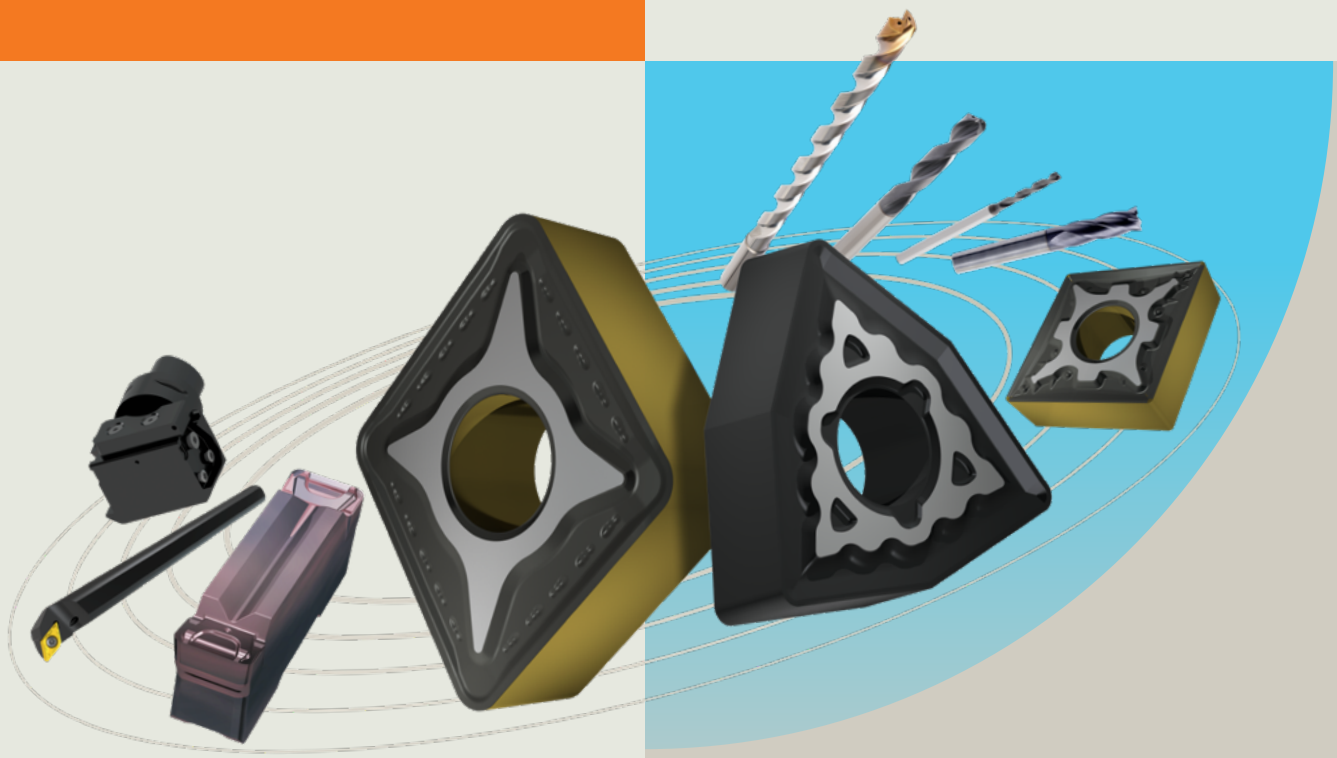
DORMER PRAMET™

新产品
2026



Certainty
at every turn™

dormerpramet.com

前言

尊敬的客户：

我们怀着无比喜悦与激动的心情，向您展示2026年度全新产品。

每一年都赋予我们提供更优解决方案的契机，本次新品发布正是我们坚守正确理念所取得稳步进展的体现。

作为全球领先的金属切削工具及相关服务供应商，最新研发成果彰显了我们在技术革新道路上的长足进步，始终致力于满足您不断变化的需求。

2026产品系列旨在助您释放最大性能潜能。这些解决方案专为提升持续稳定的生产效率、增强工艺稳定性及保障可靠成果而设计。我们的产品通过工程优化实现高效生产与性能提升，提供卓越稳定性与持久耐用性，助您攻克挑战、超越预期。这种协同效应使我们能够提供可靠性、成本节约与创新价值，为您创造更大收益。

我们期待在2026年及未来岁月里，持续助力您的成功。

Fillippo Mauri
Dormer Pramet 总裁

孔加工

原力 X 2 代	4
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车削产品

T5405 牌号	48
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刀柄

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可持续发展

携手共筑可持续未来

对于Dormer Pramet而言，可持续发展并非挑战，而是机遇。
但这绝非我们能独自应对的课题。

我们正与客户、合作伙伴及社区携手同行，以创新精神、学习态度和成长信念凝聚成一个团队。我们的理念很简单：同舟共济，共创深远影响。

我们深知，做出可持续的选择不仅关乎道德担当，更关乎企业发展的正确方向。我们的刀具经久耐用、高效可靠，助您在减少环境足迹的同时提升运营效能。

更长的刀具寿命，更少的浪费

我们的产品以耐用性为设计核心，这意味着更少的更换需求、更少的浪费，以及更持久的价值。
这正是可持续理念的实践——延长刀具使用寿命，守护珍贵资源。

降低能耗，提高生产力

我们制造的产品能帮助客户在提升效率的同时降低能耗。
凭借更低的切削力与更高的生产效率，我们让您的作业更高效、更环保。

可持续发展是每件刀具的核心

直面挑战，提供解决方案

我们对地球和您事业的承诺，驱动着我们所做的每一个决定。

循环性

我们致力于确保废弃物、产品及包装材料实现至少90%的循环利用率。我们坚持采购符合道德标准的再生材料，以在整个供应链中持续推进循环经济。

在开展新客户项目时，我们聚焦材料与资源效率，设计可重复使用和回收利用的新型产品。

在当地基础设施允许的情况下，我们努力从生产运营中回收有价值的材料，推动刀具材料采用更循环的处理方式。

二氧化碳减排

我们的目标是在2040年前实现净零排放。

截至2025年，相较于2019年基准线（范围1和范围2*），我们的二氧化碳排放量已减少约78%，这彰显了我们在可持续发展道路上取得的显著进展。

* 范围1排放涵盖企业自有运营产生的直接排放。
* 范围2排放为间接排放，源于企业采购电力、蒸汽、热能或制冷服务所产生的排放。

包装

自2025年起，Dormer Pramet产品启用全新灰色包装配橙色标签，延续使用PCR再生塑料，并通过中性色调设计使包装更易于反复回收，从而提升循环利用率。

这一举措在各生产基地均见成效：在圣保罗工厂，我们每年回收塑料超过100吨，同时实现了二氧化碳排放量的降低。

适用于各种材料的高性能整体硬质合金钻头

多功能、经久耐用，提高生产率

Force X 2 代--高要求钻孔应用的完美解决方案。

该系列包括 3xD、5xD 和 8xD，可用于不同的钻孔深度。

这些整体硬质合金钻头具有 140° 自定心四面刃分度点和先进的 CTW 刃口设计，可在各种材料上钻出优质孔（孔公差为 H9）。Force X 2 代钻头采用 TiAlN 表面涂层，可提高硬度并延长刀具寿命，即使在 ISO P、M 和 K 材料组中具有挑战性的应用中，也能确保可靠的性能。

相关产品

RC408

8xD

3 – 16毫米

TiAlN 顶部涂层 **冷却液进给**

RS405

5xD

3 – 20毫米

TiAlN 顶部涂层

RC405

5xD

3 – 20毫米

TiAlN 顶部涂层 **冷却液进给**

RS403

3xD

3 – 20毫米

TiAlN 顶部涂层

RC403

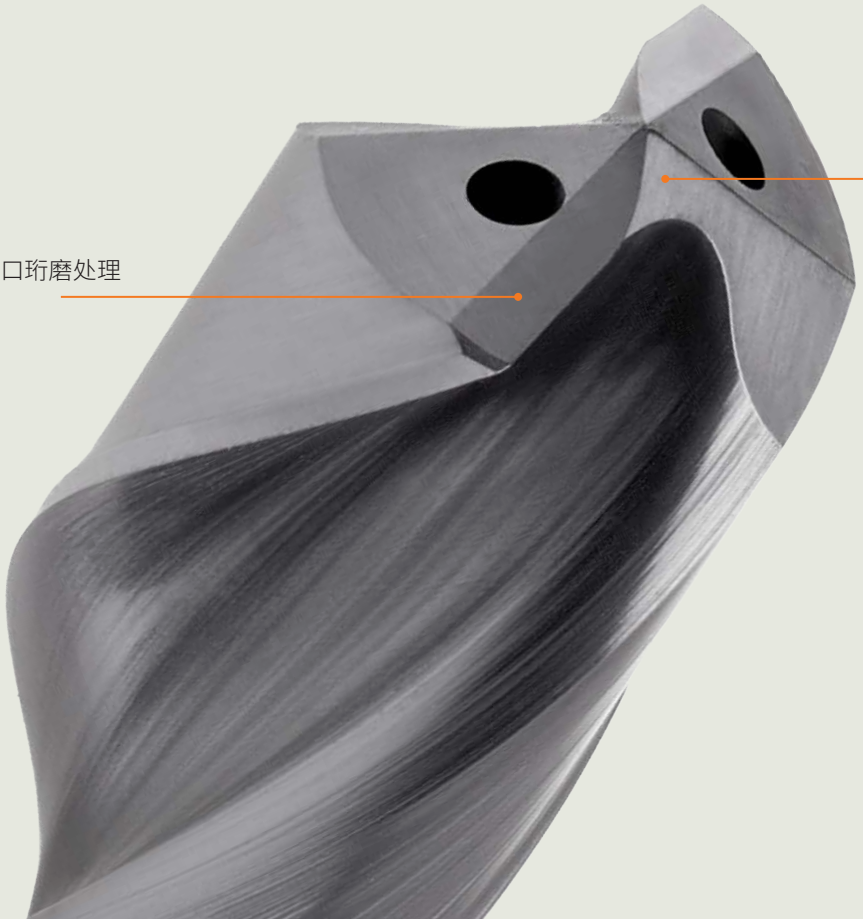
3xD

3 – 20毫米

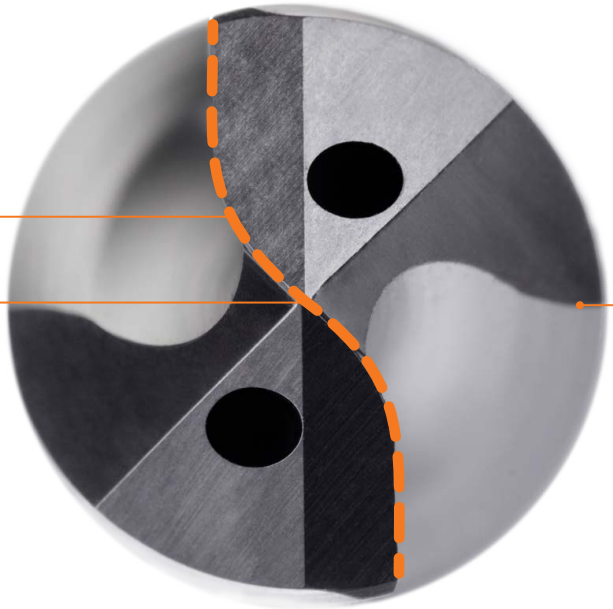
TiAlN 顶部涂层 **冷却液进给**

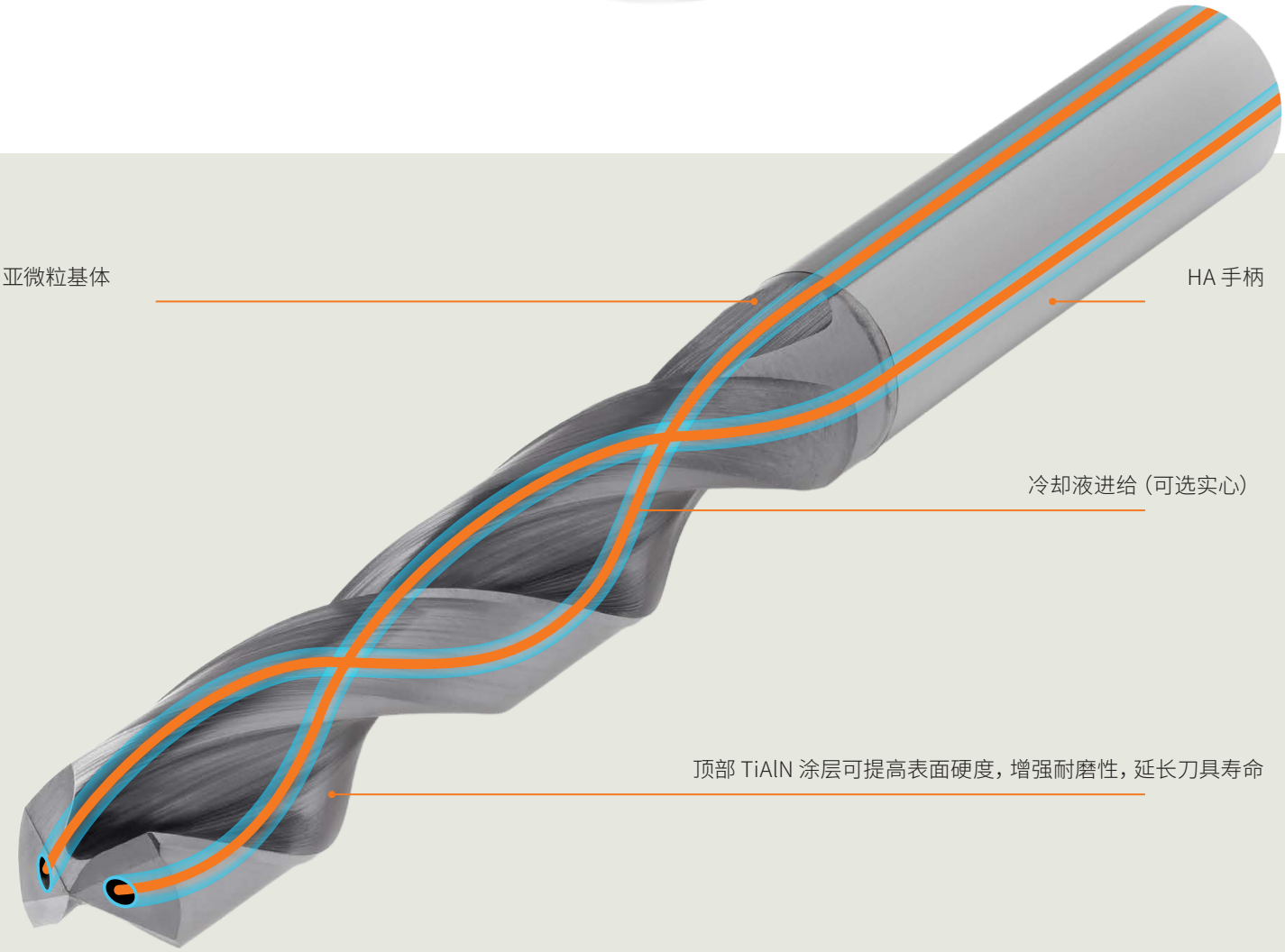
特点和优点

独特的笛形设计，笛腹连续变薄，笛跟卷曲。	**可靠的切屑控制可确保** P、M 和 K 材料的顺利排空。
亚微米级碳化物基体。	**扩展的边缘韧性和硬度平衡** 在各种材料条件下都能提供稳定的性能和较长的使用寿命。
顶部的 TiAlN 涂层可提供耐磨保护。	**提高刀具寿命** 更低的摩擦系数可在更长时间的高速运转中保持性能。
S 形四面精磨分离式钻尖。	**精确的孔定位** 支持清洁的入口、出口和高质量的表面处理。
经过优化的钻尖，转角几何形状坚固。	**更高的进给量** 缩短周期时间，提高每个零件的生产率。



特点和优点


S 形凿子，角部几何形状得到加强
4刀面分离式刀尖提供自定心精度，可实现精确钻孔和快速穿孔
线性刃线设计


亚微粒基体
HA 手柄
冷却液进给（可选实心）
顶部 TiAlN 涂层可提高表面硬度，增强耐磨性，延长刀具寿命

成功案例

在钢材加工中，刀具寿命延长 57%，成本降低 35%

客户成果：Force X 2 代钻头在钢材加工中表现出色，与同类产品相比，刀具寿命延长了 57%（640 孔比 408 孔）。尽管刀具价格相当，但 Force X 2 代将单件刀具成本降低了 35%，使其成为高性价比钻孔加工的不二之选。

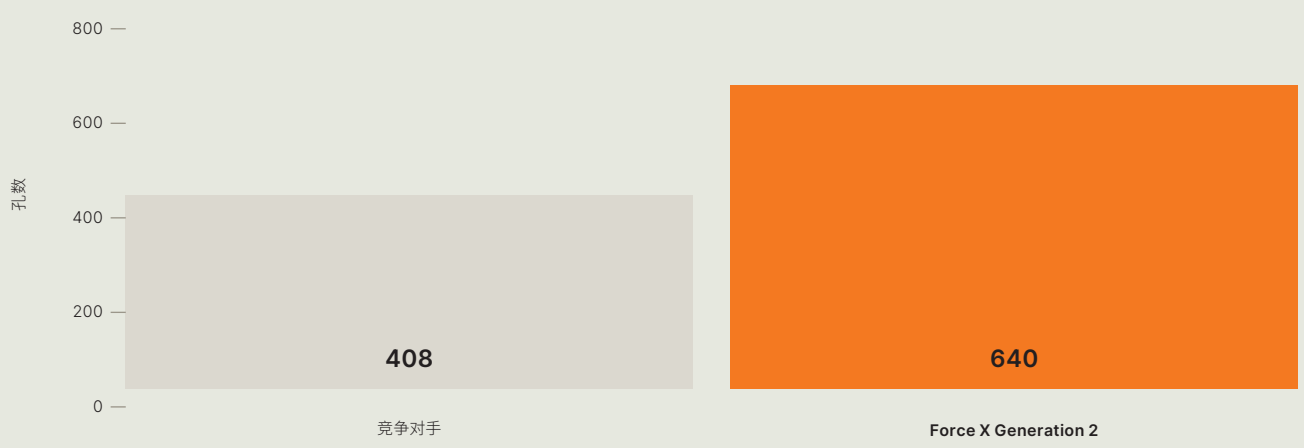
在切削参数不变的情况下，它既能保持生产率，又能显著降低总刀具成本。对于旨在最大限度提高产量和盈利能力的制造商来说，Force X 2 代为 ISO-P 应用树立了新的标杆。

行业	应用	材料	冷却液	Dormer Pramet 解决方案
模具	螺纹预钻孔	1.2379 / 255 HB	是	RC4056.8

加工数据	竞争对手	Force X Generation 2
钻孔深度 (毫米)	20	20
切削速度 v_c (米/分钟)	80	80
进给 f_n (毫米/转)	0.14	0.15
进料 v_f (毫米/分钟)	524	561

P4.1

刀具寿命(孔数)



成功案例

将钢钻孔的进给率提高 108%，从而提高生产率

客户成果：Force X 2 代钻头为多材料加工树立了新的标杆，与同类产品相比，它在 4140 钢中的进给率提高了 108%，切削速度提高了 51%。

即使在要求苛刻的不锈钢加工中，它的进给率也提高了 8%，切削速度提高了 4%，确保了 ISO-P 和 ISO-M 材料的卓越生产率。在早期试验中，Force X 2 代没有出现明显的刀具磨损，证明了其在小批量加工中实现高性价比、高性能钻孔的能力。

行业	应用	材料	冷却液	Dormer Pramet 解决方案
汽车	钻销孔	4140	有（外部）	RS4056.0

加工数据	竞争对手	Force X Generation 2
钻孔深度 (英寸)	1.2	1.2
切削速度 v_c (尺/分钟)	173	262
主轴转速 n (转/分钟)	2800	4240
进给 f_n (英寸/转)	0.0043	0.006
进料 v_f (英寸/分钟)	12	25

P3.2

行业	应用	材料	冷却液	Dormer Pramet 解决方案
汽车	钻销孔	304	有（外部）	RS4056.0

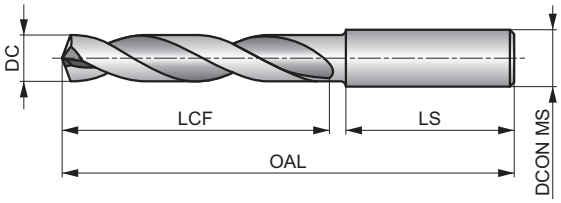
加工数据	竞争对手	Force X Generation 2
钻孔深度 (英寸)	1.35	1.35
切削速度 v_c (尺/分钟)	173	180
主轴转速 n (转/分钟)	2800	2913
进给 f_n (英寸/转)	0.0043	0.0045
进料 v_f (英寸/分钟)	12	13

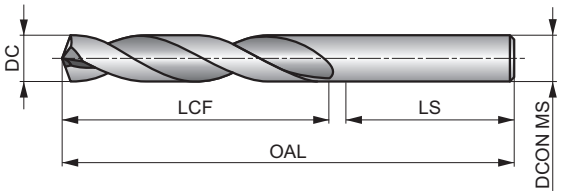
M3.2

RS403

DORMER PRAMET

FORCE X 整体硬质合金 3XD 钻头, TiAlN 顶部涂层
高性能钻头专为在高速和高进给条件下提供优异的孔质量而设计（H9 孔公差，适用于多种材料）。140° 自定心、4 刀面分瓣和 CTW 刀槽结构。顶部的 TiAlN 涂层可提高表面硬度，增强耐磨性，延长刀具寿命。





HM	DIN 6537	3×D
140°	TiAlN Top	DIN 6535HA
CTW	R	DC m7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页24开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 112 V	■ 114 V	■ 114 V	■ 98 V	■ 96 V	■ 84 V	■ 88 V	■ 82 V	■ 80 V	■ 79 V	■ 76 V	■ 40 U	◪ 79 V	◪ 76 V
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
◪ 74 U	◪ 60 U	◪ 52 U	◪ 64 U	◪ 52 U	◪ 49 U	◪ 45 U	◪ 38 U	■ 89 W	■ 86 W	■ 84 W	■ 89 W	■ 88 W	■ 79 W
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.2	N1.3	N2.1
■ 84 W	■ 79 W	■ 76 W	■ 80 W	■ 64 W	■ 62 W	■ 58 W	■ 56 W	■ 84 V	■ 80 V	■ 64 V	◪ 279 W	◪ 270 W	◪ 199 W
N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3						
◪ 198 W	◪ 180 W	◪ 166 W	◪ 162 W	◪ 158 W	◪ 40 U	◪ 32 U	◪ 28 U						

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RS4033.0	–	3.00	0.1181	20.0	62.0	36.0	6.00
RS4033.1	–	3.10	0.1220	20.0	62.0	36.0	6.00
RS4031/8	1/8	3.18	0.1250	20.0	62.0	36.0	6.00
RS4033.2	–	3.20	0.1260	20.0	62.0	36.0	6.00
RS403N30	N30	3.26	0.1283	20.0	62.0	36.0	6.00
RS4033.3	–	3.30	0.1299	20.0	62.0	36.0	6.00
RS4033.4	–	3.40	0.1339	20.0	62.0	36.0	6.00
RS403N29	N29	3.45	0.1360	20.0	62.0	36.0	6.00
RS4033.5	–	3.50	0.1378	20.0	62.0	36.0	6.00
RS403N28	N28	3.57	0.1406	20.0	62.0	36.0	6.00
RS4039/64	9/64	3.57	0.1406	20.0	62.0	36.0	6.00
RS4033.6	–	3.60	0.1417	20.0	62.0	36.0	6.00
RS403N27	N27	3.66	0.1441	20.0	62.0	36.0	6.00
RS4033.7	–	3.70	0.1457	20.0	62.0	36.0	6.00
RS4033.73	–	3.73	0.1469	24.0	66.0	36.0	6.00
RS403N26	N26	3.73	0.1469	24.0	66.0	36.0	6.00
RS403N25	N25	3.80	0.1496	24.0	66.0	36.0	6.00
RS4033.8	–	3.80	0.1496	24.0	66.0	36.0	6.00
RS403N24	N24	3.86	0.1520	24.0	66.0	36.0	6.00
RS4033.9	–	3.90	0.1535	24.0	66.0	36.0	6.00
RS403N23	N23	3.91	0.1539	24.0	66.0	36.0	6.00
RS4035/32	5/32	3.97	0.1563	24.0	66.0	36.0	6.00
RS403N22	N22	3.99	0.1571	24.0	66.0	36.0	6.00
RS4034.0	–	4.00	0.1575	24.0	66.0	36.0	6.00
RS403N21	N21	4.04	0.1591	24.0	66.0	36.0	6.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RS403N20	N20	4.09	0.1610	24.0	66.0	36.0	6.00
RS4034.1	–	4.10	0.1614	24.0	66.0	36.0	6.00
RS4034.2	–	4.20	0.1654	24.0	66.0	36.0	6.00
RS403N19	N19	4.22	0.1661	24.0	66.0	36.0	6.00
RS4034.3	–	4.30	0.1693	24.0	66.0	36.0	6.00
RS403N18	N18	4.31	0.1697	24.0	66.0	36.0	6.00
RS40311/64	11/64	4.37	0.1719	24.0	66.0	36.0	6.00
RS403N17	N17	4.39	0.1728	24.0	66.0	36.0	6.00
RS4034.4	–	4.40	0.1732	24.0	66.0	36.0	6.00
RS403N16	N16	4.50	0.1772	24.0	66.0	36.0	6.00
RS4034.5	–	4.50	0.1772	24.0	66.0	36.0	6.00
RS403N15	N15	4.57	0.1799	24.0	66.0	36.0	6.00
RS4034.6	–	4.60	0.1811	24.0	66.0	36.0	6.00
RS403N14	N14	4.62	0.1819	24.0	66.0	36.0	6.00
RS403N13	N13	4.70	0.1850	24.0	66.0	36.0	6.00
RS4034.7	–	4.70	0.1850	24.0	66.0	36.0	6.00
RS4033/16	3/16	4.76	0.1875	28.0	66.0	36.0	6.00
RS403N12	N12	4.80	0.1890	28.0	66.0	36.0	6.00
RS4034.8	–	4.80	0.1890	28.0	66.0	36.0	6.00
RS403N11	N11	4.85	0.1909	28.0	66.0	36.0	6.00
RS4034.9	–	4.90	0.1929	28.0	66.0	36.0	6.00
RS403N10	N10	4.92	0.1937	28.0	66.0	36.0	6.00
RS403N9	N9	4.98	0.1961	28.0	66.0	36.0	6.00
RS4035.0	–	5.00	0.1969	28.0	66.0	36.0	6.00
RS403N8	N8	5.06	0.1992	28.0	66.0	36.0	6.00

产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RS4035.1	–	5.10	0.2008	28.0	66.0	36.0	6.00
RS403N7	N7	5.11	0.2010	28.0	66.0	36.0	6.00
RS40313/64	13/64	5.16	0.2031	28.0	66.0	36.0	6.00
RS403N6	N6	5.18	0.2039	28.0	66.0	36.0	6.00
RS4035.2	–	5.20	0.2047	28.0	66.0	36.0	6.00
RS403N5	N5	5.22	0.2055	28.0	66.0	36.0	6.00
RS4035.3	–	5.30	0.2087	28.0	66.0	36.0	6.00
RS403N4	N4	5.31	0.2091	28.0	66.0	36.0	6.00
RS4035.4	–	5.40	0.2126	28.0	66.0	36.0	6.00
RS403N3	N3	5.41	0.2130	28.0	66.0	36.0	6.00
RS4035.5	–	5.50	0.2165	28.0	66.0	36.0	6.00
RS4037/32	7/32	5.56	0.2188	28.0	66.0	36.0	6.00
RS4035.6	–	5.60	0.2205	28.0	66.0	36.0	6.00
RS403N2	N2	5.61	0.2209	28.0	66.0	36.0	6.00
RS4035.7	–	5.70	0.2244	28.0	66.0	36.0	6.00
RS403N1	N1	5.79	0.2280	28.0	66.0	36.0	6.00
RS4035.8	–	5.80	0.2283	28.0	66.0	36.0	6.00
RS4035.9	–	5.90	0.2323	28.0	66.0	36.0	6.00
RS403A	A	5.94	0.2339	28.0	66.0	36.0	6.00
RS40315/64	15/64	5.95	0.2344	28.0	66.0	36.0	6.00
RS4036.0	–	6.00	0.2362	28.0	66.0	36.0	6.00
RS403B	B	6.05	0.2380	34.0	79.0	36.0	8.00
RS4036.1	–	6.10	0.2402	34.0	79.0	36.0	8.00
RS403C	C	6.15	0.2421	34.0	79.0	36.0	8.00
RS4036.2	–	6.20	0.2441	34.0	79.0	36.0	8.00
RS403D	D	6.25	0.2461	34.0	79.0	36.0	8.00
RS4036.3	–	6.30	0.2480	34.0	79.0	36.0	8.00
RS403E	E	6.35	0.2500	34.0	79.0	36.0	8.00
RS4031/4	1/4	6.35	0.2500	34.0	79.0	36.0	8.00
RS4036.4	–	6.40	0.2520	34.0	79.0	36.0	8.00
RS4036.5	–	6.50	0.2559	34.0	79.0	36.0	8.00
RS403F	F	6.53	0.2571	34.0	79.0	36.0	8.00
RS4036.6	–	6.60	0.2598	34.0	79.0	36.0	8.00
RS403G	G	6.63	0.2610	34.0	79.0	36.0	8.00
RS4036.7	–	6.70	0.2638	34.0	79.0	36.0	8.00
RS40317/64	17/64	6.75	0.2656	34.0	79.0	36.0	8.00
RS403H	H	6.76	0.2661	34.0	79.0	36.0	8.00
RS4036.8	–	6.80	0.2677	34.0	79.0	36.0	8.00
RS4036.9	–	6.90	0.2717	34.0	79.0	36.0	8.00
RS403I	I	6.91	0.2720	34.0	79.0	36.0	8.00
RS4037.0	–	7.00	0.2756	34.0	79.0	36.0	8.00
RS403J	J	7.04	0.2772	34.0	79.0	36.0	8.00
RS4037.1	–	7.10	0.2795	41.0	79.0	36.0	8.00
RS403K	K	7.14	0.2811	41.0	79.0	36.0	8.00
RS4039/32	9/32	7.14	0.2813	41.0	79.0	36.0	8.00
RS4037.2	–	7.20	0.2835	41.0	79.0	36.0	8.00
RS4037.3	–	7.30	0.2874	41.0	79.0	36.0	8.00
RS403L	L	7.37	0.2902	41.0	79.0	36.0	8.00
RS4037.4	–	7.40	0.2913	41.0	79.0	36.0	8.00
RS403M	M	7.49	0.2949	41.0	79.0	36.0	8.00
RS4037.5	–	7.50	0.2953	41.0	79.0	36.0	8.00
RS40319/64	19/64	7.54	0.2969	41.0	79.0	36.0	8.00
RS4037.6	–	7.60	0.2992	41.0	79.0	36.0	8.00
RS403N	N	7.67	0.3020	41.0	79.0	36.0	8.00
RS4037.7	–	7.70	0.3031	41.0	79.0	36.0	8.00
RS4037.8	–	7.80	0.3071	41.0	79.0	36.0	8.00
RS4037.9	–	7.90	0.3110	41.0	79.0	36.0	8.00
RS4035/16	5/16	7.94	0.3125	41.0	79.0	36.0	8.00
RS4038.0	–	8.00	0.3150	41.0	79.0	36.0	8.00
RS403O	O	8.03	0.3161	47.0	89.0	40.0	10.00
RS4038.1	–	8.10	0.3189	47.0	89.0	40.0	10.00
RS4038.2	–	8.20	0.3228	47.0	89.0	40.0	10.00

产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RS403P	P	8.20	0.3228	47.0	89.0	40.0	10.00
RS4038.3	–	8.30	0.3268	47.0	89.0	40.0	10.00
RS40321/64	21/64	8.33	0.3281	47.0	89.0	40.0	10.00
RS4038.4	–	8.40	0.3307	47.0	89.0	40.0	10.00
RS403Q	Q	8.43	0.3319	47.0	89.0	40.0	10.00
RS4038.5	–	8.50	0.3346	47.0	89.0	40.0	10.00
RS4038.6	–	8.60	0.3386	47.0	89.0	40.0	10.00
RS403R	R	8.61	0.3390	47.0	89.0	40.0	10.00
RS4038.7	–	8.70	0.3425	47.0	89.0	40.0	10.00
RS40311/32	11/32	8.73	0.3438	47.0	89.0	40.0	10.00
RS4038.8	–	8.80	0.3465	47.0	89.0	40.0	10.00
RS403S	S	8.84	0.3480	47.0	89.0	40.0	10.00
RS4038.9	–	8.90	0.3504	47.0	89.0	40.0	10.00
RS4039.0	–	9.00	0.3543	47.0	89.0	40.0	10.00
RS403T	T	9.09	0.3579	47.0	89.0	40.0	10.00
RS4039.1	–	9.10	0.3583	47.0	89.0	40.0	10.00
RS40323/64	23/64	9.13	0.3594	47.0	89.0	40.0	10.00
RS4039.2	–	9.20	0.3622	47.0	89.0	40.0	10.00
RS4039.3	–	9.30	0.3661	47.0	89.0	40.0	10.00
RS403U	U	9.35	0.3681	47.0	89.0	40.0	10.00
RS4039.4	–	9.40	0.3701	47.0	89.0	40.0	10.00
RS4039.5	–	9.50	0.3740	47.0	89.0	40.0	10.00
RS4033/8	3/8	9.53	0.3750	47.0	89.0	40.0	10.00
RS403V	V	9.58	0.3772	47.0	89.0	40.0	10.00
RS4039.6	–	9.60	0.3780	47.0	89.0	40.0	10.00
RS4039.7	–	9.70	0.3819	47.0	89.0	40.0	10.00
RS4039.8	–	9.80	0.3858	47.0	89.0	40.0	10.00
RS403W	W	9.80	0.3858	47.0	89.0	40.0	10.00
RS4039.9	–	9.90	0.3898	47.0	89.0	40.0	10.00
RS40325/64	25/64	9.92	0.3906	47.0	89.0	40.0	10.00
RS40310.0	–	10.00	0.3937	47.0	89.0	40.0	10.00
RS403X	X	10.08	0.3969	55.0	102.0	45.0	12.00
RS40310.1	–	10.10	0.3976	55.0	102.0	45.0	12.00
RS40310.2	–	10.20	0.4016	55.0	102.0	45.0	12.00
RS403Y	Y	10.26	0.4039	55.0	102.0	45.0	12.00
RS40310.3	–	10.30	0.4055	55.0	102.0	45.0	12.00
RS40313/32	13/32	10.32	0.4063	55.0	102.0	45.0	12.00
RS40310.4	–	10.40	0.4094	55.0	102.0	45.0	12.00
RS403Z	Z	10.49	0.4130	55.0	102.0	45.0	12.00
RS40310.5	–	10.50	0.4134	55.0	102.0	45.0	12.00
RS40310.6	–	10.60	0.4173	55.0	102.0	45.0	12.00
RS40310.7	–	10.70	0.4213	55.0	102.0	45.0	12.00
RS40327/64	27/64	10.72	0.4219	55.0	102.0	45.0	12.00
RS40310.8	–	10.80	0.4252	55.0	102.0	45.0	12.00
RS40310.9	–	10.90	0.4291	55.0	102.0	45.0	12.00
RS40311.0	–	11.00	0.4331	55.0	102.0	45.0	12.00
RS40311.1	–	11.10	0.4370	55.0	102.0	45.0	12.00
RS4037/16	7/16	11.11	0.4375	55.0	102.0	45.0	12.00
RS40311.2	–	11.20	0.4409	55.0	102.0	45.0	12.00
RS40311.3	–	11.30	0.4449	55.0	102.0	45.0	12.00
RS40311.4	–	11.40	0.4488	55.0	102.0	45.0	12.00
RS40311.5	–	11.50	0.4528	55.0	102.0	45.0	12.00
RS40329/64	29/64	11.51	0.4531	55.0	102.0	45.0	12.00
RS40311.6	–	11.60	0.4567	55.0	102.0	45.0	12.00
RS40311.7	–	11.70	0.4606	55.0	102.0	45.0	12.00
RS40311.8	–	11.80	0.4646	55.0	102.0	45.0	12.00
RS40311.9	–	11.90	0.4685	55.0	102.0	45.0	12.00
RS40315/32	15/32	11.91	0.4688	55.0	102.0	45.0	12.00
RS40312.0	–	12.00	0.4724	55.0	102.0	45.0	12.00
RS40312.1	–	12.10	0.4764	60.0	107.0	45.0	14.00
RS40312.2	–	12.20	0.4803	60.0	107.0	45.0	14.00
RS40331/64	31/64	12.30	0.4844	60.0	107.0	45.0	14.00

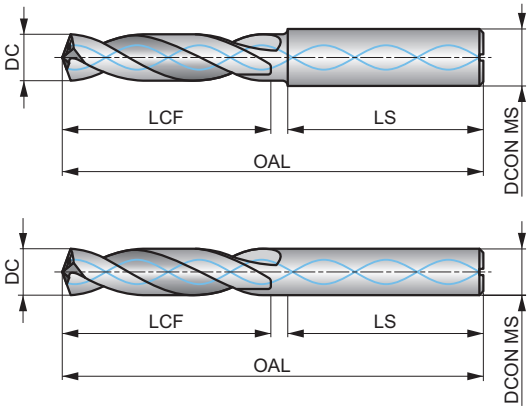
产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RS40312.5	–	12.50	0.4921	60.0	107.0	45.0	14.00
RS4031/2	1/2	12.70	0.5000	60.0	107.0	45.0	14.00
RS40312.7	–	12.70	0.5000	60.0	107.0	45.0	14.00
RS40312.8	–	12.80	0.5039	60.0	107.0	45.0	14.00
RS40313.0	–	13.00	0.5118	60.0	107.0	45.0	14.00
RS40333/64	33/64	13.10	0.5156	60.0	107.0	45.0	14.00
RS40313.3	–	13.30	0.5236	60.0	107.0	45.0	14.00
RS40317/32	17/32	13.49	0.5313	60.0	107.0	45.0	14.00
RS40313.5	–	13.50	0.5315	60.0	107.0	45.0	14.00
RS40313.8	–	13.80	0.5433	60.0	107.0	45.0	14.00
RS40335/64	35/64	13.89	0.5469	60.0	107.0	45.0	14.00
RS40314.0	–	14.00	0.5512	60.0	107.0	45.0	14.00
RS40314.25	–	14.25	0.5610	65.0	115.0	48.0	16.00
RS4039/16	9/16	14.29	0.5625	65.0	115.0	48.0	16.00
RS40314.5	–	14.50	0.5709	65.0	115.0	48.0	16.00
RS40337/64	37/64	14.68	0.5781	65.0	115.0	48.0	16.00
RS40314.8	–	14.80	0.5827	65.0	115.0	48.0	16.00
RS40315.0	–	15.00	0.5906	65.0	115.0	48.0	16.00
RS40319/32	19/32	15.08	0.5938	65.0	115.0	48.0	16.00
RS40315.1	–	15.10	0.5945	65.0	115.0	48.0	16.00
RS40315.3	–	15.30	0.6024	65.0	115.0	48.0	16.00
RS40339/64	39/64	15.48	0.6094	65.0	115.0	48.0	16.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RS40315.5	–	15.50	0.6102	65.0	115.0	48.0	16.00
RS40315.8	–	15.80	0.6220	65.0	115.0	48.0	16.00
RS4035/8	5/8	15.88	0.6250	65.0	115.0	48.0	16.00
RS40316.0	–	16.00	0.6299	65.0	115.0	48.0	16.00
RS40341/64	41/64	16.27	0.6406	73.0	123.0	48.0	18.00
RS40316.5	–	16.50	0.6496	73.0	123.0	48.0	18.00
RS40321/32	21/32	16.67	0.6563	73.0	123.0	48.0	18.00
RS40317.0	–	17.00	0.6693	73.0	123.0	48.0	18.00
RS40343/64	43/64	17.07	0.6720	73.0	123.0	48.0	18.00
RS40311/16	11/16	17.46	0.6874	73.0	123.0	48.0	18.00
RS40317.5	–	17.50	0.6890	73.0	123.0	48.0	18.00
RS40317.8	–	17.80	0.7008	73.0	123.0	48.0	18.00
RS40345/64	45/64	17.86	0.7031	73.0	123.0	48.0	18.00
RS40318.0	–	18.00	0.7087	73.0	123.0	48.0	18.00
RS40323/32	23/32	18.26	0.7189	79.0	131.0	50.0	20.00
RS40318.5	–	18.50	0.7283	79.0	131.0	50.0	20.00
RS40347/64	47/64	18.65	0.7343	79.0	131.0	50.0	20.00
RS40319.0	–	19.00	0.7480	79.0	131.0	50.0	20.00
RS4033/4	3/4	19.05	0.7500	79.0	131.0	50.0	20.00
RS40319.5	–	19.50	0.7677	79.0	131.0	50.0	20.00
RS40319.8	–	19.80	0.7795	79.0	131.0	50.0	20.00
RS40320.0	–	20.00	0.7874	79.0	131.0	50.0	20.00

RC403

FORCE X 3XD 整体硬质合金钻头，带冷却进给装置，TiAlN-Top 涂层

高性能钻头专为在高速和高进给条件下提供优异的孔质量而设计（H9 孔公差，适用于多种材料）。140° 自定心、4 刀面分刃点和 CTW 刀槽结构。冷却孔加强了排屑效果。顶部 TiAlN 涂层可提高表面硬度，增强耐磨性，延长刀具寿命。



HM	DIN 6537	3×D
140°	TiAlN Top	DIN 6535HA
CTW	R	DC m7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页24开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
140 W	142 W	142 W	122 W	120 W	105 V	110 V	102 V	100 V	99 V	95 V	50 U	105 G	101 G
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
99 G	80 G	70 E	85 G	70 G	65 F	60 F	50 E	111 W	108 W	105 W	111 W	110 W	99 W
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
105 W	99 W	95 W	100 W	80 W	77 W	72 W	70 W	105 W	100 W	80 W	305 W	310 W	300 W
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
221 W	220 W	200 W	185 W	180 W	175 W	50 V	40 V	35 U	40 U	28 U	32 U	32 U	30 U
S4.2													
25 U													

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RC4033.0	–	3.00	0.1181	20.0	62.0	36.0	6.00
RC4033.1	–	3.10	0.1220	20.0	62.0	36.0	6.00
RC4031/8	1/8	3.18	0.1250	20.0	62.0	36.0	6.00
RC4033.2	–	3.20	0.1260	20.0	62.0	36.0	6.00
RC403N30	N30	3.26	0.1283	20.0	62.0	36.0	6.00
RC4033.3	–	3.30	0.1299	20.0	62.0	36.0	6.00
RC4033.4	–	3.40	0.1339	20.0	62.0	36.0	6.00
RC403N29	N29	3.45	0.1360	20.0	62.0	36.0	6.00
RC4033.5	–	3.50	0.1378	20.0	62.0	36.0	6.00
RC403N28	N28	3.57	0.1406	20.0	62.0	36.0	6.00
RC4039/64	9/64	3.57	0.1406	20.0	62.0	36.0	6.00
RC4033.6	–	3.60	0.1417	20.0	62.0	36.0	6.00
RC403N27	N27	3.66	0.1441	20.0	62.0	36.0	6.00
RC4033.7	–	3.70	0.1457	20.0	62.0	36.0	6.00
RC403N26	N26	3.73	0.1469	24.0	66.0	36.0	6.00
RC403N25	N25	3.80	0.1496	24.0	66.0	36.0	6.00
RC4033.8	–	3.80	0.1496	24.0	66.0	36.0	6.00
RC403N24	N24	3.86	0.1520	24.0	66.0	36.0	6.00
RC4033.9	–	3.90	0.1535	24.0	66.0	36.0	6.00
RC403N23	N23	3.91	0.1539	24.0	66.0	36.0	6.00
RC4035/32	5/32	3.97	0.1563	24.0	66.0	36.0	6.00
RC403N22	N22	3.99	0.1571	24.0	66.0	36.0	6.00
RC4034.0	–	4.00	0.1575	24.0	66.0	36.0	6.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RC403N21	N21	4.04	0.1591	24.0	66.0	36.0	6.00
RC4034.05	–	4.05	0.1594	24.0	66.0	36.0	6.00
RC403N20	N20	4.09	0.1610	24.0	66.0	36.0	6.00
RC4034.1	–	4.10	0.1614	24.0	66.0	36.0	6.00
RC4034.2	–	4.20	0.1654	24.0	66.0	36.0	6.00
RC403N19	N19	4.22	0.1661	24.0	66.0	36.0	6.00
RC4034.3	–	4.30	0.1693	24.0	66.0	36.0	6.00
RC403N18	N18	4.31	0.1697	24.0	66.0	36.0	6.00
RC40311/64	11/64	4.37	0.1719	24.0	66.0	36.0	6.00
RC403N17	N17	4.39	0.1728	24.0	66.0	36.0	6.00
RC4034.4	–	4.40	0.1732	24.0	66.0	36.0	6.00
RC403N16	N16	4.50	0.1772	24.0	66.0	36.0	6.00
RC4034.5	–	4.50	0.1772	24.0	66.0	36.0	6.00
RC403N15	N15	4.57	0.1799	24.0	66.0	36.0	6.00
RC4034.6	–	4.60	0.1811	24.0	66.0	36.0	6.00
RC403N14	N14	4.62	0.1819	24.0	66.0	36.0	6.00
RC403N13	N13	4.70	0.1850	24.0	66.0	36.0	6.00
RC4034.7	–	4.70	0.1850	24.0	66.0	36.0	6.00
RC4033/16	3/16	4.76	0.1875	28.0	66.0	36.0	6.00
RC403N12	N12	4.80	0.1890	28.0	66.0	36.0	6.00
RC4034.8	–	4.80	0.1890	28.0	66.0	36.0	6.00
RC403N11	N11	4.85	0.1909	28.0	66.0	36.0	6.00
RC4034.9	–	4.90	0.1929	28.0	66.0	36.0	6.00

产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RC403N10	N10	4.92	0.1937	28.0	66.0	36.0	6.00
RC403N9	N9	4.98	0.1961	28.0	66.0	36.0	6.00
RC4035.0	–	5.00	0.1969	28.0	66.0	36.0	6.00
RC4035.05	–	5.05	0.1988	28.0	66.0	36.0	6.00
RC403N8	N8	5.06	0.1992	28.0	66.0	36.0	6.00
RC4035.1	–	5.10	0.2008	28.0	66.0	36.0	6.00
RC403N7	N7	5.11	0.2010	28.0	66.0	36.0	6.00
RC40313/64	13/64	5.16	0.2031	28.0	66.0	36.0	6.00
RC403N6	N6	5.18	0.2039	28.0	66.0	36.0	6.00
RC4035.2	–	5.20	0.2047	28.0	66.0	36.0	6.00
RC403N5	N5	5.22	0.2055	28.0	66.0	36.0	6.00
RC4035.3	–	5.30	0.2087	28.0	66.0	36.0	6.00
RC403N4	N4	5.31	0.2091	28.0	66.0	36.0	6.00
RC4035.4	–	5.40	0.2126	28.0	66.0	36.0	6.00
RC403N3	N3	5.41	0.2130	28.0	66.0	36.0	6.00
RC4035.5	–	5.50	0.2165	28.0	66.0	36.0	6.00
RC4037/32	7/32	5.56	0.2188	28.0	66.0	36.0	6.00
RC4035.6	–	5.60	0.2205	28.0	66.0	36.0	6.00
RC403N2	N2	5.61	0.2209	28.0	66.0	36.0	6.00
RC4035.7	–	5.70	0.2244	28.0	66.0	36.0	6.00
RC403N1	N1	5.79	0.2280	28.0	66.0	36.0	6.00
RC4035.8	–	5.80	0.2283	28.0	66.0	36.0	6.00
RC4035.9	–	5.90	0.2323	28.0	66.0	36.0	6.00
RC403A	A	5.94	0.2339	28.0	66.0	36.0	6.00
RC40315/64	15/64	5.95	0.2344	28.0	66.0	36.0	6.00
RC4036.0	–	6.00	0.2362	28.0	66.0	36.0	6.00
RC403B	B	6.05	0.2380	34.0	79.0	36.0	8.00
RC4036.05	–	6.05	0.2382	34.0	79.0	36.0	8.00
RC4036.1	–	6.10	0.2402	34.0	79.0	36.0	8.00
RC403C	C	6.15	0.2421	34.0	79.0	36.0	8.00
RC4036.2	–	6.20	0.2441	34.0	79.0	36.0	8.00
RC403D	D	6.25	0.2461	34.0	79.0	36.0	8.00
RC4036.3	–	6.30	0.2480	34.0	79.0	36.0	8.00
RC403E	E	6.35	0.2500	34.0	79.0	36.0	8.00
RC4031/4	1/4	6.35	0.2500	34.0	79.0	36.0	8.00
RC4036.4	–	6.40	0.2520	34.0	79.0	36.0	8.00
RC4036.5	–	6.50	0.2559	34.0	79.0	36.0	8.00
RC403F	F	6.53	0.2571	34.0	79.0	36.0	8.00
RC4036.6	–	6.60	0.2598	34.0	79.0	36.0	8.00
RC403G	G	6.63	0.2610	34.0	79.0	36.0	8.00
RC4036.7	–	6.70	0.2638	34.0	79.0	36.0	8.00
RC40317/64	17/64	6.75	0.2656	34.0	79.0	36.0	8.00
RC403H	H	6.76	0.2661	34.0	79.0	36.0	8.00
RC4036.8	–	6.80	0.2677	34.0	79.0	36.0	8.00
RC4036.9	–	6.90	0.2717	34.0	79.0	36.0	8.00
RC403I	I	6.91	0.2720	34.0	79.0	36.0	8.00
RC4037.0	–	7.00	0.2756	34.0	79.0	36.0	8.00
RC403J	J	7.04	0.2772	41.0	79.0	36.0	8.00
RC4037.1	–	7.10	0.2795	41.0	79.0	36.0	8.00
RC403K	K	7.14	0.2811	41.0	79.0	36.0	8.00
RC4039/32	9/32	7.14	0.2813	41.0	79.0	36.0	8.00
RC4037.2	–	7.20	0.2835	41.0	79.0	36.0	8.00
RC4037.3	–	7.30	0.2874	41.0	79.0	36.0	8.00
RC403L	L	7.37	0.2902	41.0	79.0	36.0	8.00
RC4037.4	–	7.40	0.2913	41.0	79.0	36.0	8.00
RC403M	M	7.49	0.2949	41.0	79.0	36.0	8.00
RC4037.5	–	7.50	0.2953	41.0	79.0	36.0	8.00
RC40319/64	19/64	7.54	0.2969	41.0	79.0	36.0	8.00
RC4037.6	–	7.60	0.2992	41.0	79.0	36.0	8.00
RC403N	N	7.67	0.3020	41.0	79.0	36.0	8.00
RC4037.7	–	7.70	0.3031	41.0	79.0	36.0	8.00
RC4037.8	–	7.80	0.3071	41.0	79.0	36.0	8.00

产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RC4037.9	–	7.90	0.3110	41.0	79.0	36.0	8.00
RC4035/16	5/16	7.94	0.3125	41.0	79.0	36.0	8.00
RC4038.0	–	8.00	0.3150	41.0	79.0	36.0	8.00
RC403O	O	8.03	0.3161	47.0	89.0	40.0	10.00
RC4038.05	–	8.05	0.3169	47.0	89.0	40.0	10.00
RC4038.1	–	8.10	0.3189	47.0	89.0	40.0	10.00
RC4038.2	–	8.20	0.3228	47.0	89.0	40.0	10.00
RC403P	P	8.20	0.3228	47.0	89.0	40.0	10.00
RC4038.3	–	8.30	0.3268	47.0	89.0	40.0	10.00
RC40321/64	21/64	8.33	0.3281	47.0	89.0	40.0	10.00
RC4038.4	–	8.40	0.3307	47.0	89.0	40.0	10.00
RC403Q	Q	8.43	0.3319	47.0	89.0	40.0	10.00
RC4038.5	–	8.50	0.3346	47.0	89.0	40.0	10.00
RC4038.6	–	8.60	0.3386	47.0	89.0	40.0	10.00
RC403R	R	8.61	0.3390	47.0	89.0	40.0	10.00
RC4038.7	–	8.70	0.3425	47.0	89.0	40.0	10.00
RC40311/32	11/32	8.73	0.3438	47.0	89.0	40.0	10.00
RC4038.8	–	8.80	0.3465	47.0	89.0	40.0	10.00
RC403S	S	8.84	0.3480	47.0	89.0	40.0	10.00
RC4038.9	–	8.90	0.3504	47.0	89.0	40.0	10.00
RC4039.0	–	9.00	0.3543	47.0	89.0	40.0	10.00
RC403T	T	9.09	0.3579	47.0	89.0	40.0	10.00
RC4039.1	–	9.10	0.3583	47.0	89.0	40.0	10.00
RC40323/64	23/64	9.13	0.3594	47.0	89.0	40.0	10.00
RC4039.2	–	9.20	0.3622	47.0	89.0	40.0	10.00
RC4039.3	–	9.30	0.3661	47.0	89.0	40.0	10.00
RC403U	U	9.35	0.3681	47.0	89.0	40.0	10.00
RC4039.4	–	9.40	0.3701	47.0	89.0	40.0	10.00
RC4039.5	–	9.50	0.3740	47.0	89.0	40.0	10.00
RC4033/8	3/8	9.53	0.3750	47.0	89.0	40.0	10.00
RC403V	V	9.58	0.3772	47.0	89.0	40.0	10.00
RC4039.6	–	9.60	0.3780	47.0	89.0	40.0	10.00
RC4039.7	–	9.70	0.3819	47.0	89.0	40.0	10.00
RC4039.8	–	9.80	0.3858	47.0	89.0	40.0	10.00
RC403W	W	9.80	0.3858	47.0	89.0	40.0	10.00
RC4039.9	–	9.90	0.3898	47.0	89.0	40.0	10.00
RC40325/64	25/64	9.92	0.3906	47.0	89.0	40.0	10.00
RC40310.0	–	10.00	0.3937	47.0	89.0	40.0	10.00
RC40310.05	–	10.05	0.3957	55.0	102.0	45.0	12.00
RC403X	X	10.08	0.3969	55.0	102.0	45.0	12.00
RC40310.1	–	10.10	0.3976	55.0	102.0	45.0	12.00
RC40310.2	–	10.20	0.4016	55.0	102.0	45.0	12.00
RC403Y	Y	10.26	0.4039	55.0	102.0	45.0	12.00
RC40310.3	–	10.30	0.4055	55.0	102.0	45.0	12.00
RC40313/32	13/32	10.32	0.4063	55.0	102.0	45.0	12.00
RC40310.4	–	10.40	0.4094	55.0	102.0	45.0	12.00
RC403Z	Z	10.49	0.4130	55.0	102.0	45.0	12.00
RC40310.5	–	10.50	0.4134	55.0	102.0	45.0	12.00
RC40310.6	–	10.60	0.4173	55.0	102.0	45.0	12.00
RC40327/64	27/64	10.72	0.4219	55.0	102.0	45.0	12.00
RC40310.8	–	10.80	0.4252	55.0	102.0	45.0	12.00
RC40310.9	–	10.90	0.4291	55.0	102.0	45.0	12.00
RC40311.0	–	11.00	0.4331	55.0	102.0	45.0	12.00
RC4037/16	7/16	11.11	0.4375	55.0	102.0	45.0	12.00
RC40311.2	–	11.20	0.4409	55.0	102.0	45.0	12.00
RC40311.3	–	11.30	0.4449	55.0	102.0	45.0	12.00
RC40311.4	–	11.40	0.4488	55.0	102.0	45.0	12.00
RC40311.5	–	11.50	0.4528	55.0	102.0	45.0	12.00
RC40329/64	29/64	11.51	0.4531	55.0	102.0	45.0	12.00
RC40311.6	–	11.60	0.4567	55.0	102.0	45.0	12.00
RC40311.8	–	11.80	0.4646	55.0	102.0	45.0	12.00
RC40315/32	15/32	11.91	0.4688	55.0	102.0	45.0	12.00

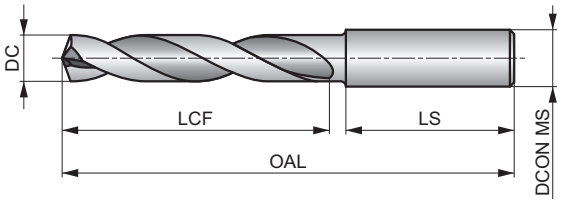
产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RC40312.0	–	12.00	0.4724	55.0	102.0	45.0	12.00
RC40312.05	–	12.05	0.4744	60.0	107.0	45.0	14.00
RC40312.1	–	12.10	0.4764	60.0	107.0	45.0	14.00
RC40312.2	–	12.20	0.4803	60.0	107.0	45.0	14.00
RC40331/64	31/64	12.30	0.4844	60.0	107.0	45.0	14.00
RC40312.5	–	12.50	0.4921	60.0	107.0	45.0	14.00
RC4031/2	1/2	12.70	0.5000	60.0	107.0	45.0	14.00
RC40312.7	–	12.70	0.5000	60.0	107.0	45.0	14.00
RC40312.8	–	12.80	0.5039	60.0	107.0	45.0	14.00
RC40313.0	–	13.00	0.5118	60.0	107.0	45.0	14.00
RC40333/64	33/64	13.10	0.5156	60.0	107.0	45.0	14.00
RC40313.3	–	13.30	0.5236	60.0	107.0	45.0	14.00
RC40317/32	17/32	13.49	0.5313	60.0	107.0	45.0	14.00
RC40313.5	–	13.50	0.5315	60.0	107.0	45.0	14.00
RC40313.8	–	13.80	0.5433	60.0	107.0	45.0	14.00
RC40335/64	35/64	13.89	0.5469	60.0	107.0	45.0	14.00
RC40314.0	–	14.00	0.5512	60.0	107.0	45.0	14.00
RC40314.25	–	14.25	0.5610	65.0	115.0	48.0	16.00
RC4039/16	9/16	14.29	0.5625	65.0	115.0	48.0	16.00
RC40314.5	–	14.50	0.5709	65.0	115.0	48.0	16.00
RC40337/64	37/64	14.68	0.5781	65.0	115.0	48.0	16.00
RC40314.8	–	14.80	0.5827	65.0	115.0	48.0	16.00
RC40315.0	–	15.00	0.5906	65.0	115.0	48.0	16.00
RC40319/32	19/32	15.08	0.5938	65.0	115.0	48.0	16.00
RC40315.1	–	15.10	0.5945	65.0	115.0	48.0	16.00

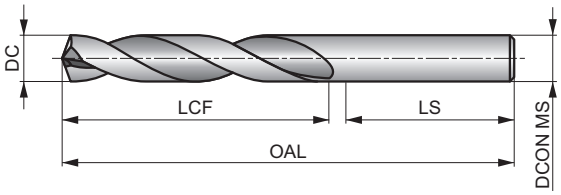
产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RC40315.3	–	15.30	0.6024	65.0	115.0	48.0	16.00
RC40339/64	39/64	15.48	0.6094	65.0	115.0	48.0	16.00
RC40315.5	–	15.50	0.6102	65.0	115.0	48.0	16.00
RC40315.8	–	15.80	0.6220	65.0	115.0	48.0	16.00
RC4035/8	5/8	15.88	0.6250	65.0	115.0	48.0	16.00
RC40316.0	–	16.00	0.6299	65.0	115.0	48.0	16.00
RC40341/64	41/64	16.27	0.6406	73.0	123.0	48.0	18.00
RC40316.5	–	16.50	0.6496	73.0	123.0	48.0	18.00
RC40321/32	21/32	16.67	0.6563	73.0	123.0	48.0	18.00
RC40317.0	–	17.00	0.6693	73.0	123.0	48.0	18.00
RC40343/64	43/64	17.07	0.6720	73.0	123.0	48.0	18.00
RC40311/16	11/16	17.46	0.6874	73.0	123.0	48.0	18.00
RC40317.5	–	17.50	0.6890	73.0	123.0	48.0	18.00
RC40345/64	45/64	17.86	0.7031	73.0	123.0	48.0	18.00
RC40318.0	–	18.00	0.7087	73.0	123.0	48.0	18.00
RC40323/32	23/32	18.26	0.7189	79.0	131.0	50.0	20.00
RC40318.5	–	18.50	0.7283	79.0	131.0	50.0	20.00
RC40347/64	47/64	18.65	0.7343	79.0	131.0	50.0	20.00
RC40318.8	–	18.80	0.7402	79.0	131.0	50.0	20.00
RC40319.0	–	19.00	0.7480	79.0	131.0	50.0	20.00
RC4033/4	3/4	19.05	0.7500	79.0	131.0	50.0	20.00
RC40319.5	–	19.50	0.7677	79.0	131.0	50.0	20.00
RC40319.8	–	19.80	0.7795	79.0	131.0	50.0	20.00
RC40320.0	–	20.00	0.7874	79.0	131.0	50.0	20.00

RS405

DORMER PRAMET

FORCE X 整体硬质合金 5XD 钻头, TiAlN 顶部涂层
高性能钻头专为在高速和高进给条件下提供优异的孔质量而设计（H9 孔公差，适用于多种材料）。140° 自定心、4 刀面分瓣和 CTW 刀槽结构。顶部的 TiAlN 涂层可提高表面硬度，增强耐磨性，延长刀具寿命。





HM	DIN 6537	5×D
140°	TiAlN Top	DIN 6535HA
CTW	R	DC m7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页24开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 112 V	■ 114 V	■ 114 V	■ 98 V	■ 96 V	■ 84 V	■ 88 V	■ 82 V	■ 80 V	■ 79 V	■ 76 V	■ 40 U	◪ 79 V	◪ 76 V
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
◪ 74 U	◪ 60 U	◪ 52 U	◪ 64 U	◪ 52 U	◪ 49 U	◪ 45 U	◪ 38 U	■ 89 W	■ 86 W	■ 84 W	■ 89 W	■ 88 W	■ 79 W
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.2	N1.3	N2.1
■ 84 W	■ 79 W	■ 76 W	■ 80 W	■ 64 W	■ 62 W	■ 58 W	■ 56 W	■ 84 V	■ 80 V	■ 64 V	◪ 279 W	◪ 270 W	◪ 199 W
N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3						
◪ 198 W	◪ 180 W	◪ 166 W	◪ 162 W	◪ 158 W	◪ 40 U	◪ 32 U	◪ 28 U						

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RS4053.0	–	3.00	0.1181	28.0	66.0	36.0	6.00
RS4053.1	–	3.10	0.1220	28.0	66.0	36.0	6.00
RS4051/8	1/8	3.18	0.1250	28.0	66.0	36.0	6.00
RS4053.2	–	3.20	0.1260	28.0	66.0	36.0	6.00
RS405N30	N30	3.26	0.1283	28.0	66.0	36.0	6.00
RS4053.3	–	3.30	0.1299	28.0	66.0	36.0	6.00
RS4053.4	–	3.40	0.1339	28.0	66.0	36.0	6.00
RS405N29	N29	3.45	0.1360	28.0	66.0	36.0	6.00
RS4053.5	–	3.50	0.1378	28.0	66.0	36.0	6.00
RS405N28	N28	3.57	0.1406	28.0	66.0	36.0	6.00
RS4059/64	9/64	3.57	0.1406	28.0	66.0	36.0	6.00
RS4053.6	–	3.60	0.1417	28.0	66.0	36.0	6.00
RS405N27	N27	3.66	0.1441	28.0	66.0	36.0	6.00
RS4053.7	–	3.70	0.1457	28.0	66.0	36.0	6.00
RS405N26	N26	3.73	0.1469	36.0	74.0	36.0	6.00
RS405N25	N25	3.80	0.1496	36.0	74.0	36.0	6.00
RS4053.8	–	3.80	0.1496	36.0	74.0	36.0	6.00
RS405N24	N24	3.86	0.1520	36.0	74.0	36.0	6.00
RS4053.9	–	3.90	0.1535	36.0	74.0	36.0	6.00
RS405N23	N23	3.91	0.1539	36.0	74.0	36.0	6.00
RS4055/32	5/32	3.97	0.1563	36.0	74.0	36.0	6.00
RS405N22	N22	3.99	0.1571	36.0	74.0	36.0	6.00
RS4054.0	–	4.00	0.1575	36.0	74.0	36.0	6.00
RS405N21	N21	4.04	0.1591	36.0	74.0	36.0	6.00
RS405N20	N20	4.09	0.1610	36.0	74.0	36.0	6.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RS4054.1	–	4.10	0.1614	36.0	74.0	36.0	6.00
RS4054.2	–	4.20	0.1654	36.0	74.0	36.0	6.00
RS405N19	N19	4.22	0.1661	36.0	74.0	36.0	6.00
RS4054.3	–	4.30	0.1693	36.0	74.0	36.0	6.00
RS405N18	N18	4.31	0.1697	36.0	74.0	36.0	6.00
RS40511/64	11/64	4.37	0.1719	36.0	74.0	36.0	6.00
RS405N17	N17	4.39	0.1728	36.0	74.0	36.0	6.00
RS4054.4	–	4.40	0.1732	36.0	74.0	36.0	6.00
RS405N16	N16	4.50	0.1772	36.0	74.0	36.0	6.00
RS4054.5	–	4.50	0.1772	36.0	74.0	36.0	6.00
RS405N15	N15	4.57	0.1799	36.0	74.0	36.0	6.00
RS4054.6	–	4.60	0.1811	36.0	74.0	36.0	6.00
RS405N14	N14	4.62	0.1819	36.0	74.0	36.0	6.00
RS405N13	N13	4.70	0.1850	36.0	74.0	36.0	6.00
RS4054.7	–	4.70	0.1850	36.0	74.0	36.0	6.00
RS4053/16	3/16	4.76	0.1875	44.0	82.0	36.0	6.00
RS405N12	N12	4.80	0.1890	44.0	82.0	36.0	6.00
RS4054.8	–	4.80	0.1890	44.0	82.0	36.0	6.00
RS405N11	N11	4.85	0.1909	44.0	82.0	36.0	6.00
RS4054.9	–	4.90	0.1929	44.0	82.0	36.0	6.00
RS405N10	N10	4.92	0.1937	44.0	82.0	36.0	6.00
RS405N9	N9	4.98	0.1961	44.0	82.0	36.0	6.00
RS4055.0	–	5.00	0.1969	44.0	82.0	36.0	6.00
RS405N8	N8	5.06	0.1992	44.0	82.0	36.0	6.00
RS4055.1	–	5.10	0.2008	44.0	82.0	36.0	6.00

产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RS405N7	N7	5.11	0.2010	44.0	82.0	36.0	6.00
RS40513/64	13/64	5.16	0.2031	44.0	82.0	36.0	6.00
RS405N6	N6	5.18	0.2039	44.0	82.0	36.0	6.00
RS4055.2	–	5.20	0.2047	44.0	82.0	36.0	6.00
RS405N5	N5	5.22	0.2055	44.0	82.0	36.0	6.00
RS405N4	N4	5.31	0.2091	44.0	82.0	36.0	6.00
RS405N3	N3	5.41	0.2130	44.0	82.0	36.0	6.00
RS4055.5	–	5.50	0.2165	44.0	82.0	36.0	6.00
RS4057/32	7/32	5.56	0.2188	44.0	82.0	36.0	6.00
RS4055.6	–	5.60	0.2205	44.0	82.0	36.0	6.00
RS405N2	N2	5.61	0.2209	44.0	82.0	36.0	6.00
RS4055.7	–	5.70	0.2244	44.0	82.0	36.0	6.00
RS405N1	N1	5.79	0.2280	44.0	82.0	36.0	6.00
RS4055.8	–	5.80	0.2283	44.0	82.0	36.0	6.00
RS405A	A	5.94	0.2339	44.0	82.0	36.0	6.00
RS40515/64	15/64	5.95	0.2344	44.0	82.0	36.0	6.00
RS4056.0	–	6.00	0.2362	44.0	82.0	36.0	6.00
RS405B	B	6.05	0.2380	53.0	91.0	36.0	8.00
RS4056.1	–	6.10	0.2402	53.0	91.0	36.0	8.00
RS405C	C	6.15	0.2421	53.0	91.0	36.0	8.00
RS4056.2	–	6.20	0.2441	53.0	91.0	36.0	8.00
RS405D	D	6.25	0.2461	53.0	91.0	36.0	8.00
RS4056.3	–	6.30	0.2480	53.0	91.0	36.0	8.00
RS405E	E	6.35	0.2500	53.0	91.0	36.0	8.00
RS4051/4	1/4	6.35	0.2500	53.0	91.0	36.0	8.00
RS4056.4	–	6.40	0.2520	53.0	91.0	36.0	8.00
RS4056.5	–	6.50	0.2559	53.0	91.0	36.0	8.00
RS405F	F	6.53	0.2571	53.0	91.0	36.0	8.00
RS4056.6	–	6.60	0.2598	53.0	91.0	36.0	8.00
RS405G	G	6.63	0.2610	53.0	91.0	36.0	8.00
RS4056.7	–	6.70	0.2638	53.0	91.0	36.0	8.00
RS40517/64	17/64	6.75	0.2656	53.0	91.0	36.0	8.00
RS405H	H	6.76	0.2661	53.0	91.0	36.0	8.00
RS4056.8	–	6.80	0.2677	53.0	91.0	36.0	8.00
RS4056.9	–	6.90	0.2717	53.0	91.0	36.0	8.00
RS405I	I	6.91	0.2720	53.0	91.0	36.0	8.00
RS4057.0	–	7.00	0.2756	53.0	91.0	36.0	8.00
RS405J	J	7.04	0.2772	53.0	91.0	36.0	8.00
RS4057.1	–	7.10	0.2795	53.0	91.0	36.0	8.00
RS405K	K	7.14	0.2811	53.0	91.0	36.0	8.00
RS4059/32	9/32	7.14	0.2813	53.0	91.0	36.0	8.00
RS4057.3	–	7.30	0.2874	53.0	91.0	36.0	8.00
RS405L	L	7.37	0.2902	53.0	91.0	36.0	8.00
RS4057.4	–	7.40	0.2913	53.0	91.0	36.0	8.00
RS405M	M	7.49	0.2949	53.0	91.0	36.0	8.00
RS4057.5	–	7.50	0.2953	53.0	91.0	36.0	8.00
RS40519/64	19/64	7.54	0.2969	53.0	91.0	36.0	8.00
RS4057.6	–	7.60	0.2992	53.0	91.0	36.0	8.00
RS405N	N	7.67	0.3020	53.0	91.0	36.0	8.00
RS4057.7	–	7.70	0.3031	53.0	91.0	36.0	8.00
RS4057.8	–	7.80	0.3071	53.0	91.0	36.0	8.00
RS4057.9	–	7.90	0.3110	53.0	91.0	36.0	8.00
RS4055/16	5/16	7.94	0.3125	53.0	91.0	36.0	8.00
RS4058.0	–	8.00	0.3150	53.0	91.0	36.0	8.00
RS405O	O	8.03	0.3161	61.0	103.0	40.0	10.00
RS4058.1	–	8.10	0.3189	61.0	103.0	40.0	10.00
RS4058.2	–	8.20	0.3228	61.0	103.0	40.0	10.00
RS405P	P	8.20	0.3228	61.0	103.0	40.0	10.00
RS40521/64	21/64	8.33	0.3281	61.0	103.0	40.0	10.00
RS4058.4	–	8.40	0.3307	61.0	103.0	40.0	10.00
RS405Q	Q	8.43	0.3319	61.0	103.0	40.0	10.00
RS4058.5	–	8.50	0.3346	61.0	103.0	40.0	10.00

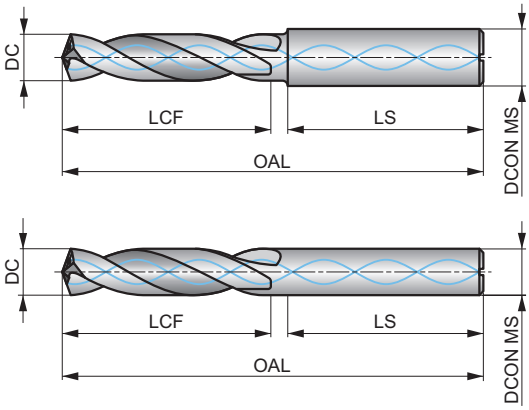
产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RS4058.6	–	8.60	0.3386	61.0	103.0	40.0	10.00
RS405R	R	8.61	0.3390	61.0	103.0	40.0	10.00
RS4058.7	–	8.70	0.3425	61.0	103.0	40.0	10.00
RS40511/32	11/32	8.73	0.3438	61.0	103.0	40.0	10.00
RS4058.8	–	8.80	0.3465	61.0	103.0	40.0	10.00
RS405S	S	8.84	0.3480	61.0	103.0	40.0	10.00
RS4058.9	–	8.90	0.3504	61.0	103.0	40.0	10.00
RS4059.0	–	9.00	0.3543	61.0	103.0	40.0	10.00
RS405T	T	9.09	0.3579	61.0	103.0	40.0	10.00
RS4059.1	–	9.10	0.3583	61.0	103.0	40.0	10.00
RS40523/64	23/64	9.13	0.3594	61.0	103.0	40.0	10.00
RS4059.3	–	9.30	0.3661	61.0	103.0	40.0	10.00
RS405U	U	9.35	0.3681	61.0	103.0	40.0	10.00
RS4059.4	–	9.40	0.3701	61.0	103.0	40.0	10.00
RS4059.5	–	9.50	0.3740	61.0	103.0	40.0	10.00
RS4053/8	3/8	9.53	0.3750	61.0	103.0	40.0	10.00
RS405V	V	9.58	0.3772	61.0	103.0	40.0	10.00
RS4059.6	–	9.60	0.3780	61.0	103.0	40.0	10.00
RS4059.7	–	9.70	0.3819	61.0	103.0	40.0	10.00
RS4059.8	–	9.80	0.3858	61.0	103.0	40.0	10.00
RS405W	W	9.80	0.3858	61.0	103.0	40.0	10.00
RS4059.9	–	9.90	0.3898	61.0	103.0	40.0	10.00
RS40525/64	25/64	9.92	0.3906	61.0	103.0	40.0	10.00
RS40510.0	–	10.00	0.3937	61.0	103.0	40.0	10.00
RS405X	X	10.08	0.3969	70.0	118.0	45.0	12.00
RS40510.1	–	10.10	0.3976	70.0	118.0	45.0	12.00
RS40510.2	–	10.20	0.4016	70.0	118.0	45.0	12.00
RS405Y	Y	10.26	0.4039	70.0	118.0	45.0	12.00
RS40510.3	–	10.30	0.4055	70.0	118.0	45.0	12.00
RS40513/32	13/32	10.32	0.4063	70.0	118.0	45.0	12.00
RS40510.4	–	10.40	0.4094	70.0	118.0	45.0	12.00
RS405Z	Z	10.49	0.4130	70.0	118.0	45.0	12.00
RS40510.5	–	10.50	0.4134	70.0	118.0	45.0	12.00
RS40510.6	–	10.60	0.4173	70.0	118.0	45.0	12.00
RS40527/64	27/64	10.72	0.4219	70.0	118.0	45.0	12.00
RS40511.0	–	11.00	0.4331	70.0	118.0	45.0	12.00
RS4057/16	7/16	11.11	0.4375	70.0	118.0	45.0	12.00
RS40511.2	–	11.20	0.4409	70.0	118.0	45.0	12.00
RS40511.4	–	11.40	0.4488	70.0	118.0	45.0	12.00
RS40511.5	–	11.50	0.4528	70.0	118.0	45.0	12.00
RS40529/64	29/64	11.51	0.4531	70.0	118.0	45.0	12.00
RS40511.6	–	11.60	0.4567	70.0	118.0	45.0	12.00
RS40511.8	–	11.80	0.4646	70.0	118.0	45.0	12.00
RS40515/32	15/32	11.91	0.4688	70.0	118.0	45.0	12.00
RS40512.0	–	12.00	0.4724	70.0	118.0	45.0	12.00
RS40512.1	–	12.10	0.4764	76.0	124.0	45.0	14.00
RS40512.2	–	12.20	0.4803	76.0	124.0	45.0	14.00
RS40531/64	31/64	12.30	0.4844	76.0	124.0	45.0	14.00
RS40512.5	–	12.50	0.4921	76.0	124.0	45.0	14.00
RS4051/2	1/2	12.70	0.5000	76.0	124.0	45.0	14.00
RS40512.7	–	12.70	0.5000	76.0	124.0	45.0	14.00
RS40512.8	–	12.80	0.5039	76.0	124.0	45.0	14.00
RS40513.0	–	13.00	0.5118	76.0	124.0	45.0	14.00
RS40533/64	33/64	13.10	0.5156	76.0	124.0	45.0	14.00
RS40517/32	17/32	13.49	0.5313	76.0	124.0	45.0	14.00
RS40513.5	–	13.50	0.5315	76.0	124.0	45.0	14.00
RS40513.8	–	13.80	0.5433	76.0	124.0	45.0	14.00
RS40535/64	35/64	13.89	0.5469	76.0	124.0	45.0	14.00
RS40514.0	–	14.00	0.5512	76.0	124.0	45.0	14.00
RS40514.25	–	14.25	0.5610	82.0	133.0	48.0	16.00
RS4059/16	9/16	14.29	0.5625	82.0	133.0	48.0	16.00
RS40514.5	–	14.50	0.5709	82.0	133.0	48.0	16.00

