

设计理念：应用为大

Design Concept: Application comes first

从应用出发，注重用户体验，提高用户生产效率，坚持原创设计，为客户量身订制解决方案及提供整包加工方案。

Starting from application, pay great attention to user experience, focus on improving productivity, persist in originality, design appropriate product for users, provide customized and comprehensive cutting solution for customers.

品质定位：高品质和稳定性

Quality Orientation: High quality

精益求精，制造性能及质量稳定性上媲美欧美日韩的产品，为客户取得更大的经济效益。

Perfecting constantly, provide product with performance and stability comparable to the standard of Europe, America, Japan or South Korea for customers.

制造精神：精品

Manufacturing Spirit: Boutique

坚持工匠精神，精雕细琢，采用现代化管理手段，注重产品的每一个细节，保证每件作品质量及稳定性。

Persist in craftsman spirit, work with meticulousness and precision, pay great attention on details, adopt modern methods of management to guarantee the quality of each product.

销售策略：互利互惠

Sales Strategy: Mutual benefit

互利互惠，提高用户生产效率，降低生产成本，帮助用户提高市场竞争力和产品质量，为经销商提供富有竞争力的产品，取代进口产品。

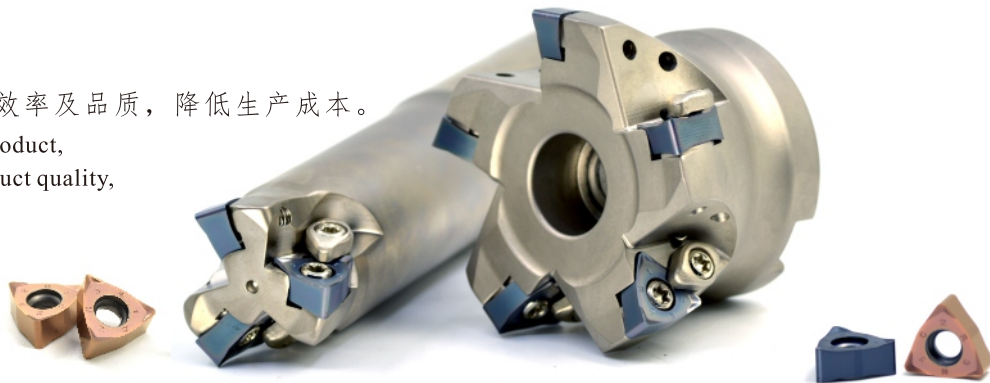
Based on mutual benefit, minimize production cost and improve productivity, help user improve product quality and competitiveness.

服务原则：技术服务

Service Principle: Technical service

走技术服务路线，提供完整刀具方案及加工参数，提高效率及品质，降低生产成本。

Persist in technology-as-a-service, help customer select appropriate product, provide cutting solution and parameters, improve productivity and product quality, and lower production cost.

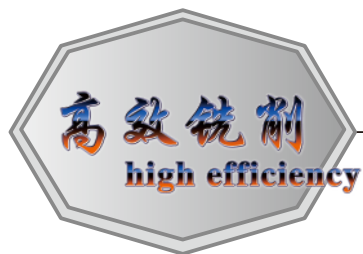


高效铣削
high efficiency



快进给铣削 SD 系列
High feed milling SD Series

大切深 ON 系列
Large Cutting Depths ON Series



重型加工设备

heavy type CNC equipment

特点：大切深 $Ap \geq 2.5\text{mm}$ $f \leq 0.5\text{mm/t}$



SNHT13T6



PNHU0905



HNGX0906



XNHU0605
XNMU0805



ONM(H)0504



ONM(H)0605



ONMU0905



LNMU1104



WNM(H)U0606



XNM(H)X0806

中轻型加工设备

Medium light CNC equipment

特点：小切深 $Ap \leq 1.5\text{mm}$ $f = 0.5-2.0\text{mm/t}$



EDHT0402



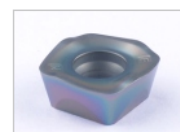
EPMT0603



LNMU0303

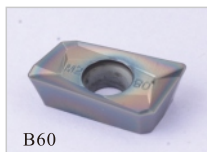


SDKT0935

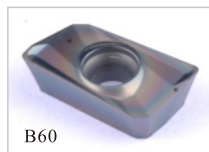


SDHT1205
SDMT1205

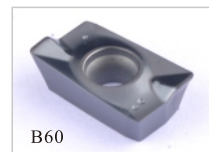
方肩铣刀片
Shoulder
milling insert



APMT1135PDER-M2
APMT1604PDER-M2



APMT1135PDER-H2
APMT1604PDER-H2



APMT1135PDTR
APMT1605PDTR

快进给
铣刀片
High feed
milling



EDHT0402ER-CM
刀杆及锁牙头直径8-16mm

锋利
切削阻力小



EPMT0603ER-CM
刀杆及锁牙头直径16-35mm
刀盘直径40-63mm

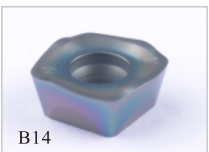
较强壮
抗冲击力强



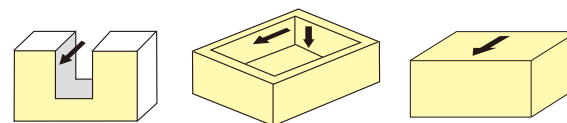
2X2
LNMU0303双面
刀杆及锁牙头直径16-35mm
刀盘直径40-80mm



SDKT093508-CM
刀杆及锁牙头直径25-35mm
刀盘直径40-80mm



SDHT120520-FN锋利
SDHT120520-SN强壮
SDMT120520-SN强壮
刀杆及锁牙头直径35mm
刀盘直径40-80mm



方肩及平面铣削 Shoulder milling & face milling Selection Guide

双面
铣刀片
Double face
milling insert



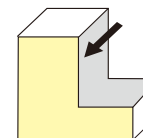
LNMU1104SRGE
刀杆及锁牙头直径16-35mm
刀盘直径40-80mm



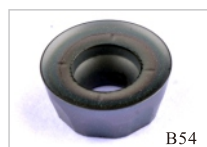
WNHU060610-FN
WNMU060610-SN
刀杆及锁牙头直径32-40mm
刀盘直径50-160mm



XNMX080608TR-CM
XNHX080608TR-CM
刀盘直径50-160mm



R型 圆刀片 Round milling



RPMTXXXX-GH

不锈钢, 高温合金
钛合金, 软钢

锋利
切削阻力小



RPMTXXXX-JS

低碳钢, 不锈钢
HRC50-58加硬淬火钢

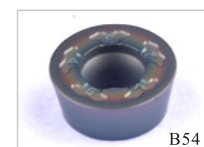
锋利
切削阻力小



RPMTXXXX-ST

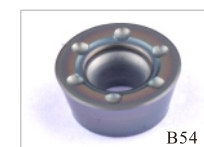
低碳钢,
HRC50-58加硬淬火钢

锋利
切削阻力小



RPMTXXXX-ST14

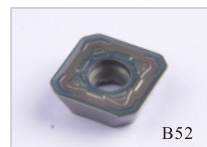
模具钢, 铸钢, 锻钢
HRC<50模具钢, 铸铁



RDMTXXXX-ST14

模具钢, 铸钢, 锻钢
HRC<50模具钢

SEK(H)T 平面铣刀片 Face milling



SEET12T3-CM

不锈钢, 高温合金
钛合金, 模具钢

较强壮
切削阻力相对较小



SEKT1204PDER-11

不锈钢, 高温合金
钛合金, 模具钢

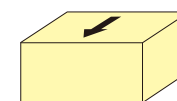
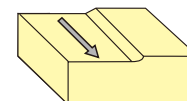
锋利(适合精加工)
切削阻力小



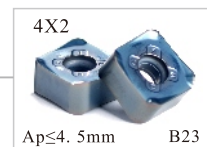
SEHT1204AFFN

铝合金及有色金属
塑胶, 尼龙

较锋利
切削阻力较小



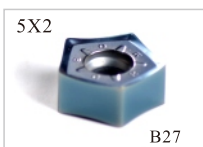
平面铣削 Face milling Selection Guide



SNHT13T6ANER-CM

钢及铸铁

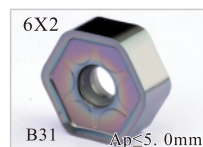
刃口强壮



PNHU0905GNER-X

不锈钢, 高温合金
钛合金, 模具钢精加工

较锋利
切削阻力较小



HNGX0906 ANT

HNGX0906 ANSN
不锈钢, 高温合金
模具钢, 铸钢, 锻钢, 铸铁



XNHU0605 ANR

XN06:Ap≤3.5mm
XN08:Ap≤4.5mm B35
XNMU0605 SNR
XNMU0805 ANR
XNHU0805 ANR

不锈钢, 高温合金
钛合金, 模具钢



ONHU0504 ANR

ONMU0504 SNR
不锈钢, 高温合金
模具钢, 铸钢, 锻钢, 铸铁

Ap≤2.5mm

B50

P3204精加工球头刀片

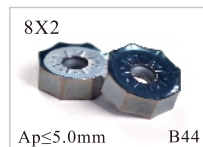
大切深 双面铣刀片 Large Cutting Depth Double face milling insert



ONHU0605 ANT

ONMU0605 ANSN

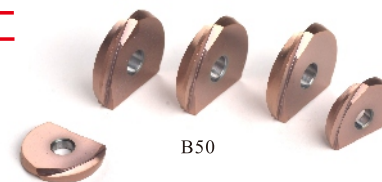
不锈钢, 高温合金
模具钢, 铸钢, 锻钢, 铸铁



ONMU 0905ANSN- M

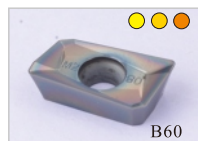
不锈钢, 高温合金
模具钢, 铸钢, 锻钢, 铸铁

仿形曲面加工 Copy milling



1. 不锈钢, 高温合金, 钛合金, 低碳钢材料:

Stainless steel, high temperature alloy, titanium alloy, low carbon steel material processing



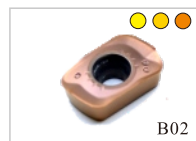
B60

APMT1135PDER-M2
APMT1604PDER-M2



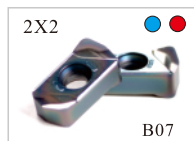
B01

EDHT0402ER-CM



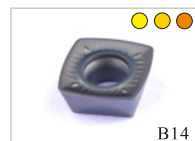
B02

EPMT0603ER-CM



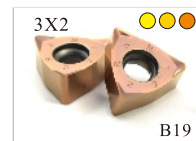
B07

LNMU0303双面



B14

SDKT093508-CM



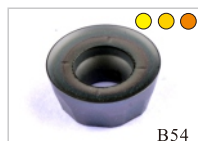
B19

WNHU060610-FN



B11

LNMU1104SRGE



B54

RPMTXXXX-GH



B54

RPMTXXXX-JS



B52

SEET12T3-CM



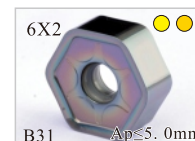
B52

SEKT1204PDER-11



B27

PNHU0905GNER-X
精加工专用槽型



B31

HNGX0906 ANTN



B35

XN06:Ap≤3.5mm
XN08:Ap≤4.5mm
XNHU0605 ANR
XNMU0805 ANR



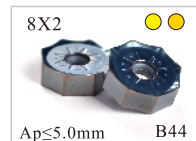
B38

ONHU0504 ANR



B41

ONMU0605 ANTN



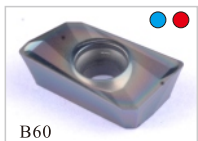
B44

ONMU 0905ANSN-M



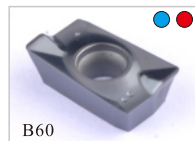
2. 模具钢, 锻钢, 铸钢, 铸铁材料:

Die steel, forged steel, cast steel, cast iron material processing



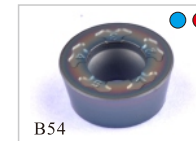
B60

APMT1135PDER-H2
APMT1604PDER-H2



B60

APMT1135PDTR
APMT1605PDTR



B54

RPMTXXXX-ST14
RDMTXXXX-ST14



B11

LNMU1104SRGE



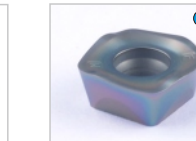
B07

LNMU0303双面



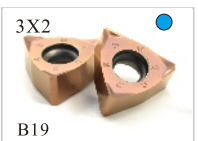
B14

SDKT093508-CM



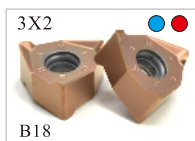
B14

SDHT120520-SN强壮
SDMT120520-SN强壮



B19

WNMU060610-SN



B18

XNMX080608TR-CM



B23

SNHT13T6ANER-CM



B31

HNGX0906 ANSN



B38

ONMU0504 SNR



B41

ONMU0605 ANTN



B44

ONMU 0905ANSN-M

铁削材质选用表 Material selection table for milling

涂层性质 Coating	涂层牌号 Coating grade	刀片颜色 Colour	材质 特性	加工 特性	冷却 	用途 Purpose
PVD涂层 物理涂层 PVD Coating NEW	CP2630T CP2440T CP2645T					通用性极强，高温合金，钛合金 ，不锈钢及钢件强断续加工。 trong intermittent turning of Stainless steel, High temperature alloy, Titanium alloy Steel machining,
	CP2430					钢件、不锈钢、高温合金、钛合金加工,适合 干式或风冷 切削。 Steel, Stainless steel, High temperature alloy, Titanium alloy machining, Suitable for dry cutting and air cooling.
	CP1120H CPA1140GH					精加工 首选,不锈钢、高温合金、钛合金及HRC40-63淬火钢加工。 Finishing first. Stainless steel, High temperature alloy, Titanium alloy and HRC40-63 Hardened Steel processing,
	CPA2130K CPA2140K CPA2145K					高温合金 、不锈钢、双向不锈钢、钢件及铸铁加工专用。 High temperature alloy, Bidirectional stainless steel Cast iron and steel parts are processed,
	NEW CP6120 CW20					有色金属，铝合金 加工。 Nonferrous Metals, Aluminum alloy processing.
CVD Coating	CC1030 CC1130					灰口铸铁 加工专用。 Cast iron parts are processed,

○：连续加工 Continuous processing ◐：不规则形状加工 Irregular processing ⚙️：断续加工 Intermittent processing

切削参数

Cutting parameters

常用计算公式 Commonly used formula

转速 S
Speed $S = \frac{Vc \times 1000}{3.14 \times Dc}$ (rev/min)

切削速度(线速度) Vc
Linear velocity $Vc = \frac{S \times 3.14 \times Dc}{1000}$ (m/min)

Dc:工件直径 (Workpiece diameter)

每分钟切削长度 F
Cutting length per minute $F = f \times S \times T$ (mm/min)

每齿进给量 f
(Feed per tooth) $f = \frac{F}{S \times T}$ (mm/tooth)

f:每齿进给量 (Feed per tooth) T: 刀具齿数 (Number of setting teeth)

切削加工小常识

1. 最小切削深度应该尽量大于刀尖圆角。
2. 最高的进给量应该小于刀尖圆角的一半.
3. PVD物理涂层适合难加工材料(软钢，不锈钢，高温合金等)、细长轴、薄壁件、机床刚性差的精加工、半精加工，Vc<180m/min, CVD化学涂层适合半精加工至粗加工,高速加工150<Vc<400m/min;

Machine work common sense

1. The minimum cutting depth should be greater than the re.
2. The highest feeding should be far less than the re.
3. PVD coating for difficult-to-machine materials and finishing, semi-finishing , Vc<180m/min; CVD coating is suitable for semi-finishing to rough machining, high speed cutting 150<Vc<400m/min;

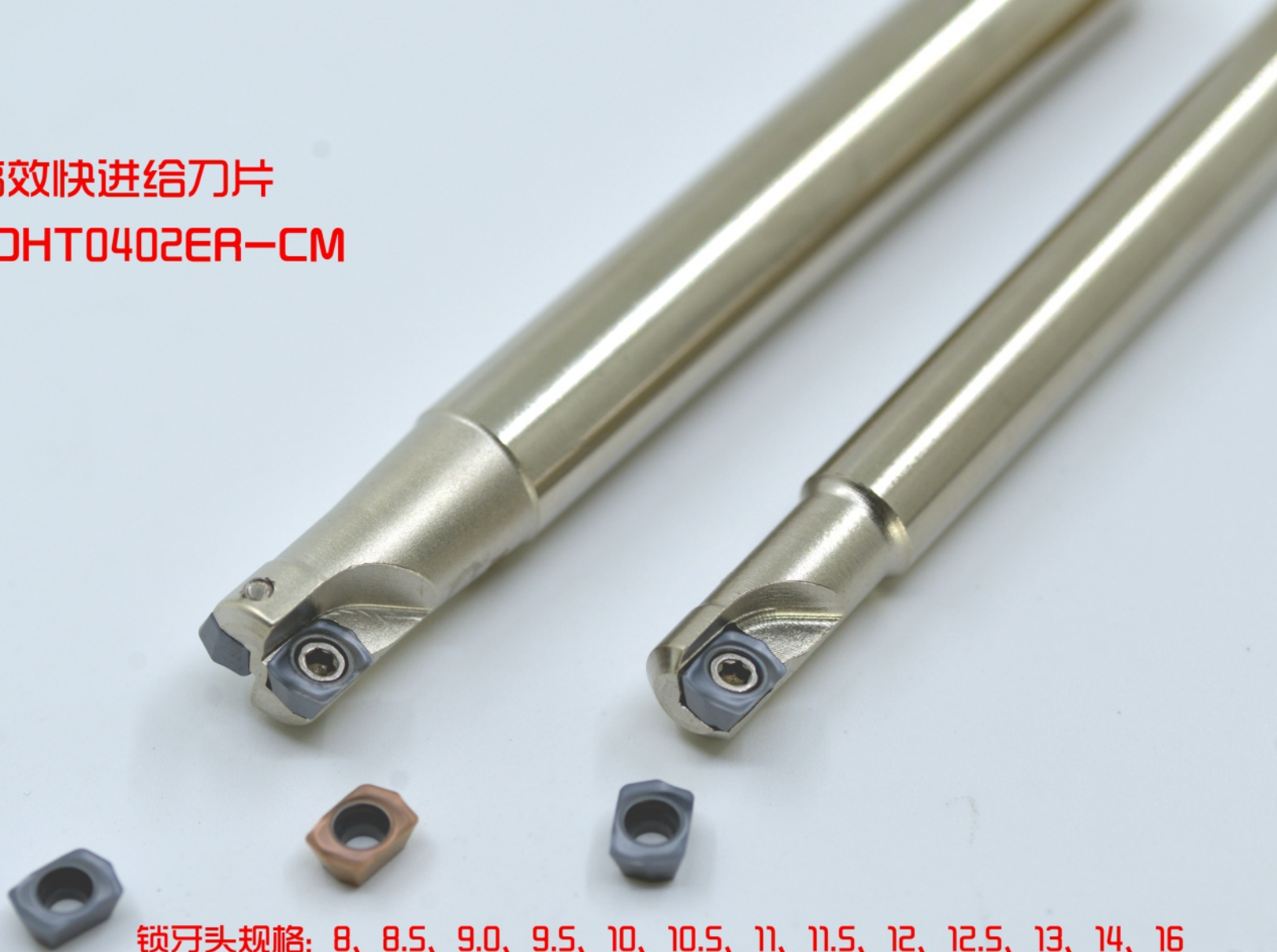
工欲善其事 必先利其器

Make good work first sharpen tools

表面粗糙度 Surface roughness

表面粗糙度 Ra um	刀尖圆角 re (mm)						
	0.1	0.2	0.4	0.8	1.2	1.6	2.4
	进给量 f (mm/rev)						
0.8	0.04	0.06	0.08	0.12	0.14	0.17	0.21
1.6	0.06	0.10	0.14	0.20	0.24	0.28	0.34
3.2		0.14	0.20	0.28	0.34	0.39	0.48
6.3			0.27	0.39	0.48	0.56	0.68
8.0				0.44	0.54	0.63	0.77

高效快进给刀片
EDHT0402ER-CM



锁牙头规格: 8、8.5、9.0、9.5、10、10.5、11、11.5、12、12.5、13、14、16

高效快进给刀片:

EPMT0603EA-CM



刀杆

16-35mm

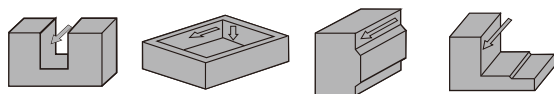
刀盘

50,63mm

EDHT
EPMT

快进给铣削刀片

EDHT
EPMT High feed milling insert



槽加工

开框加工

方肩铣

1. 相对市场传统EP及ED刀片来说，CM槽型的切削阻力小，锋利，特别适合加工高温合金，不锈钢，钛合金和软钢。
2. 适合机床功率相对来说比较小的条件。
3. CP2430适合干式切削或者风冷。



与众不同 自主研发

特点：

刃口锋利，耐磨性好，稳定性高，加工效率极高；
性能超越进口同类顶级产品。

被加工对象：

不锈钢，高温合金，低碳钢加工。

Feature:

Sharp edged, perfect abrasive resistance, high stability and efficiency.

