

PH HORN PH



整体硬质合金立铣刀

SOLID CARBIDE MILLS

2023/2024



探索 HORN
EXPLORE HORN

尊敬的HORN用户

卓越的结果总是最佳的加工工艺和完美的工具的结合。为了实现这一目标，HORN结合了先进的技术、性能和可靠性。从单个零件到批量生产，适用于标准或特殊应用：我们的工具为您提供快速，经济，高质量的解决方案。为了帮助您选择切削参数，我们目录中的表各自提供了经过验证的经验值。充分利用我们办公室职员和销售工程师的专业知识。

可持续发展是我们企业理念的核心部分。这就是为什么我们一直关注产品和生产的质量保证、环境保护、能源效率和安全。作为高效可靠的刀具合作伙伴，我们确信您与我们一起创建一个创新和强大的经济未来。



Markus Horn
首席执行官
Paul Horn GmbH



Matthias Rommel
首席执行官
Paul Horn GmbH

Explore HORN

Exceptional results are always a combination of the optimum cutting process and the perfect tool. To achieve this, HORN combines advanced technology, performance and reliability. From single part to series production, for standard or special applications: Our tools offer you fast, economical, high quality solutions. To assist you when choosing cutting parameters, our tables in the respective catalogue provide proven empirical values. Take advantage of the expertise of our office staff and sales engineers.

Sustainability is a central part of our corporate philosophy. That is why we have always focused on quality assurance, environmental protection, energy efficiency and safety with regard to our products and our production. As an efficient and reliable tool partner, we make sure that you join us in an innovative and strong economic future.



Markus Horn
CEO
Paul Horn GmbH



Matthias Rommel
CEO
Paul Horn GmbH

- A 系列 DP - 普通钢**
System DP - Common steels
- B 系列 DS - 高强度钢件**
System DS - High tensile steels
- C 系列 DS - 高硬度钢件**
System DS - Hardened steels
- D 系列 DS - 钴铬合金**
System DS - Cobalt Chromium steels
- E 系列 DS - 钛合金**
System DS - Titanium
- F 系列 DS - 铝合金**
System DS - Aluminium
- G 系列 DG - 可换刀头系列**
System DG - System with exchangeable cutter heads

A

B

C

D

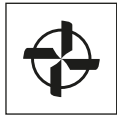
E

F

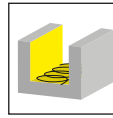
G

	材料 Material		材料示例 Example Material	硬度 HB Hardness
P3.1	高合金钢 High alloyed steel	退火 annealed	X10CrAl18	200
P3.2		硬化 hardened	X210Cr2	350
P4.1	铸钢 Cast steel	非合金 unalloyed	GE200	180
P4.2		合金 alloyed	GX40CrSi28	220
P5.1	粉末冶金钢 Sintered steel	软质 soft	Sint-D39	220
M1.1	不锈钢 Stainless steel	马氏体,铁素体 martensitic, ferritic	X16Cr13	200
M1.2		奥氏体 austenitic	X6CrNiMoTi17-12-2	300
M1.3		奥氏体,铁素体 austenitic, ferritic	X2CrNiMoN17-13-3	230
K1.1	灰铸铁 Grey cast iron	低拉伸强度 low tensile strength	GG-25	180
K1.2		高拉伸强度 high tensile strength	GG-40	250
K2.1	球磨铸铁 Spheroidal graphite cast iron	铁素体 ferritic	GGG-40	160
K2.2		珠光体 perlitic	GGG-60	260
K3.1	可锻铸铁 Malleable cast iron	铁素体 ferritic	GTW-45	200
K3.2		珠光体 perlitic	GTS-55-04	260
K4.1	奥氏体球墨铸铁 Ausferritic spheroidal cast iron ADI	调质 quenched		260
K4.2		调质 quenched		350
K4.3		调质 quenched		450
N1.1	铝合金 Al alloys	非热处理 not heat treatable	AlMg1	30
N1.2		热处理 heat treatable	AlMgSi1	100
N2.1	铸铝合金 Al cast alloys	< 6% Si	AlMgSi6	80
N2.2		6-10% Si	AlSi7Mg	100
N2.3		10-15 % Si	AlSi12	130
N3.1	铜合金 Copper alloys	纯铜 pure copper	Cu	100
N3.2		黄铜,青铜 brass	CuZn40Pb	90
N3.3		无铅黄铜 lead-free brass	CuZn40	110
N3.4		高强度 high strength	CuZn25Al5Mn4Fe3	300
N4.1	石墨 Graphite			

	材料 Material		材料示例 Example Material	硬度 HB Hardness
S1.1	耐热合金(铁基) Heat resistant alloys (Fe)	退火 annealed		200
S1.2		硬化 hardened		275
S2.1	耐热合金(镍基,钴基) Heat resistant alloys (Ni, Co)	退火 annealed	Inconel 600	250
S2.2		硬化 hardened	Inconel 713	350
S3.1	钛 Titanium	钛合金 α Titanium alloys α	Ti99,7	120
S3.2		钛合金 α - β Titanium alloys α - β	Ti6Al4V	360
S3.3		钛合金 β Titanium alloys β	Ti-10V-2Fe-3Al	410
H1.1	淬硬钢 Hardened steels	50-55 HRC	-	-
H1.2		55-60 HRC	-	-
H1.3		60-63 HRC	-	-
H1.4		> 63HRC	-	-



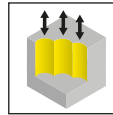
刃口过中心切削
Centre cutting



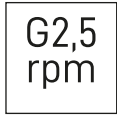
摆线铣削
Trochoidal milling



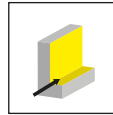
齿数
Number of teeth



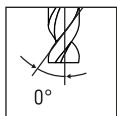
坡走铣
Diving



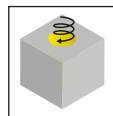
动平衡
Balance quality



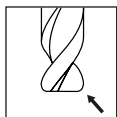
轮廓修饰
Trimming



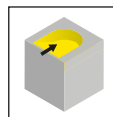
螺旋角
Helix angle



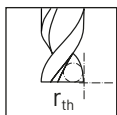
圆弧插铣
Circular plunging



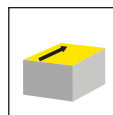
刀尖圆角
Corner radius



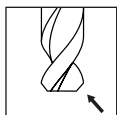
破走
Ramping



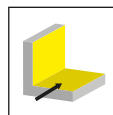
理论圆角
Radius theoretic



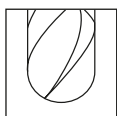
平面铣削
Face milling



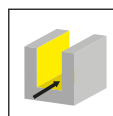
刀尖倒角
Corner chamfer



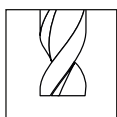
方肩铣削
Corner milling



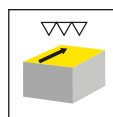
球头铣刀
Full radius



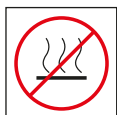
槽铣削
Slot milling



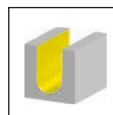
平头铣刀
Sharp



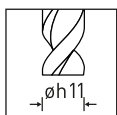
精加工
Finishing



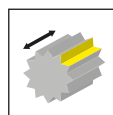
不可热缩
Do NOT heat shrink



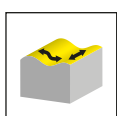
槽铣削
Full radius groove milling



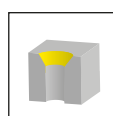
公差
Tolerance



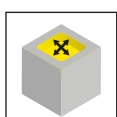
齿轮铣削
Gear milling



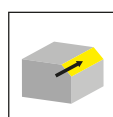
仿形铣削
Copy milling



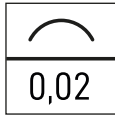
倒角铣削
Chamfer milling



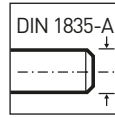
Taschenfräsen
Pocket milling



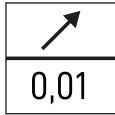
倒角
Chamfering



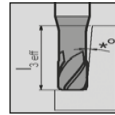
轮廓公差
Form tolerance



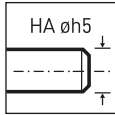
刀柄按 DIN 1835 A
Shank DIN 1835 A



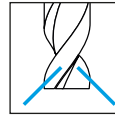
跳动
Run-out



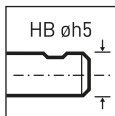
有效颈部长
Effective neck length



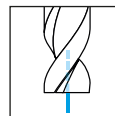
刀柄按 DIN 6535 HA
Shank DIN 6535 HA



内冷, 径向
Internal cooling



刀柄按 DIN 6535 HB
Shank DIN 6535 HB



内冷, 轴向
Internal cooling, centered

一般信息

General Information

- 除非另有说明, 所有尺寸均以毫米为单位。
All dimensions are in mm unless otherwise noted.
- 可根据要求订制更多尺寸和形式。
Further dimensions and versions are available on request.
- 交货期 / Delivery times
 - ▲ 库存 / on stock
 - △ 4周 / 4 weeks
- 根据材料组使用 / Use for material groups
 - 推荐 / recommended
 - 次推荐 / alternative recommended
 - 不合适 / not suitable

	DPSG.3	开粗立铣刀 Roughing End Mill	Ø 2 - Ø 20	Z 3	12 - 13
	DPSG.4	开粗立铣刀 Roughing End Mill	Ø 3 - Ø 20	Z 4	14 - 15
	DPSV	立铣刀 HPC End Mill HPC	Ø 4 - Ø 20	Z 4	16 - 17
	DPX	立铣刀 HPC End Mill HPC	Ø 3 - Ø 16	Z 4	18 - 21
	DPSB	开粗立铣刀 Roughing End Mill	Ø 4 - Ø 20	Z 4	22 - 23
	DPS	开粗立铣刀, 锯齿轮廓 Roughing End Mill with ripper profile	Ø 4 - Ø 20	Z 3-6	24 - 25
	DPT	立铣刀, 平头 End Mill, sharp	Ø 1 - Ø 16	Z 4	26 - 27
	DPTR.2	环面立铣刀 Torus End Mill	Ø 3 - Ø 20	Z 2	28 - 29
	DPTR.4	环面立铣刀 Torus End Mill	Ø 3 - Ø 20	Z 4	30 - 31
	DPM	多刃立铣刀 End Mill multiple fluted	Ø 6 - Ø 20	Z 6-8	32 - 33
	DPK.2	球头立铣刀 Ball Nose End Mill	Ø 1 - Ø 16	Z 2	34 - 35
	DPK.3	球头立铣刀 Ball Nose End Mill	Ø 1,5 - Ø 20	Z 3	36 - 37
	DPK.4	球头立铣刀 Ball Nose End Mill	Ø 1 - Ø 20	Z 4	38 - 39
	DPFF	倒角立铣刀 Chamfering End Mill	Ø 4 - Ø 12	Z 4	40 - 41

DP

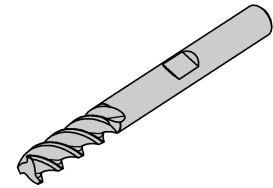
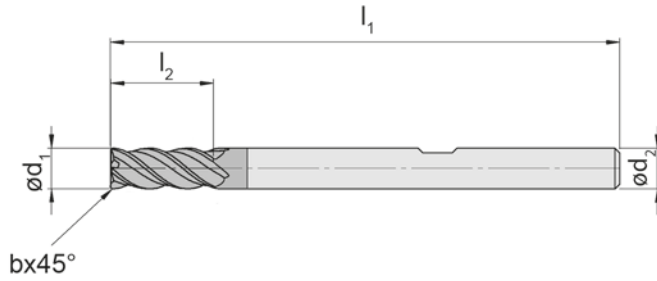
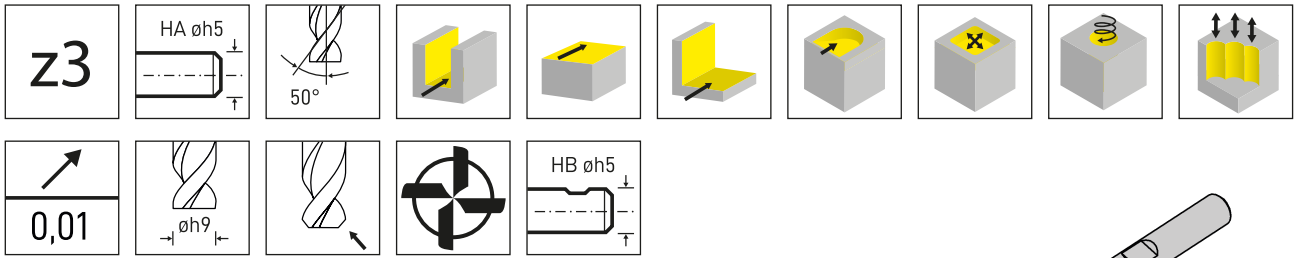


整体硬质合金立铣刀

设计用于：
- 常规钢件材料

Solid Carbide End Mills

designed for:
- all common steel materials



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPSG.3.02.010.03.08	2	0.1	8	3	40	3	HA	▲
DPSG.3.03.010.03.10	3	0.1	10	3	40	3	HA	▲
DPSG.3.04.010.04.12	4	0.1	12	4	50	3	HA	▲
DPSG.3.05.015.05.15	5	0.15	15	5	50	3	HA	▲
DPSG.3.06.015.06.15	6	0.15	15	6	65	3	HB	▲
DPSG.3.08.020.08.20	8	0.2	20	8	65	3	HB	▲
DPSG.3.10.020.10.22	10	0.2	22	10	70	3	HB	▲
DPSG.3.12.025.12.25	12	0.25	25	12	80	3	HB	▲
DPSG.3.16.025.16.35	16	0.25	35	16	90	3	HB	▲
DPSG.3.20.025.20.40	20	0.25	40	20	102	3	HB	▲
							P	●
							M	○
							K	○
							N	○
							S	○
							H	-

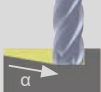


切削参数 DPSG Ø 2 - 20 mm

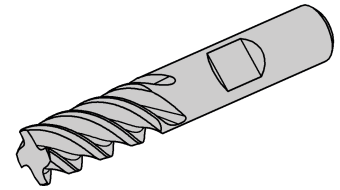
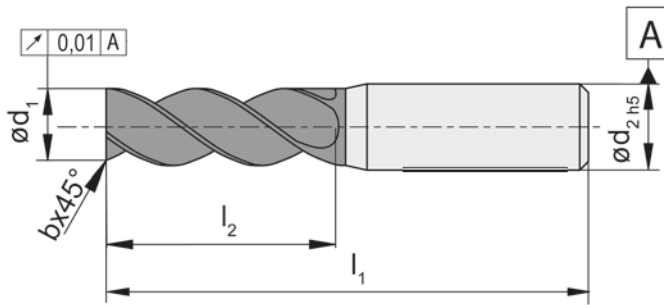
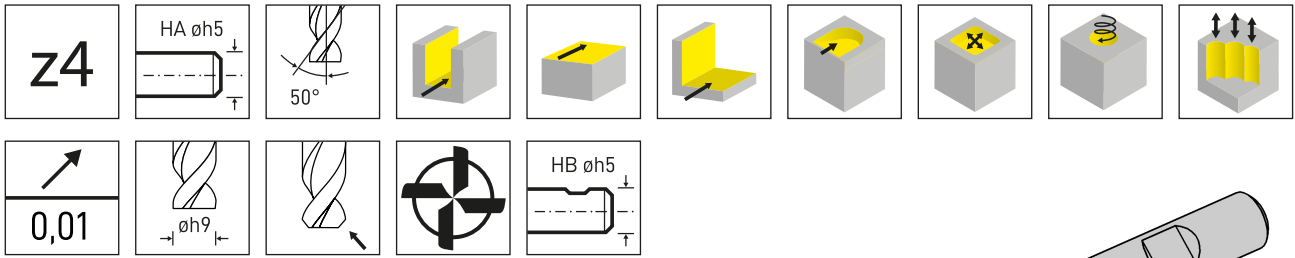
Cutting Data DPSG Ø 2 - 20 mm