产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RS40537/64	37/64	14.68	0.5781	82.0	133.0	48.0	16.00
RS40514.8	–	14.80	0.5827	82.0	133.0	48.0	16.00
RS40515.0	–	15.00	0.5906	82.0	133.0	48.0	16.00
RS40519/32	19/32	15.08	0.5938	82.0	133.0	48.0	16.00
RS40515.1	–	15.10	0.5945	82.0	133.0	48.0	16.00
RS40539/64	39/64	15.48	0.6094	82.0	133.0	48.0	16.00
RS40515.5	–	15.50	0.6102	82.0	133.0	48.0	16.00
RS40515.8	–	15.80	0.6220	82.0	133.0	48.0	16.00
RS4055/8	5/8	15.88	0.6250	82.0	133.0	48.0	16.00
RS40516.0	–	16.00	0.6299	82.0	133.0	48.0	16.00
RS40541/64	41/64	16.27	0.6406	91.0	143.0	48.0	18.00
RS40516.5	–	16.50	0.6496	91.0	143.0	48.0	18.00
RS40521/32	21/32	16.67	0.6563	91.0	143.0	48.0	18.00
RS40517.0	–	17.00	0.6693	91.0	143.0	48.0	18.00

产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RS40543/64	43/64	17.07	0.6720	91.0	143.0	48.0	18.00
RS40511/16	11/16	17.46	0.6874	91.0	143.0	48.0	18.00
RS40517.5	–	17.50	0.6890	91.0	143.0	48.0	18.00
RS40517.8	–	17.80	0.7008	91.0	143.0	48.0	18.00
RS40545/64	45/64	17.86	0.7031	91.0	143.0	48.0	18.00
RS40518.0	–	18.00	0.7087	91.0	143.0	48.0	18.00
RS40523/32	23/32	18.26	0.7189	99.0	153.0	50.0	20.00
RS40518.5	–	18.50	0.7283	99.0	153.0	50.0	20.00
RS40547/64	47/64	18.65	0.7343	99.0	153.0	50.0	20.00
RS40519.0	–	19.00	0.7480	99.0	153.0	50.0	20.00
RS4053/4	3/4	19.05	0.7500	99.0	153.0	50.0	20.00
RS40519.5	–	19.50	0.7677	99.0	153.0	50.0	20.00
RS40519.8	–	19.80	0.7795	99.0	153.0	50.0	20.00
RS40520.0	–	20.00	0.7874	99.0	153.0	50.0	20.00

RC405

FORCE X 5XD 整体硬质合金钻头，带冷却进给装置，TiAlN-Top 涂层
高性能钻头专为在高速和高进给条件下提供优异的孔质量而设计（H9 孔公差，适用于多种材料）。140° 自定心、4 刀面分刃点和 CTW 刀槽结构。冷却孔加强了排屑效果。顶部 TiAlN 涂层可提高表面硬度，增强耐磨性，延长刀具寿命。



HM	DIN 6537	5×D
140°	TiAlN Top	DIN 6535HA
CTW	R	DC m7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页24开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
140 W	142 W	142 W	122 W	120 W	105 V	110 V	102 V	100 V	99 V	95 V	50 U	105 G	101 G
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
99 G	80 G	70 E	85 G	70 G	65 F	60 F	50 E	111 W	108 W	105 W	111 W	110 W	99 W
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
105 W	99 W	95 W	100 W	80 W	77 W	72 W	70 W	105 W	100 W	80 W	305 W	310 W	300 W
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
221 W	220 W	200 W	185 W	180 W	175 W	50 V	40 V	35 U	40 U	28 U	32 U	32 U	30 U
S4.2													
25 U													

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RC4053.0	–	3.00	0.1181	28.0	66.0	36.0	6.00
RC4053.1	–	3.10	0.1220	28.0	66.0	36.0	6.00
RC4051/8	1/8	3.18	0.1250	28.0	66.0	36.0	6.00
RC4053.2	–	3.20	0.1260	28.0	66.0	36.0	6.00
RC405N30	N30	3.26	0.1283	28.0	66.0	36.0	6.00
RC4053.3	–	3.30	0.1299	28.0	66.0	36.0	6.00
RC4053.4	–	3.40	0.1339	28.0	66.0	36.0	6.00
RC405N29	N29	3.45	0.1360	28.0	66.0	36.0	6.00
RC4053.5	–	3.50	0.1378	28.0	66.0	36.0	6.00
RC405N28	N28	3.57	0.1406	28.0	66.0	36.0	6.00
RC4059/64	9/64	3.57	0.1406	28.0	66.0	36.0	6.00
RC4053.6	–	3.60	0.1417	28.0	66.0	36.0	6.00
RC405N27	N27	3.66	0.1441	28.0	66.0	36.0	6.00
RC4053.7	–	3.70	0.1457	28.0	66.0	36.0	6.00
RC405N26	N26	3.73	0.1469	36.0	74.0	36.0	6.00
RC405N25	N25	3.80	0.1496	36.0	74.0	36.0	6.00
RC4053.8	–	3.80	0.1496	36.0	74.0	36.0	6.00
RC405N24	N24	3.86	0.1520	36.0	74.0	36.0	6.00
RC4053.9	–	3.90	0.1535	36.0	74.0	36.0	6.00
RC405N23	N23	3.91	0.1539	36.0	74.0	36.0	6.00
RC4055/32	5/32	3.97	0.1563	36.0	74.0	36.0	6.00
RC405N22	N22	3.99	0.1571	36.0	74.0	36.0	6.00
RC4054.0	–	4.00	0.1575	36.0	74.0	36.0	6.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RC405N21	N21	4.04	0.1591	36.0	74.0	36.0	6.00
RC4054.05	–	4.05	0.1594	36.0	74.0	36.0	6.00
RC405N20	N20	4.09	0.1610	36.0	74.0	36.0	6.00
RC4054.1	–	4.10	0.1614	36.0	74.0	36.0	6.00
RC4054.2	–	4.20	0.1654	36.0	74.0	36.0	6.00
RC405N19	N19	4.22	0.1661	36.0	74.0	36.0	6.00
RC4054.3	–	4.30	0.1693	36.0	74.0	36.0	6.00
RC405N18	N18	4.31	0.1697	36.0	74.0	36.0	6.00
RC40511/64	11/64	4.37	0.1719	36.0	74.0	36.0	6.00
RC405N17	N17	4.39	0.1728	36.0	74.0	36.0	6.00
RC4054.4	–	4.40	0.1732	36.0	74.0	36.0	6.00
RC405N16	N16	4.50	0.1772	36.0	74.0	36.0	6.00
RC4054.5	–	4.50	0.1772	36.0	74.0	36.0	6.00
RC405N15	N15	4.57	0.1799	36.0	74.0	36.0	6.00
RC4054.6	–	4.60	0.1811	36.0	74.0	36.0	6.00
RC405N14	N14	4.62	0.1819	36.0	74.0	36.0	6.00
RC405N13	N13	4.70	0.1850	36.0	74.0	36.0	6.00
RC4054.7	–	4.70	0.1850	36.0	74.0	36.0	6.00
RC4053/16	3/16	4.76	0.1875	44.0	82.0	36.0	6.00
RC405N12	N12	4.80	0.1890	44.0	82.0	36.0	6.00
RC4054.8	–	4.80	0.1890	44.0	82.0	36.0	6.00
RC405N11	N11	4.85	0.1909	44.0	82.0	36.0	6.00
RC4054.9	–	4.90	0.1929	44.0	82.0	36.0	6.00

产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RC405N10	N10	4.92	0.1937	44.0	82.0	36.0	6.00
RC405N9	N9	4.98	0.1961	44.0	82.0	36.0	6.00
RC4055.0	–	5.00	0.1969	44.0	82.0	36.0	6.00
RC4055.05	–	5.05	0.1988	44.0	82.0	36.0	6.00
RC405N8	N8	5.06	0.1992	44.0	82.0	36.0	6.00
RC4055.1	–	5.10	0.2008	44.0	82.0	36.0	6.00
RC405N7	N7	5.11	0.2010	44.0	82.0	36.0	6.00
RC40513/64	13/64	5.16	0.2031	44.0	82.0	36.0	6.00
RC405N6	N6	5.18	0.2039	44.0	82.0	36.0	6.00
RC4055.2	–	5.20	0.2047	44.0	82.0	36.0	6.00
RC405N5	N5	5.22	0.2055	44.0	82.0	36.0	6.00
RC4055.3	–	5.30	0.2087	44.0	82.0	36.0	6.00
RC405N4	N4	5.31	0.2091	44.0	82.0	36.0	6.00
RC4055.4	–	5.40	0.2126	44.0	82.0	36.0	6.00
RC405N3	N3	5.41	0.2130	44.0	82.0	36.0	6.00
RC4055.5	–	5.50	0.2165	44.0	82.0	36.0	6.00
RC4057/32	7/32	5.56	0.2188	44.0	82.0	36.0	6.00
RC4055.6	–	5.60	0.2205	44.0	82.0	36.0	6.00
RC405N2	N2	5.61	0.2209	44.0	82.0	36.0	6.00
RC4055.7	–	5.70	0.2244	44.0	82.0	36.0	6.00
RC405N1	N1	5.79	0.2280	44.0	82.0	36.0	6.00
RC4055.8	–	5.80	0.2283	44.0	82.0	36.0	6.00
RC4055.9	–	5.90	0.2323	44.0	82.0	36.0	6.00
RC405A	A	5.94	0.2339	44.0	82.0	36.0	6.00
RC40515/64	15/64	5.95	0.2344	44.0	82.0	36.0	6.00
RC4056.0	–	6.00	0.2362	44.0	82.0	36.0	6.00
RC405B	B	6.05	0.2380	53.0	91.0	36.0	8.00
RC4056.05	–	6.05	0.2382	53.0	91.0	36.0	8.00
RC4056.1	–	6.10	0.2402	53.0	91.0	36.0	8.00
RC405C	C	6.15	0.2421	53.0	91.0	36.0	8.00
RC4056.2	–	6.20	0.2441	53.0	91.0	36.0	8.00
RC405D	D	6.25	0.2461	53.0	91.0	36.0	8.00
RC4056.3	–	6.30	0.2480	53.0	91.0	36.0	8.00
RC405E	E	6.35	0.2500	53.0	91.0	36.0	8.00
RC4051/4	1/4	6.35	0.2500	53.0	91.0	36.0	8.00
RC4056.4	–	6.40	0.2520	53.0	91.0	36.0	8.00
RC4056.5	–	6.50	0.2559	53.0	91.0	36.0	8.00
RC405F	F	6.53	0.2571	53.0	91.0	36.0	8.00
RC4056.6	–	6.60	0.2598	53.0	91.0	36.0	8.00
RC405G	G	6.63	0.2610	53.0	91.0	36.0	8.00
RC4056.7	–	6.70	0.2638	53.0	91.0	36.0	8.00
RC40517/64	17/64	6.75	0.2656	53.0	91.0	36.0	8.00
RC405H	H	6.76	0.2661	53.0	91.0	36.0	8.00
RC4056.8	–	6.80	0.2677	53.0	91.0	36.0	8.00
RC4056.9	–	6.90	0.2717	53.0	91.0	36.0	8.00
RC405I	I	6.91	0.2720	53.0	91.0	36.0	8.00
RC4057.0	–	7.00	0.2756	53.0	91.0	36.0	8.00
RC405J	J	7.04	0.2772	53.0	91.0	36.0	8.00
RC4057.1	–	7.10	0.2795	53.0	91.0	36.0	8.00
RC405K	K	7.14	0.2811	53.0	91.0	36.0	8.00
RC4059/32	9/32	7.14	0.2813	53.0	91.0	36.0	8.00
RC4057.2	–	7.20	0.2835	53.0	91.0	36.0	8.00
RC4057.3	–	7.30	0.2874	53.0	91.0	36.0	8.00
RC405L	L	7.37	0.2902	53.0	91.0	36.0	8.00
RC4057.4	–	7.40	0.2913	53.0	91.0	36.0	8.00
RC405M	M	7.49	0.2949	53.0	91.0	36.0	8.00
RC4057.5	–	7.50	0.2953	53.0	91.0	36.0	8.00
RC40519/64	19/64	7.54	0.2969	53.0	91.0	36.0	8.00
RC4057.6	–	7.60	0.2992	53.0	91.0	36.0	8.00
RC405N	N	7.67	0.3020	53.0	91.0	36.0	8.00
RC4057.7	–	7.70	0.3031	53.0	91.0	36.0	8.00
RC4057.8	–	7.80	0.3071	53.0	91.0	36.0	8.00

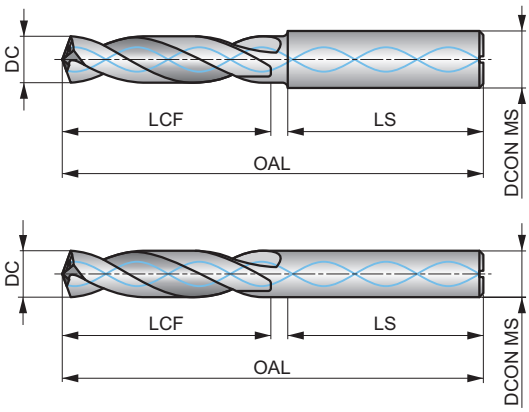
产品	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
RC4057.9	–	7.90	0.3110	53.0	91.0	36.0	8.00
RC4055/16	5/16	7.94	0.3125	53.0	91.0	36.0	8.00
RC4058.0	–	8.00	0.3150	53.0	91.0	36.0	8.00
RC405O	O	8.03	0.3161	61.0	103.0	40.0	10.00
RC4058.05	–	8.05	0.3169	61.0	103.0	40.0	10.00
RC4058.1	–	8.10	0.3189	61.0	103.0	40.0	10.00
RC4058.2	–	8.20	0.3228	61.0	103.0	40.0	10.00
RC405P	P	8.20	0.3228	61.0	103.0	40.0	10.00
RC4058.3	–	8.30	0.3268	61.0	103.0	40.0	10.00
RC40521/64	21/64	8.33	0.3281	61.0	103.0	40.0	10.00
RC4058.4	–	8.40	0.3307	61.0	103.0	40.0	10.00
RC405Q	Q	8.43	0.3319	61.0	103.0	40.0	10.00
RC4058.5	–	8.50	0.3346	61.0	103.0	40.0	10.00
RC4058.6	–	8.60	0.3386	61.0	103.0	40.0	10.00
RC405R	R	8.61	0.3390	61.0	103.0	40.0	10.00
RC4058.7	–	8.70	0.3425	61.0	103.0	40.0	10.00
RC40511/32	11/32	8.73	0.3438	61.0	103.0	40.0	10.00
RC4058.8	–	8.80	0.3465	61.0	103.0	40.0	10.00
RC405S	S	8.84	0.3480	61.0	103.0	40.0	10.00
RC4058.9	–	8.90	0.3504	61.0	103.0	40.0	10.00
RC4059.0	–	9.00	0.3543	61.0	103.0	40.0	10.00
RC405T	T	9.09	0.3579	61.0	103.0	40.0	10.00
RC4059.1	–	9.10	0.3583	61.0	103.0	40.0	10.00
RC40523/64	23/64	9.13	0.3594	61.0	103.0	40.0	10.00
RC4059.2	–	9.20	0.3622	61.0	103.0	40.0	10.00
RC4059.3	–	9.30	0.3661	61.0	103.0	40.0	10.00
RC405U	U	9.35	0.3681	61.0	103.0	40.0	10.00
RC4059.4	–	9.40	0.3701	61.0	103.0	40.0	10.00
RC4059.5	–	9.50	0.3740	61.0	103.0	40.0	10.00
RC4053/8	3/8	9.53	0.3750	61.0	103.0	40.0	10.00
RC405V	V	9.58	0.3772	61.0	103.0	40.0	10.00
RC4059.6	–	9.60	0.3780	61.0	103.0	40.0	10.00
RC4059.7	–	9.70	0.3819	61.0	103.0	40.0	10.00
RC4059.8	–	9.80	0.3858	61.0	103.0	40.0	10.00
RC405W	W	9.80	0.3858	61.0	103.0	40.0	10.00
RC4059.9	–	9.90	0.3898	61.0	103.0	40.0	10.00
RC40525/64	25/64	9.92	0.3906	61.0	103.0	40.0	10.00
RC40510.0	–	10.00	0.3937	61.0	103.0	40.0	10.00
RC40510.05	–	10.05	0.3957	70.0	118.0	45.0	12.00
RC405X	X	10.08	0.3969	70.0	118.0	45.0	12.00
RC40510.1	–	10.10	0.3976	70.0	118.0	45.0	12.00
RC40510.2	–	10.20	0.4016	70.0	118.0	45.0	12.00
RC405Y	Y	10.26	0.4039	70.0	118.0	45.0	12.00
RC40510.3	–	10.30	0.4055	70.0	118.0	45.0	12.00
RC40513/32	13/32	10.32	0.4063	70.0	118.0	45.0	12.00
RC40510.4	–	10.40	0.4094	70.0	118.0	45.0	12.00
RC405Z	Z	10.49	0.4130	70.0	118.0	45.0	12.00
RC40510.5	–	10.50	0.4134	70.0	118.0	45.0	12.00
RC40510.6	–	10.60	0.4173	70.0	118.0	45.0	12.00
RC40527/64	27/64	10.72	0.4219	70.0	118.0	45.0	12.00
RC40510.8	–	10.80	0.4252	70.0	118.0	45.0	12.00
RC40510.9	–	10.90	0.4291	70.0	118.0	45.0	12.00
RC40511.0	–	11.00	0.4331	70.0	118.0	45.0	12.00
RC4057/16	7/16	11.11	0.4375	70.0	118.0	45.0	12.00
RC40511.2	–	11.20	0.4409	70.0	118.0	45.0	12.00
RC40511.3	–	11.30	0.4449	70.0	118.0	45.0	12.00
RC40511.4	–	11.40	0.4488	70.0	118.0	45.0	12.00
RC40511.5	–	11.50	0.4528	70.0	118.0	45.0	12.00
RC40529/64	29/64	11.51	0.4531	70.0	118.0	45.0	12.00
RC40511.6	–	11.60	0.4567	70.0	118.0	45.0	12.00
RC40511.8	–	11.80	0.4646	70.0	118.0	45.0	12.00
RC40515/32	15/32	11.91	0.4688	70.0	118.0	45.0	12.00

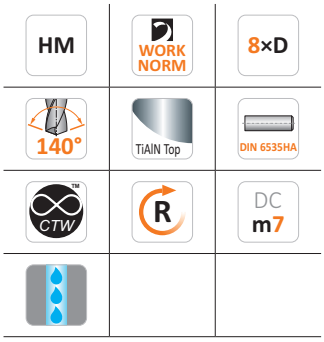
产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RC40512.0	–	12.00	0.4724	70.0	118.0	45.0	12.00
RC40512.05	–	12.05	0.4744	76.0	124.0	45.0	14.00
RC40512.2	–	12.20	0.4803	76.0	124.0	45.0	14.00
RC40531/64	31/64	12.30	0.4844	76.0	124.0	45.0	14.00
RC40512.5	–	12.50	0.4921	76.0	124.0	45.0	14.00
RC4051/2	1/2	12.70	0.5000	76.0	124.0	45.0	14.00
RC40512.7	–	12.70	0.5000	76.0	124.0	45.0	14.00
RC40512.8	–	12.80	0.5039	76.0	124.0	45.0	14.00
RC40513.0	–	13.00	0.5118	76.0	124.0	45.0	14.00
RC40533/64	33/64	13.10	0.5156	76.0	124.0	45.0	14.00
RC40513.3	–	13.30	0.5236	76.0	124.0	45.0	14.00
RC40517/32	17/32	13.49	0.5313	76.0	124.0	45.0	14.00
RC40513.5	–	13.50	0.5315	76.0	124.0	45.0	14.00
RC40513.8	–	13.80	0.5433	76.0	124.0	45.0	14.00
RC40535/64	35/64	13.89	0.5469	76.0	124.0	45.0	14.00
RC40514.0	–	14.00	0.5512	76.0	124.0	45.0	14.00
RC40514.25	–	14.25	0.5610	82.0	133.0	48.0	16.00
RC4059/16	9/16	14.29	0.5625	82.0	133.0	48.0	16.00
RC40514.5	–	14.50	0.5709	82.0	133.0	48.0	16.00
RC40537/64	37/64	14.68	0.5781	82.0	133.0	48.0	16.00
RC40514.8	–	14.80	0.5827	82.0	133.0	48.0	16.00
RC40515.0	–	15.00	0.5906	82.0	133.0	48.0	16.00
RC40519/32	19/32	15.08	0.5938	82.0	133.0	48.0	16.00
RC40515.1	–	15.10	0.5945	82.0	133.0	48.0	16.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RC40515.3	–	15.30	0.6024	82.0	133.0	48.0	16.00
RC40539/64	39/64	15.48	0.6094	82.0	133.0	48.0	16.00
RC40515.5	–	15.50	0.6102	82.0	133.0	48.0	16.00
RC40515.8	–	15.80	0.6220	82.0	133.0	48.0	16.00
RC4055/8	5/8	15.88	0.6250	82.0	133.0	48.0	16.00
RC40516.0	–	16.00	0.6299	82.0	133.0	48.0	16.00
RC40541/64	41/64	16.27	0.6406	91.0	143.0	48.0	18.00
RC40516.5	–	16.50	0.6496	91.0	143.0	48.0	18.00
RC40521/32	21/32	16.67	0.6563	91.0	143.0	48.0	18.00
RC40517.0	–	17.00	0.6693	91.0	143.0	48.0	18.00
RC40543/64	43/64	17.07	0.6720	91.0	143.0	48.0	18.00
RC40511/16	11/16	17.46	0.6874	91.0	143.0	48.0	18.00
RC40517.5	–	17.50	0.6890	91.0	143.0	48.0	18.00
RC40517.8	–	17.80	0.7008	91.0	143.0	48.0	18.00
RC40545/64	45/64	17.86	0.7031	91.0	143.0	48.0	18.00
RC40518.0	–	18.00	0.7087	91.0	143.0	48.0	18.00
RC40523/32	23/32	18.26	0.7189	99.0	153.0	50.0	20.00
RC40518.5	–	18.50	0.7283	99.0	153.0	50.0	20.00
RC40547/64	47/64	18.65	0.7343	99.0	153.0	50.0	20.00
RC40519.0	–	19.00	0.7480	99.0	153.0	50.0	20.00
RC4053/4	3/4	19.05	0.7500	99.0	153.0	50.0	20.00
RC40519.5	–	19.50	0.7677	99.0	153.0	50.0	20.00
RC40519.8	–	19.80	0.7795	99.0	153.0	50.0	20.00
RC40520.0	–	20.00	0.7874	99.0	153.0	50.0	20.00

RC408

FORCE X 8XD 整体硬质合金钻头，带冷却进给装置，TiAlN-Top 涂层
高性能钻头专为在高速和高进给条件下提供优异的孔质量而设计（H9 孔公差，适用于多种材料）。140° 自定心、4 刀面分刃点和 CTW 刀槽结构。冷却孔加强了排屑效果。顶部 TiAlN 涂层可提高表面硬度，增强耐磨性，延长刀具寿命。





工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页24开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
140 W	142 W	142 W	122 W	120 W	105 V	110 V	102 V	100 V	99 V	95 V	50 T	105 G	101 G
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
99 G	80 G	70 E	85 G	70 G	65 F	60 F	50 E	111 W	108 W	105 W	111 W	110 W	99 W
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
105 W	99 W	95 W	100 W	80 W	77 W	72 W	70 W	105 W	100 W	80 W	305 W	310 W	300 W
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
221 W	220 W	200 W	185 W	180 W	175 W	50 V	40 V	35 U	40 U	28 U	32 U	32 U	30 U
S4.2													
25 U													

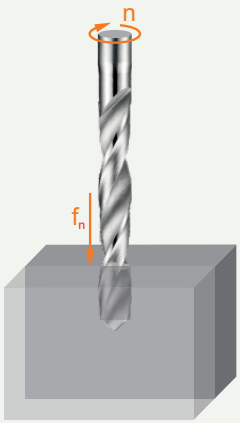
DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RC4083.0	–	3.00	0.1181	37.0	79.0	36.0	6.00
RC4083.1	–	3.10	0.1220	37.0	79.0	36.0	6.00
RC4081/8	1/8	3.18	0.1250	37.0	79.0	36.0	6.00
RC4083.2	–	3.20	0.1260	37.0	79.0	36.0	6.00
RC4083.3	–	3.30	0.1299	37.0	79.0	36.0	6.00
RC4083.4	–	3.40	0.1339	37.0	79.0	36.0	6.00
RC4083.5	–	3.50	0.1378	37.0	79.0	36.0	6.00
RC4089/64	9/64	3.57	0.1406	37.0	79.0	36.0	6.00
RC4083.6	–	3.60	0.1417	37.0	79.0	36.0	6.00
RC4083.7	–	3.70	0.1457	37.0	79.0	36.0	6.00
RC4083.8	–	3.80	0.1496	48.0	90.0	36.0	6.00
RC4083.9	–	3.90	0.1535	48.0	90.0	36.0	6.00
RC4085/32	5/32	3.97	0.1563	48.0	90.0	36.0	6.00
RC4084.0	–	4.00	0.1575	48.0	90.0	36.0	6.00
RC4084.1	–	4.10	0.1614	48.0	90.0	36.0	6.00
RC4084.2	–	4.20	0.1654	48.0	90.0	36.0	6.00
RC4084.3	–	4.30	0.1693	48.0	90.0	36.0	6.00
RC40811/64	11/64	4.37	0.1719	48.0	90.0	36.0	6.00
RC4084.4	–	4.40	0.1732	48.0	90.0	36.0	6.00
RC4084.5	–	4.50	0.1772	48.0	90.0	36.0	6.00
RC4084.6	–	4.60	0.1811	48.0	90.0	36.0	6.00
RC4084.7	–	4.70	0.1850	62.0	104.0	36.0	6.00
RC4083/16	3/16	4.76	0.1875	62.0	104.0	36.0	6.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RC4084.8	–	4.80	0.1890	62.0	104.0	36.0	6.00
RC4084.9	–	4.90	0.1929	62.0	104.0	36.0	6.00
RC4085.0	–	5.00	0.1969	62.0	104.0	36.0	6.00
RC4085.1	–	5.10	0.2008	62.0	104.0	36.0	6.00
RC40813/64	13/64	5.16	0.2031	62.0	104.0	36.0	6.00
RC4085.2	–	5.20	0.2047	62.0	104.0	36.0	6.00
RC4085.3	–	5.30	0.2087	62.0	104.0	36.0	6.00
RC4085.4	–	5.40	0.2126	62.0	104.0	36.0	6.00
RC4085.5	–	5.50	0.2165	62.0	104.0	36.0	6.00
RC4087/32	7/32	5.56	0.2188	62.0	104.0	36.0	6.00
RC4085.6	–	5.60	0.2205	62.0	104.0	36.0	6.00
RC4085.7	–	5.70	0.2244	62.0	104.0	36.0	6.00
RC4085.8	–	5.80	0.2283	62.0	104.0	36.0	6.00
RC4085.9	–	5.90	0.2323	62.0	104.0	36.0	6.00
RC40815/64	15/64	5.95	0.2344	62.0	104.0	36.0	6.00
RC4086.0	–	6.00	0.2362	62.0	104.0	36.0	6.00
RC4086.1	–	6.10	0.2402	84.0	126.0	36.0	8.00
RC4086.2	–	6.20	0.2441	84.0	126.0	36.0	8.00
RC4086.3	–	6.30	0.2480	84.0	126.0	36.0	8.00
RC4081/4	1/4	6.35	0.2500	84.0	126.0	36.0	8.00
RC4086.4	–	6.40	0.2520	84.0	126.0	36.0	8.00
RC4086.5	–	6.50	0.2559	84.0	126.0	36.0	8.00
RC4086.6	–	6.60	0.2598	84.0	126.0	36.0	8.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RC4086.7	–	6.70	0.2638	84.0	126.0	36.0	8.00
RC40817/64	17/64	6.75	0.2656	84.0	126.0	36.0	8.00
RC4086.8	–	6.80	0.2677	84.0	126.0	36.0	8.00
RC4086.9	–	6.90	0.2717	84.0	126.0	36.0	8.00
RC4087.0	–	7.00	0.2756	84.0	126.0	36.0	8.00
RC4087.1	–	7.10	0.2795	84.0	126.0	36.0	8.00
RC4089/32	9/32	7.14	0.2813	84.0	126.0	36.0	8.00
RC4087.2	–	7.20	0.2835	84.0	126.0	36.0	8.00
RC4087.3	–	7.30	0.2874	84.0	126.0	36.0	8.00
RC4087.4	–	7.40	0.2913	84.0	126.0	36.0	8.00
RC4087.5	–	7.50	0.2953	84.0	126.0	36.0	8.00
RC40819/64	19/64	7.54	0.2969	84.0	126.0	36.0	8.00
RC4087.6	–	7.60	0.2992	84.0	126.0	36.0	8.00
RC4087.7	–	7.70	0.3031	84.0	126.0	36.0	8.00
RC4087.8	–	7.80	0.3071	84.0	126.0	36.0	8.00
RC4087.9	–	7.90	0.3110	84.0	126.0	36.0	8.00
RC4085/16	5/16	7.94	0.3125	84.0	126.0	36.0	8.00
RC4088.0	–	8.00	0.3150	84.0	126.0	36.0	8.00
RC4088.1	–	8.10	0.3189	106.0	152.0	40.0	10.00
RC4088.2	–	8.20	0.3228	106.0	152.0	40.0	10.00
RC4088.3	–	8.30	0.3268	106.0	152.0	40.0	10.00
RC40821/64	21/64	8.33	0.3281	106.0	152.0	40.0	10.00
RC4088.4	–	8.40	0.3307	106.0	152.0	40.0	10.00
RC4088.5	–	8.50	0.3346	106.0	152.0	40.0	10.00
RC4088.6	–	8.60	0.3386	106.0	152.0	40.0	10.00
RC4088.7	–	8.70	0.3425	106.0	152.0	40.0	10.00
RC40811/32	11/32	8.73	0.3438	106.0	152.0	40.0	10.00
RC4088.8	–	8.80	0.3465	106.0	152.0	40.0	10.00
RC4088.9	–	8.90	0.3504	106.0	152.0	40.0	10.00
RC4089.0	–	9.00	0.3543	106.0	152.0	40.0	10.00
RC4089.1	–	9.10	0.3583	106.0	152.0	40.0	10.00
RC40823/64	23/64	9.13	0.3594	106.0	152.0	40.0	10.00
RC4089.2	–	9.20	0.3622	106.0	152.0	40.0	10.00
RC4089.3	–	9.30	0.3661	106.0	152.0	40.0	10.00
RC4089.4	–	9.40	0.3701	106.0	152.0	40.0	10.00
RC4089.5	–	9.50	0.3740	106.0	152.0	40.0	10.00
RC4083/8	3/8	9.53	0.3750	106.0	152.0	40.0	10.00
RC4089.6	–	9.60	0.3780	106.0	152.0	40.0	10.00
RC4089.7	–	9.70	0.3819	106.0	152.0	40.0	10.00
RC4089.8	–	9.80	0.3858	106.0	152.0	40.0	10.00
RC4089.9	–	9.90	0.3898	106.0	152.0	40.0	10.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
RC40825/64	25/64	9.92	0.3906	106.0	152.0	40.0	10.00
RC40810.0	–	10.00	0.3937	106.0	152.0	40.0	10.00
RC40810.2	–	10.20	0.4016	128.0	180.0	45.0	12.00
RC40810.3	–	10.30	0.4055	128.0	180.0	45.0	12.00
RC40813/32	13/32	10.32	0.4063	128.0	180.0	45.0	12.00
RC40810.4	–	10.40	0.4094	128.0	180.0	45.0	12.00
RC40810.5	–	10.50	0.4134	128.0	180.0	45.0	12.00
RC40827/64	27/64	10.72	0.4219	128.0	180.0	45.0	12.00
RC40810.8	–	10.80	0.4252	128.0	180.0	45.0	12.00
RC40811.0	–	11.00	0.4331	128.0	180.0	45.0	12.00
RC4087/16	7/16	11.11	0.4375	128.0	180.0	45.0	12.00
RC40811.2	–	11.20	0.4409	128.0	180.0	45.0	12.00
RC40811.3	–	11.30	0.4449	128.0	180.0	45.0	12.00
RC40811.5	–	11.50	0.4528	128.0	180.0	45.0	12.00
RC40829/64	29/64	11.51	0.4531	128.0	180.0	45.0	12.00
RC40811.8	–	11.80	0.4646	128.0	180.0	45.0	12.00
RC40815/32	15/32	11.91	0.4688	128.0	180.0	45.0	12.00
RC40812.0	–	12.00	0.4724	128.0	180.0	45.0	12.00
RC40812.2	–	12.20	0.4803	151.0	202.0	48.0	14.00
RC40831/64	31/64	12.30	0.4844	151.0	202.0	48.0	14.00
RC40812.5	–	12.50	0.4921	151.0	202.0	48.0	14.00
RC4081/2	1/2	12.70	0.5000	151.0	202.0	48.0	14.00
RC40812.8	–	12.80	0.5039	151.0	202.0	48.0	14.00
RC40813.0	–	13.00	0.5118	151.0	202.0	48.0	14.00
RC40833/64	33/64	13.10	0.5156	151.0	202.0	48.0	14.00
RC40817/32	17/32	13.49	0.5313	151.0	202.0	48.0	14.00
RC40813.5	–	13.50	0.5315	151.0	202.0	48.0	14.00
RC40835/64	35/64	13.89	0.5469	151.0	202.0	48.0	14.00
RC40814.0	–	14.00	0.5512	151.0	202.0	48.0	14.00
RC40814.25	–	14.25	0.5610	172.0	227.0	48.0	16.00
RC4089/16	9/16	14.29	0.5625	172.0	227.0	48.0	16.00
RC40814.5	–	14.50	0.5709	172.0	227.0	48.0	16.00
RC40837/64	37/64	14.68	0.5781	172.0	227.0	48.0	16.00
RC40815.0	–	15.00	0.5906	172.0	227.0	48.0	16.00
RC40819/32	19/32	15.08	0.5938	172.0	227.0	48.0	16.00
RC40815.1	–	15.10	0.5945	172.0	227.0	48.0	16.00
RC40839/64	39/64	15.48	0.6094	172.0	227.0	48.0	16.00
RC40815.5	–	15.50	0.6102	172.0	227.0	48.0	16.00
RC4085/8	5/8	15.88	0.6250	172.0	227.0	48.0	16.00
RC40816.0	–	16.00	0.6299	172.0	227.0	48.0	16.00



每转进给量f_n(毫米/转) 。
根据工况, 可能需要将这些值调整为 ± 25% 。

如何使用此表格查找每转进给量f_n:

1. 在产品页找到您的字母代码 (例如: 46J、“**J**” 是字母代码) 。
2. 在表格第一行找到与您切削应用最接近的直径。
3. 在表格左列找到您的字母代码。
4. 直径和字母代码的交点 (单元格) 是每转进给量f_n。

每转进给量 (毫米/转)	ø DC (毫米)																		
	0.15	0.5	1.0	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0	16.0	20.0	25.0	30.0	40.0	50.0	100
A	0.003	0.006	0.012	0.023	0.029	0.032	0.036	0.042	0.054	0.062	0.069	0.082	0.086	0.110	0.125	0.135	0.155	0.175	0.263
B	0.004	0.007	0.014	0.028	0.037	0.041	0.046	0.053	0.067	0.080	0.090	0.103	0.108	0.135	0.153	0.165	0.188	0.208	0.312
C	0.004	0.008	0.015	0.032	0.044	0.050	0.056	0.064	0.080	0.098	0.110	0.125	0.130	0.160	0.180	0.195	0.220	0.240	0.360
D	0.004	0.008	0.016	0.038	0.053	0.060	0.068	0.078	0.098	0.119	0.130	0.149	0.155	0.188	0.210	0.228	0.253	0.275	0.413
E	0.004	0.009	0.017	0.043	0.062	0.071	0.080	0.092	0.115	0.140	0.150	0.173	0.180	0.215	0.240	0.260	0.285	0.310	0.465
F	0.005	0.009	0.018	0.050	0.073	0.084	0.095	0.109	0.138	0.165	0.178	0.202	0.210	0.248	0.275	0.295	0.320	0.343	0.515
G	0.005	0.010	0.019	0.056	0.084	0.096	0.109	0.126	0.160	0.190	0.205	0.231	0.240	0.280	0.310	0.330	0.355	0.375	0.563
H	0.005	0.010	0.020	0.066	0.102	0.116	0.130	0.150	0.190	0.228	0.243	0.271	0.280	0.320	0.355	0.375	0.398	0.418	0.627
I	0.005	0.011	0.021	0.076	0.119	0.134	0.150	0.173	0.220	0.265	0.280	0.310	0.320	0.360	0.400	0.420	0.440	0.460	0.690
J	0.006	0.012	0.024	0.084	0.135	0.152	0.170	0.197	0.250	0.298	0.315	0.349	0.360	0.405	0.445	0.465	0.485	0.503	0.755
K	0.007	0.013	0.026	0.092	0.150	0.170	0.190	0.220	0.280	0.330	0.350	0.388	0.400	0.450	0.490	0.510	0.530	0.545	0.818
L	0.007	0.014	0.028	0.101	0.165	0.186	0.208	0.240	0.305	0.360	0.385	0.419	0.430	0.485	0.525	0.545	0.568	0.588	0.882
M	0.008	0.015	0.030	0.110	0.180	0.202	0.225	0.260	0.330	0.390	0.420	0.450	0.460	0.520	0.560	0.580	0.605	0.630	0.945
N	0.008	0.016	0.032	0.119	0.195	0.218	0.242	0.280	0.355	0.420	0.455	0.481	0.490	0.555	0.595	0.615	0.642	0.672	1.008
S	0.002	0.004	0.008	0.014	0.020	0.025	0.030	0.037	0.050	0.080	0.100	0.123	0.130	0.150	0.170	0.190	0.220	0.240	–
T	0.004	0.008	0.015	0.028	0.040	0.050	0.060	0.070	0.090	0.110	0.130	0.160	0.170	0.190	0.210	0.230	0.260	0.275	–
U	0.007	0.013	0.026	0.048	0.070	0.080	0.090	0.107	0.140	0.170	0.200	0.223	0.230	0.240	0.270	0.300	0.360	0.375	–
V	0.010	0.019	0.038	0.069	0.100	0.115	0.130	0.153	0.200	0.250	0.280	0.310	0.320	0.340	0.400	0.440	0.510	0.530	–
W	0.012	0.025	0.049	0.089	0.130	0.150	0.170	0.200	0.260	0.330	0.380	0.418	0.430	0.450	0.470	0.490	0.520	0.540	–
X	0.014	0.028	0.056	0.103	0.150	0.180	0.210	0.250	0.330	0.420	0.480	0.533	0.550	0.580	–	–	–	–	–
Y	0.017	0.034	0.068	0.124	0.180	0.220	0.260	0.317	0.430	0.550	0.700	0.700	0.700	0.740	–	–	–	–	–
Z	0.024	0.047	0.094	0.172	0.250	0.325	0.400	0.533	0.800	1.000	1.100	1.175	1.200	1.200	–	–	–	–	–

DORMER PRAMET™

Force深孔钻

整体硬质合金通用深孔钻

Certainty
at every turn™

整体硬质合金通用深孔钻

重新定义深孔钻，实现最高效率

Dormer Pramet 推出 Force 深孔钻 (DHD) 系列，专为 12xD、16xD 和 20xD 的高性能深孔钻而设计。

这些整体硬质合金钻头具有 140° 的钻尖角和优化的几何槽型设计，可实现快速钻削和卓越的定位精度，不会出现啄孔现象。内部冷却液通道增强了排屑能力，最大限度地减少了瓶颈，而钻尖复合涂层则提供了卓越的热稳定性和更长的刀具寿命。该系列还包括带有多层 TiAlN 涂层的 2xD 导孔钻，用于在使用深孔钻 (16xD 及更深) 之前创建精确的引导孔。

相关产品

RC412

12xD

3 – 20 毫米

纳米针尖涂层，**冷却液进给**

RC416

16xD

3 – 16 毫米

纳米针尖涂层，**冷却液进给**

RC420

20xD

3 – 16 毫米

纳米针尖涂层，**冷却液进给**

RC4P

2xD 导向钻

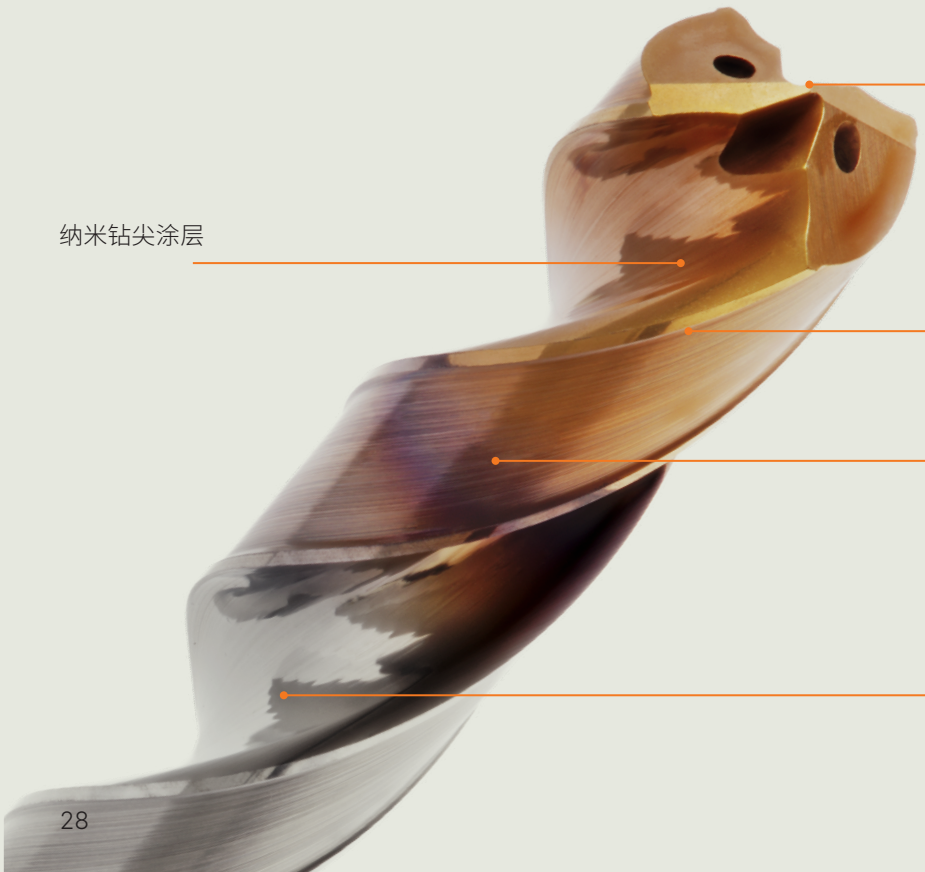
3 – 16 毫米

多层 TiAlN 涂层，**冷却液进给**

特点和优点

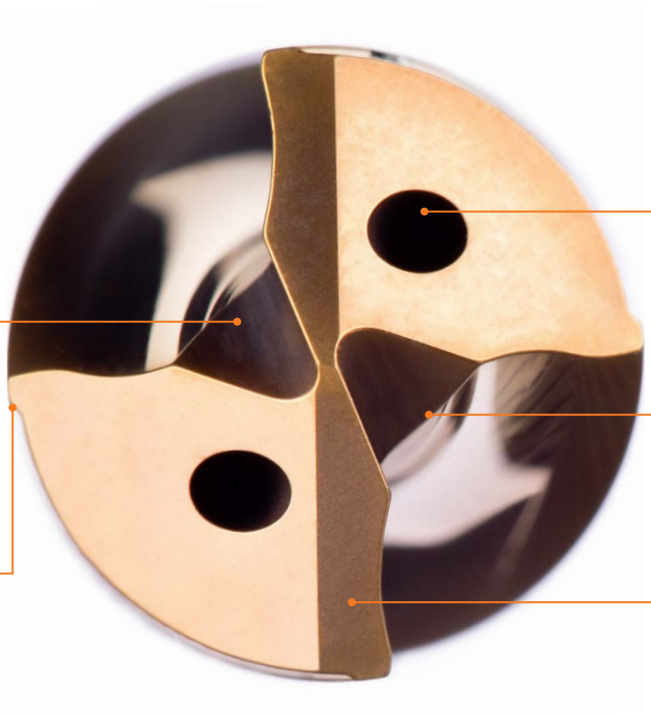
先进的几何槽型设计可将切削力降至最低。	**更高的稳定性** 确保更精确的孔定位和更笔直的钻孔路径。
内部冷却通道改善了排屑效果。	**工艺可靠性高** 保持稳定的钻孔流程，不会出现中断。
由于采用了优化的刃口几何形状，因此无需进行啄磨循环。	**钻孔速度更快** 缩短周期时间，提高高要求应用的生产率。
高性能深度功能（12xD、16xD 和 20xD）。	**多功能选项** 可在多种应用和深度下进行精确钻孔。建议在使用 16xD 和 20xD 钻头钻孔前使用先导钻。
纳米尖端涂层增强了耐磨性和热稳定性。	**延长刀具寿命** 降低单孔成本，提高整体效率。

深孔钻
(RC412、RC416、RC420)



特点和优点

几何形状
(RC412、RC416、RC420)



内部冷却液孔

- 适用于各种冷却液
- 油或乳化液
- MQL

优化的槽型设计

- 钻头刚度高
- 无钻槽尺寸限制
- 排屑安全高效

钻芯减薄

- 提高孔位置精度

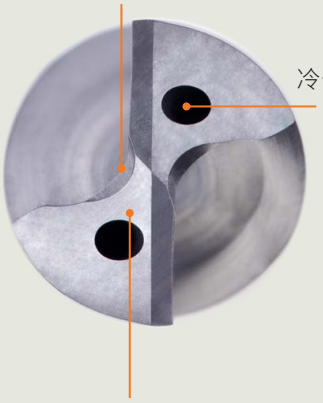
特殊倒棱设计

- 可在孔内快速引导

独特的几何形状

- 可在多种 WMG 中进行多功能钻孔
- 生产率高
- 孔精度高，无啄孔现象

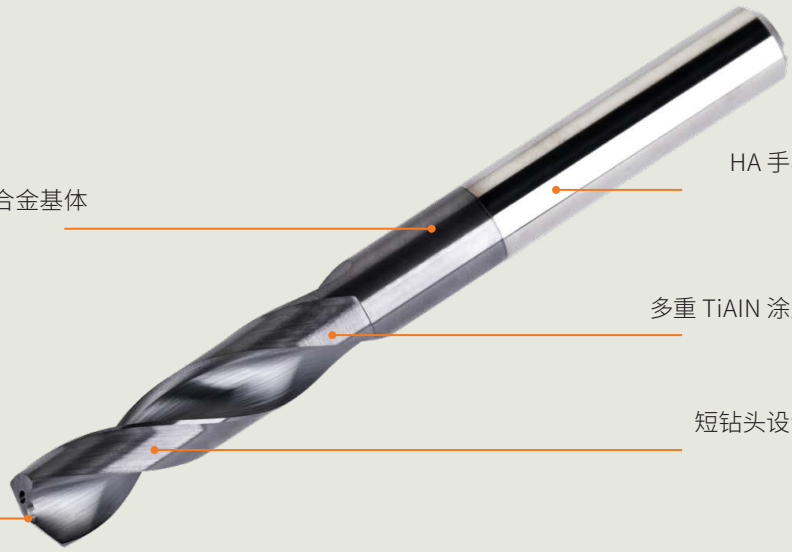
先导钻
(RC4P)



钻芯减薄

冷却液进给

4 面分离式刀尖



HA 手柄

微粒硬质合金基体

多重 TiAlN 涂层

短钻头设计

150° 尖端角

请注意：建议在使用 16xD 和 20xD 钻头钻孔前使用导向钻头

加工示例

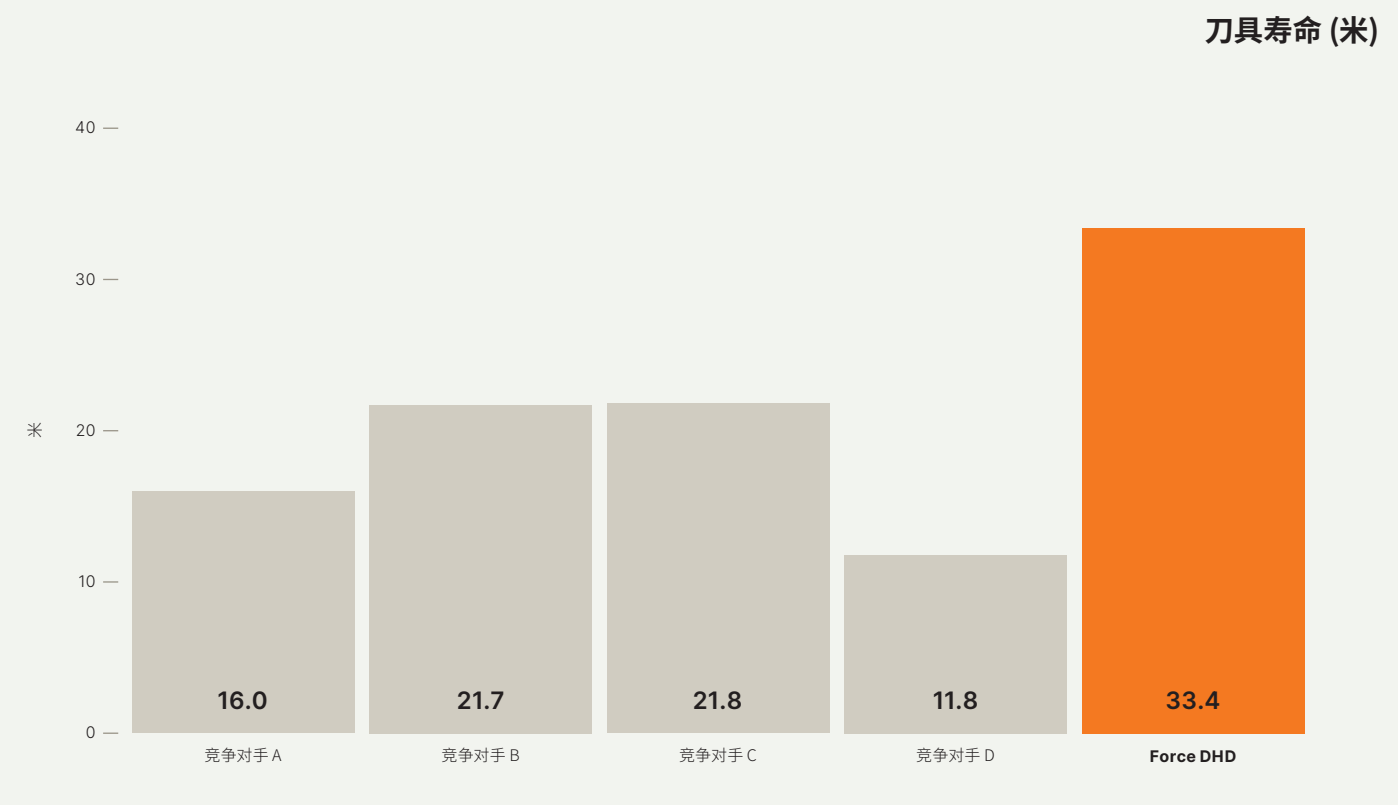
在使用 ISO-P 材料时，将刀具寿命延长 50%

Force 深孔钻的刀具寿命提高了 50%，达到 33.4 米，而最接近的竞争对手仅为 21.8 米。由于换刀次数减少，它提高了加工效率，非常适合具有挑战性的 ISO-P 应用。

机械加工	钻孔
应用	深孔钻
材料	1.7225 / 42CrMo4 / 4140
冷却液	是

Dormer Pramet 解决方案		
Force DHD RC4166.0		
加工数据		
v_c	f_n	深度
90	0.17	90

P3.2



v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），深度 = 钻孔深度（毫米）。

加工示例

在使用 ISO-K 材料时，刀具寿命延长 179%

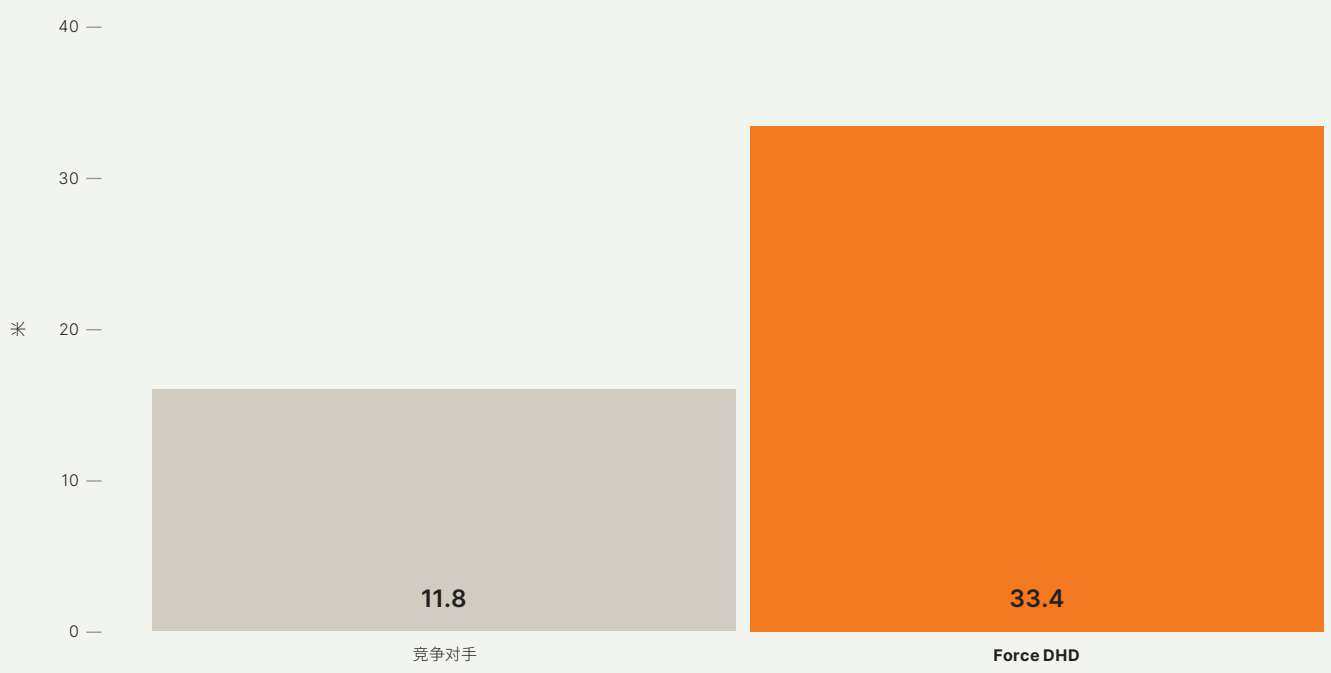
在加工 ISO-K 材料时，Force 深孔钻表现出色，刀具寿命提高了 179%，达到 33.4 米，而上一代产品仅为 11.8 米。这确保了更少的中断次数、更长的加工时间，并显著提高了高要求作业的生产率。

机械加工	钻孔
应用	深孔钻
材料	EN-GJV–450 / 230 HB
冷却液	是

Dormer Pramet 解决方案		
Force DHD RC4206.0		
加工数据		
v_c	f_n	深度
150	0.23	110

K5.3

刀具寿命 (米)



v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），深度 = 钻孔深度（毫米）。

加工示例

在使用 ISO-P 材料时，将刀具寿命延长 20%

Force 深孔钻的刀具寿命提高了 20%，每把刀具可加工 12 个零件，而竞争对手只能加工 10 个零件，刀具寿命从 27.5 米延长到 33 米。更长的耐用性确保了更高的可靠性，并优化了在苛刻的 ISO-P 环境下的加工效率。

机械加工	应用	材料	冷却液	Dormer Pramet 解决方案
钻孔	深孔钻	42CrMo4	是	Force DHD RC42010.0

加工数据	竞争对手	Force DHD
切削速度 v_c 米/分钟	79	79
进给/旋转 f_n (毫米/转)	0.25	0.25
进给/旋转 v_f (毫米/分钟)	628	628
主轴转速 n (转/分钟)	2515	2515
钻孔深度 (毫米)	185	185
部件数量	10	12
刀具寿命 (分钟)	27.5	33

P3.2

刀具寿命 (部件数量)

深孔钻加工建议

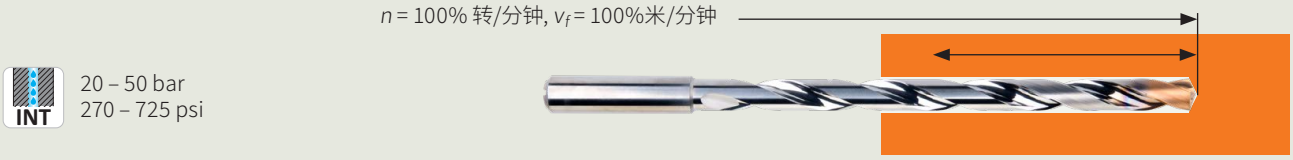
加工建议

一般注意事项:
深孔钻的移动速度不得超过 500 转/分钟 和 300毫米/分钟。

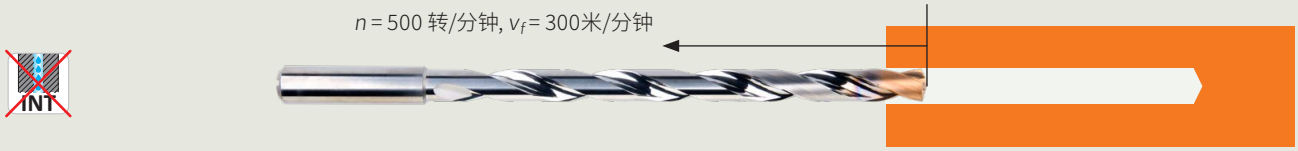
1.钻一个导向孔（最小 1.5 × D）

2.深孔钻以低进给量（500 转/分钟，300毫米/分钟）进给，直至距钻好的导向孔深度 1 毫米。

3.打开冷却液（最小 20 巴），以建议的速度开始钻孔，进给至最终钻孔深度 – 无需啄孔。将钻头退回到试钻深度。关闭冷却液!



4.以低速和低进给量（500 转/分钟 和 300毫米/分钟）将钻头从导向孔中送出。

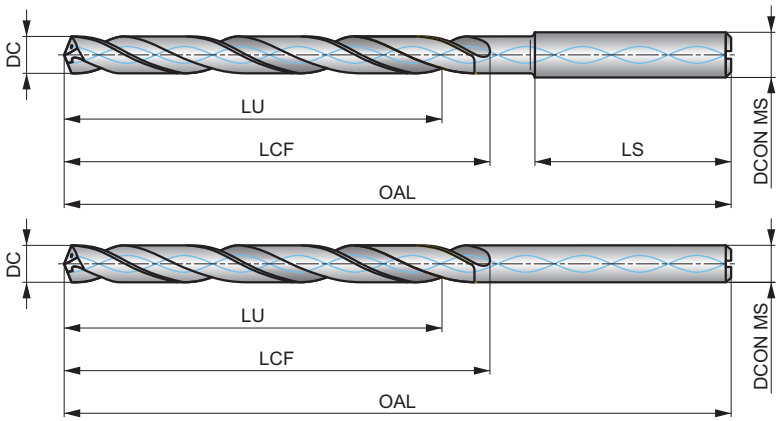


RC412

DORMER PRAMET

FORCE 12XD 深孔整体硬质合金钻头，带冷却液进给装置，纳米刀尖涂层

高性能深孔钻，钻尖角度为 140°，腹板设计更薄，钻孔深度可达 12xD，且无啄孔现象。设计用于快速穿透和精确制导，确保出色的定位精度。内部冷却液可增强排屑能力，纳米刀尖多层涂层具有卓越的热稳定性和耐磨性，可延长刀具寿命。



HM	DIN 6535	12×D
140°	Nano-Tip	DIN 6535HA
R	DC m7	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页39开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■116 H	■118 H	■121 H	■113 G	■105 H	■100 G	■113 G	■84 G	■47 E	■76 F	■84 G	■32 E	■100 H	■95 H
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
◪47 F	◪44 F	◪42 F	◪41 D	◪40 D	◪37 D	◪32 C	◪37 D	■110 J	■105 J	■95 J	■112 J	■106 J	■100 J
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■113 J	■103 J	■84 J	■95 L	■76 L	■65 V	■63 V	■58 V	■95 J	■84 J	■79 J	◪221 J	■208 J	■200 J
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
■200 J	■194 L	■147 J	■126 G	■147 H	■137 F	■37 D	■32 B	◪26 B	◪32 B	◪23 B	◪26 C	◪11 B	◪26 C
S4.2													
◪11 B													

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LU (mm)	LS (mm)	DCON MS (mm)
RC4123.0	–	3.00	0.1180	54.0	92.0	48.00	36.0	6.00
RC4123.1	–	3.10	0.1220	54.0	92.0	48.00	36.0	6.00
RC4121/8	1/8	3.17	0.1250	54.0	92.0	48.00	36.0	6.00
RC4123.2	–	3.20	0.1260	54.0	92.0	48.00	36.0	6.00
RC4123.3	–	3.30	0.1300	54.0	92.0	48.00	36.0	6.00
RC4123.4	–	3.40	0.1340	54.0	92.0	48.00	36.0	6.00
RC4123.5	–	3.50	0.1380	54.0	92.0	48.00	36.0	6.00
RC4129/64	9/64	3.57	0.1410	54.0	92.0	48.00	36.0	6.00
RC4123.6	–	3.60	0.1420	54.0	92.0	48.00	36.0	6.00
RC4123.7	–	3.70	0.1460	54.0	92.0	48.00	36.0	6.00
RC4123.8	–	3.80	0.1500	64.0	102.0	56.00	36.0	6.00
RC4123.9	–	3.90	0.1540	64.0	102.0	56.00	36.0	6.00
RC4125/32	5/32	3.97	0.1560	64.0	102.0	56.00	36.0	6.00
RC4124.0	–	4.00	0.1570	64.0	102.0	56.00	36.0	6.00
RC4124.1	–	4.10	0.1610	64.0	102.0	56.00	36.0	6.00
RC4124.2	–	4.20	0.1650	64.0	102.0	56.00	36.0	6.00
RC4124.3	–	4.30	0.1690	64.0	102.0	56.00	36.0	6.00
RC41211/64	11/64	4.37	0.1720	64.0	102.0	56.00	36.0	6.00
RC4124.4	–	4.40	0.1730	64.0	102.0	56.00	36.0	6.00
RC4124.5	–	4.50	0.1770	64.0	102.0	56.00	36.0	6.00
RC4124.6	–	4.60	0.1810	64.0	102.0	56.00	36.0	6.00
RC4124.7	–	4.70	0.1850	64.0	102.0	56.00	36.0	6.00
RC4123/16	3/16	4.76	0.1880	83.0	121.0	74.00	36.0	6.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LU (mm)	LS (mm)	DCON MS (mm)
RC4124.8	–	4.80	0.1890	83.0	121.0	74.00	36.0	6.00
RC4124.9	–	4.90	0.1930	83.0	121.0	74.00	36.0	6.00
RC4125.0	–	5.00	0.1970	83.0	121.0	74.00	36.0	6.00
RC4125.1	–	5.10	0.2010	83.0	121.0	74.00	36.0	6.00
RC41213/64	13/64	5.16	0.2030	83.0	121.0	74.00	36.0	6.00
RC4125.2	–	5.20	0.2050	83.0	121.0	74.00	36.0	6.00
RC4125.3	–	5.30	0.2090	83.0	121.0	74.00	36.0	6.00
RC4125.4	–	5.40	0.2130	83.0	121.0	74.00	36.0	6.00
RC4125.5	–	5.50	0.2170	83.0	121.0	74.00	36.0	6.00
RC4125.55	–	5.55	0.2190	83.0	121.0	74.00	36.0	6.00
RC4127/32	7/32	5.56	0.2190	83.0	121.0	74.00	36.0	6.00
RC4125.6	–	5.60	0.2200	83.0	121.0	74.00	36.0	6.00
RC4125.7	–	5.70	0.2240	83.0	121.0	74.00	36.0	6.00
RC4125.8	–	5.80	0.2280	83.0	121.0	74.00	36.0	6.00
RC4125.9	–	5.90	0.2320	83.0	121.0	74.00	36.0	6.00
RC4126.0	–	6.00	0.2360	83.0	121.0	74.00	36.0	6.00
RC4126.1	–	6.10	0.2400	110.0	148.0	98.00	36.0	8.00
RC4126.2	–	6.20	0.2440	110.0	148.0	98.00	36.0	8.00
RC4126.3	–	6.30	0.2480	110.0	148.0	98.00	36.0	8.00
RC4121/4	1/4	6.35	0.2500	110.0	148.0	98.00	36.0	8.00
RC4126.4	–	6.40	0.2520	110.0	148.0	98.00	36.0	8.00
RC4126.5	–	6.50	0.2560	110.0	148.0	98.00	36.0	8.00
RC4126.6	–	6.60	0.2600	110.0	148.0	98.00	36.0	8.00

产品	DC	DC	DC	LCF	OAL	LU	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)	(mm)
RC4126.7	–	6.70	0.2640	110.0	148.0	98.00	36.0	8.00
RC41217/64	17/64	6.75	0.2660	110.0	148.0	98.00	36.0	8.00
RC4126.8	–	6.80	0.2680	110.0	148.0	98.00	36.0	8.00
RC4126.9	–	6.90	0.2720	110.0	148.0	98.00	36.0	8.00
RC4127.0	–	7.00	0.2760	110.0	148.0	98.00	36.0	8.00
RC4127.1	–	7.10	0.2800	110.0	148.0	98.00	36.0	8.00
RC4129/32	9/32	7.14	0.2810	110.0	148.0	98.00	36.0	8.00
RC4127.2	–	7.20	0.2830	110.0	148.0	98.00	36.0	8.00
RC4127.3	–	7.30	0.2870	110.0	148.0	98.00	36.0	8.00
RC4127.4	–	7.40	0.2910	110.0	148.0	98.00	36.0	8.00
RC4127.5	–	7.50	0.2950	110.0	148.0	98.00	36.0	8.00
RC41219/64	19/64	7.54	0.2970	110.0	148.0	98.00	36.0	8.00
RC4127.8	–	7.80	0.3070	110.0	148.0	98.00	36.0	8.00
RC4127.9	–	7.90	0.3110	110.0	148.0	98.00	36.0	8.00
RC4125/16	5/16	7.94	0.3130	110.0	148.0	98.00	36.0	8.00
RC4128.0	–	8.00	0.3150	110.0	148.0	98.00	36.0	8.00
RC4128.1	–	8.10	0.3190	138.0	180.0	123.00	40.0	10.00
RC4128.2	–	8.20	0.3230	138.0	180.0	123.00	40.0	10.00
RC4128.3	–	8.30	0.3270	138.0	180.0	123.00	40.0	10.00
RC4128.4	–	8.40	0.3310	138.0	180.0	123.00	40.0	10.00
RC4128.5	–	8.50	0.3350	138.0	180.0	123.00	40.0	10.00
RC4128.6	–	8.60	0.3390	138.0	180.0	123.00	40.0	10.00
RC4128.7	–	8.70	0.3430	138.0	180.0	123.00	40.0	10.00
RC41211/32	11/32	8.73	0.3440	138.0	180.0	123.00	40.0	10.00
RC4128.8	–	8.80	0.3460	138.0	180.0	123.00	40.0	10.00
RC4129.0	–	9.00	0.3540	138.0	180.0	123.00	40.0	10.00
RC41223/64	23/64	9.13	0.3590	138.0	180.0	123.00	40.0	10.00
RC4129.2	–	9.20	0.3620	138.0	180.0	123.00	40.0	10.00
RC4129.3	–	9.30	0.3660	138.0	180.0	123.00	40.0	10.00
RC4129.5	–	9.50	0.3740	138.0	180.0	123.00	40.0	10.00
RC4123/8	3/8	9.53	0.3750	138.0	180.0	123.00	40.0	10.00
RC4129.6	–	9.60	0.3780	138.0	180.0	123.00	40.0	10.00
RC4129.7	–	9.70	0.3820	138.0	180.0	123.00	40.0	10.00
RC4129.8	–	9.80	0.3860	138.0	180.0	123.00	40.0	10.00
RC41225/64	25/64	9.92	0.3910	138.0	180.0	123.00	40.0	10.00
RC41210.0	–	10.00	0.3940	138.0	180.0	123.00	40.0	10.00
RC41210.1	–	10.10	0.3980	158.0	206.0	140.00	45.0	12.00
RC41210.2	–	10.20	0.4020	158.0	206.0	140.00	45.0	12.00
RC41210.3	–	10.30	0.4060	158.0	206.0	140.00	45.0	12.00
RC41213/32	13/32	10.32	0.4060	158.0	206.0	140.00	45.0	12.00

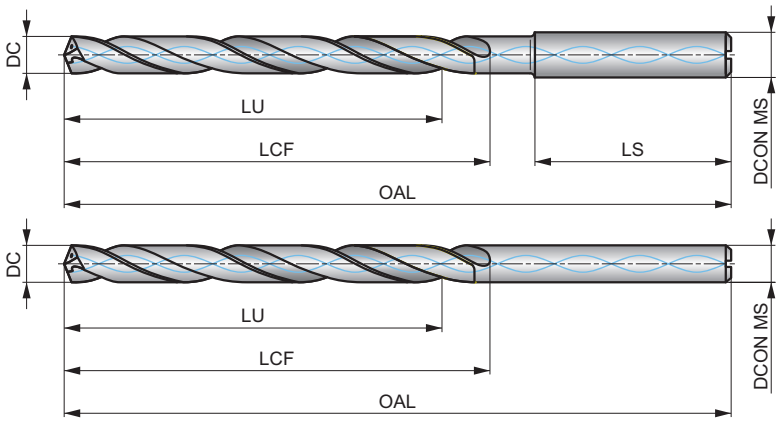
	DC	DC	DC	LCF	OAL	LU	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)	(mm)
RC41210.4	–	10.40	0.4090	158.0	206.0	140.00	45.0	12.00
RC41210.5	–	10.50	0.4130	158.0	206.0	140.00	45.0	12.00
RC41227/64	27/64	10.72	0.4220	158.0	206.0	140.00	45.0	12.00
RC41210.8	–	10.80	0.4250	158.0	206.0	140.00	45.0	12.00
RC41211.0	–	11.00	0.4330	158.0	206.0	140.00	45.0	12.00
RC41211.1	–	11.10	0.4370	158.0	206.0	140.00	45.0	12.00
RC4127/16	7/16	11.11	0.4380	158.0	206.0	140.00	45.0	12.00
RC41211.2	–	11.20	0.4410	158.0	206.0	140.00	45.0	12.00
RC41211.5	–	11.50	0.4530	158.0	206.0	140.00	45.0	12.00
RC41229/64	29/64	11.51	0.4530	158.0	206.0	140.00	45.0	12.00
RC41211.7	–	11.70	0.4610	158.0	206.0	140.00	45.0	12.00
RC41211.8	–	11.80	0.4650	158.0	206.0	140.00	45.0	12.00
RC41215/32	15/32	11.91	0.4690	158.0	206.0	140.00	45.0	12.00
RC41212.0	–	12.00	0.4720	158.0	206.0	140.00	45.0	12.00
RC41212.1	–	12.10	0.4760	182.0	230.0	168.00	45.0	14.00
RC41212.2	–	12.20	0.4800	182.0	230.0	168.00	45.0	14.00
RC41212.3	–	12.30	0.4840	182.0	230.0	168.00	45.0	14.00
RC41231/64	31/64	12.30	0.4840	182.0	230.0	168.00	45.0	14.00
RC41212.5	–	12.50	0.4920	182.0	230.0	168.00	45.0	14.00
RC41212.6	–	12.60	0.4960	182.0	230.0	168.00	45.0	14.00
RC41212.7	–	12.70	0.5000	182.0	230.0	168.00	45.0	14.00
RC41213.0	–	13.00	0.5120	182.0	230.0	168.00	45.0	14.00
RC41217/32	17/32	13.49	0.5310	182.0	230.0	168.00	45.0	14.00
RC41213.5	–	13.50	0.5310	182.0	230.0	168.00	45.0	14.00
RC41214.0	–	14.00	0.5510	182.0	230.0	168.00	45.0	14.00
RC4129/16	9/16	14.29	0.5630	208.0	260.0	192.00	48.0	16.00
RC41214.5	–	14.50	0.5710	208.0	260.0	192.00	48.0	16.00
RC41215.0	–	15.00	0.5910	208.0	260.0	192.00	48.0	16.00
RC41215.5	–	15.50	0.6100	208.0	260.0	192.00	48.0	16.00
RC4125/8	5/8	15.88	0.6250	208.0	260.0	192.00	48.0	16.00
RC41216.0	–	16.00	0.6300	208.0	260.0	192.00	48.0	16.00
RC41216.5	–	16.50	0.6500	234.0	285.0	216.00	48.0	18.00
RC41217.0	–	17.00	0.6690	234.0	285.0	216.00	48.0	18.00
RC41217.5	–	17.50	0.6890	234.0	285.0	216.00	48.0	18.00
RC41218.0	–	18.00	0.7090	234.0	285.0	216.00	48.0	18.00
RC41218.5	–	18.50	0.7280	258.0	310.0	238.00	50.0	20.00
RC41219.0	–	19.00	0.7480	258.0	310.0	238.00	50.0	20.00
RC41219.5	–	19.50	0.7680	258.0	310.0	238.00	50.0	20.00
RC41220.0	–	20.00	0.7870	258.0	310.0	238.00	50.0	20.00

RC416

DORMER PRAMET

FORCE 16XD 深孔整体硬质合金钻头，带冷却液进给装置，纳米刀尖涂层

高性能深孔钻，钻尖角度为 140°，腹板设计更薄，钻孔深度可达 16xD，且无啄孔现象。设计用于快速穿透和精确制导，确保出色的定位精度。内部冷却液可增强排屑能力，纳米刀尖多层涂层具有卓越的热稳定性和耐磨性，可延长刀具寿命。



HM	DIN 6535	16×D
140°	Nano-Tip	DIN 6535HA
R	DC h7	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页39开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■110 H	■112 H	■115 H	■108 H	■100 H	■95 G	■108 H	■80 G	■45 E	■72 G	■80 G	■30 E	■95 H	■90 H
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
◪45 F	◪42 F	◪40 F	◪39 D	◪38 D	◪35 D	◪30 C	◪35 D	■105 J	■100 J	■90 J	■107 J	■101 J	■95 J
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■108 J	■98 J	■80 J	■90 J	■72 L	■62 V	■60 V	■55 V	■90 J	■80 J	■75 J	◪210 L	■198 L	■190 L
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
■190 L	■185 L	■140 L	■120 G	■140 H	■130 F	■35 D	■30 B	◪25 B	◪30 C	◪22 A	◪25 B	◪10 B	◪25 B
S4.2													
◪10 B													