Performance exceed famous brand.

Application:

Stainless steel, Heat resisting alloy, low-carbon steel .

		PVD							
		CP2630T	CP2430	CP1120H	加工参数 parameters				
					Vc (mm/min)				
工件 材质	P	钢件加工 Steel	✱	✱		120-160-250			
	P	模具钢 P20,718,SKD11,S136H	✱	✱		100-130-160			
	P	淬火钢加工 HRC40-63 Steel	✱		✱	50-80-120			
	M	不锈钢 Stainless steel	✱	✱	✱	60-110-150			
	K	铸铁 Cast iron		✱	✱	150-180-220			
	S	钛合金 Titanium alloy	✱	✱		40-60-80			
	S	耐热合金 Heat-resisting steel	✱	✱	✱	40-70-100			
型号 规格		用途			Ap(mm)	f (mm/t)			
EDHT0402ER-CM		不锈钢 钛合金			✱	✱	✱	0.15-0.4	0.2-0.5
EPMT0603ER-CM		高温合金 模具钢						0.3-0.8	0.5-1.0

EDHT0402ER-CM编程R角为R=1.5mm；EPMT0603ER-CM编程R角为R=2.0mm
CP2430适合于干式或风冷切削。 CP2430 Suitable For Dry Or Air-cooled Cutting

EDHT
EPMT

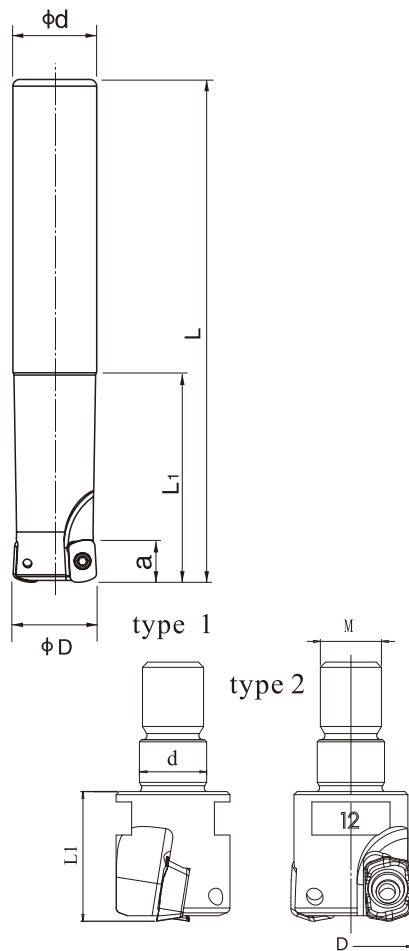
快进给铣削刀片
切削加工参数



工件材料	材料硬度	材质选择	线速度Vc m/min	每齿进给量 fz mm/t / Ap mm	
				EDHT0402	EPMT0603
碳钢 S45C, S50C	~220HB	CP2630T CP2430	100~250	fz=0.15-0.4 Ap=0.2-0.5	fz=0.5-1.0 Ap=0.3-0.8
合金钢 20CrMoTi, 42CrMo	~200HB	CP2630T CP2430	100~200	fz=0.15-0.4 Ap=0.2-0.5	fz=0.5-1.0 Ap=0.3-0.8
五金模具钢 SKD61 (H13), SKD11	350HB	CP2630T CP1120H	100~150	fz=0.15-0.35 Ap=0.2-0.4	fz=0.5-1.2 Ap=0.5-0.7
模具钢 P20, 718, 738	HRC28-32	CP2630T CP2430	100~180	fz=0.15-0.35 Ap=0.2-0.4	fz=0.5-1.0 Ap=0.5-0.7
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2630T CP2430	100~150	fz=0.1-0.3 Ap=0.2-0.4	fz=0.4-0.8 Ap=0.4-0.6
淬火钢 SKD61 (H13)	HRC40-52	CP2630T CP1120H	80~120	fz=0.15-0.35 Ap=0.2-0.4	fz=0.5-1.2 Ap=0.5-0.7
淬火钢 SKD11 (Cr12MoV)	HRC55-62	CP1120H	50~80	fz=0.05-0.1 Ap=0.05-0.15	fz=0.05-0.1 Ap=0.05-0.15
不锈钢 304, 316	200HB	CP2630T CP2430 CP1120H	100~150	fz=0.2-0.5 Ap=0.2-0.4	fz=0.4-0.7 Ap=0.5-0.8
镍基高温合金 718	HRC38-45	CP2630T CP2430 CP1120H	60~120	fz=0.1-0.3 Ap=0.2-0.35	fz=0.2-0.5 Ap=0.2-0.5
钛合金 Ti-6Al-4V (Tc4)	HRC40	CP2630T CP2430	30~80	fz=0.3-0.6 Ap=0.2-0.4	fz=0.3-0.8 Ap=0.3-0.7
灰口铸铁 FC250, HT250	~200HB	CP1120H CP2430	100~220	fz=0.3-0.6 Ap=0.2-0.4	fz=0.5-1.0 Ap=0.3-0.7
球墨铸铁 FCD400, QT300, 400, 500, 600	~200HB	CP1120H CP2430	100~200	fz=0.3-0.6 Ap=0.2-0.4	fz=0.5-1.0 Ap=0.3-0.7

CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

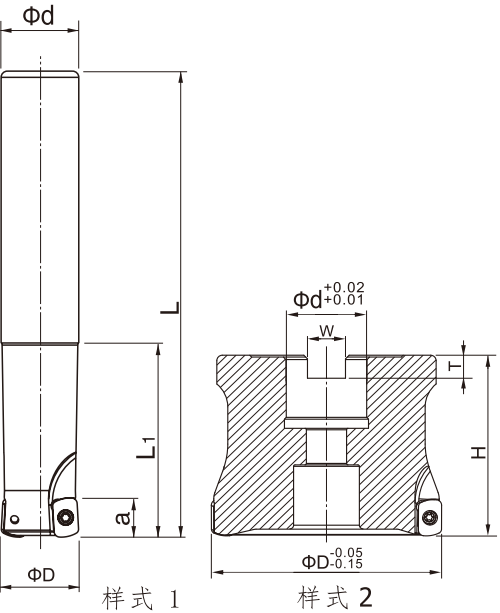
ASR 刀杆，锁牙头 用于EDHT0402 快进给刀片



本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

型号	刃数	样式	尺寸 mm					螺钉	扳手	刀片型号
			D	d	L	L1	M			
刀杆	ASR-8X80-ED04-1T	1	1	8	8	80	16	MS2040 MS2050	T6	EDHT0402
	ASR-10X80-ED04-2T	2	1	10	10	80	20			
	ASR-12X90-ED04-2T	2	1	12	12	90	25			
	ASR-14X100-ED04-3T-C16	3	1	14	16	100	35			
	ASR-16X100-ED04-4T	4	1	16	16	100	35			
锁牙头	ASR-8-ED04-1T-M4	1	2	8	4.5		11.5			
	ASR-8.5-ED04-1T-M4	1	2	8.5	4.5		11.5			
	ASR-9-ED04-1T-M4	1	2	9	4.5		11.5			
	ASR-9.5-ED04-1T-M4	1	2	9.5	4.5		11.5			
	ASR-10-ED04-2T-M5	2	2	10	5.5		12.5			
	ASR-10.5-ED04-2T-M5	2	2	10.5	5.5		12.5			
	ASR-11-ED04-2T-M5	2	2	11	5.5		12.5			
	ASR-11.5-ED04-2T-M5	2	2	11.5	5.5		12.5			
	ASR-12-ED04-2T-M6	2	2	12	6.5		12.5			
	ASR-12.5-ED04-2T-M6	2	2	12.5	6.5		12.5			
	ASR-13-ED04-2T-M6	2	2	13	6.5		14			
	ASR-13.5-ED04-2T-M6	2	2	13.5	6.5		14			
	ASR-14-ED04-3T-M6	3	2	14	6.5		14			
	ASR-15-ED04-4T-M6	4	2	15	6.5		14			
	ASR-16-ED04-4T-M8	4	2	16	8.5		16.5			

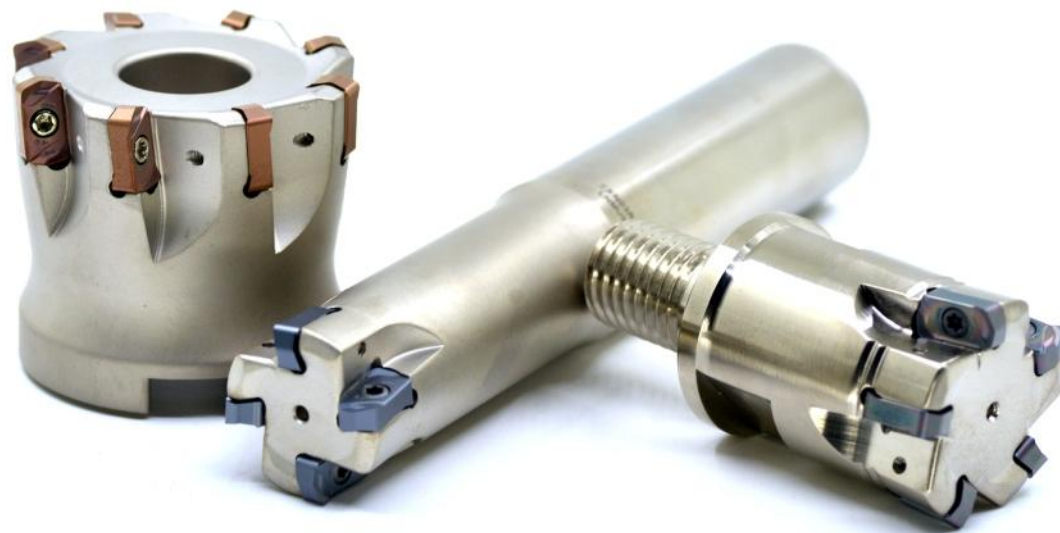
ASR 刀杆，锁牙头
用于EPMT0603 快进给刀片



本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

型号		刀数	样式	尺寸 mm					螺钉	扳手	刀片型号
				D	d	L H	L1 W	M			
刀杆	ASR-16X120-EP06-2T	2	1	16	16	120	35		MS2560	T8	EPMT0603
	ASR-17X120-EP06-2T-C16	2	1	17	16	120	35				
	ASR-20X120-EP06-2T	2	1	20	20	120	50				
	ASR-20X160-EP06-2T	2	1	20	20	160	50				
	ASR-21X120-EP06-2T-C20	2	1	21	20	120	27				
	ASR-25X120-EP06-3T	3	1	25	25	120	50				
	ASR-25X160-EP06-3T	3	1	25	25	160	50				
	ASR-32X160-EP06-4T	4	1	32	32	160	80				
	ASR-35X160-EP06-4T	4	1	35	32	160	40				
刀盘	ASR-EP06-40-16-4T	4	2	40	16	42	10.4				
	ASR-EP06-50-16-6T	6	2	50	22	50	10.4				
	ASR-EP06-63-16-8T	8	2	63	22	50	10.4				

双面快进给刀片: 4个刃
LNMU0303ZER-CM

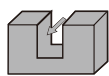
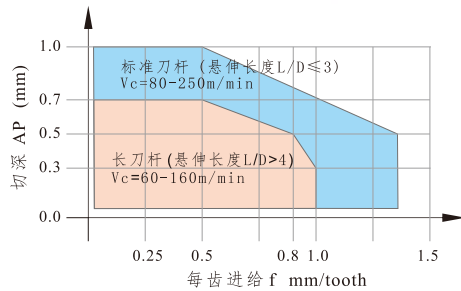


刀杆规格: 16-35mm 刀盘规格: 40, 50, 63, 80mm
锁牙头规格: 16, 17, 20, 21, 25, 26, 32, 35mm

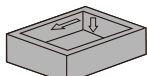
LNMU0303 快进给铣削刀片

LNMU0303 high feed milling insert

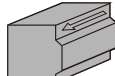
LNMU0303刀片取代R5和APMT1135的粗加工
大大提高了效率和刀片寿命



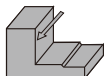
槽加工



开框加工



方肩铣



平面铣

特点:

刃口强度高, 耐磨性好, 稳定性高, 加工效率极高;
性能超越进口同类顶级产品。

被加工对象:

不锈钢, 高温合金, 模具钢及铸铁加工。

Feature:

Strong edge, perfect abrasive resistance, high stability and efficiency.

Performance exceed famous brand.

Application:

Stainless steel, Heat resisting alloy, Die steel, cast iron.

		PVD Coating			加工参数 parameters			
		CP2630T	CP2430	CP1120H				
								Vc (mm/min)
工件材质	P	钢件加工 Steel	✱	✱		120-160-250		
	P	模具钢 P20,718,SKD11,S136H	✱	✱		100-130-160		
	P	淬火钢加工 HRC50-63 Steel			✱	50-80-120		
	M	不锈钢 Stainless steel	✱	✱	✱	60-110-150		
	K	铸铁 Cast iron		✱	✱	150-180-220		
	S	钛合金 Titanium alloy	✱	✱		40-60-80		
	S	耐热合金 Heat-resisting steel	✱			40-60-100		
型号规格 Type		用途 purpose		Ap(mm)		f (mm/t)		
LNMU0303ZER-CM		不锈钢, 钢, 铸铁 钛合金, 高温合金 Stainless steel, Steel, Cast iron Ti-alloy Heat-resisting		✱	✱	✱	0.3-0.8	0.3-1.2

LNMU0303ZER-CM编程R角为**R=1.5mm**;
CP2430适合于干式或风冷切削。 CP2430 Suitable For Dry Or Air-cooled Cutting

LNMU0303 切削加工参数



■ 编制程序上的刀具形状

使用CAM编制程序时，应将刀具视为半径铣刀。一般情况下，应将刀尖半径设为 $R = 1.5\text{ mm}$ 。若使用更大的半径，会出现过度切削情况。下表显示了切削余量(t_1)过切量(t_2)。

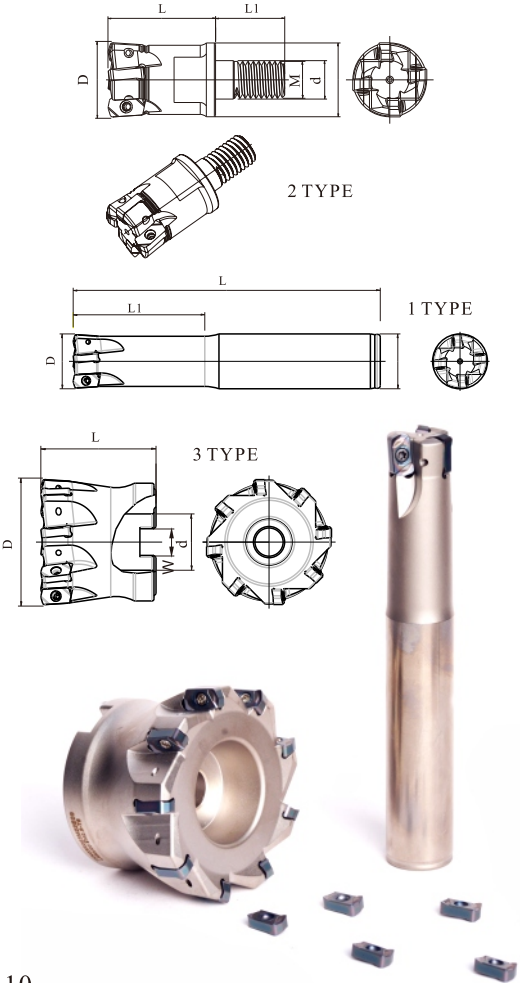


最大切深 最大 a_p (mm)	刀尖半径 r_E (mm)	W (mm)	编制程序时的 的刀尖 R	切削余量 t_1 (mm)	过切量 t_2 (mm)
1.0	1.2	3.0	1.0	0.6	-
			1.5	0.5	-
			2.0	0.25	0.08
			2.5	0.14	0.26

工件材料	材料硬度	材质选择	线速度 V_c m/min	每齿进给量 f_z mm/t / A_p mm		插 铣
				刀具直径 $\Phi 16-22$	刀具直径 $\Phi 25-50$	
碳钢 S45C, S50C	~220HB	CP2630T CP2430	100-250	$f_z=0.5-1.2$ $A_p=0.5-0.8$	$f_z=0.5-1.5$ $A_p=0.5-0.8$	0.1
合金钢 20CrMoTi, 42CrMo	~200HB	CP2630T CP2430	100-200	$f_z=0.5-1.0$ $A_p=0.4-0.6$	$f_z=0.5-1.2$ $A_p=0.4-0.6$	0.1
五金模具钢 SKD61 (H13), SKD11	350HB	CP2630T CP2430	100-150	$f_z=0.5-0.7$ $A_p=0.3-0.5$	$f_z=0.5-0.8$ $A_p=0.3-0.5$	0.1
模具钢 P20, 718, 738	HRC28-32	CP2630T CP2430	100-180	$f_z=0.5-1.0$ $A_p=0.3-0.5$	$f_z=0.5-1.0$ $A_p=0.3-0.5$	0.1
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2630T	100-150	$f_z=0.5-0.7$ $A_p=0.3-0.5$	$f_z=0.5-0.8$ $A_p=0.3-0.5$	0.1
淬火钢 SKD61 (H13)	HRC40-50	CP2630T CP1120H	80-120	$f_z=0.1-0.25$ $A_p=0.2-0.3$	$f_z=0.1-0.25$ $A_p=0.2-0.3$	0.05
淬火钢 SKD11 (Cr12MoV)	HRC50-62	CP1120H	70-120	$f_z=0.1-0.2$ $A_p=0.15-0.2$	$f_z=0.1-0.2$ $A_p=0.15-0.2$	0.05
不锈钢 304, 316	200HB	CP2630T CP2430	100-150	$f_z=0.3-0.6$ $A_p=0.3-0.6$	$f_z=0.3-0.7$ $A_p=0.3-0.6$	0.08
钛合金 Ti-alloy 镍基高温合金 718		CP2630T CP2430	60-120	$f_z=0.3-0.5$ $A_p=0.3-0.5$	$f_z=0.3-0.5$ $A_p=0.3-0.5$	0.08
灰口铸铁 FC250, HT250	~200HB	CP1120H CP2430	120-220	$f_z=0.5-1.5$ $A_p=0.5-1.0$	$f_z=0.5-1.5$ $A_p=0.5-1.0$	0.1
球墨铸铁 FCD400, QT300, 400, 500, 600	~200HB	CP1120H CP2430	100-200	$f_z=0.5-1.5$ $A_p=0.5-0.8$	$f_z=0.5-1.5$ $A_p=0.5-0.8$	0.1

CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

EXN 刀杆, 锁牙头, 刀盘



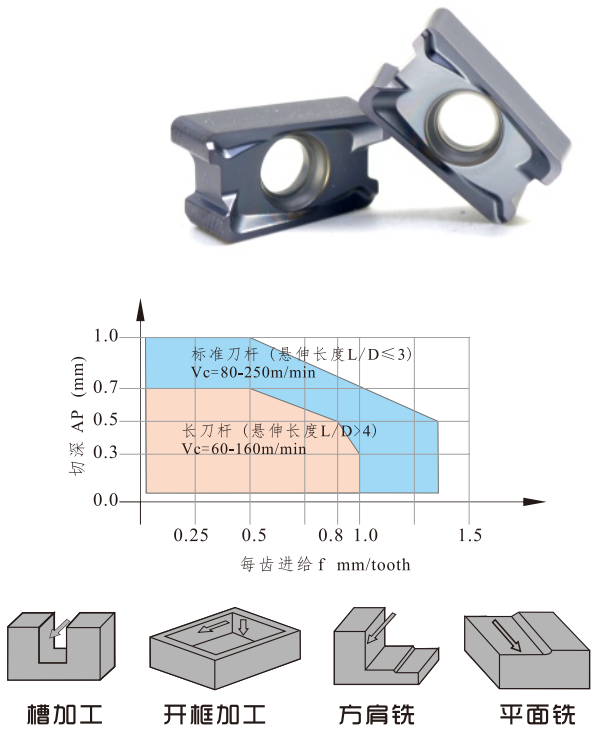
本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

