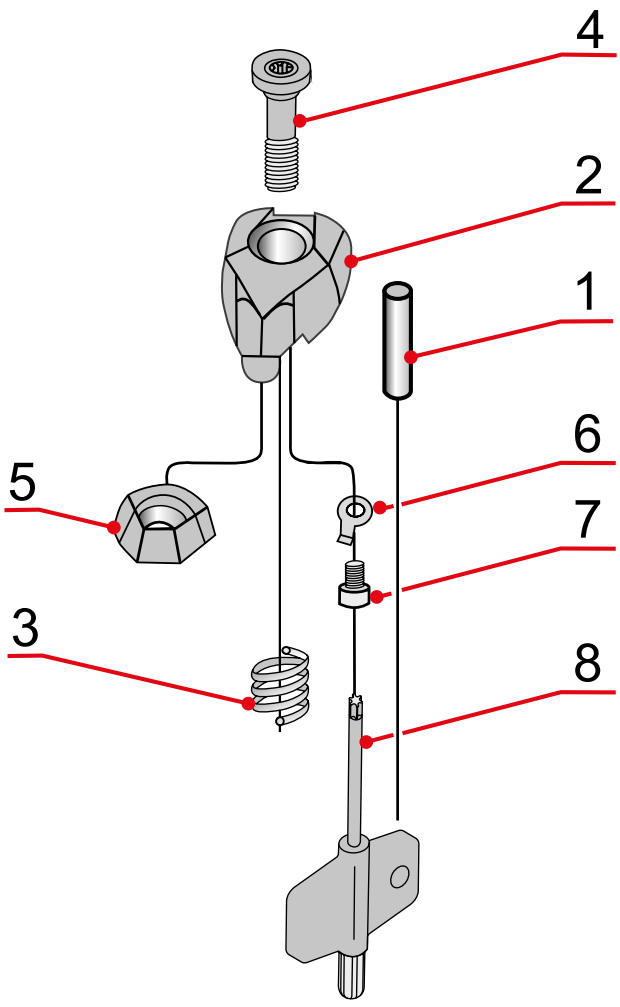
扭矩手柄	扭矩 (Nm)	夹紧螺钉螺纹
MR-0.8-2.0 vario	0.5 – 2.0	M 2 – M 3
MR-1.0-5.0 vario	0.8 – 5.0	M 2.5 – M 5
MR-0.9 fix	0.9	M 2
MR-2.0 fix	2.0	M 3
MR-3.0 fix	3.0	M 3.5
MR-3.5 fix	3.5	M 4
MR-5.0 fix	5.0	M 5

可替换的接杆

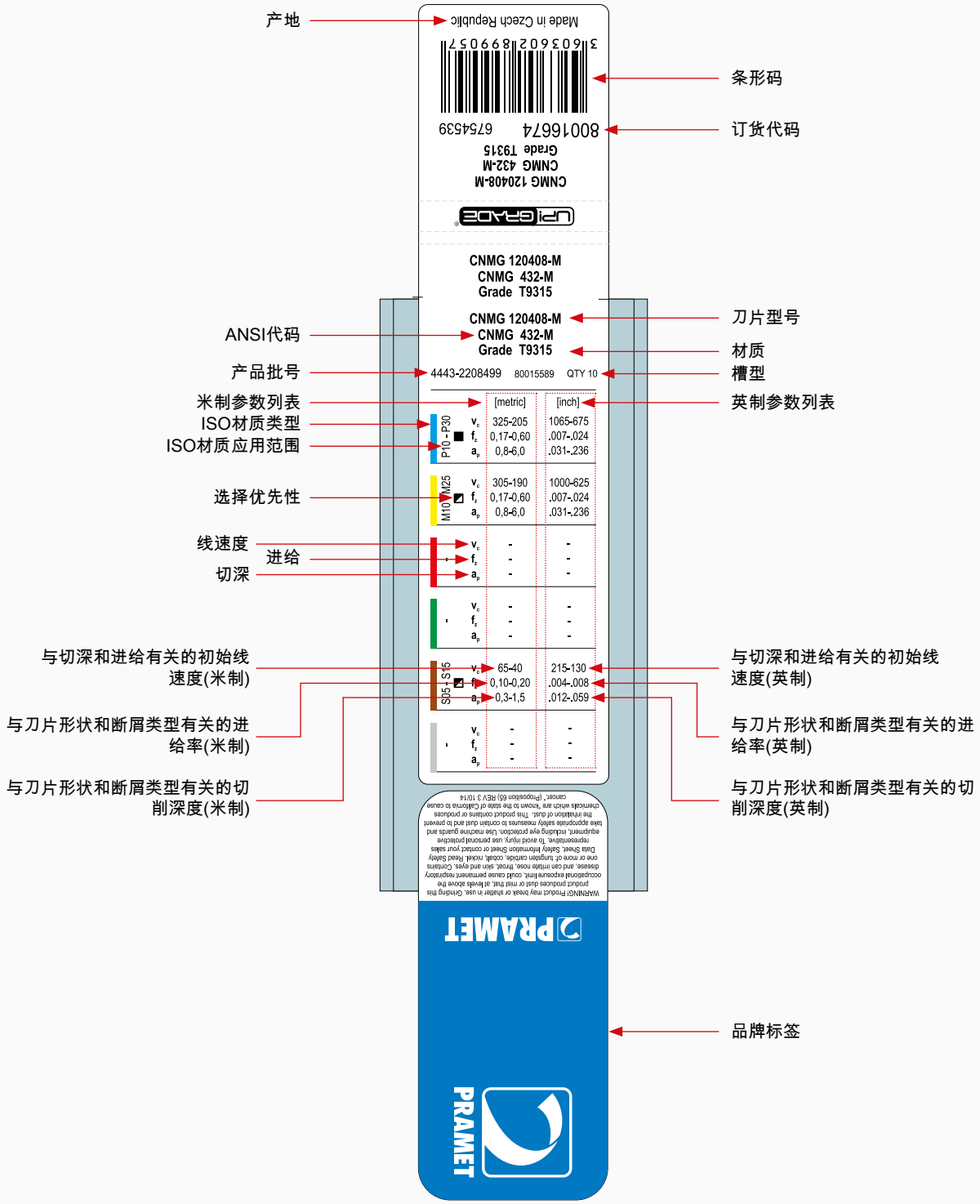
可替换的接杆		
D-T6	**D-T8**	**D-T15**
D-T6P	**D-T8P**	**D-T15P**
D-T7	**D-T9**	**D-T20**
D-T7P	**D-T9P**	**D-T20P**

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


产地
Made in Czech Republic
条形码
订货代码
CNMG 120408-M
CNMG 432-M
Grade T9315
ANSI代码
产品批号
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
刀片型号
材质
槽型
英制参数列表
4443-2208499
80015589
QTY 10
[metric]
[inch]
P10 - P30
M10 - M25
S05 - S15
65-40
215-130
0,10-0,20
.004-.008
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)
品牌标签
PRAMET

SIMPLY RELIABLE

作为你可以通过切屑判断工件质量的专业公司。该切屑是清洁和简单的形状这本身就在讲述了一个故事。这是一个清晰和一致的信号，这就是为什么我们使用它作为简洁可靠的符号。

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