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LU (mm)	LS (mm)	DCON MS (mm)
RC4163.0	–	3.00	0.1180	57.0	89.0	52.00	28.0	4.00
RC4161/8	1/8	3.17	0.1250	66.0	98.0	60.00	28.0	4.00
RC4163.5	–	3.50	0.1380	78.0	110.0	72.00	28.0	4.00
RC4169/64	9/64	3.57	0.1410	78.0	110.0	72.00	28.0	4.00
RC4165/32	5/32	3.97	0.1560	78.0	110.0	72.00	28.0	4.00
RC4164.0	–	4.00	0.1570	78.0	110.0	72.00	28.0	4.00
RC4164.5	–	4.50	0.1770	100.0	132.0	93.00	28.0	5.00
RC4163/16	3/16	4.76	0.1880	100.0	132.0	92.00	28.0	5.00
RC4164.8	–	4.80	0.1890	100.0	132.0	92.00	28.0	5.00
RC4165.0	–	5.00	0.1970	100.0	132.0	92.00	28.0	5.00
RC4165.5	–	5.50	0.2170	110.0	150.0	101.00	36.0	6.00
RC4167/32	7/32	5.56	0.2190	120.0	160.0	111.00	36.0	6.00
RC4165.8	–	5.80	0.2280	120.0	160.0	111.00	36.0	6.00
RC4166.0	–	6.00	0.2360	120.0	160.0	111.00	36.0	6.00
RC4166.1	–	6.10	0.2400	135.0	175.0	124.00	36.0	8.00
RC4161/4	1/4	6.35	0.2500	135.0	175.0	124.00	36.0	8.00
RC4166.5	–	6.50	0.2560	135.0	175.0	124.00	36.0	8.00
RC41617/64	17/64	6.75	0.2660	135.0	175.0	124.00	36.0	8.00
RC4166.8	–	6.80	0.2680	135.0	175.0	124.00	36.0	8.00
RC4167.0	–	7.00	0.2760	135.0	175.0	124.00	36.0	8.00
RC4169/32	9/32	7.14	0.2810	152.0	192.0	140.00	36.0	8.00
RC4167.4	–	7.40	0.2910	152.0	192.0	140.00	36.0	8.00
RC4167.5	–	7.50	0.2950	152.0	192.0	140.00	36.0	8.00

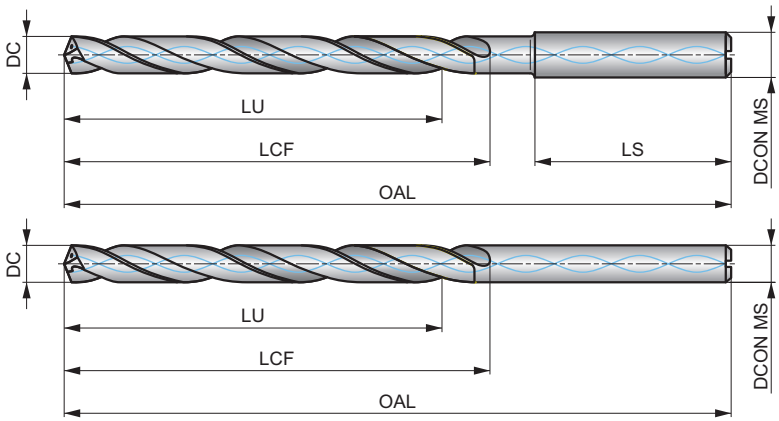
产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LU (mm)	LS (mm)	DCON MS (mm)
RC4165/16	5/16	7.94	0.3130	152.0	192.0	140.00	36.0	8.00
RC4168.0	–	8.00	0.3150	152.0	192.0	140.00	36.0	8.00
RC4168.3	–	8.30	0.3270	162.0	206.0	148.00	40.0	10.00
RC4168.5	–	8.50	0.3350	162.0	206.0	148.00	40.0	10.00
RC41611/32	11/32	8.73	0.3440	162.0	206.0	148.00	40.0	10.00
RC4169.0	–	9.00	0.3540	162.0	206.0	148.00	40.0	10.00
RC4163/8	3/8	9.53	0.3750	180.0	224.0	165.00	40.0	10.00
RC4169.8	–	9.80	0.3860	180.0	224.0	165.00	40.0	10.00
RC41610.0	–	10.00	0.3940	180.0	224.0	165.00	40.0	10.00
RC41610.2	–	10.20	0.4020	198.0	247.0	181.00	45.0	12.00
RC41613/32	13/32	10.32	0.4060	198.0	247.0	181.00	45.0	12.00
RC41611.0	–	11.00	0.4330	198.0	247.0	181.00	45.0	12.00
RC4167/16	7/16	11.11	0.4380	216.0	265.0	198.00	45.0	12.00
RC41611.5	–	11.50	0.4530	216.0	265.0	198.00	45.0	12.00
RC41611.8	–	11.80	0.4650	216.0	265.0	198.00	45.0	12.00
RC41615/32	15/32	11.91	0.4690	216.0	265.0	198.00	45.0	12.00
RC41612.0	–	12.00	0.4720	216.0	265.0	198.00	45.0	12.00
RC41612.7	–	12.70	0.5000	252.0	301.0	238.00	45.0	14.00
RC41613.0	–	13.00	0.5120	252.0	301.0	238.00	45.0	14.00
RC41614.0	–	14.00	0.5510	252.0	301.0	238.00	45.0	14.00
RC4169/16	9/16	14.29	0.5630	288.0	340.0	272.00	48.0	16.00
RC41615.0	–	15.00	0.5910	288.0	340.0	272.00	48.0	16.00
RC41616.0	–	16.00	0.6300	288.0	340.0	272.00	48.0	16.00

RC420

DORMER PRAMET

FORCE 20XD 深孔整体硬质合金钻头，带冷却液进给装置，纳米刀尖涂层

高性能深孔钻，钻尖角度为 140°，腹板设计更薄，钻孔深度可达 20xD，且不会产生啄孔现象。设计用于快速穿透和精确制导，确保出色的定位精度。内部冷却液可增强排屑能力，纳米刀尖多层涂层具有卓越的热稳定性和耐磨性，可延长刀具寿命。



HM	DIN 6535	20×D
140°	Nano-Tip	DIN 6535HA
R	DC h7	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页39开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■105 H	■106 H	■109 H	■103 G	■95 G	■90 F	■103 G	■76 F	■43 E	■68 F	■76 F	■29 E	■90 G	■86 G
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
◪43 E	◪40 E	◪38 E	◪37 C	◪36 C	◪33 C	◪29 B	◪33 D	■100 J	■95 J	■86 J	■102 J	■96 H	■90 H
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■103 H	■93 H	■76 H	■86 J	■68 J	■59 V	■57 V	■52 V	■86 J	■76 J	■71 J	◪200 L	■188 L	■181 L
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
■181 L	■176 L	■133 J	■114 G	■133 G	■124 E	■33 D	■29 B	◪24 B	◪29 B	◪21 A	◪24 B	◪10 A	◪24 B
S4.2													
◪10 A													

DCON MS公差h6

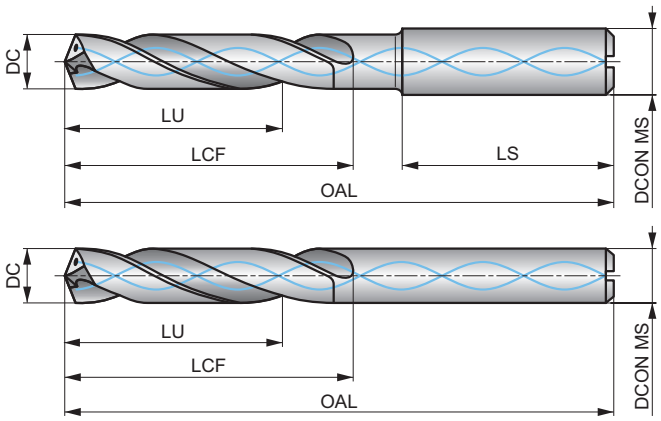
产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LU (mm)	LS (mm)	DCON MS (mm)
RC4203.0	–	3.00	0.1180	65.0	97.0	60.00	28.0	4.00
RC4201/8	1/8	3.17	0.1250	80.0	112.0	74.00	28.0	4.00
RC4203.5	–	3.50	0.1380	92.0	124.0	86.00	28.0	4.00
RC4209/64	9/64	3.57	0.1410	92.0	124.0	86.00	28.0	4.00
RC4205/32	5/32	3.97	0.1560	92.0	124.0	86.00	28.0	4.00
RC4204.0	–	4.00	0.1570	92.0	124.0	86.00	28.0	4.00
RC4204.5	–	4.50	0.1770	118.0	150.0	111.00	28.0	5.00
RC4203/16	3/16	4.76	0.1880	118.0	150.0	110.00	28.0	5.00
RC4204.8	–	4.80	0.1890	118.0	150.0	110.00	28.0	5.00
RC4205.0	–	5.00	0.1970	118.0	150.0	110.00	28.0	5.00
RC4205.5	–	5.50	0.2170	132.0	170.0	123.00	36.0	6.00
RC4207/32	7/32	5.56	0.2190	144.0	182.0	135.00	36.0	6.00
RC4205.8	–	5.80	0.2280	144.0	182.0	135.00	36.0	6.00
RC4206.0	–	6.00	0.2360	144.0	182.0	135.00	36.0	6.00
RC4206.1	–	6.10	0.2400	162.0	200.0	151.00	36.0	8.00
RC4201/4	1/4	6.35	0.2500	162.0	200.0	151.00	36.0	8.00
RC4206.5	–	6.50	0.2560	162.0	200.0	151.00	36.0	8.00
RC42017/64	17/64	6.75	0.2660	162.0	200.0	151.00	36.0	8.00
RC4206.8	–	6.80	0.2680	162.0	200.0	151.00	36.0	8.00
RC4207.0	–	7.00	0.2760	162.0	200.0	151.00	36.0	8.00
RC4209/32	9/32	7.14	0.2810	184.0	222.0	172.00	36.0	8.00
RC4207.4	–	7.40	0.2910	184.0	222.0	172.00	36.0	8.00
RC4207.5	–	7.50	0.2950	184.0	222.0	172.00	36.0	8.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LU (mm)	LS (mm)	DCON MS (mm)
RC4205/16	5/16	7.94	0.3130	184.0	222.0	172.00	36.0	8.00
RC4208.0	–	8.00	0.3150	184.0	222.0	172.00	36.0	8.00
RC4208.3	–	8.30	0.3270	198.0	240.0	184.00	40.0	10.00
RC4208.5	–	8.50	0.3350	198.0	240.0	184.00	40.0	10.00
RC42011/32	11/32	8.73	0.3440	198.0	240.0	184.00	40.0	10.00
RC4209.0	–	9.00	0.3540	198.0	240.0	184.00	40.0	10.00
RC4203/8	3/8	9.53	0.3750	220.0	262.0	205.00	40.0	10.00
RC4209.8	–	9.80	0.3860	220.0	262.0	205.00	40.0	10.00
RC42010.0	–	10.00	0.3940	220.0	262.0	205.00	40.0	10.00
RC42010.2	–	10.20	0.4020	242.0	289.0	225.00	45.0	12.00
RC42013/32	13/32	10.32	0.4060	242.0	289.0	225.00	45.0	12.00
RC42011.0	–	11.00	0.4330	242.0	289.0	225.00	45.0	12.00
RC4207/16	7/16	11.11	0.4380	264.0	311.0	246.00	45.0	12.00
RC42011.5	–	11.50	0.4530	264.0	311.0	246.00	45.0	12.00
RC42011.8	–	11.80	0.4650	264.0	311.0	246.00	45.0	12.00
RC42015/32	15/32	11.91	0.4690	264.0	311.0	246.00	45.0	12.00
RC42012.0	–	12.00	0.4720	264.0	311.0	246.00	45.0	12.00
RC42012.7	–	12.70	0.5000	308.0	357.0	294.00	45.0	14.00
RC42013.0	–	13.00	0.5120	308.0	357.0	294.00	45.0	14.00
RC42014.0	–	14.00	0.5510	308.0	357.0	294.00	45.0	14.00
RC4209/16	9/16	14.29	0.5630	352.0	404.0	336.00	48.0	16.00
RC42015.0	–	15.00	0.5910	352.0	404.0	336.00	48.0	16.00
RC42016.0	–	16.00	0.6300	352.0	404.0	336.00	48.0	16.00

RC4P

FORCE Pilot 整体硬质合金钻头 2xD，带冷却液进给，多层 TiAlN 涂层

专门设计的导向钻，用于在使用 Force 深孔钻 16xD 和 20xD 时进行精确的孔定位。钻尖角度为 150°，钻孔公差 p7 稍大，可精确钻出 2xD 以下的导向孔。高质量整体硬质合金基体和内部冷却通道提高了冷却效率。TiAlN多层涂层可最大限度地减少摩擦。



HM	DIN 6535	2×D
150°	Multi TiAlN	DIN 6535HA
R	DC p7	

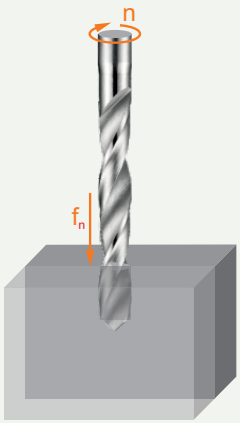
工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页39开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 110 I	■ 112 I	■ 108 I	■ 115 G	■ 100 H	■ 90 H	■ 85 H	■ 80 H	■ 70 F	■ 80 G	■ 63 G	■ 50 E	■ 79 H	■ 75 H
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
◪ 65 F	◪ 60 F	◪ 58 F	◪ 42 D	◪ 40 D	◪ 38 D	◪ 40 C	◪ 35 D	■ 121 L	■ 120 L	■ 110 J	■ 120 L	■ 110 J	■ 100 J
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■ 80 L	■ 70 J	■ 68 J	■ 100 L	■ 80 L	■ 70 V	■ 60 V	■ 50 V	■ 80 J	■ 75 J	■ 70 J	◪ 302 J	■ 300 J	■ 290 J
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
■ 250 J	■ 220 L	■ 200 J	■ 160 G	■ 120 H	■ 110 F	■ 45 D	■ 32 B	◪ 28 B	◪ 32 B	◪ 30 B	◪ 30 C	◪ 11 B	◪ 30 C
S4.2													
◪ 11 B													

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LU (mm)	LS (mm)	DCON MS (mm)
RC4P3.0	–	3.00	0.1180	20.0	66.0	14.00	36.0	6.00
RC4P1/8	1/8	3.17	0.1250	20.0	66.0	14.00	36.0	6.00
RC4P3.5	–	3.50	0.1380	20.0	66.0	14.00	36.0	6.00
RC4P9/64	9/64	3.57	0.1410	20.0	66.0	14.00	36.0	6.00
RC4P5/32	5/32	3.97	0.1560	24.0	74.0	16.00	36.0	6.00
RC4P4.0	–	4.00	0.1570	24.0	74.0	16.00	36.0	6.00
RC4P4.5	–	4.50	0.1770	24.0	74.0	16.00	36.0	6.00
RC4P3/16	3/16	4.76	0.1880	28.0	82.0	19.00	36.0	6.00
RC4P4.8	–	4.80	0.1890	28.0	82.0	19.00	36.0	6.00
RC4P5.0	–	5.00	0.1970	28.0	82.0	19.00	36.0	6.00
RC4P5.5	–	5.50	0.2170	28.0	82.0	19.00	36.0	6.00
RC4P7/32	7/32	5.56	0.2190	28.0	82.0	19.00	36.0	6.00
RC4P5.8	–	5.80	0.2280	28.0	82.0	19.00	36.0	6.00
RC4P6.0	–	6.00	0.2360	28.0	82.0	19.00	36.0	6.00
RC4P6.1	–	6.10	0.2400	34.0	91.0	23.00	36.0	8.00
RC4P1/4	1/4	6.35	0.2500	34.0	91.0	23.00	36.0	8.00
RC4P6.5	–	6.50	0.2560	34.0	91.0	23.00	36.0	8.00
RC4P6.8	–	6.80	0.2680	34.0	91.0	23.00	36.0	8.00
RC4P7.0	–	7.00	0.2760	34.0	91.0	23.00	36.0	8.00
RC4P9/32	9/32	7.14	0.2810	41.0	91.0	29.00	36.0	8.00
RC4P7.4	–	7.40	0.2910	41.0	91.0	29.00	36.0	8.00
RC4P7.5	–	7.50	0.2950	41.0	91.0	29.00	36.0	8.00
RC4P5/16	5/16	7.94	0.3130	41.0	91.0	29.00	36.0	8.00

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LU (mm)	LS (mm)	DCON MS (mm)
RC4P8.0	–	8.00	0.3150	41.0	91.0	29.00	36.0	8.00
RC4P8.3	–	8.30	0.3270	47.0	103.0	32.00	40.0	10.00
RC4P8.5	–	8.50	0.3350	47.0	103.0	32.00	40.0	10.00
RC4P11/32	11/32	8.73	0.3440	47.0	103.0	32.00	40.0	10.00
RC4P9.0	–	9.00	0.3540	47.0	103.0	32.00	40.0	10.00
RC4P3/8	3/8	9.53	0.3750	47.0	103.0	32.00	40.0	10.00
RC4P9.8	–	9.80	0.3860	47.0	103.0	32.00	40.0	10.00
RC4P10.0	–	10.00	0.3940	47.0	103.0	32.00	40.0	10.00
RC4P10.2	–	10.20	0.4020	55.0	118.0	37.00	45.0	12.00
RC4P13/32	13/32	10.32	0.4060	55.0	118.0	37.00	45.0	12.00
RC4P11.0	–	11.00	0.4330	55.0	118.0	37.00	45.0	12.00
RC4P7/16	7/16	11.11	0.4380	55.0	118.0	37.00	45.0	12.00
RC4P11.5	–	11.50	0.4530	55.0	118.0	37.00	45.0	12.00
RC4P11.8	–	11.80	0.4650	55.0	118.0	37.00	45.0	12.00
RC4P15/32	15/32	11.91	0.4690	55.0	118.0	37.00	45.0	12.00
RC4P12.0	–	12.00	0.4720	55.0	118.0	37.00	45.0	12.00
RC4P1/2	1/2	12.70	0.5000	60.0	124.0	46.00	45.0	14.00
RC4P13.0	–	13.00	0.5120	60.0	124.0	46.00	45.0	14.00
RC4P14.0	–	14.00	0.5510	60.0	124.0	46.00	45.0	14.00
RC4P9/16	9/16	14.29	0.5630	65.0	133.0	49.00	48.0	16.00
RC4P15.0	–	15.00	0.5910	65.0	133.0	49.00	48.0	16.00
RC4P16.0	–	16.00	0.6300	65.0	133.0	49.00	48.0	16.00



每转进给量f_n(毫米/转) 。
根据工况, 可能需要将这些值调整为 ± 25% 。

如何使用此表格查找每转进给量f_n:

1. 在产品页找到您的字母代码 (例如: 46J、“**J**” 是字母代码) 。
2. 在表格第一行找到与您切削应用最接近的直径。
3. 在表格左列找到您的字母代码。
4. 直径和字母代码的交点 (单元格) 是每转进给量f_n。

每转进给量 (毫米/转)	ø DC (毫米)																		
	0.15	0.5	1.0	2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0	16.0	20.0	25.0	30.0	40.0	50.0	100
A	0.003	0.006	0.012	0.023	0.029	0.032	0.036	0.042	0.054	0.062	0.069	0.082	0.086	0.110	0.125	0.135	0.155	0.175	0.263
B	0.004	0.007	0.014	0.028	0.037	0.041	0.046	0.053	0.067	0.080	0.090	0.103	0.108	0.135	0.153	0.165	0.188	0.208	0.312
C	0.004	0.008	0.015	0.032	0.044	0.050	0.056	0.064	0.080	0.098	0.110	0.125	0.130	0.160	0.180	0.195	0.220	0.240	0.360
D	0.004	0.008	0.016	0.038	0.053	0.060	0.068	0.078	0.098	0.119	0.130	0.149	0.155	0.188	0.210	0.228	0.253	0.275	0.413
E	0.004	0.009	0.017	0.043	0.062	0.071	0.080	0.092	0.115	0.140	0.150	0.173	0.180	0.215	0.240	0.260	0.285	0.310	0.465
F	0.005	0.009	0.018	0.050	0.073	0.084	0.095	0.109	0.138	0.165	0.178	0.202	0.210	0.248	0.275	0.295	0.320	0.343	0.515
G	0.005	0.010	0.019	0.056	0.084	0.096	0.109	0.126	0.160	0.190	0.205	0.231	0.240	0.280	0.310	0.330	0.355	0.375	0.563
H	0.005	0.010	0.020	0.066	0.102	0.116	0.130	0.150	0.190	0.228	0.243	0.271	0.280	0.320	0.355	0.375	0.398	0.418	0.627
I	0.005	0.011	0.021	0.076	0.119	0.134	0.150	0.173	0.220	0.265	0.280	0.310	0.320	0.360	0.400	0.420	0.440	0.460	0.690
J	0.006	0.012	0.024	0.084	0.135	0.152	0.170	0.197	0.250	0.298	0.315	0.349	0.360	0.405	0.445	0.465	0.485	0.503	0.755
K	0.007	0.013	0.026	0.092	0.150	0.170	0.190	0.220	0.280	0.330	0.350	0.388	0.400	0.450	0.490	0.510	0.530	0.545	0.818
L	0.007	0.014	0.028	0.101	0.165	0.186	0.208	0.240	0.305	0.360	0.385	0.419	0.430	0.485	0.525	0.545	0.568	0.588	0.882
M	0.008	0.015	0.030	0.110	0.180	0.202	0.225	0.260	0.330	0.390	0.420	0.450	0.460	0.520	0.560	0.580	0.605	0.630	0.945
N	0.008	0.016	0.032	0.119	0.195	0.218	0.242	0.280	0.355	0.420	0.455	0.481	0.490	0.555	0.595	0.615	0.642	0.672	1.008
S	0.002	0.004	0.008	0.014	0.020	0.025	0.030	0.037	0.050	0.080	0.100	0.123	0.130	0.150	0.170	0.190	0.220	0.240	–
T	0.004	0.008	0.015	0.028	0.040	0.050	0.060	0.070	0.090	0.110	0.130	0.160	0.170	0.190	0.210	0.230	0.260	0.275	–
U	0.007	0.013	0.026	0.048	0.070	0.080	0.090	0.107	0.140	0.170	0.200	0.223	0.230	0.240	0.270	0.300	0.360	0.375	–
V	0.010	0.019	0.038	0.069	0.100	0.115	0.130	0.153	0.200	0.250	0.280	0.310	0.320	0.340	0.400	0.440	0.510	0.530	–
W	0.012	0.025	0.049	0.089	0.130	0.150	0.170	0.200	0.260	0.330	0.380	0.418	0.430	0.450	0.470	0.490	0.520	0.540	–
X	0.014	0.028	0.056	0.103	0.150	0.180	0.210	0.250	0.330	0.420	0.480	0.533	0.550	0.580	–	–	–	–	–
Y	0.017	0.034	0.068	0.124	0.180	0.220	0.260	0.317	0.430	0.550	0.700	0.700	0.700	0.740	–	–	–	–	–
Z	0.024	0.047	0.094	0.172	0.250	0.325	0.400	0.533	0.800	1.000	1.100	1.175	1.200	1.200	–	–	–	–	–

整体硬质合金多材料微型钻头

提高小直径应用的工艺可靠性

新型 Force Micro 钻头性能卓越，适用于直径为 0.7 至 2.95 毫米的微型应用。

这些钻头专为实现最高精度和最长刀具寿命而设计，在转速超过 15.000 RPM 时也能平稳运行，具有 140° 的尖角、先进的涂层和优化的刃口设计，可在多种材料上可靠地排出切屑。

相关产品

RC305

5xD

0.7 – 2.95 毫米

AlCrN涂层,**冷却剂进给**

特点和优点

微小直径从 0.7 毫米到 2.95 毫米，具有穿透冷却能力。	**超高精度** 在微型应用中具有卓越的工具性能。
140° 的尖角和精细的切削刃。	**出色的孔质量** 表面光滑。
内部冷却和优化的刃口几何形状。	**工艺可靠性高** 有效排屑，结果一致。
先进的 AlCrN 涂层。	**延长工具寿命** 具有出色的耐磨性和热稳定性。
适用于最大 20° 的角度出口。	**多功能钻头** 适用于复杂的钻孔应用。

通过大幅延长 ISO-P 和 ISO-M 钻孔的刀具寿命来提高生产率。

通过与多家竞争对手的广泛测试，证明了其卓越的耐用性。

特点和优点

尾跟设计

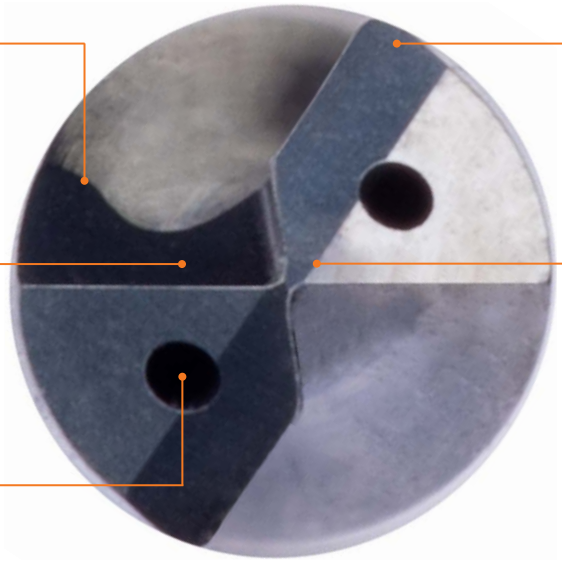
- 帮助卷曲切屑
- 防止崩角

钻芯设计

- 强壮的钻芯设计
- 优化排屑空间

冷却液通道

- 确保切削区冷却
- 加强排屑

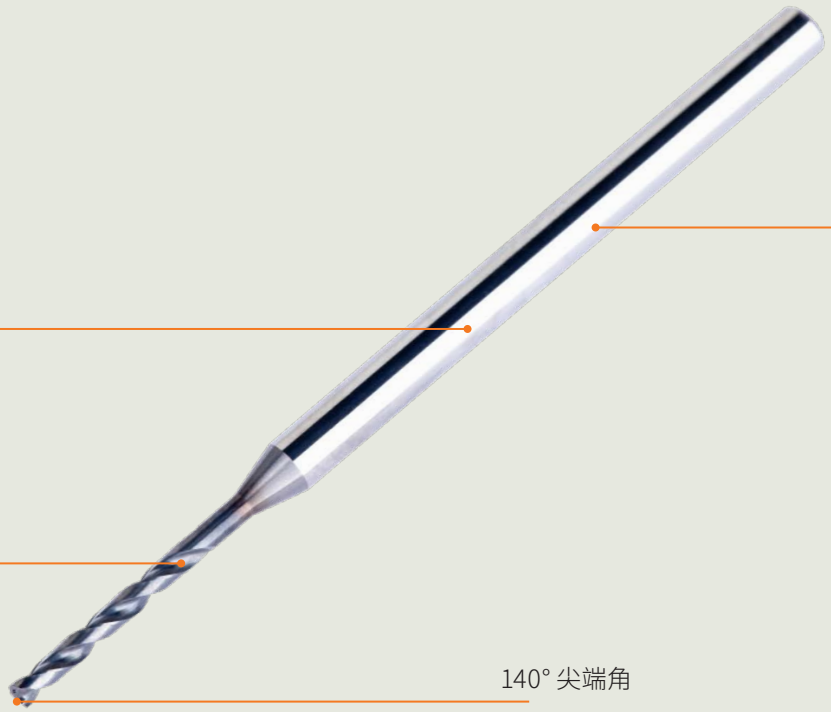


外角设计

- 增强稳定性
- 提高孔的质量

4 平面分离式钻尖

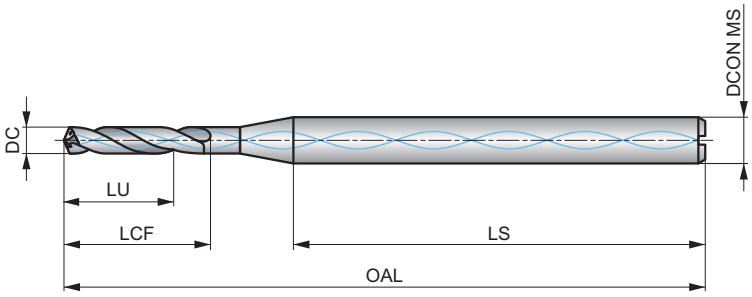
- 良好的定位精度和公差
- 刃口强度更高
- 改善切屑形态
- 更好的切削力分布



RC305

FORCE 5XD 微型整体硬质合金钻头，带冷却液进给装置，带 AlCrN 涂层

高性能微型钻头专为精密应用而设计，钻尖角度为 140°，最大钻孔深度为 5xD。精心加工的切削刃可确保优异的表面质量。内部冷却液增强了排屑能力，而先进的 AlCrN 涂层则提供了出色的耐磨性、热稳定性和工艺可靠性。



HM	DIN 6535	5×D
140°	AlCrN	DIN 6535HA
R	DC m7	

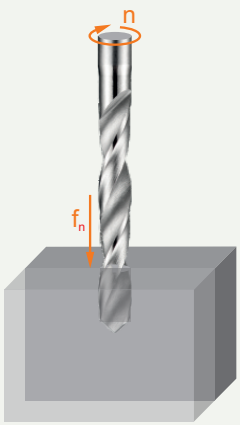
工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页46开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 100 J	■ 105 J	■ 108 J	■ 102 J	■ 82 J	■ 80 J	■ 80 J	■ 63 H	■ 40 E	■ 70 G	■ 63 H	■ 40 E	■ 65 J	■ 63 J
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
■ 60 G	■ 63 G	■ 63 G	■ 40 F	■ 37 F	■ 35 F	■ 25 E	■ 25 E	■ 105 L	■ 100 L	■ 95 L	■ 105 J	■ 65 J	■ 63 J
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■ 65 J	■ 63 J	■ 60 J	■ 80 J	■ 75 J	■ 60 U	■ 58 U	■ 55 U	■ 80 J	■ 70 J	■ 65 J	■ 125 Y	■ 120 Y	■ 119 Y
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
■ 125 Y	■ 120 L	■ 119 L	■ 80 G	■ 75 J	■ 74 E	◪ 40 E	◪ 25 C	◪ 25 C	◪ 32 E	◪ 20 C	◪ 25 D	◪ 16 D	◪ 25 D
S4.2													
◪ 16 D													

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LU (mm)	LS (mm)	DCON MS (mm)
RC3050.7	–	0.70	0.0280	6.0	48.0	4.90	30.0	3.00
RC3050.75	–	0.75	0.0300	7.0	48.0	5.80	30.0	3.00
RC3051/32	1/32	0.79	0.0310	7.0	48.0	5.80	30.0	3.00
RC3050.8	–	0.80	0.0310	7.0	48.0	5.80	30.0	3.00
RC3050.85	–	0.85	0.0330	8.0	50.0	6.60	30.0	3.00
RC3050.9	–	0.90	0.0350	8.0	50.0	6.60	30.0	3.00
RC3050.95	–	0.95	0.0370	9.0	50.0	7.50	30.0	3.00
RC3051.0	–	1.00	0.0390	9.0	50.0	7.50	30.0	3.00
RC3051.05	–	1.05	0.0410	9.0	51.0	7.00	30.0	3.00
RC3051.1	–	1.10	0.0430	9.0	51.0	7.00	30.0	3.00
RC3051.15	–	1.15	0.0450	10.0	51.0	8.00	30.0	3.00
RC3053/64	3/64	1.19	0.0470	10.0	51.0	8.00	30.0	3.00
RC3051.2	–	1.20	0.0470	10.0	51.0	8.00	30.0	3.00
RC3051.25	–	1.25	0.0490	11.0	51.0	9.00	30.0	3.00
RC3051.3	–	1.30	0.0510	11.0	53.0	9.00	30.0	3.00
RC3051.35	–	1.35	0.0530	12.0	53.0	9.00	30.0	3.00
RC3051.4	–	1.40	0.0550	12.0	53.0	9.00	30.0	3.00
RC3051.45	–	1.45	0.0570	13.0	53.0	10.00	30.0	3.00
RC3051.5	–	1.50	0.0590	13.0	53.0	10.00	30.0	3.00
RC3051.55	–	1.55	0.0610	14.0	54.0	11.00	30.0	3.00
RC3051/16	1/16	1.59	0.0630	14.0	54.0	11.00	30.0	3.00
RC3051.6	–	1.60	0.0630	14.0	54.0	11.00	30.0	3.00
RC3051.65	–	1.65	0.0650	14.0	54.0	11.00	30.0	3.00

产品	DC	DC	DC	LCF	OAL	LU	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)	(mm)
RC3051.7	–	1.70	0.0670	14.0	54.0	11.00	30.0	3.00
RC3051.75	–	1.75	0.0690	15.0	54.0	12.00	30.0	3.00
RC3051.8	–	1.80	0.0710	15.0	54.0	12.00	30.0	3.00
RC3051.85	–	1.85	0.0730	16.0	57.0	13.00	30.0	3.00
RC3051.9	–	1.90	0.0750	16.0	57.0	13.00	30.0	3.00
RC3051.95	–	1.95	0.0770	17.0	57.0	14.00	30.0	3.00
RC3055/64	5/64	1.98	0.0780	17.0	57.0	14.00	30.0	3.00
RC3052.0	–	2.00	0.0790	17.0	57.0	14.00	30.0	3.00
RC3052.05	–	2.05	0.0810	18.0	57.0	14.00	30.0	3.00
RC3052.1	–	2.10	0.0830	18.0	57.0	14.00	30.0	3.00
RC3052.15	–	2.15	0.0850	19.0	57.0	15.00	30.0	3.00
RC3052.2	–	2.20	0.0870	19.0	57.0	15.00	30.0	3.00
RC3052.25	–	2.25	0.0890	20.0	59.0	16.00	30.0	3.00
RC3052.3	–	2.30	0.0910	20.0	59.0	16.00	30.0	3.00
RC3052.35	–	2.35	0.0930	20.0	59.0	16.00	30.0	3.00
RC3053/32	3/32	2.38	0.0940	20.0	59.0	16.00	30.0	3.00
RC3052.4	–	2.40	0.0940	20.0	59.0	16.00	30.0	3.00
RC3052.45	–	2.45	0.0960	21.0	59.0	17.00	30.0	3.00
RC3052.5	–	2.50	0.0980	21.0	59.0	17.00	30.0	3.00
RC3052.55	–	2.55	0.1000	22.0	62.0	18.00	30.0	3.00
RC3052.6	–	2.60	0.1020	22.0	62.0	18.00	30.0	3.00
RC3052.65	–	2.65	0.1040	23.0	62.0	18.00	30.0	3.00
RC3052.7	–	2.70	0.1060	23.0	62.0	18.00	30.0	3.00
RC3052.75	–	2.75	0.1080	24.0	62.0	19.00	30.0	3.00
RC3057/64	7/64	2.78	0.1090	24.0	62.0	19.00	30.0	3.00
RC3052.8	–	2.80	0.1100	24.0	62.0	19.00	30.0	3.00
RC3052.85	–	2.85	0.1120	25.0	62.0	20.00	30.0	3.00
RC3052.9	–	2.90	0.1140	25.0	62.0	20.00	30.0	3.00
RC3052.95	–	2.95	0.1160	25.0	62.0	20.00	30.0	3.00



每转进给量f_n(毫米/转)。
根据工况，可能需要将这些值调整为 ± 25%。

如何使用此表格查找每转进给量f_n:

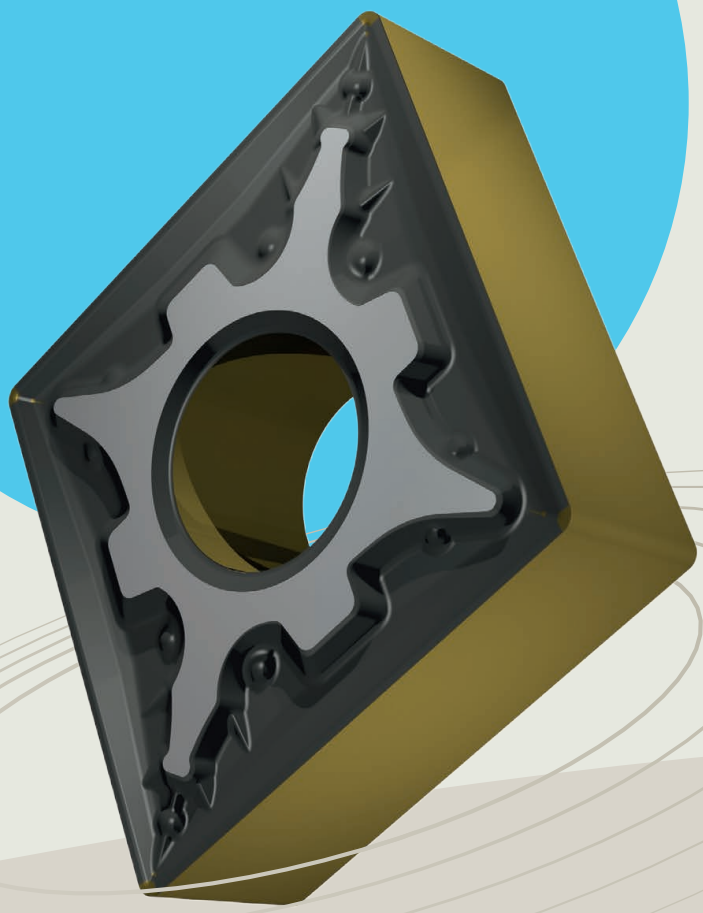
1. 在产品页找到您的字母代码 (例如: 46J、"**J**" 是字母代码)。
2. 在表格第一行找到与您切削应用最接近的直径。
3. 在表格左列找到您的字母代码。
4. 直径和字母代码的交点 (单元格) 是每转进给量f_n。

每转进给量 (毫米/转)	ø DC (毫米)											
	0.70	0.80	0.90	1.00	1.10	1.20	1.30	1.40	1.50	1.60	1.70	1.80
C	0.011	0.012	0.014	0.015	0.017	0.018	0.020	0.022	0.024	0.025	0.027	0.029
D	0.011	0.013	0.014	0.016	0.018	0.020	0.023	0.025	0.027	0.029	0.031	0.034
E	0.012	0.014	0.015	0.017	0.020	0.022	0.025	0.027	0.030	0.033	0.035	0.038
F	0.013	0.014	0.016	0.018	0.021	0.024	0.028	0.031	0.034	0.037	0.040	0.044
G	0.013	0.015	0.017	0.019	0.023	0.026	0.030	0.034	0.038	0.041	0.045	0.049
H	0.014	0.016	0.018	0.020	0.025	0.029	0.034	0.038	0.043	0.048	0.052	0.057
J	0.017	0.019	0.022	0.024	0.030	0.036	0.042	0.048	0.054	0.060	0.066	0.072
L	0.020	0.022	0.025	0.028	0.035	0.043	0.050	0.057	0.065	0.072	0.079	0.086
U	0.018	0.021	0.023	0.026	0.028	0.030	0.033	0.035	0.037	0.039	0.041	0.044
Y	0.048	0.054	0.061	0.068	0.074	0.079	0.085	0.090	0.096	0.102	0.107	0.113
	ø DC (毫米)											
	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	2.95
C	0.030	0.032	0.033	0.034	0.036	0.037	0.038	0.039	0.040	0.042	0.043	0.043
D	0.036	0.038	0.040	0.041	0.042	0.044	0.045	0.047	0.048	0.050	0.051	0.052
E	0.040	0.043	0.045	0.047	0.049	0.051	0.053	0.054	0.056	0.058	0.060	0.061
F	0.047	0.050	0.052	0.055	0.057	0.059	0.062	0.064	0.066	0.068	0.071	0.072
G	0.052	0.056	0.059	0.062	0.064	0.067	0.070	0.073	0.076	0.078	0.081	0.083
H	0.061	0.066	0.070	0.073	0.077	0.080	0.084	0.088	0.091	0.095	0.098	0.100
J	0.078	0.084	0.089	0.094	0.099	0.104	0.110	0.115	0.120	0.125	0.130	0.132
L	0.094	0.101	0.107	0.114	0.120	0.127	0.133	0.139	0.146	0.152	0.159	0.162
U	0.046	0.048	0.050	0.052	0.055	0.057	0.059	0.061	0.063	0.066	0.068	0.069
Y	0.118	0.124	0.130	0.135	0.141	0.146	0.152	0.158	0.163	0.169	0.174	0.177

DORMER PRAMET™

T5405 牌号

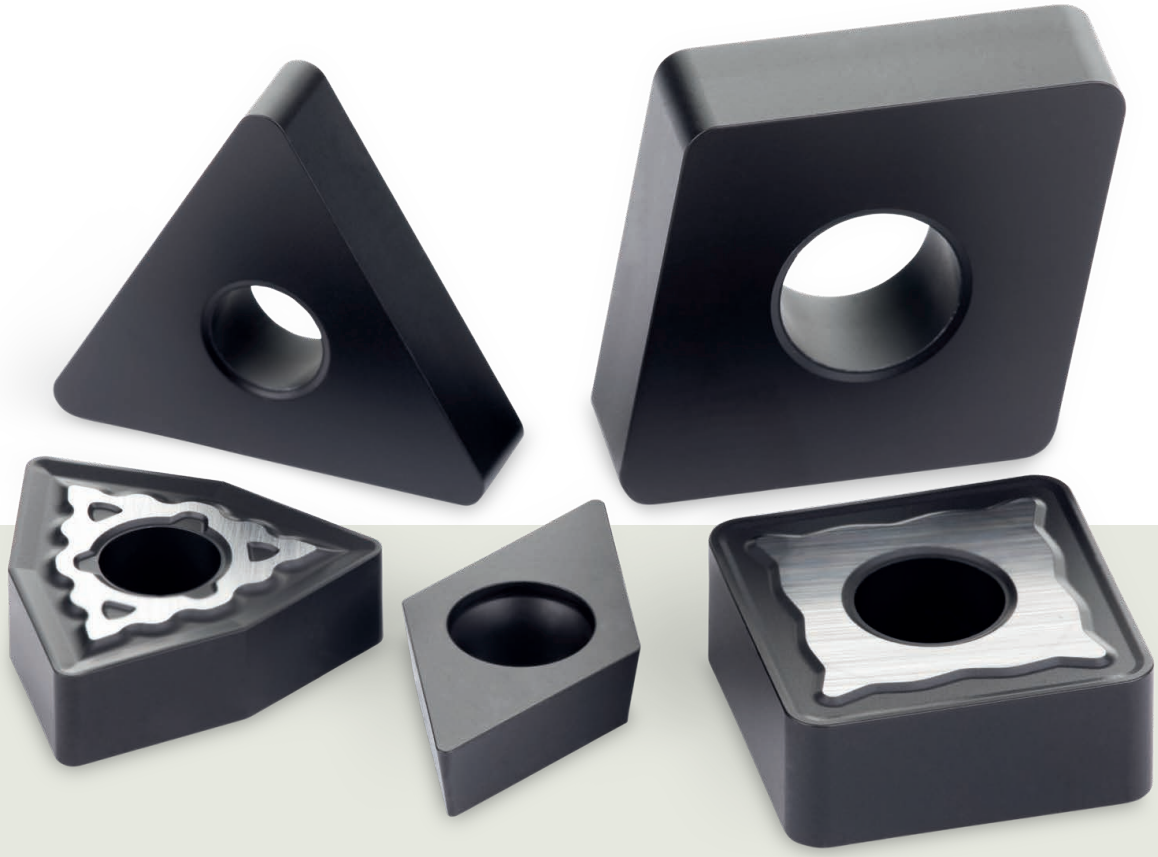
最大限度地提高灰口铸铁的生产率



Certainty
at every turn™

灰铸铁的新 CVD 牌号

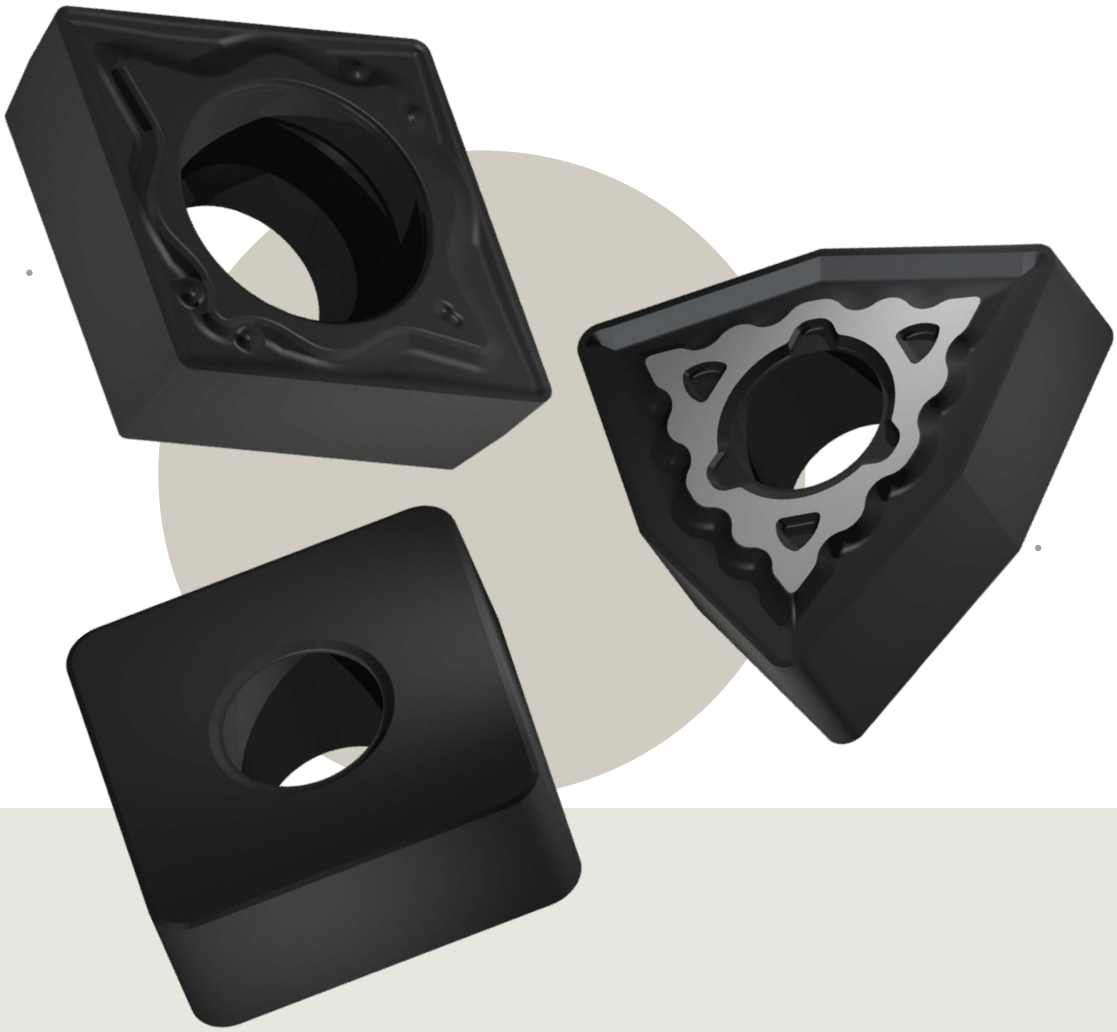
最大限度地提高灰口铸铁的生产率



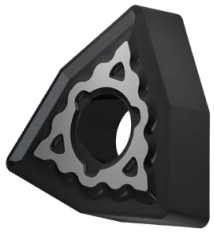
新型 T5405 CVD 车削牌号采用先进的 α-Al_2O_3 涂层技术，在灰铸铁应用中具有出色的刀具寿命。其主要特点和优点包括：在高速切削时性能出众，精密研磨的定位面可提高稳定性，并且更适用于白口铸铁。

T5405 是一种可靠、高效的解决方案，适用于对耐用性和性能要求极高的高生产率加工环境。

相关产品



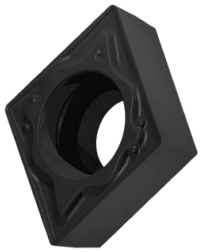
T5405



负角刀片

灰铸铁

T5405



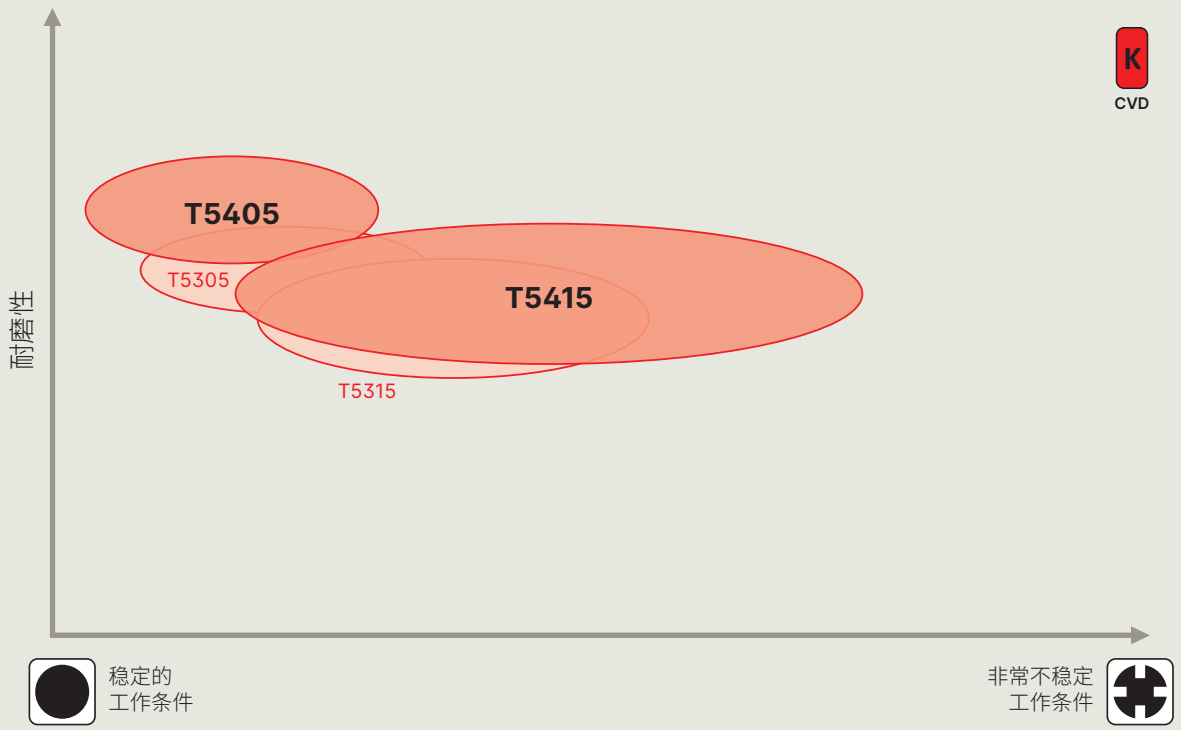
正角刀片

灰铸铁

功能和优点

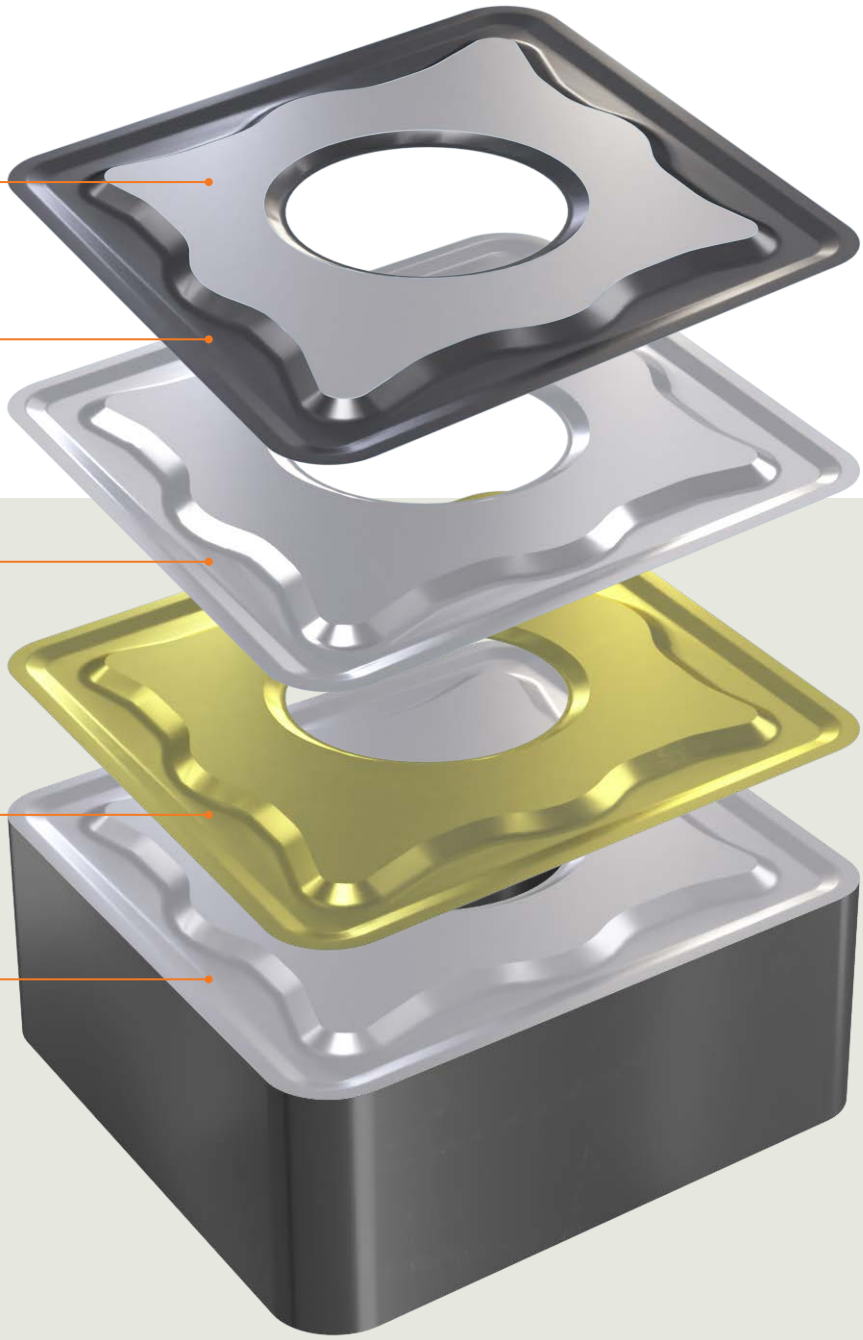
新型 CVD 涂层平台，可增强涂层厚度。	→	**显著延长刀具寿命** 和生产力。
先进的 α-Al_2O_3 涂层具有出色的耐磨性。	→	**性能可靠** 并在稳定的切削条件下延长刀具寿命。
高度纹理化的 αAl_2O_3 涂层具有更高的热稳定性。	→	**提高生产率** 在高速切削时。
磨削的座面提供了更大的接触面积，优化了热传递。	→	**提高安装稳定性** 确保始终如一的高质量性能。

T5405 车削牌号的应用领域



材质构成

厚而纹理清晰的 α-Al_2O_3 涂层，具有最高的耐用性



成功案例

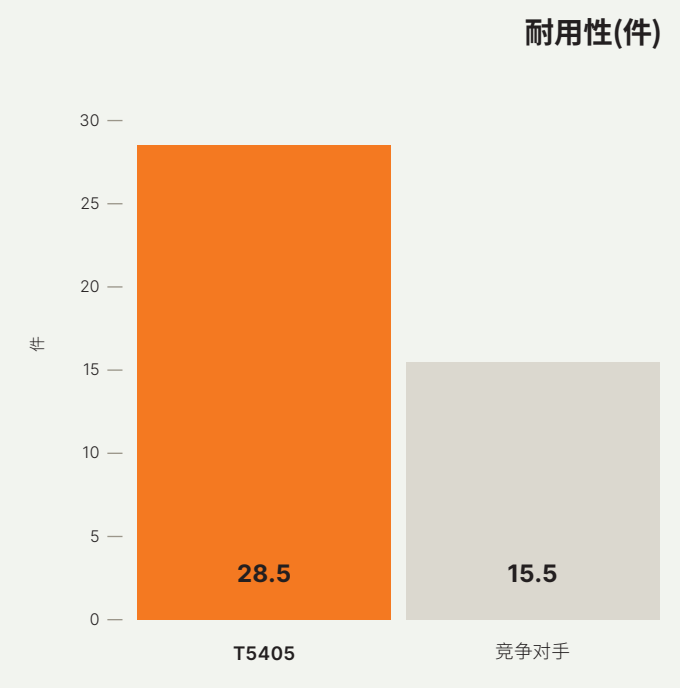
将铸铁加工的耐用性提高 84%

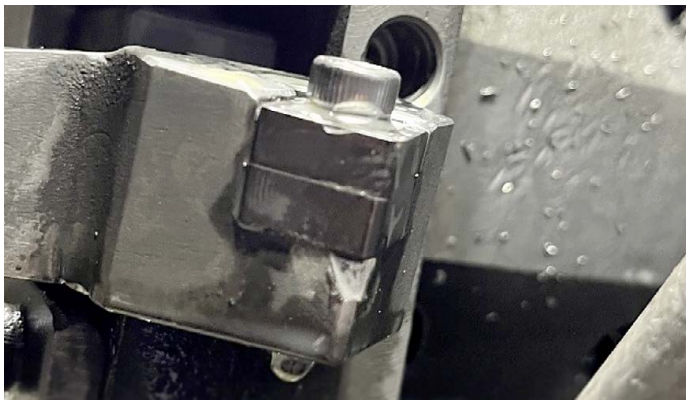
客户结果：T5405 牌号的刀具平均寿命达到 28.5 件，明显优于竞争对手的牌号（15.5 件）。在切削参数为 432 m/min、0.5 mm/rev、4 mm 切深的情况下，T5405 刀具的切削数量达到了 42件，证明了其在高速、高生产率操作中的可靠性。
这些结果证明了 T5405 在加工卡车发动机套筒时的卓越性能和耐用性。

行业	汽车
零件	卡车发动机套筒
应用	车削
材料	EN-GJS-400-15 (GG40)
冷却液	No
Dormer Pramet 解决方案	SNMA 150616S:T5405

加工数据		
v_c	f_n	a_p
432	0.5	4.0

K1.3





v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

成功案例

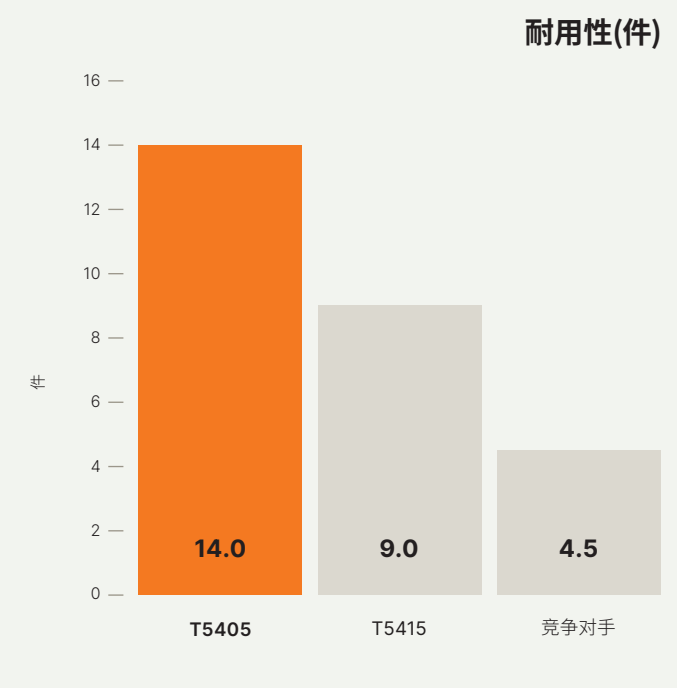
在要求苛刻的操作中，刀具寿命延长 211%

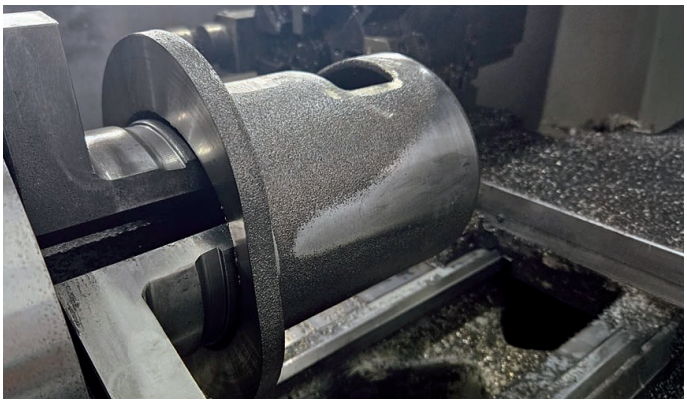
客户成果：T5405 的平均刀具寿命达到 14 件，是竞争对手刀具（4.5 件）的三倍多。在 320 米/分钟、0.22 毫米/转速和 0.8 毫米切深的条件下，T5405 的性能也优于 T5415，刀具寿命延长了 55%。
这证明 T5405 是在苛刻环境下的可靠解决方案。

行业	农业
零件	收割机套筒
应用	车削
材料	EN-GJS-500-7 (GGG50)
冷却液	是
Dormer Pramet 解决方案	WNMA 080412:T5405

加工数据		
v_c	f_n	a_p
320	0.22	0.8

K3.1





v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

加工案例

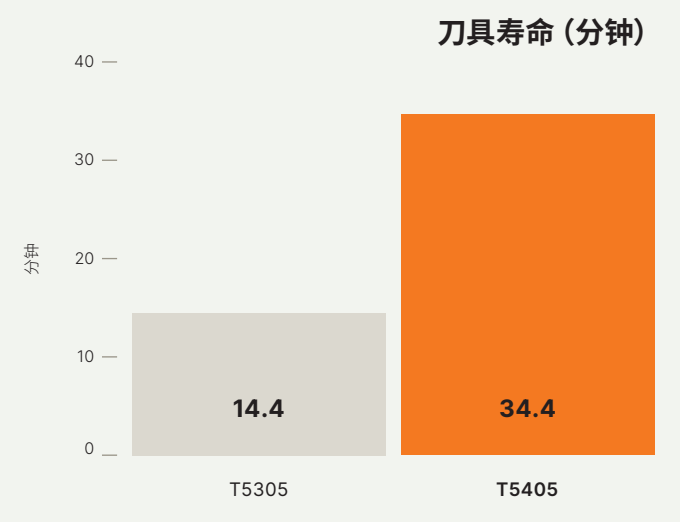
将灰铸铁端面车削的刀具寿命提高 139%

在我们的实验室进行的测试表明，与以前的牌号相比，耐用性有了显著提高。新的 T5405 牌号在端面车削加工中的刀具寿命达到了 34.4 分钟，比以前的 T5305 牌号延长了 139%。

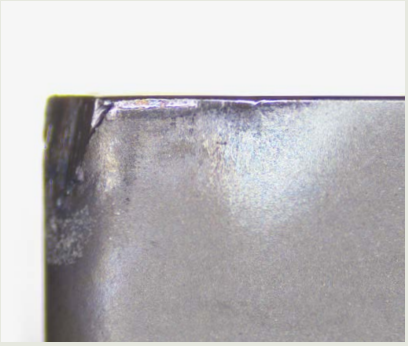
应用	端面车削
材料	GG25
冷却液	没有
Dormer Pramet 解决方案	CNMA 120408:T5405

加工数据		
v_c	f_n	a_p
330	0.3	2.0

K1.2



T5305

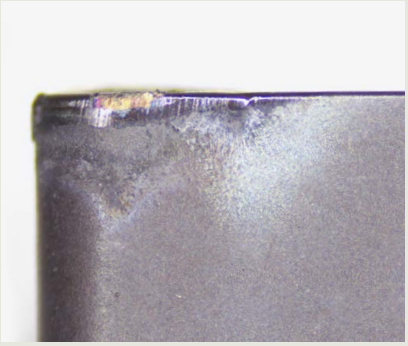


14.4 分钟后拍摄的照片

T5405

14.4 分钟后拍摄的照片

T5405



31 分钟后拍摄的照片

v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

加工案例

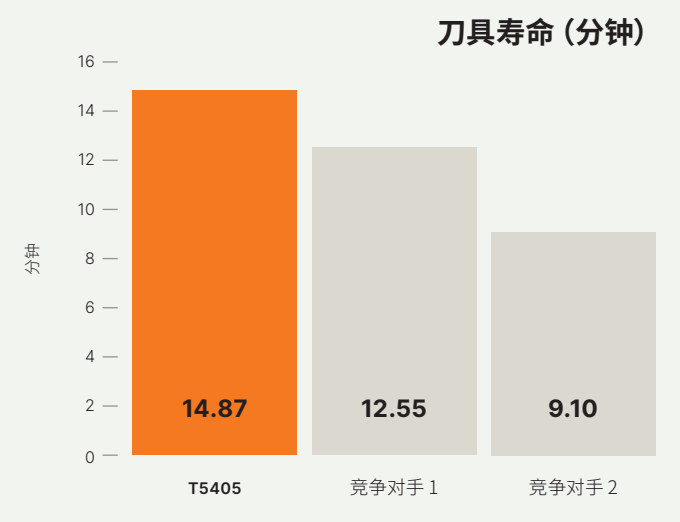
与最佳竞争对手相比，刀具寿命显著提高

在要求苛刻的联合作业中，新型 T5405 牌号的刀具寿命为 14.9 分钟，高于任何竞争对手。该牌号在两个操作过程中都保持了稳定的性能，同时比所有接受测试的竞争对手至少高出 18.5%。

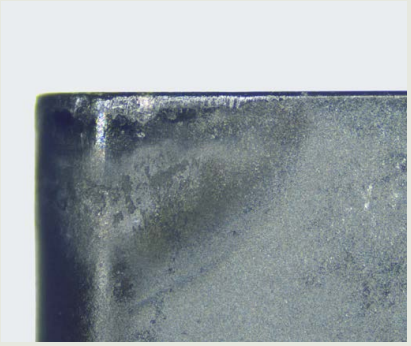
应用	组合式端面车削 和纵向车削
材料	GG25
冷却液	是
Dormer Pramet 解决方案	CNMA 120408:T5405

加工数据		
v_c	f_n	a_p
530	0.3	2.0

K1.2

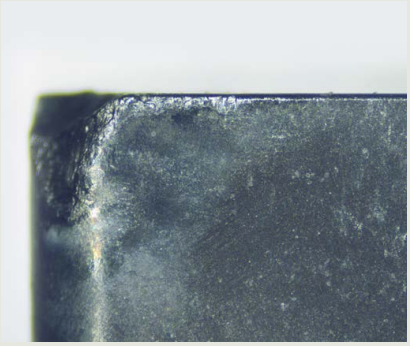


T5405



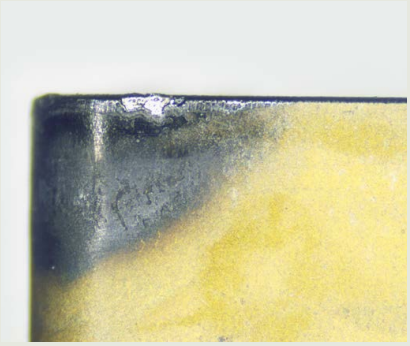
12 分钟后拍摄的照片

竞争对手 1



12 分钟后拍摄的照片

竞争对手 2



9 分钟后拍摄的照片

v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

技术信息

用于 T5405 刀片的断屑槽

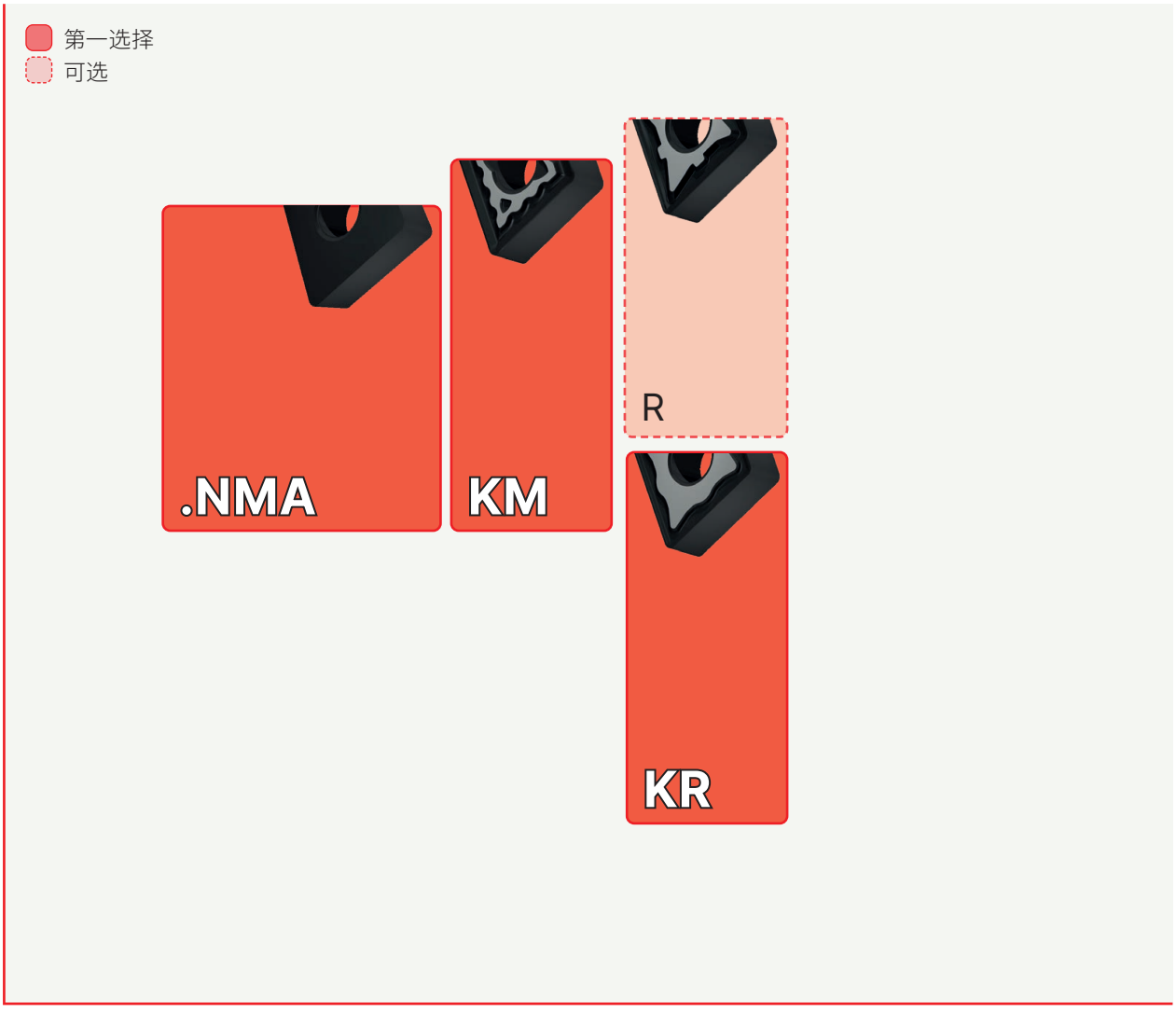
K

工作条件非常不稳定

不稳定的工作条件

稳定的工作条件

薄壁和超薄工件



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

技术信息

用于 T5405 正角刀片的断屑槽

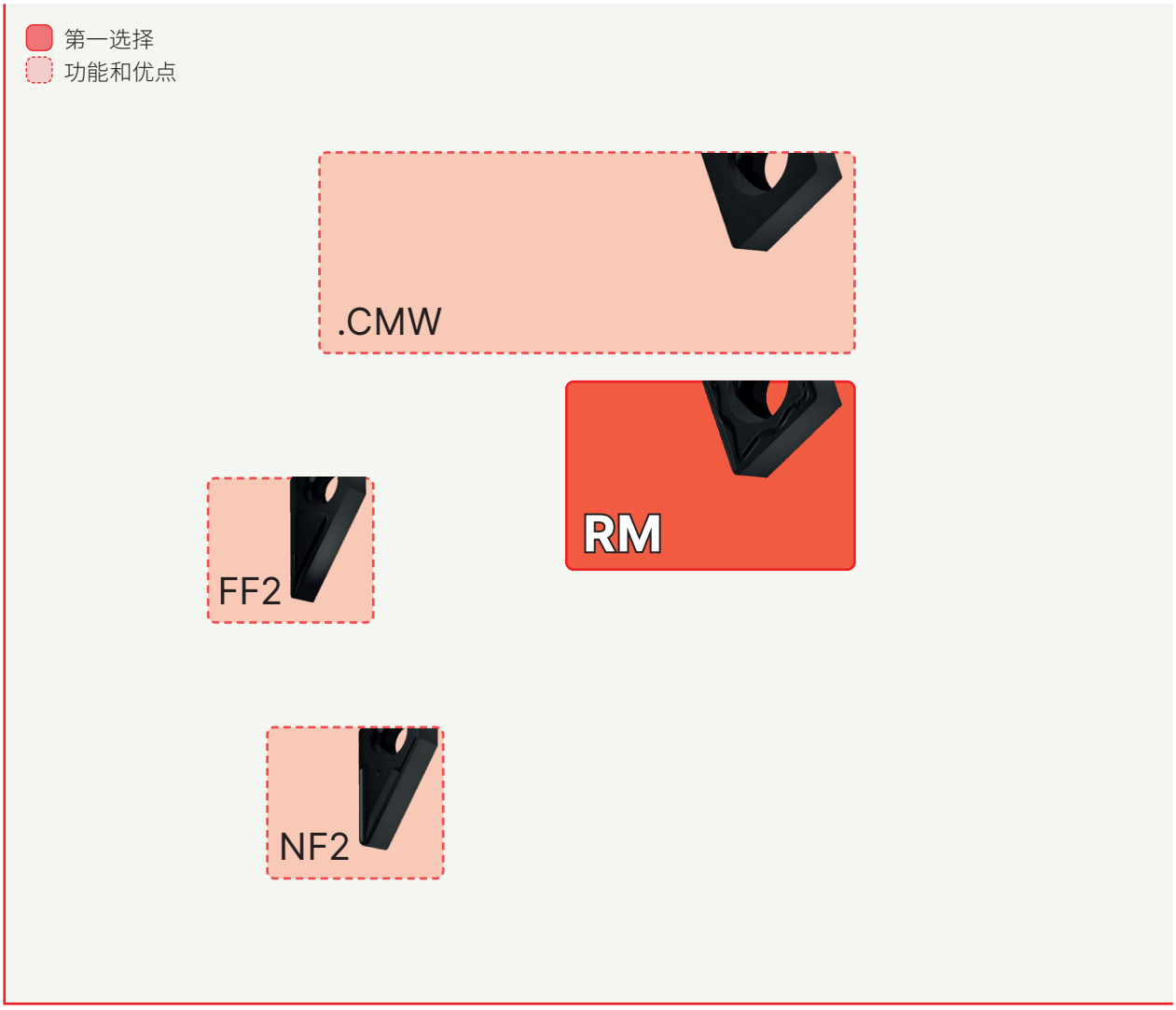
K

工作条件非常不稳定

不稳定的工作条件

稳定的工作条件

薄壁和超薄工件



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

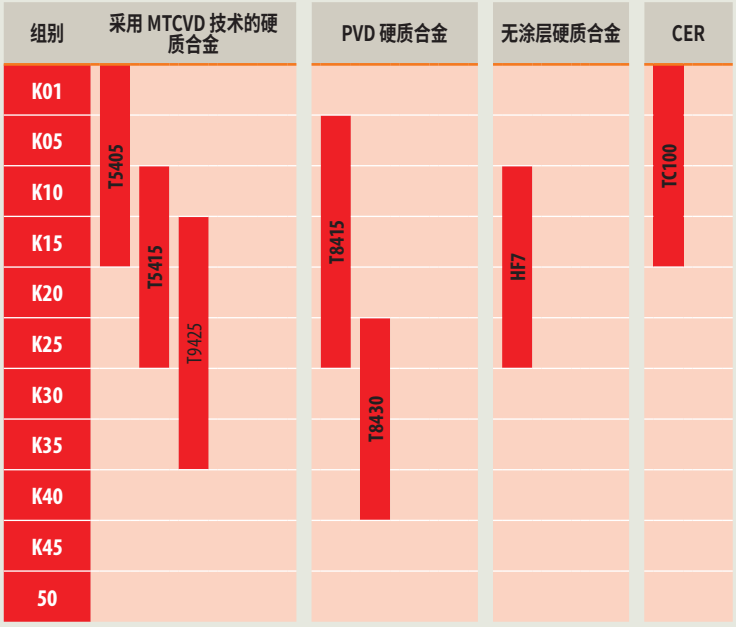
技术信息

T5405 的应用范围和材料兼容性

牌号识别	应用领域	应用	进给	切削速度	耐恶劣工作环境	涂层	颜色	基体	冷却液优势	牌号描述
T5405	P05 - P15	◪				MT-CVD		H	+	这种耐磨材料主要用于在稳定的切削条件下以极高的切削速度对铸铁件（尤其是灰口铸铁件）进行精加工和半粗加工。有条件的情况下，这种材料也可用于加工钢材。
	K01 - K15	■								

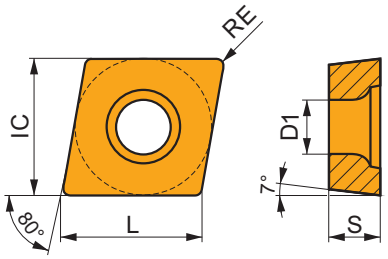
■推荐使用　◪可以使用

按 ISO 材料类别推荐的牌号

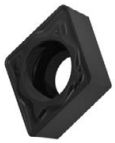
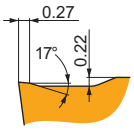