型号		刃数	样式	尺寸 mm					螺钉	扳手	刀片型号
				D	d	L	L1 W	M			
刀杆	EXN03R 16X16X100-2T	2	1	16	16	100	30		MS2560	T8	LNMU0303
	EXN03R 17X16X100-2T	2	1	17	16	100	30				
	EXN03R 17.5X16X100-2T	2	1	17.5	16	100	30				
	EXN03R 18X16X100-2T	2	1	18	16	100	30				
	EXN03R 20X20X130-3T	3	1	20	20	130	50				
	EXN03R 21X20X130-3T	3	1	21	20	130	50				
	EXN03R 21.5X20X130-3T	3	1	21.5	20	130	50				
	EXN03R 25X25X140-4T	3	1	25	25	140	50				
	EXN03R 26X25X140-4T	4	1	26	25	140	40				
	EXN03R 27.5X25X160-4T	4	1	27.5	25	160	40				
	EXN03R 32X32X150-5T	5	1	32	32	150	70				
	EXN03R 32X32X200-5T	5	1	32	32	200	80				
	EXN03R 35X32X150-5T	5	1	35	32	150	40				
锁牙头	EXN03R 16-M8-2T	2	2	16	8.5	25	16.5	M8			
	EXN03R 17-M8-2T	2	2	17	8.5	25	16.5	M8			
	EXN03R 20-M10-3T	3	2	20	10.5	30	18.5	M10			
	EXN03R 21-M10-3T	3	2	21	10.5	30	18.5	M10			
	EXN03R 25-M12-4T	4	2	25	12.5	35	22.5	M12			
	EXN03R 26-M12-4T	4	2	26	12.5	35	22.5	M12			
	EXN03R 32-M16-5T	5	2	32	16.5	43	25	M16			
	EXN03R 35-M16-5T	5	2	35	16.5	43	25	M16			
刀盘	EXN03R 40X16X40-6T	6	3	40	16	40	10.4				
	EXN03R 50X22X45-8T	8	3	50	22	45	10.4				
	EXN03R 63X22X45-9T	9	3	63	22	45	10.4				

LNMU1104
 方肩铣削刀片

LNMU1104
 right angle milling insert

LNMU1104刀片是取代APMT1135和1604最佳方案
 切深达到 9.0mm以上



特点：
 刃口强度高，耐磨性好，稳定性高，加工效率极高；
 性能超越进口同类顶级产品。
 被加工对象：
 不锈钢，高温合金，钢及铸铁加工。

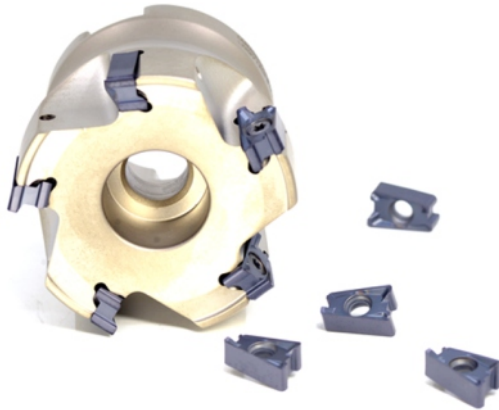
Feature:
 Strong edge, perfect abrasive resistance, high stability and efficiency.
 Performance exceed famous brand.

Application:
 Stainless steel, Heat resisting alloy, Die steel, cast iron.

		PVD Coating			加工参数 parameters	
		CP2630T	CP2430	CP1120H	V _c (mm/min)	
工件材质	P 钢件加工 Steel	✱	✱		120-160-250	
	P 模具钢P20,718,SKD11,S136H	✱	✱		100-130-160	
	P 淬火钢加工 HRC40-63 Steel			●	50-80-120	
	M 不锈钢 Stainless steel	✱	✱	●	60-110-150	
	K 铸铁 Cast iron	✱	✱	●	150-180-220	
	S 钛合金 Titanium alloy	✱			40-60-80	
	S 耐热合金 Heat-resisting steel	✱		●	40-60-100	
型号规格 Type		用途 purpose			Ap(mm)	f (mm/t)
LNMU1104SRGE		不锈钢，高温合金 钢, 铸铁 Stainless steel, Steel Cast iron Heat-resisting steel			0.3-9.0	0.3-1.0

刀尖圆角Re=0.8
 CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

LNMU1104 加工切削参数

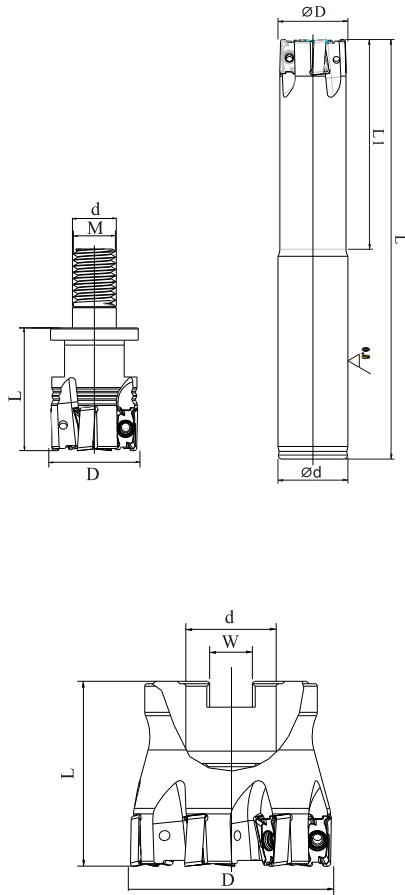


工件材料	材料硬度	材质选择	线速度Vc m/min	每齿进给量 fz mm/t / Ap mm		插 铣
				刀具直径 Φ 16-22	刀具直径 Φ 25-50	
碳钢 S45C, S50C	~220HB	CP2630T CP2430	100-250	fz=0.5-1.2 Ap=0.5-0.8	fz=0.5-1.5 Ap=0.5-0.8	0.1
合金钢 20CrMoTi, 42CrMo	~200HB	CP2630T CP2430	100-200	fz=0.5-1.0 Ap=0.4-0.6	fz=0.5-1.2 Ap=0.4-0.6	0.1
五金模具钢 SKD61 (H13), SKD11	350HB	CP2630T CP2430	100-150	fz=0.5-0.7 Ap=0.3-0.5	fz=0.5-0.8 Ap=0.3-0.5	0.1
模具钢 P20, 718, 738	HRC28-32	CP2630T CP2430	100-180	fz=0.5-1.0 Ap=0.3-0.5	fz=0.5-1.0 Ap=0.3-0.5	0.1
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2630T CP1120H	100-150	fz=0.5-0.7 Ap=0.3-0.5	fz=0.5-0.8 Ap=0.3-0.5	0.1
淬火钢 SKD61 (H13)	HRC40-50	CP2630T CP1120H	80-120	fz=0.1-0.2 Ap=0.15-0.2	fz=0.1-0.2 Ap=0.15-0.2	0.05
淬火钢 SKD11 (Cr12MoV)	HRC55-62	CP1120H	50-80	fz=0.05-0.1 Ap=0.1-0.15	fz=0.05-0.1 Ap=0.1-0.15	0.03
不锈钢 304, 316	200HB	CP2630T	100-150	fz=0.3-0.6 Ap=0.3-0.6	fz=0.3-0.7 Ap=0.3-0.6	0.08
镍基高温合金 718	HRC38-45	CP1120H CP2630T	60-120	fz=0.3-0.5 Ap=0.3-0.5	fz=0.3-0.5 Ap=0.3-0.5	0.08
灰口铸铁 FC250, HT250	~200HB	CP2430 CP1120H	120-220	fz=0.5-1.5 Ap=0.5-1.0	fz=0.5-1.5 Ap=0.5-1.0	0.1
球墨铸铁 FCD400, QT300, 400, 500, 600	~200HB	CP2430 CP1120H	120-200	fz=0.5-1.5 Ap=0.5-0.8	fz=0.5-1.5 Ap=0.5-0.8	0.1

CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

M4DR 刀杆, 锁牙头, 刀盘

用于 LNMU1104 快进给刀片



本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

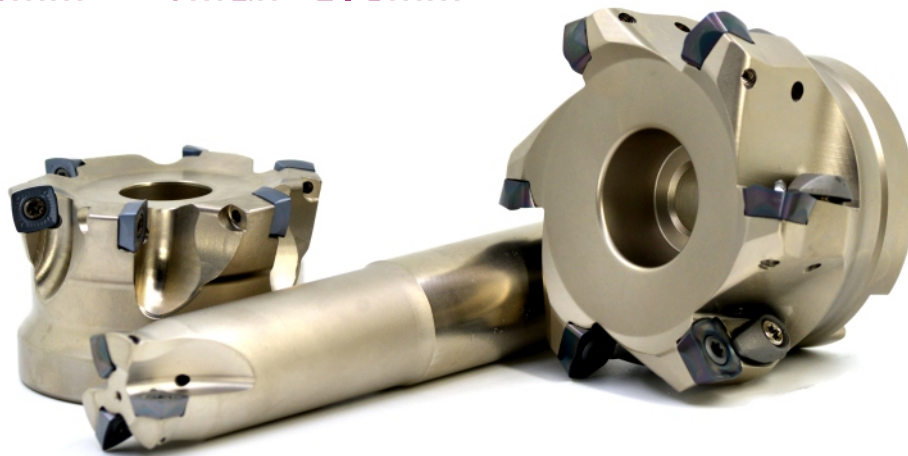
型号		刃数	样式	尺寸 mm					螺钉	扳手	刀片型号
				D	d	L	L1 W	M			
刀杆	M4DR 16X16X100-LN11-2T	2	1	16	16	100	30		MS2560	T8	LNMU1104
	M4DR 17X16X100-LN11-2T	2	1	17	16	100	30				
	M4DR 18X16X100-LN11-2T	2	1	18	16	100	30				
	M4DR 20X20X130-LN11-3T	3	1	20	20	130	50				
	M4DR 21X20X130-LN11-3T	3	1	21	20	130	50				
	M4DR 25X25X140-LN11-4T	4	1	25	25	140	50				
	M4DR 26X25X140-LN11-4T	4	1	26	25	140	40				
	M4DR 32X32X150-LN11-5T	5	1	32	32	150	70				
	M4DR 32X32X200-LN11-5T	5	1	32	32	200	80				
	M4DR 35X32X150-LN11-5T	5	1	35	32	150	40				
	M4DR 35X32X200-LN11-5T	5	1	35	32	200	40				
锁牙头	M4DR 16-M8-LN11-2T	2	2	16	8.5	25	16.5	M8			
	M4DR 17-M8-LN11-2T	2	2	17	8.5	25	16.5	M8			
	M4DR 20-M10-LN11-3T	3	2	20	10.5	30	18.5	M10			
	M4DR 21-M10-LN11-3T	3	2	21	10.5	30	18.5	M10			
	M4DR 25-M12-LN11-4T	4	2	25	12.5	35	22.5	M12			
	M4DR 26-M12-LN11-4T	4	2	26	12.5	35	22.5	M12			
	M4DR 32-M16-LN11-5T	5	2	32	16.5	43	25	M16			
	M4DR 35-M16-LN11-5T	5	2	35	16.5	43	25	M16			
刀盘	M4DR 40X16X40-LN11-6T	6	3	40	16	40	10.4				
	M4DR 50X22X45-LN11-8T	8	3	50	22	45	10.4				
	M4DR 63X22X45-LN11-9T	9	3	63	22	45	10.4				
	M4DR 80X27X50-LN11-9T	9	3	80	27	50	12.4				

高效快进给 SD 铣削刀片

High feed SD Milling Insert

金属铁屑收割机 Iron chip harvester

$A_{pmax}=2.0mm$ $f_{max}=2.0mm$



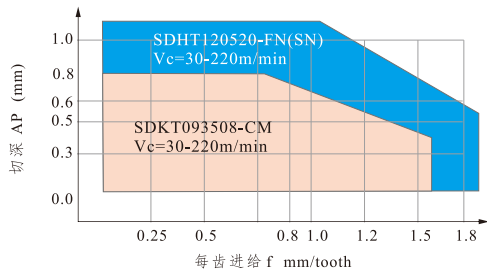
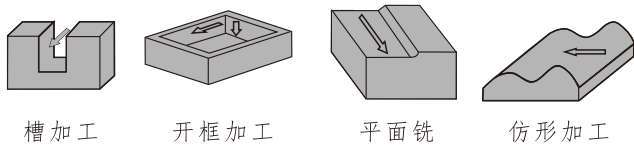
刀片型号 Insert Type

SDKT093508-CM	SDHT120520-FN,	SDMT120512-SN,
	SDHT120520-SN,	SDMT150512-SN
	SDMT120520-SN	

注意事项：快进给刀片在切削中负载较大，
对机床的功率及机床刚性要求高。

SDK(H,M)T 快进给刀片

SDK(H,M)T high feed milling insert



特点:

刃口强度高, 耐磨性好, 稳定性高, 加工效率极高;
性能超越进口同类顶级产品。

被加工对象:

不锈钢, 高温合金, 模具钢及球墨铸铁加工。

Feature:

Strong edge, perfect abrasive resistance, high stability and efficiency.
Performance exceed famous brand.

Application:

Stainless steel, Heat resisting alloy, Die steel, Nodular cast iron.

FN: 锋利 (Sharp)

SN: (强壮 Strong)

FN: 锋利 (Sharp) SN:(强壮 Strong)		PVD Coating			加工参数 parameters				
		CP2630T CP2640T	CP2430	CP1120H					
				Vc (mm/min)					
工件材质	P	钢件加工 Steel	✱	✱		120-160-250			
	P	模具钢 P20,718,SKD11,S136H	✱	✱		100-130-160			
	P	淬火钢加工 HRC40-63 Steel			●	50-80-120			
	M	不锈钢 Stainless steel	✱	✱	●	60-110-150			
	K	铸铁 Cast iron	✱	✱	●	150-180-220			
	S	钛合金 Titanium alloy	✱	✱		40-60-80			
	S	耐热合金 Heat-resisting steel	✱	✱	●	40-60-100			
刀片型号 Type		材质 purpose			Ap(mm)	f (mm/t)			
SDKT093508-CM		钛合金, 不锈钢, 高温合金, 低碳钢			✱	✱	●	0.3-0.8	0.5-1.5
SDHT120520-FN		Ti-alloy, St-steel, Heat-resisting, steel			✱	✱	●	0.5-1.2	0.8-1.5
SDHT120520-SN		铸铁及钢件 Cast iron, Steel			✱	✱	●	0.5-1.2	0.8-2.0
SDMT120520-SN					✱	✱		0.5-1.2	0.8-2.0
SDMT120512-HT					✱	✱	●	0.5-1.5	0.8-2.0
SDMT150512-HT					✱	✱		1.2-1.5	1.2-2.0

SDKT093508编程R角为R=2.0mm; 切削锋利, 用于钛合金加工的最佳选择

SDH(M)T120520编程R角为R=4.0mm

SDMT120512和SDMT150512同HITACHI通装

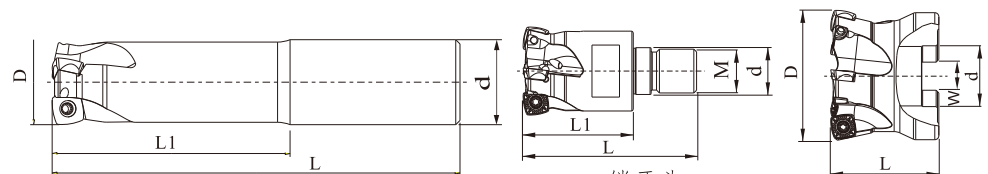
SDKT0935
 SDHT1205
 SDMT1205
 SDMT1505

快进给刀片



工件材料	材料硬度	材质选择	线速度Vc m/min	每齿进给量 fz mm/t / Ap mm	
				SDKT093508	SDHT120520
碳钢 S45C, S50C	~220HB	CP2630T CP2430	100-250	fz=0. 5-1.2 Ap=0.5-0.8	fz=0. 5-1.8 Ap=0.5-1.0
合金钢 20CrMoTi, 42CrMo	~200HB	CP2630T CP2430	100-200	fz=0. 5-1.0 Ap=0.4-0.6	fz=0. 5-1.5 Ap=0.5-1.0
五金模具钢 SKD61(H13), SKD11	350HB	CP2630T CP2430	100-150	fz=0. 5-0.7 Ap=0.3-0.6	fz=0. 5-1.2 Ap=0.5-1.0
模具钢 P20, 718, 738	HRC28-32	CP2630T CP2430	100-180	fz=0. 5-1.0 Ap=0.3-0.5	fz=0. 5-1.2 Ap=0.5-0.8
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2630T CP2430	100-150	fz=0. 5-0.7 Ap=0.3-0.5	fz=0. 5-1.2 Ap=0.5-1.0
淬火锅 SKD61(H13), S136H, NAK80	HRC40-50	CP2630T CP1120H	80-120	fz=0. 1-0.2 Ap=0.15-0.4	fz=0. 1-0.2 Ap=0.15-0.5
淬火锅	HRC50-62	CP1120H	50-80	fz=0. 1-0.2 Ap=0.10-0.4	fz=0. 1-0.2 Ap=0.15-0.5
不锈钢 304, 316	200HB	CP2630T CP2430 CP1120H	100-150	fz=0. 3-0.5 Ap=0.3-0.6	fz=0. 3-0.8 Ap=0.3-0.8
镍基高温合金 718	HRC38-45	CP1120H CP2630T	60-120	fz=0. 3-0.5 Ap=0.3-0.5	fz=0. 3-0.6 Ap=0.3-0.6
钛合金 Ti-6Al-4V(Tc4)	HRC40	CP2640T	30-80	fz=0. 3-0.8 Ap=0.3-0.5	fz=0. 3-1.0 Ap=0.3-0.8
灰口铸铁 FC250, HT250	~200HB	CP2430	120-220	fz=0.5-1.5 Ap=0.5-1.0	fz=0.5-1.8 Ap=0.5-1.2
球墨铸铁 FCD400, QT300, 400, 500, 600	~200HB	CP2630T CP2430	120-200	fz=0.5-1.5 Ap=0.5-0.8	fz=0.5-1.8 Ap=0.5-1.2

CSDR 刀杆, 锁牙头, 刀盘 用于SD系列 快进给刀片



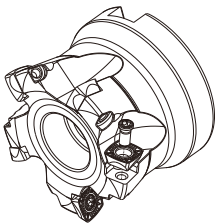
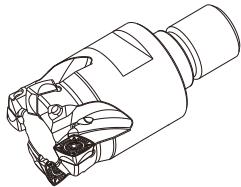
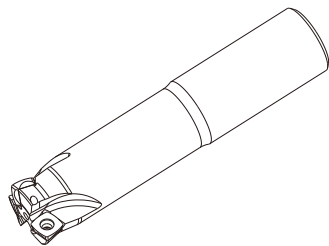
1. 刀 杆（带内冷）

2. 锁牙头
（带内冷）

3. 刀 盘（带内冷）

本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。

Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm



型 号		刃 数	样 式	尺寸 mm					螺钉 	扳手 	压板 	刀片型号 
				D	d	L	L1 W	M				
刀 杆	CSDR-25X120-SD09-3T-W	3	1	25	25	120	60	MS3070	T10			SDKT093508
	CSDR-26X25X120-SD09-3T-W	3	1	26	25	120	35					
	CSDR-26X25X150-SD09-3T-W	3	1	26	32	150	35					
	CSDR-32X160-SD09-4T-W	4	1	32	25	160	90					
	CSDR-32X200-SD09-4T-W	4	1	32	32	200	130					
锁 牙 头	CSDR-35X160-SD09-4T-W	4	1	35	32	160	90					
	CSDR-35X200-SD09-4T-W	4	1	35	32	200	130					
	CSDRM-25-SD09-M12-3T-W	3	2	25	12.5	55	33					
	CSDRM-32-SD09-M16-4T-W	4	2	32	17	63	40					
	CSDRM-35-SD09-M16-4T-W	4	2	35	17	63	40					
	CSDRM-40-SD09-M16-5T-W	5	2	40	17	63	40					
刀 盘	CSDRM-35-SD12-M16-3T-W	3	2	35	17	72	42	M16	MS4090	T15		SDHT1205 SDMT1205
	CSDRM-40-SD12-M16-4T-W	4	2	40	17	72	42					
	CSDR-40-SD09-5T-16-W	4	3	40	16	40	10.4	MS3070	T10			SDKT093508
	CSDR-50-SD09-6T-22-W	5	3	50	22	40	10.4					
	CSDR-63-SD09-6T-22-W	6	3	63	22	40	10.4					
	CSDR-63-SD09-8T-22-W	8	3	63	22	40	10.4					
	CSDR-80-SD09-8T-27-W	8	3	80	27	40	12.4	MS4090	T15	BR-6		SDHT1205 SDMT1205
	CSDR-50-SD12-4T-22	4	3	50	22	50	10.4					
	CSDR-63-SD12-5T-22	5	3	63	22	50	10.4					
	CSDR-80-SD12-6T-27	6	3	80	27	50	12.4					
	CSDR-100-SD12-6T-32	6	3	100	32	63	14.4					
	CSDR-125-SD12-7T-40	7	3	125	40	63	16.4					