A

	 vc = m/min	 vc = m/min
P1.1	130	150
P1.2	130	150
P1.3	120	140
P1.4	120	140
P1.5	120	140
P1.6	130	110
P2.1	120	110
P2.2	110	100
P2.3	110	100
P2.4	110	100
K1.1	120	140
K1.2	120	140

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
2	5°	0.007	2	2	0.011	0.50	4.00
3	5°	0.011	3	3	0.017	0.75	6.00
4	5°	0.015	4	4	0.024	1.00	8.00
5	5°	0.019	5	5	0.030	1.25	10.00
6	5°	0.023	6	6	0.037	1.50	12.00
8	5°	0.031	8	8	0.050	2.00	16.00
10	5°	0.039	10	10	0.062	2.50	20.00
12	5°	0.047	12	12	0.075	3.00	24.00
16	5°	0.063	16	16	0.101	4.00	32.00
20	5°	0.079	20	20	0.127	5.00	40.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d_1	b	l_2	d_2	l_1	Z	类型 Type	TF2K
DPSG.4.03.010.03.10	3	0.1	10	3	40	4	HA	▲
DPSG.4.04.010.04.12	4	0.1	12	4	50	4	HA	▲
DPSG.4.05.015.05.15	5	0.15	15	5	50	4	HA	▲
DPSG.4.06.015.06.15	6	0.15	15	6	65	4	HB	▲
DPSG.4.08.020.08.20	8	0.2	20	8	65	4	HB	▲
DPSG.4.10.020.10.22	10	0.2	22	10	70	4	HB	▲
DPSG.4.12.025.12.25	12	0.25	25	12	80	4	HB	▲
DPSG.4.16.025.16.35	16	0.25	35	16	90	4	HB	▲
DPSG.4.20.025.20.40	20	0.25	42	20	102	4	HB	▲
							P	•
							M	○
							K	○
							N	○
							S	○
							H	-




切削参数 DPSG Ø 3 - 20 mm

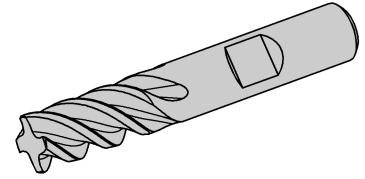
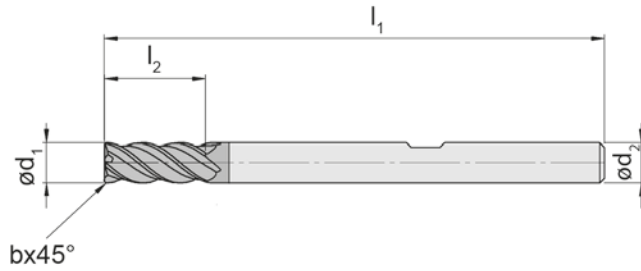
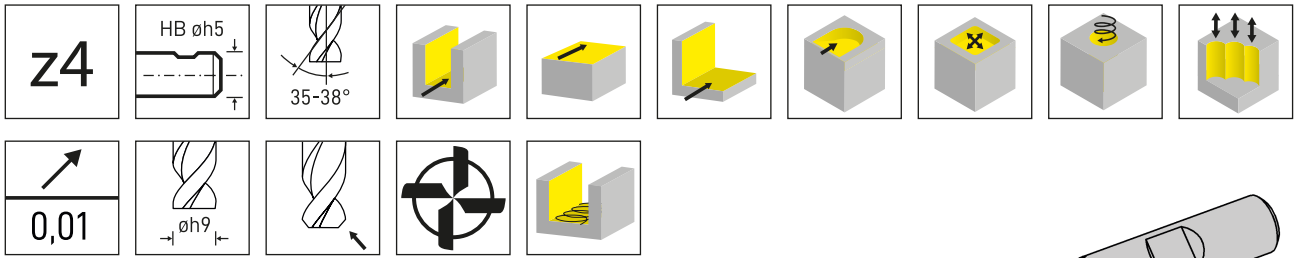
Cutting Data DPSG Ø 3 - 20 mm



A

	 vc = m/min	 vc = m/min
P1.1	130	150
P1.2	130	150
P1.3	120	140
P1.4	120	140
P1.5	120	140
P1.6	130	110
P2.1	120	110
P2.2	110	100
P2.3	110	100
P2.4	110	100
K1.1	120	140
K1.2	120	140

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
3	4°	0.007	3	3	0.010	0.75	4.00
4	4°	0.011	4	4	0.017	1.00	6.00
5	4°	0.015	5	5	0.023	1.25	8.00
6	4°	0.019	6	6	0.030	1.50	10.00
8	4°	0.027	8	8	0.043	2.00	12.00
10	4°	0.035	10	10	0.055	2.50	16.00
12	4°	0.043	12	12	0.068	3.00	20.00
16	4°	0.059	16	16	0.094	4.00	24.00
20	4°	0.075	20	20	0.120	5.00	32.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks




产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPSV.4.04.025.06.11	4	0.25	11	6	57	4	HB	▲
DPSV.4.05.025.06.13	5	0.25	13	6	57	4	HB	▲
DPSV.4.06.025.06.13	6	0.25	13	6	57	4	HB	▲
DPSV.4.08.025.08.19	8	0.25	19	8	63	4	HB	▲
DPSV.4.10.025.10.22	10	0.25	22	10	72	4	HB	▲
DPSV.4.12.025.12.26	12	0.25	26	12	83	4	HB	▲
DPSV.4.16.025.16.32	16	0.25	32	16	92	4	HB	▲
DPSV.4.20.040.20.38	20	0.4	38	20	104	4	HB	▲
							P	●
							M	○
							K	○
							N	○
							S	○
							H	-




切削参数 DPSV Ø 4 - 20 mm

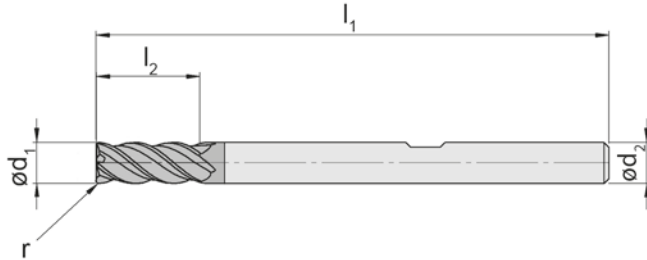
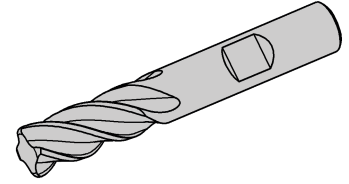
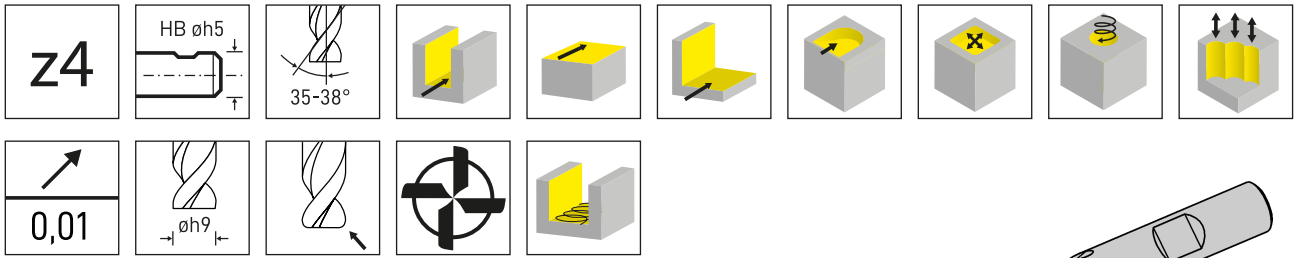
Cutting Data DPSV Ø 4 - 20 mm



A

	 vc = m/min	 vc = m/min	 vc = m/min
P1.1	140	160	160
P1.2	140	160	160
P1.3	130	150	150
P1.4	130	150	150
P1.5	130	150	150
P1.6	140	160	160
P2.1	130	150	150
P2.2	120	140	140
P2.3	120	140	140
P2.4	120	140	140
K1.1	130	150	
K1.2	130	150	

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
4	4°	0.011	4	4	0.017	1.00	8.00
5	4°	0.015	5	5	0.023	1.25	10.00
6	4°	0.019	6	6	0.030	1.50	12.00
8	4°	0.027	8	8	0.043	2.00	16.00
10	4°	0.035	10	10	0.055	2.50	20.00
12	4°	0.043	12	12	0.068	3.00	24.00
16	4°	0.059	16	16	0.094	4.00	32.00
20	4°	0.075	20	20	0.120	5.00	38.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks




产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPX.4.03.025.06.11	3	0.25	11	6	57	4	HB	▲
DPX.4.03.050.06.13	3	0.5	11	6	57	4	HB	▲
DPX.4.04.050.06.13	4	0.5	13	6	57	4	HB	▲
DPX.4.05.050.06.13	5	0.5	13	6	57	4	HB	▲
DPX.4.06.050.06.13	6	0.5	13	6	57	4	HB	▲
DPX.4.06.100.06.13	6	1	13	6	57	4	HB	▲
DPX.4.08.050.08.19	8	0.5	19	8	63	4	HB	▲
DPX.4.08.100.08.19	8	1	19	8	63	4	HB	▲
DPX.4.10.050.10.22	10	0.5	22	10	72	4	HB	▲
DPX.4.10.100.10.22	10	1	22	10	72	4	HB	▲
DPX.4.10.150.10.22	10	1.5	22	10	72	4	HB	▲
DPX.4.12.050.12.26	12	0.5	26	12	83	4	HB	▲
DPX.4.12.150.12.26	12	1.5	26	12	83	4	HB	▲
DPX.4.16.150.16.32	16	1.5	32	16	92	4	HB	▲
DPX.4.16.300.16.32	16	3	32	16	92	4	HB	▲
							P	●
							M	○
							K	○
							N	○
							S	○
							H	-




切削参数 DPX Ø 3 - 16 mm

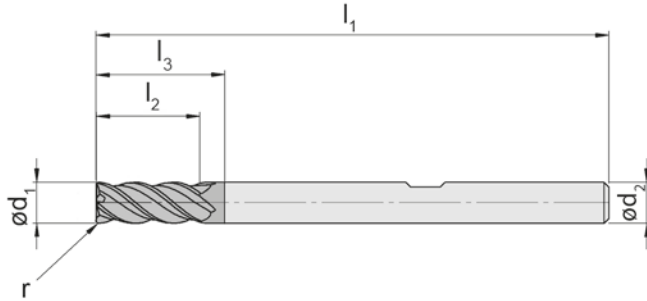
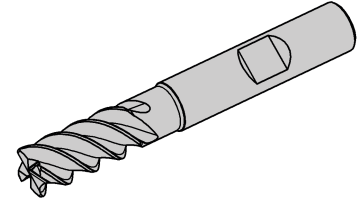
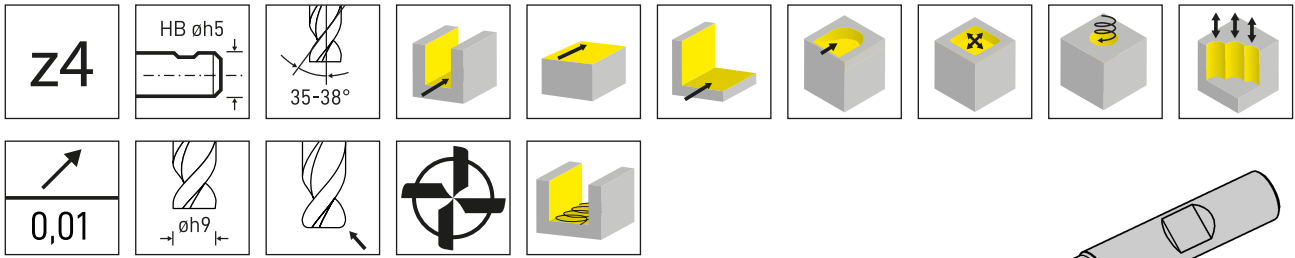
Cutting Data DPX Ø 3 - 16 mm



A

	 vc = m/min	 vc = m/min	 vc = m/min
P1.1	140	160	160
P1.2	140	160	160
P1.3	130	150	150
P1.4	130	150	150
P1.5	130	150	150
P1.6	140	160	160
P2.1	130	150	150
P2.2	120	140	140
P2.3	120	140	140
P2.4	120	140	140
K1.1	130	150	
K1.2	130	150	

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
3	3°	0.007	3	3	0.010	0.75	6.00
3	3°	0.007	3	3	0.010	0.75	6.00
4	4°	0.011	4	4	0.017	1.00	8.00
5	4°	0.015	5	5	0.023	1.25	10.00
6	4°	0.019	6	6	0.030	1.50	12.00
6	4°	0.019	6	6	0.030	1.50	12.00
8	4°	0.027	8	8	0.043	2.00	16.00
8	4°	0.027	8	8	0.043	2.00	16.00
10	4°	0.035	10	10	0.055	2.50	20.00
10	4°	0.035	10	10	0.055	2.50	20.00
10	4°	0.035	10	10	0.055	2.50	20.00
12	4°	0.043	12	12	0.068	3.00	24.00
12	4°	0.043	12	12	0.068	3.00	24.00
16	4°	0.059	16	16	0.094	4.00	32.00
16	4°	0.059	16	16	0.094	4.00	32.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks




产品型号 Part number	d_1	r	l_2	l_3	d_2	l_1	Z	类型 Type	TF2K
DPX.4.03.025.06.A21	3	0.25	11	21	6	57	4	HB	▲
DPX.4.03.050.06.A21	3	0.5	13	21	6	57	4	HB	▲
DPX.4.04.050.06.A21	4	0.5	13	21	6	57	4	HB	▲
DPX.4.05.050.06.A21	5	0.5	13	21	6	57	4	HB	▲
DPX.4.06.050.06.A21	6	0.5	13	21	6	57	4	HB	▲
DPX.4.06.100.06.A21	6	1	13	21	6	57	4	HB	▲
DPX.4.06.150.06.A21	6	1.5	13	21	6	57	4	HB	▲
DPX.4.08.050.08.A28	8	0.5	19	28	8	63	4	HB	▲
DPX.4.08.100.08.A28	8	1	19	28	8	63	4	HB	▲
DPX.4.08.150.08.A28	8	1.5	19	28	8	63	4	HB	▲
DPX.4.10.050.10.A32	10	0.5	22	32	10	72	4	HB	▲
DPX.4.10.100.10.A32	10	1	22	32	10	72	4	HB	▲
DPX.4.10.150.10.A32	10	1.5	22	32	10	72	4	HB	▲
DPX.4.12.050.12.A38	12	0.5	26	38	12	83	4	HB	▲
DPX.4.12.150.12.A38	12	1.5	26	38	12	83	4	HB	▲
DPX.4.16.150.16.A44	16	1.5	32	44	16	92	4	HB	▲
DPX.4.16.300.16.A44	16	3	32	44	16	92	4	HB	▲
								P	●
								M	○
								K	○
								N	○
								S	○
								H	-




切削参数 DPX Ø 3 - 16 mm

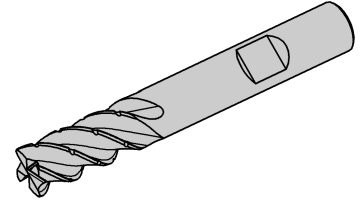
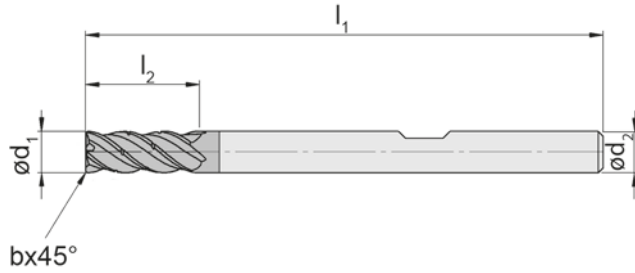
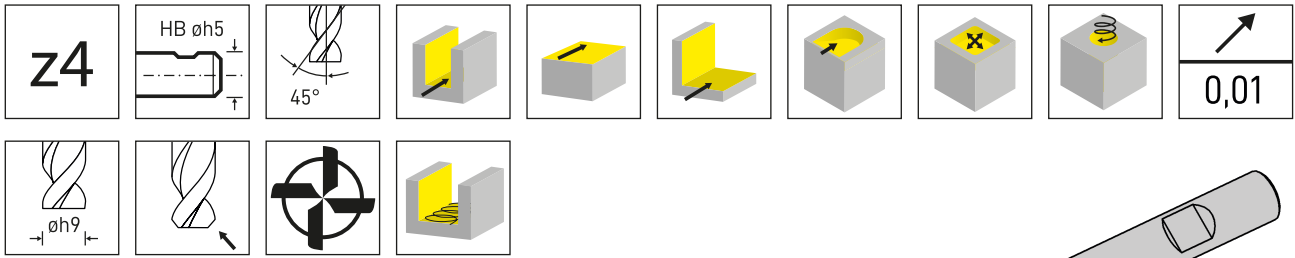
Cutting Data DPX Ø 3 - 16 mm