CCMT

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



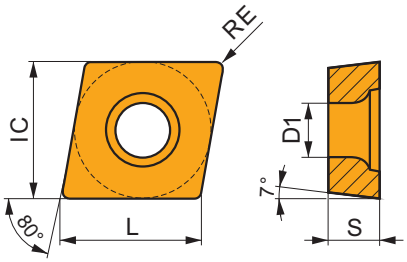
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
CCMT 09T304E-RM:T5405	●	0.4	◪	325	0.25	2.2	–	–	–	■	305	0.25	2.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-RM:T5405	⬌	0.8	◪	365	0.30	2.2	–	–	–	■	345	0.30	2.2	–	–	–	–	–	–	–	–	–
CCMT 120408E-RM:T5405	⬌	0.8	◪	355	0.30	2.7	–	–	–	■	335	0.30	2.7	–	–	–	–	–	–	–	–	–

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

CCMW

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



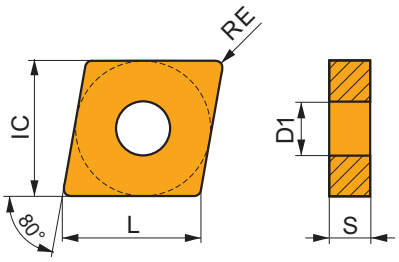
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CCMW 060202:T5405	●	0.2	–	–	–	–	–	–	■	270	0.08	2.0	–	–	–	–	–	–	–	–	–	–
CCMW 060204:T5405	●	0.4	–	–	–	–	–	–	■	270	0.10	2.0	–	–	–	–	–	–	–	–	–	–
CCMW 09T304:T5405	●	0.4	–	–	–	–	–	–	■	205	0.20	3.0	–	–	–	–	–	–	–	–	–	–
CCMW 09T308:T5405	●	0.8	–	–	–	–	–	–	■	245	0.20	3.0	–	–	–	–	–	–	–	–	–	–
CCMW 120404:T5405	●	0.4	–	–	–	–	–	–	■	245	0.10	4.0	–	–	–	–	–	–	–	–	–	–
CCMW 120408:T5405	⬌	0.8	–	–	–	–	–	–	■	235	0.20	4.0	–	–	–	–	–	–	–	–	–	–

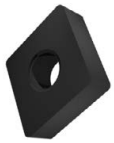
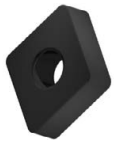
.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。

CNMA

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



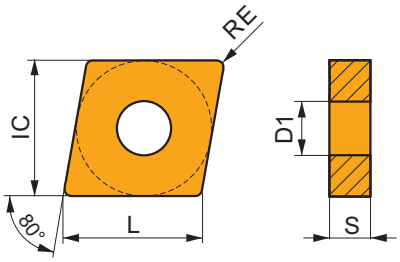
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
CNMA 120404:T5405	●	0.4	–	–	–	–	–	–	■ 275	0.10	4.0	–	–	–	–	–	–	–	–	–
CNMA 120408:T5405	⬌	0.8	–	–	–	–	–	–	■ 265	0.20	4.0	–	–	–	–	–	–	–	–	–
CNMA 120412:T5405	⬌	1.2	–	–	–	–	–	–	■ 245	0.30	4.0	–	–	–	–	–	–	–	–	–
CNMA 120416:T5405	⬌	1.6	–	–	–	–	–	–	■ 235	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMA 160612:T5405	⬌	1.2	–	–	–	–	–	–	■ 240	0.30	5.0	–	–	–	–	–	–	–	–	–
CNMA 160616:T5405	⬌	1.6	–	–	–	–	–	–	■ 230	0.40	5.0	–	–	–	–	–	–	–	–	–
CNMA 190612:T5405	⬌	1.2	–	–	–	–	–	–	■ 235	0.30	6.0	–	–	–	–	–	–	–	–	–
CNMA 190616:T5405	⬌	1.6	–	–	–	–	–	–	■ 225	0.40	6.0	–	–	–	–	–	–	–	–	–
																				
.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。																				
CNMA 120408S:T5405	⬌	0.8	–	–	–	–	–	–	■ 265	0.20	4.0	–	–	–	–	–	–	–	–	–
CNMA 120412S:T5405	⬌	1.2	–	–	–	–	–	–	■ 245	0.30	4.0	–	–	–	–	–	–	–	–	–
CNMA 160612S:T5405	⬌	1.2	–	–	–	–	–	–	■ 240	0.30	5.0	–	–	–	–	–	–	–	–	–
CNMA 190616S:T5405	⬌	1.6	–	–	–	–	–	–	■ 225	0.40	6.0	–	–	–	–	–	–	–	–	–

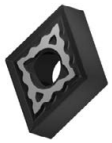
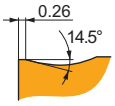
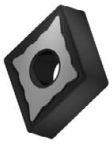
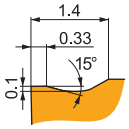
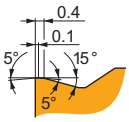
● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

CNMG

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



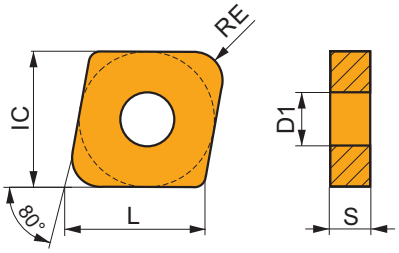
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
KM 断屑槽用途广泛，是铸铁中型加工的首选。它的特点是略带正前角和稳定宽大的 T 型面。它也有条件地适用于钢和硬质材料。																				
CNMG 120404-KM:T5405	●	0.4	◪	340	0.20	2.1	–	–	–	■	320	0.20	2.1	–	–	–	–	–	–	–	–	–	–
CNMG 120408-KM:T5405	⬌	0.8	◪	350	0.32	2.1	–	–	–	■	330	0.32	2.1	–	–	–	–	–	–	–	–	–	–
CNMG 120412-KM:T5405	⬌	1.2	◪	345	0.40	2.1	–	–	–	■	325	0.40	2.1	–	–	–	–	–	–	–	–	–	–
 																				
KR 型断屑槽坚固耐用，是铸铁粗加工的首选。它的特点是略带正前角和宽 T 倒棱。它还适用于钢材，有条件时也适用于硬质材料。																				
CNMG 120408E-KR:T5405	⬌	0.8	◪	300	0.40	4.0	–	–	–	■	285	0.40	4.0	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-KR:T5405	⬌	1.2	◪	345	0.40	2.1	–	–	–	■	325	0.40	2.1	–	–	–	–	–	–	–	–	–	–
CNMG 120416E-KR:T5405	⬌	1.6	◪	360	0.40	2.1	–	–	–	■	340	0.40	2.1	–	–	–	–	–	–	–	–	–	–
CNMG 160608E-KR:T5405	⬌	0.8	◪	310	0.35	4.5	–	–	–	■	290	0.35	4.5	–	–	–	–	–	–	–	–	–	–
CNMG 160612E-KR:T5405	⬌	1.2	◪	305	0.45	4.5	–	–	–	■	285	0.45	4.5	–	–	–	–	–	–	–	–	–	–
CNMG 160616E-KR:T5405	⬌	1.6	◪	305	0.50	4.5	–	–	–	■	285	0.50	4.5	–	–	–	–	–	–	–	–	–	–
CNMG 190608E-KR:T5405	⬌	0.8	◪	295	0.35	7.0	–	–	–	■	280	0.35	7.0	–	–	–	–	–	–	–	–	–	–
CNMG 190612E-KR:T5405	⬌	1.2	◪	290	0.45	7.0	–	–	–	■	275	0.45	7.0	–	–	–	–	–	–	–	–	–	–
CNMG 190616E-KR:T5405	⬌	1.6	◪	295	0.50	7.0	–	–	–	■	280	0.50	7.0	–	–	–	–	–	–	–	–	–	–
																				
R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																				
CNMG 120408E-R:T5405	⬌	0.8	◪	300	0.40	4.0	–	–	–	■	285	0.40	4.0	–	–	–	–	–	–	–	–	–	–
CNMG 160612E-R:T5405	⬌	1.2	◪	300	0.45	5.5	–	–	–	■	285	0.45	5.5	–	–	–	–	–	–	–	–	–	–
CNMG 160616E-R:T5405	⬌	1.6	◪	300	0.50	5.5	–	–	–	■	285	0.50	5.5	–	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T5405	⬌	1.2	◪	290	0.45	7.0	–	–	–	■	275	0.45	7.0	–	–	–	–	–	–	–	–	–	–

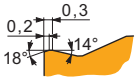
● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

CNMX 19

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1907	19.050	7.75	19.30	7.94



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

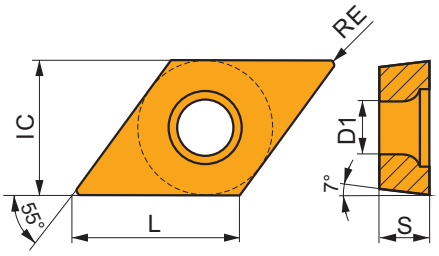
产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
CNMX 190740SN-RF:T5405	✱	4.0	◪ 125	0.85	4.0	–	–	–	■ 115	0.85	4.0	–	–	–	–	–	–	–	–	–

P

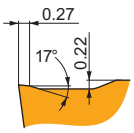
RF槽型适用于半精加工至粗加工，以及连续切削至断续切削。

DCMT

	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	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
DCMT 11T304E-RM:T5405	●	0.4	◪ 305	0.20	1.0	–	–	–	■ 285	0.20	1.0	–	–	–	–	–	–	–	–	–
DCMT 11T308E-RM:T5405	●	0.8	◪ 340	0.27	0.8	–	–	–	■ 320	0.27	0.8	–	–	–	–	–	–	–	–	–

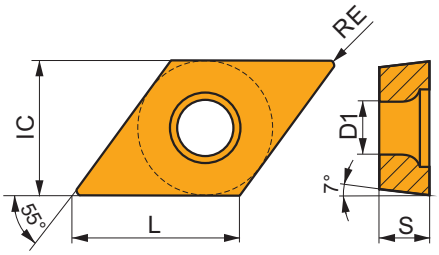
1 S

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

● 适用于稳定工况 ⚙ 适用于不稳定工况 ✱ 适用于重型加工工况 ■ 推荐使用 ◪ 可以使用

DCMW

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



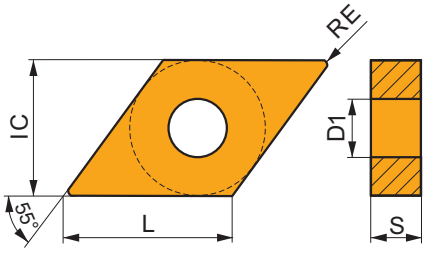
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
DCMW 070202:T5405	●	0.2	–	–	–	–	–	–	■ 235	0.08	0.8	–	–	–	–	–	–	–	–	–
DCMW 070204:T5405	●	0.4	–	–	–	–	–	–	■ 235	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMW 11T304:T5405	●	0.4	–	–	–	–	–	–	■ 225	0.10	1.2	–	–	–	–	–	–	–	–	–
DCMW 11T308:T5405	●	0.8	–	–	–	–	–	–	■ 225	0.18	1.2	–	–	–	–	–	–	–	–	–

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

DNMA

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



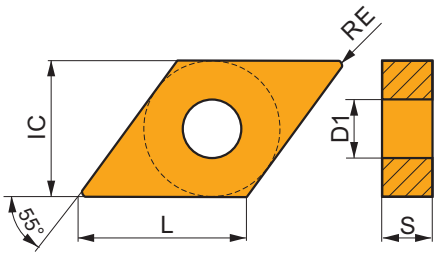
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
DNMA 150408:T5405	●	0.8	–	–	–	–	–	–	■ 230	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMA 150604:T5405	●	0.4	–	–	–	–	–	–	■ 240	0.10	1.7	–	–	–	–	–	–	–	–	–
DNMA 150608:T5405	●	0.8	–	–	–	–	–	–	■ 230	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMA 150612:T5405	⚙	1.2	–	–	–	–	–	–	■ 245	0.20	1.7	–	–	–	–	–	–	–	–	–

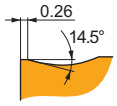
.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。

DNMG

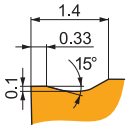
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



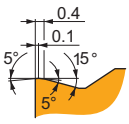
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
DNMG 150404-KM:T5405	●	0.4	◪	275	0.20	1.9	–	–	–	■	260	0.20	1.9	–	–	–	–	–	–	–	–	–	–
DNMG 150412-KM:T5405	⬌	1.2	◪	280	0.40	1.9	–	–	–	■	265	0.40	1.9	–	–	–	–	–	–	–	–	–	–
DNMG 150608-KM:T5405	●	0.8	◪	285	0.30	1.9	–	–	–	■	270	0.30	1.9	–	–	–	–	–	–	–	–	–	–

KM 断屑槽用途广泛，是铸铁中型加工的首选。它的特点是略带正前角和稳定宽大的 T 型面。它也有条件地适用于钢和硬质材料。

																							
DNMG 150608E-KR:T5405	●	0.8	◪	260	0.35	3.0	–	–	–	■	245	0.35	3.0	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-KR:T5405	⬌	1.2	◪	260	0.40	3.0	–	–	–	■	245	0.40	3.0	–	–	–	–	–	–	–	–	–	–
DNMG 150616E-KR:T5405	⬌	1.6	◪	260	0.50	3.0	–	–	–	■	245	0.50	3.0	–	–	–	–	–	–	–	–	–	–

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

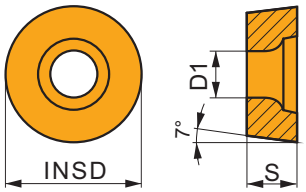
																							
DNMG 150608E-R:T5405	⬌	0.8	◪	250	0.40	3.0	–	–	–	■	235	0.40	3.0	–	–	–	–	–	–	–	–	–	–
DNMG 150616E-R:T5405	⬌	1.6	◪	275	0.40	3.0	–	–	–	■	260	0.40	3.0	–	–	–	–	–	–	–	–	–	–

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

● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

RCMW

	D1 (mm)	S (mm)
0602	2.80	2.38
0803	3.40	3.18
10T3	4.40	3.97
1204	4.40	4.76



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

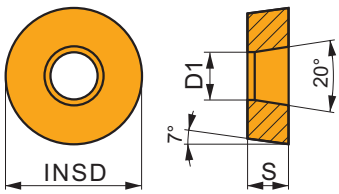
产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
RCMW 0602M0:T5405	⬌	–	–	–	–	–	–	–	■ 355	0.25	0.6	–	–	–	–	–	–	–	–	–
RCMW 0803M0:T5405	⬌	–	–	–	–	–	–	–	■ 320	0.30	0.8	–	–	–	–	–	–	–	–	–
RCMW 10T3M0:T5405	⬌	–	–	–	–	–	–	–	■ 285	0.40	1.0	–	–	–	–	–	–	–	–	–
RCMW 1204M0:T5405	⬌	–	–	–	–	–	–	–	■ 270	0.45	1.2	–	–	–	–	–	–	–	–	–

HFC E

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

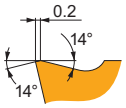
RCMX

	D1 (mm)	S (mm)
2006	6.50	6.35



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

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
RCMX 2006M0-RF1:T5405	⬌	–	◪ 155	0.80	3.5	–	–	–	◪ 145	0.80	3.5	–	–	–	–	–	–	–	–	–

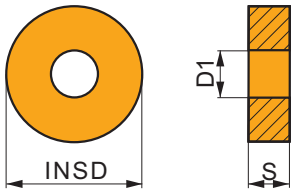


HFC S

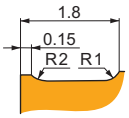
RF1 屑槽，适用于精加工至中粗加工，连续至断续切削。

RNMG

	D1 (mm)	S (mm)
1204	5.16	4.76
1506	6.35	6.35



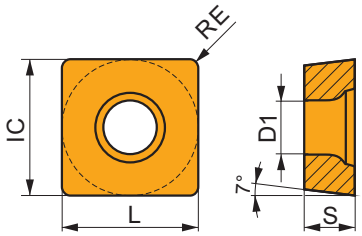
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/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)
																				
RNMG 120400E-08:T5405	●	–	◪	255	0.70	3.0	–	–	–	◪	240	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 150600E-08:T5405	●	–	◪	255	0.70	3.0	–	–	–	◪	240	0.70	3.0	–	–	–	–	–	–	–	–	–

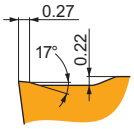
08 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。

SCMT

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



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

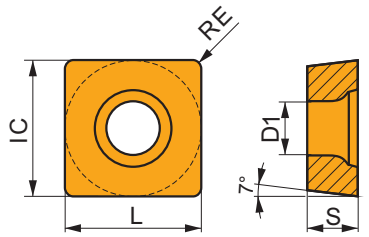
产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
SCMT 09T308E-RM:T5405	⚙	0.8	◪	390	0.30	2.0	–	–	–	■	370	0.30	2.0	–	–	–	–	–	–	–	–	–
SCMT 120408E-RM:T5405	⚙	0.8	◪	385	0.30	2.3	–	–	–	■	365	0.30	2.3	–	–	–	–	–	–	–	–	–

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

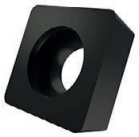
● 适用于稳定工况 ⚙ 适用于不稳定工况 ✱ 适用于重型加工工况 ■ 推荐使用 ◪ 可以使用

SCMW

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

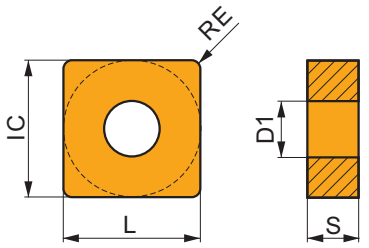


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
SCMW 09T304:T5405	●	0.4	–	–	–	–	–	–	■ 285	0.10	2.0	–	–	–	–	–	–	–	–	–
SCMW 09T308:T5405	⇕	0.8	–	–	–	–	–	–	■ 270	0.20	2.0	–	–	–	–	–	–	–	–	–
SCMW 120408:T5405	⇕	0.8	–	–	–	–	–	–	■ 250	0.20	4.0	–	–	–	–	–	–	–	–	–

SNMA

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



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

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
SNMA 120408:T5405	⇕	0.8	–	–	–	–	–	–	■ 280	0.20	4.0	–	–	–	–	–	–	–	–	–
SNMA 120412:T5405	⇕	1.2	–	–	–	–	–	–	■ 260	0.30	4.0	–	–	–	–	–	–	–	–	–
SNMA 150612:T5405	⇕	1.2	–	–	–	–	–	–	■ 255	0.30	5.0	–	–	–	–	–	–	–	–	–
SNMA 190612:T5405	⇕	1.2	–	–	–	–	–	–	■ 245	0.30	6.0	–	–	–	–	–	–	–	–	–
SNMA 190616:T5405	⇕	1.6	–	–	–	–	–	–	■ 240	0.40	6.0	–	–	–	–	–	–	–	–	–
SNMA 250724:T5405	⇕	2.4	–	–	–	–	–	–	■ 135	0.60	8.0	–	–	–	–	–	–	–	–	–
SNMA 250924:T5405	⇕	2.4	–	–	–	–	–	–	■ 135	0.60	8.0	–	–	–	–	–	–	–	–	–
.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。																				
SNMA 120412S:T5405	⇕	1.2	–	–	–	–	–	–	■ 260	0.30	4.0	–	–	–	–	–	–	–	–	–

● 适用于稳定工况　⇕ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

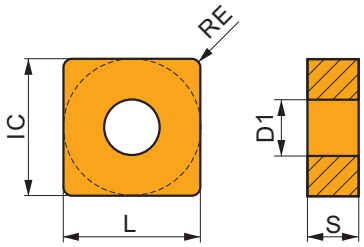
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。																				
SNMA 150616S:T5405	⚙	1.6	–	–	–	–	–	–	■ 270	0.30	5.0	–	–	–	–	–	–	–	–	–
SNMA 190616S:T5405	⚙	1.6	–	–	–	–	–	–	■ 240	0.40	6.0	–	–	–	–	–	–	–	–	–
SNMA 250724S:T5405	⚙	2.4	–	–	–	–	–	–	■ 135	0.60	8.0	–	–	–	–	–	–	–	–	–
SNMA 250924S:T5405	⚙	2.4	–	–	–	–	–	–	■ 135	0.60	8.0	–	–	–	–	–	–	–	–	–

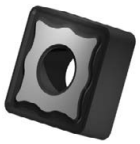
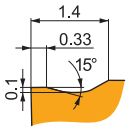
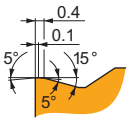
SNMG

DORMER PRAMET

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



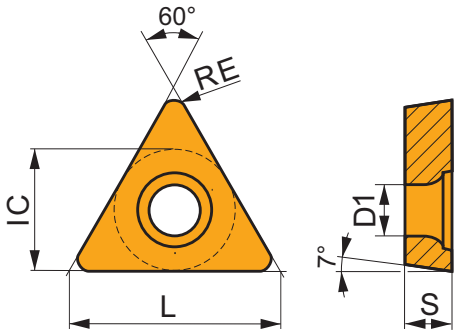
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
KR 型断屑槽坚固耐用，是铸铁粗加工的首选。它的特点是略带正前角和宽 T 倒棱。它还适用于钢材，有条件时也适用于硬质材料。																				
SNMG 120408E-KR:T5405	⚙	0.8	◪ 330	0.35	3.8	–	–	–	■ 310	0.35	3.8	–	–	–	–	–	–	–	–	–
SNMG 120412E-KR:T5405	⚙	1.2	◪ 340	0.40	3.8	–	–	–	■ 320	0.40	3.8	–	–	–	–	–	–	–	–	–
SNMG 120416E-KR:T5405	⚙	1.6	◪ 340	0.45	3.8	–	–	–	■ 320	0.45	3.8	–	–	–	–	–	–	–	–	–
SNMG 150612E-KR:T5405	⚙	1.2	◪ 320	0.45	4.5	–	–	–	■ 300	0.45	4.5	–	–	–	–	–	–	–	–	–
SNMG 150616E-KR:T5405	⚙	1.6	◪ 325	0.50	4.5	–	–	–	■ 305	0.50	4.5	–	–	–	–	–	–	–	–	–
SNMG 190612E-KR:T5405	⚙	1.2	◪ 300	0.45	7.0	–	–	–	■ 285	0.45	7.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-KR:T5405	⚙	1.6	◪ 310	0.50	7.0	–	–	–	■ 290	0.50	7.0	–	–	–	–	–	–	–	–	–
																				
R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																				
SNMG 120408E-R:T5405	⚙	0.8	◪ 320	0.40	3.8	–	–	–	■ 300	0.40	3.8	–	–	–	–	–	–	–	–	–

● 适用于稳定工况　⚙ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

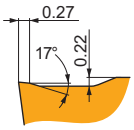
TCMT

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



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

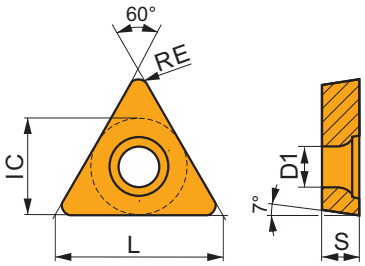
产品	● ⚭ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
TCMT 16T308E-RM:T5405	●	0.8	◪ 330	0.27	1.9	–	–	–	■ 310	0.27	1.9	–	–	–	–	–	–	–	–	–
TCMT 16T312E-RM:T5405	●	1.2	◪ 345	0.27	1.9	–	–	–	■ 325	0.27	1.9	–	–	–	–	–	–	–	–	–



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

TCMW

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



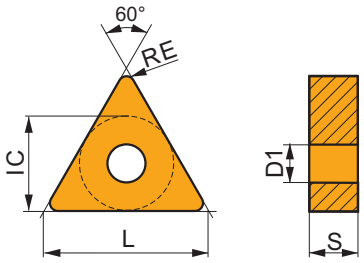
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚭ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
TCMW 110204:T5405	●	0.4	–	–	–	–	–	–	■ 240	0.10	1.2	–	–	–	–	–	–	–	–	–
TCMW 16T304:T5405	●	0.4	–	–	–	–	–	–	■ 235	0.10	1.5	–	–	–	–	–	–	–	–	–
TCMW 16T308:T5405	●	0.8	–	–	–	–	–	–	■ 230	0.18	1.5	–	–	–	–	–	–	–	–	–

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

TNMA

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

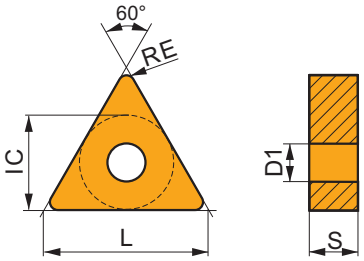


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

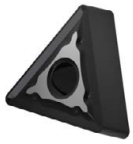
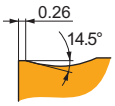
产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																		.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。		
TNMA 160404:T5405	●	0.4	–	–	–	–	–	–	■ 260	0.10	1.5	–	–	–	–	–	–	–	–	–
TNMA 160408:T5405	●	0.8	–	–	–	–	–	–	■ 250	0.20	1.5	–	–	–	–	–	–	–	–	–
TNMA 160412:T5405	⬌	1.2	–	–	–	–	–	–	■ 265	0.20	1.5	–	–	–	–	–	–	–	–	–
TNMA 220408:T5405	●	0.8	–	–	–	–	–	–	■ 245	0.20	2.0	–	–	–	–	–	–	–	–	–
TNMA 220412:T5405	⬌	1.2	–	–	–	–	–	–	■ 255	0.20	2.0	–	–	–	–	–	–	–	–	–
																		.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。		
TNMA 160408S:T5405	⬌	0.8	–	–	–	–	–	–	■ 250	0.20	1.5	–	–	–	–	–	–	–	–	–

TNMG

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

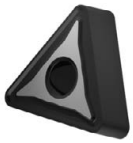
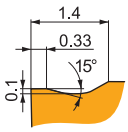


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
																		KM 断屑槽用途广泛，是铸铁中型加工的首选。它的特点是略带正前角和稳定宽大的 T 型面。它也有条件地适用于钢和硬质材料。		
TNMG 160408-KM:T5405	●	0.8	◪ 300	0.30	2.1	–	–	–	■ 285	0.30	2.1	–	–	–	–	–	–	–	–	–

● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

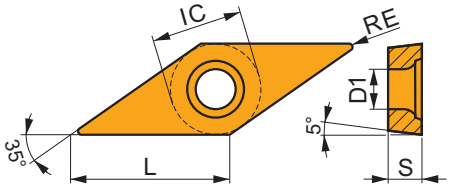
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
TNMG 160408E-KR:T5405	●	0.8	◪ 275	0.35	3.0	–	–	–	■ 260	0.35	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412E-KR:T5405	⇕	1.2	◪ 280	0.40	3.0	–	–	–	■ 265	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 220408E-KR:T5405	●	0.8	◪ 270	0.35	4.0	–	–	–	■ 255	0.35	4.0	–	–	–	–	–	–	–	–	–
TNMG 220412E-KR:T5405	⇕	1.2	◪ 270	0.40	4.0	–	–	–	■ 255	0.40	4.0	–	–	–	–	–	–	–	–	–

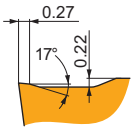
KR 型断屑槽坚固耐用，是铸铁粗加工的首选。它的特点是略带正前角和宽 T 倒棱。它还适用于钢材，有条件时也适用于硬质材料。

VBMT

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



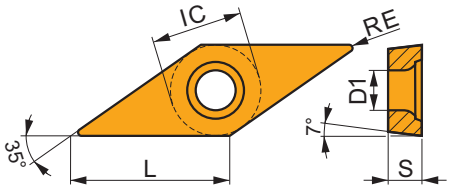
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
VBMT 160404E-RM:T5405	●	0.4	◪ 320	0.12	1.2	–	–	–	■ 300	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-RM:T5405	●	0.8	◪ 345	0.17	1.2	–	–	–	■ 325	0.17	1.2	–	–	–	–	–	–	–	–	–

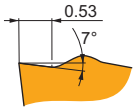
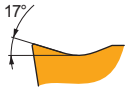
RM 型断屑槽坚固耐用，是钢和铸铁粗加工的首选。它具有正前角和稳定开放的 T 倒棱。它还适用于不锈钢，并有条件地适用于超级合金和硬质材料。

VCGT

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

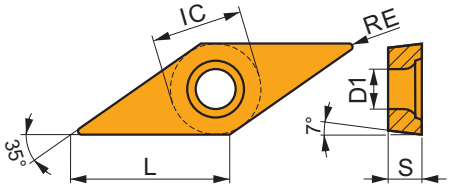


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
FF2 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。																				
VCGT 130302E-FF2:T5405	●	0.2	◪	330	0.05	1.0	–	–	–	■	310	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T5405	●	0.4	◪	270	0.12	1.0	–	–	–	■	255	0.12	1.0	–	–	–	–	–	–	–	–	–
																				
NF2 断屑槽非常锋利，是不锈钢精加工的首选。具有正前角，无T-型倒棱。还适用于耐热合金，有条件地适用于钢、铸铁和有色合金。																				
VCGT 130304E-NF2:T5405	●	0.4	◪	270	0.12	1.0	–	–	–	◪	255	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGW 130308E-NF2:T5405	●	0.8	◪	290	0.17	1.0	–	–	–	◪	275	0.17	1.0	–	–	–	–	–	–	–	–	–

VCGW

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



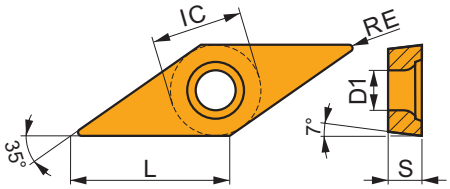
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
VCGW 130302:T5405	●	0.2	–	–	–	–	–	–	■	195	0.08	1.3	–	–	–	–	–	–	–	–	–	–
VCGW 130304:T5405	●	0.4	–	–	–	–	–	–	■	190	0.10	1.3	–	–	–	–	–	–	–	–	–	–
VCGW 130308:T5405	●	0.8	–	–	–	–	–	–	■	190	0.18	1.3	–	–	–	–	–	–	–	–	–	–

● 适用于稳定工况　⚙ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

VCMW

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



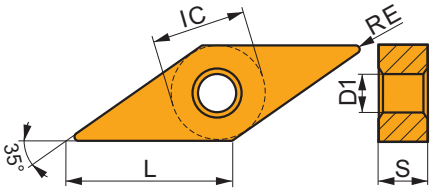
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
VCMW 110302:T5405	●	0.2	–	–	–	–	–	–	■ 195	0.08	1.2	–	–	–	–	–	–	–	–	–
VCMW 110304:T5405	●	0.4	–	–	–	–	–	–	■ 195	0.10	1.2	–	–	–	–	–	–	–	–	–
VCMW 160404:T5405	●	0.4	–	–	–	–	–	–	■ 190	0.10	1.5	–	–	–	–	–	–	–	–	–
VCMW 160408:T5405	●	0.8	–	–	–	–	–	–	■ 190	0.18	1.5	–	–	–	–	–	–	–	–	–

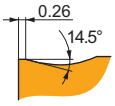
.CMW 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。

VNMG

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



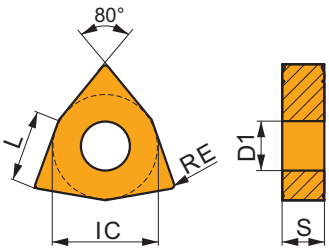
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
VNMG 160408-KM:T5405	●	0.8	◪ 260	0.30	1.4	–	–	–	■ 245	0.30	1.4	–	–	–	–	–	–	–	–	–

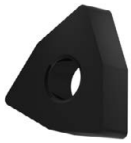
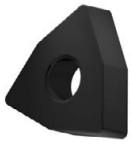
KM 断屑槽用途广泛，是铸铁中型加工的首选。它的特点是略带正前角和稳定宽大的 T 型面。它也有条件地适用于钢和硬质材料。

WNMA

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

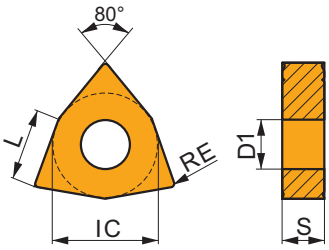


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

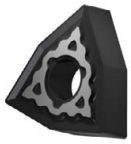
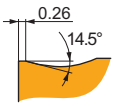
产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			E																	
.NMA 平板刀片设计用于铸铁的中等加工。特点是0°刀片后角，无T-型倒棱。也有条件地适用于硬质材料。																				
WNMA 080404:T5405	●	0.4	–	–	–	–	–	–	■ 275	0.10	4.0	–	–	–	–	–	–	–	–	–
WNMA 080408:T5405	⬌	0.8	–	–	–	–	–	–	■ 265	0.20	4.0	–	–	–	–	–	–	–	–	–
WNMA 080412:T5405	⬌	1.2	–	–	–	–	–	–	■ 245	0.30	4.0	–	–	–	–	–	–	–	–	–
			S																	
.NMA..S平刀片设计用于铸铁的中度加工。它具有中等前角和适中的负T倒棱。它也有条件地适用于硬质材料。																				
WNMA 080408S:T5405	⬌	0.8	–	–	–	–	–	–	■ 265	0.20	4.0	–	–	–	–	–	–	–	–	–

WNMG

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

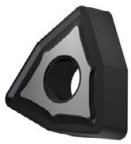
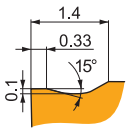
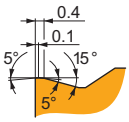


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 			S																	
KM 断屑槽用途广泛，是铸铁中型加工的首选。它的特点是略带正前角和稳定宽大的 T 型面。它也有条件地适用于钢和硬质材料。																				
WNMG 060404-KM:T5405	●	0.4	◪ 345	0.20	1.8	–	–	–	■ 325	0.20	1.8	–	–	–	–	–	–	–	–	–
WNMG 080404-KM:T5405	●	0.4	◪ 340	0.20	2.1	–	–	–	■ 320	0.20	2.1	–	–	–	–	–	–	–	–	–
WNMG 080408-KM:T5405	⬌	0.8	◪ 350	0.32	2.1	–	–	–	■ 330	0.32	2.1	–	–	–	–	–	–	–	–	–
WNMG 080412-KM:T5405	⬌	1.2	◪ 345	0.40	2.1	–	–	–	■ 325	0.40	2.1	–	–	–	–	–	–	–	–	–

● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

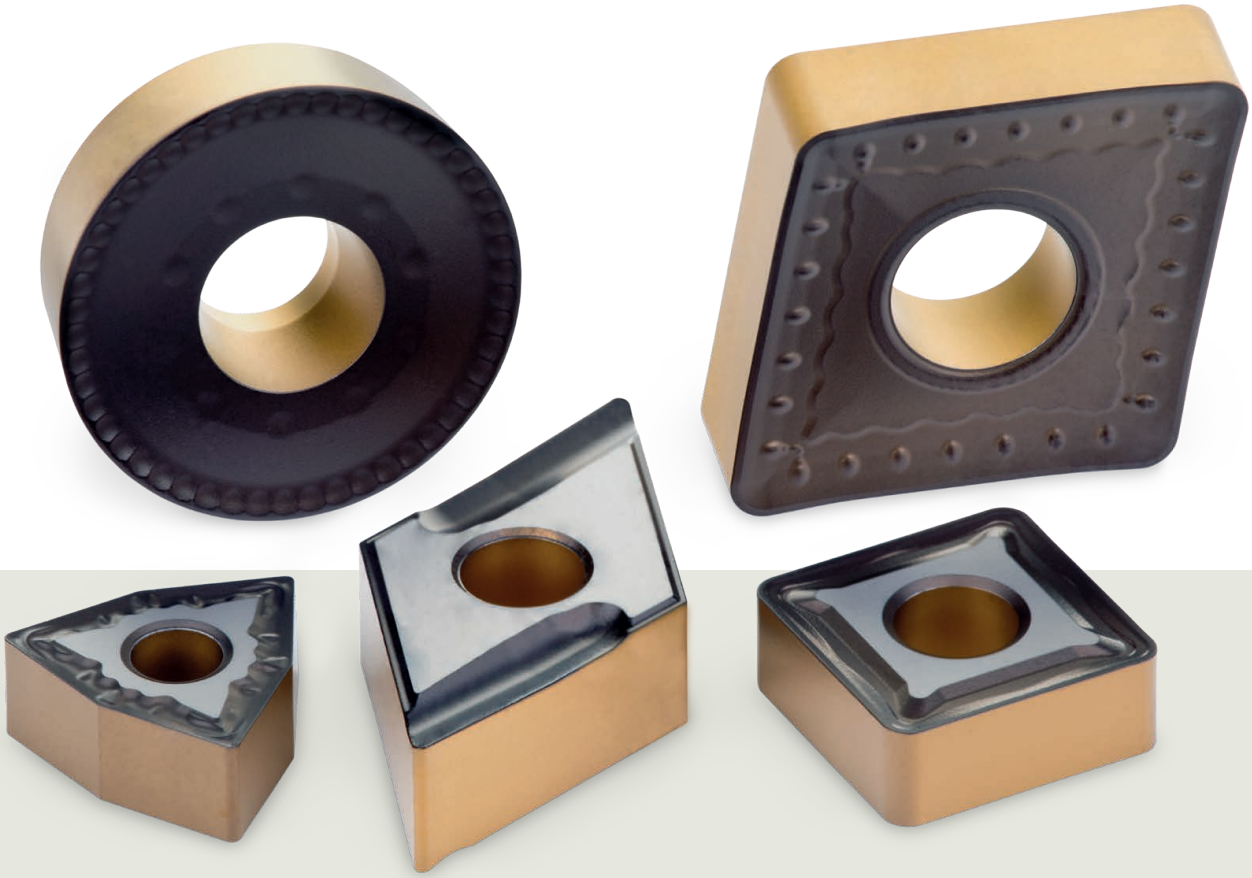
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 	KR 型断屑槽坚固耐用，是铸铁粗加工的首选。它的特点是略带正前角和宽 T 倒棱。它还适用于钢材，有条件时也适用于硬质材料。																			
WNMG 080408E-KR:T5405	⬌	0.8	◪ 320	0.35	3.5	–	–	–	■ 300	0.35	3.5	–	–	–	–	–	–	–	–	–
WNMG 080412E-KR:T5405	⬌	1.2	◪ 325	0.40	3.5	–	–	–	■ 305	0.40	3.5	–	–	–	–	–	–	–	–	–
WNMG 080416E-KR:T5405	⬌	1.6	◪ 320	0.50	3.5	–	–	–	■ 300	0.50	3.5	–	–	–	–	–	–	–	–	–
	R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																			
WNMG 080408E-R:T5405	⬌	0.8	◪ 305	0.40	3.5	–	–	–	■ 285	0.40	3.5	–	–	–	–	–	–	–	–	–
WNMG 080412E-R:T5405	⬌	1.2	◪ 315	0.45	3.5	–	–	–	■ 295	0.45	3.5	–	–	–	–	–	–	–	–	–

● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

用于车削钢材的新型多功能牌号

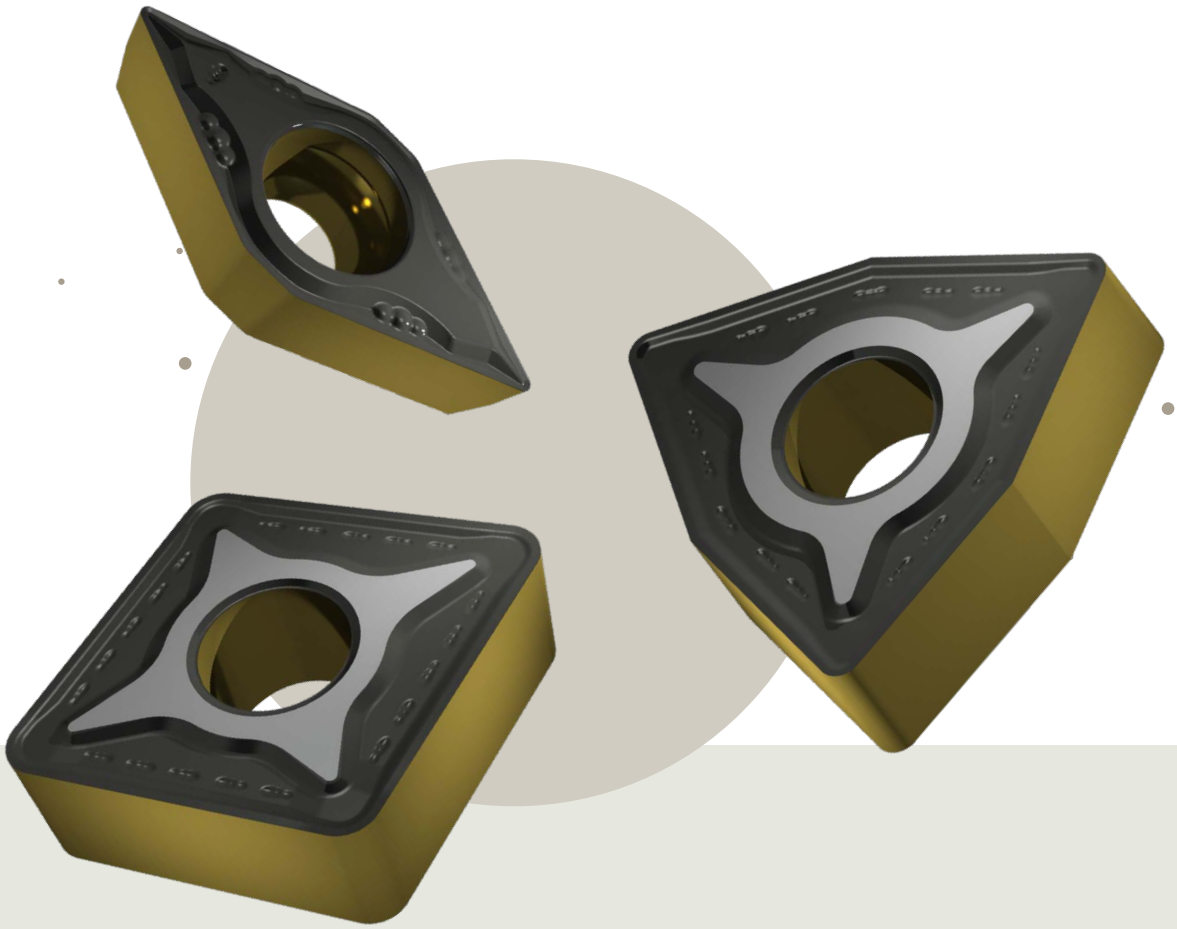
在挑战性条件下最大限度地延长刀具寿命和提高工艺稳定性



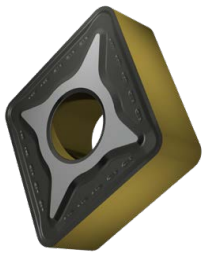
新型 T9425 车削牌号采用功能梯度基体和先进的 MT-CVD 涂层，具有卓越的性能和耐磨性。其高度纹理化的α-Al2O3层可确保在连续切削中获得一致的效果，而后处理可提高刀具在不稳定条件下的使用寿命。

金色的 TiN 涂层刀面提高了磨损检测能力，减少了停机时间，使 T9425 成为钢 (P)、不锈钢 (M) 和可选铸铁 (K) 应用的可靠选择。

相关产品



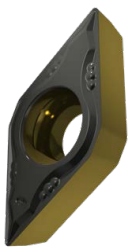
T9425



负角刀片

钢 (P)、不锈钢 (M) 和铸铁 (K) 应用

T9425

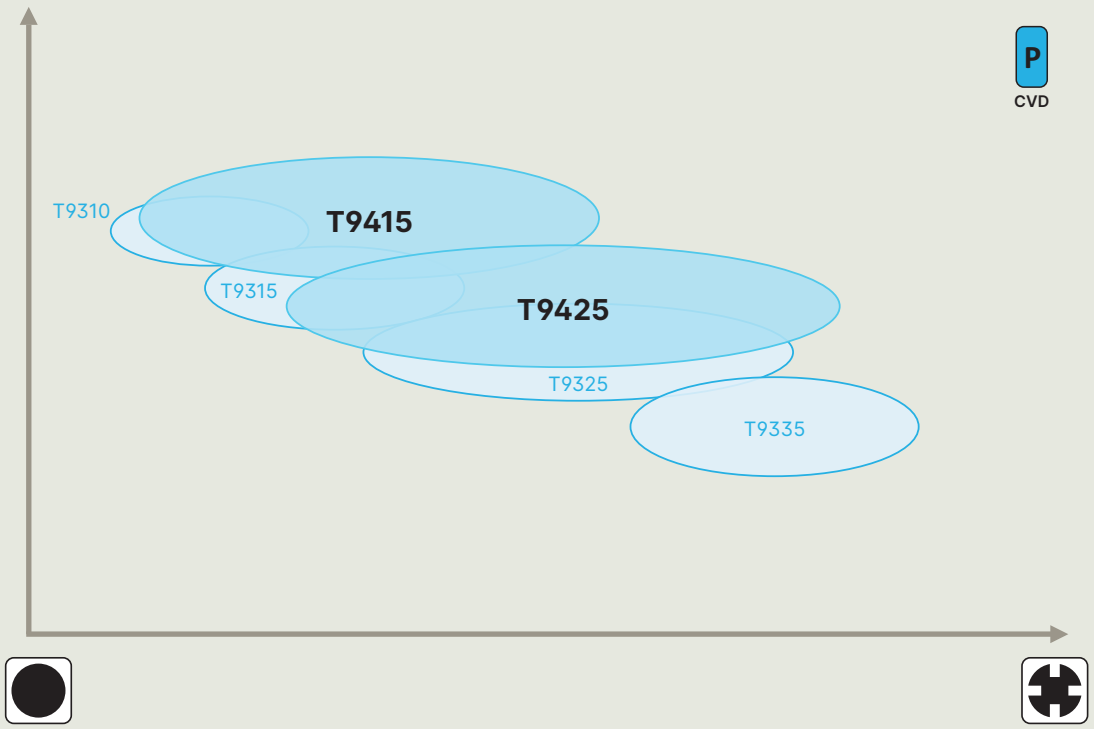


正角刀片

钢 (P)、不锈钢 (M) 和铸铁 (K) 应用

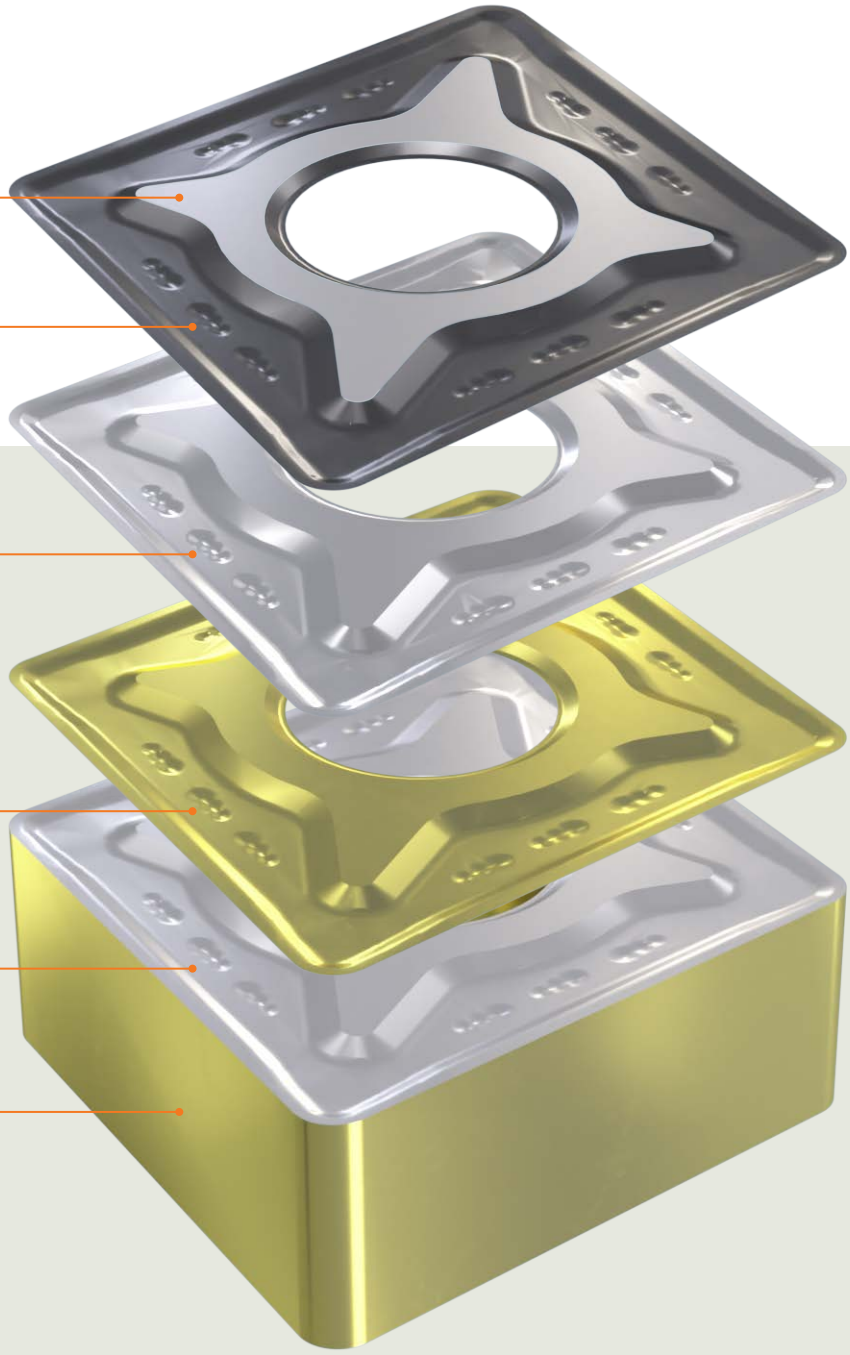
功能和优点

高度纹理化的α-Al_2O_3涂层具有出色的耐磨性和热稳定性。	→	**刀具寿命长** 并提高生产率。
新的后处理工艺提高了切削刃的稳定性。	→	**出色的可靠性** 特别是在不稳定的加工条件下。
坚硬的功能梯度基体。	→	**增强耐用性** 在连续和苛刻的切削条件下。
侧面的金色 TiN 涂层有助于可有效监测刀具状况。	→	**更容易检测磨损** 减少停机时间。
涂层后的磨削座面。	→	**改进传热** 提供更好的稳定性并延长刀具的使用寿命。



牌号构成

先进的设计，具有无与伦比的耐用性和可靠性



成功案例

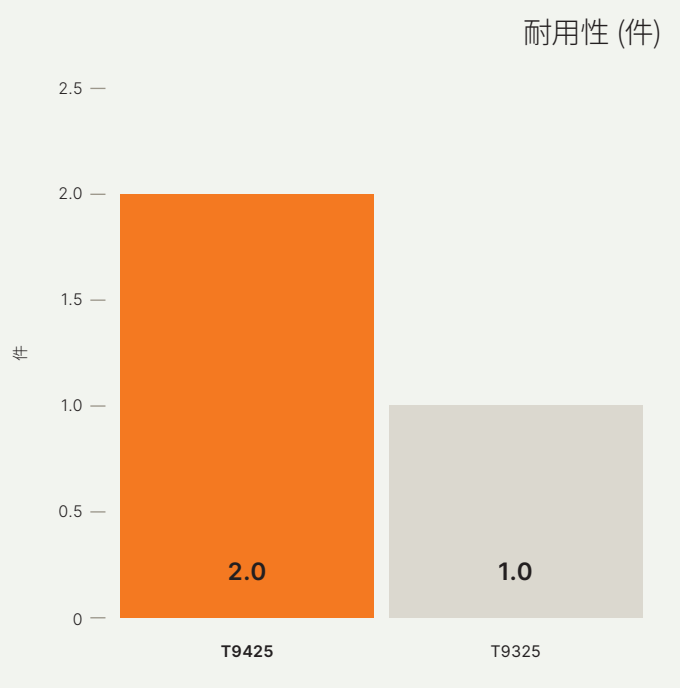
在连续切削应用中，刀具寿命延长一倍

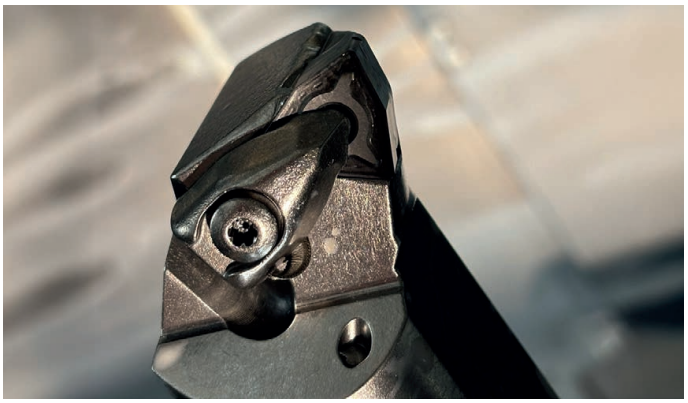
客户成果：T9425 牌号的刀具寿命提高了 100%，为连续切削操作的耐用性设定了新基准。T9425 减少了频繁更换刀具的需要，最大限度地缩短了停机时间，从而确保了不间断的加工周期。T9425 能够应对苛刻的加工条件，是高精度汽车应用的完美解决方案，将高效率与稳定、高质量的加工结果完美结合。

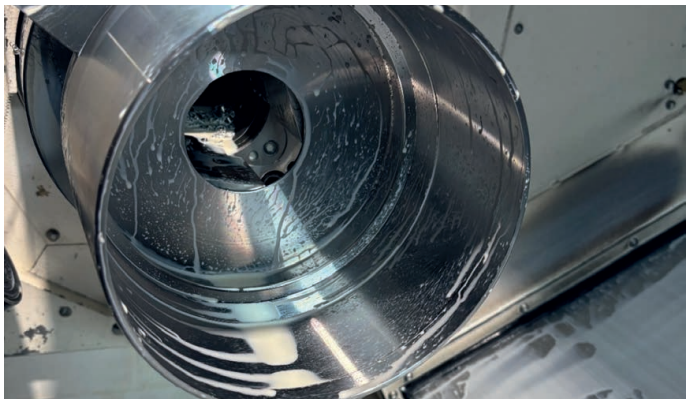
行业	汽车
零件	外围载体
应用	车削
材料	42CrMo4+QT
冷却液	是
Dormer Pramet 解决方案	WNMG 080408E-RM:T9425

加工数据		
v_c	f_n	a_p
180	0.3	3.0

P3.3







v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

成功案例

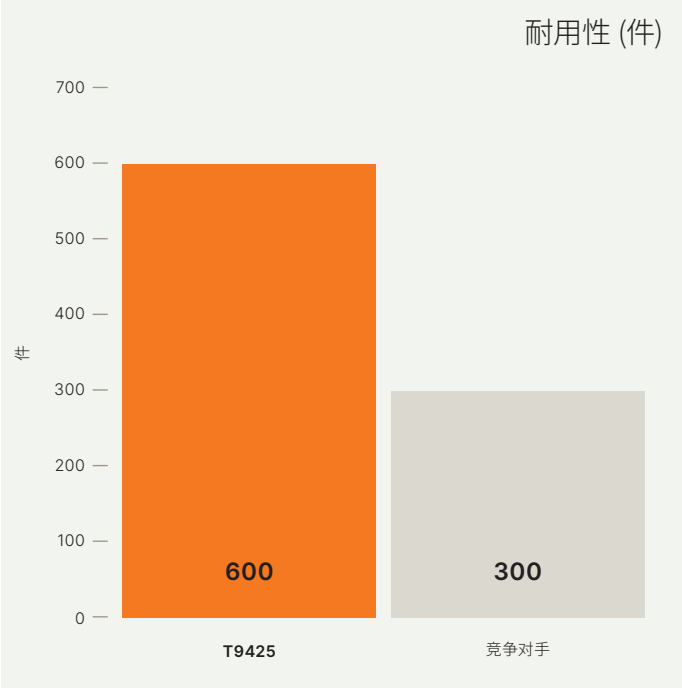
刀具寿命提高 **100%**

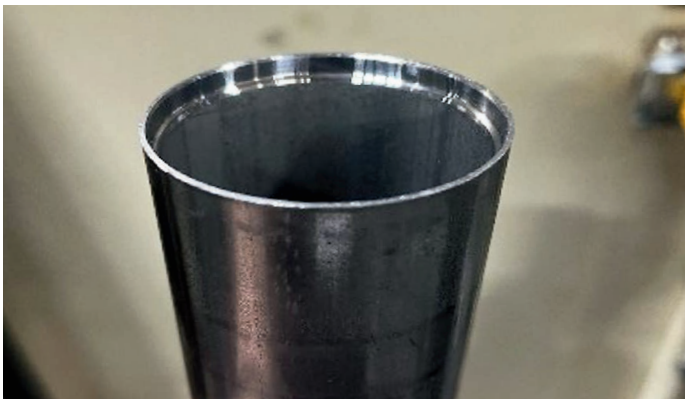
客户成果：与竞争对手相比，T9425 的刀具寿命提高了 100%，重新定义了汽车加工领域的预期。每把刀具最多可加工 600 个零件，大大降低了成本和停机时间。其先进的性能可延长加工时间，同时保持稳定的高质量结果，树立了新的标杆。

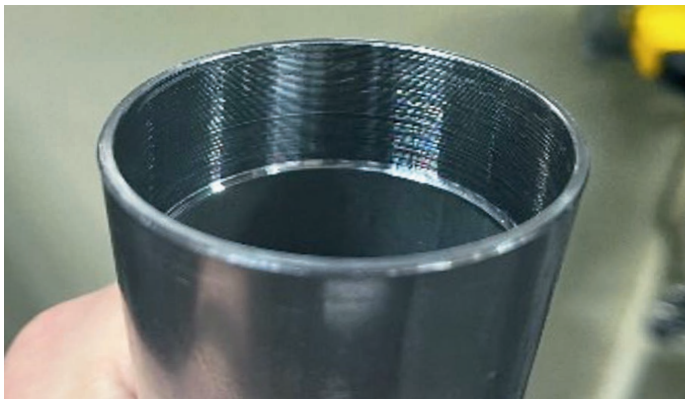
行业	汽车
零件	减震器外壳
应用	车削
材料	C45
冷却液	没有
Dormer Pramet 解决方案	WNMG 08408E-RM:T9425

加工数据		
v_c	f_n	a_p
270	0.35	0.775

P3.3







v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

成功案例

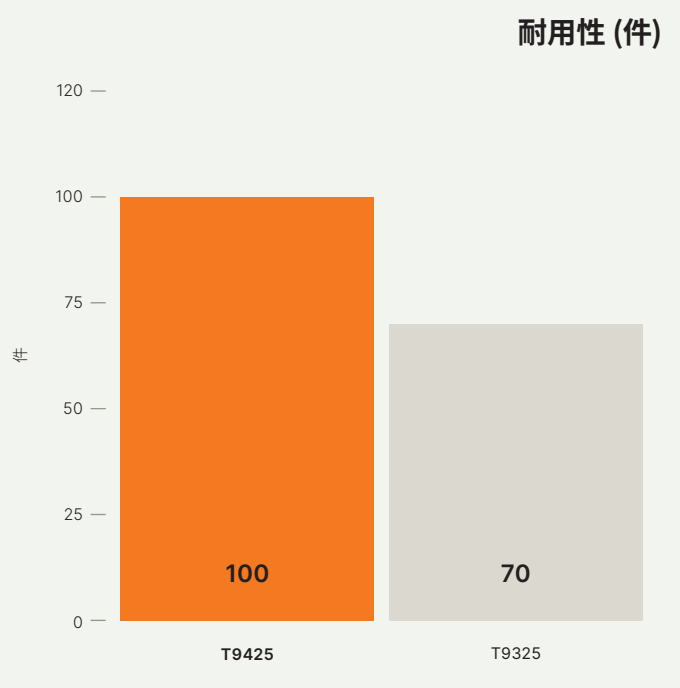
断续切削的耐用性提高 43%

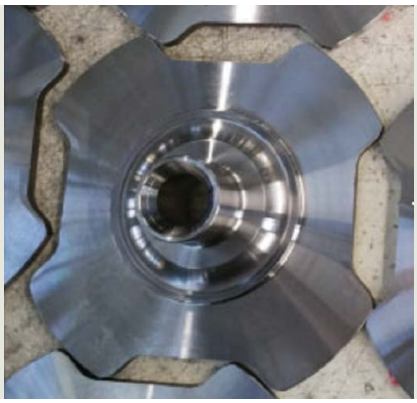
客户成果：通过先进的涂层和后处理，T9425 的刀具寿命比 T9315 提高了 43%。这一改进大大降低了加工过程中的中断次数，延长了加工周期，并提高了在苛刻加工条件下的可靠性。

行业	通用加工
零件	法兰
应用	断续车削
材料	17NiCrMo6 (HB 180–260)
冷却液	是
Dormer Pramet 解决方案	CNMG 120408E-M:T9425

加工数据		
v_c	f_n	a_p
200	0.25	1.5

P3.2





v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

成功案例

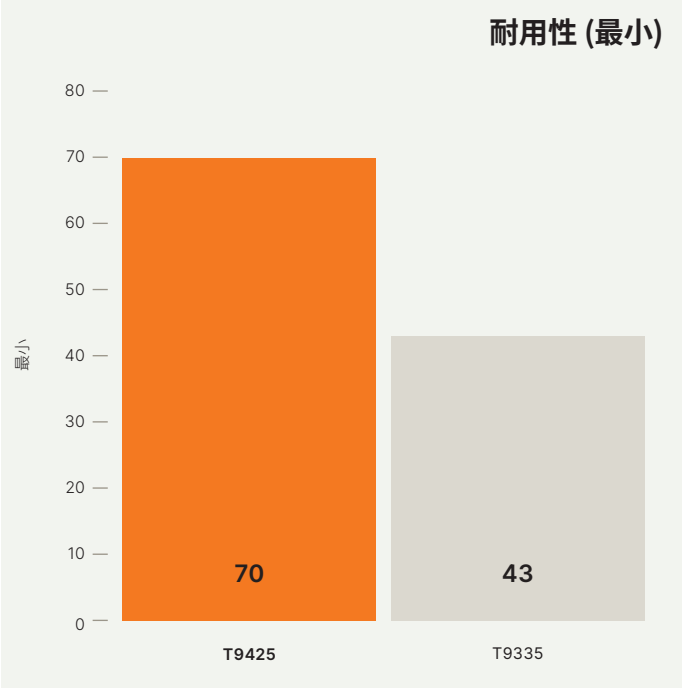
农机加工性能提高 63%

客户成果：T9425 牌号的刀具寿命提高了 63%，证明了其在农业加工任务中的有效性。T9425 每个切削刃口可持续生产 70 个工件，而上一代牌号只能生产 43 个工件，它为刀具的耐用性和可靠性树立了新的标准。它既能保持精度，又能减少停机时间，因此非常适合要求苛刻的农业机械生产环境。

行业	农业
零件	圆盘环
应用	车削
材料	42CrMo
冷却液	是
Dormer Pramet 解决方案	CNMG 120408E-M:T9425

加工数据		
v_c	f_n	a_p
120	0.3	2.5

P3.3



v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

成功案例

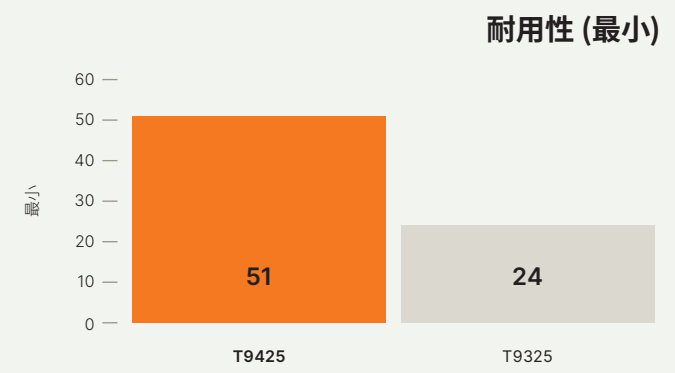
将粗加工的耐用性提高 **112.5**%

客户成果：在粗加工应用中，T9425 的刀具寿命比前一代产品提高了 112.5 %，性能更胜一筹。T9425 能够在具有挑战性的环境中经久耐用，从而减少了更换次数，确保了加工的一致性。这使得 T9425 成为钢材应用领域的首选，因为可靠性和成本效益是关键因素。

行业	能源
零件	轴
应用	车削
材料	42CrMo (HRC 28–32)
冷却液	是
Dormer Pramet 解决方案	CNMM 190616E-OR:T9425

加工数据		
v_c	f_n	a_p
72	0.5	5.0

P3.3



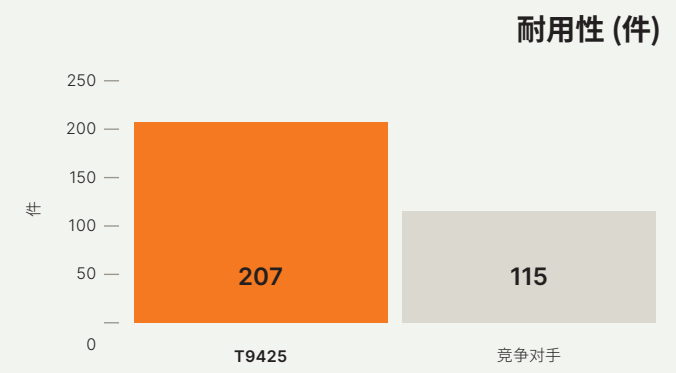
将刀具寿命提高 **80%**在大批量车削中

客户成果：与竞争对手相比，T9425 的刀具寿命延长了 80%，测试期间每把刀具可生产 207 个零件。这种优异的性能使制造商能够减少换刀次数，延长加工周期。这样，T9425 就能帮助节省成本，确保大规模生产过程更加顺畅。

行业	通用加工
零件	销
应用	车削
材料	42CrMo
冷却液	是
Dormer Pramet 解决方案	CNMM 120408E-SM:T9425

加工数据		
v_c	f_n	a_p
200	0.3	2.5

P3.2



v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

加工示例

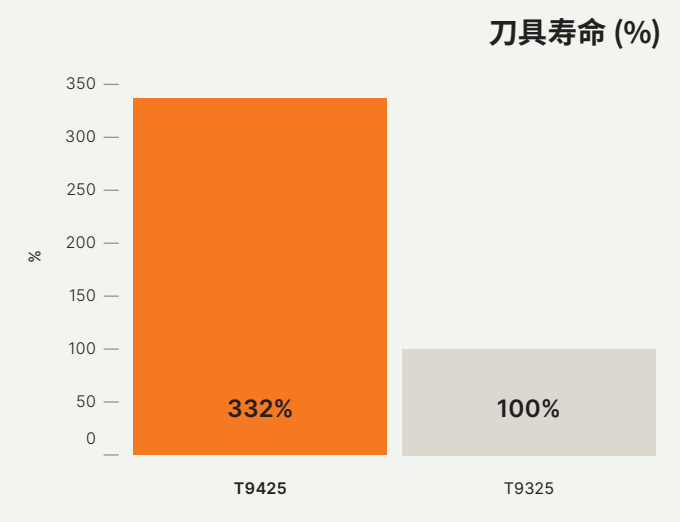
在干车削操作中，将刀具寿命延长 **232%**

新的 T9425 牌号在 C45 钢的干车削中表现出卓越的性能，与 T9325 牌号相比，刀具寿命提高了 232%。这一改进最大限度地减少了更换刀具的需要，直接缩短了停机时间，降低了总体生产成本。

应用	车削
材料	C45
冷却液	没有
Dormer Pramet 解决方案	CNMG 120408E-SM:T9425

加工数据		
v_c	f_n	a_p
315	0.25	2.0

P2.1



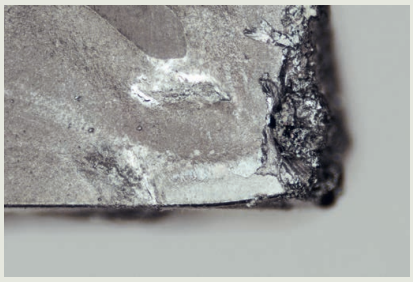
T9425

50 分钟后拍摄的照片

T9425

15 分钟后拍摄的照片

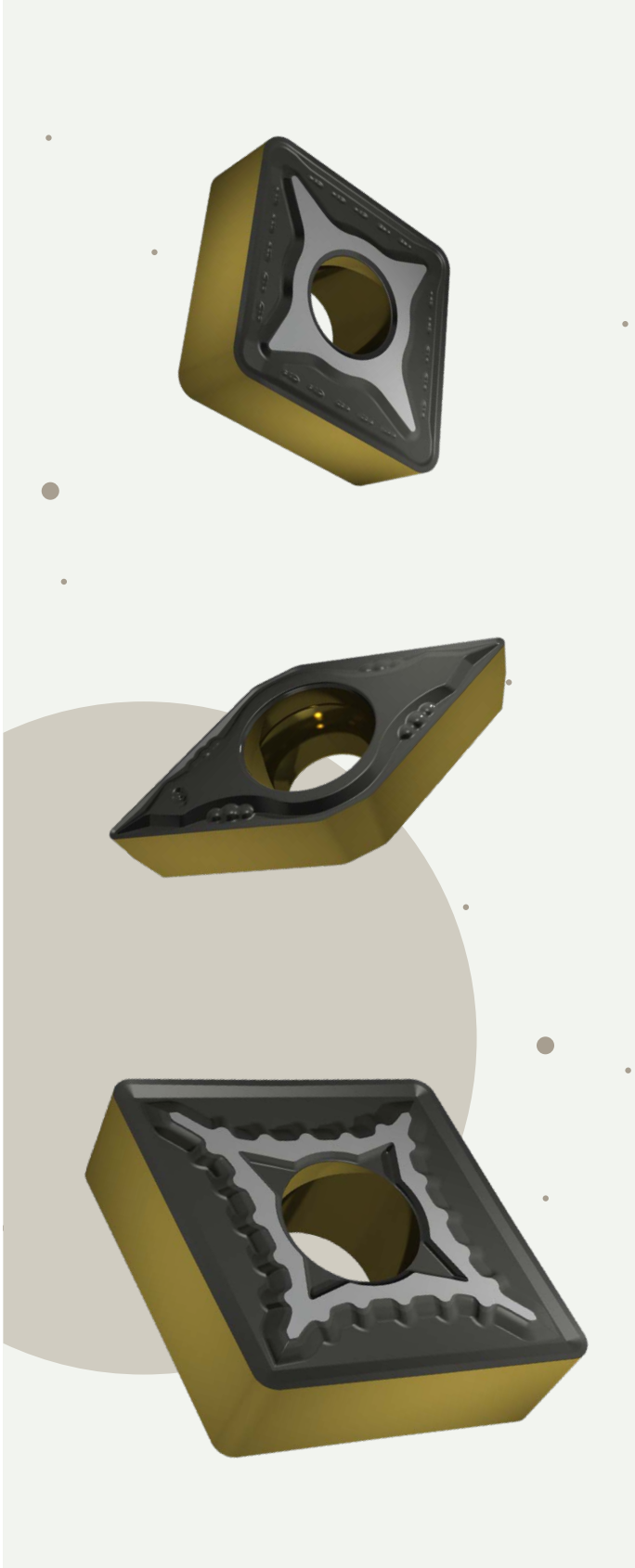
T9325



15 分钟后拍摄的照片

v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

加工示例



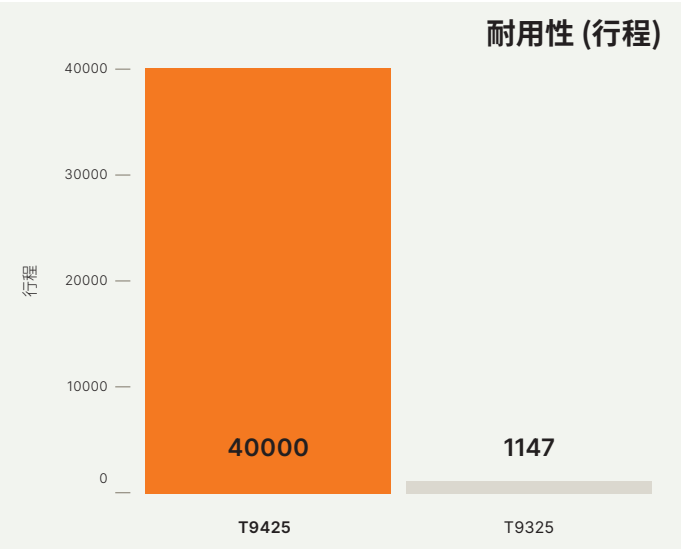
在断续切削作业中具有超强的耐用性

由于采用了新的后处理技术，T9425 在断续切削应用中表现出卓越的性能。这一重大改进延长了刀具寿命，减少了在具有挑战性的加工条件下的停机时间。每个 T9425 刀片都达到了断续切削应用的高标准，因此该牌号非常可靠。

应用	断续切削
材料	41Cr4
冷却液	No
Dormer Pramet 解决方案	CNMG 120408E-SM:T9425

加工数据		
v_c	f_n	a_p
130	0.3	1.0

P2.1



v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

技术信息

T9425 的应用范围和材料兼容性

牌号识别	应用领域	应用	进给	切削速度	耐恶劣工作环境	涂层	颜色	基体	冷却液优势	牌号描述
T9425	P10 - P35	■	▲▲▲▲	▲▲▲▲	▲▲▲▲	MT-CVD		FGM	++	这是一种承载力强、用途广泛的材料，主要用于普通碳钢和合金钢的粗车、半粗车和精车。其特点是在恶劣的切削条件下具有非常好的耐磨性。它适用于中高去除率的工作。这些材料的重点应用领域是中等和更高的切削速度。
	M10 - M30	■								
	K15 - K35	■								
	S10 - S20	◪								

按 ISO 材料类别推荐的牌号

组别	采用 MTCVD 技术的硬质合金	PVD 硬质合金	无涂层硬质合金	CER
P01				TT010
P05	T9415	T8415		
P10	T9415	T8415		
P15	T9415	T8415		
P20	T9425	T8415		TT310
P25	T9425	T8430		TT310
P30	T9425	T8430		TT310
P35	T9425	T8430		TT310
P40		T8430		
P45		T8430		
P50		T8430		

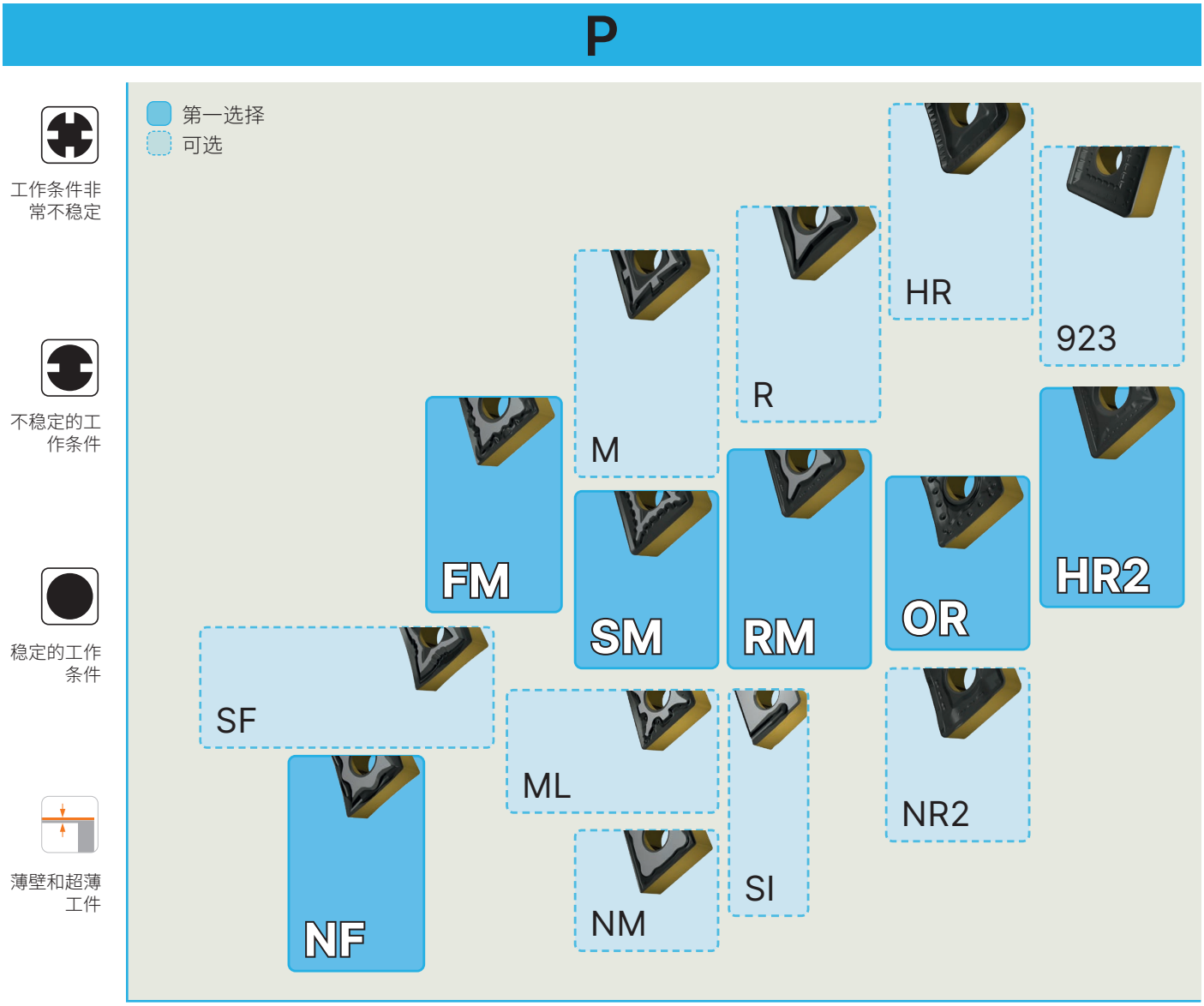
组别	采用 MTCVD 技术的硬质合金	PVD 硬质合金	无涂层硬质合金	CER
M01				
M05				
M10	T7325	T8415		
M15	T7325	T8415		
M20	T7335	T8415		
M25	T7335	T8430		
M30	T7335	T8430		
M35	T7335	T8430		
M40	T7335	T8430		
M45	T7335	T8430		
M50	T7335	T8430		