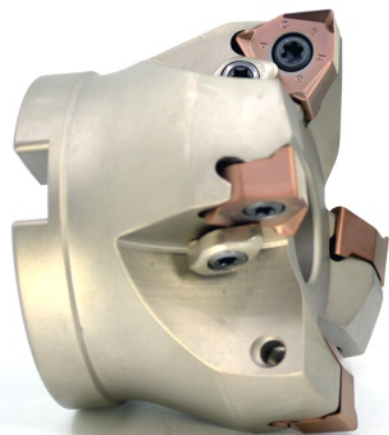
SDKT093508编程R角为R=2.0mm；SDHT120520编程R角为R=4.0mm

90°方肩铣削刀片:

钢件及铸铁加工

XNMX080608TR-CM

XNHX080608TR-CM

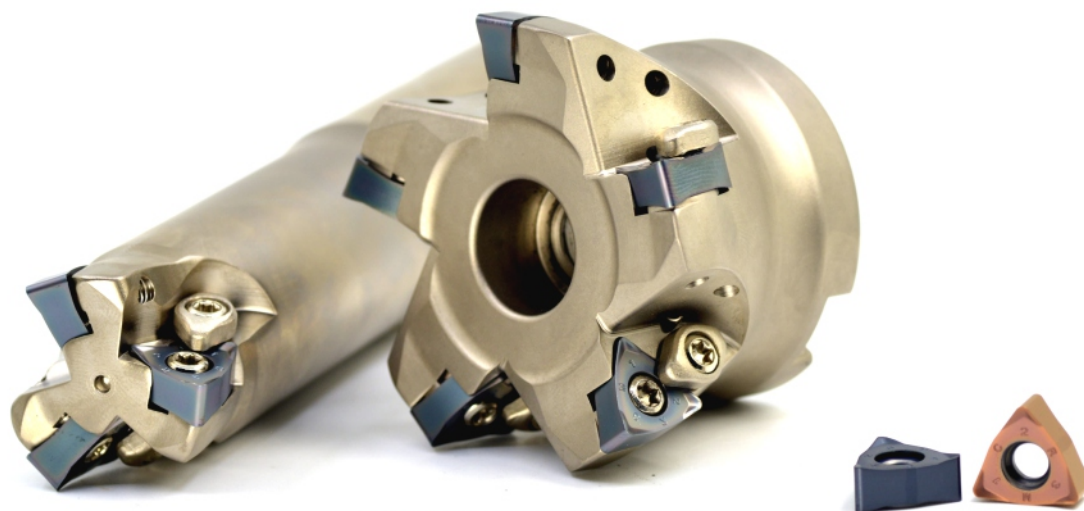


刀盘规格:

50, 63, 80, 100, 125, 160mm

90°方肩铣削刀片
刃口锋利,切削轻快

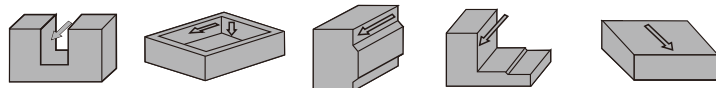
Passionate pursuit of perfection



WNMH060610-FN
WNMU060610-SN

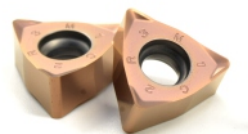
WNM(H)U XNM(H)X 双面铁削刀片

WNM(H)U
XNM(H)X Milling insert

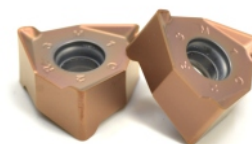


槽加工 开框加工 方肩铣 平面铣

1. WNHU060610-FN: 适合于精加工及难加工材料
(不锈钢 Stainless steel, 高温合金 Heat-resisting steel, 钛合金 Ti-alloy) 加工;
2. WNMU060610-SN: 适合于钢件 Steel 加工, 通用性极强;
3. XNMU080608TR-CM: 刃口强壮, 适合于钢件 Steel 及
铸铁 Cast iron材料加工;
4. XNHX080608TR-CM: 刃口较强壮, 适合于钢件 Steel 材料加工;
WNMU 060610 替代APMT1604PDER-H2 刀片利器
WNMU 060610 Replace APMT1604PDER-H2
WNHU060610-FN(锋利 Sharp)=APMT1604PDER-M2和
3PKT060308R-M.
WNMU060610-SN(强壮 Strong)=APMT1604PDER-H2
&APMT1605PDTR



WNMU060610-SN 刀尖R=1.0
WNHU060610-FN 锋利 (Sharp)



XNMU080608TR-CM 刀尖R=0.8
XNHU080608TR-CM (强壮 Strong)

WNMU060610刀片是自主开发
拥有自己知识产权专利申请

		PVD Coating				加工参数 parameters	
		CP2630T CP2640T	CP2430	CP1120H	CPA2140K	Vc (mm/min)	
工件 材 质	P 钢件加工 Steel	*	*		*	120-160-250	
	P 模具钢 P20,718,SKD11,S136H	*	*		*	100-130-160	
	P 淬火钢加工 HRC40-63 Steel			●		50-80-120	
	M 不锈钢 Stainless steel	*	*	●		60-110-150	
	K 铸铁 Cast iron		*	●	*	150-180-220	
	S 钛合金 Titanium alloy	*	*		*	40-60-80	
	S 耐热合金 Heat-resisting steel	*		●	*	40-60-100	
型号规格 Type		用途 purpose				Ap(mm)	f (mm/t)
WNHU 060610-FN		不锈钢, 高温合金 钛合金, 低碳钢				0.1-3.0	0.05-0.35
WNMU 060610-SN		铸铁及钢件 Cast iron, Steel				0.1-4.0	0.1-0.5
XNMU080608TR-CM		铸铁及钢件 Cast iron, Steel				0.1-4.0	0.1-0.5
XNHX080608TR-CM 带修光刃		不锈钢, 钢件 Stainless steel, Steel				0.1-4.0	0.1-0.5

XNM(H)X080608TR-CM和SECO(山高)通装;
CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

WNM(H)U0606
XNM(H)X0806

方肩铣刀片

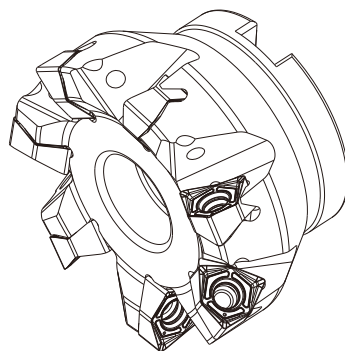
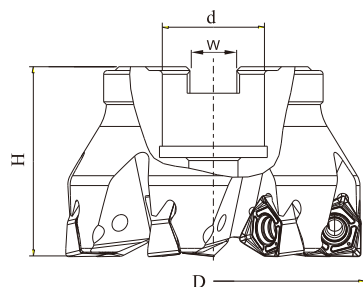


工件材料	材料硬度	材质选择	线速度Vc m/min	每齿进给量 fz mm/t
碳钢 S45C, S50C	~220HB	CP2630T CP2430	100-250	0.1-0.4
合金钢 20CrMoTi, 42CrMo	~200HB	CP2630T CP2430	100-200	0.1-0.4
五金模具钢 SKD61 (H13), SKD11	350HB	CP2630T CP2430	100-150	0.1-0.3
模具钢 P20, 718, 738	HRC28-32	CP2630T CP2430	100-180	0.1-0.4
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2630T CP2430	100-150	0.1-0.35
淬火钢 SKD61 (H13)	HRC40-48	CP2630T CP1120H	80-120	0.1-0.2
淬火钢 SKD11 (Cr12MoV)	HRC48-60	CP1120H	50-100	0.05-0.1
不锈钢 304, 316	200HB	CP2640T CP2430 CP1120H	100-150	0.07-0.35
镍基高温合金 718	HRC38-45	CP2640T CP2430 CPA2140K	60-120	0.07-0.3
钛合金 Ti-6Al-4V (Ti64)	HRC40	CP2640T CP2430 CPA2140K	30-80	0.07-0.3
灰口铸铁 FC250, HT250	~200HB	CPA2140K CP1120H	120-220	0.1-0.5
球墨铸铁 FCD400, QT300, 400, 500, 600	~200HB	CPA2140K CP1120H	120-200	0.1-0.5

铸铁和锻钢加工优先选择XNMX080608TR-CM

CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

MFWN 刀杆, 锁牙头, 刀盘 用于WN&XN 方肩铣削刀片

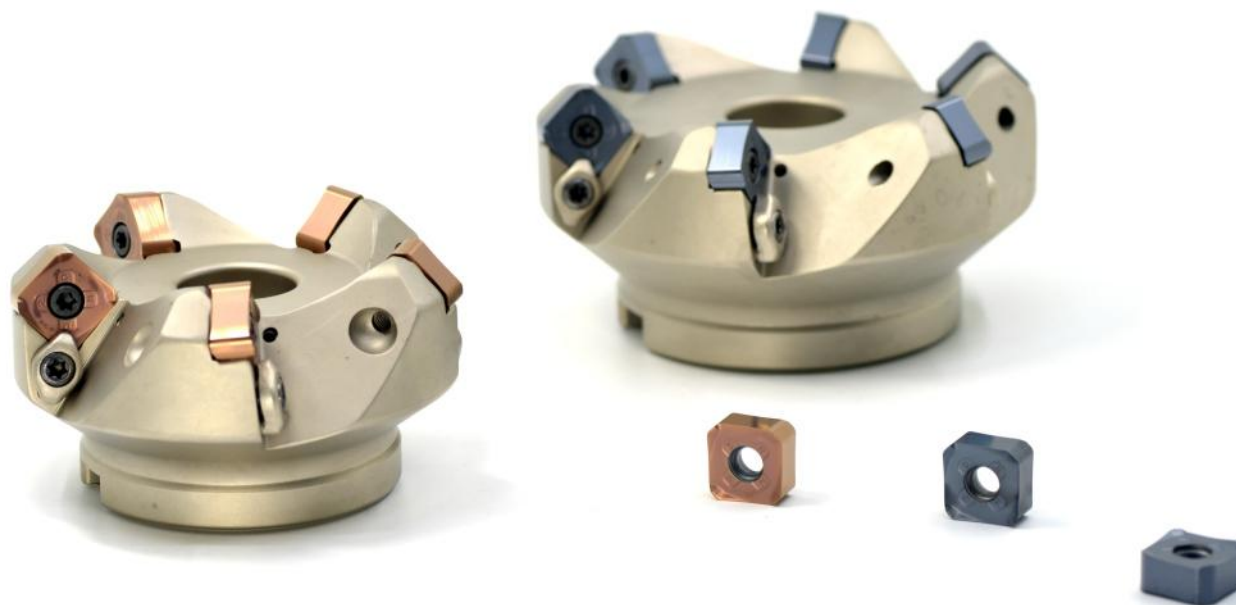


本刀体材料均采用SKD61材料, 热处理后加工, 刚性好, 抗震性能强, 精度高, 跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

型号		刃数	样式	尺寸 mm					冷却 冷却	螺钉	扳手	压板	刀片型号
				D	d	H L	W L1	M					
刀杆	MFWN06-32X32X160-3T	3	1	32	32	160	90						
	MFWN06-32X32X200-3T	3	1	32	32	200	120						
	MFWN06-35X32X160-3T	3	1	35	32	160	90						
	MFWN06-35X32X200-3T	3	1	35	32	200	120						
锁牙头	MFWN06M-90-32-M16-3T	3	2	32	17	72	42	M16		MS40120	T15		WNMU060610 WNHU060610
	MFWN06M-90-35-M16-3T	3	2	35	17	72	42						
	MFWN06M-90-40-M16-3T	3	2	40	17	72	42						
刀盘	MFWN06-90-40-16-4T	4	4	40	16	40	8.4			MS45120	T20		XNMX080608 TR-CM
	MFWN06-90-50-22-4T	4	3	50	22	40	10.4						
	MFWN06-90-63-22-5T	5	3	63	22	40	10.4						
	MFWN06-90-80-27-6T	6	3	80	27	50	12.4						
	MFWN06-90-100-32-8T	8	3	100	32	55	14.4						
	MFWN06-90-125-40-10T	10	3	125	40	63	16.4						
	MFWN06-90-160-40-12T	12	3	160	40	63	16.4						
刀盘	MFXN08-90-50-22-4T	4	3	50	22	45	10.4			MS45120	T20		XNMX080608 TR-CM
	MFXN08-90-63-22-5T	5	3	63	22	45	10.4						
	MFXN08-90-80-27-6T	6	3	80	27	50	12.4						
	MFXN08-90-100-32-8T	7	3	100	32	55	14.4						
	MFXN08-90-125-40-10T	8	3	125	40	63	16.4						
	MFXN08-90-160-40-10T	10	3	160	40	63	16.4						
	MFXN08-90-200-60-12T	12	3	200	60	63	25.7						

重力铣削刀片: $A_p4.5\text{mm}$
SNHT13T6ANER-CM

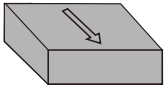
Passionate pursuit of perfection



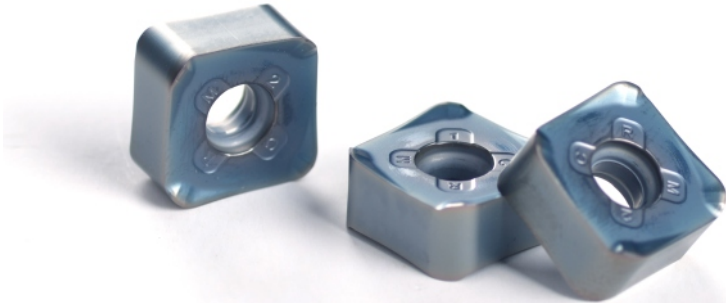
刀盘规格: 50, 63, 80, 100, 125, 160, 200

SNHT13T6 双面铣削刀片

SNHT13T6 milling insert



平面加工



- 特点：
- 刃口锋利，切削轻快，耐磨性好，稳定性高，切深 $A_p < 4.5\text{mm}$;
- 被加工对象：
- 钢及球墨铸铁加工。

- Feature:
- Sharp edge, Light cutting, good wear resistance,
 - high stability, $A_p < 4.5\text{mm}$,
- Application:
- steel, cast iron.

切削阻力相对较低，轻快

Cutting resistance is low and light

		PVD Coating				加工参数 parameters		
		CP2630T	CP2430	CP1120H	CPA2140K			
				Vc (mm/min)				
工件材质	P	钢件加工 Steel	✱	✱		✱	120-160-250	
	P	模具钢 P20,718,SKD11,S136H	✱	✱		✱	100-130-160	
	P	淬火钢加工 HRC40-63 Steel			●		50-80-120	
	M	不锈钢 Stainless steel					60-110-150	
	K	铸铁 Cast iron	✱	✱	●	✱	150-180-220	
	S	钛合金 Titanium alloy					40-60-80	
	S	耐热合金 Heat-resisting steel					40-60-100	
型号规格 Type		用途 purpose					Ap(mm)	f (mm/t)
SNHT13T6ANER-CM		钢件，铸铁 Steel, Cast iron	✱	✱	●	✱	0.1-4.5	0.07-0.5

SNHT13T6和SUMITOMO(住友) 通装；

CP2430适合于干式或风冷切削。 CP2430 Suitable For Dry Or Air-cooled Cutting

SNHT13T6 加工切削参数

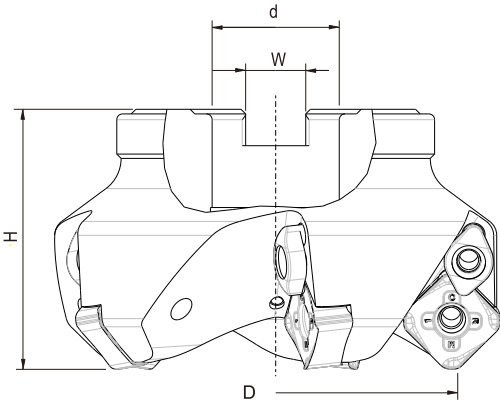
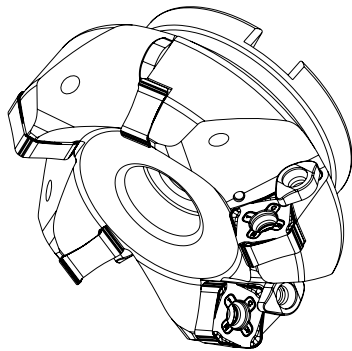


Ap max<4.5mm

工件材料	材料硬度	材质选择	线速度Vc m/min	大切深 每齿进给量 fz mm/t
碳钢 S45C, S50C	~220HB	CP2630T CP2430	100~250	0.1~0.4
合金钢 20CrMoTi, 42CrMo	~200HB	CP2630T CP2430	100~200	0.1~0.4
五金模具钢 SKD61 (H13), SKD11	350HB	CP2630T CP2430	100~150	0.1~0.3
模具钢 P20, 718, 738	HRC28-32	CP2630T CP2430	100~180	0.1~0.4
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2630T CP2430	100~150	0.1~0.35
淬火钢 SKD61 (H13)	HRC40-50	CP2630T CP1120H	80~120	0.1~0.2
淬火钢 SKD11 (Cr12MoV)	HRC40-63	CP1120H	50~100	0.05~0.1
灰口铸铁 FC250, HT250	~200HB	CPA2140K CP1120H	120~220	0.1~0.5
球墨铸铁 FCD400, QT300, 400, 500, 600	~200HB	CPA2140K CP1120H	120~200	0.1~0.4

CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

DGCM 45° 刀盘
用于SNHT13T6 重力切削刀片



本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm



型号		刀数	样式	尺寸 mm				 冷却	 螺钉	 扳手	 压板	 刀片型号
				D	d	H	W					
刀盘	DGCM 050-22-4T-45°	4	1	50	22	45	10.4		MS45120	T15	AR-6	SNHT13T6
	DGCM 063-22-5T-45°	5	1	63	22	45	10.4					
	DGCM 080-27-6T-45°	6	1	80	27	50	12.4					
	DGCM 100-32-7T-45°	7	1	100	32	50	14.4					
	DGCM 125-40-8T-45°	8	1	125	40	63	16.4					
	DGCM 160-40-10T-45°	10	1	160	40	63	16.4					
	DGCM 200-60-12T-45°	12	1	200	60	63	25.7					
	DGCM 250-60-14T-45°	14	1	250	60	63	25.7					

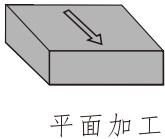
此刀盘带压板

双面五角精铣刀片:
PNHU0905GNER



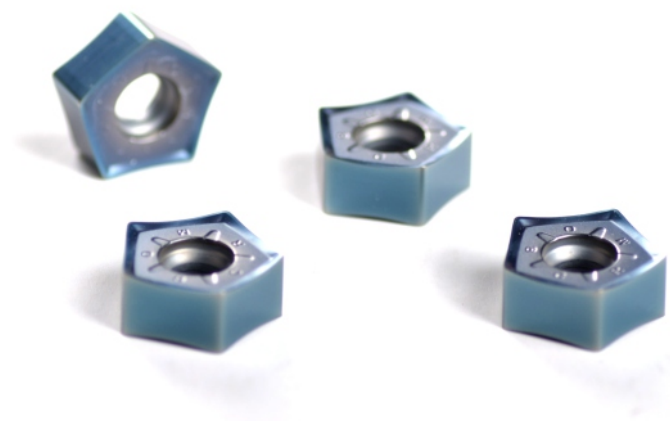
刀盘规格: 50, 63, 80, 100, 125, 160

PNHU 双面铣削刀片 刃口锋利 PNHU milling insert



特点：
 刃口锋利，切削轻快，耐磨性好，稳定性高，
 精加工性能超越进口同类顶级产品。
 被加工对象：
 不锈钢，钛合金首选，高温合金加工。

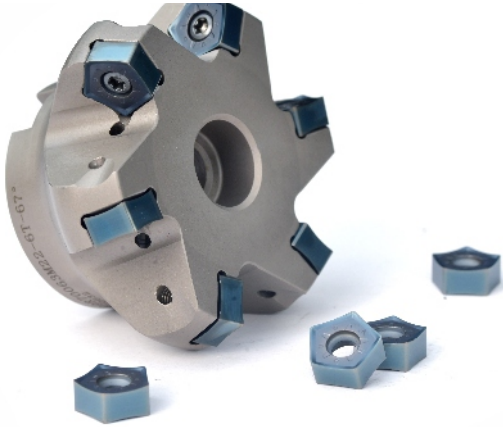
Feature:
 Sharp edge, Light cutting, good wear resistance,
 Performance exceed famous brand For Finishing .
 Application:
 Stainless steel, titanium alloy preferred, Heat resisting alloy.