A

	 vc = m/min	 vc = m/min	 vc = m/min
P1.1	140	160	160
P1.2	140	160	160
P1.3	130	150	150
P1.4	130	150	150
P1.5	130	150	150
P1.6	140	160	160
P2.1	130	150	150
P2.2	120	140	140
P2.3	120	140	140
P2.4	120	140	140
K1.1	130	150	
K1.2	130	150	

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
3	3°	0.007	3	3	0.010	0.75	6.00
3	3°	0.007	3	3	0.010	0.75	6.00
4	4°	0.011	4	4	0.017	1.00	8.00
5	4°	0.015	5	5	0.023	1.25	10.00
6	4°	0.019	6	6	0.030	1.50	12.00
6	4°	0.019	6	6	0.030	1.50	12.00
6	4°	0.019	6	6	0.030	1.50	12.00
8	4°	0.027	8	8	0.043	2.00	16.00
8	4°	0.027	8	8	0.043	2.00	16.00
8	4°	0.027	8	8	0.043	2.00	16.00
10	4°	0.035	10	10	0.055	2.50	20.00
10	4°	0.035	10	10	0.055	2.50	20.00
10	4°	0.035	10	10	0.055	2.50	20.00
12	4°	0.043	12	12	0.068	3.00	24.00
12	4°	0.043	12	12	0.068	3.00	24.00
16	4°	0.059	16	16	0.094	4.00	32.00
16	4°	0.059	16	16	0.094	4.00	32.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPSB.4.04.025.06.11	4	0.25	11	6	57	4	HB	▲
DPSB.4.06.025.06.13	6	0.25	13	6	57	4	HB	▲
DPSB.4.08.025.08.19	8	0.25	19	8	63	4	HB	▲
DPSB.4.10.025.10.22	10	0.25	22	10	72	4	HB	▲
DPSB.4.12.025.12.26	12	0.25	26	12	83	4	HB	▲
DPSB.4.16.025.16.32	16	0.25	32	16	92	4	HB	▲
DPSB.4.20.040.20.38	20	0.4	38	20	104	4	HB	▲
							P	●
							M	○
							K	○
							N	○
							S	○
							H	-




切削参数 DPSB Ø 4 - 20 mm

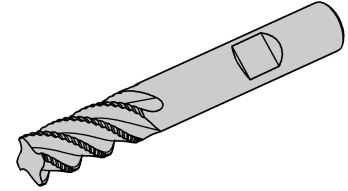
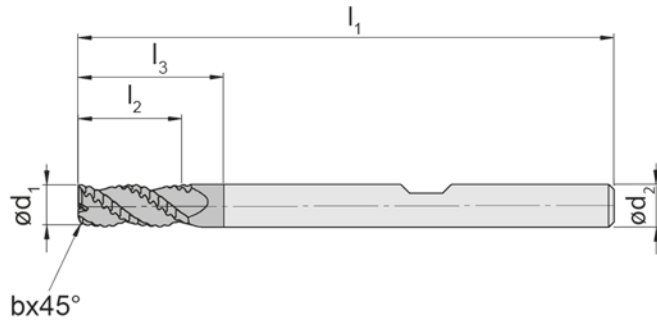
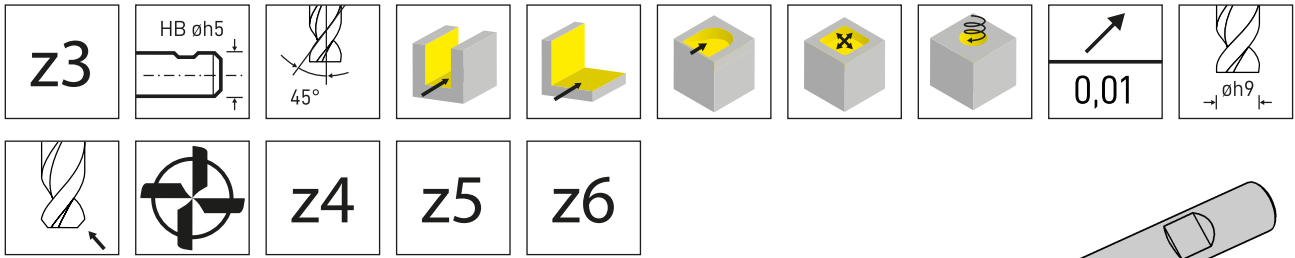
Cutting Data DPSB Ø 4 - 20 mm



A

	 vc = m/min	 vc = m/min
P1.1	130	150
P1.2	130	150
P1.3	120	140
P1.4	120	140
P1.5	120	140
P1.6	130	110
P2.1	120	110
P2.2	110	100
P2.3	110	100
P2.4	110	100
K1.1	120	140
K1.2	120	140

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
4	4°	0.011	4	4	0.015	1.20	8.00
6	4°	0.019	6	6	0.027	1.80	12.00
8	4°	0.027	8	8	0.039	2.40	16.00
10	4°	0.035	10	10	0.051	3.00	20.00
12	4°	0.043	12	12	0.062	3.60	24.00
16	4°	0.059	16	16	0.086	4.80	32.00
20	4°	0.075	20	20	0.110	6.00	38.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d_1	b	l_2	l_3	d_2	l_1	Z	类型 Type	TF2K
DPS.3.04.025.06.11	4	0.25	11	-	6	57	3	HB	▲
DPS.4.05.025.06.13	5	0.25	13	-	6	57	4	HB	▲
DPS.4.06.025.06.13	6	0.25	13	-	6	57	4	HB	▲
DPS.4.06.025.06.A21	6	0.25	13	21	6	57	4	HB	▲
DPS.4.08.025.08.19	8	0.25	19	-	8	63	4	HB	▲
DPS.4.08.025.08.A27	8	0.25	19	27	8	63	4	HB	▲
DPS.4.10.025.10.22	10	0.25	22	-	10	72	4	HB	▲
DPS.4.10.025.10.A32	10	0.25	22	32	10	72	4	HB	▲
DPS.4.12.025.12.26	12	0.25	26	-	12	83	4	HB	▲
DPS.4.12.025.12.A38	12	0.25	26	38	12	83	4	HB	▲
DPS.5.16.025.16.32	16	0.25	32	-	16	92	5	HB	▲
DPS.5.16.025.16.A44	16	0.25	32	44	16	92	5	HB	▲
DPS.6.20.040.20.38	20	0.4	38	-	20	104	6	HB	▲
DPS.6.20.040.20.A54	20	0.4	38	54	20	104	6	HB	▲



P	•
M	◦
K	◦
N	◦
S	◦
H	-




切削参数 DPS Ø 4 - 20 mm

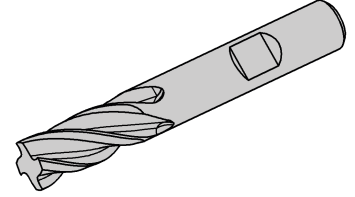
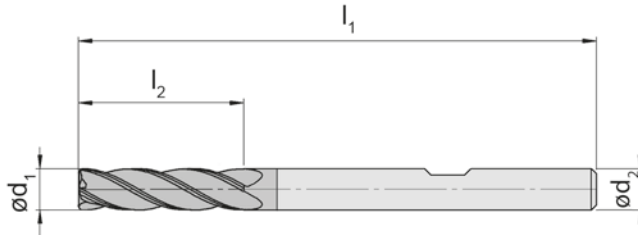
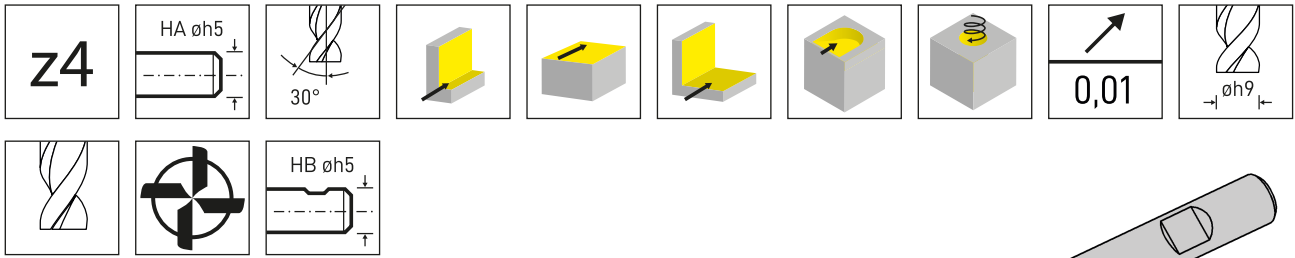
Cutting Data DPS Ø 4 - 20 mm



A

	 vc = m/min	 vc = m/min
P1.1	130	140
P1.2	130	140
P1.3	120	130
P1.4	120	130
P1.5	120	130
P1.6	130	110
P2.1	120	110
P2.2	110	100
P2.3	110	100
P2.4	110	100
K1.1	120	130
K1.2	120	130

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
4	4°	0.011	4	4	0.013	1.60	8.00
5	4°	0.015	5	5	0.018	2.00	10.00
6	4°	0.019	6	6	0.023	2.40	12.00
6	4°	0.019	6	6	0.023	2.40	12.00
8	4°	0.027	8	8	0.034	3.20	16.00
8	4°	0.027	8	8	0.034	3.20	16.00
10	4°	0.035	10	10	0.044	4.00	20.00
10	4°	0.035	10	10	0.044	4.00	20.00
12	4°	0.043	12	12	0.054	4.80	24.00
12	4°	0.043	12	12	0.054	4.80	24.00
16	3°	0.057	16	16	0.071	6.40	32.00
16	3°	0.057	16	16	0.071	6.40	32.00
20	3°	0.072	20	20	0.089	8.00	38.00
20	3°	0.072	20	20	0.089	8.00	38.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPT.4.01.00.03.03	1	3	3	40	4	HA	▲
DPT.4.15.00.03.05	1.5	5	3	40	4	HA	▲
DPT.4.02.00.03.07	2	7	3	40	4	HA	▲
DPT.4.25.00.03.07	2.5	7	3	40	4	HA	▲
DPT.4.03.00.03.10	3	10	3	40	4	HA	▲
DPT.4.35.00.04.12	3.5	12	4	50	4	HA	▲
DPT.4.04.00.04.15	4	15	4	50	4	HA	▲
DPT.4.45.00.05.15	4.5	15	5	50	4	HA	▲
DPT.4.05.00.05.15	5	15	5	50	4	HA	▲
DPT.4.06.00.06.20	6	20	6	65	4	HB	▲
DPT.4.07.00.08.20	7	20	8	65	4	HB	▲
DPT.4.08.00.08.20	8	20	8	65	4	HB	▲
DPT.4.09.00.10.22	9	22	10	70	4	HB	▲
DPT.4.10.00.10.22	10	22	10	70	4	HB	▲
DPT.4.11.00.11.25	11	25	11	70	4	HA	▲
DPT.4.12.00.12.25	12	25	12	80	4	HB	▲
DPT.4.14.00.14.30	14	30	14	90	4	HA	▲
DPT.4.16.00.16.32	16	32	16	90	4	HB	▲



P	•
M	◦
K	◦
N	◦
S	◦
H	-




切削参数 DPT Ø 1 - 16 mm

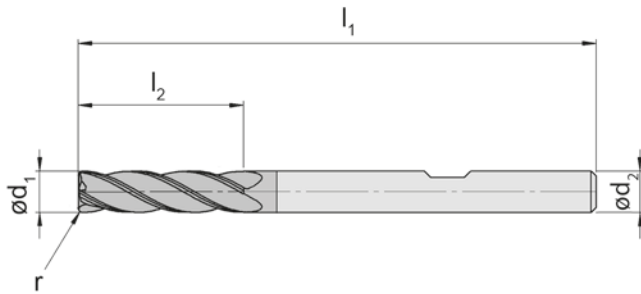
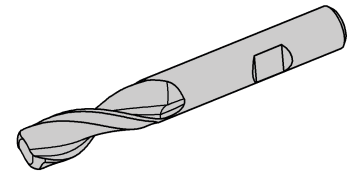
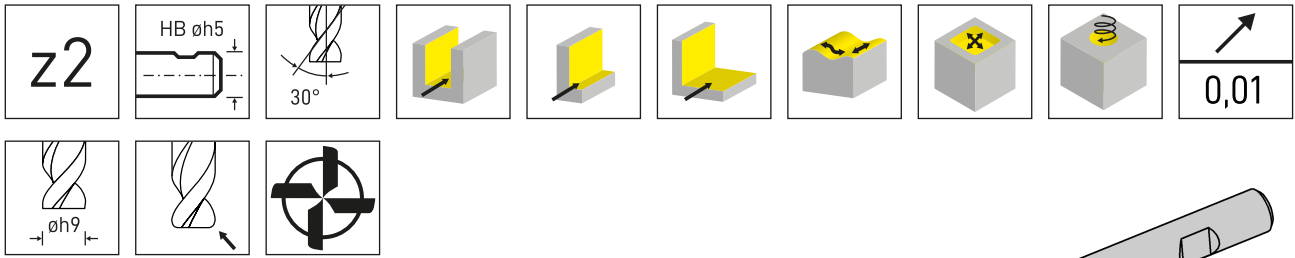
Cutting Data DPT Ø 1 - 16 mm



A

	 vc = m/min	 vc = m/min
P1.1	130	140
P1.2	130	140
P1.3	120	130
P1.4	120	130
P1.5	120	130
P1.6	130	110
P2.1	120	110
P2.2	110	100
P2.3	110	100
P2.4	110	100
K1.1	120	130
K1.2	120	130

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
1.0	4°	0.006	1	1	0.010	0.25	2.00
1.5	4°	0.007	2	2	0.013	0.38	3.00
2.0	4°	0.009	2	2	0.016	0.50	4.00
2.5	4°	0.011	3	3	0.019	0.63	5.00
3.0	4°	0.012	3	3	0.022	0.75	6.00
3.5	4°	0.014	4	4	0.024	0.88	7.00
4.0	4°	0.016	4	4	0.027	1.00	8.00
4.5	4°	0.017	5	5	0.030	1.13	9.00
5.0	4°	0.019	5	5	0.033	1.25	10.00
6.0	4°	0.022	6	6	0.038	1.50	12.00
7.0	4°	0.026	7	7	0.044	1.75	14.00
8.0	4°	0.029	8	8	0.049	2.00	16.00
9.0	4°	0.032	9	9	0.055	2.25	18.00
10.0	4°	0.036	10	10	0.060	2.50	20.00
11.0	4°	0.039	11	11	0.066	2.75	22.00
12.0	4°	0.042	12	12	0.072	3.00	24.00
14.0	4°	0.049	14	14	0.083	3.50	28.00
16.0	4°	0.056	16	16	0.094	4.00	32.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPTR.2.03.03.06.12	3	0.3	12	6	50	2	HB	▲
DPTR.2.04.05.06.15	4	0.5	15	6	50	2	HB	▲
DPTR.2.05.03.06.20	5	0.3	20	6	60	2	HB	▲
DPTR.2.05.05.06.20	5	0.5	20	6	60	2	HB	▲
DPTR.2.06.05.06.20	6	0.5	20	6	60	2	HB	▲
DPTR.2.06.10.06.20	6	1	20	6	60	2	HB	▲
DPTR.2.08.03.08.25	8	0.3	25	8	70	2	HB	▲
DPTR.2.08.20.08.25	8	2	25	8	70	2	HB	▲
DPTR.2.10.03.10.30	10	0.3	30	10	90	2	HB	▲
DPTR.2.10.05.10.30	10	0.5	30	10	90	2	HB	▲
DPTR.2.10.10.10.30	10	1	30	10	90	2	HB	▲
DPTR.2.20.05.20.50	20	0.5	50	20	110	2	HB	▲