组别	采用 MTCVD 技术的硬质合金	PVD 硬质合金	无涂层硬质合金	CER
K01				TC100
K05	T5405	T8415		TC100
K10	T5405	T8415		TC100
K15	T5415	T8415		TC100
K20	T5415	T8415	HF7	
K25	T9425	T8415	HF7	
K30	T9425	T8430	HF7	
K35	T9425	T8430		
K40	T9425	T8430		
K45	T9425	T8430		
K50	T9425	T8430		

■推荐使用　◪可以使用

技术信息

用于 T5405 刀片的断屑槽



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

技术信息

用于 T5405 正角刀片的断屑槽

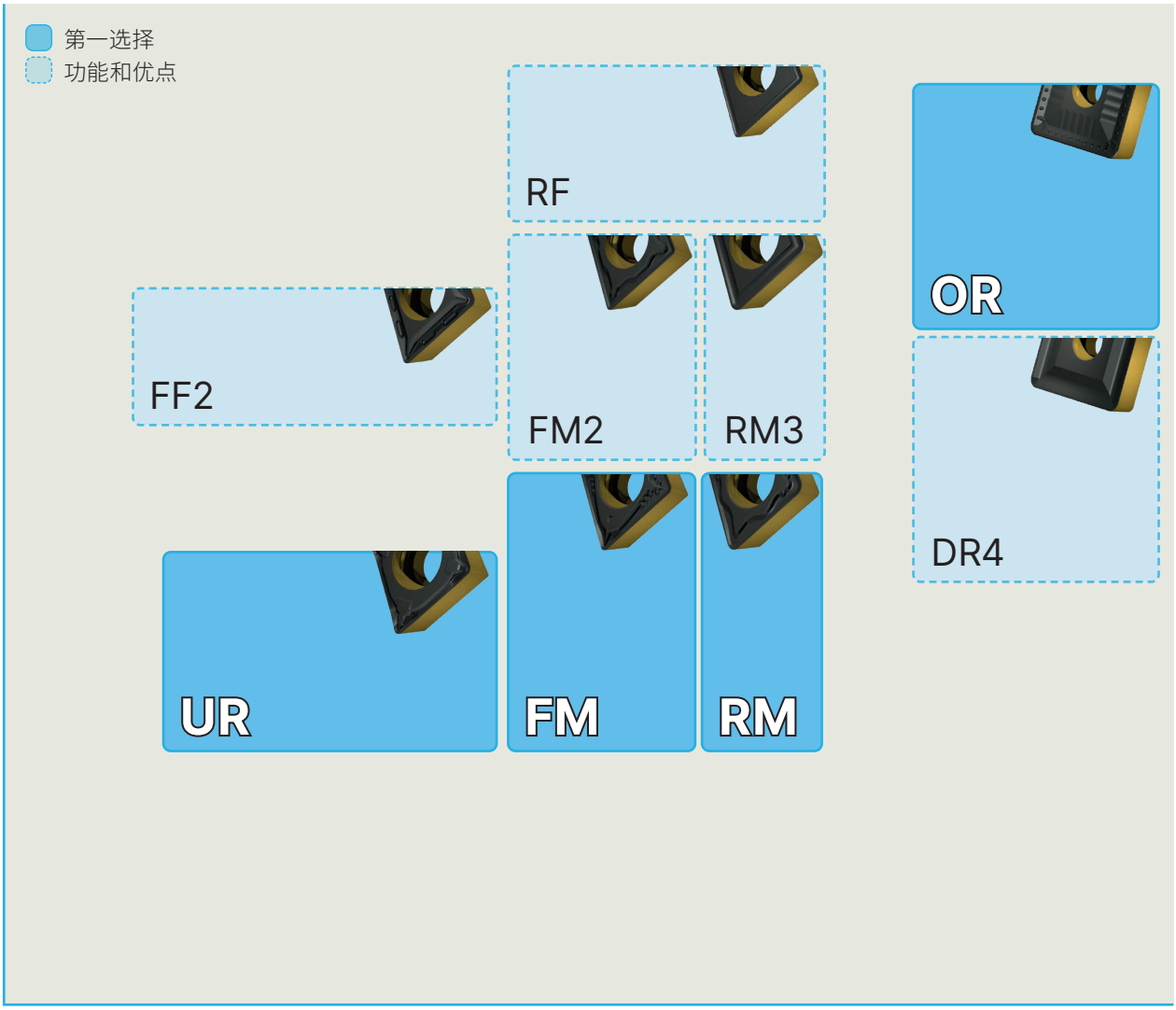
P

工作条件非常不稳定

不稳定的工作条件

稳定的工作条件

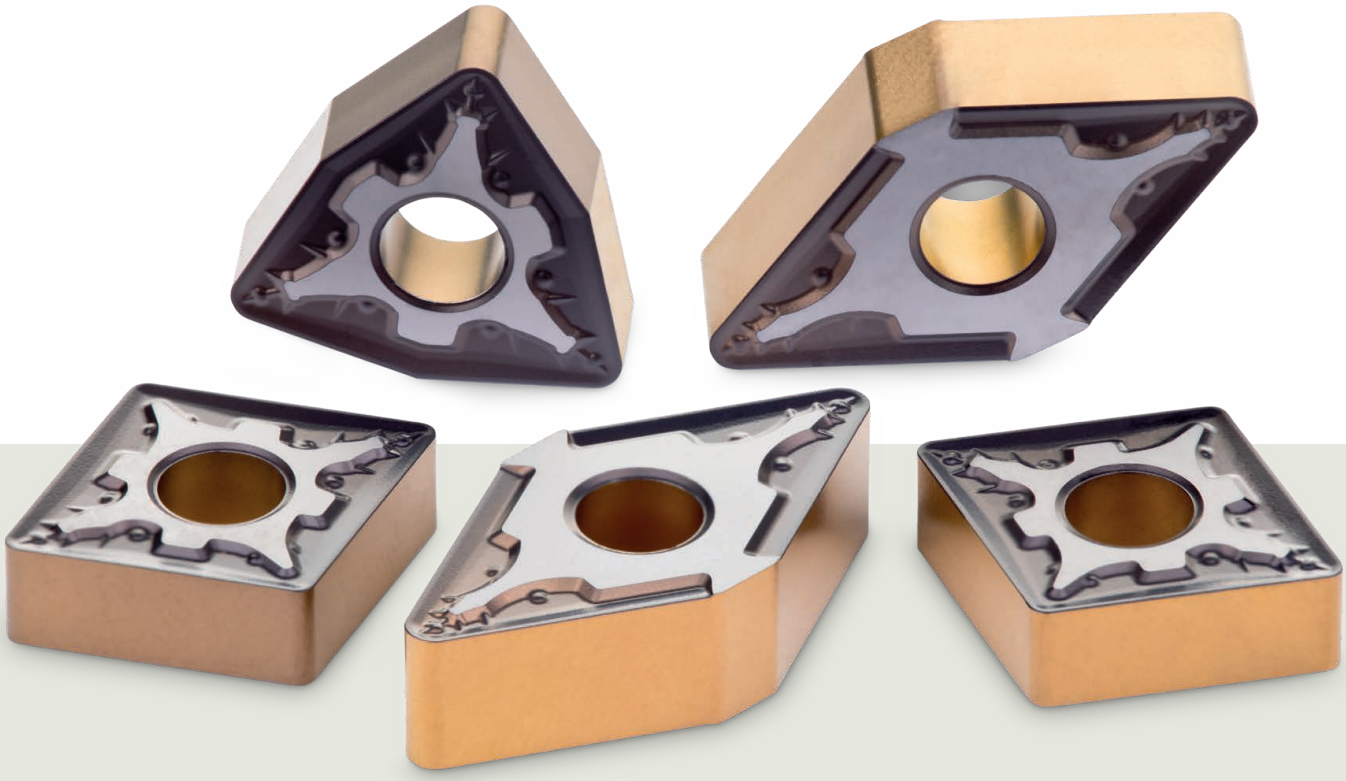
薄壁和超薄工件



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

用于车削钢材的新型断屑槽

提高车削性能

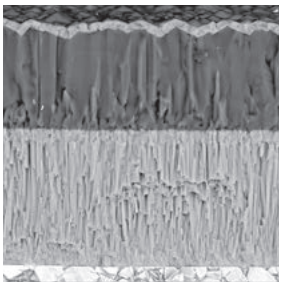


新型 ML 断屑槽专为钢材的中等应用而设计，在低切削深度和中高进给条件下性能优越。其专门开发的几何形状可确保高效的切屑控制和稳定、平稳的加工。

ML 型断屑槽既有新的 T9425牌号，也有 T9415 牌号，具有最大的稳定性、高生产率和可靠的性能，非常适合轴承、汽车和通用加工领域。

相关产品

T9415

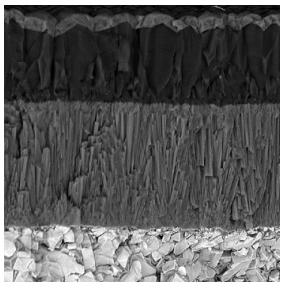


MT-CVD 牌号

耐磨 + 耐热 α-Al_2O_3 层

后刀面外层为 TiN 涂层

T9425

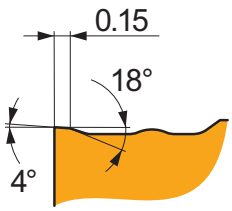


MT-CVD 牌号

高度纹理化 α-Al_2O_3 层

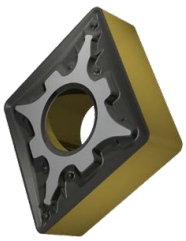
后刀面外层为 TiN 涂层

ML



ML 型断屑槽用途广泛，专为低切削深度和钢材的中型加工而设计。它具有正前角和稳定的窄 T 型面。同样适用于铸铁加工。

CNMG-ML

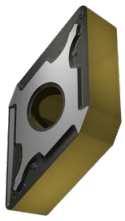


效率刀片

用于钢材

中等到半粗加工

DNMG-ML

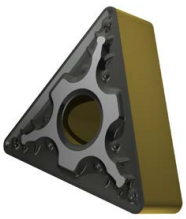


通用刀片

用于钢材

轻度至中度切削

TNMG-ML



通用刀片

用于钢材

轻度至中度切削

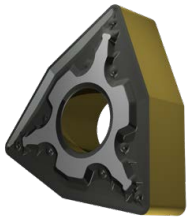
VNMG-ML

通用刀片

用于钢材

轻度切削

WNMG-ML



经济型刀片

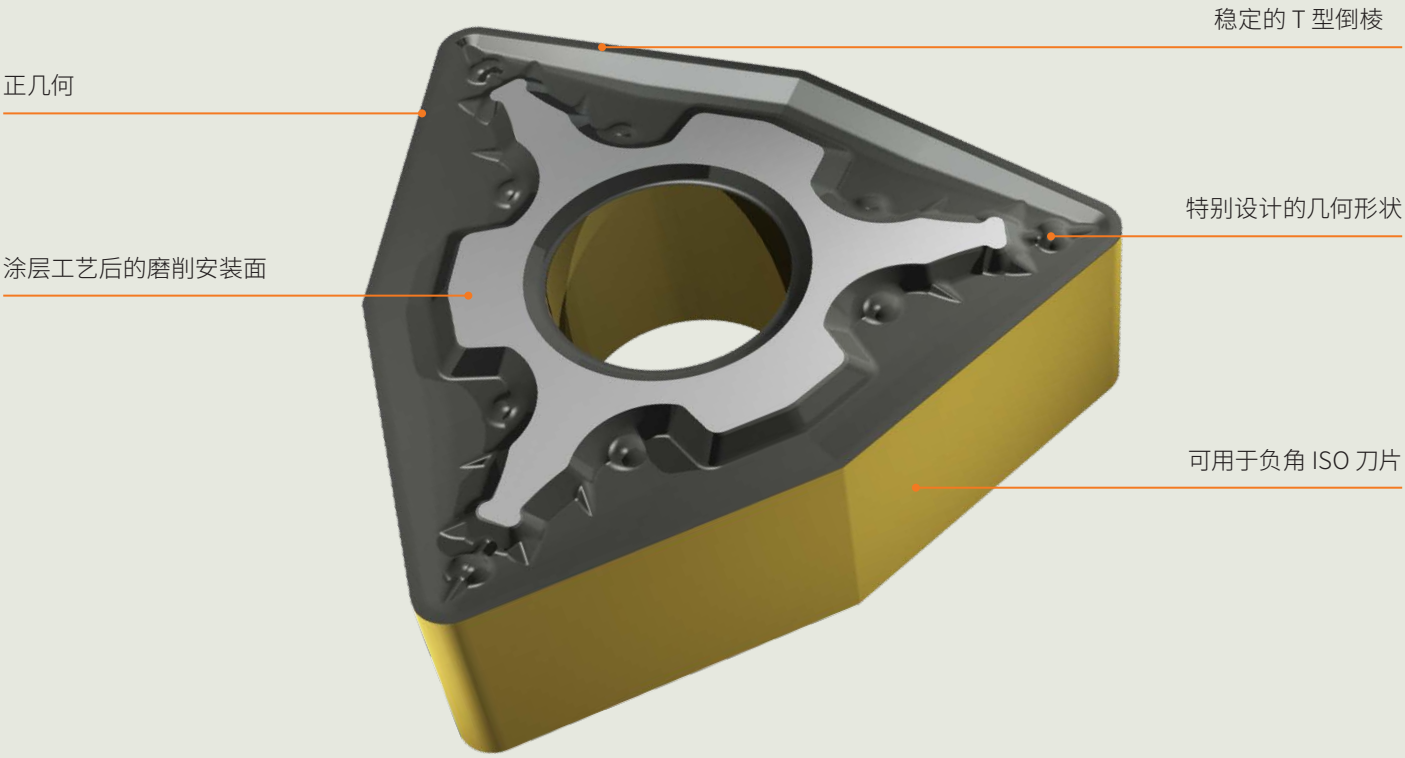
用于钢材

中等到半粗切削

功能和优点

专门设计的几何形状可在低切削深度时高效断屑。	**提高工艺可靠性，延长工具寿命** 减少机器停机时间。
稳定的 T 型倒棱面可确保在中高进给情况下顺利进行加工。	**性能可靠** 确保在苛刻条件下获得高质量的结果。
涂层工艺后的研磨安装面增强了装夹的稳定性。	**一致的结果** 确保每次切削的可预测性。
可提供最新的 CVD 牌号 T9425 和 T9415。	**增强耐用性** 提高生产效率。

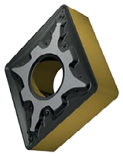
ISO-P 车削的高性能和高生产率

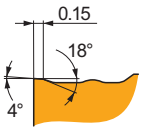


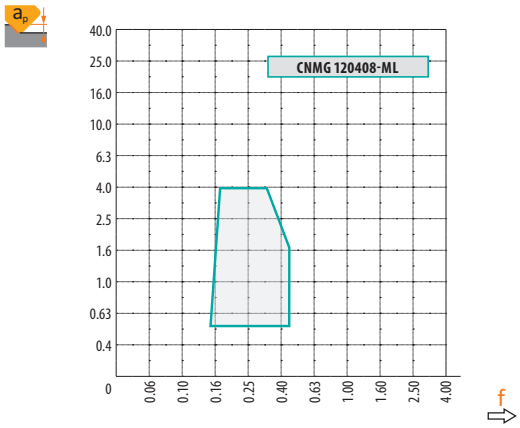
技术信息

ML 断屑槽的应用范围和材料兼容性

ML





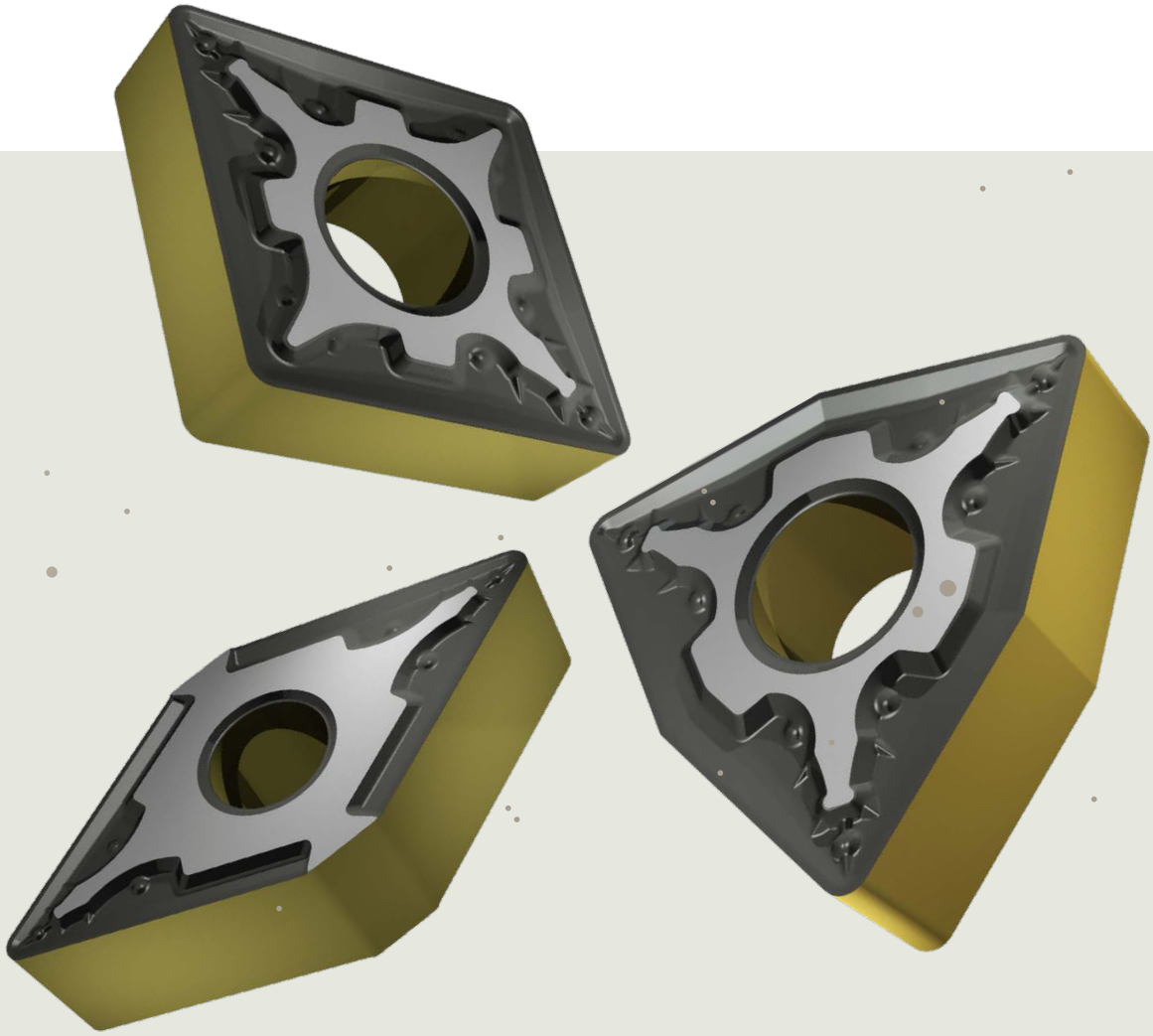


P	M	K	N	S	H
■		■			

f 0.15 – 0.55

a_p 0.3 – 4.0

? CNMG, DNMG, TNMG, VNMG, WNMG



成功案例

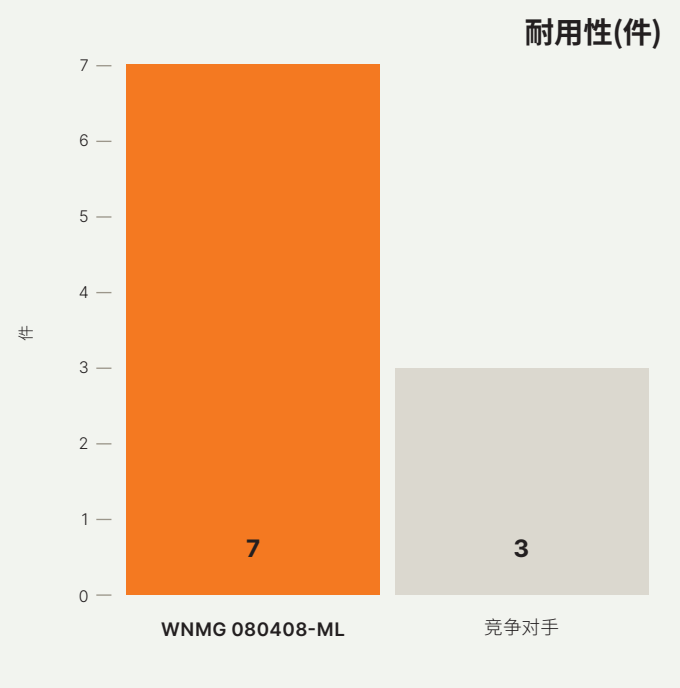
将淬硬钢车削的刀具寿命延长 133%

客户成果：在粗车淬火铁路法兰时，ML 型断屑槽每刃可加工 7 个工件，而竞争对手只能加工 3 个工件。ML 型断屑槽的几何形状降低了切削力，在保持全部生产率的同时，刀具寿命提高了 133%

行业	铁路
应用	粗车
零件	法兰
材料	42CrMo4 (HRC40)
冷却液	是
Dormer Pramet 解决方案	WNMG 080408-ML

加工数据		
v_c	f_n	a_p
297	0.3	2.0

P3.3



v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

成功案例

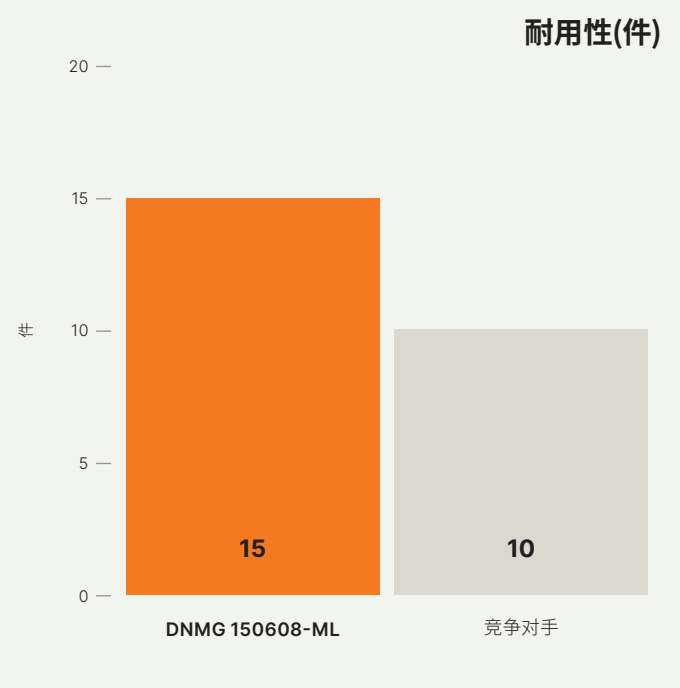
在蜗杆车削中将刀具寿命延长 50%

客户成果：在蜗杆的粗车加工中，ML 型断屑槽每刃可加工 15 个工件，而竞争对手只能加工 10 个工件，刀具寿命延长了 50%。这一改进减少了换刀频率，降低了总体加工成本，并保持了稳定的生产率。

行业	通用加工
应用	粗车
零件	蜗杆轴
材料	40Cr (HB220–270)
冷却液	是
Dormer Pramet 解决方案	DNMG 150608-ML

加工数据		
v_c	f_n	a_p
146	0.3	2.0

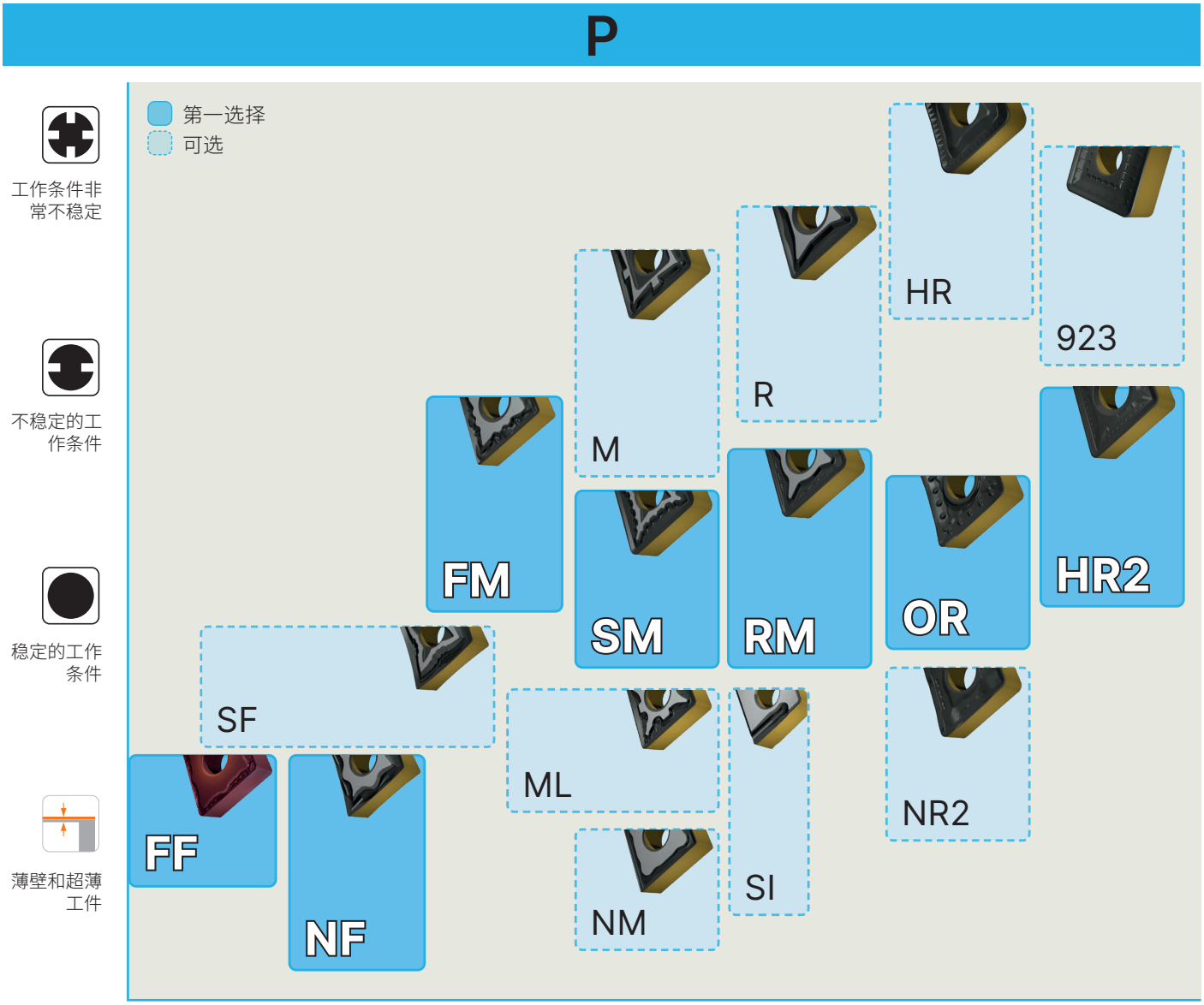
P3.2



v_c = 切削速度（米/分），f_n = 每转进给量（毫米/转），a_p = 切削深度（毫米）

技术信息

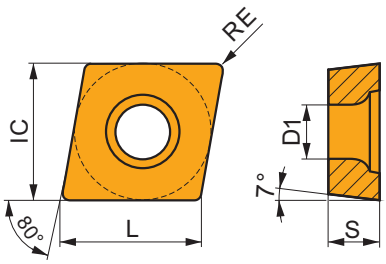
ISO 刀片负角槽型导航仪



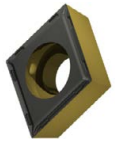
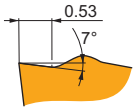
	FF	F	M	R	HR
f	0.05 – 0.2 毫米/转		0.2 – 0.4 毫米/转	0.4 – 1.0 毫米/转	> 1.0 毫米/转
a_p	0.05 – 2 毫米		2 – 4 毫米	4 – 10 毫米	> 10 毫米

CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.70	3.97

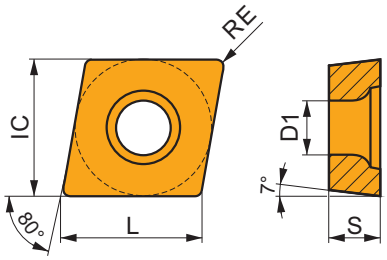


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

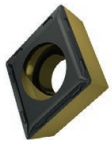
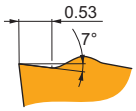
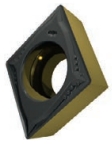
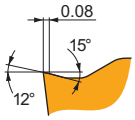
产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
FF2 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。																				
CCGT 09T302E-FF2:T9425	●	0.2	■ 455	0.05	1.0	–	–	–	■ 430	0.05	1.0	–	–	–	–	–	–	–	–	–

CCMT

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

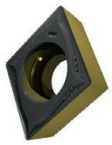
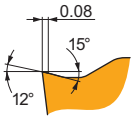


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

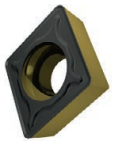
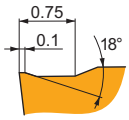
产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
FF2 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。																				
CCMT 060202E-FF2:T9425	●	0.2	■ 465	0.05	0.8	–	–	–	■ 440	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T9425	●	0.4	■ 365	0.12	1.0	–	–	–	■ 345	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080302E-FF2:T9425	●	0.2	■ 465	0.05	0.8	–	–	–	■ 440	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:T9425	●	0.4	■ 365	0.12	1.0	–	–	–	■ 345	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FF2:T9425	●	0.8	■ 385	0.17	1.0	–	–	–	■ 365	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T9425	●	0.4	■ 360	0.12	1.2	–	–	–	■ 340	0.12	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:T9425	●	0.8	■ 380	0.17	1.2	–	–	–	■ 360	0.17	1.2	–	–	–	–	–	–	–	–	–
 																				
FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。																				
CCMT 060202E-FM:T9425	●	0.2	■ 400	0.10	1.0	■ 240	0.09	1.0	◪ 380	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FM:T9425	●	0.4	■ 375	0.15	1.0	■ 225	0.15	1.0	◪ 355	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-FM:T9425	●	0.8	■ 400	0.20	1.0	■ 240	0.18	1.0	◪ 380	0.20	1.0	–	–	–	–	–	–	–	–	–

● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

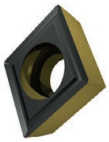
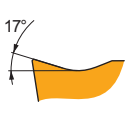
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
CCMT 09T302E-FM:T9425	●	0.2	■ 390	0.10	1.2	■ 230	0.09	1.2	◪ 370	0.10	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM:T9425	●	0.4	■ 365	0.15	1.2	■ 215	0.15	1.2	◪ 345	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM:T9425	●	0.8	■ 395	0.20	1.2	■ 235	0.18	1.2	◪ 375	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 120404E-FM:T9425	●	0.4	■ 355	0.15	1.7	■ 210	0.15	1.7	◪ 335	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM:T9425	●	0.8	■ 385	0.20	1.7	■ 230	0.18	1.7	◪ 365	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-FM:T9425	⇕	1.2	■ 365	0.27	1.7	■ 215	0.24	1.7	◪ 345	0.27	1.7	–	–	–	–	–	–	–	–	–

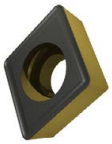
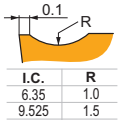
FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。

 																				
CCMT 080304E-FM2:T9425	●	0.4	■ 365	0.12	1.0	◪ 215	0.11	1.0	■ 345	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2:T9425	⇕	0.8	■ 385	0.17	1.0	◪ 230	0.15	1.0	■ 365	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T9425	●	0.4	■ 365	0.12	1.0	◪ 215	0.11	1.0	■ 345	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T9425	⇕	0.8	■ 385	0.17	1.0	◪ 230	0.15	1.0	■ 365	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T9425	⇕	0.8	■ 350	0.20	1.5	◪ 210	0.18	1.5	■ 330	0.20	1.5	–	–	–	–	–	–	–	–	–

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

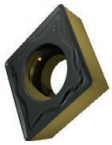
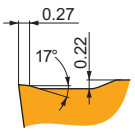
 																				
CCMT 060202E-NF2:T9425	●	0.2	◪ 370	0.10	0.8	■ 220	0.09	0.8	◪ 350	0.10	0.8	–	–	–	◪ 80	0.08	0.6	–	–	–
CCMT 060204E-NF2:T9425	●	0.4	◪ 370	0.12	0.8	■ 220	0.11	0.8	◪ 350	0.12	0.8	–	–	–	◪ 80	0.11	0.6	–	–	–
CCMT 080304E-NF2:T9425	●	0.4	◪ 365	0.12	1.0	■ 215	0.11	1.0	◪ 345	0.12	1.0	–	–	–	◪ 80	0.11	0.8	–	–	–
CCMT 080308E-NF2:T9425	⇕	0.8	◪ 385	0.17	1.0	■ 230	0.15	1.0	◪ 365	0.17	1.0	–	–	–	◪ 85	0.14	0.8	–	–	–
CCMT 09T304E-NF2:T9425	●	0.4	◪ 360	0.12	1.2	■ 215	0.11	1.2	◪ 340	0.12	1.2	–	–	–	◪ 80	0.11	1.0	–	–	–
CCMT 09T308E-NF2:T9425	⇕	0.8	◪ 405	0.14	1.2	■ 240	0.13	1.2	◪ 380	0.14	1.2	–	–	–	◪ 90	0.13	1.0	–	–	–

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

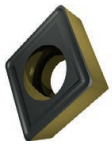
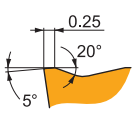
 																				
CCMT 060204E-RF:T9425	●	0.4	■ 305	0.15	1.0	◪ 180	0.15	1.0	■ 285	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-RF:T9425	●	0.4	■ 265	0.20	1.5	◪ 155	0.18	1.5	■ 250	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 09T308E-RF:T9425	●	0.8	■ 315	0.20	1.5	◪ 185	0.18	1.5	■ 295	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-RF:T9425	●	0.8	■ 295	0.22	2.2	◪ 175	0.22	2.2	■ 280	0.22	2.2	–	–	–	–	–	–	–	–	–

I.C.	R
6.35	1.0
9.525	1.5
12.7	2.5

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

 																				
CCMT 09T304E-RM:T9425	●	0.4	■ 305	0.25	2.2	■ 180	0.23	2.2	■ 285	0.25	2.2	–	–	–	◪ 65	0.18	1.8	–	–	–
CCMT 09T308E-RM:T9425	⇕	0.8	■ 340	0.30	2.2	■ 200	0.27	2.2	■ 320	0.30	2.2	–	–	–	◪ 75	0.24	1.8	–	–	–
CCMT 09T312E-RM:T9425	⇕	1.2	■ 350	0.33	2.2	■ 210	0.30	2.2	■ 330	0.33	2.2	–	–	–	◪ 75	0.23	1.8	–	–	–
CCMT 120408E-RM:T9425	⇕	0.8	■ 330	0.30	2.7	■ 195	0.27	2.7	■ 310	0.30	2.7	–	–	–	◪ 70	0.24	2.2	–	–	–
CCMT 120412E-RM:T9425	⇕	1.2	■ 340	0.33	2.7	■ 200	0.30	2.7	■ 320	0.33	2.7	–	–	–	◪ 75	0.23	2.2	–	–	–

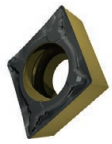
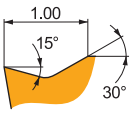
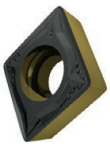
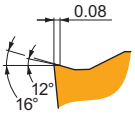
RM 型断屑槽坚固耐用，是钢和铸铁粗加工的首选。它具有正前角和稳定开放的 T 倒棱。它还适用于不锈钢，并有条件地适用于超级合金和硬质材料。

 																				
CCMT 120404E-RM3:T9425	●	0.4	■ 260	0.25	2.5	◪ 155	0.25	2.5	■ 245	0.25	2.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-RM3:T9425	⇕	0.8	■ 300	0.27	2.5	◪ 180	0.27	2.5	■ 285	0.27	2.5	–	–	–	–	–	–	–	–	–

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

● 适用于稳定工况　⇕ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

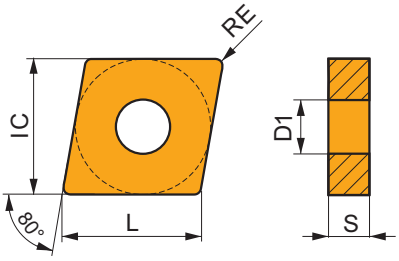
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。																				
CCMT 060202E-UR:T9425	●	0.2	■ 350	0.10	0.8	◪ 210	0.09	0.8	■ 330	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T9425	●	0.4	■ 320	0.15	1.0	◪ 190	0.15	1.0	■ 300	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T9425	●	0.8	■ 345	0.20	1.0	◪ 205	0.18	1.0	■ 325	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T9425	●	0.4	■ 315	0.15	1.2	◪ 185	0.15	1.2	■ 295	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T9425	●	0.8	■ 345	0.20	1.2	◪ 205	0.18	1.2	■ 325	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T9425	●	0.4	■ 305	0.15	1.7	◪ 180	0.15	1.7	■ 285	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T9425	●	0.8	■ 330	0.20	1.7	◪ 195	0.18	1.7	■ 310	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T9425	⇕	1.2	■ 315	0.27	1.7	◪ 185	0.24	1.7	■ 295	0.27	1.7	–	–	–	–	–	–	–	–	–
 																				
W-FM 型断屑槽具有修光刃，专为钢材、不锈钢和铸铁的精加工而设计。它具有正前角和正窄 T 倒棱。																				
CCMT 060204W-FM:T9425	●	0.4	■ 300	0.30	0.8	■ 180	0.27	0.8	■ 285	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM:T9425	●	0.4	■ 300	0.30	0.8	■ 180	0.27	0.8	■ 285	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T308W-FM:T9425	●	0.8	■ 320	0.40	1.0	■ 190	0.36	1.0	■ 300	0.40	1.0	–	–	–	–	–	–	–	–	–

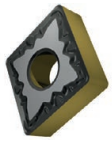
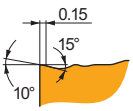
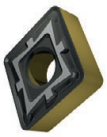
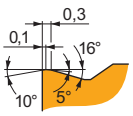
CNMG

DORMER 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	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53

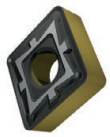
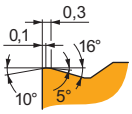
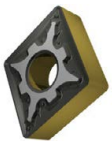
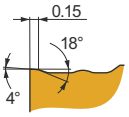
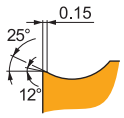
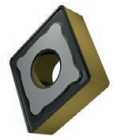
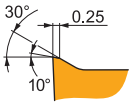
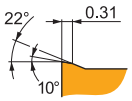


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
FM 断屑槽用途广泛，是钢和铸铁精加工的首选。它的特点是小正前角和窄的T-型倒棱。也有条件地适用于不锈钢和耐热合金。																				
CNMG 090304E-FM:T9425	●	0.4	■ 365	0.20	1.4	◪ 215	0.18	1.4	■ 345	0.20	1.4	–	–	–	◪ 80	0.16	1.1	–	–	–
CNMG 090308E-FM:T9425	●	0.8	■ 430	0.20	1.4	◪ 255	0.18	1.4	■ 405	0.20	1.4	–	–	–	◪ 95	0.16	1.1	–	–	–
CNMG 120404E-FM:T9425	●	0.4	■ 350	0.20	2.1	◪ 210	0.18	2.1	■ 330	0.20	2.1	–	–	–	◪ 75	0.16	1.7	–	–	–
CNMG 120408E-FM:T9425	●	0.8	■ 415	0.20	2.1	◪ 245	0.18	2.1	■ 390	0.20	2.1	–	–	–	◪ 90	0.16	1.7	–	–	–
CNMG 120412E-FM:T9425	⇕	1.2	■ 400	0.27	2.1	◪ 240	0.24	2.1	■ 380	0.27	2.1	–	–	–	◪ 90	0.19	1.7	–	–	–
 																				
M 型断屑槽用途广泛，是铸铁中型加工的首选。它具有正前角和负/稳定、适中的 T 倒棱。它也适用于钢材和有条件的硬质材料。																				
CNMG 090308E-M:T9425	⇕	0.8	■ 330	0.32	1.8	–	–	–	■ 310	0.32	1.8	–	–	–	–	–	–	–	–	–
CNMG 120404E-M:T9425	●	0.4	■ 320	0.20	2.1	–	–	–	■ 300	0.20	2.1	–	–	–	–	–	–	–	–	–
CNMG 120408E-M:T9425	⇕	0.8	■ 325	0.32	2.1	–	–	–	■ 305	0.32	2.1	–	–	–	–	–	–	–	–	–
CNMG 120412E-M:T9425	⇕	1.2	■ 320	0.40	2.1	–	–	–	■ 300	0.40	2.1	–	–	–	–	–	–	–	–	–
CNMG 120416E-M:T9425	⇕	1.6	■ 335	0.40	2.1	–	–	–	■ 315	0.40	2.1	–	–	–	–	–	–	–	–	–

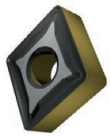
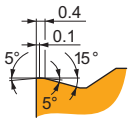
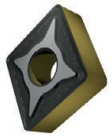
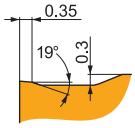
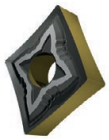
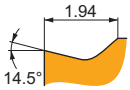
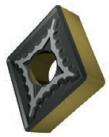
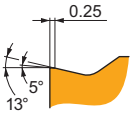
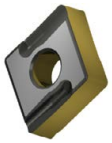
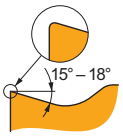
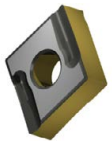
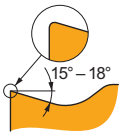
● 适用于稳定工况　⇕ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

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

产品	● ⇔ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  M 型断屑槽用途广泛，是铸铁中型加工的首选。它具有正前角和负/稳定、适中的 T 倒棱。它也适用于钢材和有条件的硬质材料。																							
CNMG 160608E-M:T9425	⇔	0.8	■ 305	0.32	3.6	–	–	–	■ 285	0.32	3.6	–	–	–	–	–	–	–	–	–
CNMG 160612E-M:T9425	⇔	1.2	■ 305	0.40	3.6	–	–	–	■ 285	0.40	3.6	–	–	–	–	–	–	–	–	–
CNMG 160616E-M:T9425	⇔	1.6	■ 320	0.40	3.6	–	–	–	■ 300	0.40	3.6	–	–	–	–	–	–	–	–	–
CNMG 190608E-M:T9425	⇔	0.8	■ 300	0.32	4.2	–	–	–	■ 285	0.32	4.2	–	–	–	–	–	–	–	–	–
CNMG 190612E-M:T9425	⇔	1.2	■ 300	0.40	4.2	–	–	–	■ 285	0.40	4.2	–	–	–	–	–	–	–	–	–
CNMG 190616E-M:T9425	⇔	1.6	■ 315	0.40	4.2	–	–	–	■ 295	0.40	4.2	–	–	–	–	–	–	–	–	–
  ML 型断屑槽用途广泛，专为低切削深度和钢材的中型加工而设计。它具有正前角和稳定的窄 T 型面。同样适用于铸铁加工。																							
CNMG 120404-ML:T9415	●	0.4	■ 365	0.20	1.0	–	–	–	◪ 345	0.20	1.0	–	–	–	–	–	–	–	–	–
CNMG 120404-ML:T9425	●	0.4	■ 340	0.20	1.0	–	–	–	■ 320	0.20	1.0	–	–	–	–	–	–	–	–	–
CNMG 120408-ML:T9415	⇔	0.8	■ 380	0.25	1.5	–	–	–	◪ 360	0.25	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408-ML:T9425	⇔	0.8	■ 365	0.25	1.5	–	–	–	■ 345	0.25	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412-ML:T9415	⇔	1.2	■ 360	0.30	2.0	–	–	–	◪ 340	0.30	2.0	–	–	–	–	–	–	–	–	–
CNMG 120412-ML:T9425	⇔	1.2	■ 355	0.30	2.0	–	–	–	■ 335	0.30	2.0	–	–	–	–	–	–	–	–	–
 NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。																							
CNMG 090304E-NF:T9425	●	0.4	■ 400	0.18	0.8	■ 240	0.16	0.8	◪ 380	0.18	0.8	–	–	–	◪ 90	0.16	0.6	–	–	–
CNMG 090308E-NF:T9425	●	0.8	■ 455	0.19	1.0	■ 270	0.17	1.0	◪ 430	0.19	1.0	–	–	–	◪ 100	0.15	0.8	–	–	–
CNMG 120404E-NF:T9425	●	0.4	■ 370	0.18	1.7	■ 220	0.16	1.7	◪ 350	0.18	1.7	–	–	–	◪ 80	0.16	1.4	–	–	–
CNMG 120408E-NF:T9425	⇔	0.8	■ 430	0.19	1.7	■ 255	0.17	1.7	◪ 405	0.19	1.7	–	–	–	◪ 95	0.15	1.4	–	–	–
CNMG 120412E-NF:T9425	⇔	1.2	■ 385	0.30	2.1	■ 230	0.27	2.1	◪ 365	0.30	2.1	–	–	–	◪ 85	0.21	1.7	–	–	–
  NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。																							
CNMG 120404E-NM:T9425	●	0.4	■ 365	0.20	2.1	■ 215	0.18	2.1	–	–	–	–	–	–	◪ 80	0.16	1.7	–	–	–
CNMG 120408E-NM:T9425	⇔	0.8	■ 400	0.25	2.1	■ 240	0.23	2.1	–	–	–	–	–	–	◪ 90	0.20	1.7	–	–	–
CNMG 120412E-NM:T9425	⇔	1.2	■ 400	0.30	2.1	■ 240	0.27	2.1	–	–	–	–	–	–	◪ 90	0.24	1.7	–	–	–
CNMG 160608E-NM:T9425	⇔	0.8	■ 360	0.30	3.6	■ 215	0.27	3.6	–	–	–	–	–	–	◪ 80	0.27	2.9	–	–	–
CNMG 160612E-NM:T9425	⇔	1.2	■ 375	0.30	3.6	■ 225	0.27	3.6	–	–	–	–	–	–	◪ 80	0.27	2.9	–	–	–
CNMG 190612E-NM:T9425	⇔	1.2	■ 355	0.35	4.2	■ 210	0.32	4.2	–	–	–	–	–	–	◪ 75	0.32	3.4	–	–	–
 NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																							
CNMG 120404E-NMR:T9425	●	0.4	■ 300	0.25	2.0	■ 180	0.23	2.0	–	–	–	–	–	–	◪ 65	0.20	1.6	–	–	–
CNMG 120408E-NMR:T9425	⇔	0.8	■ 305	0.35	2.7	■ 180	0.32	2.7	–	–	–	–	–	–	◪ 65	0.25	2.2	–	–	–
CNMG 120412E-NMR:T9425	⇔	1.2	■ 310	0.40	2.7	■ 185	0.36	2.7	–	–	–	–	–	–	◪ 65	0.28	2.2	–	–	–
CNMG 160608E-NMR:T9425	⇔	0.8	■ 295	0.35	4.0	■ 175	0.32	4.0	–	–	–	–	–	–	◪ 65	0.25	3.2	–	–	–
CNMG 160612E-NMR:T9425	⇔	1.2	■ 300	0.40	4.0	■ 180	0.36	4.0	–	–	–	–	–	–	◪ 65	0.28	3.2	–	–	–
CNMG 160616E-NMR:T9425	⇔	1.6	■ 300	0.45	4.0	■ 180	0.41	4.0	–	–	–	–	–	–	◪ 65	0.32	3.2	–	–	–
CNMG 190608E-NMR:T9425	⇔	0.8	■ 285	0.35	5.2	■ 170	0.32	5.2	–	–	–	–	–	–	◪ 60	0.25	4.2	–	–	–
CNMG 190612E-NMR:T9425	⇔	1.2	■ 290	0.40	5.2	■ 170	0.36	5.2	–	–	–	–	–	–	◪ 65	0.28	4.2	–	–	–
CNMG 190616E-NMR:T9425	⇔	1.6	■ 290	0.45	5.2	■ 170	0.41	5.2	–	–	–	–	–	–	◪ 65	0.32	4.2	–	–	–

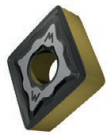
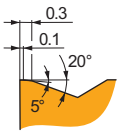
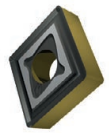
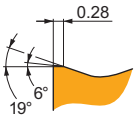
● 适用于稳定工况　⇔ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

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

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																				
CNMG 120408E-R:T9425	⬌	0.8	■ 285	0.40	4.0	–	–	–	■ 270	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-R:T9425	⬌	1.2	■ 290	0.45	4.0	–	–	–	■ 275	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120416E-R:T9425	⬌	1.6	■ 290	0.50	4.0	–	–	–	■ 275	0.50	4.0	–	–	–	–	–	–	–	–	–
CNMG 160612E-R:T9425	⬌	1.2	■ 280	0.45	5.5	–	–	–	■ 265	0.45	5.5	–	–	–	–	–	–	–	–	–
CNMG 160616E-R:T9425	✱	1.6	■ 280	0.50	5.5	–	–	–	■ 265	0.50	5.5	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T9425	⬌	1.2	■ 275	0.45	7.0	–	–	–	■ 260	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:T9425	✱	1.6	■ 275	0.50	7.0	–	–	–	■ 260	0.50	7.0	–	–	–	–	–	–	–	–	–
 																				
RM 断屑槽坚固耐用，是钢件粗加工的首选。具有正前角和宽的稳定T-型倒棱。还适用于不锈钢、铸铁，有条件的用于耐热合金。																				
CNMG 120408E-RM:T9425	⬌	0.8	■ 325	0.40	4.0	■ 195	0.36	4.0	■ 305	0.40	4.0	–	–	–	◩ 70	0.28	3.2	–	–	–
CNMG 120412E-RM:T9425	⬌	1.2	■ 330	0.45	4.0	■ 195	0.41	4.0	■ 310	0.45	4.0	–	–	–	◩ 70	0.32	3.2	–	–	–
CNMG 120416E-RM:T9425	⬌	1.6	■ 335	0.50	4.0	■ 200	0.45	4.0	■ 315	0.50	4.0	–	–	–	◩ 75	0.35	3.2	–	–	–
CNMG 160608E-RM:T9425	⬌	0.8	■ 315	0.40	6.0	■ 185	0.36	6.0	■ 295	0.40	6.0	–	–	–	◩ 70	0.28	4.8	–	–	–
CNMG 160612E-RM:T9425	⬌	1.2	■ 315	0.45	6.0	■ 185	0.41	6.0	■ 295	0.45	6.0	–	–	–	◩ 70	0.32	4.8	–	–	–
CNMG 160616E-RM:T9425	⬌	1.6	■ 325	0.50	6.0	■ 195	0.45	6.0	■ 305	0.50	6.0	–	–	–	◩ 70	0.35	4.8	–	–	–
CNMG 190608E-RM:T9425	⬌	0.8	■ 305	0.40	7.5	■ 180	0.36	7.5	■ 285	0.40	7.5	–	–	–	◩ 65	0.28	6.0	–	–	–
CNMG 190612E-RM:T9425	⬌	1.2	■ 310	0.45	7.5	■ 185	0.41	7.5	■ 290	0.45	7.5	–	–	–	◩ 65	0.32	6.0	–	–	–
CNMG 190616E-RM:T9425	⬌	1.6	■ 310	0.50	7.5	■ 185	0.45	7.5	■ 290	0.50	7.5	–	–	–	◩ 65	0.35	6.0	–	–	–
CNMG 190624E-RM:T9425	⬌	2.4	■ 325	0.50	7.5	■ 195	0.45	7.5	■ 305	0.50	7.5	–	–	–	◩ 70	0.35	6.0	–	–	–
CNMG 250924E-RM:T9425	⬌	2.4	■ 150	0.80	12.0	■ 90	0.72	12.0	■ 140	0.80	12.0	–	–	–	◩ 30	0.56	9.6	–	–	–
 																				
SF 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。特点是小正前角，无T-型倒棱。还适用于钢、铸铁和硬质材料，有条件时也适用于有色金属合金。																				
CNMG 120404E-SF:T9425	●	0.4	■ 380	0.17	1.0	■ 225	0.15	1.0	■ 360	0.17	1.0	–	–	–	◩ 85	0.15	0.8	–	–	–
CNMG 120408E-SF:T9425	⬌	0.8	■ 425	0.20	1.0	■ 255	0.18	1.0	■ 400	0.20	1.0	–	–	–	◩ 95	0.16	0.8	–	–	–
 																				
SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。																				
CNMG 120404E-SM:T9425	●	0.4	■ 335	0.20	2.0	■ 200	0.18	2.0	■ 315	0.20	2.0	–	–	–	◩ 75	0.18	1.6	–	–	–
CNMG 120408E-SM:T9425	⬌	0.8	■ 370	0.25	2.0	■ 220	0.23	2.0	■ 350	0.25	2.0	–	–	–	◩ 80	0.20	1.6	–	–	–
CNMG 120412E-SM:T9425	⬌	1.2	■ 370	0.30	2.0	■ 220	0.27	2.0	■ 350	0.30	2.0	–	–	–	◩ 80	0.24	1.6	–	–	–
CNMG 160608E-SM:T9425	⬌	0.8	■ 350	0.26	3.0	■ 210	0.23	3.0	■ 330	0.26	3.0	–	–	–	◩ 75	0.23	2.4	–	–	–
CNMG 160612E-SM:T9425	⬌	1.2	■ 355	0.30	3.0	■ 210	0.27	3.0	■ 335	0.30	3.0	–	–	–	◩ 75	0.27	2.4	–	–	–
CNMG 190612E-SM:T9425	⬌	1.2	■ 345	0.30	4.0	■ 205	0.27	4.0	■ 325	0.30	4.0	–	–	–	◩ 75	0.27	3.2	–	–	–
 																				
SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。																				
CNMG 120404ER-SI:T9425	●	0.4	■ 410	0.20	1.7	■ 245	0.18	1.7	–	–	–	–	–	–	◩ 90	0.18	1.4	–	–	–
CNMG 120408ER-SI:T9425	●	0.8	■ 400	0.35	1.7	■ 240	0.32	1.7	–	–	–	–	–	–	◩ 90	0.25	1.4	–	–	–
 																				
SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。																				
CNMG 120404EL-SI:T9425	●	0.4	■ 410	0.20	1.7	■ 245	0.18	1.7	–	–	–	–	–	–	◩ 90	0.18	1.4	–	–	–
CNMG 120408EL-SI:T9425	●	0.8	■ 400	0.35	1.7	■ 240	0.32	1.7	–	–	–	–	–	–	◩ 90	0.25	1.4	–	–	–

● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◩ 可以使用

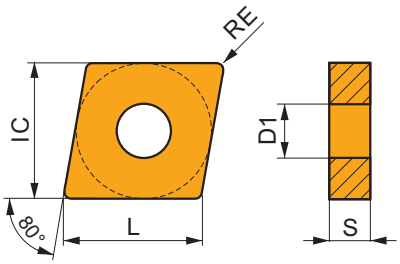
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  W S																				
W-M 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和适中的 T 倒棱。它也有条件地适用于铸铁。																				
CNMG 120408W-M:T9425	⇕	0.8	■ 300	0.45	1.5	–	–	–	◪ 285	0.45	1.5	–	–	–	–	–	–	–	–	–
  W S																				
W-MR 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和稳定、宽阔的 T 倒棱。它也有条件地适用于不锈钢和铸铁。																				
CNMG 120404W-MR:T9425	●	0.4	■ 290	0.30	1.5	◪ 170	0.27	1.5	◪ 275	0.30	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR:T9425	⇕	0.8	■ 300	0.45	1.5	◪ 180	0.41	1.5	◪ 285	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T9425	⇕	1.2	■ 300	0.55	1.5	◪ 180	0.50	1.5	◪ 285	0.55	1.5	–	–	–	–	–	–	–	–	–

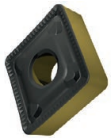
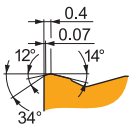
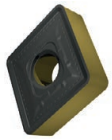
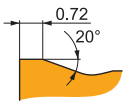
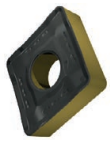
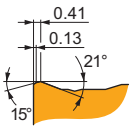
CNMM

DORMER 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

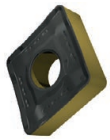
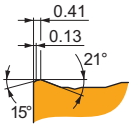
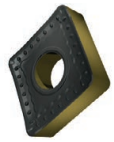
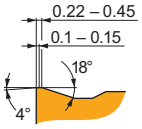
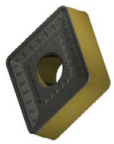
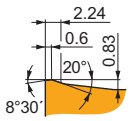


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  P																				
HR 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。																				
CNMM 190616E-HR:T9425	⇕	1.6	■ 135	0.60	10.0	◪ 80	0.54	10.0	■ 125	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T9425	⇕	2.4	■ 140	0.65	10.0	◪ 80	0.59	10.0	■ 130	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9425	✱	2.4	■ 135	0.65	14.0	◪ 80	0.59	14.0	■ 125	0.65	14.0	–	–	–	–	–	–	–	–	–
  S																				
HR2 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。																				
CNMM 190616-HR2:T9425	⇕	1.6	■ 135	0.65	10.0	◪ 80	0.59	10.0	■ 125	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624-HR2:T9425	⇕	2.4	■ 125	0.85	10.0	◪ 75	0.77	10.0	■ 115	0.85	10.0	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2:T9425	⇕	2.4	■ 125	0.85	12.0	◪ 75	0.77	12.0	■ 115	0.85	12.0	–	–	–	–	–	–	–	–	–
  P																				
NR2 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于粗加工至重载粗加工，连续切削至间断切削。它还适用于钢材，并有条件地适用于铸铁和超级合金。																				
CNMM 120408E-NR2:T9425	⇕	0.8	■ 305	0.40	5.0	■ 180	0.36	5.0	◪ 285	0.40	5.0	–	–	–	◪ 65	0.28	4.0	–	–	–
CNMM 120412E-NR2:T9425	⇕	1.2	■ 305	0.45	5.0	■ 180	0.41	5.0	◪ 285	0.45	5.0	–	–	–	◪ 65	0.32	4.0	–	–	–
CNMM 160608E-NR2:T9425	⇕	0.8	■ 300	0.40	6.0	■ 180	0.36	6.0	◪ 285	0.40	6.0	–	–	–	◪ 65	0.32	4.8	–	–	–
CNMM 160612E-NR2:T9425	⇕	1.2	■ 300	0.45	6.0	■ 180	0.41	6.0	◪ 285	0.45	6.0	–	–	–	◪ 65	0.36	4.8	–	–	–
CNMM 160616E-NR2:T9425	✱	1.6	■ 310	0.50	6.0	■ 185	0.45	6.0	◪ 290	0.50	6.0	–	–	–	◪ 65	0.40	4.8	–	–	–
CNMM 190612E-NR2:T9425	⇕	1.2	■ 290	0.45	9.0	■ 170	0.41	9.0	◪ 275	0.45	9.0	–	–	–	◪ 65	0.36	7.2	–	–	–

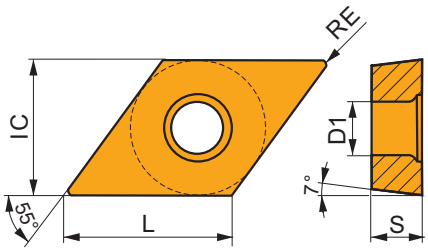
● 适用于稳定工况　⇕ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

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

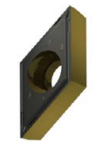
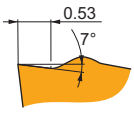
产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
NR2 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于粗加工至重载粗加工，连续切削至间断切削。它还适用于钢材，并有条件地适用于铸铁和超级合金。																				
CNMM 190616E-NR2:T9425	✱	1.6	■	290	0.50	9.0	■	170	0.45	9.0	◪	275	0.50	9.0	–	–	–	◪	65	0.40	7.2	–	–	–
CNMM 190624E-NR2:T9425	✱	2.4	■	265	0.80	9.0	■	155	0.72	9.0	◪	250	0.80	9.0	–	–	–	◪	55	0.56	7.2	–	–	–
CNMM 250924E-NR2:T9425	✱	2.4	■	145	0.80	12.0	■	85	0.72	12.0	◪	135	0.80	12.0	–	–	–	◪	30	0.56	9.6	–	–	–
 																				
OR 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于铸铁，并有条件地适用于不锈钢和超级合金。																				
CNMM 120408E-OR:T9425	⇕	0.8	■	305	0.40	5.0	◪	180	0.36	5.0	■	285	0.40	5.0	–	–	–	◪	65	0.28	4.0	–	–	–
CNMM 120412E-OR:T9425	✱	1.2	■	305	0.45	5.0	◪	180	0.41	5.0	■	285	0.45	5.0	–	–	–	◪	65	0.36	4.0	–	–	–
CNMM 120416E-OR:T9425	✱	1.6	■	315	0.50	5.0	◪	185	0.45	5.0	■	295	0.50	5.0	–	–	–	◪	70	0.40	4.0	–	–	–
CNMM 160608E-OR:T9425	⇕	0.8	■	300	0.40	6.0	◪	180	0.36	6.0	■	285	0.40	6.0	–	–	–	◪	65	0.32	4.8	–	–	–
CNMM 160612E-OR:T9425	✱	1.2	■	300	0.45	6.0	◪	180	0.41	6.0	■	285	0.45	6.0	–	–	–	◪	65	0.36	4.8	–	–	–
CNMM 160616E-OR:T9425	✱	1.6	■	310	0.50	6.0	◪	185	0.45	6.0	■	290	0.50	6.0	–	–	–	◪	65	0.40	4.8	–	–	–
CNMM 190612E-OR:T9425	✱	1.2	■	290	0.45	9.0	◪	170	0.41	9.0	■	275	0.45	9.0	–	–	–	◪	65	0.36	7.2	–	–	–
CNMM 190616E-OR:T9425	✱	1.6	■	290	0.50	9.0	◪	170	0.45	9.0	■	275	0.50	9.0	–	–	–	◪	65	0.40	7.2	–	–	–
CNMM 190624E-OR:T9425	✱	2.4	■	265	0.80	9.0	◪	155	0.72	9.0	■	250	0.80	9.0	–	–	–	◪	55	0.56	7.2	–	–	–
CNMM 250924E-OR:T9425	✱	2.4	■	130	1.00	12.0	◪	75	0.90	12.0	■	120	1.00	12.0	–	–	–	◪	25	0.70	9.6	–	–	–
 																				
923 型断屑槽坚固耐用，专为重型不锈钢粗加工而设计。适用于中粗加工至重载粗加工，连续至重断续切削。它也有条件地适用于钢和铸铁。																				
CNMM 250924S-923:T9425	✱	2.4	■	125	0.85	12.0	■	75	0.77	12.0	◪	115	0.85	12.0	–	–	–	◪	25	0.60	9.6	–	–	–

DCGT

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

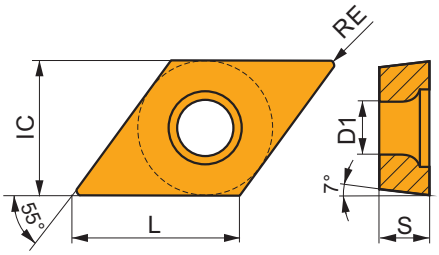


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

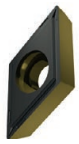
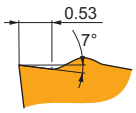
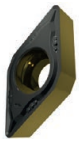
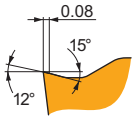
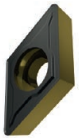
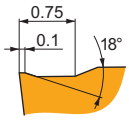
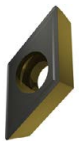
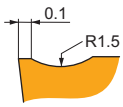
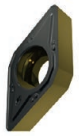
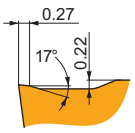
产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
FF2 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。																				
DCGT 11T302E-FF2:T9425	●	0.2	■	370	0.05	0.8	–	–	–	■	350	0.05	0.8	–	–	–	–	–	–	–	–	–	–

DCMT

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

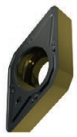
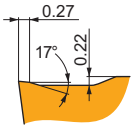
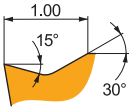
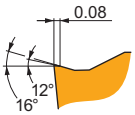


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
FF2 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。																				
DCMT 070202E-FF2:T9425	●	0.2	■ 370	0.05	0.8	–	–	–	■ 350	0.05	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T9425	●	0.4	■ 295	0.12	0.8	–	–	–	■ 280	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T9425	●	0.8	■ 315	0.17	0.8	–	–	–	■ 295	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2:T9425	●	0.4	■ 295	0.12	0.8	–	–	–	■ 280	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T9425	●	0.8	■ 315	0.17	0.8	–	–	–	■ 295	0.17	0.8	–	–	–	–	–	–	–	–	–
 																				
FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。																				
DCMT 070202E-FM:T9425	●	0.2	■ 325	0.10	0.8	■ 195	0.09	0.8	◪ 305	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T9425	●	0.4	■ 285	0.18	0.8	■ 170	0.16	0.8	◪ 270	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM:T9425	●	0.2	■ 325	0.10	0.8	■ 195	0.09	0.8	◪ 305	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T9425	●	0.4	■ 285	0.18	0.8	■ 170	0.16	0.8	◪ 270	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T9425	●	0.8	■ 345	0.17	0.8	■ 205	0.15	0.8	◪ 325	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM:T9425	●	1.2	■ 320	0.22	1.2	■ 190	0.22	1.2	◪ 300	0.22	1.2	–	–	–	–	–	–	–	–	–
 																				
FM2 断屑槽坚固耐用，是钢材中型加工的首选。它具有正前角和稳定、适中的 T 倒棱。它还适用于铸铁和有条件的不锈钢。																				
DCMT 070204E-FM2:T9425	●	0.4	■ 295	0.12	0.8	◪ 175	0.11	0.8	■ 280	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T9425	●	0.4	■ 295	0.12	0.8	◪ 175	0.11	0.8	■ 280	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T9425	●	0.8	■ 315	0.17	0.8	◪ 185	0.15	0.8	■ 295	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM2:T9425	●	1.2	■ 295	0.22	1.2	◪ 175	0.20	1.2	■ 280	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 150408E-FM2:T9425	●	0.8	■ 280	0.20	1.5	◪ 165	0.18	1.5	■ 265	0.20	1.5	–	–	–	–	–	–	–	–	–
 																				
RF 断屑槽坚固耐用，是铸铁中型加工的首选。它的特点是略带正前角和稳定、适中的 T 倒棱。它也适用于钢材，有条件时也适用于不锈钢和硬质材料。																				
DCMT 11T304E-RF:T9425	●	0.4	■ 225	0.20	0.8	◪ 135	0.18	0.8	■ 210	0.20	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-RF:T9425	●	0.8	■ 270	0.20	0.8	◪ 160	0.18	0.8	■ 255	0.20	0.8	–	–	–	–	–	–	–	–	–
 																				
RM 型断屑槽坚固耐用，是钢和铸铁粗加工的首选。它具有正前角和稳定开放的 T 倒棱。它还适用于不锈钢，并有条件地适用于超级合金和硬质材料。																				
DCMT 11T304E-RM:T9425	●	0.4	■ 280	0.20	1.0	■ 165	0.18	1.0	■ 265	0.20	1.0	–	–	–	◪ 60	0.14	0.8	–	–	–
DCMT 11T308E-RM:T9425	●	0.8	■ 310	0.27	0.8	■ 185	0.24	0.8	■ 290	0.27	0.8	–	–	–	◪ 65	0.19	0.6	–	–	–
DCMT 11T312E-RM:T9425	⬌	1.2	■ 315	0.27	1.2	■ 185	0.24	1.2	■ 295	0.27	1.2	–	–	–	◪ 70	0.19	1.2	–	–	–

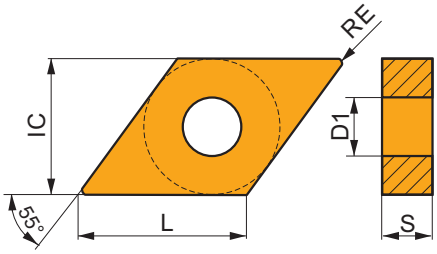
● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

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

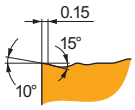
产品	●	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
RM 型断屑槽坚固耐用，是钢和铸铁粗加工的首选。它具有正前角和稳定开放的 T 倒棱。它还适用于不锈钢，并有条件地适用于超级合金和硬质材料。																				
DCMT 150408E-RM:T9425	●	0.8	■ 285	0.27	1.9	■ 170	0.24	1.9	■ 270	0.27	1.9	–	–	–	◪ 60	0.22	1.5	–	–	–
																				
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。																				
DCMT 070202E-UR:T9425	●	0.2	■ 280	0.10	0.8	◪ 165	0.09	0.8	■ 265	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T9425	●	0.4	■ 245	0.18	0.8	◪ 145	0.16	0.8	■ 230	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T9425	●	0.2	■ 280	0.10	0.8	◪ 165	0.09	0.8	■ 265	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T9425	●	0.4	■ 245	0.18	0.8	◪ 145	0.16	0.8	■ 230	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T9425	●	0.8	■ 300	0.17	0.8	◪ 180	0.15	0.8	■ 285	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T312E-UR:T9425	●	1.2	■ 280	0.22	1.2	◪ 165	0.20	1.2	■ 265	0.22	1.2	–	–	–	–	–	–	–	–	–
																				
W-FM 型断屑槽具有修光刃，专为钢材、不锈钢和铸铁的精加工而设计。它具有正前角和正窄 T 倒棱。																				
DCMX 11T304W-FM:T9425	●	0.4	■ 240	0.30	0.8	■ 140	0.27	0.8	■ 225	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T308W-FM:T9425	●	0.8	■ 255	0.40	1.0	■ 150	0.36	1.0	■ 240	0.40	1.0	–	–	–	–	–	–	–	–	–

DNMG

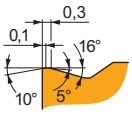
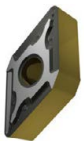
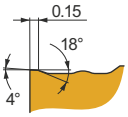
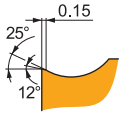
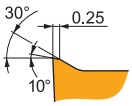
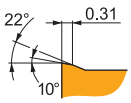
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



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

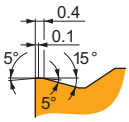
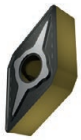
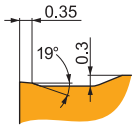
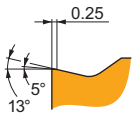
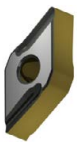
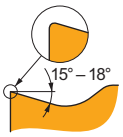
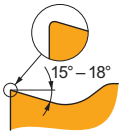
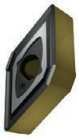
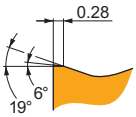
产品	●	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
FM 断屑槽用途广泛，是钢和铸铁精加工的首选。它的特点是小正前角和窄的T-型倒棱。也有条件地适用于不锈钢和耐热合金。																				
DNMG 110404E-FM:T9425	●	0.4	■ 305	0.20	0.8	◪ 180	0.18	0.8	■ 285	0.20	0.8	–	–	–	◪ 65	0.20	0.6	–	–	–
DNMG 110408E-FM:T9425	●	0.8	■ 365	0.20	0.8	◪ 215	0.18	0.8	■ 345	0.20	0.8	–	–	–	◪ 80	0.16	0.6	–	–	–
DNMG 150404E-FM:T9425	●	0.4	■ 285	0.20	1.7	◪ 170	0.18	1.7	■ 270	0.20	1.7	–	–	–	◪ 60	0.20	1.4	–	–	–
DNMG 150408E-FM:T9425	●	0.8	■ 340	0.20	1.7	◪ 200	0.18	1.7	■ 320	0.20	1.7	–	–	–	◪ 75	0.16	1.4	–	–	–
DNMG 150604E-FM:T9425	●	0.4	■ 285	0.20	1.7	◪ 170	0.18	1.7	■ 270	0.20	1.7	–	–	–	◪ 60	0.20	1.4	–	–	–
DNMG 150608E-FM:T9425	●	0.8	■ 340	0.20	1.7	◪ 200	0.18	1.7	■ 320	0.20	1.7	–	–	–	◪ 75	0.16	1.4	–	–	–
DNMG 150612E-FM:T9425	●	1.2	■ 330	0.25	1.7	◪ 195	0.23	1.7	■ 310	0.25	1.7	–	–	–	◪ 70	0.18	1.4	–	–	–
DNMG 150616E-FM:T9425	●	1.6	■ 330	0.30	1.7	◪ 195	0.27	1.7	■ 310	0.30	1.7	–	–	–	◪ 70	0.21	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	● ⇕ ✱	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 型断屑槽用途广泛，是铸铁中型加工的首选。它具有正前角和负/稳定、适中的 T 倒棱。它也适用于钢材和有条件的硬质材料。																				
DNMG 110404E-M:T9425	●	0.4	■ 270	0.20	1.2	–	–	–	■ 255	0.20	1.2	–	–	–	–	–	–	–	–	–
DNMG 110408E-M:T9425	●	0.8	■ 280	0.30	1.2	–	–	–	■ 265	0.30	1.2	–	–	–	–	–	–	–	–	–
DNMG 110412E-M:T9425	⇕	1.2	■ 270	0.40	1.2	–	–	–	■ 255	0.40	1.2	–	–	–	–	–	–	–	–	–
DNMG 150404E-M:T9425	●	0.4	■ 255	0.20	1.9	–	–	–	■ 240	0.20	1.9	–	–	–	–	–	–	–	–	–
DNMG 150408E-M:T9425	●	0.8	■ 265	0.30	1.9	–	–	–	■ 250	0.30	1.9	–	–	–	–	–	–	–	–	–
DNMG 150412E-M:T9425	⇕	1.2	■ 260	0.40	1.9	–	–	–	■ 245	0.40	1.9	–	–	–	–	–	–	–	–	–
DNMG 150604E-M:T9425	●	0.4	■ 255	0.20	1.9	–	–	–	■ 240	0.20	1.9	–	–	–	–	–	–	–	–	–
DNMG 150608E-M:T9425	●	0.8	■ 265	0.30	1.9	–	–	–	■ 250	0.30	1.9	–	–	–	–	–	–	–	–	–
DNMG 150612E-M:T9425	⇕	1.2	■ 260	0.40	1.9	–	–	–	■ 245	0.40	1.9	–	–	–	–	–	–	–	–	–
 																				