刀尖圆角Re=0.8		PVD Coating					加工参数 parameters	
		CP2630T CP2640T	CPA2140K	CP2430	CP1120H	Vc (mm/min)		
工件材质	P	钢件加工 Steel	☛	✖	☛		120-160-250	
	P	模具钢 P20,718,SKD11,S136H	☛	✖	☛		100-130-160	
	P	淬火钢加工 HRC40-63 Steel				☛	50-80-120	
	M	不锈钢 Stainless steel	☛	✖	☛	☛	60-110-150	
	K	球墨铸铁 Cast iron					150-180-220	
	S	钛合金 Titanium alloy	☛	✖	☛		40-60-80	
	S	耐热合金 Heat-resisting steel	☛	✖		☛	40-60-120	
型号规格 Type		用途 purpose					Ap(mm)	f (mm/t)
PNHU0905GNER		不锈钢，高温合金 钛合金,低碳钢 Stainless steel Titanium alloy Heat-resisting steel	☛	✖	☛	☛	0.1-2.0	0.05-0.3
PNHU090508GNEN(粗)								
PNHU0905GNER-X (带修光刃)								

PNHU0905GNER和Tungaloy通装, PNHU0905GNER-X为我公司为67° 刀盘开发;
 CP2430适合于干式或风冷切削. CP2430 suitable for dry or air-cooled cutting

PNHU0905 加工切削参数

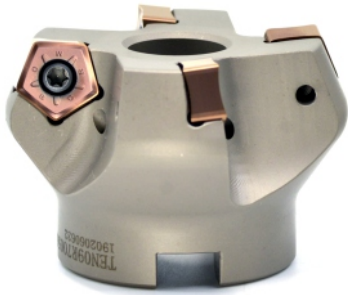
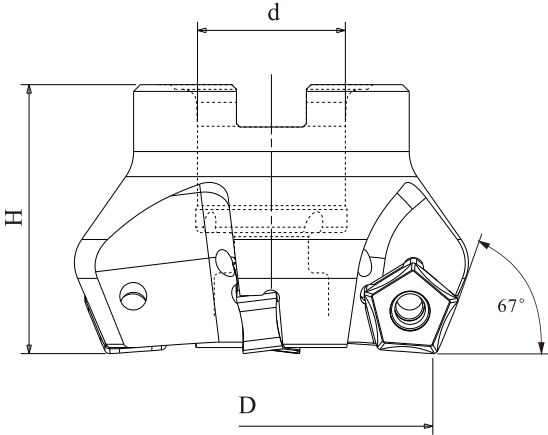
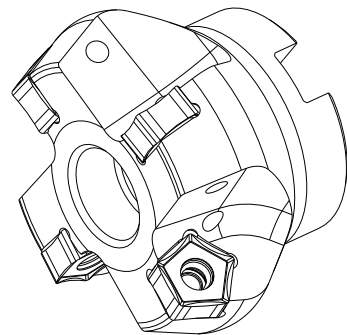


Ap max<2.0mm

工件材料	材料硬度	材质选择	线速度Vc m/min	每齿进给量 fz mm/ t
碳钢 S45C, S50C	~220HB	CP2630T CP2430	100~250	0. 05~0.3
合金钢 20CrMoTi, 42CrMo	~200HB	CP2630T CP2430	100~200	0. 05~0.25
五金模具钢 SKD61 (H13) , SKD11	350HB	CP2630T CP2430	100~150	0. 05~0.25
模具钢 P20, 718, 738	HRC28-32	CP2630T CP2430	100~150	0. 05~0. 25
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2630T CP1120H	100~150	0. 05~0.15
不锈钢 304, 316	200HB	CP2640T CP1120H	100~150	0. 05~0.25
镍基高温合金 718	HRC38-45	CPA2140K CP1120H	60~120	0. 05~0.2
钛合金 Ti-6Al-4V (Tc4)	HRC40	CP2640T CP2430	30~80	0. 05~0.25

CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

TEN67° 刀盘
用于PNHU0905 双面刀片

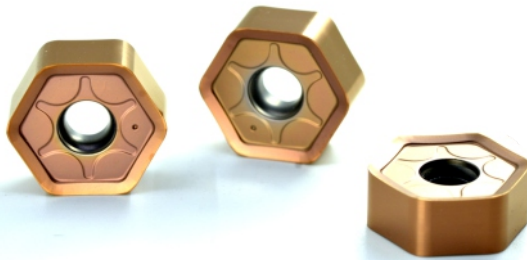


本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高,跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment,good rigidity, strong seismic performance, high precision <0.03mm

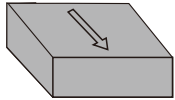
型号		刃数	样式	尺寸 mm							刀片型号 
				D	d	H	W				
刀盘	TEN09R050M22-4T-67°-W	4	1	50	22	40	10.4	●	MS40120	T15	PNHU0905
	TEN09R063M22-6T-67°-W	6	1	63	22	40	10.4	●			
	TEN09R080M27-7T-67°-W	7	1	80	27	50	12.4	●			
	TEN09R100M32-8T-67°-W	8	1	100	32	50	14.4	●			
	TEN09R125M40-8T-67°-W	10	1	125	40	63	16.4	●			
	TEN09R160M40-8T-67°-W	10	1	160	40	63	16.4	●			

重力铣削刀片 A_p 5.0
HNGX0906ANTN (带修光刃)
HNGX0906ANSN

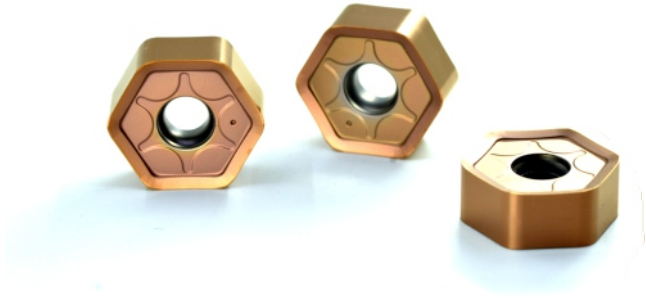
刀盘规格:
63, 80, 100, 125, 160,
200, 250, 315



HNGX0906 双面铣削刀片
HNGX0906 milling insert



平面加工



特点：
刃口锋利，切削轻快，耐磨性好，稳定性高，切深 $A_p < 5.0\text{mm}$ ；
被加工对象：
不锈钢，钛合金，高温合金，模具钢及球墨铸铁加工。

Feature:
Sharp edge, Light cutting, good wear resistance, high stability, $A_p < 5.5\text{mm}$.
Application:
Stainless steel, Titanium alloy, Heat resisting alloy, Die steel, Nodular cast iron.

		PVD Coating			加工参数 parameters	
		CP2630T	CP1120H	CPA2140K	Vc (mm/min)	
工件 材 质	P 钢件加工 Steel	✱		✱	120-160-250	
	P 模具钢 P20,718,SKD11,S136H	✱		✱	100-130-160	
	P 淬火钢加工 HRC40-63 Steel		●		50-80-120	
	M 不锈钢 Stainless steel			✱	60-110-150	
	K 铸铁 Cast iron	✱	●	✱	150-180-220	
	S 钛合金 Titanium alloy			✱	40-60-80	
	S 耐热合金 Heat-resisting steel	✱		✱	40-60-100	
型号规格 Type					Ap(mm)	f (mm/t)
HNGX 0906ANSN		✱	●	✱	0.1-5.0	0.1-0.4
HNGX 0906ANTN (带修光刃)		✱	●	✱	0.1-5.0	0.07-0.3

PRAMET(普拉米特)通装

HNGX0906 加工切削参数

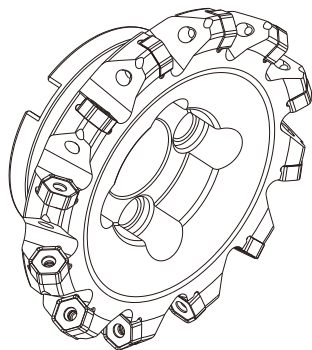
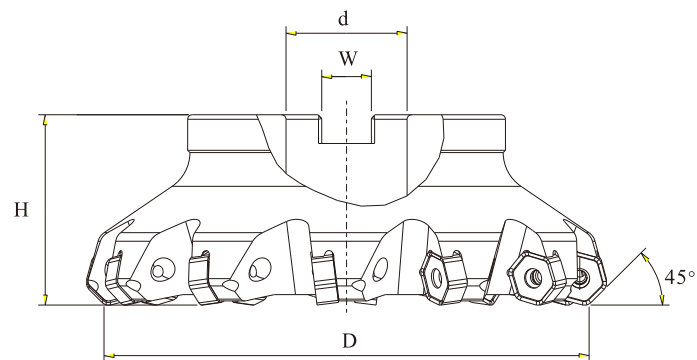


Ap max<5.0mm

工件材料	材料硬度	材质选择	线速度Vc m/ min	每齿进给量 fz mm/ t
碳钢 S45C, S50C	~220HB	CP2630T CP2430	100-250	0. 07-0.4
合金钢 20CrMoTi, 42CrMo	~200HB	CP2630T CP2430	100-200	0. 07-0.4
模具钢 P20, 718, 738	HRC28-32	CP2630T CP2430	100-180	0. 07-0.35
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2630T CP2430	100-150	0. 07-0.2
五金模具钢 SKD61 (H13), SKD11	350HB	CP2630T CP2430	100-150	0. 07-0.3
不锈钢 304, 316	200HB	CP2630T CP1120H	100-150	0. 07-0.3
镍基高温合金 718	HRC38-45	CP1120H CPA2140K	60-120	0. 07-0.2
灰口铸铁 FC250, HT250	~200HB	CP1120H CPA2140K	120-220	0.07-0.4
球墨铸铁 FCD400,QT300, 400, 500, 600	~200HB	CP1120H CPA2140K	120-200	0.07-0.4

CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

HNGX0906 45°刀盘 用于 HNGX09 刀片

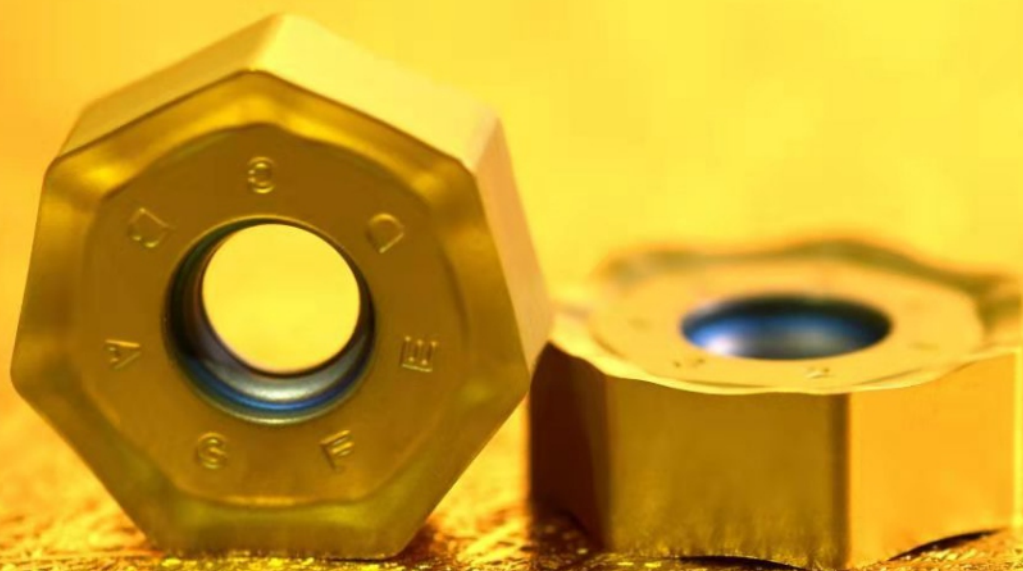


本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

型号		刃数	样式	尺寸 mm				冷却 cooling	螺钉 	扳手 	刀片型号 
				D	d	H	W				
刀盘	63A06R-S45HN09-W	6	1	63	22	40	10.4	●	MS45120	T15	HNGX0906
	80A08R-S45HN09-W	8	1	80	27	50	12.4	●			
	100A10R-S45HN09-W	10	1	100	32	50	14.4	●			
	125A10R-S45HN09-W	10	1	125	40	63	16.4	●			
	160A12R-S45HN09-W	12	2	160	40	63	16.4	●			
	200A12R-S45HN09-W	12	2	200	60	63	25.7	●			
	250A14R-S45HN09-W	14	2	250	60	63	25.7	●			
	315A16R-S45HN09-W	16	2	315	60	80	25.7	●			

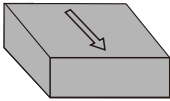
XNMU0805ANTN. CP2645T

高温合金
不锈钢
钢件
球墨铸铁



粗加工
之王

XNH(M)U06
XNMU08 双面铁削刀片
XNH(M)U06
XNMU08 Milling insert



平面加工

特点：
刃口锋利，切削轻快，耐磨性好，稳定性高，
覆盖切深XN06 Ap<3.5mm，XN08 Ap<4.5mm，加工效率极高；
性能超越进口同类顶级产品。
被加工对象：
不锈钢，钛合金，高温合金，模具钢及球墨铸铁加工。

Feature:
Sharp edge, Light cutting, good wear resistance,
high stability, XN06 Ap<3.5mm, XN08 Ap<4.5mm,
Performance exceed famous brand.

Application:
Stainless steel, Titanium alloy, Heat resisting alloy,
Die steel, Nodular cast iron.



高温合金加工专用

精加工：

XNHU0605ANR.CP1120H, CPA1140G

粗加工：

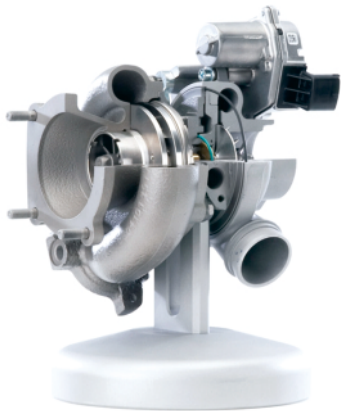
XNM(H)U0805ANTN.CPA2145K

精加工： XNHU0605ANR.CP1120H, CPA1140G 粗加工： XNM(H)U0805ANTN.CPA2145K		PVD Coating				加工参数 parameters			
		CP2640T CP2645T	CPA2140K CPA2145K	CP1120H CPA1140GH					
					Vc (mm/min)				
工件 材 质	P	钢件加工 Steel	✱	✱	✱	120-160-250			
	P	模具钢 P20,718,SKD11,S136H	✱	✱	✱	100-130-160			
	P	淬火钢加工 HRC40-63 Steel	✱		✱	50-80-120			
	M	不锈钢 Stanless steel	✱	✱	✱	60-110-150			
	K	铸铁 Cast iron		✱	✱	150-180-220			
	S	钛合金 Titanium alloy	✱	✱	✱	40-60-80			
	S	耐热合金 Heat-resisting steel		✱	✱	40-60-120			
型号规格 Type		用途 purpose			Ap(mm)		f (mm/t)		
XNMU0605SNR 强壮 strong		铸铁及钢件 Cast iron, Steel			✱	✱	0.1-3.5	0.1-0.30	
XNHU0605ANR 锋利 sharp		不锈钢，高温合金 钛合金,低碳钢 Stainless steel Titanium alloy Heat-resisting steel Low-carbon steel			✱	✱	✱	0.1-3.5	0.05-0.22
XNHU0805ANTN 锋利 sharp					✱	✱	✱	0.1-4.5	0.05-0.25
XNMU0805ANTN					✱	✱			

XNHU0605与TAEGUTEC(特固克)通装
XNM(H)0605的刀尖圆角Re=0.8，XNMU0805的刀尖圆角Re=1.2

XNH(M)U06
XNH(M)U08 加工切削参数

XN06 Ap<3.5mm, XN08 Ap<4.5mm



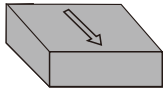
蜗壳整套方案加工



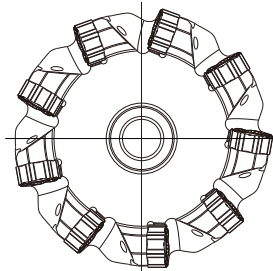
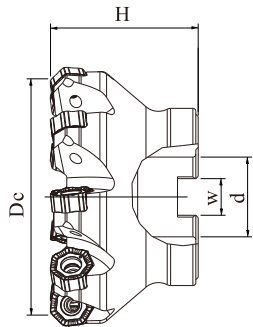
工件材料	材料硬度	材质选择	线速度Vc m/min	每齿进给量 fz mm/t
碳钢 S45C, S50C	~220HB	CP2640T CPA2140K	100-250	0.05-0.4
合金钢 20CrMoTi, 42CrMo	~200HB	CP2640T CPA2140K	100-200	0.05-0.4
五金模具钢 SKD61 (H13), SKD11	350HB	CP2640T CPA2140K	100-150	0.05-0.3
模具钢 P20, 718, 738	HRC28-32	CP2640T CPA2140K	100-180	0.05-0.3
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2640T CPA2140K	100-150	0.05-0.25
不锈钢 304, 316	200HB	CP2640T CP2645T CPA2140K	100-150	0.05-0.3
镍基高温合金 718	HRC38-45	CP2645T CPA1140GH CPA2140K	60-120	0.05-0.2
钛合金 Ti-6Al-4V (Tc4)	HRC40	CP2645T CP1140GH	30-80	0.05-0.25
灰口铸铁 FC250, HT250	~200HB	CPA2140K	120-220	0.05-0.4
球墨铸铁 FCD400, QT300, 400, 500, 600	~200HB	CPA2140K	120-200	0.05-0.4

XNM(H)U0605
XNMU0805

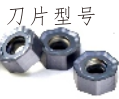
45°刀盘 Planar milling



平面加工



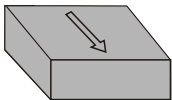
本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

型 号 type		Ap	刃 数 Z	样 式	尺寸Size mm				 冷却	螺钉 	扳手 	刀片型号 
					Dc	d	H	W				
刀 盘 Cutter head	50A05R-S45-XN06-W	3.5	5	1	50	22	40	10.4	●	MS45120	T15	XNMU0605 XNHU0605
	63A06R-S45-XN06-W	3.5	6	1	63	22	50	10.4	●			
	80A07R-S45-XN06-W	3.5	9	1	80	27	50	12.4	●			
	100A7R-S45-XN06-W	3.5	10	1	100	32	50	14.4	●			
	125A7R-S45-XN06-W	3.5	10	1	125	40	63	16.4	●			
	160A8R-S45-XN06-W	3.5	10	2	160	40	63	16.4	●			
	50A04R-S45-XN08	4.5	4	1	50	22	40	10.4		MS45120	T15	XNMU0805 XNHU0805
	63A05R-S45-XN08	4.5	5	1	63	22	50	10.4				
	80A07R-S45-XN08	4.5	7	1	80	27	50	12.4				
	100A08R-S45-XN08	4.5	8	1	100	32	50	14.4				
	125A09R-S45-XN08	4.5	9	1	125	40	63	16.4				
	160A09R-S45-XN08	4.5	9	2	160	40	63	16.4				
	160A12R-S45-XN08	4.5	12	2	160	60	63	16.4				
	200A14R-S45-XN08	4.5	14	2	200	60	63	25.7				
	250A16R-S45-XN08	4.5	16	2	250	60	63	25.7				
	315A18R-S45-XN08	4.5	18	2	315	60	80	25.7				

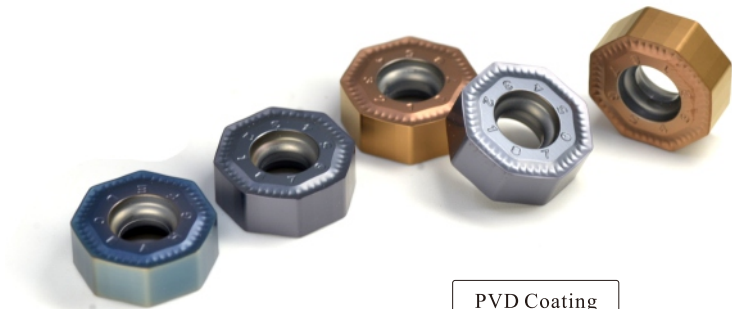
XNHU0605ANR用于精加工，XNMU0805ANR用于粗加工。

ONM(H)U05 双面铣削刀片

ONM(H)U05 milling insert



超高性能及性价比通用产品



- 特点:
- 经济通用性产品，耐磨性好，稳定性高，
 - 覆盖切深<2.5mm，加工效率极高；
 - 性能超越进口同类顶级产品。
- 被加工对象:
- 不锈钢，钛合金，高温合金，模具钢及球墨铸铁加工。

- Feature:
- Economic and universal products, good wear resistance,
 - high stability, $A_p < 2.5\text{mm}$,
 - Performance exceed famous brand.