P	•
M	◦
K	◦
N	◦
S	◦
H	-




切削参数 DPTR Ø 3 - 20 mm

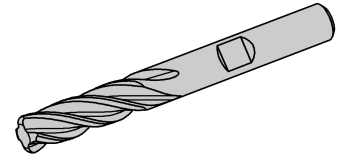
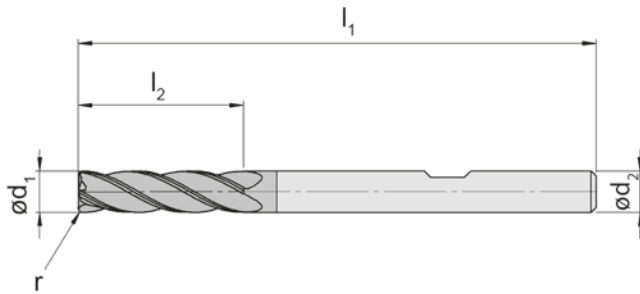
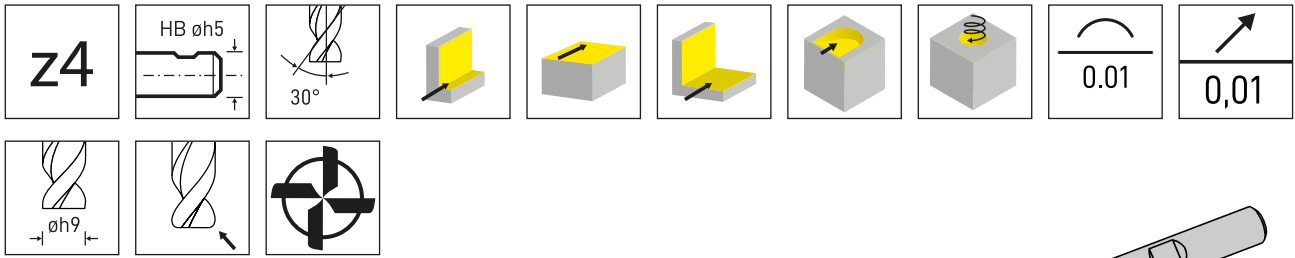
Cutting Data DPTR Ø 3 - 20 mm



A

			
	vc = m/min	vc = m/min	vc = m/min
P1.1	120	140	130
P1.2	120	140	130
P1.3	110	130	120
P1.4	110	130	120
P1.5	110	130	120
P1.6	120	110	130
P2.1	110	110	120
P2.2	100	100	110
P2.3	100	100	110
P2.4	100	100	110
K1.1	110	120	130
K1.2	110	120	130

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
3	5°	0.019	3	3	0.036	0.75	6.00
4	5°	0.023	4	4	0.041	1.00	8.00
5	5°	0.026	5	5	0.047	1.25	10.00
5	5°	0.026	5	5	0.047	1.25	10.00
6	5°	0.029	6	6	0.052	1.50	12.00
6	5°	0.029	6	6	0.052	1.50	12.00
8	5°	0.036	8	8	0.063	2.00	16.00
8	5°	0.036	8	8	0.063	2.00	16.00
10	5°	0.043	10	10	0.074	2.50	20.00
10	5°	0.043	10	10	0.074	2.50	20.00
10	5°	0.043	10	10	0.074	2.50	20.00
20	5°	0.076	20	20	0.130	5.00	40.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPTR.4.03.03.06.12	3	0.3	12	6	50	4	HB	▲
DPTR.4.04.03.06.15	4	0.3	15	6	50	4	HB	▲
DPTR.4.04.05.06.15	4	0.5	15	6	50	4	HB	▲
DPTR.4.05.03.06.20	5	0.3	20	6	60	4	HB	▲
DPTR.4.05.05.06.20	5	0.5	20	6	60	4	HB	▲
DPTR.4.06.03.06.20	6	0.3	20	6	60	4	HB	▲
DPTR.4.06.05.06.20	6	0.5	20	6	60	4	HB	▲
DPTR.4.06.10.06.20	6	1	20	6	60	4	HB	▲
DPTR.4.08.03.08.25	8	0.3	25	8	70	4	HB	▲
DPTR.4.08.05.08.25	8	0.5	25	8	70	4	HB	▲
DPTR.4.08.10.08.25	8	1	25	8	70	4	HB	▲
DPTR.4.08.15.08.25	8	1.5	25	8	70	4	HB	▲
DPTR.4.08.20.08.25	8	2	25	8	70	4	HB	▲
DPTR.4.10.03.10.30	10	0.3	30	10	90	4	HB	▲
DPTR.4.10.05.10.30	10	0.5	30	10	90	4	HB	▲
DPTR.4.10.10.10.30	10	1	30	10	90	4	HB	▲
DPTR.4.10.15.10.30	10	1.5	30	10	90	4	HB	▲
DPTR.4.10.20.10.30	10	2	30	10	90	4	HB	▲
DPTR.4.12.05.12.30	12	0.5	30	12	90	4	HB	▲
DPTR.4.12.10.12.30	12	1	30	12	90	4	HB	▲
DPTR.4.12.20.12.30	12	2	30	12	90	4	HB	▲
DPTR.4.16.05.16.50	16	0.5	50	16	110	4	HB	▲
DPTR.4.16.10.16.50	16	1	50	16	110	4	HB	▲
DPTR.4.16.20.16.50	16	2	50	16	110	4	HB	▲
DPTR.4.20.05.20.50	20	0.5	50	20	110	4	HB	▲
DPTR.4.20.10.20.50	20	1	50	20	110	4	HB	▲
DPTR.4.20.20.20.50	20	2	50	20	110	4	HB	▲




P	●
M	○
K	○
N	○
S	○
H	-




切削参数 DPTR Ø 3 - 20 mm

Cutting Data DPTR Ø 3 - 20 mm



A

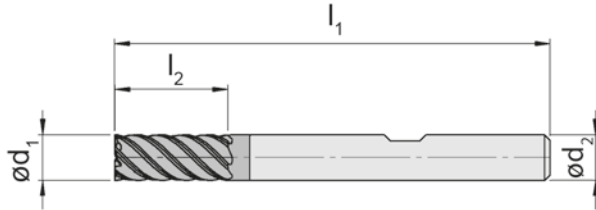
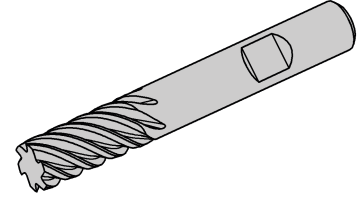
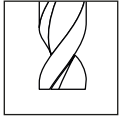
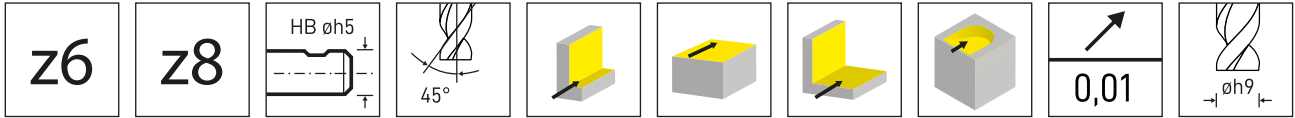
	 vc = m/min	 vc = m/min	 vc = m/min
P1.1	140	130	160
P1.2	140	130	160
P1.3	130	120	150
P1.4	130	120	150
P1.5	130	120	150
P1.6	110	130	130
P2.1	110	120	130
P2.2	100	110	120
P2.3	100	110	120
P2.4	100	110	120
K1.1	120	130	140
K1.2	120	130	140

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
3	4°	0.012	3	3	0.022	0.75	6.00
4	4°	0.016	4	4	0.027	1.00	8.00
4	4°	0.016	4	4	0.027	1.00	8.00
5	4°	0.019	5	5	0.033	1.25	10.00
5	4°	0.019	5	5	0.033	1.25	10.00
6	4°	0.022	6	6	0.038	1.50	12.00
6	4°	0.022	6	6	0.038	1.50	12.00
6	4°	0.022	6	6	0.038	1.50	12.00
8	4°	0.029	8	8	0.049	2.00	16.00
8	4°	0.029	8	8	0.049	2.00	16.00
8	4°	0.029	8	8	0.049	2.00	16.00
8	4°	0.029	8	8	0.049	2.00	16.00
8	4°	0.029	8	8	0.049	2.00	16.00
10	4°	0.036	10	10	0.060	2.50	20.00
10	4°	0.036	10	10	0.060	2.50	20.00
10	4°	0.036	10	10	0.060	2.50	20.00
10	4°	0.036	10	10	0.060	2.50	20.00
10	4°	0.036	10	10	0.060	2.50	20.00
12	4°	0.042	12	12	0.072	3.00	24.00
12	4°	0.042	12	12	0.072	3.00	24.00
12	4°	0.042	12	12	0.072	3.00	24.00
16	4°	0.056	16	16	0.094	4.00	32.00
16	4°	0.056	16	16	0.094	4.00	32.00
16	4°	0.056	16	16	0.094	4.00	32.00
20	4°	0.069	20	20	0.116	5.00	40.00
20	4°	0.069	20	20	0.116	5.00	40.00
20	4°	0.069	20	20	0.116	5.00	40.00

多刃立铣刀

End Mill multiple fluted

DPM



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPM.6.06.00.06.13	6	13	6	58	6	HB	▲
DPM.6.08.00.08.19	8	19	8	65	6	HB	▲
DPM.6.10.00.10.22	10	22	10	72	6	HB	▲
DPM.6.12.00.12.26	12	26	12	83	6	HB	▲
DPM.6.16.00.16.32	16	32	16	92	6	HB	▲
DPM.8.20.00.20.38	20	38	20	103	8	HB	▲
						P	●
						M	○
						K	○
						N	○
						S	○
						H	-



切削参数 DPM Ø 6 - 20 mm




Cutting Data DPM Ø 6 - 20 mm

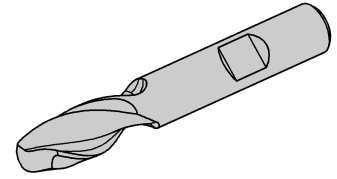
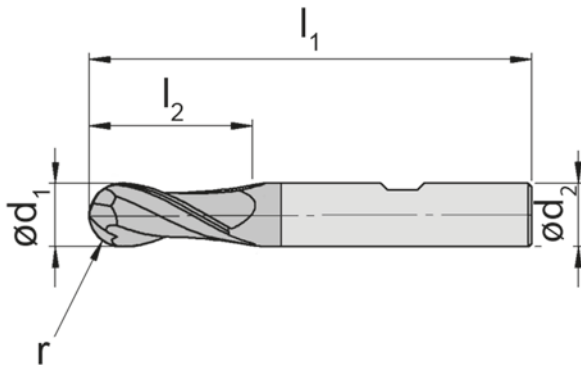
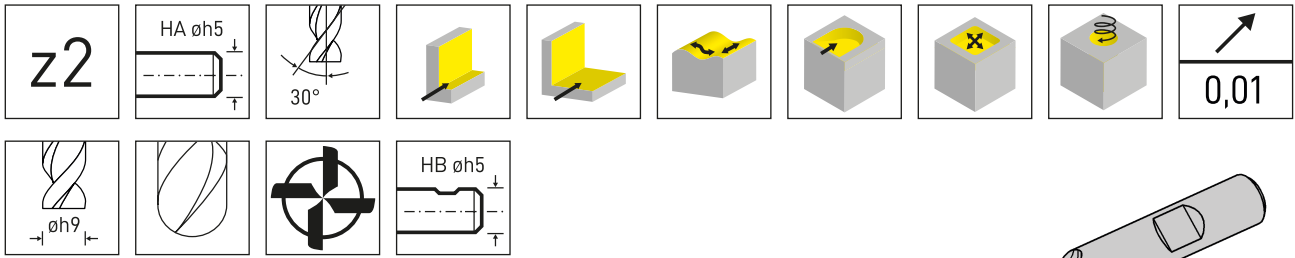


A

	 vc = m/min	 vc = m/min
P1.1	120	140
P1.2	120	140
P1.3	110	130
P1.4	110	130
P1.5	110	130
P1.6	120	140
P2.1	110	130
P2.2	100	120
P2.3	100	120
P2.4	100	120

	 vc = m/min	 vc = m/min
K1.1	140	160
K1.2	140	160
K2.1	140	160
K2.2	140	160
K3.1	140	160
K3.2	130	150
K4.1	130	150
K4.2	130	150
K4.3	130	150

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
6	2°	0.010	0.60	12.00	0.018	0.06	12.00
8	2°	0.015	0.80	16.00	0.035	0.08	16.00
10	2°	0.021	1.00	20.00	0.053	0.10	20.00
12	2°	0.027	1.20	24.00	0.070	0.12	24.00
16	2°	0.038	1.60	32.00	0.104	0.16	32.00
20	2°	0.040	2.00	40.00	0.110	0.20	38.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPK.2.010.03.03	1	0.5	3	3	40	2	HA	▲
DPK.2.015.03.05	1.5	0.75	5	3	40	2	HA	▲
DPK.2.020.03.07	2	1	7	3	40	2	HA	▲
DPK.2.025.03.07	2.5	1.25	7	3	40	2	HA	▲
DPK.2.030.03.10	3	1.5	10	3	40	2	HA	▲
DPK.2.035.04.12	3.5	1.75	12	4	50	2	HA	▲
DPK.2.040.04.15	4	2	15	4	50	2	HA	▲
DPK.2.045.05.15	4.5	2.25	15	5	50	2	HA	▲
DPK.2.050.05.15	5	2.5	15	5	50	2	HA	▲
DPK.2.060.06.20	6	3	20	6	65	2	HB	▲
DPK.2.080.08.20	8	4	20	8	65	2	HB	▲
DPK.2.100.10.22	10	5	22	10	70	2	HB	▲
DPK.2.120.12.25	12	6	25	12	80	2	HB	▲
DPK.2.160.16.32	16	8	32	16	90	2	HB	▲





P	•
M	◦
K	◦
N	◦
S	◦
H	-




切削参数 DPK Ø 1 - 16 mm

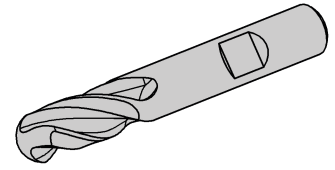
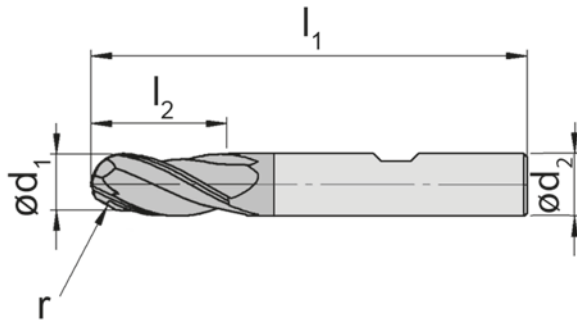
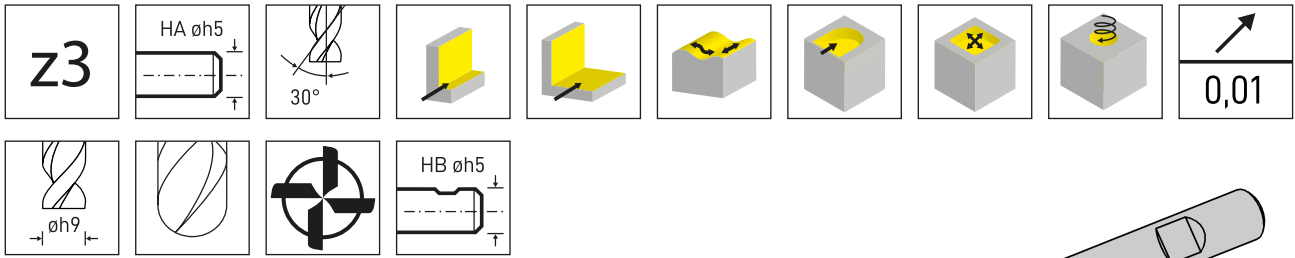
Cutting Data DPK Ø 1 - 16 mm