ML 型断屑槽用途广泛，专为低切削深度和钢材的中型加工而设计。它具有正前角和稳定的窄 T 型面。同样适用于铸铁加工。																				
DNMG 110408-ML:T9415	●	0.8	■ 300	0.25	1.5	–	–	–	◪ 285	0.25	1.5	–	–	–	–	–	–	–	–	–
DNMG 110408-ML:T9425	●	0.8	■ 290	0.25	1.5	–	–	–	■ 275	0.25	1.5	–	–	–	–	–	–	–	–	–
DNMG 150408-ML:T9415	●	0.8	■ 300	0.25	1.5	–	–	–	◪ 285	0.25	1.5	–	–	–	–	–	–	–	–	–
DNMG 150408-ML:T9425	●	0.8	■ 290	0.25	1.5	–	–	–	■ 275	0.25	1.5	–	–	–	–	–	–	–	–	–
DNMG 150608-ML:T9415	●	0.8	■ 300	0.25	1.5	–	–	–	◪ 285	0.25	1.5	–	–	–	–	–	–	–	–	–
DNMG 150608-ML:T9425	⇕	0.8	■ 290	0.25	1.5	–	–	–	■ 275	0.25	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612-ML:T9415	⇕	1.2	■ 285	0.30	2.0	–	–	–	◪ 270	0.30	2.0	–	–	–	–	–	–	–	–	–
DNMG 150612-ML:T9425	⇕	1.2	■ 280	0.30	2.0	–	–	–	■ 265	0.30	2.0	–	–	–	–	–	–	–	–	–
DNMG 150616-ML:T9415	⇕	1.6	■ 280	0.35	2.0	–	–	–	◪ 265	0.35	2.0	–	–	–	–	–	–	–	–	–
DNMG 150616-ML:T9425	⇕	1.6	■ 280	0.35	2.0	–	–	–	■ 265	0.35	2.0	–	–	–	–	–	–	–	–	–
																				
NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T 倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。																				
DNMG 110404E-NF:T9425	●	0.4	■ 320	0.18	0.8	■ 190	0.16	0.8	◪ 300	0.18	0.8	–	–	–	◪ 70	0.16	0.6	–	–	–
DNMG 110408E-NF:T9425	●	0.8	■ 370	0.18	1.0	■ 220	0.16	1.0	◪ 350	0.18	1.0	–	–	–	◪ 80	0.16	0.8	–	–	–
DNMG 150404E-NF:T9425	●	0.4	■ 295	0.18	1.7	■ 175	0.16	1.7	◪ 280	0.18	1.7	–	–	–	◪ 65	0.16	1.4	–	–	–
DNMG 150408E-NF:T9425	●	0.8	■ 355	0.18	1.7	■ 210	0.16	1.7	◪ 335	0.18	1.7	–	–	–	◪ 75	0.16	1.4	–	–	–
DNMG 150604E-NF:T9425	●	0.4	■ 295	0.18	1.9	■ 175	0.16	1.9	◪ 280	0.18	1.9	–	–	–	◪ 65	0.16	1.5	–	–	–
DNMG 150608E-NF:T9425	●	0.8	■ 350	0.18	1.9	■ 210	0.16	1.9	◪ 330	0.18	1.9	–	–	–	◪ 75	0.16	1.5	–	–	–
																				
NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。																				
DNMG 110408E-NM:T9425	●	0.8	■ 355	0.25	0.8	■ 210	0.23	0.8	–	–	–	–	–	–	◪ 75	0.20	0.6	–	–	–
DNMG 150604E-NM:T9425	●	0.4	■ 295	0.20	1.9	■ 175	0.18	1.9	–	–	–	–	–	–	◪ 65	0.20	1.5	–	–	–
DNMG 150608E-NM:T9425	●	0.8	■ 325	0.25	1.9	■ 195	0.23	1.9	–	–	–	–	–	–	◪ 70	0.20	1.5	–	–	–
																				
NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
DNMG 110404E-NMR:T9425	●	0.4	■ 280	0.20	0.8	■ 165	0.18	0.8	–	–	–	–	–	–	◪ 60	0.18	0.6	–	–	–
DNMG 150404E-NMR:T9425	●	0.4	■ 255	0.20	1.9	■ 150	0.18	1.9	–	–	–	–	–	–	◪ 55	0.18	1.5	–	–	–
DNMG 150408E-NMR:T9425	⇕	0.8	■ 265	0.30	1.9	■ 155	0.27	1.9	–	–	–	–	–	–	◪ 55	0.24	1.5	–	–	–
DNMG 150604E-NMR:T9425	●	0.4	■ 255	0.20	1.9	■ 150	0.18	1.9	–	–	–	–	–	–	◪ 55	0.18	1.5	–	–	–
DNMG 150608E-NMR:T9425	⇕	0.8	■ 265	0.30	1.9	■ 155	0.27	1.9	–	–	–	–	–	–	◪ 55	0.24	1.5	–	–	–
DNMG 150612E-NMR:T9425	⇕	1.2	■ 280	0.30	1.9	■ 165	0.27	1.9	–	–	–	–	–	–	◪ 60	0.24	1.5	–	–	–

● 适用于稳定工况　⇕ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

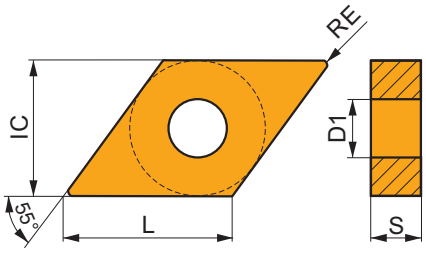
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																				
DNMG 150608E-R:T9425	⇕	0.8	■ 235	0.40	3.0	–	–	–	■ 220	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-R:T9425	⇕	1.2	■ 245	0.40	3.0	–	–	–	■ 230	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150616E-R:T9425	⇕	1.6	■ 260	0.40	3.0	–	–	–	■ 245	0.40	3.0	–	–	–	–	–	–	–	–	–
 																				
RM 断屑槽坚固耐用，是钢件粗加工的首选。具有正前角和宽的稳定T-型倒棱。还适用于不锈钢、铸铁，有条件的用于耐热合金。																				
DNMG 110408E-RM:T9425	●	0.8	■ 275	0.40	2.0	■ 165	0.36	2.0	■ 260	0.40	2.0	–	–	–	◪ 60	0.28	1.6	–	–	–
DNMG 110412E-RM:T9425	⇕	1.2	■ 290	0.40	2.0	■ 170	0.36	2.0	■ 275	0.40	2.0	–	–	–	◪ 65	0.28	1.6	–	–	–
DNMG 150408E-RM:T9425	●	0.8	■ 270	0.40	3.0	■ 160	0.36	3.0	■ 255	0.40	3.0	–	–	–	◪ 60	0.28	2.4	–	–	–
DNMG 150412E-RM:T9425	⇕	1.2	■ 285	0.40	3.0	■ 170	0.36	3.0	■ 270	0.40	3.0	–	–	–	◪ 60	0.28	2.4	–	–	–
DNMG 150608E-RM:T9425	⇕	0.8	■ 270	0.40	3.0	■ 160	0.36	3.0	■ 255	0.40	3.0	–	–	–	◪ 60	0.28	2.4	–	–	–
DNMG 150612E-RM:T9425	⇕	1.2	■ 285	0.40	3.0	■ 170	0.36	3.0	■ 270	0.40	3.0	–	–	–	◪ 60	0.28	2.4	–	–	–
DNMG 150616E-RM:T9425	⇕	1.6	■ 295	0.40	3.0	■ 175	0.36	3.0	■ 280	0.40	3.0	–	–	–	◪ 65	0.33	2.4	–	–	–
																				
SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。																				
DNMG 110404E-SM:T9425	●	0.4	■ 295	0.20	0.8	■ 175	0.18	0.8	■ 280	0.20	0.8	–	–	–	◪ 65	0.18	0.6	–	–	–
DNMG 110408E-SM:T9425	●	0.8	■ 315	0.25	1.2	■ 185	0.23	1.2	■ 295	0.25	1.2	–	–	–	◪ 70	0.20	1.0	–	–	–
DNMG 150604E-SM:T9425	●	0.4	■ 275	0.20	1.7	■ 165	0.18	1.7	■ 260	0.20	1.7	–	–	–	◪ 60	0.18	1.4	–	–	–
DNMG 150608E-SM:T9425	●	0.8	■ 300	0.25	1.7	■ 180	0.23	1.7	■ 285	0.25	1.7	–	–	–	◪ 65	0.20	1.4	–	–	–
DNMG 150612E-SM:T9425	⇕	1.2	■ 300	0.30	1.7	■ 180	0.27	1.7	■ 285	0.30	1.7	–	–	–	◪ 65	0.24	1.4	–	–	–
 																				
SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。																				
DNMG 110404ER-SI:T9425	●	0.4	■ 340	0.20	1.0	■ 200	0.18	1.0	–	–	–	–	–	–	◪ 75	0.18	0.8	–	–	–
DNMG 110408ER-SI:T9425	●	0.8	■ 340	0.35	1.0	■ 200	0.32	1.0	–	–	–	–	–	–	◪ 75	0.25	0.8	–	–	–
DNMG 150404ER-SI:T9425	●	0.4	■ 330	0.20	1.5	■ 195	0.18	1.5	–	–	–	–	–	–	◪ 70	0.18	1.2	–	–	–
DNMG 150408ER-SI:T9425	●	0.8	■ 325	0.35	1.5	■ 195	0.32	1.5	–	–	–	–	–	–	◪ 70	0.25	1.2	–	–	–
DNMG 150604ER-SI:T9425	●	0.4	■ 330	0.20	1.5	■ 195	0.18	1.5	–	–	–	–	–	–	◪ 70	0.18	1.2	–	–	–
DNMG 150608ER-SI:T9425	●	0.8	■ 325	0.35	1.5	■ 195	0.32	1.5	–	–	–	–	–	–	◪ 70	0.25	1.2	–	–	–
																				
SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。																				
DNMG 110404EL-SI:T9425	●	0.4	■ 340	0.20	1.0	■ 200	0.18	1.0	–	–	–	–	–	–	◪ 75	0.18	0.8	–	–	–
DNMG 110408EL-SI:T9425	●	0.8	■ 340	0.35	1.0	■ 200	0.32	1.0	–	–	–	–	–	–	◪ 75	0.25	0.8	–	–	–
DNMG 150404EL-SI:T9425	●	0.4	■ 330	0.20	1.5	■ 195	0.18	1.5	–	–	–	–	–	–	◪ 70	0.18	1.2	–	–	–
DNMG 150408EL-SI:T9425	●	0.8	■ 325	0.35	1.5	■ 195	0.32	1.5	–	–	–	–	–	–	◪ 70	0.25	1.2	–	–	–
DNMG 150604EL-SI:T9425	●	0.4	■ 330	0.20	1.5	■ 195	0.18	1.5	–	–	–	–	–	–	◪ 70	0.18	1.2	–	–	–
DNMG 150608EL-SI:T9425	●	0.8	■ 325	0.35	1.5	■ 195	0.32	1.5	–	–	–	–	–	–	◪ 70	0.25	1.2	–	–	–
 																				
W-MR 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和稳定、宽阔的 T 倒棱。它也有条件地适用于不锈钢和铸铁。																				
DNMG 150608W-MR:T9425	●	0.8	■ 250	0.40	1.5	◪ 150	0.36	1.5	◪ 235	0.40	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR:T9425	⇕	1.2	■ 245	0.50	1.5	◪ 145	0.45	1.5	◪ 230	0.50	1.5	–	–	–	–	–	–	–	–	–

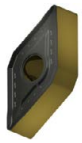
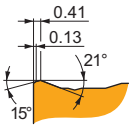
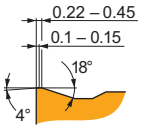
● 适用于稳定工况　⇕ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

DNMM

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

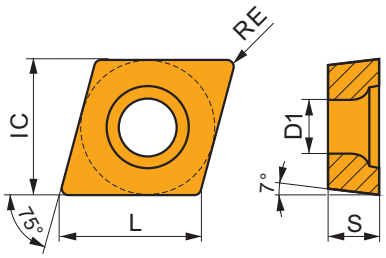


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

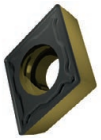
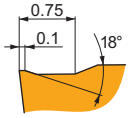
产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
NR2 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于粗加工至重载粗加工，连续切削至间断切削。它还适用于钢材，并有条件地适用于铸铁和超级合金。																				
DNMM 150608E-NR2:T9425	⚙	0.8	■	255	0.40	3.0	■	150	0.36	3.0	◪	240	0.40	3.0	–	–	–	◪	55	0.32	2.4	–	–	–
																				
OR 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于铸铁，并有条件地适用于不锈钢和超级合金。																				
DNMM 150608E-OR:T9425	⚙	0.8	■	255	0.40	3.0	◪	150	0.36	3.0	■	240	0.40	3.0	–	–	–	◪	55	0.28	2.4	–	–	–
DNMM 150612E-OR:T9425	⚙	1.2	■	270	0.40	3.0	◪	160	0.36	3.0	■	255	0.40	3.0	–	–	–	◪	60	0.32	2.4	–	–	–
DNMM 150616E-OR:T9425	⚙	1.6	■	270	0.45	3.0	◪	160	0.41	3.0	■	255	0.45	3.0	–	–	–	◪	60	0.41	2.4	–	–	–

ECMT

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



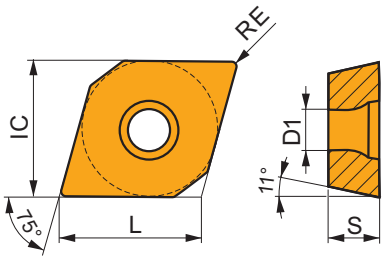
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
FM2 断屑槽坚固耐用，是钢材中型加工的首选。它具有正前角和稳定、适中的 T 倒棱。它还适用于铸铁和有条件的不锈钢。																				
ECMT 060204E-FM2:T9425	●	0.4	■	370	0.12	0.8	◪	220	0.11	0.8	■	350	0.12	0.8	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T9425	●	0.4	■	365	0.12	1.0	◪	215	0.11	1.0	■	345	0.12	1.0	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T9425	⚙	0.8	■	385	0.17	1.0	◪	230	0.15	1.0	■	365	0.17	1.0	–	–	–	–	–	–	–	–	–

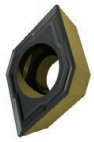
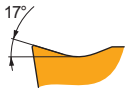
● 适用于稳定工况　⚙ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

EPMT

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

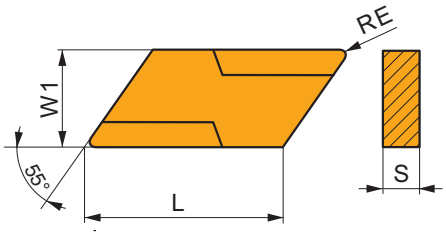


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

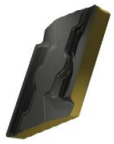
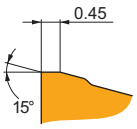
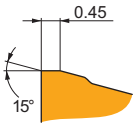
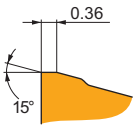
产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  U ✱ E	NF2 断屑槽非常锋利，是不锈钢精加工的首选。具有正前角，无T-型倒棱。还适用于耐热合金，有条件地适用于钢、铸铁和有色合金。																			
EPMT 050202E-NF2:T9425	●	0.2	◪ 415	0.07	0.8	■ 245	0.06	0.8	◪ 390	0.07	0.8	–	–	–	◪ 90	0.06	0.6	–	–	–

KNUX

	L (mm)	S (mm)
1604	19.50	4.76

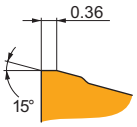
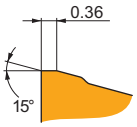
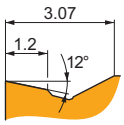
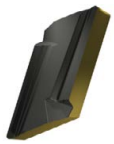
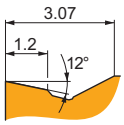


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	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	L-22 屑槽，左手设计，适用于精加工至中粗加工，连续切削。																			
KNUX 160405L-22:T9425	●	0.5	■ 245	0.25	2.7	◪ 145	0.25	2.7	◪ 230	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160410L-22:T9425	⬌	1.0	■ 280	0.32	2.7	◪ 165	0.32	2.7	◪ 265	0.32	2.7	–	–	–	–	–	–	–	–	–
 U E	R-22 屑槽，右手设计，适用于精加工至中粗加工，连续切削。																			
KNUX 160405R-22:T9425	●	0.5	■ 245	0.25	2.7	◪ 145	0.25	2.7	◪ 230	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160410R-22:T9425	⬌	1.0	■ 280	0.32	2.7	◪ 165	0.32	2.7	◪ 265	0.32	2.7	–	–	–	–	–	–	–	–	–
 U E	L-32 屑槽，左手设计，适用于精加工至中粗加工，连续切削。																			
KNUX 160405L-32:T9425	●	0.5	■ 245	0.25	2.7	◪ 145	0.25	2.7	◪ 230	0.25	2.7	–	–	–	–	–	–	–	–	–

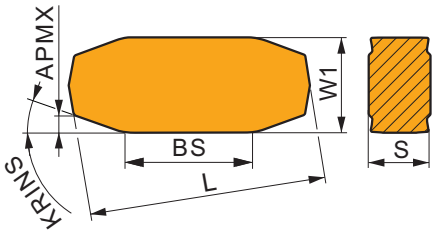
● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

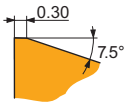
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
L-32 屑槽，左手设计，适用于精加工至中粗加工，连续切削。																				
KNUX 160410L-32:T9425	●	1.0	■ 280	0.32	2.7	◪ 165	0.32	2.7	◪ 265	0.32	2.7	–	–	–	–	–	–	–	–	–
																				
R-32 型，右手设计，适用于精加工至中粗加工，连续切削。																				
KNUX 160405R-32:T9425	●	0.5	■ 245	0.25	2.7	◪ 145	0.25	2.7	◪ 230	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160410R-32:T9425	●	1.0	■ 280	0.32	2.7	◪ 165	0.32	2.7	◪ 265	0.32	2.7	–	–	–	–	–	–	–	–	–
																				
ER-72 屑槽，右手设计，适用于精细的精加工，连续切削。																				
KNUX 160405ER-72:T9425	●	0.5	■ 325	0.20	2.0	◪ 195	0.18	2.0	■ 305	0.20	2.0	–	–	–	◪ 70	0.16	1.6	–	–	–
 																				
EL-72 屑槽，左手设计，适用于精细的精加工，连续切削。																				
KNUX 160405EL-72:T9425	●	0.5	■ 325	0.20	2.0	◪ 195	0.18	2.0	■ 305	0.20	2.0	–	–	–	◪ 70	0.16	1.6	–	–	–

LNGF 30

	L (mm)	S (mm)
3007	30.12	7.54

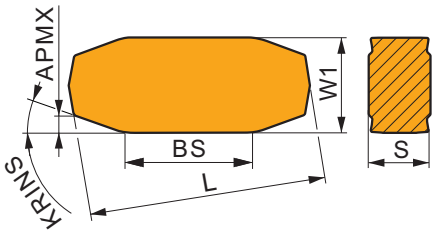


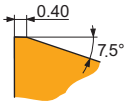
产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
LNGF 300715-PM-S01:T9425	⬌	–	■ 205	1.70	0.7	◪ 120	1.53	0.7	–	–	–	–	–	–	–	–	–	–	–	–

●适用于稳定工况 ⬌适用于不稳定工况 ✱适用于重型加工工况 ■推荐使用 ◪可以使用

LNGF 36

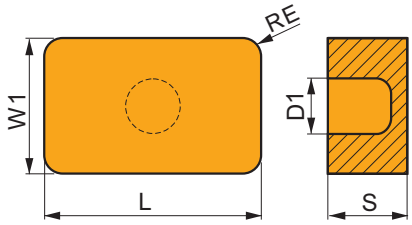
	L (mm)	S (mm)	APMX (mm)
3612	36.50	12.00	2.00



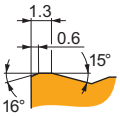
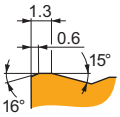
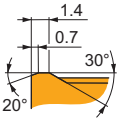
产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 W HFC S 带修光刃的PM槽型，适用于中等切削深度、高线速度的稳定至不稳定切削工况。																				
LNGF 361220-PM-S01:T9425	⚙	–	■ 180	2.50	0.8	◪ 105	2.25	0.8	–	–	–	–	–	–	–	–	–	–	–	–

LNUX 40, LN.X 50

	D1 (mm)	L (mm)	S (mm)
40-1	9.30	40.00	14.00
50-1	9.30	50.80	14.00
5014	6.35	50.80	14.00



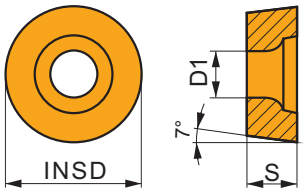
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 P LN.X 适用于重载粗加工，连续至断续切削。																				
LNUX 40-1129003:T9425	⚙	3.2	■ 80	1.35	25.0	–	–	–	■ 75	1.35	25.0	–	–	–	–	–	–	–	–	–
 P LN.X 适用于重载粗加工，连续至断续切削。																				
LNUX 50-1275000:T9425	⚙	3.2	■ 80	1.35	25.0	–	–	–	■ 75	1.35	25.0	–	–	–	–	–	–	–	–	–
 P LN.X 设计用于重载粗加工，连续至重载断续切削。																				
LNMX 501432E:T9425	✱	3.2	■ 85	1.50	25.0	–	–	–	■ 80	1.50	25.0	–	–	–	–	–	–	–	–	–

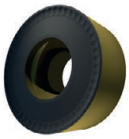
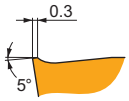
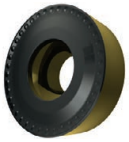
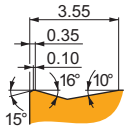
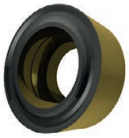
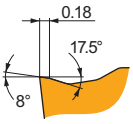
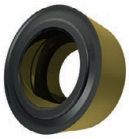
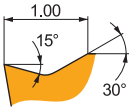
● 适用于稳定工况　⚙ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

RCMT

	D1 (mm)	S (mm)
0602	2.80	2.38
0803	3.40	3.18
10T3	4.40	3.97
1204	4.40	4.76
1606	5.50	6.35
2006	6.50	6.35



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

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/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)
 																				
RCMT 1606MOS-37:T9425	✱	–	■ 245	0.60	3.0	–	–	–	■ 230	0.60	3.0	–	–	–	–	–	–	–	–	–
 																				
RCMT 2006MOS-371:T9425	✱	–	■ 225	0.80	3.0	–	–	–	■ 210	0.80	3.0	–	–	–	–	–	–	–	–	–
 																				
RCMT 0602MOE-FM:T9425	⚙	–	■ 385	0.45	1.2	■ 230	0.41	1.2	◪ 365	0.45	1.2	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-FM:T9425	⚙	–	■ 345	0.60	1.6	■ 205	0.54	1.6	◪ 325	0.60	1.6	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-FM:T9425	⚙	–	■ 335	0.65	1.7	■ 200	0.59	1.7	◪ 315	0.65	1.7	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-FM:T9425	⚙	–	■ 320	0.70	1.8	■ 190	0.63	1.8	◪ 300	0.70	1.8	–	–	–	–	–	–	–	–	–
 																				
RCMT 0602MOE-UR:T9425	⚙	–	■ 350	0.40	1.2	◪ 210	0.36	1.2	■ 330	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T9425	⚙	–	■ 325	0.45	1.6	◪ 195	0.41	1.6	■ 305	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T9425	⚙	–	■ 320	0.50	1.4	◪ 190	0.45	1.4	■ 300	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T9425	⚙	–	■ 305	0.55	1.8	◪ 180	0.50	1.8	■ 285	0.55	1.8	–	–	–	–	–	–	–	–	–

37 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。

371 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。

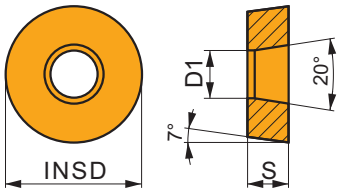
FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。

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

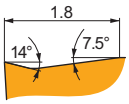
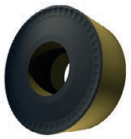
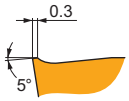
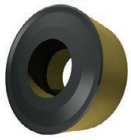
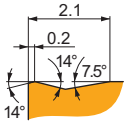
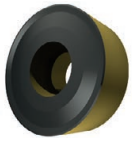
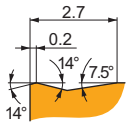
● 适用于稳定工况　⚙ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

RCMX

	D1 (mm)	S (mm)
1003	3.60	3.18
1204	4.20	4.76
1606	5.20	6.35

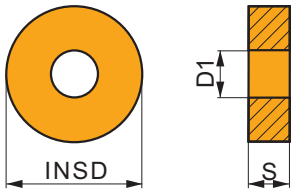


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

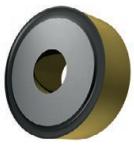
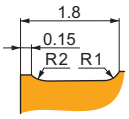
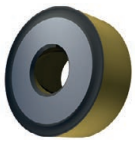
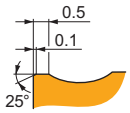
产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
RCMX 1003MOS-31:T9425	⚙	–	■ 275	0.50	2.0	◪ 165	0.45	2.0	■ 260	0.50	2.0	–	–	–	–	–	–	–	–	–
31 断屑槽适用于精加工至中粗加工，连续至断续切削。																				
 																				
RCMX 1606MOS-37:T9425	✱	–	■ 245	0.60	3.0	–	–	–	■ 230	0.60	3.0	–	–	–	–	–	–	–	–	–
37 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。																				
 																				
RCMX 1204MOS-321:T9425	✱	–	■ 210	1.00	3.0	–	–	–	■ 195	1.00	3.0	–	–	–	–	–	–	–	–	–
321 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。																				
 																				
RCMX 1606MOS-331:T9425	✱	–	■ 195	1.20	3.5	–	–	–	■ 185	1.20	3.5	–	–	–	–	–	–	–	–	–
331 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。																				

RNMG

	D1 (mm)	S (mm)
1204	5.16	4.76
1506	6.35	6.35
1906	7.94	6.35
2509	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。

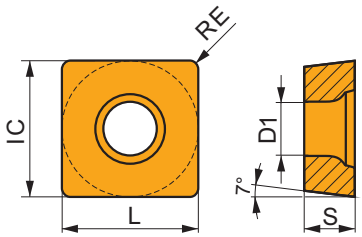
产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
RNMG 120400E-08:T9425	●	–	◪	240	0.70	3.0	–	–	–	◪	225	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 150600E-08:T9425	✱	–	◪	360	0.70	3.0	–	–	–	◪	340	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 190600E-08:T9425	●	–	◪	240	0.70	3.0	–	–	–	◪	225	0.70	3.0	–	–	–	–	–	–	–	–	–
 																				
RNMG 250900E-081:T9425	✱	–	◪	180	0.90	5.0	–	–	–	◪	170	0.90	5.0	–	–	–	–	–	–	–	–	–

08 断屑槽适用于中粗加工至重载粗加工，连续至断续切削。

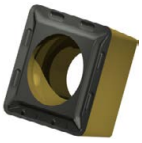
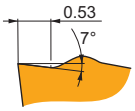
081 断屑槽适用于粗加工至重载粗加工，连续切削至间断切削。

SCMT

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



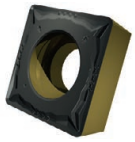
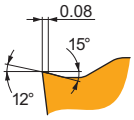
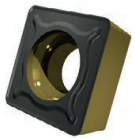
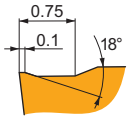
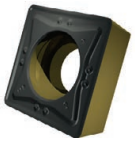
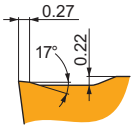
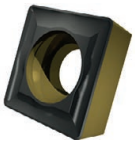
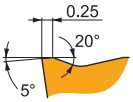
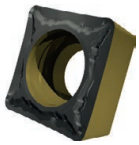
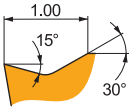
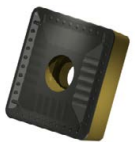
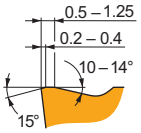
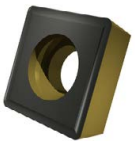
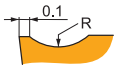
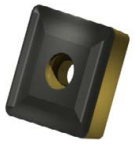
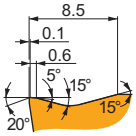
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	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)
 																				
SCMT 09T304E-FF2:T9425	●	0.4	■	375	0.12	1.2	–	–	–	■	355	0.12	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FF2:T9425	●	0.8	■	395	0.17	1.2	–	–	–	■	375	0.17	1.2	–	–	–	–	–	–	–	–	–

FF2 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。

● 适用于稳定工况 ⇕ 适用于不稳定工况 ✱ 适用于重型加工工况 ■ 推荐使用 ◪ 可以使用

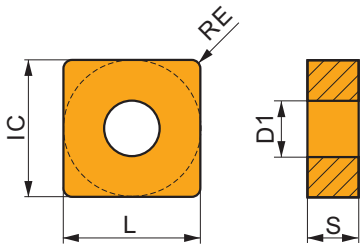
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。																				
SCMT 09T304E-FM:T9425	●	0.4	■ 385	0.15	1.2	■ 230	0.15	1.2	◪ 365	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T9425	●	0.8	■ 415	0.20	1.2	■ 245	0.18	1.2	◪ 390	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM:T9425	●	0.4	■ 370	0.15	1.6	■ 220	0.15	1.6	◪ 350	0.15	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T9425	●	0.8	■ 400	0.20	1.6	■ 240	0.18	1.6	◪ 380	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-FM:T9425	⚙	1.2	■ 385	0.27	1.6	■ 230	0.24	1.6	◪ 365	0.27	1.6	–	–	–	–	–	–	–	–	–
 																				
FM2 断屑槽坚固耐用，是钢材中型加工的首选。它具有正前角和稳定、适中的 T 倒棱。它还适用于铸铁和有条件的不锈钢。																				
SCMT 09T304E-FM2:T9425	●	0.4	■ 385	0.12	1.0	◪ 230	0.11	1.0	■ 365	0.12	1.0	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM2:T9425	⚙	0.8	■ 405	0.17	1.0	◪ 240	0.15	1.0	■ 380	0.17	1.0	–	–	–	–	–	–	–	–	–
 																				
RM 型断屑槽坚固耐用，是钢和铸铁粗加工的首选。它具有正前角和稳定开放的 T 倒棱。它还适用于不锈钢，并有条件地适用于超级合金和硬质材料。																				
SCMT 09T308E-RM:T9425	⚙	0.8	■ 365	0.30	2.0	■ 215	0.27	2.0	■ 345	0.30	2.0	–	–	–	◪ 80	0.24	1.6	–	–	–
SCMT 120408E-RM:T9425	⚙	0.8	■ 360	0.30	2.3	■ 215	0.27	2.3	■ 340	0.30	2.3	–	–	–	◪ 80	0.24	1.8	–	–	–
 																				
RM3 断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。具有正前角和宽的T-型倒棱。也有条件地适用于不锈钢和硬质材料。																				
SCMT 120408E-RM3:T9425	⚙	0.8	■ 320	0.27	2.3	◪ 190	0.27	2.3	■ 300	0.27	2.3	–	–	–	–	–	–	–	–	–
SCMT 120412E-RM3:T9425	⚙	1.2	■ 330	0.30	2.3	◪ 195	0.27	2.3	■ 310	0.30	2.3	–	–	–	–	–	–	–	–	–
 																				
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。																				
SCMT 09T304E-UR:T9425	●	0.4	■ 330	0.15	1.2	◪ 195	0.15	1.2	■ 310	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T9425	●	0.8	■ 360	0.20	1.2	◪ 215	0.18	1.2	■ 340	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T9425	●	0.8	■ 345	0.20	1.6	◪ 205	0.18	1.6	■ 325	0.20	1.6	–	–	–	–	–	–	–	–	–
 																				
OR 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于钢、铸铁和有条件的超级合金。																				
SCMT 250924E-OR:T9425	✱	2.4	■ 125	1.00	10.0	■ 75	0.90	10.0	■ 115	1.00	10.0	–	–	–	◪ 25	0.70	8.0	–	–	–
SCMT 380932E-OR:T9425	✱	3.2	■ 110	1.20	18.0	■ 65	1.08	18.0	■ 100	1.20	18.0	–	–	–	◪ 20	1.08	9.9	–	–	–
 																				
I.C. / R: 9.525 / 1.5; 12.7 / 2.5																				
RF 断屑槽坚固耐用，是铸铁中型加工的首选。它的特点是略带正前角和稳定、适中的 T 倒槽。它也适用于钢材，有条件时也适用于不锈钢和硬质材料。																				
SCMT 09T308E-RF:T9425	●	0.8	■ 335	0.20	1.5	◪ 200	0.18	1.5	■ 315	0.20	1.5	–	–	–	–	–	–	–	–	–
SCMT 120408E-RF:T9425	●	0.8	■ 310	0.22	2.2	◪ 185	0.22	2.2	■ 290	0.22	2.2	–	–	–	–	–	–	–	–	–
 																				
DR4 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于粗加工至重载粗加工，连续切削至断续切削。它还适用于铸铁，并有条件地适用于不锈钢。																				
SCMT 380932E-DR4:T9425	⚙	3.2	■ 85	1.33	16.0	◪ 50	1.20	16.0	■ 80	1.33	16.0	–	–	–	–	–	–	–	–	–

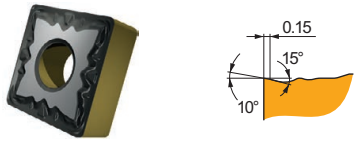
● 适用于稳定工况　⚙ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

SNMG

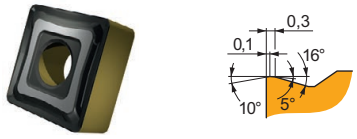
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	–	–	–	–
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2509	25.400	9.12	25.40	9.53



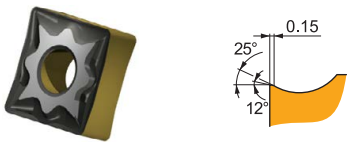
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
SNMG 120404E-FM:T9425	●	0.4	■ 365	0.20	2.1	◪ 215	0.18	2.1	■ 345	0.20	2.1	–	–	–	◪ 80	0.16	1.7	–	–	–
SNMG 120408E-FM:T9425	⬌	0.8	■ 435	0.20	2.1	◪ 260	0.18	2.1	■ 410	0.20	2.1	–	–	–	◪ 95	0.16	1.7	–	–	–
SNMG 120412E-FM:T9425	⬌	1.2	■ 420	0.27	2.1	◪ 250	0.24	2.1	■ 395	0.27	2.1	–	–	–	◪ 90	0.19	1.7	–	–	–

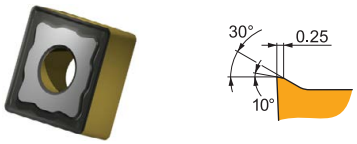
FM 断屑槽用途广泛，是钢和铸铁精加工的首选。它的特点是小正前角和窄的T-型倒棱。也有条件地适用于不锈钢和耐热合金。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
SNMG 090308E-M:T9425	⬌	–	■ 340	0.32	2.1	–	–	–	■ 320	0.32	2.1	–	–	–	–	–	–	–	–	–
SNMG 120408E-M:T9425	⬌	0.8	■ 340	0.32	2.1	–	–	–	■ 320	0.32	2.1	–	–	–	–	–	–	–	–	–
SNMG 120412E-M:T9425	⬌	1.2	■ 335	0.40	2.1	–	–	–	■ 315	0.40	2.1	–	–	–	–	–	–	–	–	–
SNMG 120416E-M:T9425	⬌	1.6	■ 350	0.40	2.1	–	–	–	■ 330	0.40	2.1	–	–	–	–	–	–	–	–	–
SNMG 150612E-M:T9425	⬌	1.2	■ 320	0.40	3.4	–	–	–	■ 300	0.40	3.4	–	–	–	–	–	–	–	–	–
SNMG 190612E-M:T9425	⬌	1.2	■ 315	0.40	4.0	–	–	–	■ 295	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-M:T9425	⬌	1.6	■ 330	0.40	4.0	–	–	–	■ 310	0.40	4.0	–	–	–	–	–	–	–	–	–

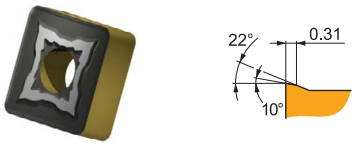
M 型断屑槽用途广泛，是铸铁中型加工的首选。它具有正前角和负/稳定、适中的 T 倒棱。它也适用于钢材和有条件的硬质材料。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
SNMG 120404E-NF:T9425	●	0.4	■ 390	0.18	1.7	■ 230	0.16	1.7	◪ 370	0.18	1.7	–	–	–	◪ 85	0.16	1.4	–	–	–
SNMG 120408E-NF:T9425	⬌	0.8	■ 455	0.19	1.7	■ 270	0.17	1.7	◪ 430	0.19	1.7	–	–	–	◪ 100	0.15	1.4	–	–	–

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

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
SNMG 120408E-NM:T9425	⬌	0.8	■ 420	0.25	2.1	■ 250	0.23	2.1	–	–	–	–	–	–	◪ 90	0.20	1.7	–	–	–

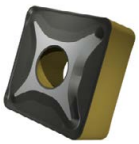
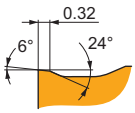
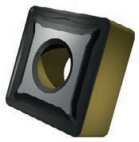
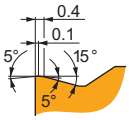
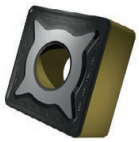
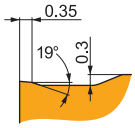
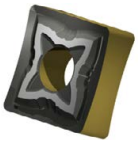
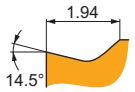
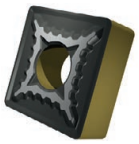
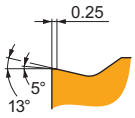
NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
SNMG 120408E-NMR:T9425	⬌	0.8	■ 320	0.35	2.6	■ 190	0.32	2.6	–	–	–	–	–	–	◪ 70	0.25	2.1	–	–	–
SNMG 120412E-NMR:T9425	⬌	1.2	■ 330	0.40	2.6	■ 195	0.36	2.6	–	–	–	–	–	–	◪ 70	0.28	2.1	–	–	–
SNMG 150612E-NMR:T9425	⬌	1.2	■ 315	0.40	3.8	■ 185	0.36	3.8	–	–	–	–	–	–	◪ 70	0.28	3.0	–	–	–

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

● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

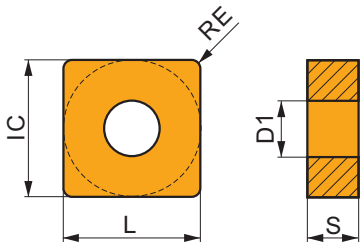
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 	NRM 型断屑槽用途广泛，是不锈钢粗加工的首选。它具有正前角和稳定、宽大的 T 倒棱。它还适用于钢和超级合金。																			
SNMG 250924-NRM:T9425	⬌	2.4	■ 150	0.65	9.0	■ 90	0.59	9.0	■ 140	0.65	9.0	–	–	–	◩ 30	0.46	7.2	–	–	–
 	R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																			
SNMG 120408E-R:T9425	⬌	0.8	■ 295	0.40	3.8	–	–	–	■ 280	0.40	3.8	–	–	–	–	–	–	–	–	–
SNMG 120412E-R:T9425	⬌	1.2	■ 300	0.45	3.8	–	–	–	■ 285	0.45	3.8	–	–	–	–	–	–	–	–	–
SNMG 120416E-R:T9425	✱	1.6	■ 305	0.50	3.8	–	–	–	■ 285	0.50	3.8	–	–	–	–	–	–	–	–	–
SNMG 150612E-R:T9425	✱	1.2	■ 295	0.45	4.5	–	–	–	■ 280	0.45	4.5	–	–	–	–	–	–	–	–	–
SNMG 150616E-R:T9425	✱	1.6	■ 300	0.50	4.5	–	–	–	■ 285	0.50	4.5	–	–	–	–	–	–	–	–	–
SNMG 190612E-R:T9425	✱	1.2	■ 285	0.45	6.0	–	–	–	■ 270	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:T9425	✱	1.6	■ 295	0.50	6.0	–	–	–	■ 280	0.50	6.0	–	–	–	–	–	–	–	–	–
 	RM 断屑槽坚固耐用，是钢件粗加工的首选。具有正前角和宽的稳定T-型倒棱。还适用于不锈钢、铸铁，有条件的用于耐热合金。																			
SNMG 120408E-RM:T9425	⬌	0.8	■ 340	0.40	4.0	■ 200	0.36	4.0	■ 320	0.40	4.0	–	–	–	◩ 75	0.28	3.2	–	–	–
SNMG 120412E-RM:T9425	⬌	1.2	■ 350	0.45	4.0	■ 210	0.41	4.0	■ 330	0.45	4.0	–	–	–	◩ 75	0.32	3.2	–	–	–
SNMG 120416E-RM:T9425	⬌	1.6	■ 355	0.50	4.0	■ 210	0.45	4.0	■ 335	0.50	4.0	–	–	–	◩ 75	0.35	3.2	–	–	–
SNMG 150612E-RM:T9425	⬌	1.2	■ 335	0.45	5.0	■ 200	0.41	5.0	■ 315	0.45	5.0	–	–	–	◩ 75	0.32	4.0	–	–	–
SNMG 150616E-RM:T9425	⬌	1.6	■ 345	0.50	5.0	■ 205	0.45	5.0	■ 325	0.50	5.0	–	–	–	◩ 75	0.35	4.0	–	–	–
SNMG 190612E-RM:T9425	⬌	1.2	■ 330	0.45	7.0	■ 195	0.41	7.0	■ 310	0.45	7.0	–	–	–	◩ 70	0.32	5.6	–	–	–
SNMG 190616E-RM:T9425	⬌	1.6	■ 335	0.50	7.0	■ 200	0.45	7.0	■ 315	0.50	7.0	–	–	–	◩ 75	0.35	5.6	–	–	–
SNMG 250924E-RM:T9425	⬌	2.4	■ 155	0.80	12.0	■ 90	0.72	12.0	■ 145	0.80	12.0	–	–	–	◩ 30	0.56	9.6	–	–	–
 	SF 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。特点是小正前角，无T-型倒棱。还适用于钢、铸铁和硬质材料，有条件时也适用于有色金属合金。																			
SNMG 120408E-SF:T9425	⬌	0.8	■ 450	0.20	1.0	■ 270	0.18	1.0	■ 425	0.20	1.0	–	–	–	◩ 100	0.16	0.8	–	–	–
 	SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。																			
SNMG 120408E-SM:T9425	⬌	0.8	■ 395	0.25	1.8	■ 235	0.23	1.8	■ 375	0.25	1.8	–	–	–	◩ 85	0.20	1.4	–	–	–
SNMG 190612E-SM:T9425	⬌	1.2	■ 360	0.30	4.0	■ 215	0.27	4.0	■ 340	0.30	4.0	–	–	–	◩ 80	0.27	3.2	–	–	–
SNMG 190616E-SM:T9425	⬌	1.6	■ 345	0.40	4.0	■ 205	0.36	4.0	■ 325	0.40	4.0	–	–	–	◩ 75	0.32	3.2	–	–	–

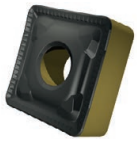
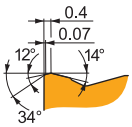
● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◩ 可以使用

SNMM

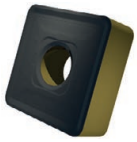
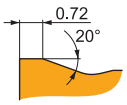
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



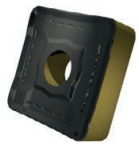
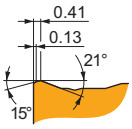
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
SNMM 190616E-HR:T9425	⚙	1.6	■ 145	0.60	9.0	◪ 85	0.54	9.0	■ 135	0.60	9.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9425	✱	2.4	■ 150	0.65	9.0	◪ 90	0.59	9.0	■ 140	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR:T9425	✱	1.6	■ 140	0.60	13.0	◪ 80	0.54	13.0	■ 130	0.60	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T9425	✱	2.4	■ 140	0.65	13.0	◪ 80	0.59	13.0	■ 130	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250732E-HR:T9425	✱	3.2	■ 130	0.80	13.0	◪ 75	0.72	13.0	■ 120	0.80	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T9425	✱	2.4	■ 140	0.65	13.0	◪ 80	0.59	13.0	■ 130	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250932E-HR:T9425	✱	3.2	■ 130	0.80	13.0	◪ 75	0.72	13.0	■ 120	0.80	13.0	–	–	–	–	–	–	–	–	–

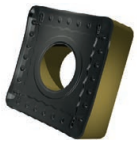
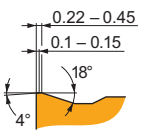
HR 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。

 																				
SNMM 190616-HR2:T9425	⚙	1.6	■ 140	0.65	8.9	◪ 80	0.59	8.9	■ 130	0.65	8.9	–	–	–	–	–	–	–	–	–
SNMM 190624-HR2:T9425	✱	2.4	■ 135	0.85	8.9	◪ 80	0.77	8.9	■ 125	0.85	8.9	–	–	–	–	–	–	–	–	–
SNMM 250724-HR2:T9425	✱	2.4	■ 130	0.85	11.0	◪ 75	0.77	11.0	■ 120	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9425	✱	2.4	■ 130	0.85	11.0	◪ 75	0.77	11.0	■ 120	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250932-HR2:T9425	✱	3.2	■ 125	1.00	11.0	◪ 75	0.90	11.0	■ 115	1.00	11.0	–	–	–	–	–	–	–	–	–

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

 																				
SNMM 120408E-NR2:T9425	⚙	0.8	■ 320	0.40	4.7	■ 190	0.36	4.7	◪ 300	0.40	4.7	–	–	–	◪ 70	0.32	3.8	–	–	–
SNMM 150612E-NR2:T9425	⚙	1.2	■ 315	0.45	6.0	■ 185	0.41	6.0	◪ 295	0.45	6.0	–	–	–	◪ 70	0.36	4.8	–	–	–
SNMM 150616E-NR2:T9425	✱	1.6	■ 325	0.50	6.0	■ 195	0.45	6.0	◪ 305	0.50	6.0	–	–	–	◪ 70	0.40	4.8	–	–	–
SNMM 190612E-NR2:T9425	✱	1.2	■ 310	0.45	8.0	■ 185	0.41	8.0	◪ 290	0.45	8.0	–	–	–	◪ 65	0.36	6.4	–	–	–
SNMM 190616E-NR2:T9425	✱	1.6	■ 315	0.50	8.0	■ 185	0.45	8.0	◪ 295	0.50	8.0	–	–	–	◪ 70	0.40	6.4	–	–	–
SNMM 190624E-NR2:T9425	✱	2.4	■ 285	0.80	8.0	■ 170	0.72	8.0	◪ 270	0.80	8.0	–	–	–	◪ 60	0.56	6.4	–	–	–
SNMM 250724E-NR2:T9425	✱	2.4	■ 150	0.80	12.0	■ 90	0.72	12.0	◪ 140	0.80	12.0	–	–	–	◪ 30	0.56	9.6	–	–	–
SNMM 250924E-NR2:T9425	✱	2.4	■ 150	0.80	12.0	■ 90	0.72	12.0	◪ 140	0.80	12.0	–	–	–	◪ 30	0.56	9.6	–	–	–

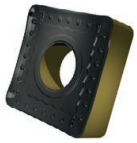
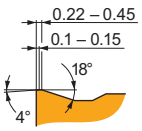
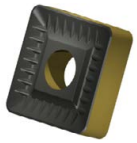
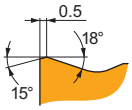
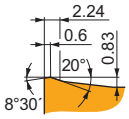
NR2 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于粗加工至重载粗加工，连续切削至间断切削。它还适用于钢材，并有条件地适用于铸铁和超级合金。

 																				
SNMM 120408E-OR:T9425	⚙	0.8	■ 320	0.40	4.7	◪ 190	0.36	4.7	■ 300	0.40	4.7	–	–	–	◪ 70	0.32	3.8	–	–	–
SNMM 120412E-OR:T9425	✱	1.2	■ 325	0.45	4.7	◪ 195	0.41	4.7	■ 305	0.45	4.7	–	–	–	◪ 70	0.36	3.8	–	–	–
SNMM 120416E-OR:T9425	✱	1.6	■ 330	0.50	4.7	◪ 195	0.45	4.7	■ 310	0.50	4.7	–	–	–	◪ 70	0.40	3.8	–	–	–
SNMM 150608E-OR:T9425	⚙	0.8	■ 315	0.40	6.0	◪ 185	0.36	6.0	■ 295	0.40	6.0	–	–	–	◪ 70	0.36	4.8	–	–	–
SNMM 150612E-OR:T9425	✱	1.2	■ 315	0.45	6.0	◪ 185	0.41	6.0	■ 295	0.45	6.0	–	–	–	◪ 70	0.36	4.8	–	–	–
SNMM 150616E-OR:T9425	✱	1.6	■ 325	0.50	6.0	◪ 195	0.45	6.0	■ 305	0.50	6.0	–	–	–	◪ 70	0.40	4.8	–	–	–
SNMM 190612E-OR:T9425	✱	1.2	■ 310	0.45	8.0	◪ 185	0.41	8.0	■ 290	0.45	8.0	–	–	–	◪ 65	0.36	6.4	–	–	–

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

● 适用于稳定工况　⚙ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

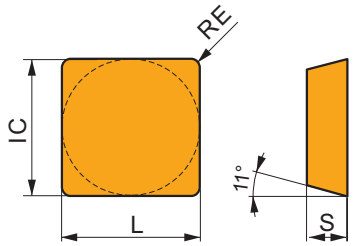
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
OR 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于铸铁，并有条件地适用于不锈钢和超级合金。																				
SNMM 190616E-OR:T9425	✱	1.6	■ 315	0.50	8.0	◪ 185	0.45	8.0	■ 295	0.50	8.0	–	–	–	◪ 70	0.40	6.4	–	–	–
SNMM 190624E-OR:T9425	✱	2.4	■ 285	0.80	8.0	◪ 170	0.72	8.0	■ 270	0.80	8.0	–	–	–	◪ 60	0.56	6.4	–	–	–
SNMM 250716E-OR:T9425	✱	1.6	■ 160	0.55	12.0	◪ 95	0.50	12.0	■ 150	0.55	12.0	–	–	–	◪ 35	0.50	9.6	–	–	–
SNMM 250724E-OR:T9425	✱	2.4	■ 135	1.00	12.0	◪ 80	0.90	12.0	■ 125	1.00	12.0	–	–	–	◪ 30	0.70	9.6	–	–	–
SNMM 250924E-OR:T9425	✱	2.4	■ 135	1.00	12.0	◪ 80	0.90	12.0	■ 125	1.00	12.0	–	–	–	◪ 30	0.70	9.6	–	–	–
 																				
SR 屑槽，适用于粗加工至重载粗加工，连续至断续切削。																				
SNMM 250724S-SR:T9425	✱	2.4	■ 110	1.00	12.0	◪ 65	0.90	12.0	■ 100	1.00	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924S-SR:T9425	✱	2.4	■ 110	1.00	14.0	◪ 65	0.90	14.0	■ 100	1.00	14.0	–	–	–	–	–	–	–	–	–
																				
923 型断屑槽坚固耐用，专为重型不锈钢粗加工而设计。适用于中粗加工至重载粗加工，连续至重断续切削。它也有条件地适用于钢和铸铁。																				
SNMM 190616S-923:T9425	✱	1.6	■ 255	0.65	8.9	■ 150	0.59	8.9	◪ 240	0.65	8.9	–	–	–	◪ 55	0.52	7.1	–	–	–
SNMM 250724S-923:T9425	✱	2.4	■ 130	0.85	11.0	■ 75	0.77	11.0	◪ 120	0.85	11.0	–	–	–	◪ 25	0.60	8.8	–	–	–
SNMM 250924S-923:T9425	✱	2.4	■ 130	0.85	11.0	■ 75	0.77	11.0	◪ 120	0.85	11.0	–	–	–	◪ 25	0.60	8.8	–	–	–

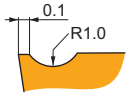
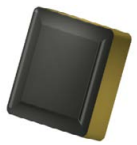
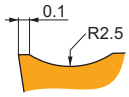
SPMR

DORMER PRAMET

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



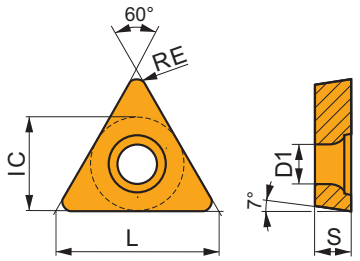
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
46 断屑槽适用于精细的精加工，连续切削至间断切削。																				
SPMR 090308E-46:T9425	●	0.8	■ 380	0.15	1.0	◪ 225	0.15	1.0	■ 360	0.15	1.0	–	–	–	–	–	–	–	–	–
 																				
48 断屑槽适用于精加工至中粗加工，连续至断续切削。																				
SPMR 120304E-48:T9425	●	0.4	■ 260	0.22	2.2	◪ 155	0.22	2.2	■ 245	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120308E-48:T9425	⇕	0.8	■ 310	0.22	2.2	◪ 185	0.22	2.2	■ 290	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120312E-48:T9425	⇕	1.2	■ 325	0.22	2.2	◪ 195	0.22	2.2	■ 305	0.22	2.2	–	–	–	–	–	–	–	–	–

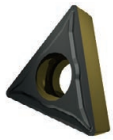
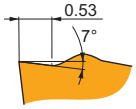
● 适用于稳定工况　⇕ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

TCMT

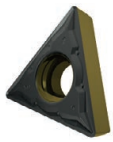
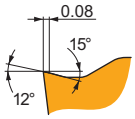
	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



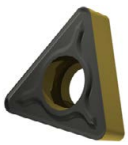
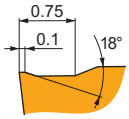
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
TCMT 06T104E-FF2:T9425	●	0.4	■ 315	0.12	0.8	–	–	–	■ 295	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T9425	●	0.4	■ 310	0.12	1.0	–	–	–	■ 290	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2:T9425	●	0.4	■ 315	0.12	0.8	–	–	–	■ 295	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FF2:T9425	●	0.8	■ 335	0.17	0.8	–	–	–	■ 315	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T9425	●	0.4	■ 315	0.12	0.8	–	–	–	■ 295	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2:T9425	●	0.8	■ 335	0.17	0.8	–	–	–	■ 315	0.17	0.8	–	–	–	–	–	–	–	–	–

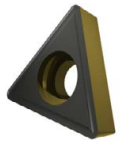
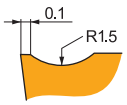
FF2 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。

 																				
TCMT 110202E-FM:T9425	●	0.2	■ 345	0.10	0.8	■ 205	0.09	0.8	◪ 325	0.10	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T9425	●	0.4	■ 305	0.18	0.8	■ 180	0.16	0.8	◪ 285	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM:T9425	●	0.8	■ 370	0.17	0.8	■ 220	0.15	0.8	◪ 350	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T9425	●	0.4	■ 285	0.18	1.7	■ 170	0.16	1.7	◪ 270	0.18	1.7	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T9425	●	0.8	■ 340	0.17	1.7	■ 200	0.15	1.7	◪ 320	0.17	1.7	–	–	–	–	–	–	–	–	–

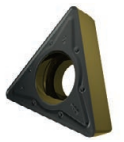
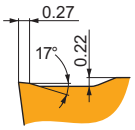
FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。

 																				
TCMT 110204E-FM2:T9425	●	0.4	■ 315	0.12	0.8	◪ 185	0.11	0.8	■ 295	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM2:T9425	●	0.8	■ 335	0.17	0.8	◪ 200	0.15	0.8	■ 315	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2:T9425	●	0.8	■ 310	0.20	1.0	◪ 185	0.18	1.0	■ 290	0.20	1.0	–	–	–	–	–	–	–	–	–

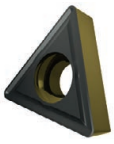
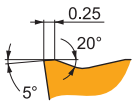
FM2 断屑槽坚固耐用，是钢材中型加工的首选。它具有正前角和稳定、适中的 T 倒棱。它还适用于铸铁和有条件的不锈钢。

 																				
TCMT 16T308E-RF:T9425	●	0.8	■ 270	0.20	1.5	◪ 160	0.18	1.5	■ 255	0.20	1.5	–	–	–	–	–	–	–	–	–

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

 																				
TCMT 16T308E-RM:T9425	●	0.8	■ 305	0.27	1.9	■ 180	0.24	1.9	■ 285	0.27	1.9	–	–	–	◪ 65	0.19	1.5	–	–	–
TCMT 16T312E-RM:T9425	⚙	1.2	■ 320	0.27	1.9	■ 190	0.24	1.9	■ 300	0.27	1.9	–	–	–	◪ 70	0.19	1.5	–	–	–

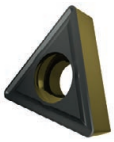
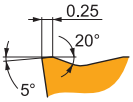
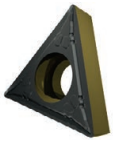
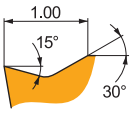
RM 型断屑槽坚固耐用，是钢和铸铁粗加工的首选。它具有正前角和稳定开放的 T 倒棱。它还适用于不锈钢，并有条件地适用于超级合金和硬质材料。

 																				
TCMT 16T304E-RM3:T9425	●	0.4	■ 225	0.25	2.0	◪ 135	0.25	2.0	■ 210	0.25	2.0	–	–	–	–	–	–	–	–	–
TCMT 16T308E-RM3:T9425	●	0.8	■ 265	0.27	2.0	◪ 155	0.27	2.0	■ 250	0.27	2.0	–	–	–	–	–	–	–	–	–

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

● 适用于稳定工况　⚙ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

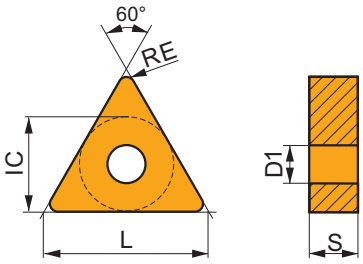
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
RM3 断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。具有正前角和宽的T-型倒棱。也有条件地适用于不锈钢和硬质材料。																				
 																				
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。																				
TCMT 110204E-UR:T9425	●	0.4	260	0.18	0.8	155	0.16	0.8	245	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:T9425	●	0.4	260	0.18	0.8	155	0.16	0.8	245	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T9425	●	0.8	320	0.17	0.8	190	0.15	0.8	300	0.17	0.8	–	–	–	–	–	–	–	–	–

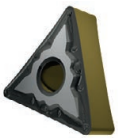
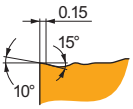
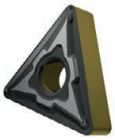
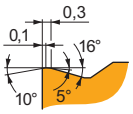
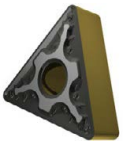
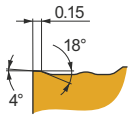
TNMG

DORMER 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	9.53

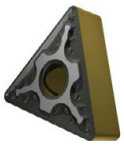
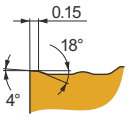
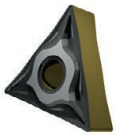
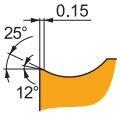
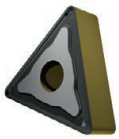
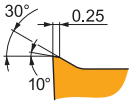
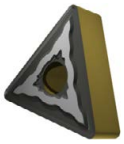
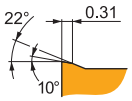
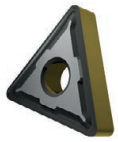
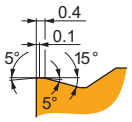
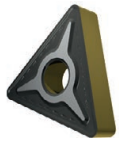
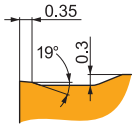


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
FM 断屑槽用途广泛，是钢和铸铁精加工的首选。它的特点是小正前角和窄的T-型倒棱。也有条件地适用于不锈钢和耐热合金。																				
TNMG 160404E-FM:T9425	●	0.4	305	0.20	1.7	180	0.18	1.7	285	0.20	1.7	–	–	–	65	0.20	1.4	–	–	–
TNMG 160408E-FM:T9425	●	0.8	360	0.20	1.7	215	0.18	1.7	340	0.20	1.7	–	–	–	80	0.16	1.4	–	–	–
TNMG 160412E-FM:T9425	●	1.2	355	0.25	1.7	210	0.23	1.7	335	0.25	1.7	–	–	–	75	0.18	1.4	–	–	–
TNMG 220404E-FM:T9425	●	0.4	305	0.20	1.7	180	0.18	1.7	285	0.20	1.7	–	–	–	65	0.18	1.4	–	–	–
TNMG 220408E-FM:T9425	●	0.8	360	0.20	1.7	215	0.18	1.7	340	0.20	1.7	–	–	–	80	0.16	1.4	–	–	–
 																				
M 型断屑槽用途广泛，是铸铁中型加工的首选。它具有正前角和负/稳定、适中的 T 倒棱。它也适用于钢材和有条件的硬质材料。																				
TNMG 160404E-M:T9425	●	0.4	275	0.20	1.6	–	–	–	260	0.20	1.6	–	–	–	–	–	–	–	–	–
TNMG 160408E-M:T9425	●	0.8	290	0.30	1.6	–	–	–	275	0.30	1.6	–	–	–	–	–	–	–	–	–
TNMG 160412E-M:T9425	⬌	1.2	280	0.40	1.6	–	–	–	265	0.40	1.6	–	–	–	–	–	–	–	–	–
TNMG 220408E-M:T9425	●	0.8	280	0.30	2.1	–	–	–	265	0.30	2.1	–	–	–	–	–	–	–	–	–
TNMG 220412E-M:T9425	⬌	1.2	270	0.40	2.1	–	–	–	255	0.40	2.1	–	–	–	–	–	–	–	–	–
 																				
ML 型断屑槽用途广泛，专为低切削深度和钢材的中型加工而设计。它具有正前角和稳定的窄 T 型面。同样适用于铸铁加工。																				
TNMG 160404-ML:T9415	●	0.4	310	0.20	1.0	–	–	–	290	0.20	1.0	–	–	–	–	–	–	–	–	–
TNMG 160404-ML:T9425	●	0.4	290	0.20	1.0	–	–	–	275	0.20	1.0	–	–	–	–	–	–	–	–	–
TNMG 160408-ML:T9415	●	0.8	320	0.25	1.5	–	–	–	300	0.25	1.5	–	–	–	–	–	–	–	–	–

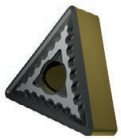
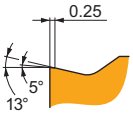
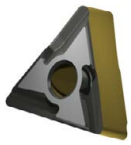
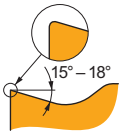
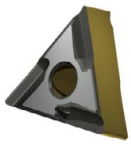
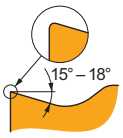
● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

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

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
ML 型断屑槽用途广泛，专为低切削深度和钢材的中型加工而设计。它具有正前角和稳定的窄 T 型面。同样适用于铸铁加工。																				
TNMG 160408-ML:T9425	⇕	0.8	■ 310	0.25	1.5	–	–	–	■ 290	0.25	1.5	–	–	–	–	–	–	–	–	–
TNMG 160412-ML:T9415	⇕	1.2	■ 305	0.30	2.0	–	–	–	◪ 285	0.30	2.0	–	–	–	–	–	–	–	–	–
TNMG 160412-ML:T9425	⇕	1.2	■ 300	0.30	2.0	–	–	–	■ 285	0.30	2.0	–	–	–	–	–	–	–	–	–
 																				
NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。																				
TNMG 160404E-NF:T9425	●	0.4	■ 320	0.18	1.4	■ 190	0.16	1.4	◪ 300	0.18	1.4	–	–	–	◪ 70	0.16	1.1	–	–	–
TNMG 160408E-NF:T9425	●	0.8	■ 380	0.18	1.4	■ 225	0.16	1.4	◪ 360	0.18	1.4	–	–	–	◪ 85	0.16	1.1	–	–	–
 																				
NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。																				
TNMG 160404E-NM:T9425	●	0.4	■ 315	0.20	1.9	■ 185	0.18	1.9	–	–	–	–	–	–	◪ 70	0.20	1.5	–	–	–
TNMG 160408E-NM:T9425	●	0.8	■ 345	0.25	1.9	■ 205	0.23	1.9	–	–	–	–	–	–	◪ 75	0.20	1.5	–	–	–
TNMG 220408E-NM:T9425	●	0.8	■ 350	0.25	1.7	■ 210	0.23	1.7	–	–	–	–	–	–	◪ 75	0.20	1.4	–	–	–
TNMG 220412E-NM:T9425	⇕	1.2	■ 340	0.30	2.1	■ 200	0.27	2.1	–	–	–	–	–	–	◪ 75	0.24	1.7	–	–	–
 																				
NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
TNMG 160404E-NMR:T9425	●	0.4	■ 275	0.20	1.7	■ 165	0.18	1.7	–	–	–	–	–	–	◪ 60	0.18	1.4	–	–	–
TNMG 160408E-NMR:T9425	⇕	0.8	■ 290	0.30	1.7	■ 170	0.27	1.7	–	–	–	–	–	–	◪ 65	0.24	1.4	–	–	–
TNMG 220408E-NMR:T9425	⇕	0.8	■ 280	0.30	2.1	■ 165	0.27	2.1	–	–	–	–	–	–	◪ 60	0.24	1.7	–	–	–
TNMG 220412E-NMR:T9425	⇕	1.2	■ 295	0.30	2.1	■ 175	0.27	2.1	–	–	–	–	–	–	◪ 65	0.24	1.7	–	–	–
 																				
R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																				
TNMG 160408E-R:T9425	⇕	0.8	■ 250	0.40	3.0	–	–	–	■ 235	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412E-R:T9425	⇕	1.2	■ 260	0.40	3.0	–	–	–	■ 245	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 220408E-R:T9425	⇕	0.8	■ 240	0.40	4.0	–	–	–	■ 225	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220412E-R:T9425	⇕	1.2	■ 255	0.40	4.0	–	–	–	■ 240	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220416E-R:T9425	⇕	1.6	■ 265	0.40	4.0	–	–	–	■ 250	0.40	4.0	–	–	–	–	–	–	–	–	–
 																				
RM 断屑槽坚固耐用，是钢件粗加工的首选。具有正前角和宽的稳定T-型倒棱。还适用于不锈钢、铸铁，有条件的用于耐热合金。																				
TNMG 160408E-RM:T9425	⇕	0.8	■ 285	0.40	3.0	■ 170	0.36	3.0	■ 270	0.40	3.0	–	–	–	◪ 60	0.30	2.4	–	–	–
TNMG 160412E-RM:T9425	⇕	1.2	■ 300	0.40	3.0	■ 180	0.36	3.0	■ 285	0.40	3.0	–	–	–	◪ 65	0.30	2.4	–	–	–
TNMG 220408E-RM:T9425	⇕	0.8	■ 275	0.40	4.0	■ 165	0.36	4.0	■ 260	0.40	4.0	–	–	–	◪ 60	0.30	3.2	–	–	–
TNMG 220412E-RM:T9425	⇕	1.2	■ 290	0.40	4.0	■ 170	0.36	4.0	■ 275	0.40	4.0	–	–	–	◪ 65	0.30	3.2	–	–	–
TNMG 220416E-RM:T9425	⇕	1.6	■ 305	0.40	4.0	■ 180	0.36	4.0	■ 285	0.40	4.0	–	–	–	◪ 65	0.30	3.2	–	–	–
TNMG 270612E-RM:T9425	⇕	1.2	■ 155	0.40	6.0	■ 90	0.36	6.0	■ 145	0.40	6.0	–	–	–	◪ 30	0.30	4.8	–	–	–
TNMG 270616E-RM:T9425	⇕	1.6	■ 160	0.40	6.0	■ 95	0.36	6.0	■ 150	0.40	6.0	–	–	–	◪ 35	0.30	4.8	–	–	–
TNMG 270624E-RM:T9425	⇕	2.4	■ 155	0.50	6.0	■ 90	0.45	6.0	■ 145	0.50	6.0	–	–	–	◪ 30	0.38	4.8	–	–	–
TNMG 270632E-RM:T9425	⇕	3.2	■ 150	0.60	6.0	■ 90	0.54	6.0	■ 140	0.60	6.0	–	–	–	◪ 30	0.45	4.8	–	–	–
TNMG 330924E-RM:T9425	⇕	2.4	■ 150	0.50	10.0	■ 90	0.45	10.0	■ 140	0.50	10.0	–	–	–	◪ 30	0.38	8.0	–	–	–

● 适用于稳定工况　⇕ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

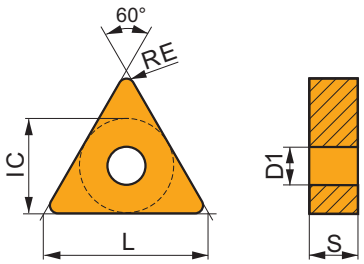
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 	SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。																			
TNMG 160404E-SM:T9425	●	0.4	■ 290	0.20	1.7	■ 170	0.18	1.7	■ 275	0.20	1.7	–	–	–	◪ 65	0.18	1.4	–	–	–
TNMG 160408E-SM:T9425	●	0.8	■ 320	0.25	1.7	■ 190	0.23	1.7	■ 300	0.25	1.7	–	–	–	◪ 70	0.20	1.4	–	–	–
TNMG 160412E-SM:T9425	⬌	1.2	■ 320	0.30	1.7	■ 190	0.27	1.7	■ 300	0.30	1.7	–	–	–	◪ 70	0.24	1.4	–	–	–
TNMG 220404E-SM:T9425	●	0.4	■ 290	0.20	1.7	■ 170	0.18	1.7	■ 275	0.20	1.7	–	–	–	◪ 65	0.18	1.4	–	–	–
TNMG 220408E-SM:T9425	●	0.8	■ 320	0.25	1.7	■ 190	0.23	1.7	■ 300	0.25	1.7	–	–	–	◪ 70	0.20	1.4	–	–	–
TNMG 220412E-SM:T9425	⬌	1.2	■ 320	0.30	1.7	■ 190	0.27	1.7	■ 300	0.30	1.7	–	–	–	◪ 70	0.24	1.4	–	–	–
 	SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。																			
TNMG 160404ER-SI:T9425	●	0.4	■ 350	0.20	1.5	■ 210	0.18	1.5	–	–	–	–	–	–	◪ 75	0.18	1.2	–	–	–
TNMG 160408ER-SI:T9425	●	0.8	■ 345	0.35	1.5	■ 205	0.32	1.5	–	–	–	–	–	–	◪ 75	0.25	1.2	–	–	–
 	SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。																			
TNMG 160404EL-SI:T9425	●	0.4	■ 350	0.20	1.5	■ 210	0.18	1.5	–	–	–	–	–	–	◪ 75	0.18	1.2	–	–	–
TNMG 160408EL-SI:T9425	●	0.8	■ 345	0.35	1.5	■ 205	0.32	1.5	–	–	–	–	–	–	◪ 75	0.25	1.2	–	–	–

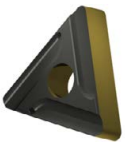
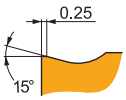
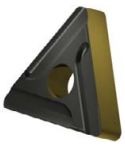
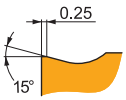
TNMM

DORMER PRAMET

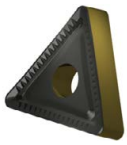
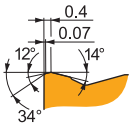
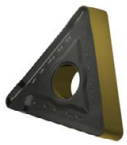
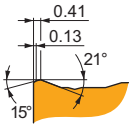
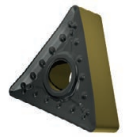
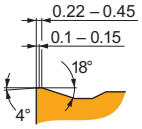
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76
2706	15.875	6.35	27.50	6.35



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。

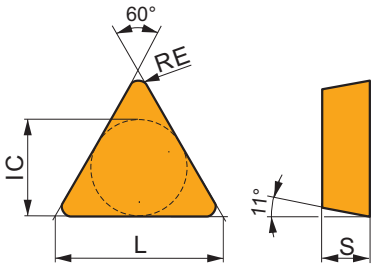
产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 	EL 屑槽，左手设计，适用于中等至中粗加工，连续切削。																			
TNMM 220412EL:T9425	●	1.2	■ 355	0.35	2.1	■ 210	0.32	2.1	–	–	–	–	–	–	◪ 75	0.25	1.7	–	–	–
 	ER 屑槽，右手设计，适用于中等至中粗加工，连续切削。																			
TNMM 220412ER:T9425	●	1.2	■ 355	0.35	2.1	■ 210	0.32	2.1	–	–	–	–	–	–	◪ 75	0.25	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。

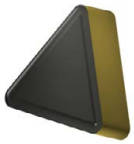
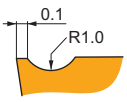
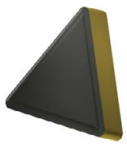
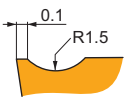
产品	● ⇔ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
HR 型断屑槽坚固耐用，专为钢和铸铁的重型粗加工而设计。适用于粗加工至重载粗加工，连续切削至间断切削。它也有条件地适用于不锈钢。																				
TNMM 270616E-HR:T9425	⇔	1.6	■ 120	0.60	7.0	◪ 70	0.54	7.0	■ 110	0.60	7.0	–	–	–	–	–	–	–	–	–
 																				
NR2 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于粗加工至重载粗加工，连续切削至间断切削。它还适用于钢材，并有条件地适用于铸铁和超级合金。																				
TNMM 160408E-NR2:T9425	⇔	0.8	■ 275	0.40	3.0	■ 165	0.36	3.0	◪ 260	0.40	3.0	–	–	–	◪ 60	0.28	2.4	–	–	–
TNMM 220408E-NR2:T9425	⇔	0.8	■ 265	0.40	4.0	■ 155	0.36	4.0	◪ 250	0.40	4.0	–	–	–	◪ 55	0.28	3.2	–	–	–
TNMM 220412E-NR2:T9425	⇔	1.2	■ 280	0.40	4.0	■ 165	0.36	4.0	◪ 265	0.40	4.0	–	–	–	◪ 60	0.32	3.2	–	–	–
 																				
OR 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于铸铁，并有条件地适用于不锈钢和超级合金。																				
TNMM 160408E-OR:T9425	⇔	0.8	■ 275	0.40	3.0	◪ 165	0.36	3.0	■ 260	0.40	3.0	–	–	–	◪ 60	0.28	2.4	–	–	–
TNMM 220408E-OR:T9425	⇔	0.8	■ 265	0.40	4.0	◪ 155	0.36	4.0	■ 250	0.40	4.0	–	–	–	◪ 55	0.32	3.2	–	–	–
TNMM 220412E-OR:T9425	⇔	1.2	■ 285	0.40	3.0	◪ 170	0.36	3.0	■ 270	0.40	3.0	–	–	–	◪ 60	0.32	2.4	–	–	–

TPMR

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

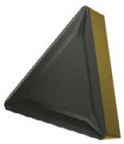
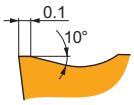


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⇔ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
46 断屑槽适用于精细的精加工，连续切削至间断切削。																				
TPMR 110304E-46:T9425	●	0.4	■ 260	0.15	1.0	◪ 155	0.15	1.0	■ 245	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110308E-46:T9425	●	0.8	■ 310	0.15	1.0	◪ 185	0.15	1.0	■ 290	0.15	1.0	–	–	–	–	–	–	–	–	–
 																				
47 断屑槽适用于精加工至中粗加工，连续至断续切削。																				
TPMR 160304E-47:T9425	●	0.4	■ 225	0.20	1.5	◪ 135	0.18	1.5	■ 210	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160308E-47:T9425	●	0.8	■ 270	0.20	1.5	◪ 160	0.18	1.5	■ 255	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160312E-47:T9425	●	1.2	■ 285	0.20	1.5	◪ 170	0.18	1.5	■ 270	0.20	1.5	–	–	–	–	–	–	–	–	–

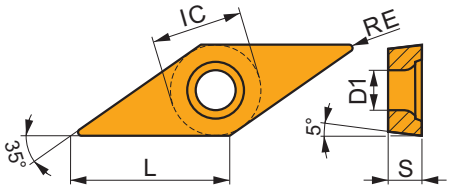
● 适用于稳定工况　⇔ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

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

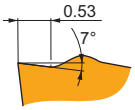
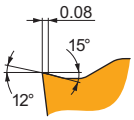
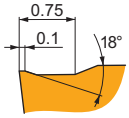
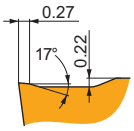
产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
61 断屑槽适用于中等进给和切削深度的精加工，连续至断续切削。																				
TPMR 160308E-61:T9425	●	0.8	■ 220	0.35	1.8	◩ 130	0.32	1.8	■ 205	0.35	1.8	–	–	–	–	–	–	–	–	–

VBMT

	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

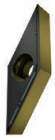
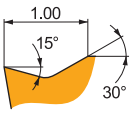


