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全磨制直柄麻花钻 D100

Full grinding straight shank drill Hemp flowers

材料 Material	HSS	螺旋角 Spiral angle	30°	钻尖角度 point angle	120°
适用于加工 Suitable for processing	普通钢铁, 合金钢、铸铁、铸钢等, 被切削材料硬度在HRC30以内。 Suitable for processing: ordinary steel, alloy steel, cast iron, cast steel and so on, by cutting the material hardness within HRC30. 适用于一般钻床及加工中心上钻孔加工。 Applicable to general drilling machine and machining center hole drilling.				



单位(Unit): mm

编号 No.	直径 Diameter	沟长 Flute Length	总长 Total Length	编号 No.	直径 Diameter	沟长 Flute Length	总长 Total Length
D100010	1.0	18	40	D100071	7.1	75	108
D100011	1.1	20	42	D100072	7.2	75	108
D100012	1.2	20	42	D100073	7.3	75	108
D100013	1.3	22	45	D100074	7.4	78	111
D100014	1.4	23	48	D100075	7.5	78	111
D100015	1.5	23	48	D100076	7.6	78	111
D100016	1.6	25	50	D100077	7.7	81	114
D100017	1.7	25	50	D100078	7.8	81	114
D100018	1.8	28	52	D100079	7.9	81	114
D100019	1.9	28	52	D100080	8.0	81	114
D100020	2.0	29	55	D100081	8.1	84	117
D100021	2.1	29	55	D100082	8.2	84	117
D100022	2.2	33	58	D100083	8.3	84	117
D100023	2.3	33	58	D100084	8.4	87	121
D100024	2.4	35	61	D100085	8.5	87	121
D100025	2.5	35	61	D100086	8.6	87	121
D100026	2.6	37	64	D100087	8.7	87	121
D100027	2.7	37	64	D100088	8.8	89	124
D100028	2.8	39	67	D100089	8.9	89	124
D100029	2.9	42	71	D100090	9.0	89	124
D100030	3.0	42	71	D100091	9.1	89	124
D100031	3.1	42	71	D100092	9.2	92	127
D100032	3.2	42	71	D100093	9.3	92	127
D100033	3.3	45	73	D100094	9.4	92	127
D100034	3.4	45	73	D100095	9.5	92	127
D100035	3.5	45	73	D100096	9.6	95	130
D100036	3.6	48	76	D100097	9.7	95	130
D100037	3.7	48	76	D100098	9.8	95	130
D100038	3.8	48	76	D100099	9.9	95	130
D100039	3.9	51	79	D100100	10.0	95	130
D100040	4.0	54	83	D100101	10.1	98	133
D100041	4.1	54	83	D100102	10.2	98	133
D100042	4.2	54	83	D100103	10.3	98	133
D100043	4.3	54	83	D100104	10.4	98	133
D100044	4.4	56	86	D100105	10.5	100	137
D100045	4.5	56	86	D100106	10.6	100	137
D100046	4.6	56	89	D100107	10.7	100	137
D100047	4.7	59	89	D100108	10.8	103	140
D100048	4.8	59	89	D100109	10.9	103	140
D100049	4.9	62	92	D100110	11.0	103	140
D100050	5.0	62	92	D100111	11.1	103	140
D100051	5.1	62	92	D100112	11.2	106	143
D100052	5.2	64	95	D100113	11.3	106	143
D100053	5.3	64	95	D100114	11.4	106	143
D100054	5.4	64	95	D100115	11.5	106	143
D100055	5.5	64	95	D100116	11.6	109	146
D100056	5.6	67	98	D100117	11.7	109	146
D100057	5.7	67	98	D100118	11.8	109	146
D100058	5.8	67	98	D100119	11.9	109	146
D100059	5.9	67	98	D100120	12.0	111	149
D100060	6.0	70	102	D100121	12.1	111	149
D100061	6.1	70	102	D100122	12.2	111	149
D100062	6.2	70	102	D100123	12.3	111	149
D100063	6.3	70	102	D100124	12.4	114	152
D100064	6.4	73	105	D100125	12.5	114	152
D100065	6.5	73	105	D100126	12.6	114	152
D100066	6.6	73	105	D100127	12.7	114	152
D100067	6.7	73	105	D100128	12.8	114	152
D100068	6.8	73	105	D100129	12.9	114	152
D100069	6.9	73	105	D100130	13.0	114	152
D100070	7.0	73	105				

高钴直柄麻花钻 (不锈钢专用) SU101

COBALT PARALLET SHANK TWIST DRILLS (special stainless steel)

材料 Material	HSS-E	螺旋角 Spiral angle	38°	钻尖角度 point angle	130°
适用于加工 Suitable for processing	不锈钢、钛合金、调质硬钢件。 Stainless steel, titanium alloy, Quenched and tempered steel.				



单位(Unit): mm

编号 No.	直径 Diameter	沟长 Flute Length	总长 Total Length	编号 No.	直径 Diameter	沟长 Flute Length	总长 Total Length
SU101010	1.0	12	34	SU101071	7.1	69	109
SU101011	1.1	14	36	SU101072	7.2	69	109
SU101012	1.2	16	38	SU101073	7.3	69	109
SU101013	1.3	16	38	SU101074	7.4	69	109
SU101014	1.4	18	40	SU101075	7.5	69	109
SU101015	1.5	18	40	SU101076	7.6	75	117
SU101016	1.6	20	43	SU101077	7.7	75	117
SU101017	1.7	20	43	SU101078	7.8	75	117
SU101018	1.8	22	46	SU101079	7.9	75	117
SU101019	1.9	22	46	SU101080	8.0	75	117
SU101020	2.0	24	49	SU101081	8.1	75	117
SU101021	2.1	24	49	SU101082	8.2	75	117
SU101022	2.2	27	53	SU101083	8.3	75	117
SU101023	2.3	27	53	SU101084	8.4	75	117
SU101024	2.4	30	57	SU101085	8.5	75	117
SU101025	2.5	30	57	SU101086	8.6	81	125
SU101026	2.6	30	57	SU101087	8.7	81	125
SU101027	2.7	33	61	SU101088	8.8	81	125
SU101028	2.8	33	61	SU101089	8.9	81	125
SU101029	2.9	33	61	SU101090	9.0	81	125
SU101030	3.0	33	61	SU101091	9.1	81	125
SU101031	3.1	36	65	SU101092	9.2	81	125
SU101032	3.2	36	65	SU101093	9.3	81	125
SU101033	3.3	36	65	SU101094	9.4	81	125
SU101034	3.4	39	70	SU101095	9.5	81	125
SU101035	3.5	39	70	SU101096	9.6	87	133
SU101036	3.6	39	70	SU101097	9.7	87	133
SU101037	3.7	39	70	SU101098	9.8	87	133
SU101038	3.8	43	75	SU101099	9.9	87	133
SU101039	3.9	43	75	SU101100	10.0	87	133
SU101040	4.0	43	75	SU101101	10.1	87	133
SU101041	4.1	43	75	SU101102	10.2	87	133
SU101042	4.2	43	75	SU101103	10.3	87	133
SU101043	4.3	47	80	SU101104	10.4	87	133
SU101044	4.4	47	80	SU101105	10.5	87	133
SU101045	4.5	47	80	SU101106	10.6	87	133
SU101046	4.6	47	80	SU101107	10.7	94	142
SU101047	4.7	47	80	SU101108	10.8	94	142
SU101048	4.8	52	86	SU101109	10.9	94	142
SU101049	4.9	52	86	SU101110	11.0	94	142
SU101050	5.0	52	86	SU101111	11.1	94	142
SU101051	5.1	52	86	SU101112	11.2	94	142
SU101052	5.2	52	86	SU101113	11.3	94	142
SU101053	5.3	52	86	SU101114	11.4	94	142
SU101054	5.4	57	93	SU101115	11.5	94	142
SU101055	5.5	57	93	SU101116	11.6	94	142
SU101056	5.6	57	93	SU101117	11.7	94	142
SU101057	5.7	57	93	SU101118	11.8	94	142
SU101058	5.8	57	93	SU101119	11.9	101	151
SU101059	5.9	57	93	SU101120	12.0	101	151
SU101060	6.0	57	93	SU101121	12.1	101	151
SU101061	6.1	63	101	SU101122	12.2	101	151
SU101062	6.2	63	101	SU101123	12.3	101	151
SU101063	6.3	63	101	SU101124	12.4	101	151
SU101064	6.4	63	101	SU101125	12.5	101	151
SU101065	6.5	63	101	SU101126	12.6	101	151
SU101066	6.6	63	101	SU101127	12.7	101	151
SU101067	6.7	63	101	SU101128	12.8	101	151
SU101068	6.8	69	109	SU101129	12.9	101	151
SU101069	6.9	69	109	SU101130	13.0	101	151
SU101070	7.0	69	109				

高钴直柄麻花钻（不锈钢专用）SU102

COBALT PARALLET SHANK TWIST DRILLS (special stainless steel)

材料 Material	HSS-E(NACHI)	螺旋角 Spiral angle	38°	钻尖角度 point angle	130°
适用于加工 Suitable for processing	不锈钢、钛合金、调质硬钢件。 Stainless steel, titanium alloy, Quenched and tempered steel.				