A

	 vc = m/min	 vc = m/min	 vc = m/min	 vc = m/min
P1.1	120	130	140	150
P1.2	120	130	140	150
P1.3	110	120	130	140
P1.4	110	120	130	140
P1.5	110	120	130	140
P1.6	120	130	140	150
P2.1	110	120	130	140
P2.2	100	110	120	130
P2.3	100	110	120	130
P2.4	100	110	120	130
K1.1	110	120	130	140
K1.2	110	120	130	140

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
1.0	5°	0.016	0.30	0.30	0.023	0.02	0.05
1.5	5°	0.019	0.45	0.45	0.027	0.02	0.08
2.0	5°	0.022	0.60	0.60	0.031	0.03	0.10
2.5	5°	0.025	0.75	0.75	0.034	0.04	0.13
3.0	5°	0.028	0.90	0.90	0.038	0.05	0.15
3.5	5°	0.031	1.05	1.05	0.042	0.05	0.18
4.0	5°	0.034	1.20	1.20	0.045	0.06	0.20
4.5	5°	0.037	1.35	1.35	0.049	0.07	0.23
5.0	5°	0.040	1.50	1.50	0.053	0.08	0.25
6.0	5°	0.046	1.80	1.80	0.060	0.09	0.30
8.0	5°	0.058	2.40	2.40	0.075	0.12	0.40
10.0	5°	0.070	3.00	3.00	0.090	0.15	0.50
12.0	5°	0.081	3.60	3.60	0.105	0.18	0.60
16.0	5°	0.105	4.80	4.80	0.134	0.24	0.80



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPK.3.015.03.05	1.5	0.75	5	3	40	3	HA	▲
DPK.3.020.03.07	2	1	7	3	40	3	HA	▲
DPK.3.025.03.07	2.5	1.25	7	3	40	3	HA	▲
DPK.3.030.03.10	3	1.5	10	3	40	3	HA	▲
DPK.3.035.04.12	3.5	1.75	12	4	50	3	HA	▲
DPK.3.040.04.15	4	2	15	4	50	3	HA	▲
DPK.3.045.05.15	4.5	2.25	15	5	50	3	HA	▲
DPK.3.050.05.15	5	2.5	15	5	50	3	HA	▲
DPK.3.060.06.20	6	3	20	6	65	3	HB	▲
DPK.3.080.08.20	8	4	20	8	65	3	HB	▲
DPK.3.100.10.22	10	5	22	10	70	3	HB	▲
DPK.3.120.12.25	12	6	25	12	80	3	HB	▲
DPK.3.140.14.30	14	7	30	14	90	3	HA	▲
DPK.3.160.16.32	16	8	32	16	90	3	HB	▲
DPK.3.200.20.38	20	10	38	20	100	3	HB	▲





P	•
M	○
K	○
N	○
S	○
H	-




切削参数 DPK Ø 1.5 - 20 mm

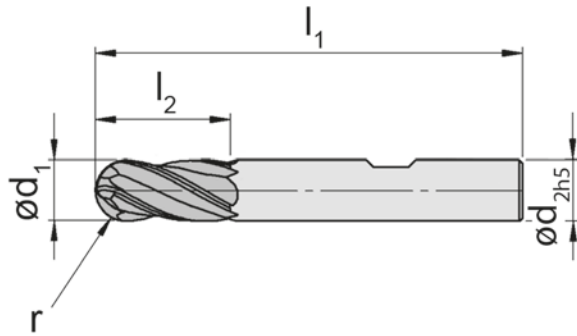
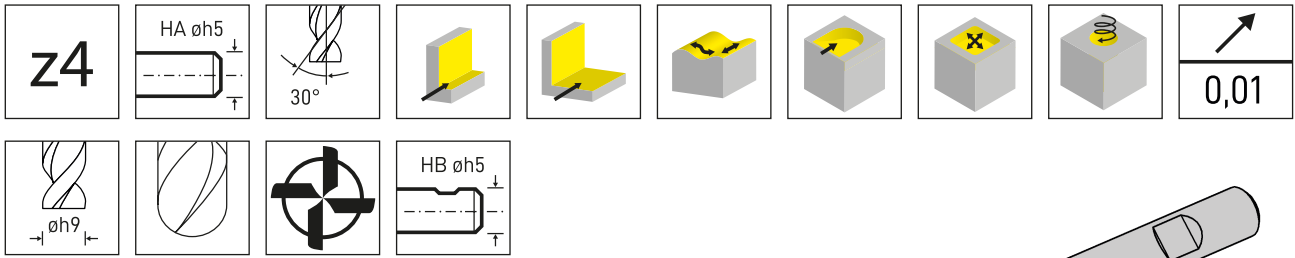
Cutting Data DPK Ø 1,5 - 20 mm



A

	 vc = m/min	 vc = m/min	 vc = m/min	 vc = m/min
P1.1	120	130	140	150
P1.2	120	130	140	150
P1.3	110	120	130	140
P1.4	110	120	130	140
P1.5	110	120	130	140
P1.6	120	130	140	150
P2.1	110	120	130	140
P2.2	100	110	120	130
P2.3	100	110	120	130
P2.4	100	110	120	130
K1.1	110	120	130	140
K1.2	110	120	130	140

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
1.5	5°	0.010	0.45	0.45	0.016	0.02	0.08
2.0	5°	0.013	0.60	0.60	0.020	0.03	0.10
2.5	5°	0.016	0.75	0.75	0.024	0.04	0.13
3.0	5°	0.019	0.90	0.90	0.027	0.05	0.15
3.5	5°	0.022	1.05	1.05	0.031	0.05	0.18
4.0	5°	0.024	1.20	1.20	0.035	0.06	0.20
4.5	5°	0.027	1.35	1.35	0.038	0.07	0.23
5.0	5°	0.030	1.50	1.50	0.042	0.08	0.25
6.0	5°	0.036	1.80	1.80	0.050	0.09	0.30
8.0	5°	0.048	2.40	2.40	0.064	0.12	0.40
10.0	5°	0.060	3.00	3.00	0.079	0.15	0.50
12.0	5°	0.072	3.60	3.60	0.094	0.18	0.60
14.0	5°	0.084	4.20	4.20	0.109	0.21	0.70
16.0	5°	0.095	4.80	4.80	0.124	0.24	0.80
20.0	5°	0.119	6.00	6.00	0.153	0.30	1.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Type	TF2K
DPK.4.010.03.03	1	0.5	3	3	40	4	HA	▲
DPK.4.015.03.05	1.5	0.75	5	3	40	4	HA	▲
DPK.4.020.03.07	2	1	7	3	40	4	HA	▲
DPK.4.025.03.07	2.5	1.25	7	3	40	4	HA	▲
DPK.4.030.03.10	3	1.5	10	3	40	4	HA	▲
DPK.4.035.04.12	3.5	1.75	12	4	50	4	HA	▲
DPK.4.040.04.15	4	2	15	4	50	4	HA	▲
DPK.4.050.05.15	5	2.5	15	5	50	4	HA	▲
DPK.4.060.06.20	6	3	20	6	65	4	HB	▲
DPK.4.080.08.20	8	4	20	8	65	4	HB	▲
DPK.4.100.10.22	10	5	22	10	70	4	HB	▲
DPK.4.120.12.25	12	6	25	12	80	4	HB	▲
DPK.4.160.16.32	16	8	32	16	90	4	HB	▲
DPK.4.200.20.38	20	10	38	20	100	4	HB	▲





P	•
M	◦
K	◦
N	◦
S	◦
H	-




切削参数 DPK Ø 1 - 20 mm

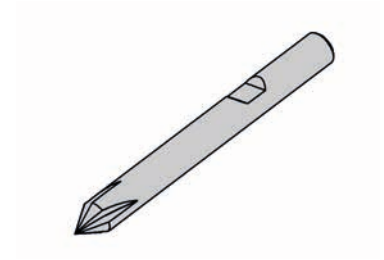
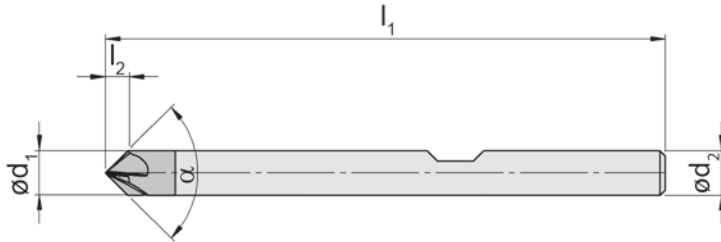
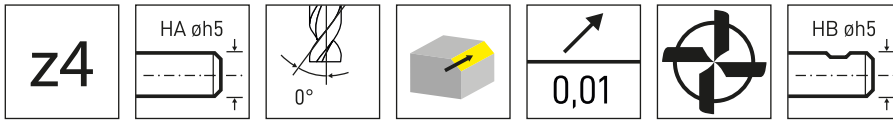
Cutting Data DPK Ø 1 - 20 mm



A

	 vc = m/min	 vc = m/min	 vc = m/min	 vc = m/min
P1.1	120	130	140	150
P1.2	120	130	140	150
P1.3	110	120	130	140
P1.4	110	120	130	140
P1.5	110	120	130	140
P1.6	120	130	140	150
P2.1	110	120	130	140
P2.2	100	110	120	130
P2.3	100	110	120	130
P2.4	100	110	120	130
K1.1	110	120	130	140
K1.2	110	120	130	140

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
1.0	4°	0.002	0.30	0.30	0.007	0.02	0.05
1.5	4°	0.005	0.45	0.45	0.011	0.02	0.08
2.0	4°	0.008	0.60	0.60	0.015	0.03	0.10
2.5	4°	0.011	0.75	0.75	0.018	0.04	0.13
3.0	4°	0.014	0.90	0.90	0.022	0.05	0.15
3.5	4°	0.017	1.05	1.05	0.026	0.05	0.18
4.0	4°	0.020	1.20	1.20	0.029	0.06	0.20
5.0	4°	0.026	1.50	1.50	0.037	0.08	0.25
6.0	4°	0.032	1.80	1.80	0.044	0.09	0.30
8.0	4°	0.043	2.40	2.40	0.059	0.12	0.40
10.0	4°	0.055	3.00	3.00	0.074	0.15	0.50
12.0	4°	0.067	3.60	3.60	0.089	0.18	0.60
16.0	4°	0.091	4.80	4.80	0.118	0.24	0.80
20.0	4°	0.114	6.00	6.00	0.148	0.30	1.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks





产品型号 Part number	d_1	α	l_2	l_3	d_2	l_1	Z	类型 Type	TF2K
DPFF.4.04.035.060	4	60°	3.5	3.5	4	51	4	HA	▲
DPFF.4.06.052.060	6	60°	5.2	5.2	6	64	4	HB	▲
DPFF.4.08.069.060	8	60°	6.9	6.9	8	64	4	HB	▲
DPFF.4.10.087.060	10	60°	8.7	8.7	10	70	4	HB	▲
DPFF.4.12.104.060	12	60°	10.4	10.4	12	78	4	HB	▲
DPFF.4.04.020.090	4	90°	2	2	4	51	4	HA	▲
DPFF.4.06.030.090	6	90°	3	3	6	64	4	HB	▲
DPFF.4.08.040.090	8	90°	4	4	8	64	4	HB	▲
DPFF.4.10.050.090	10	90°	5	5	10	70	4	HB	▲
DPFF.4.12.060.090	12	90°	6	6	12	78	4	HB	▲
DPFF.4.04.011.120	4	120°	1.1	1.1	4	51	4	HA	▲
DPFF.4.06.017.120	6	120°	1.7	1.7	6	64	4	HB	▲
DPFF.4.08.023.120	8	120°	2.3	2.3	8	64	4	HB	▲
DPFF.4.10.028.120	10	120°	2.8	2.8	10	70	4	HB	▲
DPFF.4.12.034.120	12	120°	3.4	3.4	12	78	4	HB	▲
								P	●
								M	○
								K	○
								N	○
								S	○
								H	-



切削参数 DPFF Ø 4 - 12 mm

Cutting Data DPFF Ø 4 - 12 mm



A

	 vc = m/min	 vc = m/min	 vc = m/min	 vc = m/min
P1.1	120	130	140	150
P1.2	120	130	140	150
P1.3	110	120	130	140
P1.4	110	120	130	140
P1.5	110	120	130	140
P1.6	120	130	140	150
P2.1	110	120	130	140
P2.2	100	110	120	130
P2.3	100	110	120	130
P2.4	100	110	120	130
K1.1	110	120	130	140
K1.2	110	120	130	140

d ₁						
	f _z	a _e	a _p	f _z	a _e	a _p
4	0.021	1.00	1.00	0.038	0.10	0.10
6	0.026	1.50	1.50	0.062	0.09	0.30
8	0.031	2.00	2.00	0.059	0.20	0.20
10	0.036	2.50	2.50	0.089	0.15	0.50
12	0.041	3.00	3.00	0.080	0.30	0.30
4	0.021	1.00	1.00	0.049	0.06	0.20
6	0.026	1.50	1.50	0.048	0.15	0.15
8	0.031	2.00	2.00	0.076	0.12	0.40
10	0.036	2.50	2.50	0.069	0.25	0.25
12	0.041	3.00	3.00	0.103	0.18	0.60
4	0.021	1.00	1.00	0.038	0.10	0.10
6	0.026	1.50	1.50	0.062	0.09	0.30
8	0.031	2.00	2.00	0.059	0.20	0.20
10	0.036	2.50	2.50	0.089	0.15	0.50
12	0.041	3.00	3.00	0.080	0.30	0.30

整体硬质合金立铣刀

Solid Carbide End Mills



B

	DSKM	微型立铣刀 End Mill Micro	Ø 0.1 – Ø 3	Z 2	44-47
	DSTM.2	圆角微型立铣刀 Torus End Mill Micro	Ø 0.1 – Ø 3	Z 2	48-57
	DSTM.4	圆角微型立铣刀 Torus End Mill Micro	Ø 0.2 – Ø 3	Z 4	58-67
	DSK	圆头立铣刀 Ball Nose End Mill	Ø 3.5 – Ø 16	Z 2	68 – 69
	DST.2	圆角立铣刀 Torus End Mill	Ø 3.5 – Ø 16	Z 2	70 – 77
	DST.4	圆角立铣刀 Torus End Mill	Ø 3.5 – Ø 16	Z 4	78 – 85
	DSM	多刃立铣刀 End Mill multiple fluted	Ø 2 – Ø 20	Z 6-8	86 – 89
	DSMR	多刃立铣刀 End Mill multiple fluted	Ø 2 – Ø 20	Z 6-8	90 – 97
	DSHPC	立铣刀 HPC End Mill HPC	Ø 2 – Ø 20	Z 6-8	98 – 99
	DSR.3	粗加工立铣刀 Roughing End Mill	Ø 2 – Ø 10	Z 3	100 – 101
	DSF.3	粗加工立铣刀 Roughing End Mill	Ø 2 – Ø 16	Z 3	102 – 103
	DSFT	摆线铣立铣刀 Trochoidal End Mill	Ø 2 – Ø 20	Z 4-7	104 – 107
	DSH	高进给立铣刀 High Feed End Mill	Ø 2 – Ø 16	Z 4	108 – 109
	DSFF	铣削倒角刀 Chamfer End Mill	Ø 4 – Ø 12.0	Z 4	110 – 111