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
FF2 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。																				
VBMT 160404E-FF2:T9425	●	0.4	■ 275	0.12	0.8	–	–	–	■ 260	0.12	0.8	–	–	–	–	–	–	–	–	–
																				
FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。																				
VBMT 110302E-FM:T9425	●	0.2	■ 300	0.10	0.8	■ 180	0.09	0.8	◩ 285	0.10	0.8	–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T9425	●	0.4	■ 260	0.19	0.8	■ 155	0.17	0.8	◩ 245	0.19	0.8	–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T9425	●	0.8	■ 320	0.17	0.8	■ 190	0.15	0.8	◩ 300	0.17	0.8	–	–	–	–	–	–	–	–	–
VBMT 160402E-FM:T9425	●	0.2	■ 290	0.10	1.2	■ 170	0.09	1.2	◩ 275	0.10	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T9425	●	0.4	■ 250	0.19	1.2	■ 150	0.17	1.2	◩ 235	0.19	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T9425	●	0.8	■ 305	0.17	1.2	■ 180	0.15	1.2	◩ 285	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T9425	●	1.2	■ 295	0.22	1.2	■ 175	0.22	1.2	◩ 280	0.22	1.2	–	–	–	–	–	–	–	–	–
																				
FM2 断屑槽坚固耐用，是钢材中型加工的首选。它具有正前角和稳定、适中的 T 倒棱。它还适用于铸铁和有条件的不锈钢。																				
VBMT 160404E-FM2:T9425	●	0.4	■ 265	0.12	1.2	◩ 155	0.11	1.2	■ 250	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T9425	●	0.8	■ 265	0.20	1.2	◩ 155	0.18	1.2	■ 250	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T9425	●	1.2	■ 270	0.22	1.2	◩ 160	0.20	1.2	■ 255	0.22	1.2	–	–	–	–	–	–	–	–	–
																				
RM 型断屑槽坚固耐用，是钢和铸铁粗加工的首选。它具有正前角和稳定开放的 T 倒棱。它还适用于不锈钢，并有条件地适用于超级合金和硬质材料。																				
VBMT 160404E-RM:T9425	●	0.4	■ 260	0.20	1.2	■ 155	0.18	1.2	■ 245	0.20	1.2	–	–	–	◩ 55	0.18	1.0	–	–	–
VBMT 160408E-RM:T9425	●	0.8	■ 305	0.20	1.2	■ 180	0.18	1.2	■ 285	0.20	1.2	–	–	–	◩ 65	0.18	1.0	–	–	–
VBMT 160412E-RM:T9425	●	1.2	■ 290	0.27	1.2	■ 170	0.24	1.2	■ 275	0.27	1.2	–	–	–	◩ 65	0.19	1.0	–	–	–

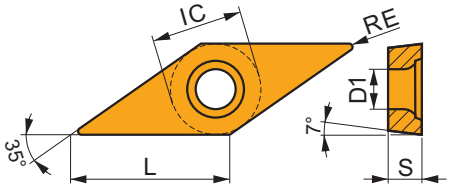
● 适用于稳定工况　⚙ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◩ 可以使用

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

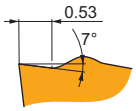
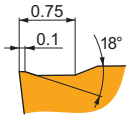
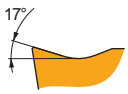
产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。																				
VBMT 110204E-UR:T9425	●	0.4	■ 225	0.19	0.8	◪ 135	0.17	0.8	■ 210	0.19	0.8	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T9425	●	0.4	■ 220	0.18	1.2	◪ 130	0.16	1.2	■ 205	0.18	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T9425	●	0.8	■ 265	0.17	1.2	◪ 155	0.15	1.2	■ 250	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-UR:T9425	●	1.2	■ 255	0.22	1.2	◪ 150	0.20	1.2	■ 240	0.22	1.2	–	–	–	–	–	–	–	–	–

VCGT

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



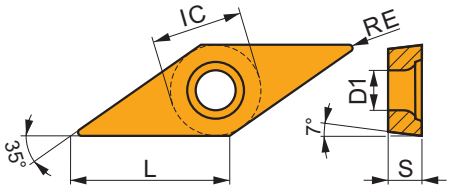
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⚙ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
FF2 断屑槽非常锋利，是钢件精加工的首选。特点是小正前角，没有T-型倒棱。也适用于铸铁。																				
VCGT 130302E-FF2:T9425	●	0.2	■ 315	0.05	1.0	–	–	–	■ 295	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T9425	●	0.4	■ 255	0.12	1.0	–	–	–	■ 240	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2:T9425	●	0.8	■ 270	0.17	1.0	–	–	–	■ 255	0.17	1.0	–	–	–	–	–	–	–	–	–
																				
FM2 断屑槽坚固耐用，是钢材中型加工的首选。它具有正前角和稳定、适中的 T 倒棱。它还适用于铸铁和有条件的不锈钢。																				
VCGT 130308E-FM2:T9425	●	0.8	■ 270	0.17	1.0	◪ 160	0.15	1.0	■ 255	0.17	1.0	–	–	–	–	–	–	–	–	–
																				
NF2 断屑槽非常锋利，是不锈钢精加工的首选。具有正前角，无T-型倒棱。还适用于耐热合金，有条件地适用于钢、铸铁和有色合金。																				
VCGT 130302E-NF2:T9425	●	0.2	◪ 285	0.07	1.0	■ 170	0.06	1.0	◪ 270	0.07	1.0	–	–	–	◪ 60	0.06	0.8	–	–	–
VCGT 130304E-NF2:T9425	●	0.4	◪ 255	0.12	1.0	■ 150	0.11	1.0	◪ 240	0.12	1.0	–	–	–	◪ 55	0.08	0.8	–	–	–
VCGT 130308E-NF2:T9425	●	0.8	◪ 270	0.17	1.0	■ 160	0.15	1.0	◪ 255	0.17	1.0	–	–	–	◪ 60	0.12	0.8	–	–	–

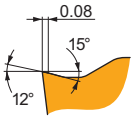
● 适用于稳定工况　⚙ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

VCMT

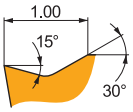
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



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

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
VCMT 160404E-FM:T9425	●	0.4	■	235	0.19	1.2	■	140	0.17	1.2	◪	220	0.19	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM:T9425	●	0.8	■	290	0.17	1.2	■	170	0.15	1.2	◪	275	0.17	1.2	–	–	–	–	–	–	–	–	–

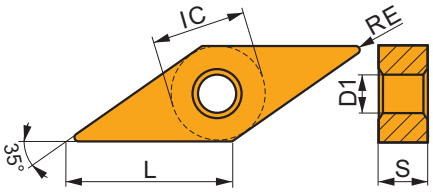
FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。

																							
VCMT 110304E-UR:T9425	●	0.4	■	215	0.19	0.8	◪	125	0.17	0.8	■	200	0.19	0.8	–	–	–	–	–	–	–	–	–
VCMT 110308E-UR:T9425	●	0.8	■	260	0.17	0.8	◪	155	0.15	0.8	■	245	0.17	0.8	–	–	–	–	–	–	–	–	–
VCMT 160404E-UR:T9425	●	0.4	■	205	0.19	1.2	◪	120	0.17	1.2	■	190	0.19	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-UR:T9425	●	0.8	■	250	0.17	1.2	◪	150	0.15	1.2	■	235	0.17	1.2	–	–	–	–	–	–	–	–	–

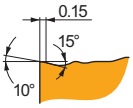
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。

VNMG

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

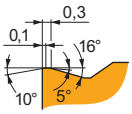
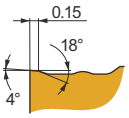
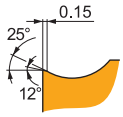
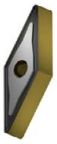
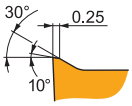
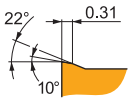
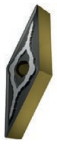
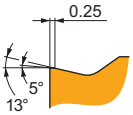


线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
VNMG 160404E-FM:T9425	●	0.4	■	260	0.20	1.2	◪	155	0.18	1.2	■	245	0.20	1.2	–	–	–	◪	55	0.20	1.0	–	–	–
VNMG 160408E-FM:T9425	●	0.8	■	300	0.20	1.4	◪	180	0.18	1.4	■	285	0.20	1.4	–	–	–	◪	65	0.16	1.1	–	–	–
VNMG 160412E-FM:T9425	●	1.2	■	310	0.22	1.4	◪	185	0.20	1.4	■	290	0.22	1.4	–	–	–	◪	65	0.18	1.1	–	–	–

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

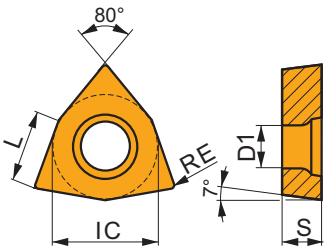
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
M 型断屑槽用途广泛，是铸铁中型加工的首选。它具有正前角和负/稳定、适中的 T 倒棱。它也适用于钢材和有条件的硬质材料。																				
VNMG 160404E-M:T9425	●	0.4	■ 235	0.20	1.2	–	–	–	■ 220	0.20	1.2	–	–	–	–	–	–	–	–	–
VNMG 160408E-M:T9425	●	0.8	■ 240	0.30	1.4	–	–	–	■ 225	0.30	1.4	–	–	–	–	–	–	–	–	–
VNMG 160412E-M:T9425	●	1.2	■ 230	0.40	1.4	–	–	–	■ 215	0.40	1.4	–	–	–	–	–	–	–	–	–
																				
ML 型断屑槽用途广泛，专为低切削深度和钢材的中型加工而设计。它具有正前角和稳定的窄 T 型面。同样适用于铸铁加工。																				
VNMG 160404-ML:T9415	●	0.4	■ 255	0.20	1.0	–	–	–	◪ 240	0.20	1.0	–	–	–	–	–	–	–	–	–
VNMG 160404-ML:T9425	●	0.4	■ 240	0.20	1.0	–	–	–	■ 225	0.20	1.0	–	–	–	–	–	–	–	–	–
VNMG 160408-ML:T9415	●	0.8	■ 265	0.25	1.5	–	–	–	◪ 250	0.25	1.5	–	–	–	–	–	–	–	–	–
VNMG 160408-ML:T9425	●	0.8	■ 255	0.25	1.5	–	–	–	■ 240	0.25	1.5	–	–	–	–	–	–	–	–	–
																				
NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T 倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。																				
VNMG 160404E-NF:T9425	●	0.4	■ 270	0.18	1.2	■ 160	0.16	1.2	◪ 255	0.18	1.2	–	–	–	◪ 60	0.16	1.0	–	–	–
VNMG 160408E-NF:T9425	●	0.8	■ 310	0.18	1.4	■ 185	0.16	1.4	◪ 290	0.18	1.4	–	–	–	◪ 65	0.16	1.1	–	–	–
 																				
NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。																				
VNMG 160408E-NM:T9425	●	0.8	■ 265	0.30	2.1	■ 155	0.27	2.1	–	–	–	–	–	–	◪ 55	0.24	1.7	–	–	–
																				
NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
VNMG 160404E-NMR:T9425	●	0.4	■ 235	0.20	1.2	■ 140	0.18	1.2	–	–	–	–	–	–	◪ 50	0.18	1.0	–	–	–
VNMG 160408E-NMR:T9425	●	0.8	■ 240	0.30	1.4	■ 140	0.27	1.4	–	–	–	–	–	–	◪ 50	0.24	1.1	–	–	–
 																				
SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。																				
VNMG 160404E-SM:T9425	●	0.4	■ 255	0.18	1.2	■ 150	0.16	1.2	■ 240	0.18	1.2	–	–	–	◪ 55	0.16	1.0	–	–	–
VNMG 160408E-SM:T9425	●	0.8	■ 270	0.25	1.4	■ 160	0.23	1.4	■ 255	0.25	1.4	–	–	–	◪ 60	0.20	1.1	–	–	–

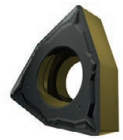
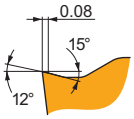
● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

WCMT

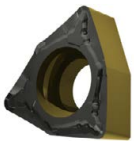
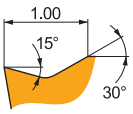
	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



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

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
WCMT 06T304E-FM:T9425	●	0.4	■ 365	0.15	1.2	■ 215	0.15	1.2	◪ 345	0.15	1.2	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T9425	●	0.8	■ 395	0.20	1.2	■ 235	0.18	1.2	◪ 375	0.20	1.2	–	–	–	–	–	–	–	–	–
WCMT 080404E-FM:T9425	●	0.4	■ 355	0.15	1.7	■ 210	0.15	1.7	◪ 335	0.15	1.7	–	–	–	–	–	–	–	–	–
WCMT 080408E-FM:T9425	●	0.8	■ 385	0.20	1.7	■ 230	0.18	1.7	◪ 365	0.20	1.7	–	–	–	–	–	–	–	–	–
WCMT 080412E-FM:T9425	⬌	1.2	■ 365	0.27	1.7	■ 215	0.24	1.7	◪ 345	0.27	1.7	–	–	–	–	–	–	–	–	–

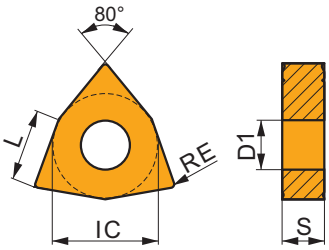
FM 断屑槽用途广泛，是钢件精加工的首选。具有正前角和窄的T-型倒棱。也适用于不锈钢，并有条件地适用于铸铁和有色金属合金。

 																				
WCMT 06T308E-UR:T9425	●	0.8	■ 345	0.20	1.2	◪ 205	0.18	1.2	■ 325	0.20	1.2	–	–	–	–	–	–	–	–	–

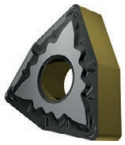
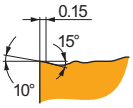
UR 断屑槽用途广泛，是铸铁精加工的首选。具有正前角，无T-型倒棱。也适用于钢，并有条件地适用于不锈钢。

WNMG

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



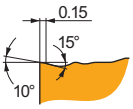
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
WNMG 060404E-FM:T9425	●	0.4	■ 365	0.20	1.4	◪ 215	0.18	1.4	■ 345	0.20	1.4	–	–	–	◪ 80	0.16	1.1	–	–	–
WNMG 060408E-FM:T9425	●	0.8	■ 430	0.20	1.4	◪ 255	0.18	1.4	■ 405	0.20	1.4	–	–	–	◪ 95	0.16	1.1	–	–	–
WNMG 06T304E-FM:T9425	●	0.4	■ 365	0.20	1.4	◪ 215	0.18	1.4	■ 345	0.20	1.4	–	–	–	◪ 80	0.16	1.1	–	–	–
WNMG 06T308E-FM:T9425	●	0.8	■ 430	0.20	1.4	◪ 255	0.18	1.4	■ 405	0.20	1.4	–	–	–	◪ 95	0.16	1.1	–	–	–
WNMG 080404E-FM:T9425	●	0.4	■ 370	0.20	1.2	◪ 220	0.18	1.2	■ 350	0.20	1.2	–	–	–	◪ 80	0.16	1.0	–	–	–

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

● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

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

产品	● ⇕ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
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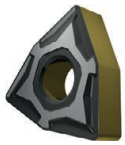
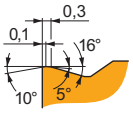
WNMG 080408E-FM:T9425	●	0.8	■ 420	0.20	1.9	◪ 250	0.18	1.9	■ 395	0.20	1.9	–	–	–	◪ 90	0.16	1.5	–	–	–
WNMG 080412E-FM:T9425	⇕	1.2	■ 400	0.27	1.9	◪ 240	0.24	1.9	■ 380	0.27	1.9	–	–	–	◪ 90	0.19	1.5	–	–	–
 																				
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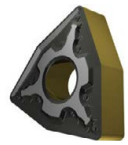
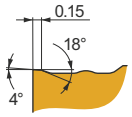
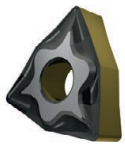
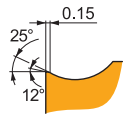
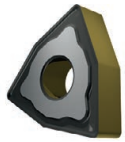
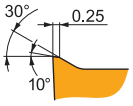
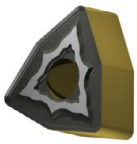
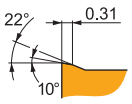
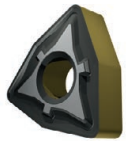
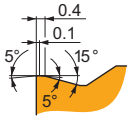
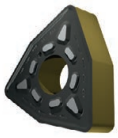
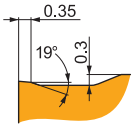
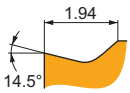
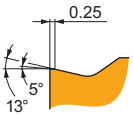
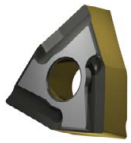
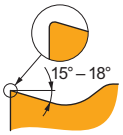
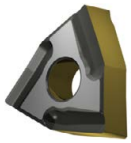
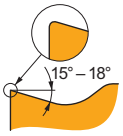
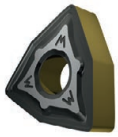
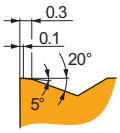
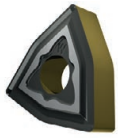
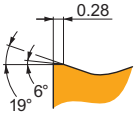
WNMG 060404E-M:T9425	●	0.4	■ 320	0.20	1.8	–	–	–	■ 300	0.20	1.8	–	–	–	–	–	–	–	–	–
WNMG 060408E-M:T9425	⇕	0.8	■ 330	0.32	1.8	–	–	–	■ 310	0.32	1.8	–	–	–	–	–	–	–	–	–
WNMG 080404E-M:T9425	●	0.4	■ 320	0.20	2.1	–	–	–	■ 300	0.20	2.1	–	–	–	–	–	–	–	–	–
WNMG 080408E-M:T9425	⇕	0.8	■ 325	0.32	2.1	–	–	–	■ 305	0.32	2.1	–	–	–	–	–	–	–	–	–
WNMG 080412E-M:T9425	⇕	1.2	■ 320	0.40	2.1	–	–	–	■ 300	0.40	2.1	–	–	–	–	–	–	–	–	–
 																				
ML 型断屑槽用途广泛，专为低切削深度和钢材的中型加工而设计。它具有正前角和稳定的窄 T 型面。同样适用于铸铁加工。																				
WNMG 080404-ML:T9415	●	0.4	■ 365	0.20	1.0	–	–	–	◪ 345	0.20	1.0	–	–	–	–	–	–	–	–	–
WNMG 080404-ML:T9425	●	0.4	■ 340	0.20	1.0	–	–	–	■ 320	0.20	1.0	–	–	–	–	–	–	–	–	–
WNMG 080408-ML:T9415	⇕	0.8	■ 380	0.25	1.5	–	–	–	◪ 360	0.25	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408-ML:T9425	⇕	0.8	■ 365	0.25	1.5	–	–	–	■ 345	0.25	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412-ML:T9415	⇕	1.2	■ 360	0.30	2.0	–	–	–	◪ 340	0.30	2.0	–	–	–	–	–	–	–	–	–
WNMG 080412-ML:T9425	⇕	1.2	■ 355	0.30	2.0	–	–	–	■ 335	0.30	2.0	–	–	–	–	–	–	–	–	–
 																				
NF 型断屑槽非常锋利，是钢和不锈钢精加工的首选。它具有大正前角和窄 的T倒棱的特点。它也有条件地适用于铸铁、有色金属合金和超级合金。																				
WNMG 060404E-NF:T9425	●	0.4	■ 400	0.18	0.8	■ 240	0.16	0.8	◪ 380	0.18	0.8	–	–	–	◪ 90	0.16	0.6	–	–	–
WNMG 060408E-NF:T9425	⇕	0.8	■ 455	0.19	1.0	■ 270	0.17	1.0	◪ 430	0.19	1.0	–	–	–	◪ 100	0.15	0.8	–	–	–
WNMG 080404E-NF:T9425	●	0.4	■ 370	0.18	1.7	■ 220	0.16	1.7	◪ 350	0.18	1.7	–	–	–	◪ 80	0.16	1.4	–	–	–
WNMG 080408E-NF:T9425	⇕	0.8	■ 430	0.19	1.7	■ 255	0.17	1.7	◪ 405	0.19	1.7	–	–	–	◪ 95	0.15	1.4	–	–	–
 																				
NM 断屑槽型锋利，专为钢、不锈钢和耐热合金的中等加工而设计。具有大正前角和中等的T-型倒棱。也有条件地适用于有色金属合金。																				
WNMG 060408E-NM:T9425	⇕	0.8	■ 415	0.25	1.8	■ 245	0.23	1.8	–	–	–	–	–	–	◪ 90	0.20	1.4	–	–	–
WNMG 060412E-NM:T9425	⇕	1.2	■ 405	0.30	1.8	■ 240	0.27	1.8	–	–	–	–	–	–	◪ 90	0.24	1.4	–	–	–
WNMG 080404E-NM:T9425	●	0.4	■ 365	0.20	2.1	■ 215	0.18	2.1	–	–	–	–	–	–	◪ 80	0.16	1.7	–	–	–
WNMG 080408E-NM:T9425	⇕	0.8	■ 400	0.25	2.1	■ 240	0.23	2.1	–	–	–	–	–	–	◪ 90	0.20	1.7	–	–	–
WNMG 080412E-NM:T9425	⇕	1.2	■ 400	0.30	2.1	■ 240	0.27	2.1	–	–	–	–	–	–	◪ 90	0.24	1.7	–	–	–
 																				
NMR 断屑槽用途广泛，是不锈钢中型加工的首选。它具有正前角和正宽 T 倒棱。它还适用于钢和超级合金。																				
WNMG 060408E-NMR:T9425	⇕	0.8	■ 325	0.35	1.6	■ 195	0.32	1.6	–	–	–	–	–	–	◪ 70	0.25	1.3	–	–	–
WNMG 080408E-NMR:T9425	⇕	0.8	■ 305	0.35	2.7	■ 180	0.32	2.7	–	–	–	–	–	–	◪ 65	0.25	2.2	–	–	–
WNMG 080412E-NMR:T9425	⇕	1.2	■ 310	0.40	2.7	■ 185	0.36	2.7	–	–	–	–	–	–	◪ 65	0.28	2.2	–	–	–
 																				
R 型断屑槽坚固耐用，专为钢和铸铁的粗加工而设计。适用于中粗加工至粗加工，连续至断续切削。它也有条件地适用于硬质材料。																				
WNMG 080408E-R:T9425	⇕	0.8	■ 285	0.40	3.5	–	–	–	■ 270	0.40	3.5	–	–	–	–	–	–	–	–	–
WNMG 080412E-R:T9425	⇕	1.2	■ 295	0.45	3.5	–	–	–	■ 280	0.45	3.5	–	–	–	–	–	–	–	–	–

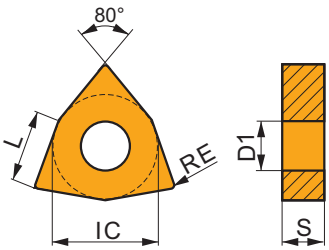
● 适用于稳定工况　⇕ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

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

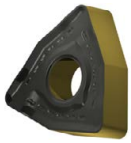
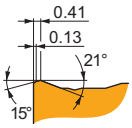
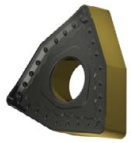
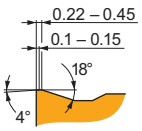
产品	● ⇔ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
RM 断屑槽坚固耐用，是钢件粗加工的首选。具有正前角和宽的稳定T-型倒棱。还适用于不锈钢、铸铁，有条件的用于耐热合金。																				
WNMG 060412E-RM:T9425	⇔	1.2	■ 370	0.45	1.2	■ 220	0.41	1.2	■ 350	0.45	1.2	–	–	–	◪ 80	0.32	1.0	–	–	–
WNMG 080408E-RM:T9425	⇔	0.8	■ 325	0.40	4.0	■ 195	0.36	4.0	■ 305	0.40	4.0	–	–	–	◪ 70	0.28	3.2	–	–	–
WNMG 080412E-RM:T9425	⇔	1.2	■ 330	0.45	4.0	■ 195	0.41	4.0	■ 310	0.45	4.0	–	–	–	◪ 70	0.32	3.2	–	–	–
WNMG 080416E-RM:T9425	⇔	1.6	■ 335	0.50	4.0	■ 200	0.45	4.0	■ 315	0.50	4.0	–	–	–	◪ 75	0.35	3.2	–	–	–
																				
SF 断屑槽非常锋利，是不锈钢和耐热合金精加工的首选。特点是小正前角，无T-型倒棱。还适用于钢、铸铁和硬质材料，有条件时也适用于有色金属合金。																				
WNMG 080408E-SF:T9425	⇔	0.8	■ 425	0.20	1.0	■ 255	0.18	1.0	■ 400	0.20	1.0	–	–	–	◪ 95	0.16	0.8	–	–	–
																				
SM 断屑槽用途广泛，是钢和耐热合金中等加工的首选。特点是小正前角和稳定、中等的T-型倒棱。还适用于不锈钢、铸铁以及有色金属合金，有条件加工硬质材料。																				
WNMG 060404E-SM:T9425	●	0.4	■ 340	0.20	1.7	■ 200	0.18	1.7	■ 320	0.20	1.7	–	–	–	◪ 75	0.18	1.4	–	–	–
WNMG 060408E-SM:T9425	⇔	0.8	■ 375	0.25	1.7	■ 225	0.23	1.7	■ 355	0.25	1.7	–	–	–	◪ 80	0.20	1.4	–	–	–
WNMG 060412E-SM:T9425	⇔	1.2	■ 375	0.30	1.7	■ 225	0.27	1.7	■ 355	0.30	1.7	–	–	–	◪ 80	0.24	1.4	–	–	–
WNMG 080404E-SM:T9425	●	0.4	■ 335	0.20	2.0	■ 200	0.18	2.0	■ 315	0.20	2.0	–	–	–	◪ 75	0.18	1.6	–	–	–
WNMG 080408E-SM:T9425	⇔	0.8	■ 370	0.25	2.0	■ 220	0.23	2.0	■ 350	0.25	2.0	–	–	–	◪ 80	0.20	1.6	–	–	–
WNMG 080412E-SM:T9425	⇔	1.2	■ 370	0.30	2.0	■ 220	0.27	2.0	■ 350	0.30	2.0	–	–	–	◪ 80	0.24	1.6	–	–	–
 																				
SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。																				
WNMG 060404ER-SI:T9425	●	0.4	■ 410	0.20	1.7	■ 245	0.18	1.7	–	–	–	–	–	–	◪ 90	0.18	1.4	–	–	–
WNMG 080404ER-SI:T9425	●	0.4	■ 410	0.20	1.7	■ 245	0.18	1.7	–	–	–	–	–	–	◪ 90	0.18	1.4	–	–	–
WNMG 080408ER-SI:T9425	●	0.8	■ 400	0.35	1.7	■ 240	0.32	1.7	–	–	–	–	–	–	◪ 90	0.25	1.4	–	–	–
 																				
SI 断屑槽型锋利，专为钢和不锈钢的中等加工而设计。具有正前角，无T-型倒棱。也有条件地适用于有色金属合金和耐热合金。																				
WNMG 060404EL-SI:T9425	●	0.4	■ 410	0.20	1.7	■ 245	0.18	1.7	–	–	–	–	–	–	◪ 90	0.18	1.4	–	–	–
WNMG 080404EL-SI:T9425	●	0.4	■ 410	0.20	1.7	■ 245	0.18	1.7	–	–	–	–	–	–	◪ 90	0.18	1.4	–	–	–
WNMG 080408EL-SI:T9425	●	0.8	■ 400	0.35	1.7	■ 240	0.32	1.7	–	–	–	–	–	–	◪ 90	0.25	1.4	–	–	–
 																				
W-M 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和适中的 T 倒棱。它也有条件地适用于铸铁。																				
WNMG 060408W-M:T9425	⇔	0.8	■ 305	0.45	1.2	–	–	–	◪ 285	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 080408W-M:T9425	⇔	0.8	■ 300	0.45	1.5	–	–	–	◪ 285	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-M:T9425	⇔	1.2	■ 300	0.55	1.5	–	–	–	◪ 285	0.55	1.5	–	–	–	–	–	–	–	–	–
 																				
W-MR 型断屑槽具有修光刃，专为钢材精加工而设计。它具有正前角和稳定、宽阔的 T 倒棱。它也有条件地适用于不锈钢和铸铁。																				
WNMG 080408W-MR:T9425	⇔	0.8	■ 300	0.45	1.5	◪ 180	0.41	1.5	◪ 285	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-MR:T9425	⇔	1.2	■ 300	0.55	1.5	◪ 180	0.50	1.5	◪ 285	0.55	1.5	–	–	–	–	–	–	–	–	–

WNMM

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



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

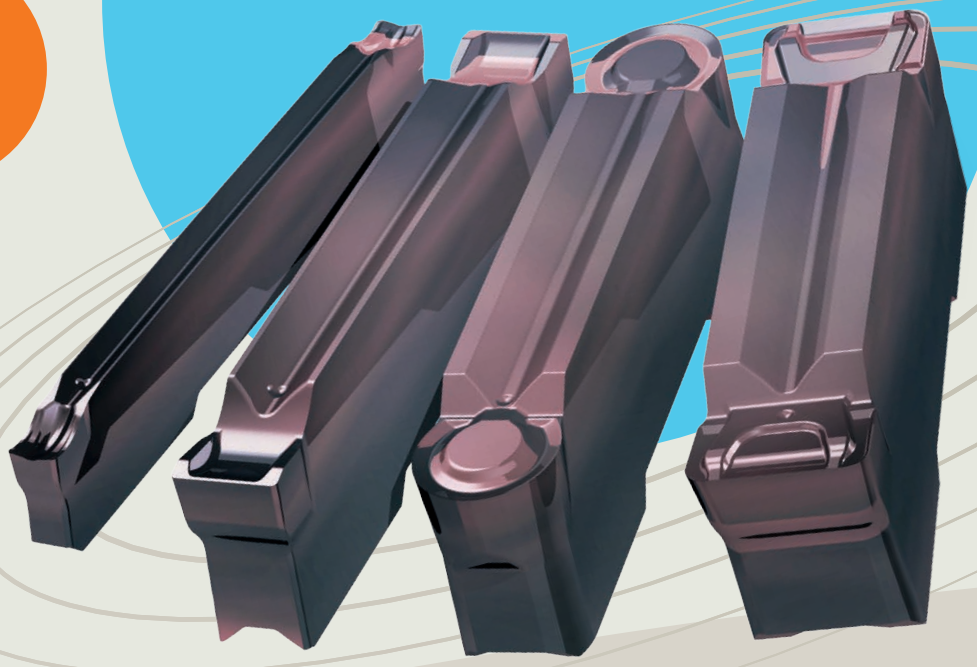
产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
NR2 型断屑槽坚固耐用，是不锈钢重型粗加工的首选。适用于粗加工至重载粗加工，连续切削至间断切削。它还适用于钢材，并有条件地适用于铸铁和超级合金。																				
WNMM 080412E-NR2:T9425	⬌	1.2	■	315	0.45	4.0	■	185	0.41	4.0	◪	295	0.45	4.0	–	–	–	◪	70	0.32	3.2	–	–	–
 																				
OR 型断屑槽坚固耐用，是重型钢材粗加工的首选。适用于中粗加工至粗加工，连续至断续切削。它还适用于铸铁，并有条件地适用于不锈钢和超级合金。																				
WNMM 080408E-OR:T9425	⬌	0.8	■	310	0.40	4.0	◪	185	0.36	4.0	■	290	0.40	4.0	–	–	–	◪	65	0.28	3.2	–	–	–
WNMM 080412E-OR:T9425	✱	1.2	■	315	0.45	4.0	◪	185	0.41	4.0	■	295	0.45	4.0	–	–	–	◪	70	0.36	3.2	–	–	–
WNMM 080416E-OR:T9425	✱	1.6	■	320	0.50	4.0	◪	190	0.45	4.0	■	300	0.50	4.0	–	–	–	◪	70	0.40	3.2	–	–	–
WNMM 130612E-OR:T9425	✱	1.2	■	300	0.45	6.0	◪	180	0.41	6.0	■	285	0.45	6.0	–	–	–	◪	65	0.36	4.8	–	–	–
WNMM 130616E-OR:T9425	✱	1.6	■	310	0.50	6.0	◪	185	0.45	6.0	■	290	0.50	6.0	–	–	–	◪	65	0.40	4.8	–	–	–

● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

DORMER PRAMET™

G8415 牌号

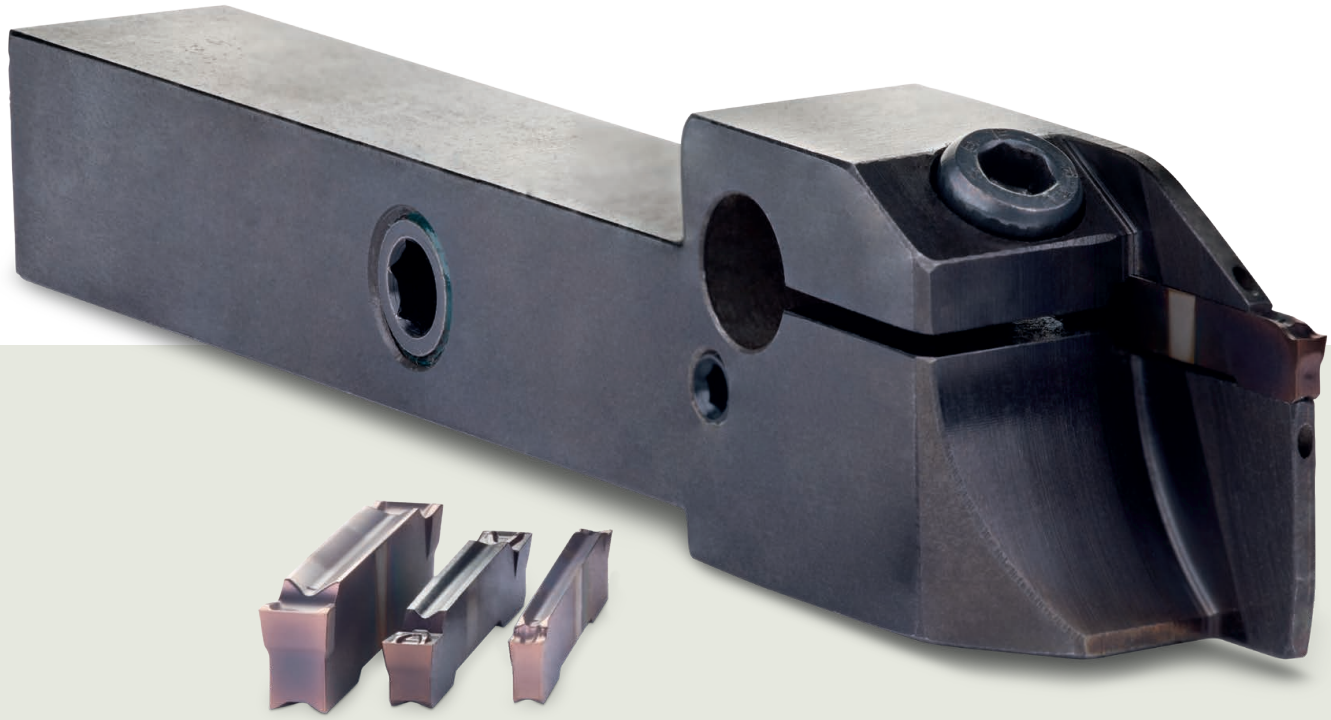
性能可靠，提高加工效率



Certainty
at every turn™

用于切断和切槽应用的新型独特 PVD 牌号

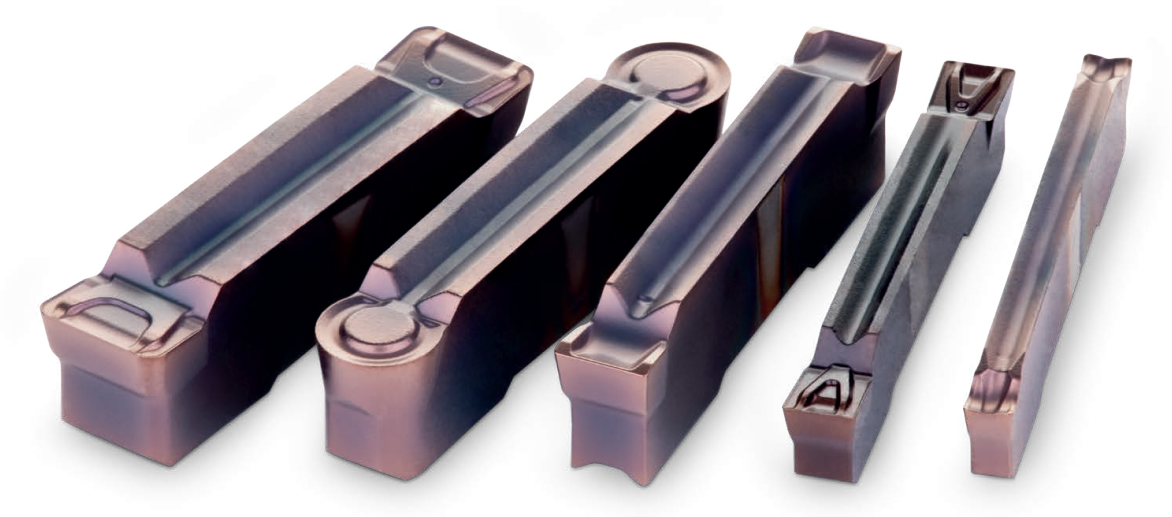
性能可靠，提高加工效率



新的 G8415 牌号可在钢材、不锈钢、铸铁、耐热和淬硬材料中提供稳定可靠的性能。它具有独特的 TiBN 滑动表层和耐用的多层 PVD 涂层，即使在苛刻的条件下也能提供出色的耐磨性和稳定性。

G8415 可与所有 GL 断屑槽配合使用，是切断、切槽和仿形应用中实用而高效的选择。

相关产品



GL. D-PR

用于切断和切槽的双头刀片

GL. D-PM

双刃刀片，用于深度切断

GL. D-MM

用于切槽和仿形的双头刀片

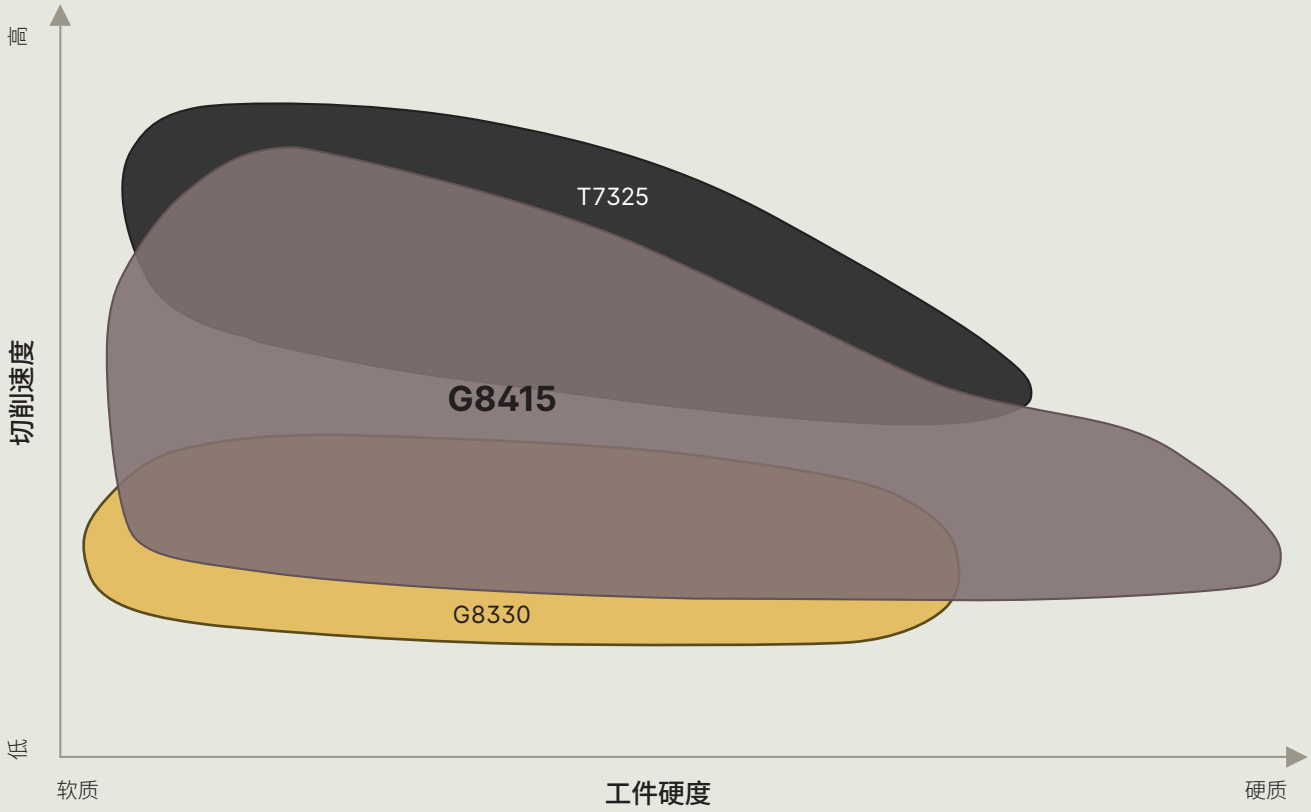
GL. D-GM

用于切槽和纵向车削的双头刀片

功能和优点

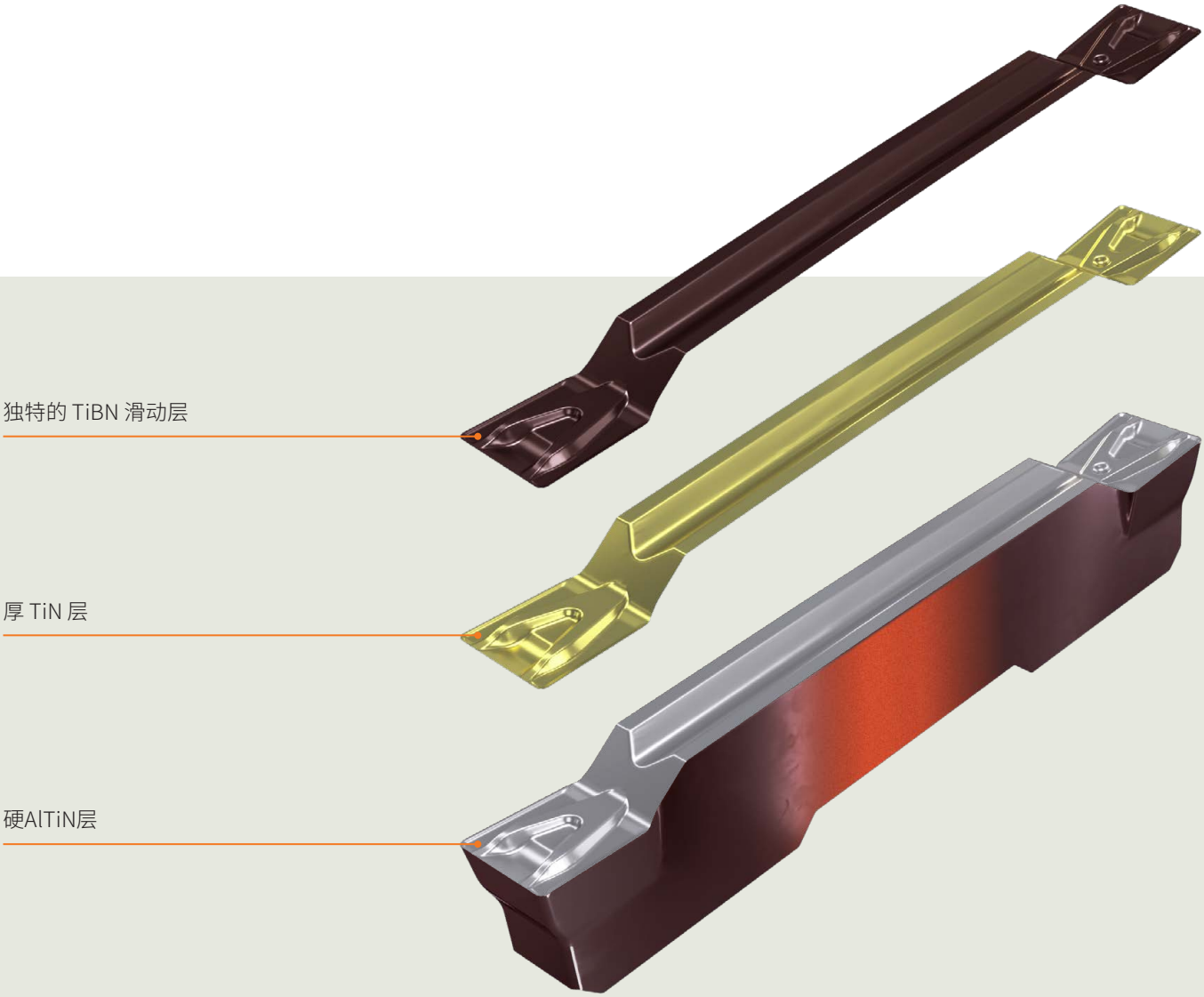
新一代多层 PVD 涂层与高端亚微米级碳化物相结合。	→	**用途广泛** 适用于各种工件。
TiBN 滑动表层可减少积聚边缘的形成。	→	**增强切削性能** 确保切屑流动顺畅，提高加工表面质量。
具有低压缩残余应力的厚 TiN 层和具有新开发成分的硬 AlTiN 层。	→	**延长刀具使用寿命** 即使在恶劣的切削条件下也是如此。
可用的断屑槽（PM、PR、GM、MM）可优化各种应用的性能。	→	**针对特定应用的多功能性** 确保了切断、切槽和仿形任务的可靠性能、开槽和仿形任务。

G8415 车削牌号的应用领域



牌号构成

精密设计的涂层可实现最长的刀具寿命和性能



成功案例

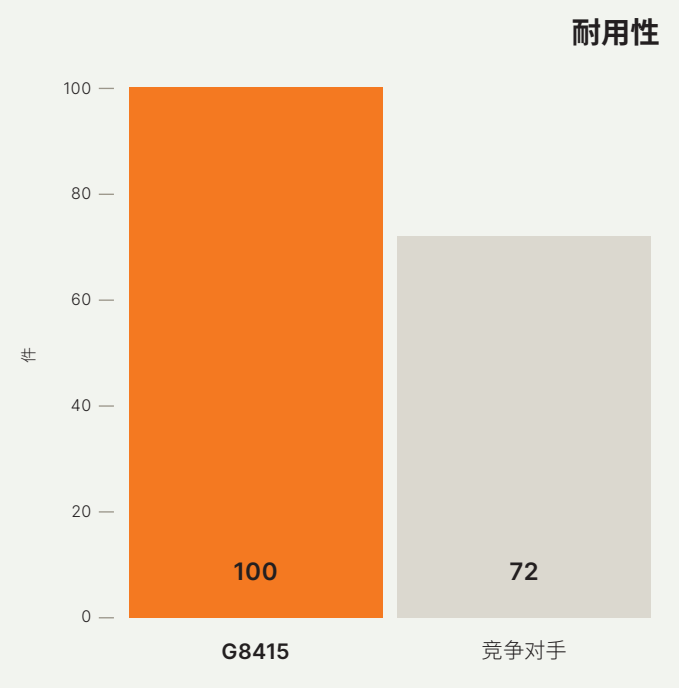
出色的耐用性可将工具寿命延长 39%

客户成果：G8415 牌号的性能明显优于竞争对手的解决方案，在螺纹销加工操作中将刀具寿命延长了 39%。这一改进减少了刀具更换和停机时间，从而提高了生产率，降低了钢材分切应用中的单件成本。

行业	通用加工
应用	切断
零件	螺纹销
材料	SAE 1045
冷却液	是
Dormer Pramet 解决方案	GL3-D300M02-PM:G8415

加工数据			
n	f_n	CD	CW
1350	0.035	8.0	3.0

P2.2



n = 主轴转速（转/分），f_n = 每转进给量（毫米/转），CD = 切削深度（毫米），CW = 切削宽度（毫米）

成功案例

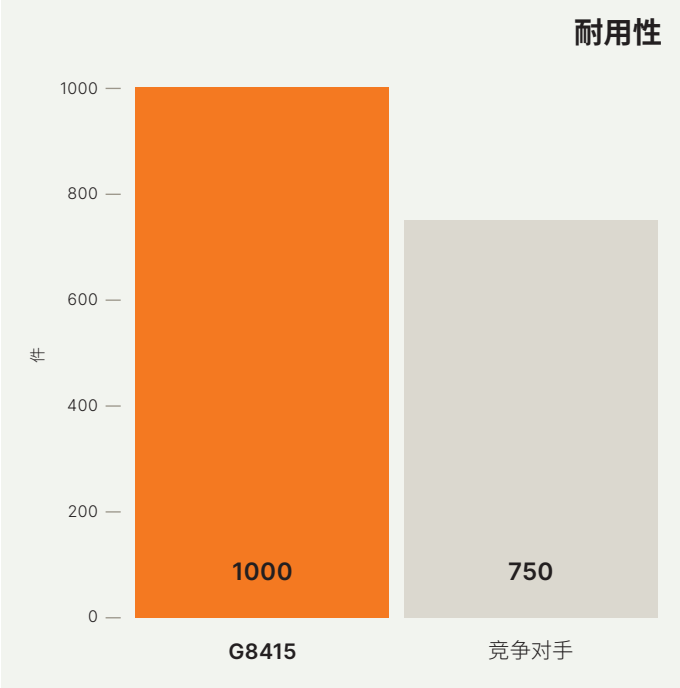
将工具寿命延长 33%，同时确保结果的一致性

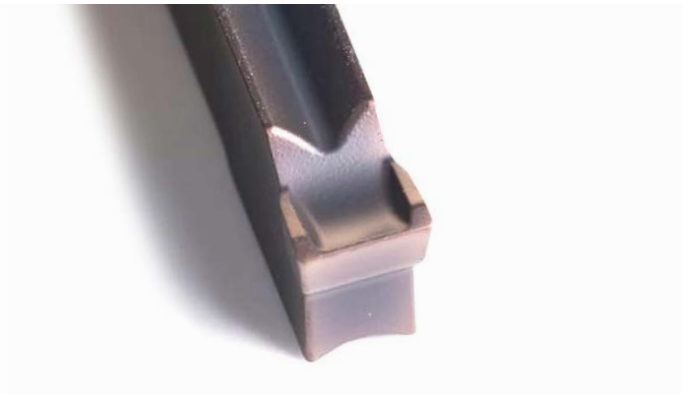
客户成果：与竞争对手的解决方案相比，G8415 具有出色的性能。它的刀具寿命延长了 33%，每个切削刃在更换前可进行 1000 次切削，而竞争对手的产品只能进行 750 次切削。这一改进使客户更换切削刃的频率大大降低，从而减少了停机时间。

行业	汽车
应用	切断
零件	环
材料	18NiCrMo5
冷却液	是
Dormer Pramet 解决方案	GL3-D300M02-PR:G8415

加工数据			
n	f_n	CD	CW
656	0.2	15.0	3.0

P3.2

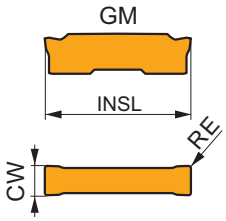




n = 主轴转速（转/分），f_n = 每转进给量（毫米/转），CD = 切削深度（毫米），CW = 切削宽度（毫米）

GL. D - GM

	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



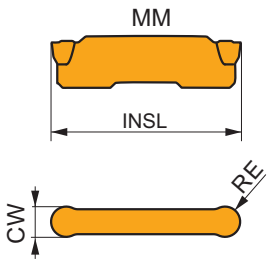
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

GM 用途断屑槽，适用于切槽和轴向车削，以及连续至断续切削。

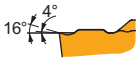
产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
GL2-D200M02-GM:G8415	●	0.2	155	0.15	0.8	80	0.14	0.8	140	0.15	0.8	–	–	–	35	0.11	0.6	–	–	–
GL3-D300M02-GM:G8415	●	0.2	155	0.20	1.0	80	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M04-GM:G8415	●	0.4	155	0.20	1.0	80	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL4-D400M04-GM:G8415	●	0.4	155	0.25	1.2	80	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL5-D500M08-GM:G8415	●	0.8	155	0.30	1.2	80	0.27	1.2	140	0.30	1.2	–	–	–	35	0.21	1.0	–	–	–
GL6-D600M08-GM:G8415	●	0.8	155	0.30	1.2	80	0.27	1.2	140	0.30	1.2	–	–	–	35	0.21	1.0	–	–	–

GL. D - MM

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



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



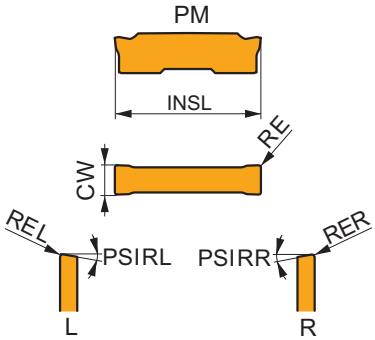
MM 屑槽，球头外形，适用于仿形加工和轴向车削，连续至断续切削。

产品	● ⬌ ✱	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
GL2-D200MM0-MM:G8415	⬌	1.0	155	0.10	1.0	80	0.09	1.0	140	0.10	1.0	–	–	–	35	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8415	⬌	1.5	155	0.20	1.2	80	0.18	1.2	140	0.20	1.2	–	–	–	35	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8415	⬌	2.0	155	0.20	1.2	80	0.18	1.2	140	0.20	1.2	–	–	–	35	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8415	⬌	2.5	155	0.25	1.2	80	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8415	⬌	3.0	155	0.30	1.2	80	0.27	1.2	140	0.30	1.2	–	–	–	35	0.21	1.0	–	–	–

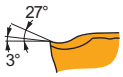
● 适用于稳定工况　⬌ 适用于不稳定工况　✱ 适用于重型加工工况　■ 推荐使用　◪ 可以使用

GL. D - PM

	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



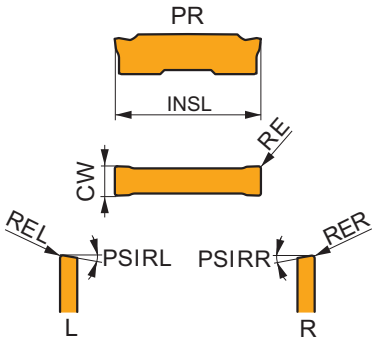
线速度(vc)和进给量(f)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

产品	● ⬌ ✱	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 (°)
																
GL2-D200M02-PM:G8415	●	0.2	■ 155	0.08	■ 80	0.07	◪ 140	0.08	◪ 390	0.10	◪ 35	0.06	–	–	–	–
GL3-D300M02-PM:G8415	●	0.2	■ 155	0.10	■ 80	0.09	◪ 140	0.10	◪ 390	0.12	◪ 35	0.07	–	–	–	–
GL4-D400M02-PM:G8415	●	0.2	■ 155	0.12	■ 80	0.11	◪ 140	0.12	◪ 390	0.14	◪ 35	0.10	–	–	–	–

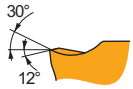
PM 具有大正前角的型，是切断和切槽加工以及连续切削至轻微断续切削的首选。

GL. D - PR

	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



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	● ⬌ ✱	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 (°)
																
GL2-D200M02-PR:G8415	●	0.2	■ 155	0.10	◪ 80	0.09	■ 140	0.10	–	–	–	–	◪ 25	0.07	–	–
GL3-D300M02-PR:G8415	●	0.2	■ 155	0.12	◪ 80	0.11	■ 140	0.12	–	–	–	–	◪ 25	0.08	–	–
GL4-D400M02-PR:G8415	●	0.2	■ 155	0.15	◪ 80	0.14	■ 140	0.15	–	–	–	–	◪ 25	0.11	–	–

PR 带负T-型倒棱的型，是不利工况下切槽加工和切断加工以及连续切削至间断切削的首选。

扩大整体硬质合金立铣刀范围

钢、不锈钢和铸铁加工的精度和耐用性

扩展后的 S9xx 整体硬质合金立铣刀系列推出了两种新的立铣刀类型，分别为直角和圆角，公制和英制多种长度索引。该产品专为钢材、不锈钢、铸铁和可选有色金属材料而设计，可在侧铣、开槽、轮廓加工和斜面加工等各种应用中确保精度和耐用性。

S9xx 系列共有 204 种新产品，为汽车分包商和一般工程设计提供了多功能、可靠的性能和卓越的价值。

相关产品

中等长度的 2 刃直角

1/16 – 1 inch

中等长度的 4 刃直角

2 – 20 mm

1/16 – 1 inch

中等长度的 6 刃直角

6 – 20 mm

1/4 – 1 inch

4 刃倒角

1/16 – 1 inch

2 刃圆角

3 – 18 mm

4 刃圆角

3 – 18 mm

1/8 – 1 inch

加长2刃直角

2 – 20 mm

加长4刃直角

2 – 20 mm

1/16 – 1 inch

加长6刃直角

6 – 20 mm

1/4 – 1 inch

功能和优点

TiAlN 涂层具有出色的耐磨性，可延长刀具寿命。

延长刀具使用寿命
大大提高了生产率，降低了每个部件的成本。

多种几何形状的刀具，包括直角、圆角和倒角选项，以及公制和英制尺寸的 2、4 和 6 刃刀具的各种设计。

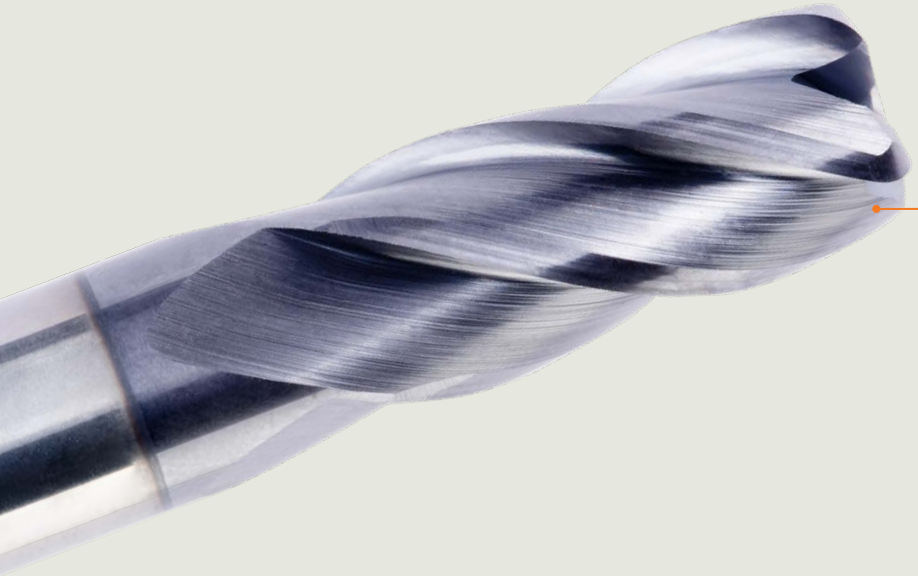
操作多功能性
可进行侧铣、开槽、轮廓加工和斜面加工等多种应用。

可加工多种材料：
适用于钢、不锈钢、铸铁和可选的有色金属材料（不锈钢，扩大了可用性）。

多功能性
适用于侧铣、开槽、轮廓加工、斜面加工以及各种加工操作。

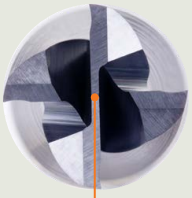
优化的刃口几何形状和坚固的设计，以及端齿上的直角、倒角和圆角设计，可减少崩刃。

提高工艺可靠性
减少停机时间，确保始终如一的高质量结果。

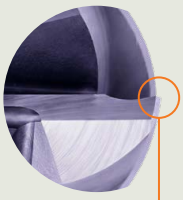


4齿

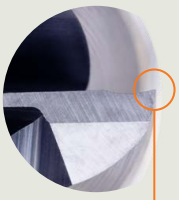
技术信息



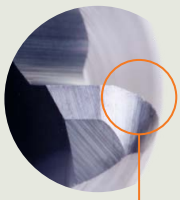
中心切削



CHW 倒角



直角



RE 圆角

RE

2齿

CHW RE

4齿

6齿

成功案例

将开槽加工时间缩短 80%

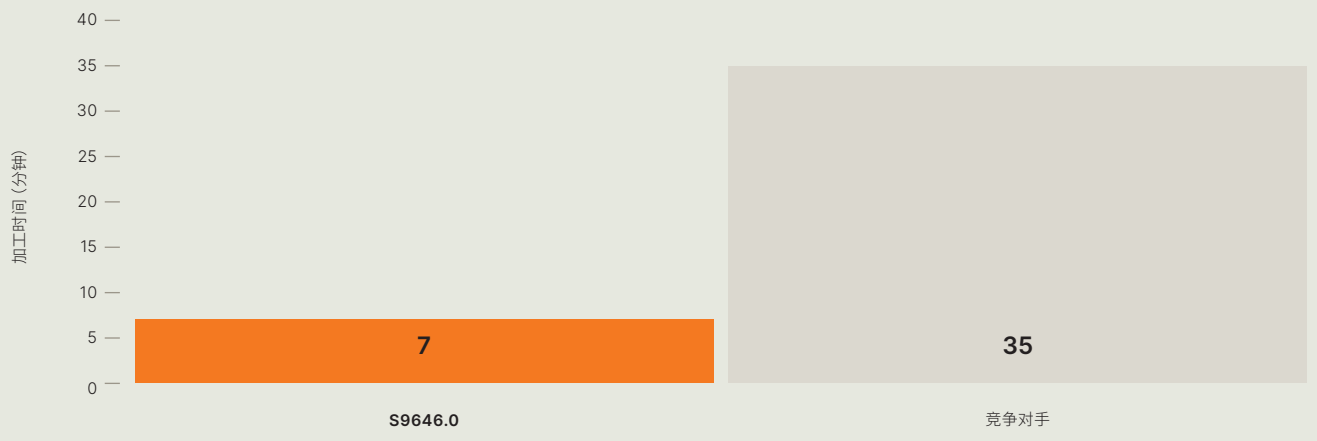
S964 整体硬质合金立铣刀在 304 不锈钢的开槽加工中表现出色。每次加工时间从 35 分钟缩短到仅 7 分钟，与竞争对手相比，生产率提高了 400%。

行业	应用	材料	冷却液	Dormer Pramet 解决方案
医疗	开槽	304 不锈钢	是	S9646.0

加工数据	竞争对手	S9646.0
切削深度 a_p (毫米)	0.5	2.0
切削宽度 a_e (毫米)	6.0	6.0
切削速度 v_c (米/分)	55	70
每齿进给量 f_z (毫米/分)	0.022	0.01
进给速度 v_f (毫米/分)	257	210

M3.1

生产率(分钟)



加工案例

在要求苛刻的铣削应用中，可将刀具寿命延长 16.7%

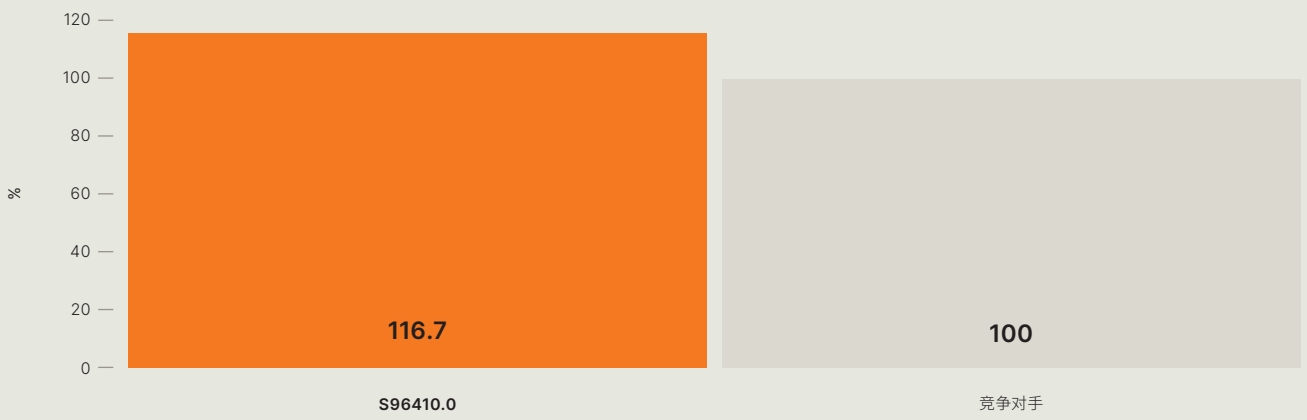
S96410.0 的线米数为 14，而竞争对手的线米数为 12，刀具寿命延长了 16.7%。在使用冷却液对 SAE 1045 材料进行斜切和开槽加工时，该立铣表现出了卓越的耐用性，与竞争对手的解决方案相比，耐用性更强，成本更低。

行业	应用	材料	冷却液	Dormer Pramet 解决方案
通用加工	斜坡和开槽	SAE 1045	是	S96410.0

加工数据	竞争对手	S96410.0
切削深度 a_p (毫米)	10.0	10.0
切削宽度 a_e (毫米)	10.0	10.0
切削速度 v_c (米/分)	120	120
每齿进给量 f_z (毫米/分)	0.048	0.048
进给速度 v_f (毫米/分)	733	733

P2.2

刀具寿命 (%)



加工案例

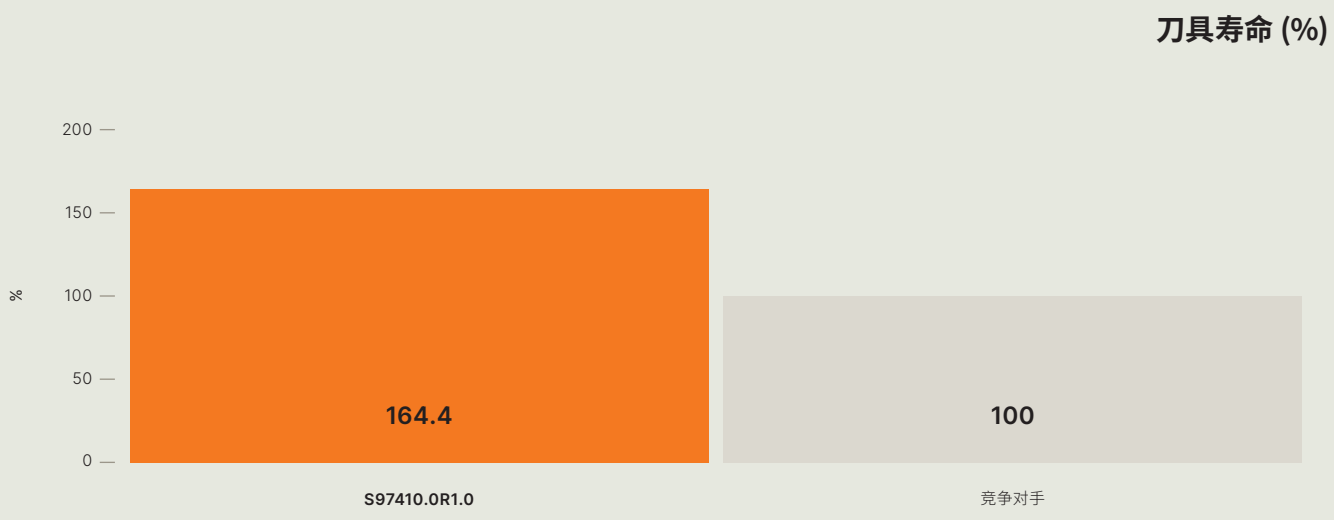
不锈钢刀具寿命延长 64.4%

与竞争对手相比，S97410.0R1.0 在不锈钢侧铣加工中的刀具寿命延长了 64.4%。我们的立铣刀可加工 14.8 米长的直线距离，而竞争对手的立铣刀只能加工 9 米长的直线距离。

行业	应用	材料	冷却液	Dormer Pramet 解决方案
通用加工	侧铣	316L 不锈钢	是	S97410.0R1.0

加工数据	竞争对手	S97410.0R1.0
切削深度 a_p (毫米)	5.0	5.0
切削宽度 a_e (毫米)	10.0	10.0
切削速度 v_c (米/分)	35	35
每齿进给量 f_z (毫米/分)	0.042	0.042
进给速度 v_f (毫米/分)	187	187

M3.1



材料代码(BMC)		HM	HM	HM	HM	HM	HM	HM	HM	HM
铣刀齿形		N	N	N	N	N	N	N	N	N
容屑槽数(NOF)		NOF 4	NOF 2	NOF 4	NOF 2	NOF 4	NOF 6	NOF 2	NOF 4	NOF 6
切削长度										
容屑槽螺旋角(FHA)		λ 34°	λ 28°	λ 34°	λ 28°	λ 34°	λ 45°	λ 28°	λ 34°	λ 45°
径向前角度(GAMF)		γ 9°	γ 9°	γ 9°	γ 9°	γ 9°	γ 9°	γ 9°	γ 9°	γ 9°
柄部			DIN 6535HA	DIN 6535HA		DIN 6535HA	DIN 6535HA	DIN 6535HA	DIN 6535HA	DIN 6535HA
涂层		TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN
切削直径公差等级(TCDC)		DC h10	DC h10	DC h10	DC h10	DC h10	DC h10	DC h10	DC h10	DC h10
方向										
基本标准组(BSG)		WORK NORM	WORK NORM	WORK NORM	WORK NORM	WORK NORM	WORK NORM	WORK NORM	WORK NORM	WORK NORM
切削刃形状		CHW	RE	RE						
产品系列代码		S954	S972	S974	S962	S964	S966	S982	S984	S986
PSF切削直径范围		1/16" – 1"	3.00 – 18.00	3.00 – 18.00 1/8" – 1"	1/16" – 1"	2.00 – 20.00 1/16" – 1"	6.00 – 20.00 1/4" – 1"	2.00 – 20.00	2.00 – 20.00 1/16" – 1"	6.00 – 20.00 1/4" – 1"
		150	151	152	154	155	157	158	159	161
P	P1	■	■	■	■	■	■	■	■	■
	P2	■	■	■	■	■	■	■	■	■
	P3	■	■	■	■	■	■	■	■	■
	P4	■	■	■	■	■	■	■	■	■
M	M1	■	■	■	■	■	■	■	■	■
	M2	■	■	■	■	■	■	■	■	■
	M3	■	■	■	■	■	■	■	■	■
	M4									
K	K1	■	■	■	■	■	■	■	■	■
	K2	■	■	■	■	■	■	■	■	■
	K3	■	■	■	■	■	■	■	■	■
	K4	■	■	■	■	■	■	■	■	■
	K5	■	■	■	■	■	■	■	■	■
N	N1	◪	◪	◪	◪	◪	◪	◪	◪	◪
	N2	■	■	■	■	■	■	■	■	■
	N3	◪	◪	◪	◪	◪	◪	◪	◪	◪
	N4	◪	◪	◪	◪	◪	◪	◪	◪	◪
	N5									
S	S1									
	S2									
	S3									
	S4									
H	H1									
	H2									
	H3									
	H4									

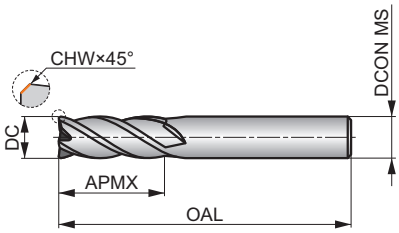
■推荐使用　◪可以使用

S954

DORMER PRAMET

4 刃整体硬质合金倒角立铣刀

中等切削长度，4刃设计，34°螺旋角，具有高刚性，适用于一般成型和切入铣削应用。TiALN 涂层具有更高的耐温性，刀具寿命更长。



HM	N	NOF 4
	λ 34°	γ 9°
	TiAlN	DC h10
	WORK NORM	

工件材料组的适用性，线速度(m/min)的起始值和Alpha代码。从162页开始，可以找到每齿进给量和校正系数的表格。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 158 I	■ 177 I	■ 183 I	■ 135 I	■ 120 I	■ 105 G	■ 117 I	■ 95 G	■ 80 G	■ 70 G	■ 60 G	■ 49 G	■ 35 I	■ 29 I
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■ 30 I	■ 26 I	■ 28 I	■ 24 I	■ 120 J	■ 88 J	■ 67 J	■ 128 J	■ 104 J	■ 84 I	■ 114 J	■ 86 J	■ 70 I	■ 105 I
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■ 80 I	■ 58 I	■ 50 I	■ 42 I	■ 120 I	■ 90 I	■ 69 I	◪ 296 J	◪ 222 J	■ 149 J	■ 149 J	■ 133 J	■ 96 J	■ 156 J
N3.2	N3.3	N4.1	N4.2	N4.3									
◪ 91 J	◪ 47 J	◪ 156 J	◪ 60 J	◪ 64 J									

DCON MS公差h6

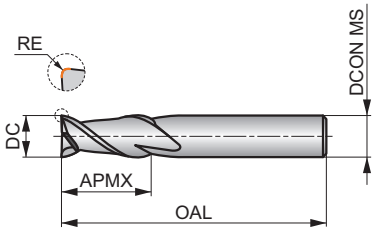
产品	DC (inch)	DC (mm)	DC (inch)	CHW (inch)	DCON MS (inch)	APMX (inch)	OAL (inch)	NOF
S9541/16	1/16	1.59	0.0630	0.003	0.125	0.250	1.500	4
S9543/32	3/32	2.38	0.0940	0.002	0.125	0.375	1.500	4
S9541/8	1/8	3.18	0.1250	0.004	0.125	0.500	1.500	4
S9545/32	5/32	3.97	0.1560	0.005	0.188	0.563	2.000	4
S9543/16	3/16	4.76	0.1880	0.005	0.188	0.625	2.000	4
S9547/32	7/32	5.56	0.2190	0.005	0.250	0.625	2.500	4
S9541/4	1/4	6.35	0.2500	0.005	0.250	0.750	2.500	4
S9545/16	5/16	7.94	0.3130	0.005	0.313	0.875	2.500	4
S9543/8	3/8	9.53	0.3750	0.006	0.375	0.875	2.500	4
S9547/16	7/16	11.11	0.4380	0.008	0.438	1.000	2.500	4
S9541/2	1/2	12.70	0.5000	0.008	0.500	1.000	3.000	4
S9549/16	9/16	14.29	0.5630	0.008	0.563	1.250	3.500	4
S9545/8	5/8	15.88	0.6250	0.008	0.625	1.250	3.500	4
S9543/4	3/4	19.05	0.7500	0.012	0.750	1.500	4.000	4
S9547/8	7/8	22.23	0.8750	0.008	0.875	1.500	4.000	4
S9541	1	25.40	1.0000	0.012	1.000	1.500	4.000	4

S972

DORMER PRAMET

两刃整体硬质合金圆角半径立铣刀

中等切削长度，双刃设计，可提供不同的转角半径，28° 螺旋角提高了铣削标准槽的刚性。TiALN 涂层具有更高的耐温性，可延长刀具寿命。



HM	N	NOF 2
	λ 28°	γ 9°
DIN 6535HA	TiAlN	DC h10
	WORK NORM	

工件材料组的适用性，线速度(m/min)的起始值和Alpha代码。从162页开始，可以找到每齿进给量和校正系数的表格。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 158 J	■ 177 J	■ 183 J	■ 135 J	■ 120 J	■ 105 I	■ 117 J	■ 95 I	■ 80 I	■ 70 I	■ 60 I	■ 49 I	■ 55 I	■ 45 I
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■ 47 I	■ 41 I	■ 44 I	■ 38 I	■ 120 J	■ 88 J	■ 67 J	■ 128 J	■ 104 J	■ 84 I	■ 114 J	■ 86 J	■ 70 I	■ 105 I
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■ 80 I	■ 58 I	■ 50 I	■ 42 I	■ 120 I	■ 90 I	■ 69 I	◪ 296 J	◪ 222 J	■ 149 J	■ 149 J	■ 133 J	■ 96 J	■ 156 J
N3.2	N3.3	N4.1	N4.2	N4.3									
◪ 91 J	◪ 47 J	◪ 156 J	◪ 60 J	◪ 64 J									