单位(Unit): mm

编号 No.	直径 Diameter	沟长 Flute Length	总长 Total Length	编号 No.	直径 Diameter	沟长 Flute Length	总长 Total Length
SU102010	1.0	14	39	SU102071	7.1	60	105
SU102011	1.1	15	41	SU102072	7.2	60	105
SU102012	1.2	15	41	SU102073	7.3	60	105
SU102013	1.3	16	44	SU102074	7.4	62	108
SU102014	1.4	18	47	SU102075	7.5	62	108
SU102015	1.5	18	47	SU102076	7.6	62	108
SU102016	1.6	19	49	SU102077	7.7	63	111
SU102017	1.7	19	49	SU102078	7.8	63	111
SU102018	1.8	20	51	SU102079	7.9	63	111
SU102019	1.9	20	51	SU102080	8.0	63	111
SU102020	2.0	22	53	SU102081	8.1	68	115
SU102021	2.1	22	53	SU102082	8.2	68	115
SU102022	2.2	23	56	SU102083	8.3	68	115
SU102023	2.3	23	56	SU102084	8.4	69	118
SU102024	2.4	25	59	SU102085	8.5	69	118
SU102025	2.5	25	59	SU102086	8.6	69	118
SU102026	2.6	27	62	SU102087	8.7	69	118
SU102027	2.7	27	62	SU102088	8.8	71	121
SU102028	2.8	28	65	SU102089	8.9	71	121
SU102029	2.9	34	69	SU102090	9.0	71	121
SU102030	3.0	34	69	SU102091	9.1	71	121
SU102031	3.1	34	69	SU102092	9.2	73	124
SU102032	3.2	34	69	SU102093	9.3	73	124
SU102033	3.3	35	71	SU102094	9.4	73	124
SU102034	3.4	35	71	SU102095	9.5	73	124
SU102035	3.5	35	71	SU102096	9.6	75	127
SU102036	3.6	36	74	SU102097	9.7	75	127
SU102037	3.7	36	74	SU102098	9.8	75	127
SU102038	3.8	36	74	SU102099	9.9	75	127
SU102039	3.9	38	77	SU102100	10.0	75	127
SU102040	4.0	42	81	SU102101	10.1	81	131
SU102041	4.1	42	81	SU102102	10.2	81	131
SU102042	4.2	42	81	SU102103	10.3	81	131
SU102043	4.3	42	81	SU102104	10.4	81	131
SU102044	4.4	44	84	SU102105	10.5	84	135
SU102045	4.5	44	84	SU102106	10.6	84	135
SU102046	4.6	44	84	SU102107	10.7	84	135
SU102047	4.7	45	87	SU102108	10.8	86	138
SU102048	4.8	45	87	SU102109	10.9	86	138
SU102049	4.9	49	90	SU102110	11.0	86	138
SU102050	5.0	49	90	SU102111	11.1	86	138
SU102051	5.1	49	90	SU102112	11.2	88	141
SU102052	5.2	49	92	SU102113	11.3	88	141
SU102053	5.3	49	92	SU102114	11.4	88	141
SU102054	5.4	49	92	SU102115	11.5	88	141
SU102055	5.5	49	92	SU102116	11.6	89	144
SU102056	5.6	51	95	SU102117	11.7	89	144
SU102057	5.7	51	95	SU102118	11.8	89	144
SU102058	5.8	51	95	SU102119	11.9	89	144
SU102059	5.9	51	95	SU102120	12.0	90	146
SU102060	6.0	56	99	SU102121	12.1	90	146
SU102061	6.1	56	99	SU102122	12.2	90	146
SU102062	6.2	56	99	SU102123	12.3	90	146
SU102063	6.3	56	99	SU102124	12.4	92	149
SU102064	6.4	58	102	SU102125	12.5	92	149
SU102065	6.5	58	102	SU102126	12.6	92	149
SU102066	6.6	58	102	SU102127	12.7	92	149
SU102067	6.7	58	102	SU102128	12.8	92	149
SU102068	6.8	58	102	SU102129	12.9	92	149
SU102069	6.9	58	102	SU102130	13.0	92	149
SU102070	7.0	58	102				

高钴锥柄麻花钻（不锈钢专用）SU103

COBALT TAPER SHANK TWIST DRILLS (special stainless steel)

材料 Material	HSS-E	螺旋角 Spiral angle	38°	钻尖角度 point angle	130°
适用于加工 Suitable for processing	不锈钢、钛合金、调质硬钢件。 Stainless steel, titanium alloy, Quenched and tempered steel.				



单位(Unit): mm

编号 No.	柄号 Shank No.	直径 Diameter	刃长 Flute Length	总长 Total Length	编号 No.	柄号 Shank No.	直径 Diameter	刃长 Flute Length	总长 Total Length
SU103100	1	10.0	87	168	SU103200	2	20.0	140	238
SU103105	1	10.5	87	168	SU103205	2	20.5	145	243
SU103110	1	11.0	94	175	SU103210	2	21.0	145	243
SU103115	1	11.5	94	175	SU103215	2	21.5	150	248
SU103120	1	12.0	101	182	SU103225	2	22.5	155	253
SU103125	1	12.5	101	182	SU103230	2	23.0	155	253
SU103130	1	13.0	101	182	SU103235	3	23.5	155	276
SU103135	1	13.5	108	189	SU103240	3	24.0	160	281
SU103140	1	14.0	108	189	SU103245	3	24.5	160	281
SU103145	2	14.5	114	212	SU103250	3	25.0	160	281
SU103150	2	15.0	114	212	SU103255	3	25.5	165	286
SU103155	2	15.5	120	218	SU103260	3	26.0	165	286
SU103160	2	16.0	120	218	SU103265	3	26.5	165	286
SU103165	2	16.5	125	223	SU103270	3	27.0	170	291
SU103170	2	17.0	125	223	SU103275	3	27.5	170	291
SU103175	2	17.5	130	228	SU103280	3	28.0	170	296
SU103180	2	18.0	130	228	SU103285	3	28.5	170	296
SU103185	2	18.5	135	233	SU103290	3	29.0	170	296
SU103190	2	19.0	135	233	SU103295	3	29.5	170	296
SU103195	2	19.5	140	238	SU103300	3	30.0	170	296

麻花钻(切削参数)

全磨制直柄麻花钻 D100

加工材料	P									
	低碳素钢·软钢 S15·CSS400									
切削速度	32~40m/min									
直径 mm	1	2	3	4	5	6	8	10	12	13
转速 r/min	10,000	5,700	3,850	2,900	2,260	1,900	1,400	1,120	950	880
进给量 mm/rev	0.02~0.05	0.06~0.09	0.10~0.13	0.11~0.15	0.12~0.18	0.13~0.19	0.17~0.24	0.20~0.28	0.24~0.34	0.25~0.36