DS



整体硬质合金立铣刀

设计用于：
- 高强度钢件

Solid Carbide End Mills

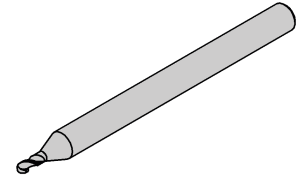
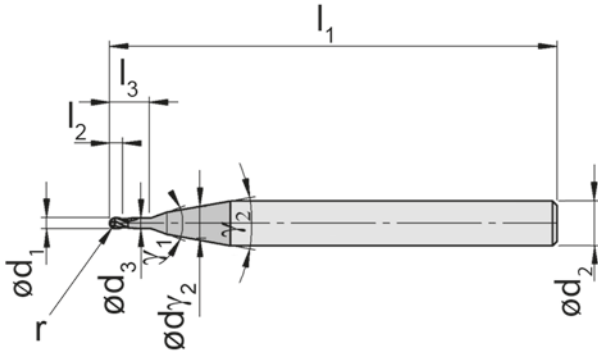
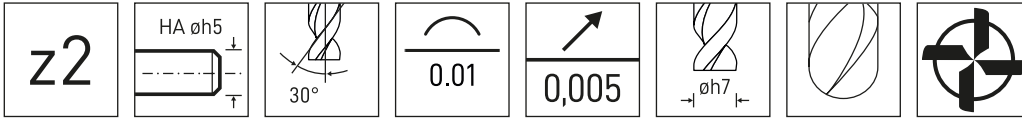
designed for:
- high tensile steels

微型立铣刀 End Mill Micro

DSKM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSKM.2.010.030	0.1	0.05	0.2	0.3	0.08	4	50	2	20°	-	▲
DSKM.2.010.050	0.1	0.05	0.2	0.5	0.08	4	50	2	40°	20°	▲
DSKM.2.020.030	0.2	0.1	0.4	0.6	0.18	4	50	2	20°	-	▲
DSKM.2.020.050	0.2	0.1	0.4	1	0.18	4	50	2	40°	20°	▲
DSKM.2.020.070	0.2	0.1	0.4	1.4	0.18	4	50	2	40°	20°	▲
DSKM.2.030.030	0.3	0.15	0.6	0.9	0.28	4	50	2	20°	-	▲
DSKM.2.030.050	0.3	0.15	0.6	1.5	0.28	4	50	2	40°	20°	▲
DSKM.2.030.070	0.3	0.15	0.6	2.1	0.28	4	50	2	40°	20°	▲
DSKM.2.040.030	0.4	0.2	0.8	1.2	0.35	4	50	2	20°	-	▲
DSKM.2.040.050	0.4	0.2	0.8	2	0.35	4	50	2	40°	20°	▲
DSKM.2.040.070	0.4	0.2	0.8	2.8	0.35	4	50	2	40°	20°	▲
DSKM.2.050.030	0.5	0.25	1	1.5	0.47	4	50	2	20°	-	▲
DSKM.2.050.050	0.5	0.25	1	2.5	0.47	4	50	2	40°	20°	▲
DSKM.2.050.070	0.5	0.25	1	3.5	0.47	4	50	2	40°	20°	▲
DSKM.2.060.030	0.6	0.3	1.2	1.8	0.55	4	50	2	20°	-	▲
DSKM.2.060.050	0.6	0.3	1.2	3	0.55	4	50	2	40°	20°	▲
DSKM.2.060.070	0.6	0.3	1.2	4.2	0.55	4	50	2	40°	20°	▲
DSKM.2.070.030	0.7	0.35	1.4	2.1	0.65	4	50	2	20°	-	▲
DSKM.2.070.050	0.7	0.35	1.4	3.5	0.65	4	50	2	40°	20°	▲
DSKM.2.080.030	0.8	0.4	1.6	2.4	0.75	4	50	2	20°	-	▲
DSKM.2.080.050	0.8	0.4	1.6	4	0.75	4	50	2	40°	20°	▲





P	●
M	○
K	○
N	-
S	○
H	○


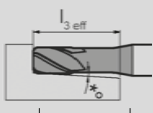


切削参数 DSKM Ø 0.1 - 0.8 mm

Cutting Data DSKM Ø 0.1 - 0.8 mm



B

	 vc = m/min	 vc = m/min		 vc = m/min	 vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

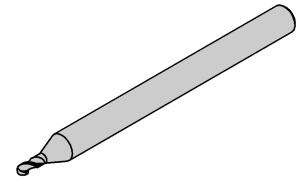
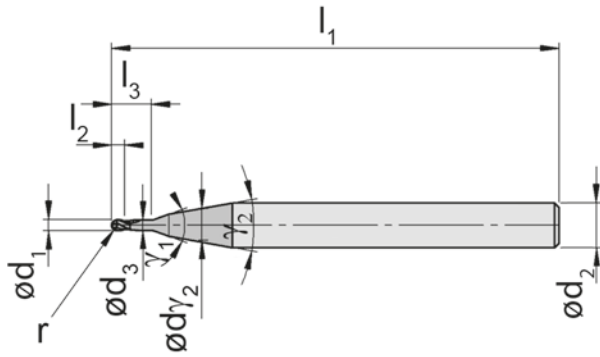
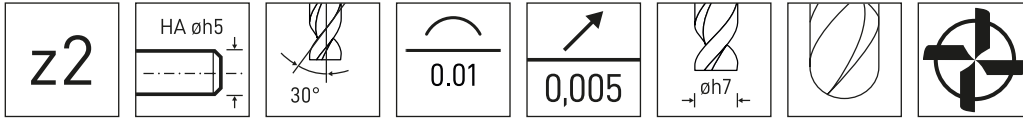
d ₁							f _z						
		0°	0.5°	1°	2°	3°		a _e	a _p	f _z	a _e	a _p	
0.1	5°	0.3	0.3	0.3	0.3	0.4	0.004	0.01	0.02	0.005	0.01	0.01	
0.1	5°	0.5	0.5	0.5	0.5	0.5	0.003	0.01	0.02	0.005	0.01	0.01	
0.2	5°	0.6	0.6	0.6	0.7	0.8	0.004	0.02	0.04	0.006	0.01	0.02	
0.2	5°	1.0	1.0	1.0	1.1	1.1	0.004	0.02	0.03	0.005	0.01	0.02	
0.2	3°	1.4	1.4	1.4	1.5	1.6	0.003	0.02	0.02	0.005	0.01	0.01	
0.3	5°	0.9	0.9	0.9	1.0	1.2	0.005	0.03	0.06	0.007	0.02	0.03	
0.3	5°	1.5	1.5	1.5	1.6	1.7	0.004	0.03	0.05	0.006	0.02	0.02	
0.3	3°	2.1	2.1	2.2	2.3	2.4	0.004	0.03	0.03	0.006	0.02	0.02	
0.4	5°	1.2	1.2	1.2	1.3	1.5	0.006	0.04	0.08	0.008	0.02	0.04	
0.4	5°	2.0	2.0	2.0	2.1	2.2	0.005	0.04	0.06	0.007	0.02	0.03	
0.4	3°	2.8	2.8	2.9	3.0	3.1	0.004	0.04	0.04	0.006	0.02	0.02	
0.5	5°	1.5	1.5	1.6	1.8	2.0	0.006	0.05	0.10	0.009	0.03	0.05	
0.5	5°	2.5	2.5	2.6	2.7	2.8	0.006	0.05	0.08	0.008	0.03	0.04	
0.5	3°	3.5	3.5	3.6	3.8	4.0	0.005	0.05	0.05	0.007	0.03	0.03	
0.6	5°	1.8	1.8	1.9	2.1	2.4	0.007	0.06	0.12	0.010	0.03	0.06	
0.6	5°	3.0	3.0	3.1	3.2	3.4	0.006	0.06	0.09	0.009	0.03	0.05	
0.6	3°	4.2	4.3	4.4	4.6	4.8	0.005	0.06	0.06	0.008	0.03	0.04	
0.7	5°	2.1	2.1	2.2	2.4	2.7	0.007	0.07	0.14	0.010	0.04	0.07	
0.7	5°	3.5	3.5	3.6	3.7	3.9	0.007	0.07	0.11	0.009	0.04	0.06	
0.8	5°	2.4	2.5	2.6	2.9	3.2	0.008	0.08	0.16	0.011	0.04	0.08	
0.8	5°	4.0	4.0	4.1	4.3	4.6	0.007	0.08	0.12	0.010	0.04	0.06	

微型立铣刀 End Mill Micro

DSKM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSKM.2.090.030	0.9	0.45	1.8	2.7	0.85	4	50	2	20°	-	▲
DSKM.2.090.050	0.9	0.45	1.8	4.5	0.85	4	50	2	40°	20°	▲
DSKM.2.100.030	1	0.5	2	3	0.95	4	50	2	20°	-	▲
DSKM.2.100.050	1	0.5	2	5	0.95	4	50	2	40°	20°	▲
DSKM.2.100.070	1	0.5	2	7	0.95	4	50	2	40°	20°	▲
DSKM.2.120.030	1.2	0.6	2.4	3.6	1.15	4	50	2	20°	-	▲
DSKM.2.120.050	1.2	0.6	2.4	6	1.15	4	50	2	40°	20°	▲
DSKM.2.120.070	1.2	0.6	2.4	8.4	1.15	4	50	2	40°	20°	▲
DSKM.2.150.030	1.5	0.75	3	4.5	1.45	4	50	2	20°	-	▲
DSKM.2.150.050	1.5	0.75	3	7.5	1.45	4	50	2	40°	20°	▲
DSKM.2.150.070	1.5	0.75	3	10.5	1.45	4	50	2	40°	20°	▲
DSKM.2.200.030	2	1	4	6	1.9	4	50	2	20°	-	▲
DSKM.2.200.050	2	1	4	10	1.9	4	50	2	40°	20°	▲
DSKM.2.200.070	2	1	4	14	1.9	4	50	2	40°	20°	▲
DSKM.2.250.030	2.5	1.25	5	7.5	2.4	4	50	2	20°	-	▲
DSKM.2.250.050	2.5	1.25	5	12.5	2.4	4	50	2	40°	20°	▲
DSKM.2.250.070	2.5	1.25	5	17.5	2.4	4	60	2	40°	20°	▲
DSKM.2.300.030	3	1.5	6	9	2.9	4	50	2	20°	-	▲
DSKM.2.300.050	3	1.5	6	15	2.9	4	50	2	40°	20°	▲
DSKM.2.300.070	3	1.5	6	21	2.9	4	60	2	40°	20°	▲





P	●
M	○
K	○
N	-
S	○
H	○


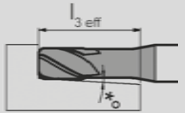


切削参数 DSKM Ø 0.9 - 3 mm

Cutting Data DSKM Ø 0.9 - 3 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

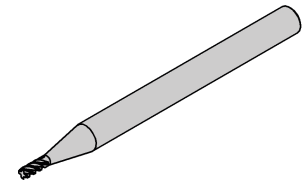
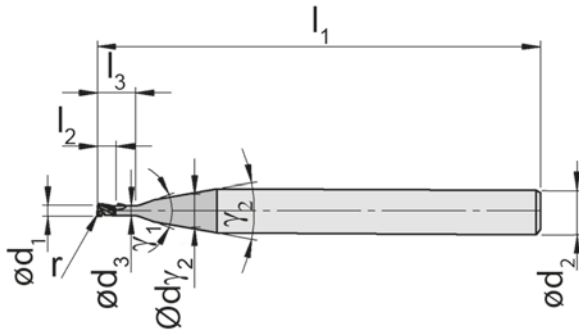
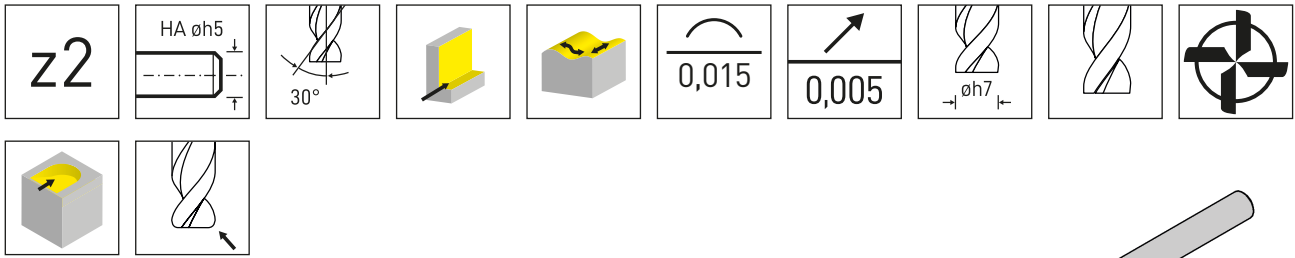
d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
0.9	5°	2.7	2.8	2.9	3.2	3.5	0.009	0.09	0.18	0.012	0.05	0.09
0.9	5°	4.5	4.5	4.6	4.8	5.1	0.008	0.09	0.14	0.011	0.05	0.07
1.0	5°	3.0	3.1	3.2	3.6	4	0.009	0.10	0.20	0.013	0.05	0.10
1.0	5°	5.0	5.1	5.2	5.4	5.7	0.008	0.10	0.15	0.012	0.05	0.08
1.0	3°	7.0	7	7.1	7.3	7.4	0.007	0.10	0.10	0.011	0.05	0.06
1.2	5°	3.6	3.7	3.9	4.3	4.8	0.011	0.12	0.24	0.015	0.06	0.12
1.2	5°	6.0	6.1	6.2	6.5	6.9	0.010	0.12	0.18	0.013	0.06	0.10
1.2	3°	8.4	8.5	8.7	9.2	9.8	0.008	0.12	0.12	0.012	0.06	0.07
1.5	5°	4.5	4.7	4.9	5.4	6.1	0.012	0.15	0.30	0.018	0.08	0.15
1.5	5°	7.5	7.6	7.8	8.2	8.6	0.011	0.15	0.23	0.016	0.08	0.12
1.5	3°	10.5	10.7	10.9	11.5	12.3	0.010	0.15	0.15	0.014	0.08	0.09
2.0	5°	6.0	6.2	6.5	7.2	8.1	0.016	0.20	0.40	0.022	0.10	0.20
2.0	5°	10.0	10.2	10.4	10.9	11.5	0.014	0.20	0.30	0.020	0.10	0.16
2.0	3°	14.0	14.3	14.6	15.3	17.2	0.013	0.20	0.20	0.018	0.10	0.12
2.5	5°	7.5	7.8	8.1	9	10.1	0.019	0.25	0.50	0.027	0.13	0.25
2.5	5°	12.5	12.7	13	13.7	∞	0.017	0.25	0.38	0.024	0.13	0.20
2.5	3°	17.5	17.9	18.3	19.5	∞	0.015	0.25	0.25	0.021	0.13	0.15
3.0	5°	9.0	9.3	9.8	10.8	∞	0.022	0.30	0.60	0.031	0.15	0.30
3.0	5°	15.0	15.3	15.6	∞	∞	0.020	0.30	0.45	0.028	0.15	0.24
3.0	3°	21.0	21.4	22.1	∞	∞	0.018	0.30	0.30	0.025	0.15	0.18

圆角微型立铣刀 Torus End Mill Micro

DSTM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSTM.2.010.000.030	0.1	0	0.2	0.3	0.08	4	50	2	20°	-	▲
DSTM.2.010.000.070	0.1	0	0.2	0.7	0.08	4	50	2	40°	20°	▲
DSTM.2.020.000.030	0.2	0	0.4	0.6	0.18	4	50	2	20°	-	▲
DSTM.2.020.000.050	0.2	0	0.4	1	0.18	4	50	2	40°	20°	▲
DSTM.2.020.000.070	0.2	0	0.4	1.4	0.18	4	50	2	40°	20°	▲
DSTM.2.030.000.030	0.3	0	0.6	0.9	0.28	4	50	2	20°	-	▲
DSTM.2.030.000.050	0.3	0	0.6	1.5	0.28	4	50	2	40°	20°	▲
DSTM.2.030.000.070	0.3	0	0.6	2.1	0.28	4	50	2	40°	20°	▲
DSTM.2.040.000.030	0.4	0	0.7	1.2	0.38	4	50	2	20°	-	▲
DSTM.2.040.000.050	0.4	0	0.7	2	0.38	4	50	2	40°	20°	▲
DSTM.2.040.000.070	0.4	0	0.7	2.8	0.38	4	50	2	40°	20°	▲
DSTM.2.050.000.030	0.5	0	1	1.5	0.47	4	50	2	20°	-	▲
DSTM.2.050.000.050	0.5	0	1	2.5	0.47	4	50	2	40°	20°	▲
DSTM.2.050.000.070	0.5	0	1	3.5	0.47	4	50	2	40°	20°	▲
DSTM.2.050.010.030	0.5	0.1	1	1.5	0.47	4	50	2	20°	-	▲
DSTM.2.050.010.050	0.5	0.1	1	2.5	0.47	4	50	2	40°	20°	▲
DSTM.2.050.010.070	0.5	0.1	1	3.5	0.47	4	50	2	40°	20°	▲
DSTM.2.060.000.030	0.6	0	1.2	1.8	0.6	4	50	2	20°	-	▲
DSTM.2.060.000.050	0.6	0	1.2	3	0.55	4	50	2	40°	20°	▲
DSTM.2.060.000.070	0.6	0	1.2	4.2	0.55	4	50	2	40°	20°	▲
DSTM.2.060.010.050	0.6	0.1	1.2	3	0.55	4	50	2	40°	20°	▲
DSTM.2.060.010.070	0.6	0.1	1.2	4.2	0.55	4	50	2	40°	20°	▲