DCON MS公差h6

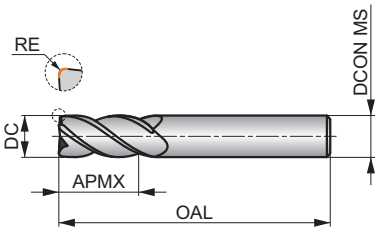
产品	DC (mm)	DC (inch)	RE (mm)	DCON MS (mm)	APMX (mm)	OAL (mm)	NOF
S9723.0XR0.3	3.00	0.1180	0.30	3.00	12.00	38.0	2
S9724.0XR0.3	4.00	0.1570	0.30	4.00	14.00	50.0	2
S9724.0XR0.5	4.00	0.1570	0.50	4.00	14.00	50.0	2
S9725.0XR0.3	5.00	0.1970	0.30	5.00	16.00	50.0	2
S9725.0XR0.5	5.00	0.1970	0.50	5.00	16.00	50.0	2
S9726.0XR0.5	6.00	0.2360	0.50	6.00	19.00	57.0	2
S9726.0XR1.0	6.00	0.2360	1.00	6.00	19.00	57.0	2
S9728.0XR0.5	8.00	0.3150	0.50	8.00	19.00	63.0	2
S9728.0XR1.0	8.00	0.3150	1.00	8.00	19.00	63.0	2
S97210.0XR0.5	10.00	0.3940	0.50	10.00	22.00	72.0	2
S97210.0XR1.0	10.00	0.3940	1.00	10.00	22.00	72.0	2
S97210.0XR2.0	10.00	0.3940	2.00	10.00	22.00	72.0	2
S97212.0XR1.0	12.00	0.4720	1.00	12.00	25.00	73.0	2
S97212.0XR2.0	12.00	0.4720	2.00	12.00	25.00	73.0	2
S97212.0XR3.0	12.00	0.4720	3.00	12.00	25.00	73.0	2
S97216.0XR1.0	16.00	0.6300	1.00	16.00	32.00	92.0	2
S97216.0XR2.0	16.00	0.6300	2.00	16.00	32.00	92.0	2
S97216.0XR3.0	16.00	0.6300	3.00	16.00	32.00	92.0	2
S97218.0XR2.0	18.00	0.7090	2.00	18.00	32.00	92.0	2

S974

DORMER PRAMET

4 刃整体硬质合金圆半径立铣刀

中等切削长度，4刃设计，有不同的圆角半径可供选择，34°螺旋角提高了表面光洁度，可用于需要圆角半径的轮廓铣削。TiALN 涂层具有更高的耐温性，可延长刀具寿命。



HM	N	NOF 4
	λ 34°	γ 9°
DIN 6535HA	TiAlN	DC h10
	WORK NORM	

工件材料组的适用性，线速度(m/min)的起始值和Alpha代码。从162页开始，可以找到每齿进给量和校正系数的表格。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 158 J	■ 177 J	■ 183 J	■ 135 J	■ 120 J	■ 105 I	■ 117 J	■ 95 I	■ 80 I	■ 70 I	■ 60 I	■ 49 I	■ 55 I	■ 45 I
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■ 47 I	■ 41 I	■ 44 I	■ 38 I	■ 120 J	■ 88 J	■ 67 J	■ 128 J	■ 104 J	■ 84 I	■ 114 J	■ 86 J	■ 70 I	■ 105 I
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■ 80 I	■ 58 I	■ 50 I	■ 42 I	■ 120 I	■ 90 I	■ 69 I	◪ 296 J	◪ 222 J	■ 149 J	■ 149 J	■ 133 J	■ 96 J	■ 156 J
N3.2	N3.3	N4.1	N4.2	N4.3									
◪ 91 J	◪ 47 J	◪ 156 J	◪ 60 J	◪ 64 J									

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	RE (mm)	RE (inch)	DCON MS (mm)	DCON MS (inch)	APMX (mm)	APMX (inch)	OAL (mm)	OAL (inch)	NOF
S9743.0XR0.3	–	3.00	0.1180	0.30	0.0120	3.00	0.118	12.00	0.472	38.0	1.496	4
S9741/8XR.015 [1]	1/8	3.18	0.1250	0.38	0.0150	3.18	0.125	12.70	0.500	38.1	1.500	4
S9741/8XR.030 [1]	1/8	3.18	0.1250	0.76	0.0300	3.18	0.125	12.70	0.500	38.1	1.500	4
S9744.0XR0.3	–	4.00	0.1570	0.30	0.0120	4.00	0.157	14.00	0.551	50.0	1.969	4
S9744.0XR0.5	–	4.00	0.1570	0.50	0.0200	4.00	0.157	14.00	0.551	50.0	1.969	4
S9743/16XR.015 [1]	3/16	4.76	0.1880	0.38	0.0150	4.76	0.188	15.88	0.625	50.8	2.000	4
S9743/16XR.030 [1]	3/16	4.76	0.1880	0.76	0.0300	4.76	0.188	15.88	0.625	50.8	2.000	4
S9745.0XR0.3	–	5.00	0.1970	0.30	0.0120	5.00	0.197	16.00	0.630	50.0	1.969	4
S9745.0XR0.5	–	5.00	0.1970	0.50	0.0200	5.00	0.197	16.00	0.630	50.0	1.969	4
S9746.0XR0.5	–	6.00	0.2360	0.50	0.0200	6.00	0.236	19.00	0.748	57.0	2.244	4
S9746.0XR1.0	–	6.00	0.2360	1.00	0.0390	6.00	0.236	19.00	0.748	57.0	2.244	4
S9741/4XR.015 [1]	1/4	6.35	0.2500	0.38	0.0150	6.35	0.250	19.05	0.750	63.5	2.500	4
S9741/4XR.030 [1]	1/4	6.35	0.2500	0.76	0.0300	6.35	0.250	19.05	0.750	63.5	2.500	4
S9745/16XR.015 [1]	5/16	7.94	0.3130	0.38	0.0150	7.94	0.313	22.23	0.875	63.5	2.500	4
S9745/16XR.030 [1]	5/16	7.94	0.3130	0.76	0.0300	7.94	0.313	22.23	0.875	63.5	2.500	4
S9748.0XR0.5	–	8.00	0.3150	0.50	0.0200	8.00	0.315	19.00	0.748	63.0	2.480	4
S9748.0XR1.0	–	8.00	0.3150	1.00	0.0390	8.00	0.315	19.00	0.748	63.0	2.480	4
S9743/8XR.015 [1]	3/8	9.53	0.3750	0.38	0.0150	9.53	0.375	22.23	0.875	63.5	2.500	4
S9743/8XR.030 [1]	3/8	9.53	0.3750	0.76	0.0300	9.53	0.375	22.23	0.875	63.5	2.500	4
S97410.0XR0.5	–	10.00	0.3940	0.50	0.0200	10.00	0.394	22.00	0.866	72.0	2.835	4
S97410.0XR1.0	–	10.00	0.3940	1.00	0.0390	10.00	0.394	22.00	0.866	72.0	2.835	4
S97410.0XR2.0	–	10.00	0.3940	2.00	0.0790	10.00	0.394	22.00	0.866	72.0	2.835	4
S9747/16XR.020 [1]	7/16	11.11	0.4380	0.51	0.0200	11.11	0.438	25.40	1.000	63.5	2.500	4
S9747/16XR.045 [1]	7/16	11.11	0.4380	1.14	0.0450	11.11	0.438	25.40	1.000	63.5	2.500	4
S97412.0XR1.0	–	12.00	0.4720	1.00	0.0390	12.00	0.472	25.00	0.984	73.0	2.874	4

产品	DC	DC	DC	RE	RE	DCON MS	DCON MS	APMX	APMX	OAL	OAL	NOF
	(inch)	(mm)	(inch)	(mm)	(inch)	(mm)	(inch)	(mm)	(inch)	(mm)	(inch)	
S97412.0XR2.0	–	12.00	0.4720	2.00	0.0790	12.00	0.472	25.00	0.984	73.0	2.874	4
S97412.0XR3.0	–	12.00	0.4720	3.00	0.1180	12.00	0.472	25.00	0.984	73.0	2.874	4
S9741/2XR.030 [1]	1/2	12.70	0.5000	0.76	0.0300	12.70	0.500	25.40	1.000	76.2	3.000	4
S9741/2XR.060 [1]	1/2	12.70	0.5000	1.52	0.0600	12.70	0.500	25.40	1.000	76.2	3.000	4
S9749/16XR.045 [1]	9/16	14.29	0.5630	1.14	0.0450	14.29	0.563	31.75	1.250	88.9	3.500	4
S9749/16XR.060 [1]	9/16	14.29	0.5630	1.52	0.0600	14.29	0.563	31.75	1.250	88.9	3.500	4
S9745/8XR.060 [1]	5/8	15.88	0.6250	1.52	0.0600	15.88	0.625	31.75	1.250	88.9	3.500	4
S9745/8XR.090 [1]	5/8	15.88	0.6250	2.29	0.0900	15.88	0.625	31.75	1.250	88.9	3.500	4
S97416.0XR1.0	–	16.00	0.6300	1.00	0.0390	16.00	0.630	32.00	1.260	92.0	3.622	4
S97416.0XR2.0	–	16.00	0.6300	2.00	0.0790	16.00	0.630	32.00	1.260	92.0	3.622	4
S97416.0XR3.0	–	16.00	0.6300	3.00	0.1180	16.00	0.630	32.00	1.260	92.0	3.622	4
S97418.0XR2.0	–	18.00	0.7090	2.00	0.0790	18.00	0.709	32.00	1.260	92.0	3.622	4
S9743/4XR.030 [1]	3/4	19.05	0.7500	0.76	0.0300	19.05	0.750	38.10	1.500	101.6	4.000	4
S9743/4XR.060 [1]	3/4	19.05	0.7500	1.52	0.0600	19.05	0.750	38.10	1.500	101.6	4.000	4
S9741XR.030 [1]	1	25.40	1.0000	0.76	0.0300	25.40	1.000	38.10	1.500	101.6	4.000	4

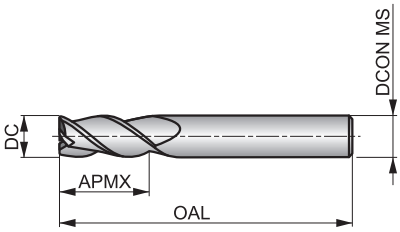
[1] 圆柱刀柄

S962

双刃整体硬质合金立铣刀

中等切削长度，双刃设计，28° 螺旋角，为铣削标准槽提供更高的刚性。TiALN 涂层具有更高的耐温性和更长的刀具寿命。

HM	N	NOF 2
	λ 28°	γ 9°
	TiAlN	DC h10
	WORK NORM	



工件材料组的适用性，线速度(m/min)的起始值和Alpha代码。从162页开始，可以找到每齿进给量和校正系数的表格。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 158 I	■ 177 I	■ 183 I	■ 135 I	■ 120 I	■ 105 G	■ 117 I	■ 95 G	■ 80 G	■ 70 G	■ 60 G	■ 49 G	■ 35 I	■ 29 I
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■ 30 I	■ 26 I	■ 28 I	■ 24 I	■ 120 J	■ 88 J	■ 67 J	■ 128 J	■ 104 J	■ 84 I	■ 114 J	■ 86 J	■ 70 I	■ 105 I
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■ 80 I	■ 58 I	■ 50 I	■ 42 I	■ 120 I	■ 90 I	■ 69 I	◪ 296 J	◪ 222 J	■ 149 J	■ 149 J	■ 133 J	■ 96 J	■ 156 J
N3.2	N3.3	N4.1	N4.2	N4.3									
◪ 91 J	◪ 47 J	◪ 156 J	◪ 60 J	◪ 64 J									

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	DCON MS (inch)	APMX (inch)	OAL (inch)	NOF
S9621/16	1/16	1.59	0.0630	0.125	0.250	1.500	2
S9623/32	3/32	2.38	0.0940	0.125	0.375	1.500	2
S9621/8	1/8	3.18	0.1250	0.125	0.500	1.500	2
S9625/32	5/32	3.97	0.1560	0.188	0.563	2.000	2
S9623/16	3/16	4.76	0.1880	0.188	0.625	2.000	2
S9627/32	7/32	5.56	0.2190	0.250	0.625	2.500	2
S9621/4	1/4	6.35	0.2500	0.250	0.750	2.500	2
S9625/16	5/16	7.94	0.3130	0.313	0.875	2.500	2
S9623/8	3/8	9.53	0.3750	0.375	0.875	2.500	2
S9627/16	7/16	11.11	0.4380	0.438	1.000	2.500	2
S9621/2	1/2	12.70	0.5000	0.500	1.000	3.000	2
S9629/16	9/16	14.29	0.5630	0.563	1.250	3.500	2
S9625/8	5/8	15.88	0.6250	0.625	1.250	3.500	2
S96211/16	11/16	17.46	0.6880	0.750	1.500	2.000	2
S9623/4	3/4	19.05	0.7500	0.750	1.500	4.000	2
S9627/8	7/8	22.23	0.8750	0.875	1.500	4.000	2
S9621	1	25.40	1.0000	1.000	1.500	4.000	2

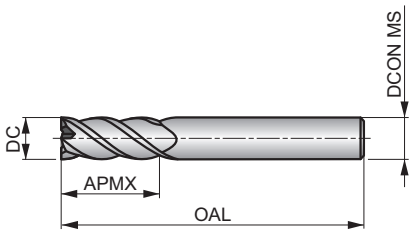
S964

DORMER PRAMET

4 刃整体硬质合金立铣刀

中等切削长度，4 刃设计，34° 螺旋角，为轮廓铣削提供高刚性。TiALN 涂层具有更高的耐温性，刀具寿命更长。

HM	N	NOF 4
	λ 34°	γ 9°
DIN 6535HA	TiAlN	DC h10
	WORK NORM	



工件材料组的适用性，线速度(m/min)的起始值和Alpha代码。从162页开始，可以找到每齿进给量和校正系数的表格。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 158 I	■ 177 I	■ 183 I	■ 135 I	■ 120 I	■ 105 G	■ 117 I	■ 95 G	■ 80 G	■ 70 G	■ 60 G	■ 49 G	■ 35 I	■ 29 I
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■ 30 I	■ 26 I	■ 28 I	■ 24 I	■ 120 J	■ 88 J	■ 67 J	■ 128 J	■ 104 J	■ 84 I	■ 114 J	■ 86 J	■ 70 I	■ 105 I
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■ 80 I	■ 58 I	■ 50 I	■ 42 I	■ 120 I	■ 90 I	■ 69 I	◪ 296 J	◪ 222 J	■ 149 J	■ 149 J	■ 133 J	■ 96 J	■ 156 J
N3.2	N3.3	N4.1	N4.2	N4.3									
◪ 91 J	◪ 47 J	◪ 156 J	◪ 60 J	◪ 64 J									

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	DCON MS (inch)	DCON MS (mm)	APMX (inch)	APMX (mm)	OAL (inch)	OAL (mm)	NOF
S9641/16 [1]	1/16	1.59	0.0630	0.125	3.18	0.250	6.35	1.500	38.1	4
S9642.0	–	2.00	0.0790	0.118	3.00	0.236	6.00	1.496	38.0	4
S9643/32 [1]	3/32	2.38	0.0940	0.125	3.18	0.375	9.53	1.500	38.1	4
S9642.5	–	2.50	0.0980	0.118	3.00	0.354	9.00	1.496	38.0	4
S9643.0	–	3.00	0.1180	0.118	3.00	0.472	12.00	1.496	38.0	4
S9641/8 [1]	1/8	3.18	0.1250	0.125	3.18	0.500	12.70	1.500	38.1	4
S9645/32 [1]	5/32	3.97	0.1560	0.188	4.76	0.563	14.29	2.000	50.8	4
S9644.0	–	4.00	0.1570	0.157	4.00	0.551	14.00	1.969	50.0	4
S9643/16 [1]	3/16	4.76	0.1880	0.188	4.76	0.625	15.88	2.000	50.8	4
S9645.0	–	5.00	0.1970	0.197	5.00	0.630	16.00	1.969	50.0	4
S9647/32 [1]	7/32	5.56	0.2190	0.250	6.35	0.625	15.88	2.500	63.5	4
S9646.0	–	6.00	0.2360	0.236	6.00	0.748	19.00	2.244	57.0	4
S9641/4 [1]	1/4	6.35	0.2500	0.250	6.35	0.750	19.05	2.500	63.5	4
S9647.0	–	7.00	0.2760	0.315	8.00	0.748	19.00	2.480	63.0	4
S9645/16 [1]	5/16	7.94	0.3130	0.313	7.94	0.875	22.23	2.500	63.5	4
S9648.0	–	8.00	0.3150	0.315	8.00	0.748	19.00	2.480	63.0	4
S9649.0	–	9.00	0.3540	0.394	10.00	0.827	21.00	2.835	72.0	4
S9643/8 [1]	3/8	9.53	0.3750	0.375	9.53	0.875	22.23	2.500	63.5	4
S96410.0	–	10.00	0.3940	0.394	10.00	0.866	22.00	2.835	72.0	4
S9647/16 [1]	7/16	11.11	0.4380	0.438	11.11	1.000	25.40	2.500	63.5	4
S96412.0	–	12.00	0.4720	0.472	12.00	0.984	25.00	2.874	73.0	4
S9641/2 [1]	1/2	12.70	0.5000	0.500	12.70	1.000	25.40	3.000	76.2	4
S96414.0	–	14.00	0.5510	0.551	14.00	1.181	30.00	3.268	83.0	4
S9649/16 [1]	9/16	14.29	0.5630	0.563	14.29	1.250	31.75	3.500	88.9	4
S9645/8 [1]	5/8	15.88	0.6250	0.625	15.88	1.250	31.75	3.500	88.9	4

产品	DC	DC	DC	DCON MS	DCON MS	APMX	APMX	OAL	OAL	NOF
	(inch)	(mm)	(inch)	(inch)	(mm)	(inch)	(mm)	(inch)	(mm)	
S96416.0	–	16.00	0.6300	0.630	16.00	1.260	32.00	3.622	92.0	4
S96418.0	–	18.00	0.7090	0.709	18.00	1.260	32.00	3.622	92.0	4
S9643/4 [1]	3/4	19.05	0.7500	0.750	19.05	1.500	38.10	4.000	101.6	4
S96420.0	–	20.00	0.7870	0.787	20.00	1.496	38.00	4.094	104.0	4
S9647/8 [1]	7/8	22.23	0.8750	0.875	22.23	1.500	38.10	4.000	101.6	4
S9641 [1]	1	25.40	1.0000	1.000	25.40	1.500	38.10	4.000	101.6	4

[1] 圆柱刀柄

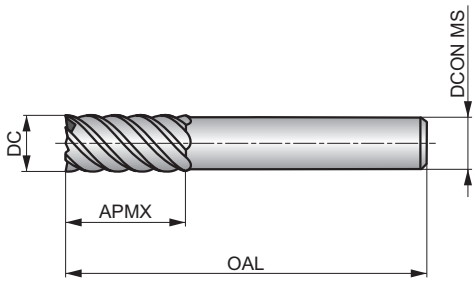
S966

DORMER PRAMET

6 刃整体硬质合金立铣刀

中等切削长度，6 刀刃设计，45° 螺旋角，为型材精加工提供高刚性。TiALN 涂层具有更高的耐温性和更长的刀具寿命。

HM	N	NOF 6
	λ 45°	γ 9°
DIN 6535HA	TiAlN	DC h10
	WORK NORM	



工件材料组的适用性，线速度(m/min)的起始值和Alpha代码。从162页开始，可以找到每齿进给量和校正系数的表格。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■85 F	■96 F	■99 F	■73 F	■65 F	■57 F	■63 F	■51 F	■43 F	■38 F	■32 F	■27 F	■35 I	■29 I
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■30 I	■26 I	■28 I	■24 I	■65 J	■48 J	■36 J	■69 J	■56 J	■45 I	■62 J	■46 J	■38 I	■57 I
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■43 I	■31 I	■27 I	■23 I	■65 I	■49 I	■37 I	◪296 J	◪222 J	■149 J	■149 J	■133 J	■96 J	■156 J
N3.2	N3.3	N4.1	N4.2	N4.3									
◪91 J	◪47 J	◪156 J	◪60 J	◪64 J									

DCON MS公差h6

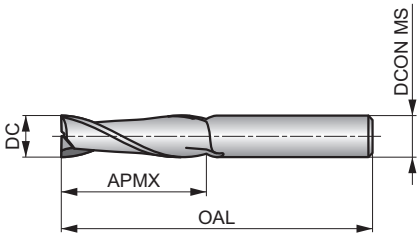
产品	DC (inch)	DC (mm)	DC (inch)	DCON MS (inch)	DCON MS (mm)	APMX (inch)	APMX (mm)	OAL (inch)	OAL (mm)	NOF
S9666.0	–	6.00	0.2360	0.236	6.00	0.748	19.00	2.244	57.0	6
S9661/4 [1]	1/4	6.35	0.2500	0.250	6.35	0.750	19.05	2.500	63.5	6
S9665/16 [1]	5/16	7.94	0.3130	0.313	7.94	0.875	22.23	2.500	63.5	6
S9668.0	–	8.00	0.3150	0.315	8.00	0.748	19.00	2.480	63.0	6
S9663/8 [1]	3/8	9.53	0.3750	0.375	9.53	0.875	22.23	2.500	63.5	6
S96610.0	–	10.00	0.3940	0.394	10.00	0.866	22.00	2.835	72.0	6
S9667/16 [1]	7/16	11.11	0.4380	0.438	11.11	1.000	25.40	2.500	63.5	6
S96612.0	–	12.00	0.4720	0.472	12.00	1.024	26.00	3.268	83.0	6
S9661/2 [1]	1/2	12.70	0.5000	0.500	12.70	1.000	25.40	3.000	76.2	6
S9669/16 [1]	9/16	14.29	0.5630	0.563	14.29	1.250	31.75	3.500	88.9	6
S9665/8 [1]	5/8	15.88	0.6250	0.625	15.88	1.250	31.75	3.500	88.9	6
S96616.0	–	16.00	0.6300	0.630	16.00	1.260	32.00	3.622	92.0	6
S96611/16 [1]	11/16	17.46	0.6880	0.750	19.05	1.500	38.10	4.000	101.6	6
S9663/4 [1]	3/4	19.05	0.7500	0.750	19.05	1.500	38.10	4.000	101.6	6
S96620.0	–	20.00	0.7870	0.787	20.00	1.496	38.00	4.094	104.0	6
S9667/8 [1]	7/8	22.23	0.8750	0.875	22.23	1.500	38.10	4.000	101.6	6
S9661 [1]	1	25.40	1.0000	1.000	25.40	1.500	38.10	4.000	101.6	6

[1] 圆柱刀柄

S982

双刃整体硬质合金立铣刀

切削长度长，双刃设计，28° 螺旋角，为铣削深槽提供更高的刚性。TiALN 涂层具有更高的耐温性，刀具寿命更长。



HM	N	NOF 2
	λ 28°	γ 9°
DIN 6535HA	TiAlN	DC h10
	WORK NORM	

工件材料组的适用性，线速度(m/min)的起始值和Alpha代码。从162页开始，可以找到每齿进给量和校正系数的表格。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 158 I	■ 177 I	■ 183 I	■ 135 I	■ 120 I	■ 105 G	■ 117 I	■ 95 G	■ 80 G	■ 70 G	■ 60 G	■ 49 G	■ 35 I	■ 29 I
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■ 30 I	■ 26 I	■ 28 I	■ 24 I	■ 120 J	■ 88 J	■ 67 J	■ 128 J	■ 104 J	■ 84 I	■ 114 J	■ 86 J	■ 70 I	■ 105 I
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■ 80 I	■ 58 I	■ 50 I	■ 42 I	■ 120 I	■ 90 I	■ 69 I	◪ 296 J	◪ 222 J	■ 149 J	■ 149 J	■ 133 J	■ 96 J	■ 156 J
N3.2	N3.3	N4.1	N4.2	N4.3									
◪ 91 J	◪ 47 J	◪ 156 J	◪ 60 J	◪ 64 J									

DCON MS公差h6

产品	DC (mm)	DC (inch)	DCON MS (mm)	APMX (mm)	OAL (mm)	NOF
S9822.0	2.00	0.0790	3.00	19.00	60.0	2
S9822.5	2.50	0.0980	3.00	19.00	60.0	2
S9823.0	3.00	0.1180	3.00	19.00	60.0	2
S9824.0	4.00	0.1570	4.00	19.00	60.0	2
S9825.0	5.00	0.1970	5.00	19.00	60.0	2
S9826.0	6.00	0.2360	6.00	31.00	75.0	2
S9827.0	7.00	0.2760	8.00	31.00	75.0	2
S9828.0	8.00	0.3150	8.00	31.00	75.0	2
S9829.0	9.00	0.3540	10.00	31.00	75.0	2
S98210.0	10.00	0.3940	10.00	31.00	75.0	2
S98212.0	12.00	0.4720	12.00	50.00	100.0	2
S98214.0	14.00	0.5510	14.00	57.00	125.0	2
S98216.0	16.00	0.6300	16.00	57.00	125.0	2
S98218.0	18.00	0.7090	18.00	57.00	125.0	2
S98220.0	20.00	0.7870	20.00	57.00	125.0	2

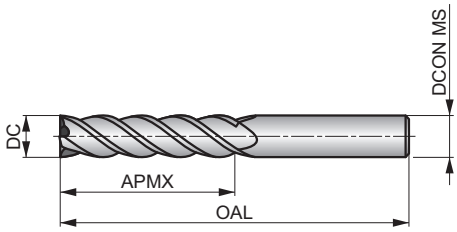
S984

DORMER PRAMET

4 刃整体硬质合金立铣刀

长切削长度、4 刃设计、34° 螺旋角，为铣削深壁提供了高刚性。TiALN 涂层可提高性能并延长刀具寿命。

HM	N	NOF 4
	λ 34°	γ 9°
DIN 6535HA	TiAlN	DC h10
	WORK NORM	



工件材料组的适用性，线速度(m/min)的起始值和Alpha代码。从162页开始，可以找到每齿进给量和校正系数的表格。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 158 I	■ 177 I	■ 183 I	■ 135 I	■ 120 I	■ 105 G	■ 117 I	■ 95 G	■ 80 G	■ 70 G	■ 60 G	■ 49 G	■ 35 I	■ 29 I
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■ 30 I	■ 26 I	■ 28 I	■ 24 I	■ 120 J	■ 88 J	■ 67 J	■ 128 J	■ 104 J	■ 84 I	■ 114 J	■ 86 J	■ 70 I	■ 105 I
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■ 80 I	■ 58 I	■ 50 I	■ 42 I	■ 120 I	■ 90 I	■ 69 I	◪ 296 J	◪ 222 J	■ 149 J	■ 149 J	■ 133 J	■ 96 J	■ 156 J
N3.2	N3.3	N4.1	N4.2	N4.3									
◪ 91 J	◪ 47 J	◪ 156 J	◪ 60 J	◪ 64 J									

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	DCON MS (mm)	DCON MS (inch)	APMX (mm)	APMX (inch)	OAL (mm)	OAL (inch)	NOF
S9841/16 [1]	1/16	1.59	0.0630	3.18	0.125	19.05	0.750	50.8	2.000	4
S9842.0	–	2.00	0.0790	3.00	0.118	19.00	0.748	60.0	2.362	4
S9843/32 [1]	3/32	2.38	0.0940	3.18	0.125	19.05	0.750	50.8	2.000	4
S9842.5	–	2.50	0.0980	3.00	0.118	19.00	0.748	60.0	2.362	4
S9843.0	–	3.00	0.1180	3.00	0.118	19.00	0.748	60.0	2.362	4
S9841/8 [1]	1/8	3.18	0.1250	3.18	0.125	19.05	0.750	50.8	2.000	4
S9845/32 [1]	5/32	3.97	0.1560	4.76	0.188	19.05	0.750	63.5	2.500	4
S9844.0	–	4.00	0.1570	4.00	0.157	19.00	0.748	60.0	2.362	4
S9843/16 [1]	3/16	4.76	0.1880	4.76	0.188	19.05	0.750	63.5	2.500	4
S9845.0	–	5.00	0.1970	5.00	0.197	19.00	0.748	60.0	2.362	4
S9847/32 [1]	7/32	5.56	0.2190	6.35	0.250	28.57	1.125	76.2	3.000	4
S9846.0	–	6.00	0.2360	6.00	0.236	31.00	1.220	75.0	2.953	4
S9841/4 [1]	1/4	6.35	0.2500	6.35	0.250	28.57	1.125	76.2	3.000	4
S9847.0	–	7.00	0.2760	8.00	0.315	31.00	1.220	75.0	2.953	4
S9845/16 [1]	5/16	7.94	0.3130	7.94	0.313	28.57	1.125	76.2	3.000	4
S9848.0	–	8.00	0.3150	8.00	0.315	31.00	1.220	75.0	2.953	4
S9849.0	–	9.00	0.3540	10.00	0.394	31.00	1.220	75.0	2.953	4
S9843/8 [1]	3/8	9.53	0.3750	9.53	0.375	28.57	1.125	76.2	3.000	4
S98410.0	–	10.00	0.3940	10.00	0.394	31.00	1.220	100.0	3.937	4
S9847/16 [1]	7/16	11.11	0.4380	11.11	0.438	50.80	2.000	101.6	4.000	4
S98412.0	–	12.00	0.4720	12.00	0.472	50.00	1.969	100.0	3.937	4
S9841/2 [1]	1/2	12.70	0.5000	12.70	0.500	57.15	2.250	127.0	5.000	4
S98414.0	–	14.00	0.5510	14.00	0.551	57.00	2.244	125.0	4.921	4
S9849/16 [1]	9/16	14.29	0.5630	14.29	0.563	50.80	2.000	101.6	4.000	4
S9845/8 [1]	5/8	15.88	0.6250	15.88	0.625	57.15	2.250	127.0	5.000	4

产品	DC	DC	DC	DCON MS	DCON MS	APMX	APMX	OAL	OAL	NOF
	(inch)	(mm)	(inch)	(mm)	(inch)	(mm)	(inch)	(mm)	(inch)	
S98416.0	–	16.00	0.6300	16.00	0.630	57.00	2.244	125.0	4.921	4
S98418.0	–	18.00	0.7090	18.00	0.709	57.00	2.244	125.0	4.921	4
S9843/4 [1]	3/4	19.05	0.7500	19.05	0.750	57.15	2.250	127.0	5.000	4
S98420.0	–	20.00	0.7870	20.00	0.787	57.00	2.244	125.0	4.921	4
S9847/8 [1]	7/8	22.23	0.8750	22.23	0.875	50.80	2.000	101.6	4.000	4
S9841 [1]	1	25.40	1.0000	25.40	1.000	57.15	2.250	127.0	5.000	4

[1] 圆柱刀柄

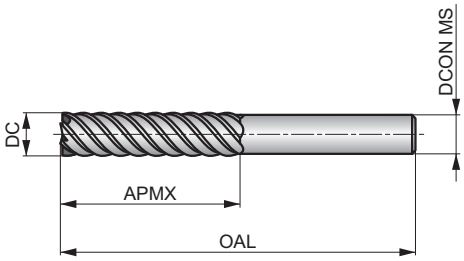
S986

DORMER PRAMET

6 刃整体硬质合金立铣刀

切削长度长，6刃设计，带 45° 螺旋角，为深壁精加工提供了高刚性。TiALN 涂层具有更高的耐温性和更长的刀具寿命。

HM	N	NOF 6
	λ 45°	γ 9°
DIN 6535HA	TiAlN	DC h10
	WORK NORM	



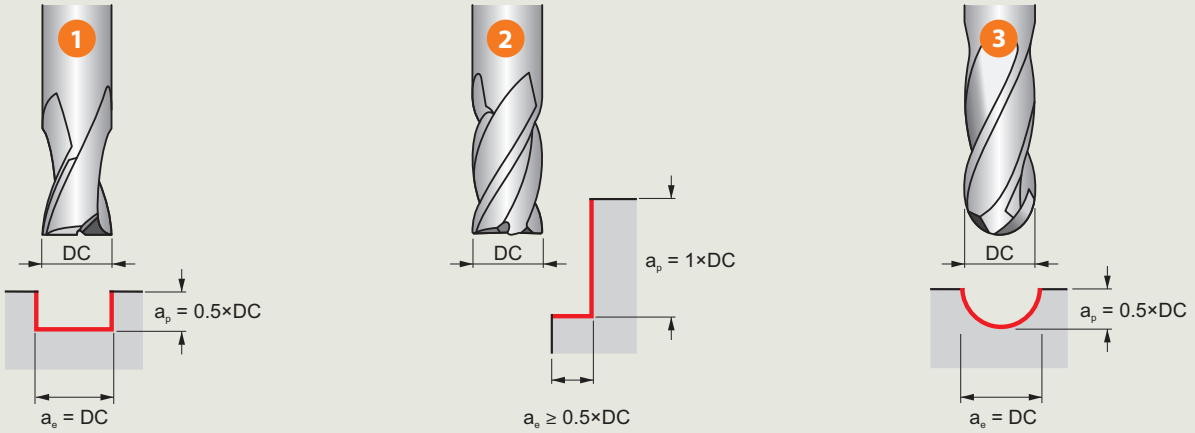
工件材料组的适用性，线速度(m/min)的起始值和Alpha代码。从162页开始，可以找到每齿进给量和校正系数的表格。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■85 F	■96 F	■99 F	■73 F	■65 F	■57 F	■63 F	■51 F	■43 F	■38 F	■32 F	■27 F	■35 I	■29 I
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■30 I	■26 I	■28 I	■24 I	■65 J	■48 J	■36 J	■69 J	■56 J	■45 I	■62 J	■46 J	■38 I	■57 I
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■43 I	■31 I	■27 I	■23 I	■65 I	■49 I	■37 I	◪296 J	◪222 J	■149 J	■149 J	■133 J	■96 J	■156 J
N3.2	N3.3	N4.1	N4.2	N4.3									
◪91 J	◪47 J	◪156 J	◪60 J	◪64 J									

DCON MS公差h6

产品	DC (inch)	DC (mm)	DC (inch)	DCON MS (mm)	DCON MS (inch)	APMX (mm)	APMX (inch)	OAL (mm)	OAL (inch)	NOF
S9866.0	–	6.00	0.2360	6.00	0.236	31.00	1.220	75.0	2.953	6
S9861/4 [1]	1/4	6.35	0.2500	6.35	0.250	28.57	1.125	76.2	3.000	6
S9865/16 [1]	5/16	7.94	0.3130	7.94	0.313	28.57	1.125	76.2	3.000	6
S9868.0	–	8.00	0.3150	8.00	0.315	31.00	1.220	75.0	2.953	6
S9863/8 [1]	3/8	9.53	0.3750	9.53	0.375	28.57	1.125	76.2	3.000	6
S98610.0	–	10.00	0.3940	10.00	0.394	31.00	1.220	100.0	3.937	6
S9867/16 [1]	7/16	11.11	0.4380	11.11	0.438	50.80	2.000	101.6	4.000	6
S98612.0	–	12.00	0.4720	12.00	0.472	50.00	1.969	100.0	3.937	6
S9861/2 [1]	1/2	12.70	0.5000	12.70	0.500	50.80	2.000	101.6	4.000	6
S98614.0	–	14.00	0.5510	14.00	0.551	57.00	2.244	125.0	4.921	6
S9869/16 [1]	9/16	14.29	0.5630	14.29	0.563	50.80	2.000	101.6	4.000	6
S9865/8 [1]	5/8	15.88	0.6250	15.88	0.625	57.15	2.250	127.0	5.000	6
S98616.0	–	16.00	0.6300	16.00	0.630	57.00	2.244	125.0	4.921	6
S98618.0	–	18.00	0.7090	18.00	0.709	57.00	2.244	125.0	4.921	6
S9863/4 [1]	3/4	19.05	0.7500	19.05	0.750	57.15	2.250	127.0	5.000	6
S98620.0	–	20.00	0.7870	20.00	0.787	57.00	2.244	125.0	4.921	6
S9867/8 [1]	7/8	22.23	0.8750	22.23	0.875	57.15	2.250	101.6	4.000	6
S9861 [1]	1	25.40	1.0000	25.40	1.000	57.15	2.250	127.0	5.000	6

[1] 圆柱刀柄



每齿进给量 (f_z, 单位mm/tooth) 取决于工况，在这些数值基础上±25%。
仅当使用具有过中心切削立铣刀对坚固材料进行插铣时，才直接将本表中的数值视为f_n (每转进给)。

如何使用此表格查找每齿进给量 f_z:

1. 在产品页找到相应的字母代码 (示例：199K，“**K**”为字母代码)。
2. 在表格第一行找到与切削应用最接近的直径。
3. 在表格左列找到相应的字母代码。
4. 直径和字母代码的交点 (格) 就是每齿进给量fz。

仅用于整硬合金铣削刀具

每齿进给量(mm/tooth)	ø DC (mm)																
	1.0	2.0	3.0	4.0	5.0	6.0	7.0	8.0	9.0	10.0	12.0	14.0	16.0	18.0	20.0	22.0	25.0
A	0.002	0.003	0.004	0.005	0.006	0.007	0.008	0.009	0.010	0.011	0.014	0.015	0.017	0.019	0.021	0.025	0.028
B	0.002	0.003	0.004	0.005	0.006	0.007	0.008	0.009	0.010	0.011	0.014	0.015	0.017	0.019	0.021	0.025	0.028
C	0.002	0.003	0.004	0.005	0.006	0.007	0.008	0.009	0.010	0.011	0.014	0.015	0.017	0.019	0.021	0.025	0.028
D	0.002	0.003	0.004	0.005	0.007	0.008	0.009	0.010	0.011	0.012	0.014	0.015	0.017	0.019	0.021	0.025	0.028
E	0.002	0.003	0.004	0.008	0.009	0.012	0.013	0.014	0.015	0.016	0.019	0.021	0.024	0.026	0.028	0.030	0.034
F	0.002	0.003	0.006	0.010	0.013	0.016	0.017	0.019	0.021	0.022	0.026	0.029	0.032	0.035	0.039	0.042	0.047
G	0.002	0.005	0.008	0.014	0.018	0.022	0.024	0.026	0.028	0.031	0.035	0.040	0.044	0.048	0.053	0.057	0.064
I	0.003	0.006	0.011	0.019	0.024	0.030	0.032	0.036	0.039	0.042	0.049	0.054	0.061	0.066	0.073	0.079	0.088
J	0.004	0.009	0.014	0.026	0.033	0.041	0.044	0.048	0.053	0.057	0.066	0.074	0.083	0.090	0.099	0.107	0.120
K	0.006	0.012	0.019	0.035	0.044	0.054	0.059	0.064	0.070	0.076	0.088	0.098	0.110	0.120	0.132	0.142	0.160
N	0.008	0.016	0.025	0.047	0.058	0.072	0.078	0.086	0.094	0.101	0.117	0.131	0.146	0.160	0.175	0.189	0.212
O	0.010	0.021	0.034	0.062	0.078	0.096	0.104	0.114	0.124	0.135	0.156	0.174	0.195	0.213	0.233	0.252	0.283
P	0.014	0.028	0.045	0.083	0.104	0.128	0.138	0.152	0.166	0.180	0.207	0.231	0.259	0.283	0.311	0.335	0.376
R	0.018	0.037	0.060	0.110	0.138	0.170	0.184	0.202	0.221	0.239	0.276	0.308	0.345	0.377	0.414	0.446	0.501
S	0.024	0.049	0.080	0.147	0.183	0.226	0.245	0.269	0.294	0.318	0.367	0.410	0.459	0.502	0.550	0.593	0.667

用于模块化 BS 刀片的多边形柄定位 (PSC) 刀柄

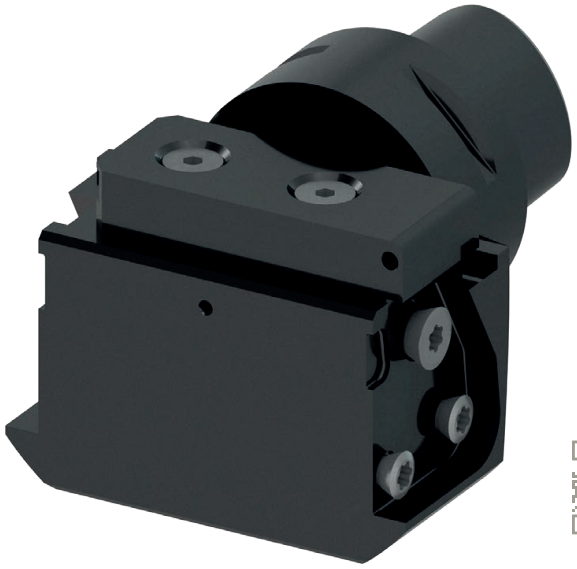
以经济高效的高精度扩展您的加工能力

我们的多边形定位(PSC) 刀柄为外径向车削应用提供了经济的解决方案，可与我们现有的 BS 刀片库存无缝集成。

这些模块化刀柄专为右侧或左侧装配而设计，无需投资新刀片即可提高切断和切槽操作的通用性。

相关产品

C.-BS-F EXT
C4 – C6



GLS BS

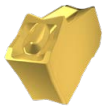
XLCF (NRL) BS

XLXFL BS AXIAL

GL. 2–6

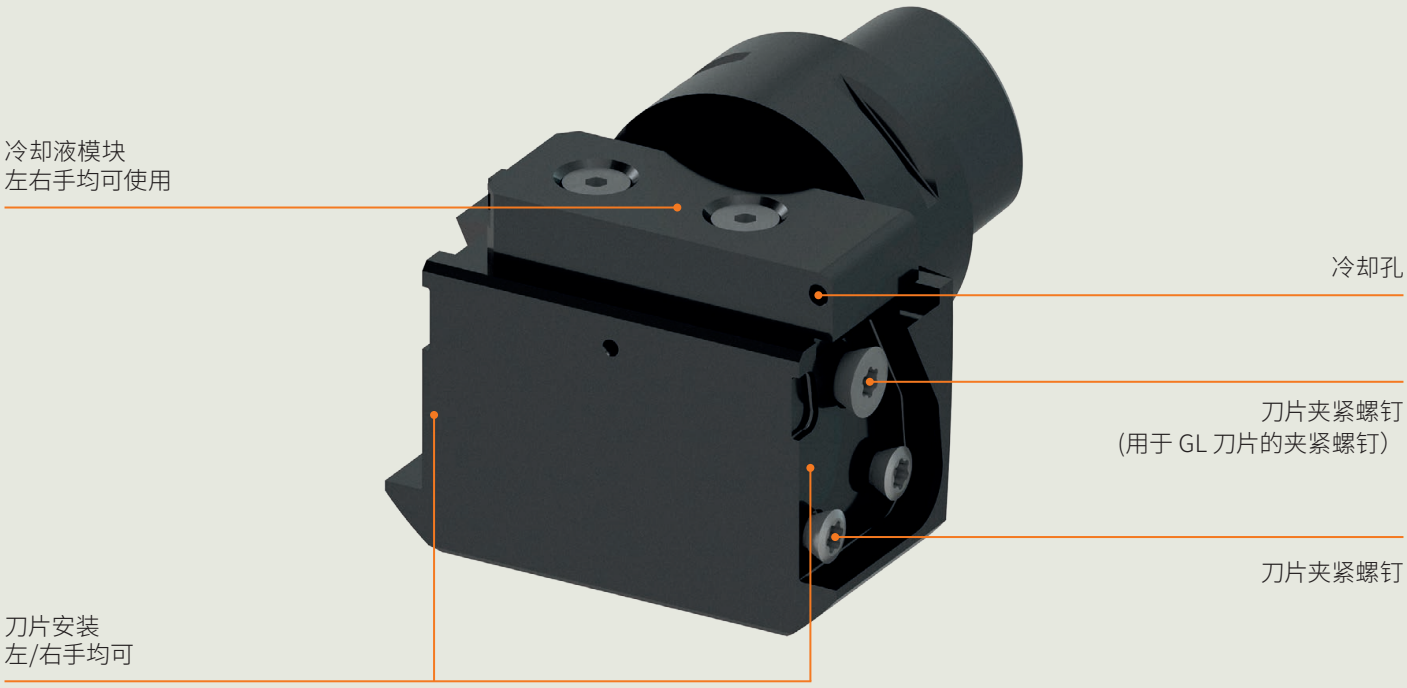
LFMX 1.4 – 6.35

LFMX 3.1



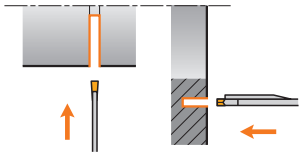
功能和优点

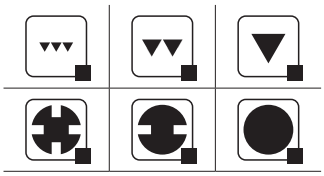
冷却液模块设计。	**引导冷却液流向** 精确到切削刃，改善排屑，从而提高表面质量，减少中断。
优化冷却。	**延长耐用性，减少磨损** 提高整体生产率。
组装左右两侧的刀片。	**多功能刀具夹持解决方案** 支持多种加工应用。
模块化设计。	**可重复使用现有的 BS 刀片** 降低投资需求，优化资源。
坚固的结构。	**优化的稳定性和可靠的性能** 提供始终如一的高质量结果。

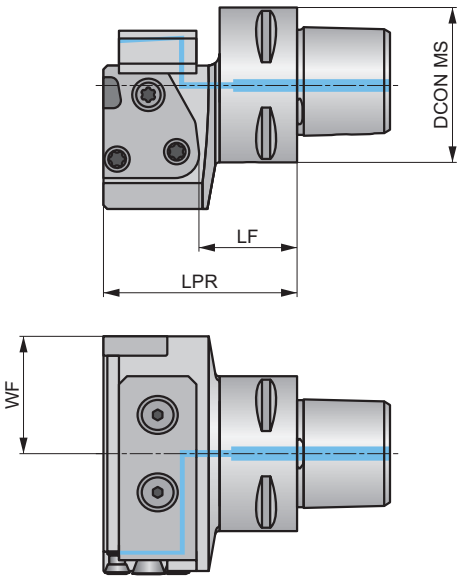


C.-BS-F EXT

用于 BS 刀片的模块化刀柄，带多边形刀柄接头 - 外部
用于 BS 型切槽、切断刀片的模块化刀柄，配有可调节的冷却液块。刀柄符合 ISO 26623 标准（多边形刀柄接头）。







	产品	LF (mm)	LPR (mm)	DCON MS (mm)	WF (mm)		kg			
	C4-BS-SFN3050	25.3	50	40	30.3	✓	0.65	GI003	CO700	CC04
	C5-BS-SFN3050	25.3	50	50	30.3	✓	0.83	GI003	CO700	CC04
	C6-BS-SFN4260	35.3	60	63	42.3	✓	1.73	GI003	CO700	CC05

GI003	XLC.. 25..15...	XLC.. 25..25...	GL.BS	XLXFL 25...

		Nm			Nm		
CO700	US 45013-T20P	5.0	M5	US 46017-T20P	5.0	M6	FLAG T20P

CO700=2x US 45013-T20P

		Nm				
CC04	HCS 0416	4.0	M4	CHP-O5X1	CHP-BL2048	HXK 2.5
CC05	HCS 0416	4.0	M4	CHP-O5X1	CHP-BL2068	HXK 2.5

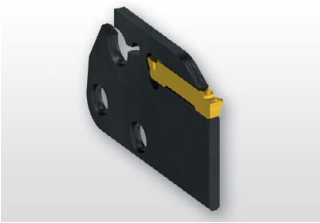
CC04=2xHCS 0416 + 2xCHP-O5x1, CC05=2xHCS 0416 + 2xCHP-O5x1

GLS BS

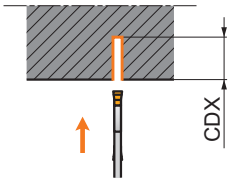
P M K N S H

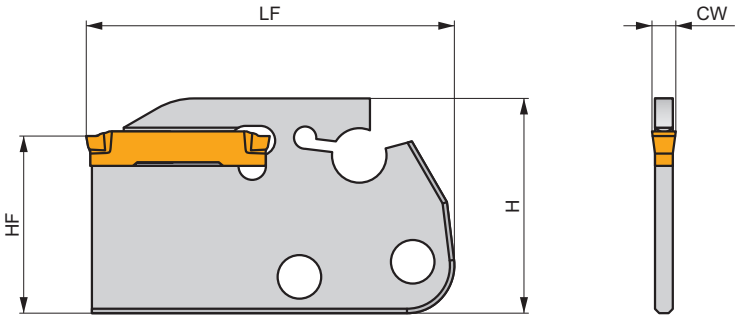
DORMER PRAMET

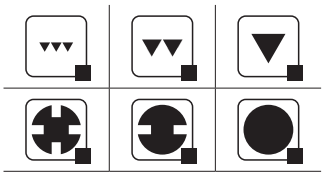
G



切槽和切断加工刀板，用于GL刀片、MS-EN刀柄
用于模块化刀柄MS-EN的刀板，设计用于GL刀片。适用于切槽和切断加工应用。刀片经过处理，确保了更长的刀具寿命。







产品	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg	
GL2-S29CBS	24	29	50	2.00	24	0.01	GI334
GL3-S29CBS	24	29	50	3.00	24	0.02	GI335
GL4-S29CBS	24	29	50	4.00	24	0.02	GI336
GL5-S29CBS	24	29	50	5.00	24	0.03	GI337
GL6-S29CBS	24	29	50	6.00	24	0.04	GI338

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

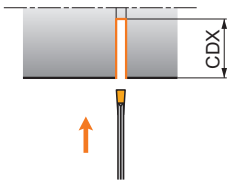
XLCF(NRL) BS

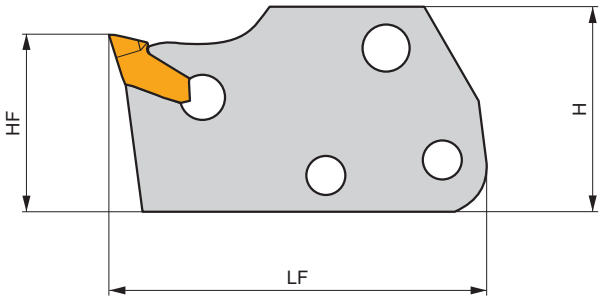
P M K N S H

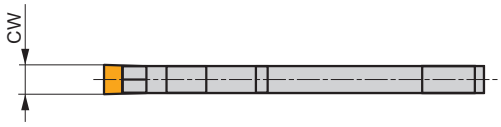
DORMER PRAMET

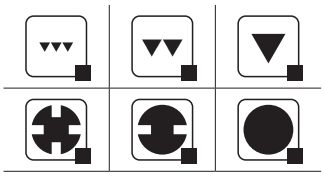
X

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	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
R	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 250115-1.60	24	29	40	1.50	15	0.04	GI132	KV
	XLCFL 250115-2.00	24	29	40	2.00	15	0.05	GI061	KV
N	XLCFN 250215-3.00	24	29	40	3.10	15	0.04	GI001	KV
	XLCFN 250225-3.00	24	29	50	3.10	25	0.02	GI001	KV
	XLCFN 250315-4.00	24	29	40	4.10	15	0.04	GI002	KV
	XLCFN 250325-4.00	24	29	50	4.10	25	0.04	GI002	KV
	XLCFN 250425-5.00	24	29	50	5.10	25	0.04	GI004	KV
	XLCFN 250525-6.35	24	29	50	6.35	25	0.07	GI005	KV

GI001	LFMX 3.1-.	–	–
GI002	LFMX 4.1-.	–	–
GI004	LFMX 5.1-.	–	–
GI005	LFMX 6.35-.	–	–
GI061	LFMX 2.0-.	LFMX 2.2-.	–
GI132	LFMX 1.4-.	LFMX 1.5-.	LFMX 1.6-.

KV	KV 5x70

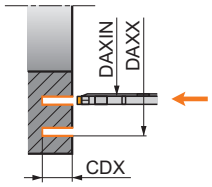
XLXFL BS AXIAL

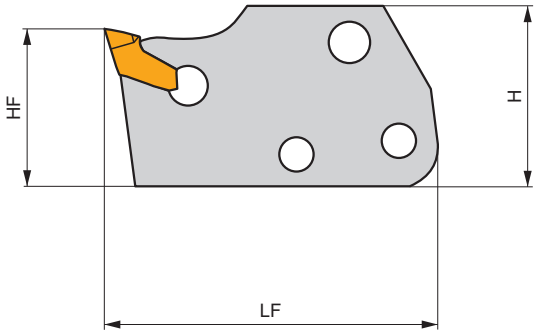
P M K N S H

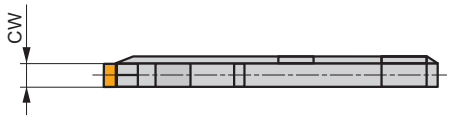
DORMER PRAMET

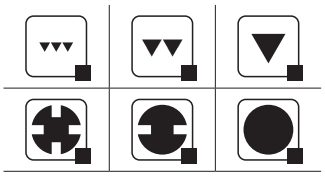
X

模块化MS-EN槽刀杆的端面开槽刀板，使用LFMX刀片。
模块化切槽刀板，切槽加工，使用单面LFMX3.1刀片。适用于端面开槽（最大切削深度为20mm）应用。
可以安装在MS-EN车刀杆上。刀板经过处理，使用寿命更长。









	产品	H (mm)	HF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	kg		
L	XLXFL 250220-3.00-60	29	24	46	3.10	20	60	85	0.05	GI001	KV
	XLXFL 250220-3.00-80	29	24	46	3.10	20	80	105	0.05	GI001	KV
	XLXFL 250220-3.00-100	29	24	46	3.10	20	100	155	0.03	GI001	KV
	XLXFL 250220-3.00-150	29	24	46	3.10	20	150	280	0.03	GI001	KV

GI001	LFMX 3.1-.

KV	KV 5x70

刀杆采用 ISO S 型夹持方式，用于内圆车削加工

加工深孔，提高工艺稳定性

我们的新型刀柄（ISO S系列）为车床内孔车削作业提供高效解决方案，其集成式冷却液供应系统可确保刀具寿命稳定。该系列刀柄采用加长整体设计，无需特殊装夹即可加工深孔及难以触及的内孔几何结构。

请注意：随着新系列的推出，我们将逐步停产旧款刀具。停产产品已在官网标注，售完即止。替换产品名称已同步展示以便查阅。请注意，新旧版本在尺寸、角度及备件方面可能存在差异。

相关产品

SCLC(RL) INT

用于 CC..06、CC..09、CC..12 的内部刀具

刀柄尺寸 DCON MS: 08; 10; 12; 16; 20 ; 25; 32

KAPR 95°

SDQC(RL) INT

用于 DC...07; DC...11 的内部刀具

刀柄尺寸 DCON MS: 10; 12; 16; 20; 25

KAPR 107.5°

SDUC(RL) INT

用于 DC...07; DC...11 的内部刀具

刀柄尺寸 DCON MS: 10; 12; 16; 20; 25

KAPR 93°

STFC(RL) INT

用于TC.11; TC.16 的内部刀具

刀柄尺寸 DCON MS: 12; 16; 20; 25; 32

KAPR 91°

功能和优点

内部冷却液供应将冷却液直接输送到切削刃。	**稳定的刀具寿命** 确保性能稳定，排屑可靠。
加长的总长度提供了更高的悬伸能力。	**进入深孔** 可加工难以触及的内部几何形状。

产品系列替换表

适用于 ISO S 材料的内圆车削刀具，具有内冷却液供应和加长型设计

过时			新		差异		
					功能长度 - 毫米 (LF)		
PSF	MID	订购代码	MID	订购代码	旧	新	
SCLC (RL) INT	6760285	A08H-SCLCR 06	8998323	A08H-SCLCR06-**A**	100	100	相同
SCLC (RL) INT	6761028	A08H-SCLCL 06	8998322	A08H-SCLCL06-**A**	100	100	相同
SCLC (RL) INT	6756827	A10H-SCLCR 06	8957512	A10**K**-SCLCR 06	100	125	更长
SCLC (RL) INT	6756872	A10H-SCLCL 06	8922972	A10**K**-SCLCL 06	100	125	更长
SCLC (RL) INT	6756828	A12K-SCLCR 06	8922974	A12**M**-SCLCR 06	125	150	更长
SCLC (RL) INT	6756869	A12K-SCLCL 06	8922973	A12**M**-SCLCL 06	125	150	更长
SCLC (RL) INT	6756716	A16M-SCLCR 09-A	8922976	A16**R**-SCLCR 09	150	200	更长
SCLC (RL) INT	6756717	A16M-SCLCL 09-A	8922975	A16**R**-SCLCL 09	150	200	更长
SCLC (RL) INT	6757212	A20Q-SCLCR 09	8922978	A20**S**-SCLCR 09	180	250	更长
SCLC (RL) INT	6756856	A20Q-SCLCL 09	8922977	A20**S**-SCLCL 09	180	250	更长
SCLC (RL) INT	6756874	A25R-SCLCL 09	8922979	A25**T**-SCLCL 09	200	300	更长
SCLC (RL) INT	6756870	A25R-SCLCR 09	9003069	A25**T**-SCLCR 09	200	300	更长
SCLC (RL) INT	7773890	A25T-SCLCL 12	7773890	A25T-SCLCL 12	300	300	相同
SCLC (RL) INT	6756870	A25R-SCLCR 09	8922980	A25**T**-SCLCR 12	200	300	更长
SCLC (RL) INT	6756641	A32S-SCLCR 12-A	8922982	A32**T**-SCLCR 12	250	300	更长
SCLC (RL) INT	6756640	A32S-SCLCL 12-A	8922981	A32**T**-SCLCL 12	250	300	更长
SDQC (RL) INT	6756996	A10H-SDQCR 07	8922984	A10**K**-SDQCR 07	100	125	更长
SDQC (RL) INT	6757007	A10H-SDQCL 07	8922983	A10**K**-SDQCL 07	100	125	更长
SDQC (RL) INT	6757020	A12K-SDQCR 07	8922986	A12**M**-SDQCR 07	125	150	更长
SDQC (RL) INT	6757008	A12K-SDQCL 07	8922985	A12**M**-SDQCL 07	125	150	更长
SDQC (RL) INT	6756997	A16M-SDQCR 07	8922988	A16**R**-SDQCR 07	150	200	更长
SDQC (RL) INT	6757009	A16M-SDQCL 07	8922987	A16**R**-SDQCL 07	150	200	更长
SDQC (RL) INT	6757001	A20Q-SDQCR 11	8922990	A20**S**-SDQCR 11	180	250	更长
SDQC (RL) INT	6757297	A20Q-SDQCL 11	8922989	A20**S**-SDQCL 11	180	250	更长
SDQC (RL) INT	6757002	A25R-SDQCR 11	8922992	A25**T**-SDQCR 11	200	300	更长
SDQC (RL) INT	6757298	A25R-SDQCL 11	8922991	A25**T**-SDQCL 11	200	300	更长
SDUC (RL) INT	6757102	A10H-SDUCR 07	8922994	A10**K**-SDUCR 07	100	125	更长
SDUC (RL) INT	6757005	A10H-SDUCL 07	8922993	A10**K**-SDUCL 07	100	125	更长
SDUC (RL) INT	6757103	A12K-SDUCR 07	8922996	A12**M**-SDUCR 07	125	150	更长
SDUC (RL) INT	6757006	A12K-SDUCL 07	8922995	A12**M**-SDUCL 07	125	150	更长
SDUC (RL) INT	6757104	A16M-SDUCR 07	8922998	A16**R**-SDUCR 07	150	200	更长
SDUC (RL) INT	6757151	A16M-SDUCL 07	8922997	A16**R**-SDUCL 07	150	200	更长
SDUC (RL) INT	6757105	A20Q-SDUCR 11	8923000	A20**S**-SDUCR 11	180	250	更长
SDUC (RL) INT	6757152	A20Q-SDUCL 11	8922999	A20**S**-SDUCL 11	180	250	更长
SDUC (RL) INT	6757107	A25R-SDUCR 11	8923002	A25**T**-SDUCR 11	200	300	更长
SDUC (RL) INT	6756857	A25R-SDUCL 11	8923001	A25**T**-SDUCL 11	200	300	更长
STFC (RL) INT	6761011	A12M-STFCR 11	8998325	A12M-STFCR 11-**A**	150	150	相同
STFC (RL) INT	6761010	A12M-STFCL 11	8998324	A12M-STFCL 11-**A**	150	150	相同
STFC (RL) INT	6761017	A25R-STFCR 16	8923004	A25**T**-STFCR 16	200	300	更长
STFC (RL) INT	6761016	A25R-STFCL 16	8923003	A25**T**-STFCL 16	200	300	更长
STFC (RL) INT	6761013	A16R-STFCR 11	8998327	A16R-STFCR 11-**A**	200	200	相同
STFC (RL) INT	6761012	A16R-STFCL 11	8998326	A16R-STFCL 11-**A**	200	200	相同
STFC (RL) INT	6761019	A32S-STFCR 16	8923006	A32**T**-STFCR 16	250	300	更长
STFC (RL) INT	6761018	A32S-STFCL 16	8923005	A32**T**-STFCL 16	250	300	更长
STFC (RL) INT	6761015	A20S-STFCR 11	8998329	A20S-STFCR 11-**A**	250	250	相同
STFC (RL) INT	6761014	A20S-STFCL 11	8998328	A20S-STFCL 11-**A**	250	250	相同

SCLC(RL) INT

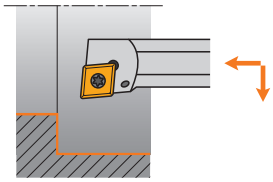
P M K N S H

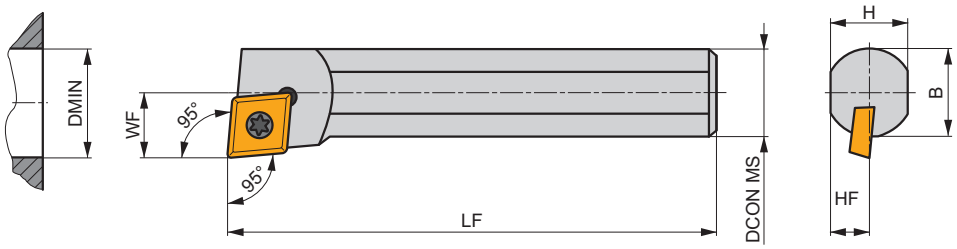
DORMER PRAMET

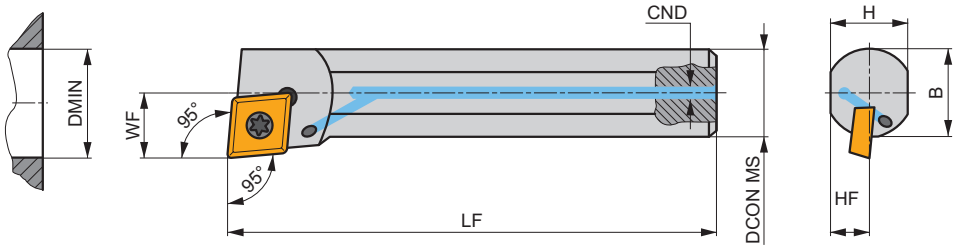
S

内孔螺钉夹紧镗杆，使用CC..刀片，主偏角为95°

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







	产品	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A08H-SCLCR 06-A	8	10	5	7	–	100	–	-14	0	✓	0.04	GI045	SC06M
	A10K-SCLCR 06	10	12	6	9	–	125	–	-11	0	✓	0.06	GI045	SC06M
	A12M-SCLCR 06	12	16	9	11	–	150	–	-7	0	✓	0.11	GI045	SC06M
	A16R-SCLCR 09	16	20	11	15	–	200	–	-8	0	✓	0.26	GI041	SC09M
	A20S-SCLCR 09	20	25	13	18	–	250	–	-6	0	✓	0.50	GI041	SC09M
	A25T-SCLCR 09	25	32	17	23	–	300	–	-3	0	✓	0.89	GI041	SC09
	A25T-SCLCR 12	25	32	17	23	–	300	–	-5	0	✓	0.90	GI011	CO480
	A32T-SCLCR 12	32	40	22	30	–	300	–	-10	0	✓	1.58	GI011	SC12
L	A08H-SCLCL 06-A	8	10	5	7	–	100	–	-14	0	✓	0.03	GI045	SC06M
	A10K-SCLCL 06	10	12	6	9	–	125	–	-11	0	✓	0.06	GI045	SC06M
	A12M-SCLCL 06	12	16	9	11	–	150	–	-7	0	✓	0.11	GI045	SC06M
	A16R-SCLCL 09	16	20	11	15	–	200	–	-8	0	✓	0.25	GI041	SC09M
	A20S-SCLCL 09	20	25	13	18	–	250	–	-6	0	✓	0.50	GI041	SC09M
	A25T-SCLCL 09	25	32	17	23	–	300	–	-3	0	✓	0.90	GI041	SC09
	A25T-SCLCL 12	25	32	17	23	–	300	–	-5	0	✓	0.90	GI011	CO480
	A32T-SCLCL 12	32	40	22	30	–	300	–	-10	0	✓	1.58	GI011	SC12

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

		Nm					
CO480	US 2017-T15P	3.0	M 4	11	–	–	FLAG T15P/3,5

		Nm					
SC06M	US 2046-T07P	0.9	M 2.5	5.1	–	–	FLAG T07P
SC09	US 2010-T15P	3.0	M 3.5	10.1	–	–	FLAG T15P/3,5
SC09M	US 2009-T15P	3.0	M 3.5	8.1	–	–	FLAG T15P/3,5
SC12	US 2018-T15P	3.0	M 4	14	SCS 232-02	MS 9003	FLAG T15P/4

SDQC(RL) INT

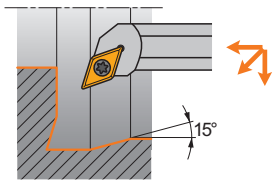
P M K N S H

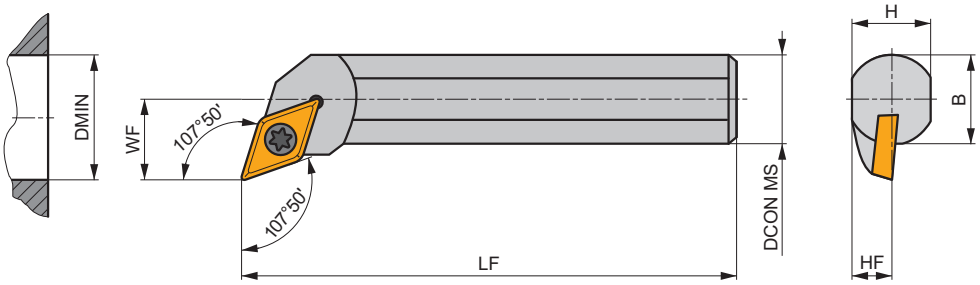
DORMER PRAMET

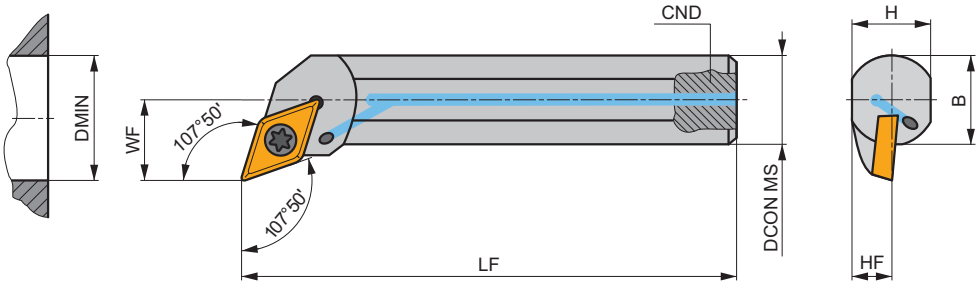
S

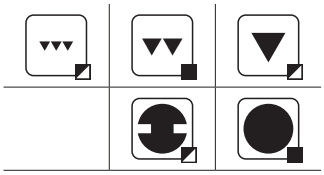
内孔镗杆,螺钉夹紧,使用DC..刀片,主偏角为107.5°

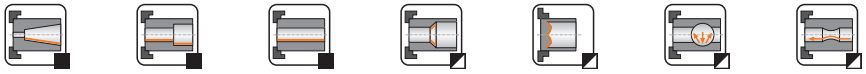
内孔左/右手镗杆,有内冷通道,螺钉夹紧。主偏角为107.5⊠。使用DC..刀片。适用于有阶梯孔的轴向车削,锥面,仿形和倒角车削。刀杆经过处理,使用寿命更长。











	产品	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A10K-SDQCR 07	10	13	7	9	–	125	–	-10	0	✓	0.08	GI052	CO481
	A12M-SDQCR 07	12	16	9	11	–	150	–	-7	0	✓	0.11	GI052	SD07
	A16R-SDQCR 07	16	20	11	15	–	200	–	-5	0	✓	0.25	GI052	SD07
	A20S-SDQCR 11	20	25	13	18	–	250	–	-6	0	✓	0.54	GI012	SD11M
	A25T-SDQCR 11	25	32	17	23	–	300	–	-4	0	✓	0.89	GI012	SD11I
L	A10K-SDQCL 07	10	13	7	9	–	125	–	-10	0	✓	0.06	GI052	CO481
	A12M-SDQCL 07	12	16	9	11	–	150	–	-7	0	✓	0.11	GI052	SD07
	A16R-SDQCL 07	16	20	11	15	–	200	–	-5	0	✓	0.25	GI052	SD07
	A20S-SDQCL 11	20	25	13	18	–	250	–	-6	0	✓	0.49	GI012	SD11M
	A25T-SDQCL 11	25	32	17	23	–	300	–	-4	0	✓	0.89	GI012	SD11I

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

		Nm			
CO481	US 2048-T07P	0.9	M 2.5	5.7	FLAG T07P
SD07	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P
SD11I	US 2010-T15P	3.0	M 3.5	10.1	FLAG T15P/3,5
SD11M	US 2009-T15P	3.0	M 3.5	8.1	FLAG T15P/3,5

SDUC(RL) INT

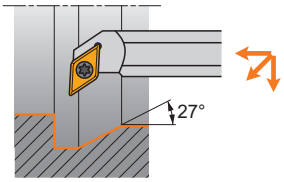
P M K N S H

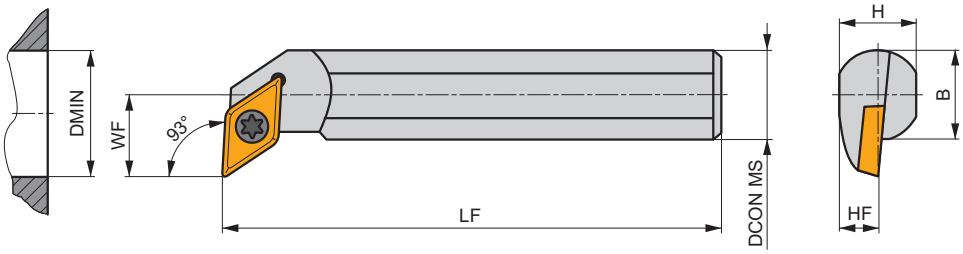
DORMER PRAMET

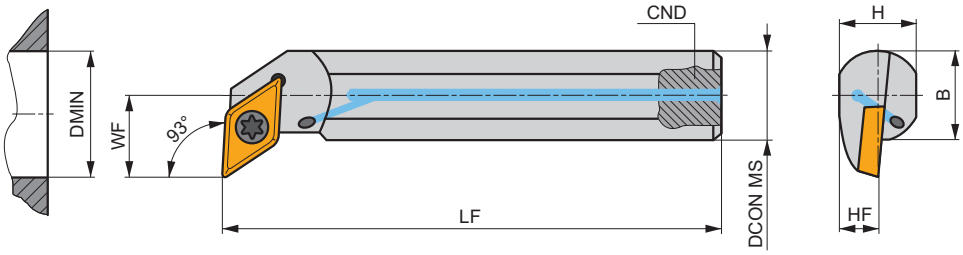
S

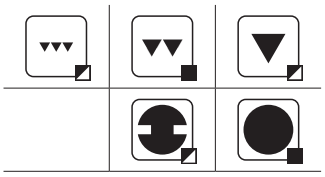
内孔螺钉夹紧镗杆，使用DC..刀片，主偏角为93°

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









	产品	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A10K-SDUCR 07	10	13	7	9	–	125	–	-9	0	✓	0.07	GI052	CO481
	A12M-SDUCR 07	12	16	9	11	–	150	–	-7	0	✓	0.11	GI052	SD07
	A16R-SDUCR 07	16	20	11	15	–	200	–	-4	0	✓	0.25	GI052	SD07
	A20S-SDUCR 11	20	25	13	18	–	250	–	-6	0	✓	0.50	GI012	SD11M
	A25T-SDUCR 11	25	32	17	23	–	300	–	-3	0	✓	0.90	GI012	SD11I
L	A10K-SDUCL 07	10	13	7	9	–	125	–	-9	0	✓	0.08	GI052	CO481
	A12M-SDUCL 07	12	16	9	11	–	150	–	-7	0	✓	0.13	GI052	SD07
	A16R-SDUCL 07	16	20	11	15	–	200	–	-4	0	✓	0.25	GI052	SD07
	A20S-SDUCL 11	20	25	13	18	–	250	–	-6	0	✓	0.50	GI012	SD11M
	A25T-SDUCL 11	25	32	17	23	–	300	–	-3	0	✓	0.90	GI012	SD11I

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

		Nm			
CO481	US 2048-T07P	0.9	M 2.5	5.7	FLAG T07P
SD07	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P
SD11I	US 2010-T15P	3.0	M 3.5	10.1	FLAG T15P/3,5
SD11M	US 2009-T15P	3.0	M 3.5	8.1	FLAG T15P/3,5

STFC(RL) INT

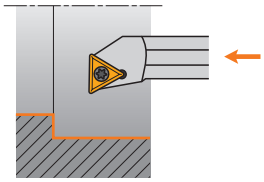
P M K N S H

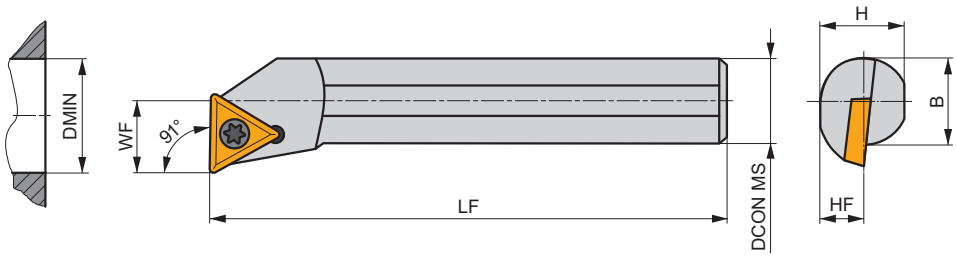
DORMER PRAMET

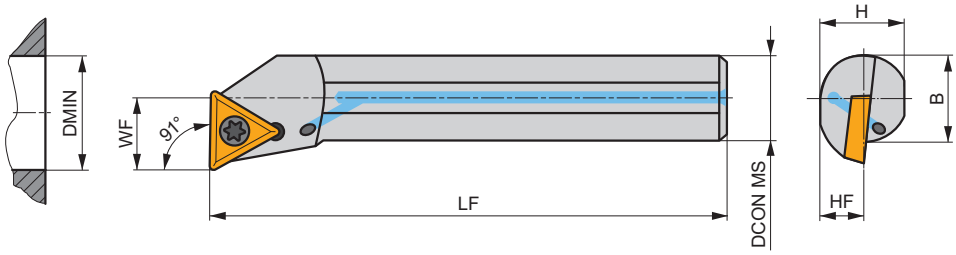
S

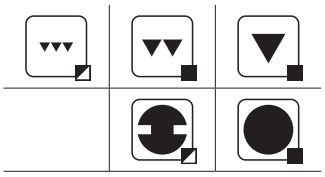
内孔螺钉夹紧镗杆，使用TC..刀片，主偏角为91°

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









	产品	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A12M-STFCR 11-A	12	16	9	11	–	150	-7	0	✓	0.12	GI056	C0481
	A16R-STFCR 11-A	16	20	11	15	–	200	-4	0	✓	0.25	GI056	ST11
	A20S-STFCR 11-A	20	25	13	18	–	250	-3	0	✓	0.50	GI056	ST11
	A25T-STFCR 16	25	32	17	23	–	300	-3	0	✓	0.90	GI016	ST16I
	A32T-STFCR 16	32	40	22	30	–	300	-8	0	✓	1.58	GI016	ST16I
L	A12M-STFCL 11-A	12	16	9	11	–	150	-7	0	✓	0.12	GI056	C0481
	A16R-STFCL 11-A	16	20	11	15	–	200	-4	0	✓	0.28	GI056	ST11
	A20S-STFCL 11-A	20	25	13	18	–	250	-3	0	✓	0.50	GI056	ST11
	A25T-STFCL 16	25	32	17	23	–	300	-3	0	✓	0.90	GI016	ST16I
	A32T-STFCL 16	32	40	22	30	–	300	-8	0	✓	1.58	GI016	ST16I

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

		Nm			
C0481	US 2048-T07P	0.9	M 2.5	5.7	FLAG T07P
ST11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P
ST16I	US 2010-T15P	3.0	M 3.5	10.1	FLAG T15P/3,5

ISO组			WMG（加工材料组）		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	–

DORMER PRAMET™

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无论现在还是将来，我们都将共同努力，
让世界继续运转。我们期望助力行业树立信心，
使其能随时随地获取正确的建议。工具和培训。
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