高钴直柄麻花钻（不锈钢专用）SU101 / SU102

加工材料	M									
	不锈钢（奥氏体系列）S15C·SS400									
切削速度	13~18m/min									
直径 mm	1	2	3	4	5	6	8	10	12	13
转速 r/min	4,800	2,400	1,600	1,200	950	800	600	480	400	370
进给量 mm/rev	0.02~0.04	0.05~0.07	0.06~0.09	0.08~0.12	0.10~0.15	0.12~0.18	0.16~0.24	0.20~0.28	0.24~0.34	0.26~0.36
加工材料	P									
	调质钢（~300HB）S15C·SS400									
切削速度	21~26m/min									
直径 mm	1	2	3	4	5	6	8	10	12	13
转速 r/min	6,570	3,750	2,530	1,900	1,480	1,250	920	730	620	570
进给量 mm/rev	0.02~0.05	0.06~0.09	0.10~0.13	0.11~0.15	0.12~0.18	0.13~0.19	0.17~0.24	0.20~0.28	0.24~0.34	0.25~0.36

高钴锥柄麻花钻（不锈钢专用）SU103

加工材料	M														
	不锈钢（奥氏体系列）S15C·SS400														
切削速度	13~17m/min														
直径mm	10	12	13	14	15	16	17	18	19	20	22	24	26	28	30
转速r/min	480	400	370	340	320	300	280	265	250	240	215	200	185	170	160
进给量 mm/rev	0.20~0.28	0.24~0.34	0.26~0.36	0.28~0.39	0.29~0.40	0.30~0.43	0.31~0.45	0.32~0.47	0.33~0.48	0.34~0.50	0.36~0.54	0.38~0.57	0.40~0.60	0.41~0.63	0.42~0.66
加工材料	P														
	调质钢（~300HB）S15C·SS400														
切削速度	21~26m/min														
直径mm	10	12	13	14	15	16	17	18	19	20	22	24	26	28	30
转速r/min	730	620	570	530	500	470	440	420	290	370	340	310	290	270	250
进给量 mm/rev	0.20~0.28	0.24~0.34	0.25~0.36	0.27~0.39	0.28~0.42	0.29~0.43	0.30~0.46	0.32~0.49	0.33~0.51	0.34~0.52	0.37~0.57	0.39~0.61	0.41~0.66	0.43~0.71	0.45~0.75

注：表中数据为参考值，实际加工中，先选低值，逐渐加大。

整体硬质合金定柄钻 CDP-03

The whole hard alloy fixed shank drill CDP-03

材料 Material	CB-CERATLZAT W200	涂层 Coating	Tin (balzers)
适用于加工 Suitable for processing	小于3倍直径孔深的钢件类加工 less than 3 times the diameter of hole depth of steel parts processing		



单位(Unit): mm

序号 No.	型号规格 Model Specification	刃径 (m7) Mill Diameter	沟长 Flute Length	总长 Total Length	柄径 (h6) Shank Diameter
1	CDP-03-3.3~3.7	3.3~3.7	20	62	6
2	CDP-03-3.8~4.7	3.8~4.7	24	66	6
3	CDP-03-4.8~6.0	4.8~6.0	28	66	6
4	CDP-03-6.1~7.0	6.1~7.0	34	79	8
5	CDP-03-7.1~8.0	7.1~8.0	41	79	8
6	CDP-03-8.1~10.0	8.1~10.0	47	89	10
7	CDP-03-10.1~12	10.1~12	55	102	12
8	CDP-03-12.1~14	12.1~14	60	107	14
9	CDP-03-14.1~16	14.1~16	65	115	16
10	CDP-03-16.1~18	16.1~18	73	123	18
11	CDP-03-18.1~20	18.1~20	79	131	20

整体硬质合金定柄钻 CDK-03

The whole hard alloy fixed shank drill CDK-03

材料 Material	CB-CERATLZAT W200	涂层 Coating	AlTin (balzers)
适用于加工 Suitable for processing	小于3倍直径孔深的铸件类加工 less than 3 times the diameter of hole depth of steel parts processing		



单位(Unit): mm

序号 No.	型号规格 Model Specification	刃径 (m7) Mill Diameter	沟长 Flute Length	总长 Total Length	柄径 (h6) Shank Diameter
1	CDK-03-3.3~3.7	3.3~3.7	20	62	6
2	CDK-03-3.8~4.7	3.8~4.7	24	66	6
3	CDK-03-4.8~6.0	4.8~6.0	28	66	6
4	CDK-03-6.1~7.0	6.1~7.0	34	79	8
5	CDK-03-7.1~8.0	7.1~8.0	41	79	8
6	CDK-03-8.1~10.0	8.1~10.0	47	89	10
7	CDK-03-10.1~12	10.1~12	55	102	12
8	CDK-03-12.1~14	12.1~14	60	107	14
9	CDK-03-14.1~16	14.1~16	65	115	16
10	CDK-03-16.1~18	16.1~18	73	123	18
11	CDK-03-18.1~20	18.1~20	79	131	20

整体硬质合金定柄钻 CDP-05

The whole hard alloy fixed shank drill CDP-05

材料 Material	CB-CERATLZAT W200	涂层 Coating	Tin (balzers)
适用于加工 Suitable for processing	小于5倍直径孔深的钢件类加工 less than 5 times the diameter of hole depth of steel processing		



单位(Unit): mm

序号 No.	型号规格 Model Specification	刃径 (m7) Mill Diameter	沟长 Flute Length	总长 Total Length	柄径 (h6) Shank Diameter
1	CDP-05 -D3.3~D3.7	3.3~3.7	28	66	6
2	CDP-05- D3.8~D4.7	3.8~4.7	36	74	6
3	CDP-05- D4.8~D6.0	4.8~6.0	44	82	6
4	CDP-05- D6.1~D7.0	6.1~7.0	53	91	8
5	CDP-05- D7.1~D8.0	7.1~8.0	53	91	8
6	CDP-05- D8.1~D10	8.1~10.0	61	103	10
7	CDP-05- D10.1~D12	10.1~12	71	118	12
8	CDP-05- D12.1~D14	12.1~14	77	124	14
9	CDP-05- D14.1~D16	14.1~16	83	133	16
10	CDP-05- D16.1~D18	16.1~18	93	143	18
11	CDP-05- D18.1~D20	18.1~20	101	153	20

整体硬质合金定柄钻 CDK-05

The whole hard alloy fixed shank drill CDK-05

材料 Material	CB-CERATLZAT W200	涂层 Coating	AlTin (balzers)
适用于加工 Suitable for processing	小于5倍直径孔深的铸件类加工 less than 5 times the diameter of hole depth of casting processing		



单位(Unit): mm

序号 No.	型号规格 Model Specification	刃径 (m7) Mill Diameter	沟长 Flute Length	总长 Total Length	柄径 (h6) Shank Diameter
1	CDK-05-D3.3~D3.7	3.3~3.7	28	66	6
2	CDK-05-D3.8~D4.7	3.8~4.7	36	74	6
3	CDK-05-D4.8~D6.0	4.8~6.0	44	82	6
4	CDK-05-D6.1~D7.0	6.1~7.0	53	91	8
5	CDK-05-D7.1~D8.0	7.1~8.0	53	91	8
6	CDK-05-D8.1~D10	8.1~10.0	61	103	10
7	CDK-05-D10.1~D12	10.1~12	71	118	12
8	CDK-05-D12.1~D14	12.1~14	77	124	14
9	CDK-05-D14.1~D16	14.1~16	83	133	16
10	CDK-05-D16.1~D18	16.1~18	93	143	18
11	CDK-05-D18.1~D20	18.1~20	101	153	20

整体硬质合金内冷定柄钻 SCDP-03

Solid carbide in sizing shank drill SCDP - 03

材料 Material	CB-CERATLZAT W200	涂层 Coating	Tin (balzers)
适用于加工 Suitable for processing	小于3倍直径孔深的钢件类加工 less than 3 times the diameter of the hole depth of steel processing		