P	●
M	○
K	○
N	-
S	○
H	○


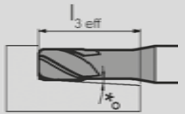


切削参数 DSTM Ø 0.1 - 0.6 mm

Cutting Data DSTM Ø 0.1 - 0.6 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	80	110
P3.1	130	160	S1.2	70	100
P3.2	130	160	S2.1	60	90
P4.1	130	160	S2.2	50	80
P4.2	130	160	S3.1	90	120
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

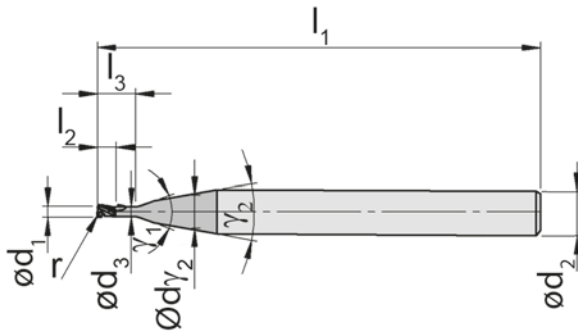
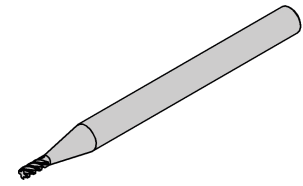
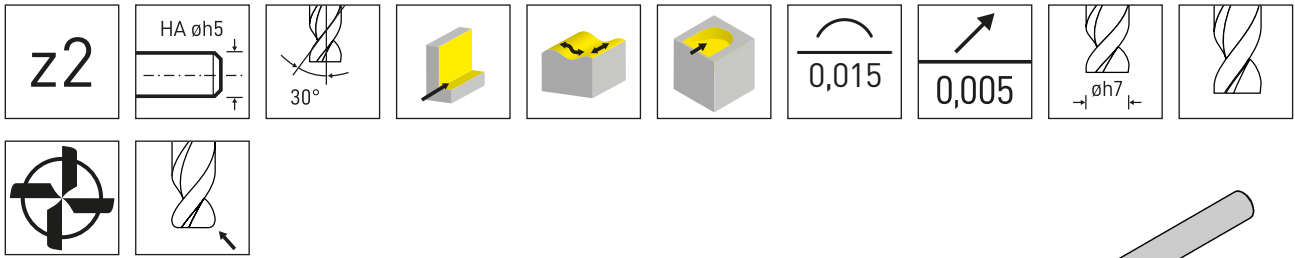
d_1												
		0°	0.5°	1°	2°	3°	f_z	a_e	a_p	f_z	a_e	a_p
0.1	5°	0.3	0.3	0.3	0.3	0.4	0.004	0.01	0.02	0.005	0.01	0.01
0.1	3°	0.7	0.7	0.7	0.8	0.9	0.003	0.01	0.01	0.004	0.01	0.01
0.2	5°	0.6	0.6	0.6	0.7	0.8	0.004	0.02	0.04	0.006	0.01	0.02
0.2	5°	1.0	1	1	1.1	1.1	0.004	0.02	0.03	0.005	0.01	0.02
0.2	3°	1.4	1.4	1.4	1.5	1.6	0.003	0.02	0.02	0.005	0.01	0.01
0.3	5°	0.9	0.9	0.9	1.1	1.2	0.005	0.03	0.06	0.007	0.02	0.03
0.3	5°	1.5	1.5	1.5	1.6	1.7	0.004	0.03	0.05	0.006	0.02	0.02
0.3	3°	2.1	2.1	2.2	2.3	2.4	0.004	0.03	0.03	0.006	0.02	0.02
0.4	5°	1.2	1.2	1.2	1.4	1.5	0.006	0.04	0.08	0.008	0.02	0.04
0.4	5°	2.0	2	2	2.1	2.2	0.005	0.04	0.06	0.007	0.02	0.03
0.4	3°	2.8	2.8	2.9	3	3.1	0.004	0.04	0.04	0.006	0.02	0.02
0.5	5°	1.5	1.5	1.6	1.8	2.1	0.006	0.05	0.10	0.009	0.03	0.05
0.5	5°	2.5	2.5	2.6	2.7	2.9	0.006	0.05	0.08	0.008	0.03	0.04
0.5	3°	3.5	3.5	3.6	3.8	4	0.005	0.05	0.05	0.007	0.03	0.03
0.5	5°	1.5	1.5	1.6	1.8	2	0.006	0.05	0.10	0.009	0.03	0.05
0.5	5°	2.5	2.5	2.6	2.7	2.9	0.006	0.05	0.08	0.008	0.03	0.04
0.5	3°	3.5	3.5	3.6	3.8	4	0.005	0.05	0.05	0.007	0.03	0.03
0.6	5°	1.8	1.8	1.9	2.2	2.5	0.007	0.06	0.12	0.010	0.03	0.06
0.6	5°	3.0	3	3.1	3.3	3.5	0.006	0.06	0.09	0.009	0.03	0.05
0.6	3°	4.2	4.2	4.4	4.6	4.9	0.005	0.06	0.06	0.008	0.03	0.04
0.6	5°	3.0	3	3.1	3.3	3.4	0.006	0.06	0.09	0.009	0.03	0.05
0.6	3°	4.2	4.2	4.4	4.6	4.8	0.005	0.06	0.06	0.008	0.03	0.04

圆角微型立铣刀 Torus End Mill Micro

DSTM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSTM.2.070.000.030	0.7	0	1.4	2.1	0.65	4	50	2	20°	-	▲
DSTM.2.070.010.030	0.7	0.1	1.4	2.1	0.65	4	50	2	20°	-	▲
DSTM.2.070.010.070	0.7	0.1	1.4	4.9	0.65	4	50	2	40°	20°	▲
DSTM.2.080.000.030	0.8	0	1.6	2.4	0.75	4	50	2	20°	-	▲
DSTM.2.080.000.050	0.8	0	1.6	4	0.75	4	50	2	40°	20°	▲
DSTM.2.080.000.070	0.8	0	1.6	5.6	0.75	4	50	2	40°	20°	▲
DSTM.2.080.010.070	0.8	0.1	1.6	5.6	0.75	4	50	2	40°	20°	▲
DSTM.2.090.000.030	0.9	0	1.8	2.7	0.85	4	50	2	20°	-	▲
DSTM.2.090.000.050	0.9	0	1.8	4.5	0.85	4	50	2	40°	20°	▲
DSTM.2.090.010.070	0.9	0.1	1.8	6.3	0.85	4	50	2	40°	20°	▲
DSTM.2.100.000.030	1	0	2	3	0.95	4	50	2	20°	-	▲
DSTM.2.100.000.050	1	0	2	5	0.95	4	50	2	40°	20°	▲
DSTM.2.100.000.070	1	0	2	7	0.95	4	50	2	40°	20°	▲
DSTM.2.100.010.030	1	0.1	2	3	0.95	4	50	2	20°	-	▲
DSTM.2.100.010.050	1	0.1	2	5	0.95	4	50	2	40°	20°	▲
DSTM.2.100.020.030	1	0.2	2	3	0.95	4	50	2	20°	-	▲
DSTM.2.100.020.050	1	0.2	2	5	0.95	4	50	2	40°	20°	▲





P	●
M	○
K	○
N	-
S	○
H	○


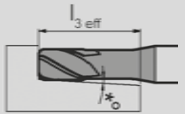


切削参数 DSTM Ø 0.7 - 1 mm

Cutting Data DSTM Ø 0.7 - 1 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	80	110
P3.1	130	160	S1.2	70	100
P3.2	130	160	S2.1	60	90
P4.1	130	160	S2.2	50	80
P4.2	130	160	S3.1	90	120
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

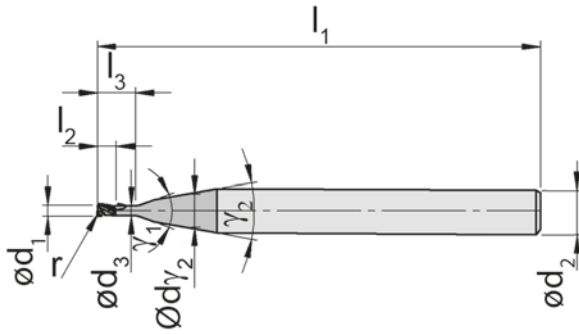
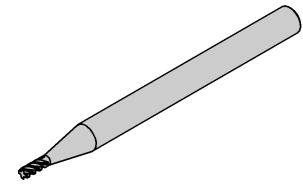
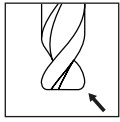
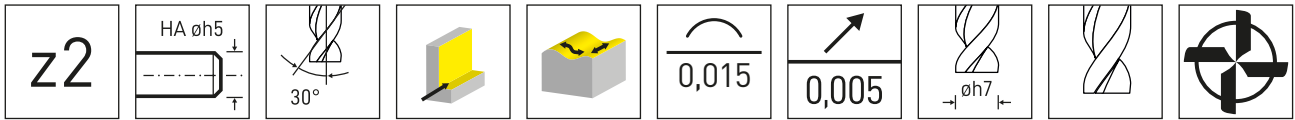
d_1												
		0°	0.5°	1°	2°	3°	f_z	a_e	a_p	f_z	a_e	a_p
0.7	5°	2.1	2.1	2.2	2.5	2.8	0.007	0.07	0.14	0.010	0.04	0.07
0.7	5°	2.1	2.1	2.2	2.5	2.8	0.007	0.07	0.14	0.010	0.04	0.07
0.7	3°	4.9	4.9	5.1	5.3	5.5	0.006	0.07	0.07	0.008	0.04	0.04
0.8	5°	2.4	2.5	2.6	2.9	3.3	0.008	0.08	0.16	0.011	0.04	0.08
0.8	5°	4.0	4	4.2	4.4	4.6	0.007	0.08	0.12	0.010	0.04	0.06
0.8	3°	5.6	5.7	5.8	6.1	6.5	0.006	0.08	0.08	0.009	0.04	0.05
0.8	3°	5.6	5.7	5.8	6.1	6.5	0.006	0.08	0.08	0.009	0.04	0.05
0.9	5°	2.7	2.8	2.9	3.2	3.6	0.009	0.09	0.18	0.012	0.05	0.09
0.9	5°	4.5	4.5	4.7	4.9	5.1	0.008	0.09	0.14	0.011	0.05	0.07
0.9	3°	6.3	6.4	6.5	6.8	7.2	0.007	0.09	0.09	0.010	0.05	0.05
1.0	5°	3.0	3.1	3.3	3.7	4.2	0.009	0.10	0.20	0.013	0.05	0.10
1.0	5°	5.0	5.1	5.2	5.5	5.8	0.008	0.10	0.15	0.012	0.05	0.08
1.0	3°	7.0	7.1	7.3	7.7	8.1	0.007	0.10	0.10	0.011	0.05	0.06
1.0	5°	3.0	3.1	3.3	3.7	4.2	0.009	0.10	0.20	0.013	0.05	0.10
1.0	5°	5.0	5.1	5.2	5.5	5.8	0.008	0.10	0.15	0.012	0.05	0.08
1.0	5°	3.0	3.1	3.3	3.7	4.2	0.009	0.10	0.20	0.013	0.05	0.10
1.0	5°	5.0	5.1	5.2	5.5	5.8	0.008	0.10	0.15	0.012	0.05	0.08

圆角微型立铣刀 Torus End Mill Micro

DSTM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSTM.2.120.000.030	1.2	0	2.4	3.6	1.15	4	50	2	20°	-	▲
DSTM.2.120.000.070	1.2	0	2.4	8.4	1.15	4	50	2	40°	20°	▲
DSTM.2.120.010.030	1.2	0.1	2.4	3.6	1.15	4	50	2	20°	-	▲
DSTM.2.120.010.050	1.2	0.1	2.4	6	1.15	4	50	2	40°	20°	▲
DSTM.2.120.010.070	1.2	0.1	2.4	8.4	1.15	4	50	2	40°	20°	▲
DSTM.2.120.020.030	1.2	0.2	2.4	3.6	1.15	4	50	2	20°	-	▲
DSTM.2.120.020.050	1.2	0.2	2.4	6	1.15	4	50	2	40°	20°	▲
DSTM.2.120.020.070	1.2	0.2	2.4	8.4	1.15	4	50	2	40°	20°	▲
DSTM.2.150.000.030	1.5	0	3	4.5	1.45	4	50	2	20°	-	▲
DSTM.2.150.000.070	1.5	0	3	10.5	1.45	4	50	2	40°	20°	▲
DSTM.2.150.010.030	1.5	0.1	3	4.5	1.45	4	50	2	20°	-	▲
DSTM.2.150.010.050	1.5	0.1	3	7.5	1.45	4	50	2	40°	20°	▲
DSTM.2.150.010.070	1.5	0.1	3	10.5	1.45	4	50	2	40°	20°	▲
DSTM.2.150.020.030	1.5	0.2	3	4.5	1.45	4	50	2	20°	-	▲
DSTM.2.150.050.030	1.5	0.5	3	4.5	1.45	4	50	2	20°	-	▲
DSTM.2.150.050.070	1.5	0.5	3	10.5	1.45	4	50	2	40°	20°	▲





P	●
M	○
K	○
N	-
S	○
H	○


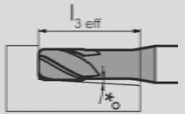


切削参数 DSTM Ø 1.2 - 1.5 mm

Cutting Data DSTM Ø 1.2 - 1.5 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	80	110
P3.1	130	160	S1.2	70	100
P3.2	130	160	S2.1	60	90
P4.1	130	160	S2.2	50	80
P4.2	130	160	S3.1	90	120
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