- Application:
- Stainless steel, Titanium alloy, Heat resisting alloy,
 - Die steel, Nodular cast iron.

		PVD Coating			加工参数 parameters	
		CP2640T	CP1120H	CPA2140K	Vc (mm/min)	
工件 材 质	P 钢件加工 Steel	✳		✳	120-160-250	
	P 模具钢 P20,718,SKD11,S136H	✳		✳	100-130-160	
	P 淬火钢加工 HRC40-63 Steel		●		50-80-120	
	M 不锈钢 Stainless steel	✳	●	✳	60-110-150	
	K 铸铁 Cast iron			✳	150-180-220	
	S 钛合金 Titanium alloy	✳		✳	40-60-80	
	S 耐热合金 Heat-resisting steel	✳	●	✳	40-60-120	
刀尖圆角 Re=1.0						
型号规格 Type		用途 purpose			Ap(mm)	f (mm/t)
ONMU0504ANSN 强壮 strong		铸铁及钢件 Cast iron, Steel			0.1-2.5	0.05-0.40
ONHU0504ANTN 锋利 sharp 带修光刃		不锈钢，高温合金 钛合金，低碳钢 Stainless steel Titanium alloy Heat-resisting steel			0.1-2.0	0.05-0.3

ONM(H)U0504ANTN和TAEGUTEC(特固克)通装，CP1120H专注于精加工 Focus on finishing。

ONM(H)0504 加工切削参数



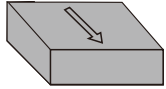
Ap max<2.5mm

工件材料	材料硬度	材质选择	线速度Vc m/min	每齿进给量 fz mm/t
碳钢 S45C, S50C	~220HB	CP2640T	100-250	0.05-0.4
合金钢 20CrMoTi, 42CrMo	~200HB	CP2640T	100-200	0.05-0.4
五金模具钢 SKD61 (H13), SKD11	350HB	CP2640T	100-150	0.05-0.2
模具钢 P20, 718, 738	HRC28-32	CP2640T	100-180	0.05-0.4
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2640T	100-150	0.05-0.25
不锈钢 304, 316	200HB	CP2640T CP1120H	100-150	0.05-0.25
镍基高温合金 718	HRC38-45	CPA2140K CP1120H	60-120	0.05-0.2
钛合金 Ti-6Al-4V (Tc4)	HRC40	CP2640T CPA2140K	30-80	0.05-0.25
灰口铸铁 FC250, HT250	~200HB	CPA2140K	120-220	0.05-0.4
球墨铸铁 FCD400, QT300, 400, 500, 600	~200HB	CPA2140K	120-200	0.05-0.35

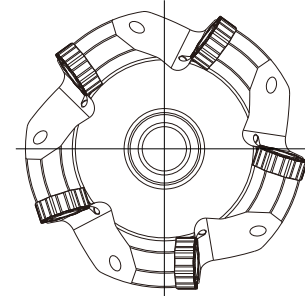
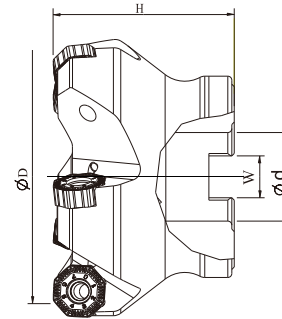
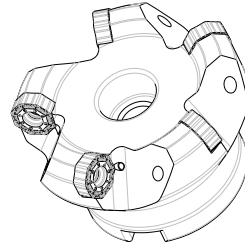
CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

ONM(H)U0504 42° 刀盘

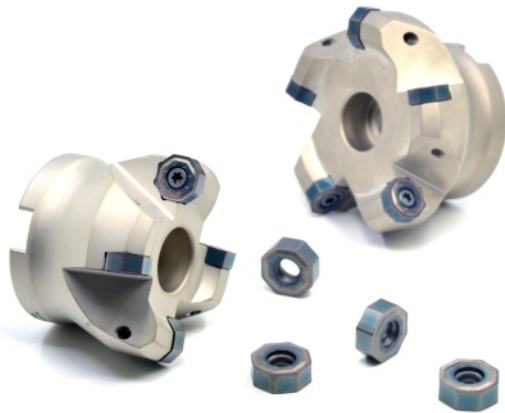
平面切削加工 Planar milling



平面加工



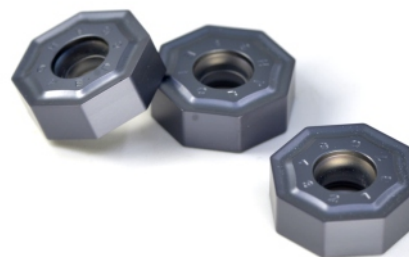
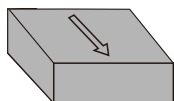
本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision<0.03mm



型号 type	Ap max	刃 数 Z	样 式	尺寸Size mm				冷却 cooling	螺钉	扳手	刀片型号
				Dc	d	H	W				
40A04R-S42-ON05	2.5	4	1	40	16	40	8.4		MS40120	T15	ONMU0504 ONHU0504
50A04R-S42-ON05	2.5	4	1	50	22	40	10.4				
63A05R-S42-ON05	2.5	5	1	63	22	50	10.4				
80A06R-S42-ON05	2.5	6	1	80	27	50	12.4				
80A08R-S42-ON05-W	2.5	9	1	80	27	50	12.4	●			
100A08R-S42-ON05	2.5	8	1	100	32	50	14.4				
100A08R-S42-ON05-W	2.5	10	1	100	32	50	14.4	●			
125A08R-S42-ON05-W	2.5	10	2	125	40	63	16.4	●			
160A10R-S42-ON05-W	2.5	10	2	160	40	63	16.4	●			
200A12R-S42ON05	2.5	12	2	200	60	63	25.7				
250A14R-S42ON05	2.5	14	2	250	60	63	25.7				
315A16R-S42ON05	2.5	16	2	315	60	80	25.7				

ONMU06 双面铁削刀片

ONMU06 milling insert



高效铸铁平面

“粗精加工”一次完成

Face Rough machining for cast iron
The rough finishing is finished at one time

特点:

刃口强壮，耐磨性好，稳定性高，
覆盖切深 $A_p < 3.8\text{mm}$ ，加工效率极高；
性能超越进口同类顶级产品。

被加工对象:

铸铁粗精加工首选，特别是汽车的铸铁缸体缸盖加工。

Feature:

Strong blade, good wear resistance,
high stability, $A_p < 3.8\text{mm}$,
Performance exceed famous brand.

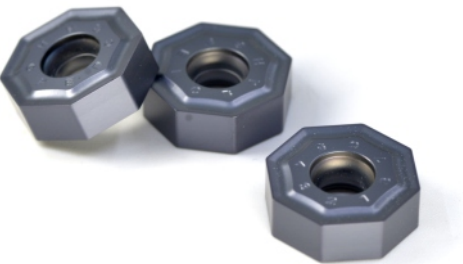
Application:

Cast iron Rough machining preferred.
Especially the cast iron cylinder block
Cylinder head processing.

刀片尖角为Re=0. 8		材质			加工参数 parameters	
		CP2640T	CP1120H	CC1030 CC1130	Vc (mm/min)	
工件 材质	P	钢件加工 Steel	✖	✖		120-160-250
	P	模具钢 P20,718,SKD11,S136H	✖	✖		100-130-160
	P	淬火钢加工 HRC40-63 Steel				50-80-120
	M	不锈钢 Stainless steel				60-110-150
	K	铸铁 Cast iron	✖	✖	✖	150-180-220
	S	钛合金 Titanium alloy				40-60-80
	S	耐热合金 Heat-resisting steel				40-60-100
型号规格 Type		用途 purpose			Ap(mm)	f (mm/t)
ONMU0605ANSN 强壮 strong		铸铁及钢件 Cast iron, Steel			0.1-3.8	0.1-0.50
ONHU0605ANR-W 锋利 sharp						

刀片尖角为 $R_e=0.8$

ONM(H)U0605加工切削参数（铸铁首选）

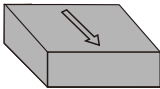


Ap max<3.8mm

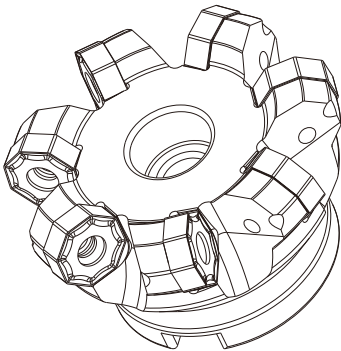
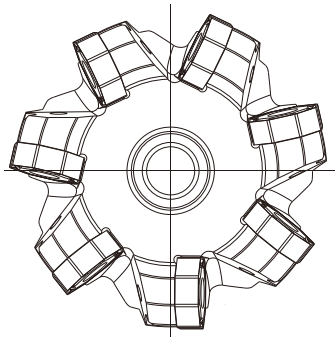
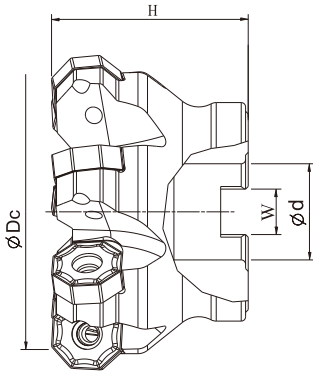
工件材料	材料硬度	材质选择	线速度Vc m/min	每齿进给量 fz mm/ t
碳钢 S45C, S50C	~220HB	CP2640T	100~250	0. 1~0.4
合金钢 20CrMoTi, 42CrMo	~200HB	CP2640T	100~200	0. 1~0.4
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2640T	100~150	0. 1~0.25
模具钢 P20, 718, 738	HRC28-32	CP2640T	100~180	0. 1~0.3
五金模具钢 SKD61 (H13), SKD11	350HB	CP2640T	100~150	0. 1~0.3
灰口铸铁 FC250, HT250	~200HB	CP2640T CC1130	120~220	0.1~0.4
球墨铸铁 FCD400, QT300, 400, 500, 600	~200HB	CP2640T CC1130	120~200	0.1~0.35

ONM(H)U0605 44°刀盘 平面切削加工

用于ONM(H)U0605 刀片



平面加工

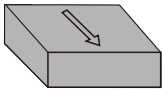


本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

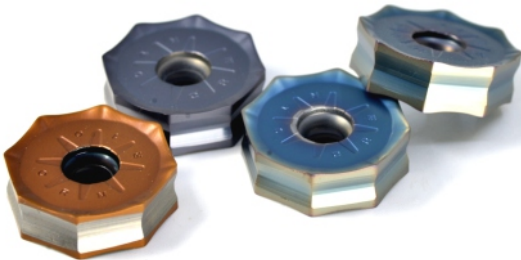
型号 type		Ap max	刃 数 Z	样 式	尺寸Size mm				冷却 cooling	螺钉	扳手	刀片型号
					Dc	d	H	W				
刀 盘 Cutter head	50A04R-S44W-ON06	3.8	4	1	50	22	40	10.4		MS45120	T20	ONMU0605 +一片 ONHU0605
	63A05R-S44W-ON06	3.8	5	1	63	22	50	10.4				
	80A07R-S44W-ON06	3.8	7	1	80	27	50	12.4				
	100A09R-S44W-ON06	3.8	9	1	100	32	50	14.4				
	125A11R-S44W-ON06	3.8	11	2	125	40	63	16.4				
	160A12R-S44W-ON06	3.8	12	2	160	40	63	16.4				
	200A14R-S44W-ON06	3.8	14	2	200	60	63	25.7				
	250A16R-S44W-ON06	3.8	16	2	250	60	63	25.7				
	315A18R-S44W-ON06	3.8	18	2	315	60	63	25.7				

ONMU0905 双面铣削刀片

ONMU0905 milling insert



FACE MILLING



- 特点：
- 刃口锋利，切削轻快，耐磨性好，稳定性高，覆盖切深 $Ap<5.0\text{mm}$ ，加工效率极高；
 - 性能超越进口同类顶级产品。
- 被加工对象：
- 不锈钢，钛合金，高温合金，模具钢及球墨铸铁加工。

- Feature:
- Sharp edge, Light cutting, good wear resistance, high stability, $Ap<5.0\text{mm}$,
 - Performance exceed famous brand.
- Application:
- Stainless steel, Titanium alloy, Heat resisting alloy, Die steel, Nodular cast iron.

刀尖圆角 $Re=1.0$

		PVD Coating				加工参数 parameters	
		CP2645T	CP2445	CP1120H	CPA2145K	V _c (mm/min)	
工件 材 质	P 钢件加工 Steel	✱	✱		✱	120-160-250	
	P 模具钢 P20,718,SKD11,S136H	✱	✱		✱	100-130-160	
	P 淬火钢加工 HRC40-63 Steel			●	✱	50-80-120	
	M 不锈钢 Stainless steel	✱	✱	●	✱	60-110-150	
	K 铸铁 Cast iron		✱	●	✱	150-180-220	
	S 钛合金 Titanium alloy	✱			✱	40-60-80	
				●	✱	40-60-100	
型号规格 Type		用途 purpose				Ap(mm)	f (mm/t)
ONMU0905ANTN-M		铸铁及钢件 Cast iron, Steel				42° 刀盘 0.8-4.8mm	0.1-0.40
		不锈钢，高温合金 Stainless steel Heat-resisting steel				16° 刀盘 0.3-0.7mm	0.5-1.0

ONMU0905 加工切削参数：

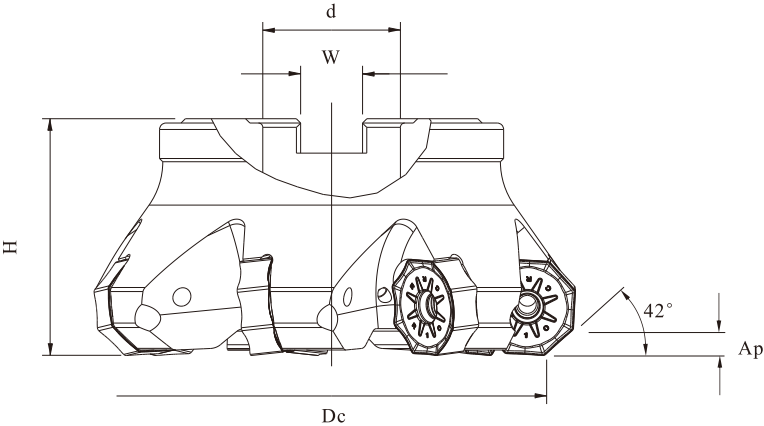
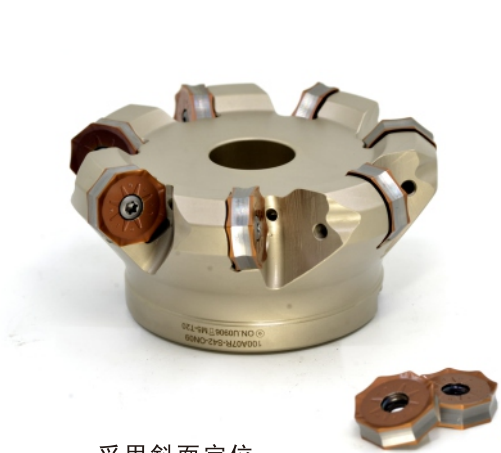
Ap max<5.0mm

工件材料	材料硬度	材质选择	线速度Vc m/min	每齿进给量 fz mm/t	
				42° 刀盘	16° 刀盘
碳钢 S45C, S50C	~220HB	CP2645T CP2445	100-250	0.1-0.4	0.2-0.4
合金钢 20CrMoTi, 42CrMo	~200HB	CP2645T CP2430	100-200	0.1-0.4	0.2-0.4
五金模具钢 SKD61 (H13), SKD11	350HB	CP2645T CP2445	100-150	0.1-0.3	0.2-0.3
模具钢 P20, 718, 738	HRC28-32	CP2645T CP2445	100-180	0.1-0.4	0.2-0.4
塑胶模具钢及不锈钢 S136H, NAK80, 4Cr13	HRC30-40	CP2645T CP2430	100-150	0.1-0.35	0.1-0.2
不锈钢 304, 316	200HB	CP2645T CP1120H	100-150	0.07-0.3	0.2-0.3
镍基高温合金 718	HRC38-45	CP2645T CP1120H CPA2140K	60-120	0.07-0.3	0.1-0.2
灰口铸铁 FC250, HT250	~200HB	CP1120H CPA2145	120-220	0.1-0.4	0.2-0.4
球墨铸铁 FCD400, QT300, 400, 500, 600	~200HB	CP1120H CPA2145	120-200	0.1-0.4	0.2-0.4

CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting



ONMU0905 42°刀盘 重切削加工
用于ONMU0905 刀片



- 采用斜面定位:
- 1. 提高定位的可靠性,提升刀片寿命30%;
 - 2. 提升刀盘的刀片跳动精度<0.03mm。

型 号		Ap	刃 数	样 式	尺寸 mm				 cooling	 螺钉	 扳手	 刀片型号
					Dc	d	H	W				
刀 盘	80A06R-S42-ON09-W	4.5	6	1	80	27	50	12.4	●	MS50120	T20	ONMU0905
	100A07R-S42-ON09-W	4.5	7	1	100	32	50	14.4	●			
	125A8R-S42-ON09-W	4.5	8	1	125	40	63	16.4	●			
	160A10R-S42-ON09-W	4.5	10	1	160	40	63	16.4	●			
	200A10R-S42-ON09-W	4.5	10	2	200	60	63	25.7	●			
	250A12R-S42-ON09-W	4.5	12	2	250	60	63	25.7	●			
	315A18R-S42-ON09-W	4.5	18	2	315	60	63	25.7	●			

SDMT09TXX 铣削刀片

SDMT09T3XX milling insert



特点:

- 刃口锋利，切削轻快，耐磨性好，
- 稳定性高，专用于背铣加工；
- 性能超越进口同类顶级产品。

被加工对象:

高温合金，不锈钢，钛合金，加工。

Feature:

- Sharp edge, Light cutting, good wear resistance,
- Specially used for back milling.
- Performance exceed famous brand.

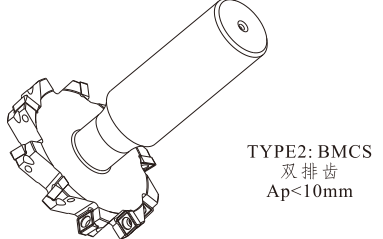
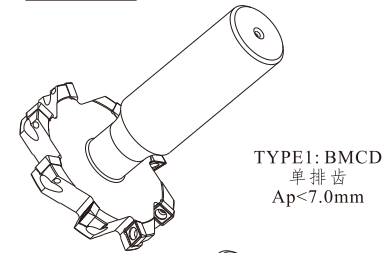
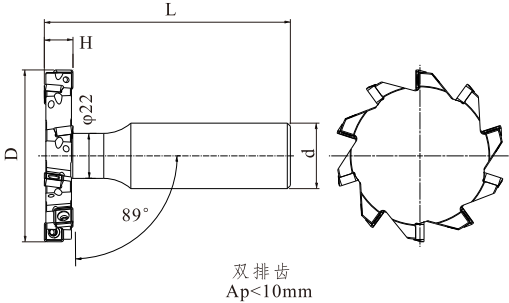
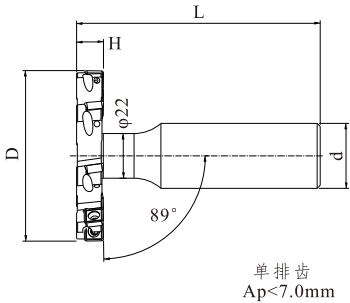
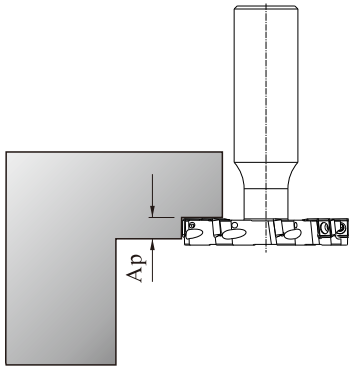
Application:

- Stainless steel, Titanium alloy, Heat resisting alloy,
- Die steel, Nodular cast iron.