单位(Unit): mm

序号 No.	型号规格 Model Specification	刃径 (m7) Mill Diameter	槽长 Flute Length	总长 Total Length	柄径 (h6) Shank Diameter
1	SCDP-03 -D3.3~D3.7	3.3~3.7	20	58	4
2	SCDP-03- D3.8~D4.0	3.8~4.0	24	58	4
3	SCDP-03- D4.2~D4.6	4.2~4.6	24	66	6
4	SCDP-03- D4.9~D6.0	4.9~6.0	28	66	6
5	SCDP-03- D6.1~D7.0	6.1~7.0	34	79	8
6	SCDP-03-D7.1~D8.0	7.1-8.0	41	79	8
7	SCDP-03- D8.1~D10	8.1~10	47	89	10
8	SCDP-03- D10.1~D12	10.1~12	55	102	12
9	SCDP-03- D12.1~D14	12.1~14	60	107	14
10	SCDP-03- D14.1~D16	14.1~16	65	115	16
11	SCDP-03- D16.1~D18	16.1~18	73	123	18
12	SCDP-03- D18.1~D20	18.1~20	79	131	20

整体硬质合金内冷定柄钻 SCDK-03

Solid carbide in sizing shank drill SCDK- 03

材料 Material	CB-CERATLZAT W200	涂层 Coating	AlTiN (balzers)
适用于加工 Suitable for processing	小于3倍直径孔深的铸件类加工 less than 3 times the diameter of the hole depth of casting processing		



单位(Unit): mm

序号 No.	型号规格 Model Specification	刃径 (m7) Mill Diameter	槽长 Flute Length	总长 Total Length	柄径 (h6) Shank Diameter
1	SCDK-03 -D3.3~D3.7	3.3~3.7	20	54	4
2	SCDK-03- D3.8~D4.0	3.8~4.0	24	58	4
3	SCDK-03- D4.2~D4.6	4.2~4.6	24	66	6
4	SCDK-03- D4.9~D6.0	4.9~6.0	28	66	6
5	SCDK-03- D6.1~D7.0	6.1~7.0	34	79	8
6	SCDK-03-D7.1~D8.0	7.1-8.0	41	79	8
7	SCDK-03- D8.1~D10	8.1~10	47	89	10
8	SCDK-03- D10.1~D12	10.1~12	55	102	12
9	SCDK-03- D12.1~D14	12.1~14	60	107	14
10	SCDK-03- D14.1~D16	14.1~16	65	115	16
11	SCDK-03- D16.1~D18	16.1~18	73	123	18
12	SCDK-03- D18.1~D20	18.1~20	79	131	20

整体硬质合金内冷定柄钻 SCDP-05

Solid carbide in sizing shank drill SCDP - 05

材料 Material	CB-CERATLZAT W200	涂层 Coating	Tin (balzers)
适用于加工 Suitable for processing	小于5倍直径孔深的钢件类加工 less than 5 times the diameter of the hole depth of steel processing		



单位(Unit): mm

序号 No.	型号规格 Model Specification	刃径 (m7) Mill Diameter	槽长 Flute Length	总长 Total Length	柄径 (h6) Shank Diameter
1	SCDP-05 -D3.3~D3.7	3.3~3.7	28	58	4
2	SCDP-05- D3.8~D4.0	3.8~4.0	36	66	4
3	SCDP-05- D4.2~D4.6	4.2~4.6	36	74	6
4	SCDP-05- D4.9~D6.0	4.9~6.0	44	82	6
5	SCDP-05- D6.1~D8.0	6.1~8.0	53	91	8
6	SCDP-05- D8.1~D10	8.1~10	61	103	10
7	SCDP-05- D10.1~D12	10.1~12	71	118	12
8	SCDP-05- D12.1~D14	12.1~14	77	124	14
9	SCDP-05- D14.1~D16	14.1~16	83	133	16
10	SCDP-05- D16.1~D18	16.1~18	93	143	18
11	SCDP-05- D18.1~D20	18.1~20	101	153	20

整体硬质合金内冷定柄钻 SCDK-05

Solid carbide in sizing shank drill SCDK- 05

材料 Material	CB-CERATLZAT W200	涂层 Coating	AlTiN (balzers)
适用于加工 Suitable for processing	小于5倍直径孔深的铸件类加工 less than 5 times the diameter of the hole depth of casting processing		



单位(Unit): mm

序号 No.	型号规格 Model Specification	刃径 (m7) Mill Diameter	槽长 Flute Length	总长 Total Length	柄径 (h6) Shank Diameter
1	SCDK-05 -D3.3~D3.7	3.3~3.7	28	58	4
2	SCDK-05- D3.8~D4.0	3.8~4.0	36	66	4
3	SCDK-05- D4.2~D4.6	4.2~4.6	36	74	6
4	SCDK-05- D4.9~D6.0	4.9~6.0	44	82	6
5	SCDK-05- D6.1~D8.0	6.1~8.0	53	91	8
6	SCDK-05- D8.1~D10	8.1~10	61	103	10
7	SCDK-05- D10.1~D12	10.1~12	71	118	12
8	SCDK-05- D12.1~D14	12.1~14	77	124	14
9	SCDK-05- D14.1~D16	14.1~16	83	133	16
10	SCDK-05- D16.1~D18	16.1~18	93	143	18
11	SCDK-05- D18.1~D20	18.1~20	101	153	20

整体硬质合金定柄钻(切削参数)

ISO		P					M				
加工材料		低碳钢	易切削钢	结构钢、中碳钢	调质钢、普通低合金钢	普通工具钢、调质钢	难加工工具钢、高合金钢	易切削奥氏体不锈钢	中等加工难度的不锈钢	奥氏体与双相不锈钢	难加工的奥氏体不锈钢
硬度		~150HB	125~220HB	140~170HB	170~220HB	220~280HB	280~350HB	~180HB	180~200HB	200~240HB	≤250HB
切削速度Vc (m/min)		90~105	90~105	85~100	80~95	65~80	40~50	40~50	35~45	30~40	30~35
进给量 f mm/rev	D=3.3~5	0.030D	0.038D	0.038D	0.030D	0.023D	0.023D	0.018D	0.018D	0.015D	0.015D
	D=5~12.5	0.023D	0.030D	0.030D	0.023D	0.018D	0.018D	0.015D	0.015D	0.012D	0.012D
	D=12.5~20	0.018D	0.023D	0.023D	0.018D	0.015D	0.015D	0.012D	0.012D	0.010D	0.010D
ISO		K				N		S			
加工材料		灰铸铁	中等硬度铸铁、灰铸铁	可锻铸铁、球墨铸铁	可锻铸铁、球墨铸铁	含Si量<12的铝合金	含Si量>12的铝合金	有色金属、铜合金	镍基、钴基、铁基高温合金	镍基、钴基、铁基高温合金	钛合金
硬度		<200HB	<300HB	<240HB	<300HB	<130HB	<180HB	<180HB	<280HB	>280HB	250~300HB
切削速度Vc (m/min)		125~150	110~130	100~120	90~110	180~210	145~170	145~170	19~22	16~18	26~30
进给量 f mm/rev	D=3.3~5	0.045D	0.045D	0.035D	0.035D	0.050D	0.040D	0.035D	0.018D	0.018D	0.015D
	D=5~12.5	0.035D	0.035D	0.030D	0.030D	0.040D	0.035D	0.030D	0.015D	0.015D	0.012D
	D=12.5~20	0.030D	0.030D	0.020D	0.020D	0.035D	0.030D	0.023D	0.012D	0.012D	0.010D

整体硬质合金内冷定柄钻(切削参数)

ISO		P					M				
加工材料		低碳钢	易切削钢	结构钢、中碳钢	调质钢、普通低合金钢	普通工具钢、调质钢	难加工工具钢、高合金钢	易切削奥氏体不锈钢	中等加工难度的不锈钢	奥氏体与双相不锈钢	难加工的奥氏体不锈钢
硬度		~150HB	125~220HB	140~170HB	170~220HB	220~280HB	280~350HB	~180HB	180~200HB	200~240HB	≤250HB
切削速度Vc (m/min)		95~115	110~130	95~115	85~100	70~85	50~60	45~55	40~50	40~45	35~40
进给量 f mm/rev	D=3.3~5	0.030D	0.040D	0.035D	0.035D	0.022D	0.022D	0.022D	0.022D	0.022D	0.022D
	D=5~12.5	0.022D	0.035D	0.030D	0.030D	0.018D	0.018D	0.018D	0.018D	0.018D	0.018D
	D=12.5~20	0.018D	0.030D	0.022D	0.022D	0.015D	0.015D	0.015D	0.015D	0.015D	0.015D
ISO		K				N		S			
加工材料		灰铸铁	中等硬度铸铁、灰铸铁	可锻铸铁、球墨铸铁	可锻铸铁、球墨铸铁	含Si量<12的铝合金	含Si量>12的铝合金	有色金属、铜合金	镍基、钴基、铁基高温合金	镍基、钴基、铁基高温合金	钛合金
硬度		<200HB	<300HB	<240HB	<300HB	<130HB	<180HB	<180HB	<280HB	>280HB	250~300HB
切削速度Vc (m/min)		145~170	115~135	105~125	95~115	210~250	180~210	185~220	30~35	25~30	35~40
进给量 f mm/rev	D=3.3~5	0.050D	0.050D	0.050D	0.040D	0.050D	0.040D	0.035D	0.018D	0.018D	0.015D
	D=5~12.5	0.050D	0.040D	0.040D	0.035D	0.050D	0.035D	0.030D	0.015D	0.015D	0.012D
	D=12.5~20	0.035D	0.035D	0.035D	0.030D	0.035D	0.030D	0.022D	0.012D	0.012D	0.010D

二刃合金铣刀 G450-2M

2-flutes carbide end mills

螺旋角Helix	35°
齿数 NO.of cutting cdgcs	2
长度系列 series of lengths	M-标准系列 M-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在45HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 45HRC.



型号 Type	规格尺寸 Dimension					
	刃径 Drill Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G450-2M0150450	1.5	4	4	50	2	●
G450-2M0200450	2.0	4	5	50	2	●
G450-2M0250450	2.5	4	5	50	2	●
G450-2M0300450	3.0	4	8	50	2	●
G450-2M0400450	4.0	4	10	50	2	●
G450-2M0400650	4.0	6	10	50	2	●
G450-2M0500650	5.0	6	15	50	2	●
G450-2M0600650	6.0	6	15	50	2	●
G450-2M0700860	7.0	8	20	60	2	●
G450-2M0800860	8.0	8	20	60	2	●
G450-2M0901075	9.0	10	25	75	2	●
G450-2M1001075	10.0	10	25	75	2	●
G450-2M1101275	11.0	12	30	75	2	●
G450-2M1201275	12.0	12	30	75	2	●
G450-2M13014100	13.0	14	35	100	2	●
G450-2M14014100	14.0	14	35	100	2	●
G450-2M16016100	16.0	16	40	100	2	●
G450-2M18018100	18.0	18	45	100	2	●
G450-2M20020100	20.0	20	50	100	2	●

二刃合金铣刀 G450-2ML

2-flutes carbide end mills

螺旋角Helix	35°
齿数 NO.of cutting cdgcs	2
长度系列 series of lengths	ML-标准加长系列 ML-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在45HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 45HRC.



型号 Type	规格尺寸 Dimension					
	刃径 Drill Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G450-2L0600675	6.0	6	24	75	2	●
G450-2L06006100	6.0	6	24	100	2	●
G450-2L08008100	8.0	8	32	100	2	●
G450-2L10010150	10	10	40	150	2	●
G450-2L12012150	12	12	45	150	2	●
G450-2L14014150	14	14	45	150	2	●
G450-2L16016150	16	16	50	150	2	●
G450-2L18018150	18	18	50	150	2	●
G450-2L20020150	20	20	50	150	2	●

四刃合金立铣刀 G450-4M

4-fluted end mills with straight shank

螺旋角Helix	35°
齿数 NO.of cutting cdgcs	4
长度系列 series of lengths	M-标准系列 M-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在45HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 45HRC.

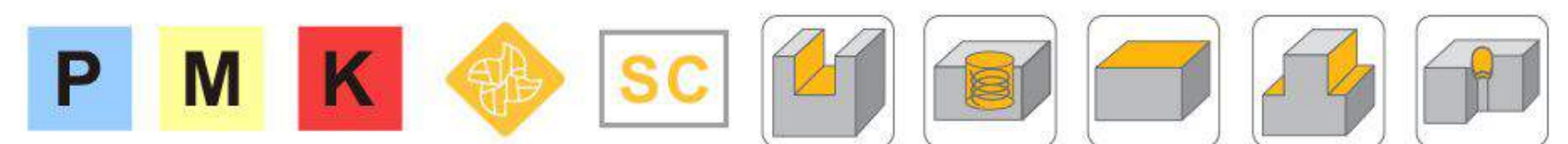


型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G450-4M0150450	1.5	4	4	50	4	●
G450-4M0200450	2.0	4	5	50	4	●
G450-4M0250450	2.5	4	6	50	4	●
G450-4M0300450	3.0	4	8	50	4	●
G450-4M0400450	4.0	4	10	50	4	●
G450-4M0400650	4.0	6	10	50	4	●
G450-4M0500650	5.0	6	13	50	4	●
G450-4M0600650	6.0	6	15	50	4	●
G450-4M0700860	7.0	8	20	60	4	●
G450-4M0800860	8.0	8	20	60	4	●
G450-4M0901075	9.0	10	25	75	4	●
G450-4M1001075	10	10	25	75	4	●
G450-4M1101275	11	12	25	75	4	●
G450-4M1201275	12	12	30	75	4	●
G450-4M13014100	13	14	35	100	4	●
G450-4M14014100	14	14	35	100	4	●
G450-4M16016100	16	16	40	100	4	●
G450-4M18018100	18	18	45	100	4	●
G450-4M20020100	20	20	50	100	4	●

四刃合金立铣刀 G450-4ML

4-fluted end mills with straight shank

螺旋角Helix	35°
齿数 NO.of cutting cdgcs	4
长度系列 series of lengths	ML-标准加长系列 ML-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在45HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 45HRC.



型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G450-4L0600675	6.0	6	24	75	4	●
G450-4L06006100	6.0	6	24	100	4	●
G450-4L08008100	8.0	8	32	100	4	●
G450-4L10010150	10	10	40	150	4	●
G450-4L12012150	12	12	45	150	4	●
G450-4L14014150	14	14	45	150	4	●
G450-4L16016150	16	16	50	150	4	●
G450-4L18018150	18	18	50	150	4	●
G450-4L20020150	20	20	50	150	4	●

二刃球头合金铣刀 G450-2MR

2-fluted end mills with straight shank

螺旋角Helix	35°
齿数 NO.of cutting cdgcs	2
长度系列 series of lengths	M-标准系列 ML-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在45HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 45HRC.

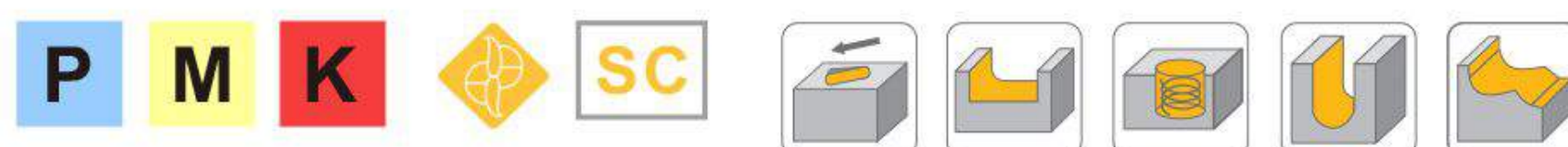


型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G450-2MR0100450	R1.0	4	5	50	2	●
G450-2MR0150450	R1.5	4	6	50	2	●
G450-2MR0200450	R2.0	4	8	50	2	●
G450-2MR0250650	R2.5	6	10	50	2	●
G450-2MR0300650	R3.0	6	12	50	2	●
G450-2MR0350860	R3.5	8	14	60	2	●
G450-2MR0400860	R4.0	8	16	60	2	●
G450-2MR0451075	R4.5	10	20	75	2	●
G450-2MR0501075	R5.0	10	20	75	2	●
G450-2MR0601275	R6.0	12	25	75	2	●
G450-2MR07014100	R7.0	14	25	100	2	●
G450-2MR08016100	R8.0	16	32	100	2	●
G450-2MR09018100	R9.0	18	35	100	2	●
G450-2MR10020100	R10	20	40	100	2	●