PVD Coating			
CP2640T CP2645T	CPA1140H		加工参数 parameters
			Vc (mm/min)
✳			120-160-250
✳			100-130-160
	●		50-80-120
✳	●		60-110-150
✳	●		150-180-220
	●		40-60-80
✳	●		40-60-100
			Ap(mm) f (mm/t)
✳	●		5-7mm 0.05-0.10

背铣刀盘

Back milling cutter



本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

型号		刃数	样式	尺寸 mm				内冷	螺钉	扳手	刀片型号
				D	d	H	L				
刀盘	BMCD84X14-S32-SD09-8T	8	1	84	32	14	120		MS3580	T20	SDMT09T308 SDMT09T311 SDMT09T315 SDMT09T320
	BMCD100X14-S32-SD09-8T	8	1	100	32	14	120				
	BMCD125X14-S32-SD09-8T	8	1	125	32	14	120				
	BMCS84X14-S32-SD09-10T	10	2	84	32	14	120				
	BMCS100X14-S32-SD09-10T	10	2	100	32	14	120				
	BMCS125X14-S32-SD09-10T	10	2	125	32	14	120				

P3204 型精加工球头铣刀片

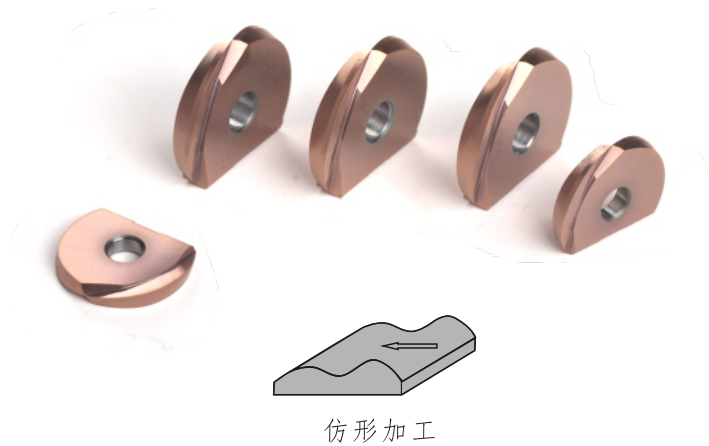
1.特点：

全新的设计理念，提升母材性能，搭配重新调整设计涂层，带来通用性极强的铣刀片。

2.加工对象及范围：

CP2630T：广泛地用于**模具钢半精及精**加工，从软钢到热处理淬火钢一款完成,加工硬度达到HRC<50，VC=50-220m/min;且兼容**通用材质** 加工不锈钢和高温合金加工，抗冲击能力极强；
CP1125H：用于**模具钢精**加工，加工硬度达到HRC50~62，VC=20-120m/min，耐磨性极强。

3.同欧洲WALTER同款通装。

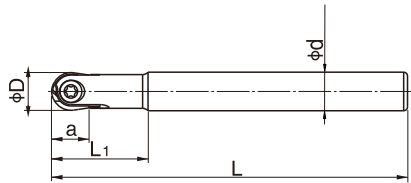


●：连续加工 ●：不规则形状加工 ✖：断续加工 ●：首选；○ 可选

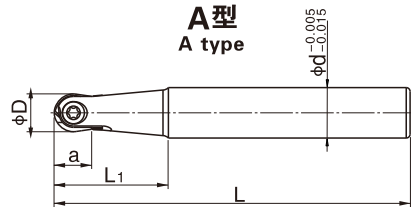
工件材质	P	模具钢 HRC<50	✖	✖		
	P	模具钢 HRC50-63	✖			
	S	不锈钢，钛合金，可伐合金	✖	✖		
	N	有色金属				✖
	S	耐热合金	✖	✖		
	K	铸铁		✖		
型号规格			PVD涂层		金属陶瓷	硬质合金
			CP1125H	CP2630T	CT20	CW20
精加工球头铣刀						
P3204-D10			●	●		●
P3204-D12			●	●		●
P3204-D16			●	●		●
P3204-D20			●	●		●
P3204-D25			●	●		●
P3204-D30			●	●		●
P3204-D32			●	●		●

同WALTER同款。

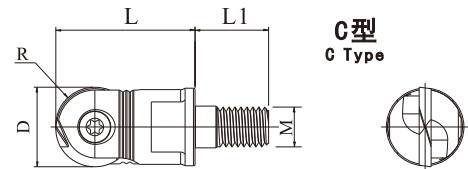
★ T2139 型精加工球头铣刀杆



A型
A type



B型
B type



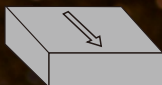
C型
C Type

本刀体材料均采用SKD61材料，热处理后加工，刚性好，抗震性能强，精度高，跳动在0.03mm内。
Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

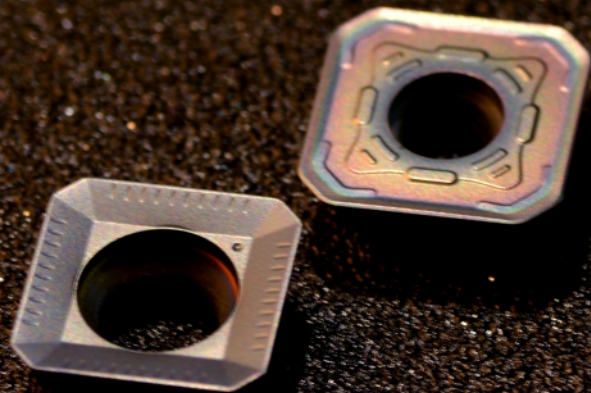
型号 MODEL NO.			尺寸 mm				螺钉 	扳手 	刀片型号 
			D	d M	L	L1			
刀 杆	T2139-R5-C10-130L	A	10	10	130	40	A40090-5R	T15	P320X-D10
	T2139-R5-C12-130L	B	10	12	130	50			
	T2139-R5-C12-160L	B	10	12	160	40			
	T2139-R6-C12-130L	A	12	12	130	40	A50090-6R	T20	P320X-D12
	T2139-R6-C16-160L	B	12	16	160	65			
	T2139-R8-C16-130L	A	16	16	130	60	A50130-8R	T20	P320X-D16
	T2139-R8-C16-160L	A	16	16	160	60			
	T2139-R8-C20-200L	B	16	20	200	80			
	T2139-R10-C20-160L	A	20	20	160	60	A50160-10R	T20	P320X-D20
	T2139-R10-C20-200L	A	20	20	200	80			
	T2139-R10-C25-250L	B	20	25	250	100			
	T2139-R12.5-C24-180L	A	25	25	180	65	A60210-12.5R	T30	P320X-D25
	T2139-R12.5-C32-200L	B	25	32	200	80			
	T2139-R12.5-C32-250L	B	25	32	250	100			
	T2139-R15-C32-200L	B	30	32	200	80	A80250-15R	T30	P320X-D30
	T2139-R15-C32-250L	B	30	32	250	100			
	T2139-R16-C32-200L	A	32	32	200	80	A80250-16R	T30	P320X-D32
	T2139-R16-C32-250L	A	32	32	250	100			
	T2139-R16-C42-300L	B	32	42	300	150			
	T2139-R16-C42-350L	B	32	42	350	200			
锁 牙 头	T2139-5R-M5	C	10	M5	21	11	A40090-5R	T15	P320X-D10
	T2139-6R-M6	C	12	M6	23	12.5	A50090-6R	T20	P320X-D12
	T2139-8R-M8	C	16	M8	28	16.5	A50130-8R	T20	P320X-D16
	T2139-10R-M10	C	20	M10	35	18.5	A50160-10R	T20	P320X-D20
	T2139-12.5R-M12	C	25	M12	43	22.5	A60210-12.5R	T30	P320X-D25
	T2139-15R-M16	C	30	M16	50	25	A80250-15R	T30	P320X-D30
	T2139-16R-M16	C	32	M16	52	25	A80250-16R	T30	P320X-D32

SEK(E)T 四方铣削刀片

SEK(E)T milling insert



平面加工



特点:

加工光洁度高, 耐磨性好, 稳定性高;

性能超越进口同类顶级产品。

被加工对象:

不锈钢, 高温合金, 模具钢, 铝合金加工。

Feature:

Machined surface finish, perfect abrasive resistance,

high stability and efficiency. Performance exceed famous brand.

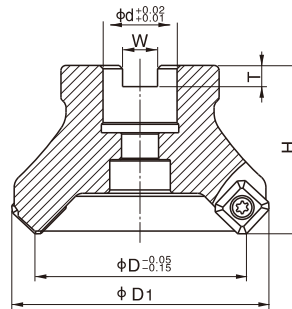
Application:

Stainless steel, Heat resisting alloy, Die steel, Aluminium alloy.

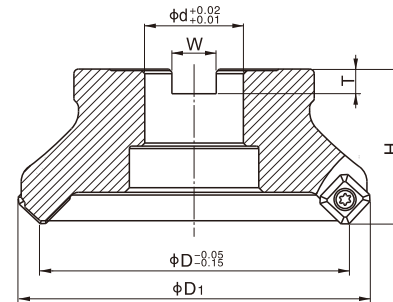
		PVD				加工参数 parameters		
		CP2630T	CP2430	CW20		Vc (mm/min)		
工件材质	P 钢件加工 Steel	●	●			120-160-250		
	P 模具钢 P20, 718, SKD11, S136H	●	●			100-130-160		
	P 淬火钢加工 HAC50-55 Steel					50-80-120		
	M 不锈钢 Stainless steel	●	●			60-110-150		
	N 铝合金 Aluminium alloy			●		150-180-220		
	S 钛合金 Titanium alloy	●	●			40-60-80		
	S 耐热合金 Heat-resisting steel	●	●			40-60-100		
型号规格 Type		用途 purpose			Ap (mm)		f (mm/t)	
SEET12T3-CM		不锈钢, 高温合金 钛合金, 低碳钢			●	●	0.1-4.0	0.05-0.2
SEKT1204AFEN-11		Stainless steel, steel Titanium alloy			●	●		
SEHT1204AFFN		Heat-resisting steel				●		

CP2430适合于干式或风冷切削. CP2430 Suitable For Dry Or Air-cooled Cutting

KM12 45° 壳形面铣刀



A型
A type



B型
B type

MODEL NO.	刃数	样式	尺寸 mm					螺钉 	扳手 	压板 	刀片型号
			D	D1	d	H	W				
KM12-50-22-4T	4	A	50	64	22	50	10.4	MS5087	T20		SE□T1204□□
KM12-63-22-5T	5	A	63	77	22	50	10.4				
KM12-80-27-6T	6	A	80	94	27	50	12.4				
KM12-100-32-7T	7	B	100	114	32	50	14.4				
KM12-125-40-8T	8	C	125	139	40	63	16.4				
KM12-160-40-10T	10	C	160	174	40	63	16.4				
KM12-200-60-12T	12	C	200	214	60	63	25.7				
KM12-250-60-12T	12	C	250	264	60	63	25.7	MS4080	T15		SEET12T3-CM
KM12T3-50-22-4T	4	A	50	64	22	50	10.4				
KM12T3-63-22-5T	5	A	63	77	22	50	10.4				
KM12T3-80-27-6T	6	A	80	94	27	50	12.4				
KM12T3-100-32-7T	7	B	100	114	32	50	14.4				
KM12T3-125-40-8T	8	C	125	139	40	63	16.4				
KM12T3-160-40-10T	10	C	160	174	40	63	16.4				

RP(M)KT 铣削圆刀片

RPM(K) T milling insert



特点:

刃口强度高, 耐磨性好, 稳定性高, 通用性强;
性能超越进口同类顶级产品。

被加工对象:

-GH: 不锈钢, 钛合金, 高温合金, 低碳合金钢加工。
-ST: 钢件及铸铁加工。

Feature:

Strong edge, perfect abrasive resistance, high stability, wide cutting scope.
Performance exceed famous brand.

Application:

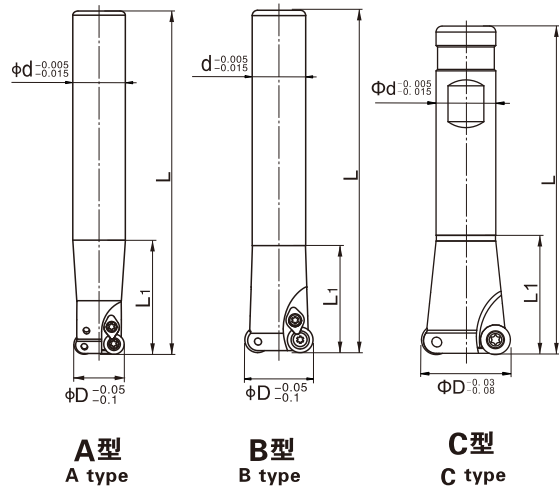
-GH: Stainless steel, Titanium alloy,
Heat resisting alloy, Low-carbon steel.
-ST: Steel, cast iron.

mous brand.		PVD			加工参数 parameters		
		CP2630T CP2640T	CP1120H	CP2430			
Titanium alloy,					Vc (mm/min)		
oy, Low-carbon steel.							
工件材质	P 钢件加工 Steel	✱		✱	120-160-250		
	P 模具钢 P20, 718, SKD11, S136H	✱		✱	100-130-160		
	P 淬火钢加工 HRC40-63 Steel		✱		50-80-120		
	M 不锈钢 Stainless steel	✱	✱	✱	60-110-150		
	K 铸铁 Cast iron	✱	✱	✱	150-180-220		
	S 钛合金 Titanium alloy	✱		✱	40-60-80		
	S 耐热合金 Heat-resisting steel	✱	✱		40-60-100		
型号规格		用途			Ap(mm)	f(mm/t)	
RPKT0802MO-GH		不锈钢 高温合金 钛合金 A3低碳钢	✱	✱	✱	0.15-0.30	0.25-0.4
RPKT08T2MO-GH			✱	✱	✱	0.15-0.30	0.25-0.4
RPKT1003MO-GH			✱	✱	✱	0.30-0.50	0.3-0.6
RPKT1204MO-GH			✱	✱	✱	0.30-0.50	0.3-0.6
RPKT10T3MO-JS		不锈钢 软钢 淬火钢 HRC50-63	✱	✱	✱	0.20-0.30	0.2-0.3
RPKT1204MO-JS			✱	✱	✱	0.20-0.30	0.2-0.3
RPMW1003MO-ST7			✱	✱	✱	0.20-0.30	0.2-0.3
RDMW1003MO-ST14			✱		✱	0.30-0.50	0.3-0.6
RDMW10T3MO-ST14		HRC<50 模具钢 S50C P20 718,738H 铸铁	✱		✱	0.30-0.50	0.3-0.6
RPMT1003MO-ST14			✱		✱	0.40-0.80	0.5-1.0
RPMT1204MO-ST14			✱		✱	0.30-0.50	0.3-0.6
RDMW1204MO-ST14			✱		✱	0.40-0.80	0.5-1.0
RDMW1604MO-ST14			✱		✱	0.60-1.20	0.8-1.5
RDMW1605MO-ST14			✱		✱	0.60-1.20	0.8-1.5

CP2430适合于干式或风冷切削.

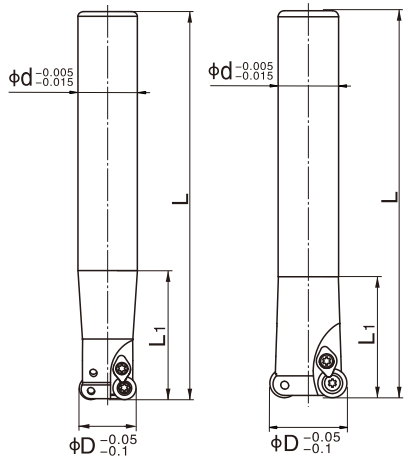
CP2430 suitable for dry or air-cooled cutting

★ EMR 型圆鼻立铣刀



型 号 MODEL NO.	刃 数	样 式	尺寸 mm								刀片型号
			D	d	L	L1	L2				
EMR-4Rx12x120	1	A	12	12	120	40	-	MS3070	T10F T10	—	RP□□0802
EMR-4Rx13x120-C12	1	B	13	12	120	40	-				
EMR-4Rx16x120	2	A	16	16	120	40	-	MS3070	T10F T10	A-4R	
EMR-4Rx16x160	2	A	16	16	160	40	-				
EMR-4Rx17x160-C16	2	B	17	16	160	40	-				
EMR-4Rx20x120	2	A	20	20	120	40	-				
EMR-4Rx20x160	2	A	20	20	160	50	-				
EMR-4Rx21x160-C20	2	B	21	20	160	50	-	MS4090 MS35100	T15F T15	A-5R	RP□□1003
EMR-5Rx20x120	2	A	20	20	120	50	-				
EMR-5Rx20x160	2	A	20	20	160	50	-				
EMR-5Rx21x160-C20	2	B	21	20	160	50	-				
EMR-5Rx25x120	2	A	25	25	120	50	-				
EMR-5Rx25x160	2	A	25	25	160	50	-				
EMR-5Rx25x200	2	A	25	25	200	75	-				
EMR-5Rx30x110-C20	2	C	30	20	110	40	-				
EMR-5Rx30x160-C25	2	B	30	25	160	50	-				
EMR-5Rx30x200-C25	2	B	30	25	200	50	-				
EMR-5Rx32x160	2	A	32	32	160	50	-				
EMR-5Rx32x200	2	A	32	32	200	60	-				
EMR-5Rx32x250	2	A	32	32	250	60	-				
EMR-5Rx35x160-C32	3	B	35	32	160	50	-				
EMR-5Rx35x200-C32	3	B	35	32	200	50	-				
EMR-5Rx35x250-C32	3	B	35	32	250	60	-				
EMR-5Rx40x160-C32	4	B	40	32	160	50	-				
EMR-5Rx40x200-C32	4	B	40	32	200	50	-				
EMR-5Rx40x250-C32	4	B	40	32	250	60	-				

EMRW型圆鼻立铣刀



A型
A type

B型
B type

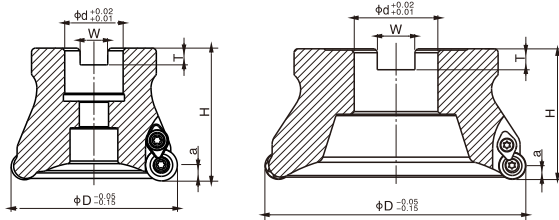
型号 MODEL NO.	刃数	样式	尺寸 mm					螺钉 	扳手 	压板 	刀片型号
			D	d	L	L1	L2				
EMRW-6Rx25x160	2	A	25	25	160	50	-	MS40100 MS40100	T15F T15	A-6R	RP□□1204
EMRW-6Rx32x160	2	A	32	32	160	50	-				
EMRW-6Rx32x200	2	A	32	32	200	60	-				
EMRW-6Rx32x250	2	A	32	32	250	60	-				
EMRW-6Rx35x160-C32	3	B	35	32	160	50	-				
EMRW-6Rx35x200-C32	3	B	35	32	200	60	-				
EMRW-6Rx35x250-C32	3	B	35	32	250	60	-				
EMRW-6Rx35x300-C32	3	B	35	32	300	60	-				
EMRW-6Rx40x160-C32	3	B	40	32	160	60	-				
EMRW-6Rx40x200-C32	3	B	40	32	200	60	-				
EMRW-6Rx40x250-C32	3	B	40	32	250	60	-				
EMRW-6Rx40x300-C32	3	B	40	32	300	60	-				

★ EMRF 型圆鼻立铣刀(不锈钢及高温合金叶片加工专用)

型号 MODEL NO.	刃数	样式	尺寸 mm					螺钉 	扳手 	压板	刀片型号
			D	d	L	L1	L2				
EMRF-5Rx25x160	2	A	25	25	160	60	-	MS4090 MS35100	T15F T15	A-5R	RPHT10T3MO-SF
EMRF-5Rx32x160	2	A	32	32	160	60	-				
EMRF-5Rx35x160-C32	3	B	35	32	160	60	-				
EMRF-5Rx35x200-C32	3	B	35	32	200	60	-				
EMRF-6Rx35x160-C32	3	B	40	32	160	60	-	MS40100 MS40100	T15F T15	A-6R	RPHT1204MO-SF
EMRF-6Rx35x200-C32	3	B	40	32	200	60	-				
EMRF-6Rx40x160-C32	3	B	40	32	250	60	-				
EMRF-6Rx40x200-C32	3	B	40	32	300	60	-				