二刃球头合金铣刀 G450-2ML R

2-fluted end mills with straight shank

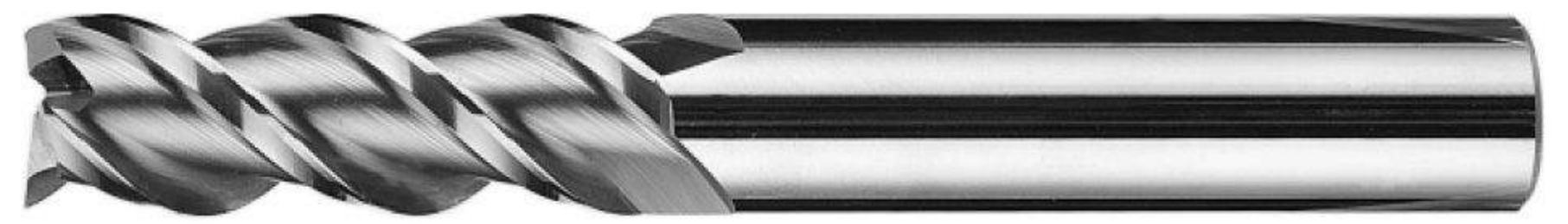
螺旋角Helix	35°
齿数 NO.of cutting cdgcs	2
长度系列 series of lengths	ML-标准加长系列 ML-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在45HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 45HRC.



型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G450-2LR0300675	R3.0	6	12	75	2	●
G450-2LR03006100	R3.0	6	12	100	2	●
G450-2LR04008100	R4.0	8	16	100	2	●
G450-2LR05010150	R5.0	10	20	150	2	●
G450-2LR06012150	R6.0	12	25	150	2	●
G450-2LR07014150	R7.0	14	30	150	2	●
G450-2LR08016150	R8.0	16	32	150	2	●
G450-2LR09018150	R9.0	18	35	150	2	●
G450-2LR10020150	R10	20	40	150	2	●

三刃铝用合金铣刀 L450-3M
3-fluted aluminum alloy milling cutter

齿数 NO.of cutting cdgcs	3
长度系列 series of lengths	M-标准系列 M-standard series
适应场合 Application	适用：铝及铝合金材质加工。 Application: aluminum and aluminum alloy material.



型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
L450-3M0150450	1.5	4	4	50	3	●
L450-3M0200450	2.0	4	10	50	3	●
L450-3M0250450	2.5	4	10	50	3	●
L450-3M0300450	3.0	4	10	50	3	●
L450-3M0400450	4.0	4	10	50	3	●
L450-3M0500650	5.0	6	15	50	3	●
L450-3M0600650	6.0	6	15	50	3	●
L450-3M0800860	8.0	8	20	60	3	●
L450-3M1001075	10	10	25	75	3	●
L450-3M1201275	12	12	30	75	3	●
L450-3M14014100	14	14	35	100	3	●
L450-3M16016100	16	16	40	100	3	●
L450-3M18018100	18	18	45	100	3	●
L450-3M20020100	20	20	50	100	3	●

整体硬质合金铣刀 G450 (切削参数)

铣刀	2刃铣刀G450 铣槽							3刃铣刀L450 铣槽			
ISO	P			M		K		N			
加工材料	低碳钢、易切钢	结构钢、碳钢、低合金钢、铁素体、马氏体不锈钢	工具钢、调质钢、高合金钢、马氏体不锈钢	易切削或中等加工难度的奥氏体钢、不锈钢	难加工的奥氏体钢、不锈钢	中等硬度铸铁、灰铸铁、低合金钢、球墨铸铁	难加工的高合金铸铁、球墨铸铁	含Si量>12的铝合金	有色金属、铜合金	石墨	软塑料
硬度	125~220HB	140~220HB	~45HRC	~45HRC	~45HRC	<300HB	<300HB	<180HB	<180HB		
切削速度 Vc m/min	60~85	45~65	40~58	40~55	30~40	45~60	25~35	75~100	125~170	105~140	105~140
进给量 fz mm/z	0.005D	0.005D	0.005D	0.005D	0.005D	0.005D	0.005D	0.014D	0.010D	0.009D	0.007D
切削深度 ap mm	0.50D	0.40D	0.30D	0.35D	0.20D	0.40D	0.20D	0.40D	0.50D	0.60D	0.50D
切削宽度 ae mm											

铣刀	4刃铣刀G450 精铣侧面							3刃铣刀L450 精铣侧面		
ISO	P			M		K		N		
加工材料	低碳钢、易切钢	结构钢、碳钢、低合金钢、铁素体、马氏体不锈钢	工具钢、调质钢、高合金钢、马氏体不锈钢	易切削或中等加工难度的奥氏体钢、不锈钢	难加工的奥氏体钢、不锈钢	中等硬度铸铁、灰铸铁、低合金钢、球墨铸铁	难加工的高合金铸铁、球墨铸铁	含Si量>12的铝合金	有色金属、铜合金	石墨
硬度	125~220HB	140~220HB	~45HRC	~45HRC	~45HRC	~45HRC	<300HB	<300HB	<180HB	<180HB
切削速度 Vc m/min	90~110	85~100	75~85	65~75	50~60	80~95	45~55	175~200	230~260	110~130
进给量 fz mm/z	0.008D	0.008D	0.008D	0.008D	0.008D	0.008D	0.008D	0.020D	0.015D	0.012D
切削深度 ap mm	1.00D	1.00D	1.00D	1.00D	1.00D	1.00D	1.00D	1.00D	1.00D	1.00D
切削宽度 ae mm	0.04D	0.03D	0.03D	0.03D	0.02D	0.03D	0.02D	0.03D	0.02D	0.10D

二刃合金铣刀 G550-2M

2-fluted end mills with straight shank

螺旋角Helix	35°
齿数 NO.of cutting cdgcs	2
长度系列 series of lengths	M-标准系列 M-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在55HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 55HRC.



型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G550-2M0150450	1.5	4	6	50	2	●
G550-2M0200450	2.0	4	6	50	2	●
G550-2M0250450	2.5	4	8	50	2	●
G550-2M0300450	3.0	4	8	50	2	●
G550-2M0400450	4.0	4	12	50	2	●
G550-2M0400650	4.0	6	12	50	2	●
G550-2M0500650	5.0	6	13	50	2	●
G550-2M0600650	6.0	6	15	50	2	●
G550-2M0700860	7.0	8	20	60	2	●
G550-2M0800860	8.0	8	20	60	2	●
G550-2M0901075	9.0	10	25	75	2	●
G550-2M1001075	10	10	25	75	2	●
G550-2M1101275	11	12	25	75	2	●
G550-2M1201275	12	12	25	75	2	●
G550-2M13014100	13	14	30	100	2	●
G550-2M14014100	14	14	35	100	2	●
G550-2M16016100	16	16	40	100	2	●
G550-2M18018100	18	18	45	100	2	●
G550-2M20020100	20	20	50	100	2	●

二刃合金铣刀 G550-2ML

2-fluted end mills with straight shank

螺旋角Helix	35°
齿数 NO.of cutting cdgcs	2
长度系列 series of lengths	ML-标准加长系列 ML-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在55HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 55HRC.