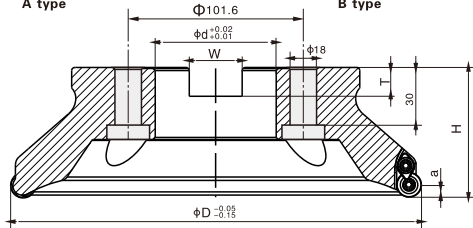
★ EMR,EPRW 型圆鼻壳形面铣刀

EMRF 型(不锈钢及高温合金叶片加工专用)



A型
A type

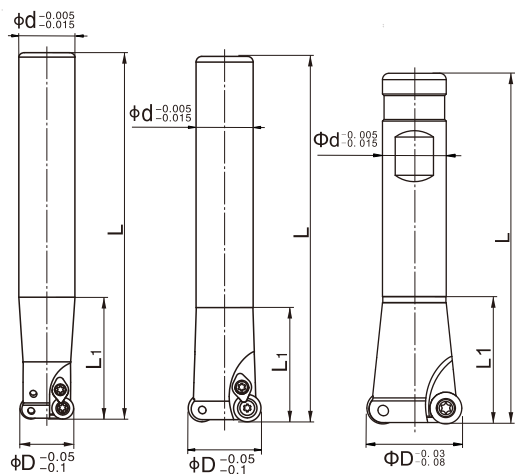
B型
B type



C型
C type

MODEL NO.	刃数	样式	尺寸 mm					螺钉 	扳手 	压板 	刀片型号
			D	d	H	W	T				
EMR-4R-40-16	4	A	40	16	42	8.4	6.3	MS3070	T10F T10	A-4R	RP□□0802
EMR-4R-50-22	5	A	50	22	42	10.4	6.3				
EMR-5R-50-22	4	A	50	22	50	10.4	6.3				
EMR-5R-63-22	5	A	63	22	50	10.4	6.3	MS4090 MS35100	T15F T15	A-5R	RP□□1003
EMR-5R-80-27	6	A	80	27	50	12.4	7				
EMR-5R-100-32	6	B	100	32	50	14.4	8				
EMR-5R-50-25.4	4	A	50	25.4	50	10	6				
EMR-5R-63-25.4	5	A	63	25.4	50	10	6				
EMR-5R-80-25.4	6	A	80	25.4	50	12	6				
EMRW-6R-50-22	4	A	50	22	50	10.4	6.3	MS40100 MS40100	T15F T15	A-6R	RP□□1204MO
EMRW-6R-63-22	5	A	63	22	50	10.4	6.3				
EMRW-6R-80-27	6	A	80	27	50	12.4	7				
EMRW-6R-100-32	6	B	100	32	50	14.4	8				
EMRW-6R-125-40	6	B	125	40	63	16.4	9				
EMRW-6R-160-40	8	B	160	40	63	16.4	9				
EMRW-6R-200-60	10	C	200	60	63	25.7	14				
EMRW-6R-50-25.4	4	A	50	25.4	50	10	6				
EMRW-6R-63-25.4	5	A	63	25.4	50	10	6				
EMRW-6R-80-25.4	6	A	80	25.4	50	12	6				
EMRF-6R-40-16	4	A	40	16	42	8.4	6.3	MS40100 MS40100	T15F T15	A-6R	RPHT1204MO-SS
EMRF-6R-50-22	4	A	50	22	50	10.4	6.3				
EMRF-6R-63-22	4	A	63	22	50	10.4	6.3				

★ TRS 型圆鼻立铣刀



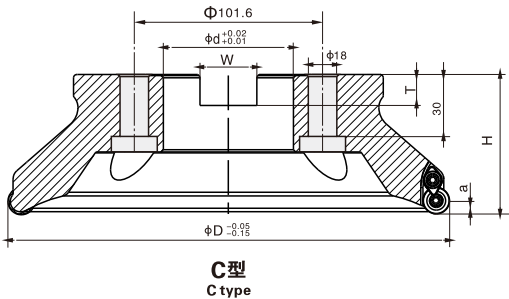
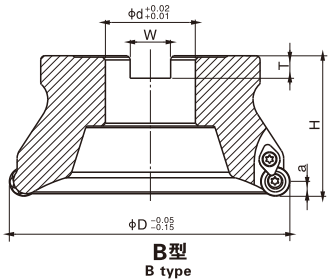
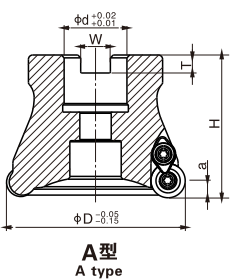
A型
A type

B型
B type

C型
C type

MODEL NO.	刃数	样式	尺寸 mm					螺钉 	扳手 	压板 	刀片型号
			D	d	L	L1	L2				
TRS-5Rx20x120	2	A	20	20	120	50	-	MS4090 MS35100	T15F T15	A-5R	RD□□10T3
TRS-5Rx20x160	2	A	20	20	160	50	-				
TRS-5Rx21x160-C20	2	B	21	20	160	50	-				
TRS-5Rx25x120	2	A	25	25	120	50	-				
TRS-5Rx25x160	2	A	25	25	160	50	-				
TRS-5Rx25x200	2	A	25	25	200	75	-				
TRS-5Rx30x110-C20	2	C	30	20	110	60	-				
TRS-5Rx30x160-C25	2	B	30	25	160	60	-				
TRS-5Rx30x200-C25	2	B	30	25	200	60	-				
TRS-5Rx32x160	2	A	32	32	160	60	-				
TRS-5Rx32x200	2	A	32	32	200	75	-				
TRS-5Rx32x250	2	A	32	32	250	100	-				
TRS-5Rx35x160-C32	3	B	35	32	160	60	-				
TRS-5Rx35x200-C32	3	B	35	32	200	60	-	MS40100 MS40100	T15F T15	A-6R	RDMW1204MO
TRS-5Rx35x250-C32	3	B	35	32	250	60	-				
TRS-5Rx40x160-C32	4	B	40	32	160	60	-				
TRS-5Rx40x200-C32	4	B	40	32	200	60	-				
TRS-5Rx40x250-C32	4	B	40	32	250	60	-				
TRS-6Rx32x160	2	A	32	32	160	60	-				
TRS-6Rx32x200	2	A	32	32	200	60	-				
TRS-6Rx32x250	2	A	32	32	250	60	-				
TRS-6Rx35x160-C32	3	B	35	32	160	60	-				
TRS-6Rx35x200-C32	3	B	35	32	200	60	-				
TRS-6Rx35x250-C32	3	B	35	32	250	60	-				
TRS-6Rx40x160-C32	3	B	40	32	160	60	-				
TRS-6Rx40x200-C32	3	B	40	32	200	60	-				
TRS-6Rx40x250-C32	3	B	40	32	250	60	-				

★ TRS 型圆鼻壳形面铣刀



MODEL NO.	刃数	样式	尺寸 mm					螺钉 	扳手 	压板 	刀片型号
			D	d	H	W	T				
TRS-5R-50-22	4	A	50	22	50	10.4	6.3	MS4090 MS35100	T15F T15	A-5R	RD□□10T3
TRS-5R-63-22	5	A	63	22	50	10.4	6.3				
TRS-5R-80-27	6	A	80	27	50	12.4	7				
TRS-5R-100-32	6	B	100	32	50	14.4	8				
TRS-5R-50-25.4	4	A	50	25.4	50	10	6				
TRS-5R-63-25.4	5	A	63	25.4	50	10	6				
TRS-5R-80-25.4	6	A	80	25.4	50	12	6	MS40100 MS40100	T15F T15	A-6R	RDMW1204MO
TRS-6R-50-22	4	A	50	22	50	10.4	6.3				
TRS-6R-63-22	5	A	63	22	50	10.4	6.3				
TRS-6R-80-27	6	A	80	27	50	12.4	7				
TRS-6R-100-32	6	B	100	32	50	14.4	8				
TRS-6R-125-40	6	B	125	40	63	16.4	9				
TRS-6R-160-40	8	B	160	40	63	16.4	9				
TRS-6R-200-60	10	C	200	60	63	25.7	14				
TRS-6R-50-25.4	4	A	50	25.4	50	10	6				
TRS-6R-63-25.4	5	A	63	25.4	50	10	6				
TRS-6R-80-25.4	6	A	80	25.4	50	12	6				

APMT 铁削刀片

APMT milling insert



B-60

特点:

刃口强度高, 耐磨性好, 稳定性高, 通用性强;

性能超越进口同类顶级产品。

被加工对象:

-M2: 不锈钢, 钛合金, 高温合金, 低碳合金钢加工。

-H2& PDTR: 钢件及铸铁加工;

CP1120H: 专用于加工HAC40-63淬火钢。

Feature:

Strong edge, perfect abrasive resistance, high stability, wide cutting scope.

Performance exceed famous brand.

Application:

-M2: Stainless steel, Titanium alloy,
Heat resisting alloy, Low-carbon steel.

-SS&PDTR: Steel, Cast iron.

ation:

2: Stainless steel, Titanium alloy,
eat resisting alloy, Low-carbon steel.

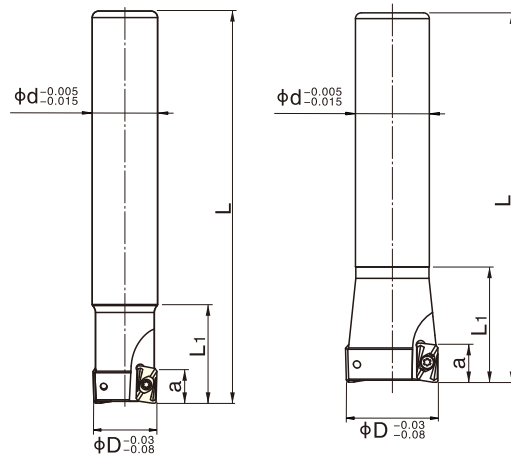
S&PDTR: Steel, Cast iron.

		PVD					
		CP2630T	CP1120H	CP2430	加工参数 parameters		
					Vc (mm/min)		
工件材质	P 钢件加工 Steel	✱		✱	120-160-250		
	P 模具钢 P20, 718, SKD11, S136H	✱		✱	100-130-160		
	P 淬火钢加工 HAC40-63 Steel		✱		50-80-120		
	M 不锈钢 Stainless steel	✱	✱	✱	60-110-150		
	K 铸铁 Cast iron	✱		✱	150-180-220		
	S 钛合金 Titanium alloy	✱		✱	40-60-80		
S 耐热合金 Heat-resisting steel	✱	✱	✱	40-60-100			
型号规格		用途			Ap(mm)	f (mm/ t)	
APMT1135PDER-M2		不锈钢 高温合金 钛合金 淬火钢		✱	✱	0.25-0.35	0.25-0.4
APMT1604PDER-M2				✱	✱	0.3-0.6	0.3-0.6
APMT1135PDER-H2		模具钢 S50C, P20 718, 738H 淬火钢 铸铁	✱	✱	✱	0.20-0.35	0.25-0.4
APMT1604PDER-H2			✱	✱	✱	0.30-0.60	0.3-0.6
APMT1135PDTR			✱		✱	0.20-0.35	0.3-0.5
APMT1605PDTR			✱		✱	0.40-0.70	0.5-0.8

CP2430适合于干式或风冷切削。

CP2430 suitable for dry or air-cooled cutting

★ BAP 直角台肩立铣刀

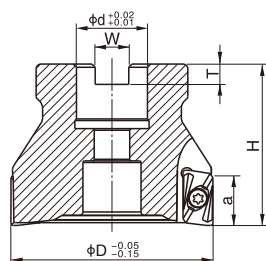


A型
A type

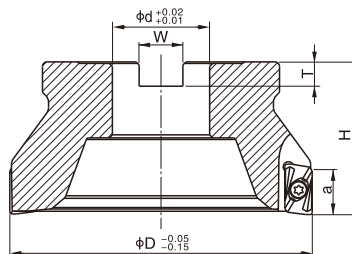
B型
B type

MODEL NO.	刃数	样式	尺寸 mm					螺钉 	扳手 	压板 	刀片型号
			D	d	L	L1	L2				
BAP300R-10X120	1	A	10	10	120	30	-	MS2550 	T8F T8 		AP001135
BAP300R-12X120	1	A	12	12	120	30	-				
BAP300R-13X120-C12	1	B	13	12	120	30	-				
BAP300R-16X120	2	A	16	16	120	40	-	MS2560 	T8F T8 		AP001135
BAP300R-16X160	2	A	16	16	160	40	-				
BAP300R-17X160-C16	2	B	17	16	160	40	-				
BAP300R-20X120	3	A	20	20	120	40	-				
BAP300R-20X160	3	A	20	20	160	50	-				
BAP300R-21X120-C20	3	A	21	20	120	40	-				
BAP300R-21X160-C20	3	A	21	20	160	50	-				
BAP300R-25X160	3	A	25	25	160	50	-				
BAP300R-25X200	3	A	25	25	200	75	-				
BAP300R-30X160-C25	3	B	30	25	160	50	-				
BAP300R-30X200-C25	3	B	30	25	200	75	-	MS4090 	T15F T15 		AP001604
BAP400R-25X160	3	A	25	25	160	50	-				
BAP400R-25X200	3	A	25	25	200	75	-				
BAP400R-26X160-C25	3	B	26	25	160	50	-				
BAP400R-26X200-C25	3	B	26	25	200	50	-				
BAP400R-32X160-C25	3	B	32	25	160	50	-				
BAP400R-32X200-C25	3	B	32	25	200	50	-				
BAP400R-32X160	3	A	32	32	160	50	-				
BAP400R-32X200	3	A	32	32	200	80	-				
BAP400R-32X250	3	A	32	32	250	80	-				
BAP400R-35X160-C32	3	B	35	32	160	50	-				
BAP400R-35X200-C32	3	B	35	32	200	50	-				
BAP400R-35X250-C32	3	B	35	32	250	60	-				
BAP400R-40X160-C32	4	B	40	32	160	50	-				
BAP400R-40X200-C32	4	B	40	32	200	50	-				

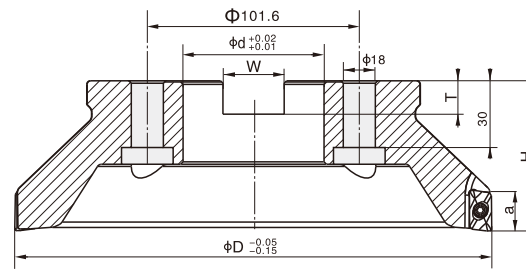
★ BAP 直角台肩壳形面铣刀



A型
A type



B型
B type

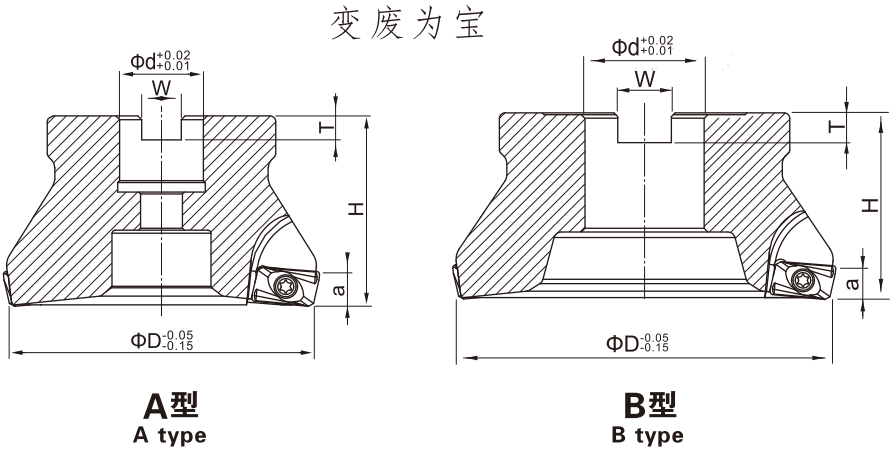


C型
C type



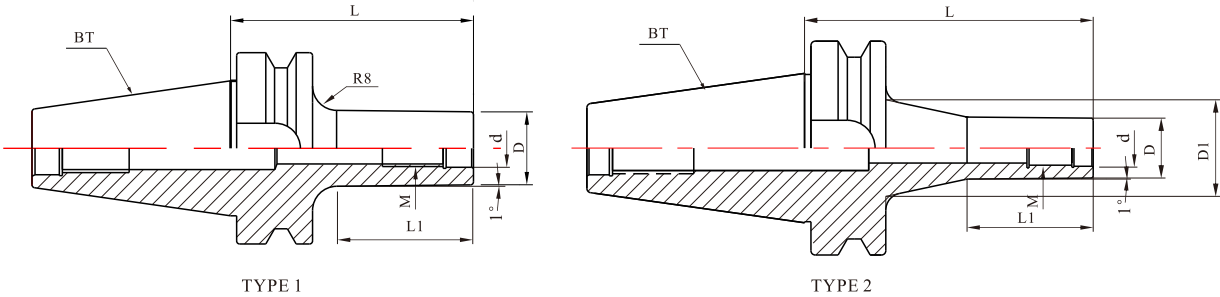
型号 MODEL NO.	刃数	样式	尺寸 mm					螺钉 	扳手 	压板 	刀片型号
			D	d	H	W	T				
BAP300R-40-16	4	A	40	16	42	8.4	6.3	MS2560	T8F T8		AP□□1135
BAP300R-50-22	4	A	50	22	50	10.4	6.3				
BAP400R-50-22	4	A	50	22	50	10.4	6.3	MS4090	T15F T15		AP□□1604
BAP400R-63-22	5	A	63	22	50	10.4	6.3				
BAP400R-80-27	6	A	80	27	50	12.4	7				
BAP400R-100-32	6	B	100	32	50	14.4	8				
BAP400R-125-40	8	B	125	40	63	16.4	9				
BAP400R-160-40	9	B	160	40	63	16.4	9				
BAP400R-200-60	9	C	200	60	63	25.7	14				
BAP400R-50-25.4	4	A	50	25.4	50	10	6				
BAP400R-63-25.4	5	A	63	25.4	50	10	6				
BAP400R-80-25.4	6	A	80	25.4	50	12	6				

★ RAP 壳形面铣刀
(使用APMT1604刀片另外两个角)



MODEL NO.	刃数	样式	尺寸					螺钉 	扳手 	压板 	刀片型号
			D	d	H	W	T				
RAP400R-63-22	4	A	63	22	50	10.4	6.3	MS4090	T15F T15		AP□□1604
RAP400R-80-27	5	A	80	27	50	12.4	7				
RAP400R-100-32	6	B	100	32	50	14.4	8				
RAP400R-125-40	6	B	125	40	63	16.4	9				

锁牙头刀柄



型号		锥柄	样 式	尺寸 mm					
				D	d	D1	L	L1	M
直 身	BT40-SOM12-45-80	BT40	1	23	12.5	33	80	45	M12x1.75
	BT40-SOM16-65-100			30	17	40	100	65	M16x2.0
	BT50-SOM12-34-70	BT50	1	23	12.5	33	70	34	M12x1.75
	BT50-SOM12-54-100			23	12.5	33	100	54	M12x1.75
	BT50-SOM16-59-105			30	17	40	105	59	M16X2.0
	BT50-SOM16-104-150			30	17	40	150	104	M16X2.0
锥 度 头	BT40-SOM8-15-75-A	BT40	2	14.7	8.5	25	75	15	M8X1.25
	BT40-SOM10-25-85-A			18.7	10.5	29	85	25	M10X1.5
	BT40-SOM12-30-90-A			23	12.5	33	90	30	M12X1.75
	BT40-SOM12-60-120-A			23	12.5	33	120	60	M12X1.75
	BT40-SOM16-40-100-A			30	17	40	100	40	M16X2.0
	BT40-SOM16-80-140-A			30	17	40	140	80	M16X2.0
	BT50-SOM8-15-90-A	BT50	2	14.7	8.5	25	90	15	M8X1.25
	BT50-SOM10-25-100-A			18.7	10.5	29	100	25	M10X1.5
	BT50-SOM12-30-105-A			23	12.5	33	105	30	M12X1.75
	BT50-SOM12-55-130-A			23	12.5	33	130	55	M12X1.75
	BT50-SOM16-40-115-A			30	17	40	115	40	M16X2.0
	BT50-SOM16-80-155-A			30	17	40	155	80	M16X2.0