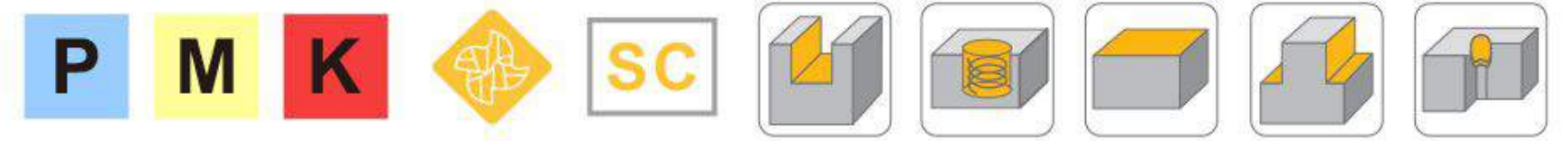


型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G550-2L0600675	6.0	6	24	75	2	●
G550-2L06006100	6.0	6	24	100	2	●
G550-2L08008100	8.0	8	30	100	2	●
G550-2L10010150	10	10	35	150	2	●
G550-2L12012150	12	12	40	150	2	●
G550-2L14014150	14	14	45	150	2	●
G550-2L16016150	16	16	50	150	2	●
G550-2L18018150	18	18	50	150	2	●
G550-2L20020150	20	20	50	150	2	●

四刃合金立铣刀 G550-4M

4-fluted end mills with straight shank

螺旋角Helix	35°
齿数 NO.of cutting cdgcs	4
长度系列 series of lengths	M-标准系列 M-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在55HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 55HRC.



型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G550-4M0150450	1.5	4	6	50	4	●
G550-4M0200450	2.0	4	6	50	4	●
G550-4M0250450	2.5	4	6	50	4	●
G550-4M0300450	3.0	4	8	50	4	●
G550-4M0400450	4.0	4	12	50	4	●
G550-4M0400650	4.0	6	12	50	4	●
G550-4M0500650	5.0	6	13	50	4	●
G550-4M0600650	6.0	6	15	50	4	●
G550-4M0700860	7.0	8	20	50	4	●
G550-4M0800860	8.0	8	20	60	4	●
G550-4M0901075	9.0	10	25	75	4	●
G550-4M1001075	10	10	25	75	4	●
G550-4M1101275	11	12	25	75	4	●
G550-4M1201275	12	12	25	75	4	●
G550-4M13014100	13	14	30	100	4	●
G550-4M14014100	14	14	35	100	4	●
G550-4M16016100	16	16	40	100	4	●
G550-4M18018100	18	18	45	100	4	●
G550-4M20020100	20	20	45	100	4	●

四刃合金铣刀 G550-4ML

4-fluted end mills with straight shank

螺旋角Helix	35°
齿数 NO.of cutting cdgcs	4
长度系列 series of lengths	ML-标准加长系列 ML-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在55HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 55HRC.



型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G550-4L06006075	6.0	6	24	75	4	●
G550-4L06006100	6.0	6	24	100	4	●
G550-4L08008100	8.0	8	30	100	4	●
G550-4L10010150	10	10	35	150	4	●
G550-4L12012150	12	12	45	150	4	●
G550-4L14014150	14	14	45	150	4	●
G550-4L16016150	16	16	50	150	4	●
G550-4L18018150	18	18	50	150	4	●
G550-4L20020150	20	20	50	150	4	●

二刃球头合金铣刀 G550-2MR

2-fluted end mills with straight shank

螺旋角Helix	35°
齿数 NO.of cutting cdgcs	2
长度系列 series of lengths	M-标准系列 M-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在55HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 55HRC.



型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G550-2MR0100450	R1.0	4	6	50	2	●
G550-2MR0150450	R1.5	4	8	50	2	●
G550-2MR0200450	R2.0	4	12	50	2	●
G550-2MR0250650	R2.5	6	13	50	2	●
G550-2MR0300650	R3.0	6	15	50	2	●
G550-2MR0350860	R3.5	8	20	60	2	●
G550-2MR0400860	R4.0	8	20	60	2	●
G550-2MR0451075	R4.5	10	25	75	2	●
G550-2MR0501075	R5.0	10	25	75	2	●
G550-2MR0601275	R6.0	12	25	75	2	●
G550-2MR07014100	R7.0	14	28	100	2	●
G550-2MR08016100	R8.0	16	32	100	2	●
G550-2MR09018100	R9.0	18	35	100	2	●
G550-2MR10020100	R10.0	20	40	100	2	●

二刃球头合金铣刀 G550-2MLR

2-fluted end mills with straight shank

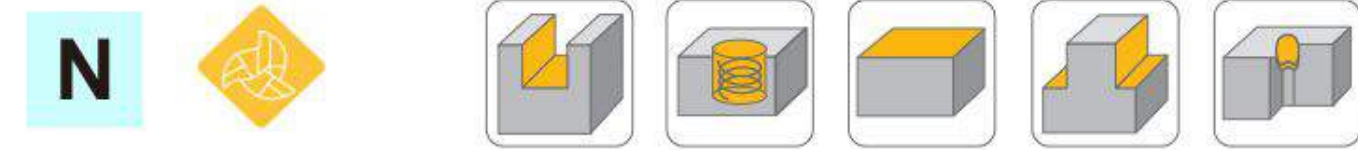
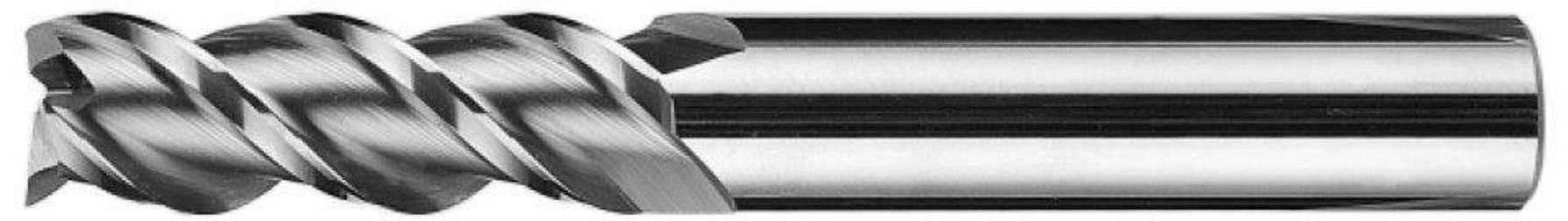
螺旋角Helix	35°
齿数 NO.of cutting cdgcs	2
长度系列 series of lengths	ML-标准加长系列 M-standard series
适应场合 Application	主要加工：碳钢，工具钢，合金钢，不锈钢；适应硬度在55HRC以内。 Main processing: carbon steel, tool steel, alloy steel, stainless steel; adapt to the hardness within 55HRC.



型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
G550-2LR0300675	R3.0	6	13	75	2	●
G550-2LR03006100	R3.0	6	15	100	2	●
G550-2LR04008100	R4.0	8	15	100	2	●
G550-2LR05010150	R5.0	10	25	150	2	●
G550-2LR06012150	R6.0	12	25	150	2	●
G550-2LR07014150	R7.0	14	30	150	2	●
G550-2LR08016150	R8.0	16	32	150	2	●
G550-2LR09018150	R9.0	18	35	150	2	●
G550-2LR10020150	R10.0	20	40	150	2	●

三刃铝用合金铣刀 L550-3M
3-fluted aluminum alloy milling cutter

螺旋角Helix	45°
齿数 NO.of cutting cdgcs	3
长度系列 series of lengths	M-标准系列 M-standard series
适应场合 Application	适用：铝及铝合金材质加工。 Application: aluminum and aluminum alloy material.



型号 Type	规格尺寸 Dimension					
	刃径 Blade Diameter	柄径 Shank Diameter	刃长 Flute length	全长 Overall Length	齿数 NO.of cutting cdgcs	库存 Stock
L550-3M0150450	1.5	4	4	50	3	●
L550-3M0200450	2.0	4	10	50	3	●
L550-3M0250450	2.5	4	10	50	3	●
L550-3M0300450	3.0	4	10	50	3	●
L550-3M0400450	4.0	4	10	50	3	●
L550-3M0500650	5.0	6	15	50	3	●
L550-3M0600650	6.0	6	15	50	3	●
L550-3M0800860	8.0	8	20	60	3	●
L550-3M1001075	10	10	25	75	3	●
L550-3M1201275	12	12	30	75	3	●
L550-3M14014100	14	14	35	100	3	●
L550-3M16016100	16	16	40	100	3	●
L550-3M18018100	18	18	45	100	3	●
L550-3M20020100	20	20	50	100	3	●

整体硬质合金铣刀 G550 (切削参数)

铣刀	2刃铣刀G550铣槽							3刃铣刀L550 铣槽		2刃铣刀G550 铣槽
	P			M		K		N		H
加工材料	低碳钢、 易切钢	结构钢、 碳钢、低 合金钢、 铁素体、 马氏体 不锈钢	工具钢、 调质钢、 高合金钢、 马氏体不 锈钢	易切削或 中等加工 难度的奥 氏体钢、 不锈钢	难加工的 奥氏体钢、 不锈钢	中等硬度 铸铁、灰 铸铁、低 合金钢、 球墨铸铁	难加工的 高合金铸 铁、球墨 铸铁	含Si量> 12的铝合 金	有色金属、 铜合金	淬硬钢
硬度	125~ 220HB	140~ 220HB	~45HRC	~45HRC	~45HRC	<300HB	<300HB	<180HB	<180HB	48~55HRC
切削速度 Vc m/min	60~90	55~75	45~60	45~65	30~40	45~65	30~40	80~110	165~220	30~45
进给量 fz mm/z	0.006D	0.006D	0.004D	0.004D	0.004D	0.006D	0.006D	0.015D	0.015D	0.002D
切削深度 ap mm	0.50D	0.40D	0.30D	0.35D	0.20D	0.40D	0.20D	0.40D	0.50D	0.05D
切削宽度 ae mm										

铣刀	4刃铣刀G550铣槽							3刃铣刀L550 铣槽		4刃铣刀G550 铣槽
	P			M		K		N		H
加工材料	低碳钢、 易切钢	结构钢、 碳钢、低 合金钢、 铁素体、 马氏体 不锈钢	工具钢、 调质钢、 高合金钢、 马氏体不 锈钢	易切削或 中等加工 难度的奥 氏体钢、 不锈钢	难加工的 奥氏体钢、 不锈钢	中等硬度 铸铁、灰 铸铁、低 合金钢、 球墨铸铁	难加工的 高合金铸 铁、球墨 铸铁	含Si量> 12的铝合 金	有色金属、 铜合金	淬硬钢
硬度	125~ 220HB	140~ 220HB	~45HRC	~45HRC	~45HRC	<300HB	<300HB	<180HB	<180HB	48~55HRC
切削速度 Vc m/min	100~115	100~115	80~95	75~85	50~60	90~100	50~60	220~250	320~360	130~150
进给量 fz mm/z	0.009D	0.009D	0.006D	0.007D	0.006D	0.008D	0.008D	0.020D	0.015D	0.005D
切削深度 ap mm	1.00D	1.00D	1.00D	1.00D	1.00D	1.00D	1.00D	1.00D	1.00D	1.00D
切削宽度 ae mm	0.04D	0.03D	0.03D	0.03D	0.02D	0.03D	0.02D	0.03D	0.02D	0.02D

G-PO 先端丝锥

G-PO tip tap

适用于 Scope of application	适用于加工通孔 Suitable for processing through-hole
适用于加工 Suitable for processing	碳钢合金钢，中低碳钢 carbon steel alloy steel, low carbon steel



- 标准在库 Standard in the library
- 咨询营业部 Consulting business department

产品编号 Products NO.	规格 Specification	精度 Precision	库存 Stock
Gp20102040	M2X0.4	6H	●
GP20125450	M2.5X0.45	6H	○
GP20103050	M3X0.5	6H	●
GP20104070	M4X0.7	6H	●
GP20105080	M5X0.8	6H	●
GP20106100	M6X1	6H	●
GP20108125	M8X1.25	6H	●
GP20108100	M8X1	6H	○
GP20110150	M10X1.5	6H	●
GP20110125	M10X1.25	6H	○
GP20110100	M10X1	6H	○
GP20112175	M12X1.75	6H	●
GP20112150	M12X1.5	6H	○
Gp20112125	M12X1.25	6H	○

G-H-PO 先端丝锥 (氧化处理)

G-H-PO tip tap(oxidation)

适用于 Scope of application	适用于加工通孔 Suitable for processing through-hole
适用于加工 Suitable for processing	碳钢合金钢，中低碳钢 carbon steel alloy steel, low carbon steel



- 标准在库 Standard in the library
- 咨询营业部 Consulting business department

产品编号 Products NO.	规格 Specification	精度 Precision	库存 Stock
GPH20102040	M2X0.4	6H	●
GPH20125450	M2.5X0.45	6H	○
GPH20103050	M3X0.5	6H	●
GPH20104070	M4X0.7	6H	●
GPH20105080	M5X0.8	6H	●
GPH20106100	M6X1	6H	●
GPH20108125	M8X1.25	6H	●
GPH20108100	M8X1	6H	○
GPH20110150	M10X1.5	6H	●
GPH20110125	M10X1.25	6H	○
GPH20110100	M10X1	6H	○
GPH20112175	M12X1.75	6H	●
GPH20112150	M12X1.5	6H	○
GPH20112125	M12X1.25	6H	○

高速钢先端丝锥切削速度 (m/min)

被加工材料 work materials	低碳素钢	中碳素钢	高碳素钢	合金钢	调质钢	模具钢	铸钢	铸铁	强韧铸铁
代号	Ss400 S10C~S25C	S25C~S45C	S45C~S58C	SCM、SNCM	20~50HRC	SKD	SC	FC	FCD
切削速度	10~20	8~14	8~12	7~10	4~7	6~10	8~13	10~18	5~10

G-SP 螺旋丝锥

G-P screw tap

适用于 Scope of application	适用于加工盲孔 Applicable to processing of blind
适用于加工 Suitable for processing	碳钢合金钢，中低碳钢 carbon steel alloy steel, low carbon steel



- 标准在库 Standard in the library
- 咨询营业部 Consulting business department

产品编号 Products NO.	规格 Specification	精度 Precision	库存 Stock
Gs20202040	M2X0.4	6H	●
GS20225450	M2.5X0.45	6H	○
GS20203050	M3X0.5	6H	●
GS20204070	M4X0.7	6H	●
GS20205080	M5X0.8	6H	●
GS20206100	M6X1	6H	●
GS20208125	M8X1.25	6H	●
GS20208100	M8X1	6H	○
GS20210150	M10X1.5	6H	●
GS20210125	M10X1.25	6H	○
GS20210100	M10X1	6H	○
GS20212175	M12X1.75	6H	●
GS20212150	M12X1.5	6H	○
GS20212125	M12X1.25	6H	○

G-H-SP 螺旋丝锥 (氧化处理)

G-H-SP spiral tap (oxidation)

适用于 Scope of application	适用于加工盲孔 Applicable to processing of blind
适用于加工 Suitable for processing	碳钢合金钢，中低碳钢 carbon steel alloy steel, low carbon steel



- 标准在库 Standard in the library
- 咨询营业部 Consulting business department

产品编号 Products NO.	规格 Specification	精度 Precision	库存 Stock
GSH20202040	M2X0.4	6H	●
GSH20225450	M2.5X0.45	6H	○
GSH20203050	M3X0.5	6H	●
GSH20204070	M4X0.7	6H	●
GSH20205080	M5X0.8	6H	●
GSH20206100	M6X1	6H	●
GSH20208125	M8X1.25	6H	●
GSH20208100	M8X1	6H	○
GSH20210150	M10X1.5	6H	●
GSH20210125	M10X1.25	6H	○
GSH20210100	M10X1	6H	○
GSH20212175	M12X1.75	6H	●
GSH20212150	M12X1.5	6H	○
GSH20212125	M12X1.25	6H	○

高速钢螺旋丝锥切削速度 (m/min)

被加工材料 work materials	低碳素钢	中碳素钢	高碳素钢	合金钢	调质钢	模具钢	铸钢	铸铁	强韧铸铁
代号	Ss400 S10C~S25C	S25C~S45C	S45C~S58C	SCM、SNCM	20~50HRC	SKD	SC	FC	FCD
切削速度	8~15	6~12	5~10	5~10	3~5	5~8	6~10	9~16	5~10



海纳精密切削科技股份有限公司

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