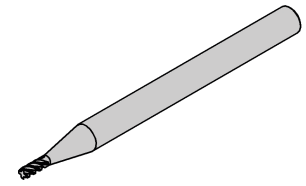
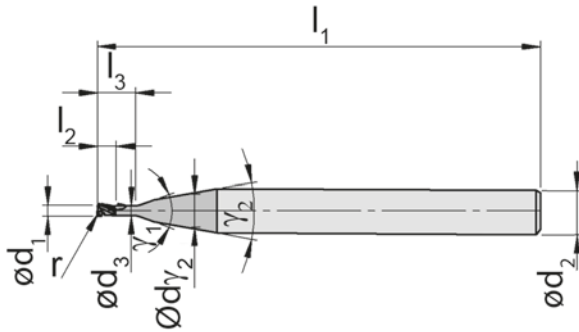
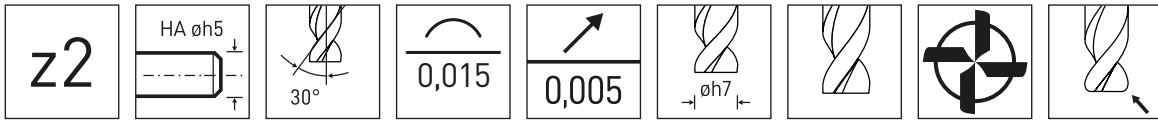
d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
1.2	5°	3.6	3.7	3.9	4.4	5.1	0.011	0.12	0.24	0.015	0.06	0.12
1.2	3°	8.4	8.6	8.8	9.2	10	0.008	0.12	0.12	0.012	0.06	0.07
1.2	5°	3.6	3.7	3.9	4.4	5	0.011	0.12	0.24	0.015	0.06	0.12
1.2	5°	6.0	6.1	6.3	6.6	6.9	0.010	0.12	0.18	0.013	0.06	0.10
1.2	3°	8.4	8.6	8.8	9.2	10	0.008	0.12	0.12	0.012	0.06	0.07
1.2	5°	3.6	3.7	3.9	4.4	5	0.011	0.12	0.24	0.015	0.06	0.12
1.2	5°	6.0	6.1	6.2	6.6	6.9	0.010	0.12	0.18	0.013	0.06	0.10
1.2	3°	8.4	8.5	8.8	9.2	10	0.008	0.12	0.12	0.012	0.06	0.07
1.5	5°	4.5	4.7	4.9	5.5	6.3	0.012	0.15	0.30	0.018	0.08	0.15
1.5	3°	10.5	10.7	11	11.6	12.6	0.010	0.15	0.15	0.014	0.08	0.09
1.5	5°	4.5	4.7	4.9	5.5	6.3	0.012	0.15	0.30	0.018	0.08	0.15
1.5	5°	7.5	7.6	7.8	8.2	8.7	0.011	0.15	0.23	0.016	0.08	0.12
1.5	3°	10.5	10.7	11	11.6	12.6	0.010	0.15	0.15	0.014	0.08	0.09
1.5	5°	4.5	4.7	4.9	5.5	6.3	0.012	0.15	0.30	0.018	0.08	0.15
1.5	5°	4.5	4.7	4.9	5.4	6.2	0.012	0.15	0.30	0.018	0.08	0.15
1.5	3°	10.5	10.7	11	11.5	12.4	0.010	0.15	0.15	0.014	0.08	0.09

圆角微型立铣刀 Torus End Mill Micro

DSTM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSTM.2.200.000.030	2	0	4	6	1.9	4	50	2	20°	-	▲
DSTM.2.200.000.050	2	0	4	10	1.9	4	50	2	40°	20°	▲
DSTM.2.200.000.070	2	0	4	14	1.9	4	50	2	40°	20°	▲
DSTM.2.200.010.030	2	0.1	4	6	1.9	4	50	2	20°	-	▲
DSTM.2.200.010.050	2	0.1	4	10	1.9	4	50	2	40°	20°	▲
DSTM.2.200.010.070	2	0.1	4	14	1.9	4	50	2	40°	20°	▲
DSTM.2.200.020.030	2	0.2	4	6	1.9	4	50	2	20°	-	▲
DSTM.2.200.020.050	2	0.2	4	10	1.9	4	50	2	40°	20°	▲
DSTM.2.200.020.070	2	0.2	4	14	1.9	4	50	2	40°	20°	▲
DSTM.2.200.050.030	2	0.5	4	6	1.9	4	50	2	20°	-	▲
DSTM.2.200.050.050	2	0.5	4	10	1.9	4	50	2	40°	20°	▲
DSTM.2.200.050.070	2	0.5	4	14	1.9	4	50	2	40°	20°	▲
DSTM.2.250.000.030	2.5	0	5	7.5	2.4	4	50	2	20°	-	▲
DSTM.2.250.000.050	2.5	0	5	12.5	2.4	4	50	2	40°	20°	▲
DSTM.2.250.000.070	2.5	0	5	17.5	2.4	4	60	2	40°	20°	▲
DSTM.2.250.010.030	2.5	0.1	5	7.5	2.4	4	50	2	20°	-	▲
DSTM.2.250.010.050	2.5	0.1	5	12.5	2.4	4	50	2	40°	20°	▲
DSTM.2.250.010.070	2.5	0.1	5	17.5	2.4	4	60	2	40°	20°	▲
DSTM.2.250.020.030	2.5	0.2	5	7.5	2.4	4	50	2	20°	-	▲





P	●
M	○
K	○
N	-
S	○
H	○


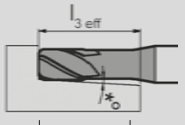


切削参数 DSTM Ø 2 - 2.5 mm

Cutting Data DSTM Ø 2 - 2.5 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	80	110
P3.1	130	160	S1.2	70	100
P3.2	130	160	S2.1	60	90
P4.1	130	160	S2.2	50	80
P4.2	130	160	S3.1	90	120
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

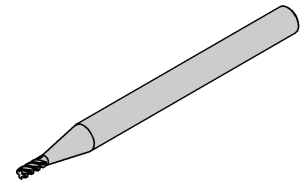
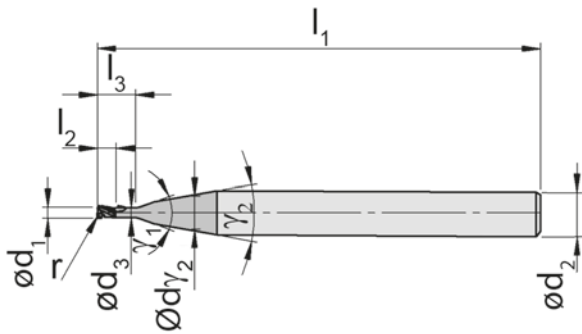
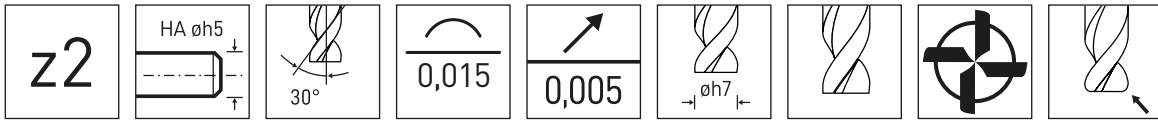
d ₁							f _z						
		0°	0.5°	1°	2°	3°		a _e	a _p	f _z	a _e	a _p	
2.0	5°	6.0	6.3	6.6	7.4	8.5	0.016	0.20	0.40	0.022	0.10	0.20	
2.0	5°	10.0	10.2	10.5	11	11.9	0.014	0.20	0.30	0.020	0.10	0.16	
2.0	3°	14.0	14.3	14.7	15.4	17.6	0.013	0.20	0.20	0.018	0.10	0.12	
2.0	5°	6.0	6.3	6.6	7.4	8.5	0.016	0.20	0.40	0.022	0.10	0.20	
2.0	5°	10.0	10.2	10.5	11	11.9	0.014	0.20	0.30	0.020	0.10	0.16	
2.0	3°	14.0	14.3	14.7	15.4	17.6	0.013	0.20	0.20	0.018	0.10	0.12	
2.0	5°	6.0	6.3	6.6	7.4	8.4	0.016	0.20	0.40	0.022	0.10	0.20	
2.0	5°	10.0	10.2	10.4	11	11.8	0.014	0.20	0.30	0.020	0.10	0.16	
2.0	3°	14.0	14.3	14.7	15.4	17.5	0.013	0.20	0.20	0.018	0.10	0.12	
2.0	5°	6.0	6.2	6.6	7.3	8.3	0.016	0.20	0.40	0.022	0.10	0.20	
2.0	5°	10.0	11.7	11	10.4	10.2	0.014	0.20	0.30	0.020	0.10	0.16	
2.0	3°	14.0	14.3	14.6	15.4	17.4	0.013	0.20	0.20	0.018	0.10	0.12	
2.5	5°	7.5	7.8	8.3	9.3	10.6	0.019	0.25	0.50	0.027	0.13	0.25	
2.5	5°	12.5	12.8	13.1	13.8	∞	0.017	0.25	0.38	0.024	0.13	0.20	
2.5	3°	17.5	17.9	18.3	19.8	∞	0.015	0.25	0.25	0.021	0.13	0.15	
2.5	5°	7.5	7.8	8.3	9.3	10.6	0.019	0.25	0.50	0.027	0.13	0.25	
2.5	5°	12.5	12.8	13.1	13.8	∞	0.017	0.25	0.38	0.024	0.13	0.20	
2.5	3°	17.5	17.9	18.3	19.8	∞	0.015	0.25	0.25	0.021	0.13	0.15	
2.5	5°	7.5	7.8	8.3	9.3	10.5	0.019	0.25	0.50	0.027	0.13	0.25	

圆角微型立铣刀 Torus End Mill Micro

DSTM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSTM.2.300.000.030	3	0	6	9	2.9	4	50	2	20°	-	▲
DSTM.2.300.000.050	3	0	6	15	2.9	4	50	2	40°	20°	▲
DSTM.2.300.000.070	3	0	6	21	2.9	4	60	2	40°	20°	▲
DSTM.2.300.010.030	3	0.1	6	9	2.9	4	50	2	20°	-	▲
DSTM.2.300.010.050	3	0.1	6	15	2.9	4	50	2	40°	20°	▲
DSTM.2.300.010.070	3	0.1	6	21	2.9	4	60	2	40°	20°	▲
DSTM.2.300.020.030	3	0.2	6	9	2.9	4	50	2	20°	-	▲
DSTM.2.300.100.030	3	1	6	9	2.9	4	50	2	20°	-	▲





P	●
M	○
K	○
N	-
S	○
H	○

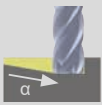
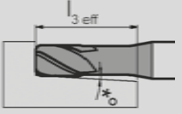


切削参数 DSTM Ø 3 mm

Cutting Data DSTM Ø 3 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	80	110
P3.1	130	160	S1.2	70	100
P3.2	130	160	S2.1	60	90
P4.1	130	160	S2.2	50	80
P4.2	130	160	S3.1	90	120
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

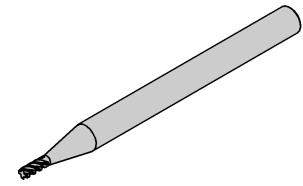
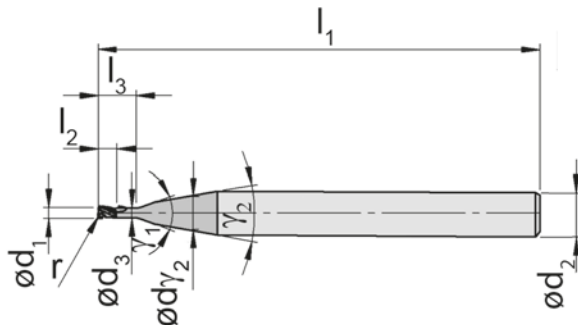
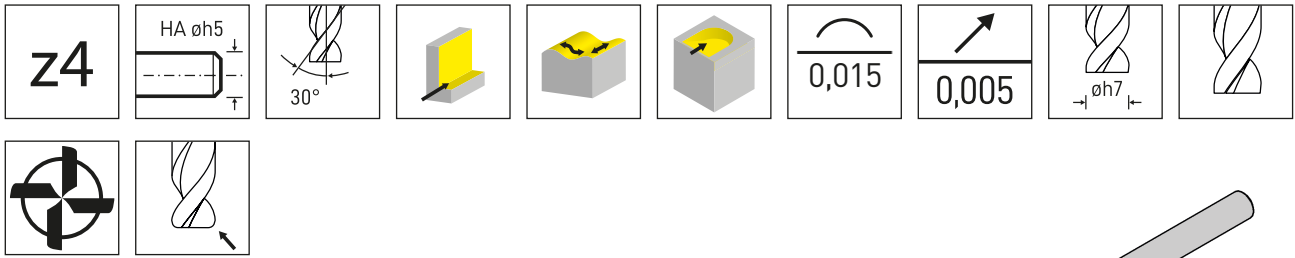
d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
3	5°	9.0	9.4	9.9	11.2	12.7	0.022	0.30	0.60	0.031	0.15	0.30
3	5°	15.0	15.3	15.7	∞	∞	0.020	0.30	0.45	0.028	0.15	0.24
3	3°	21.0	21.5	22.3	∞	∞	0.018	0.30	0.30	0.025	0.15	0.18
3	5°	9.0	9.4	9.9	11.2	12.7	0.022	0.30	0.60	0.031	0.15	0.30
3	5°	15.0	15.3	15.7	∞	∞	0.020	0.30	0.45	0.028	0.15	0.24
3	3°	21.0	21.5	22.3	∞	∞	0.018	0.30	0.30	0.025	0.15	0.18
3	5°	9.0	9.4	9.9	11.1	∞	0.022	0.30	0.60	0.031	0.15	0.30
3	5°	9.0	9.4	9.8	10.9	∞	0.022	0.30	0.60	0.031	0.15	0.30

圆角微型立铣刀 Torus End Mill Micro

DSTM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSTM.4.020.000.030	0.2	0	0.4	0.6	0.18	4	50	4	20°	-	▲
DSTM.4.020.000.050	0.2	0	0.4	1	0.18	4	50	4	40°	20°	▲
DSTM.4.020.000.070	0.2	0	0.4	1.4	0.18	4	50	4	40°	20°	▲
DSTM.4.030.000.030	0.3	0	0.6	0.9	0.28	4	50	4	20°	-	▲
DSTM.4.030.000.070	0.3	0	0.6	2.1	0.28	4	50	4	40°	20°	▲
DSTM.4.040.000.030	0.4	0	0.7	1.2	0.38	4	50	4	20°	-	▲
DSTM.4.040.000.050	0.4	0	0.7	2	0.38	4	50	4	40°	20°	▲
DSTM.4.040.000.070	0.4	0	0.7	2.8	0.38	4	50	4	40°	20°	▲
DSTM.4.050.000.030	0.5	0	1	1.5	0.47	4	50	4	20°	-	▲
DSTM.4.050.000.050	0.5	0	1	2.5	0.47	4	50	4	40°	20°	▲
DSTM.4.050.000.070	0.5	0	1	3.5	0.47	4	50	4	40°	20°	▲
DSTM.4.050.010.030	0.5	0.1	1	1.5	0.47	4	50	4	20°	-	▲
DSTM.4.050.010.050	0.5	0.1	1	2.5	0.47	4	50	4	40°	20°	▲
DSTM.4.050.010.070	0.5	0.1	1	3.5	0.47	4	50	4	40°	20°	▲
DSTM.4.060.000.030	0.6	0	1.2	1.8	0.6	4	50	4	20°	-	▲
DSTM.4.060.000.050	0.6	0	1.2	3	0.55	4	50	4	40°	20°	▲
DSTM.4.060.000.070	0.6	0	1.2	4.2	0.55	4	50	4	40°	20°	▲
DSTM.4.060.010.030	0.6	0.1	1.2	1.8	0.55	4	50	4	20°	-	▲
DSTM.4.060.010.050	0.6	0.1	1.2	3	0.55	4	50	4	40°	20°	▲
DSTM.4.060.010.070	0.6	0.1	1.2	4.2	0.55	4	50	4	40°	20°	▲



P	●
M	○
K	○
N	-
S	○
H	○


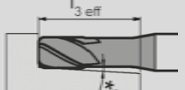


切削参数 DSTM Ø 0.2 - 0.6 mm

Cutting Data DSTM Ø 0.2 - 0.6 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	80	110
P3.1	130	160	S1.2	70	100
P3.2	130	160	S2.1	60	90
P4.1	130	160	S2.2	50	80
P4.2	130	160	S3.1	90	120
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

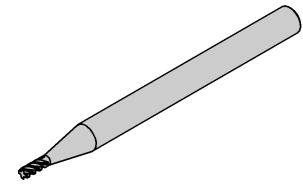
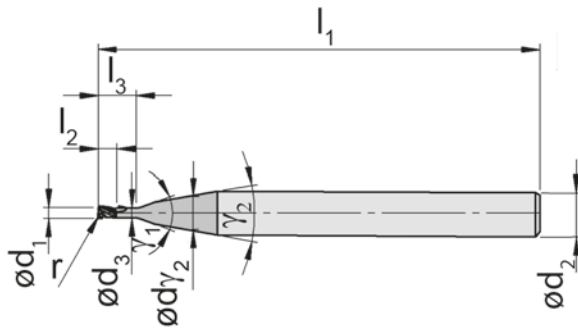
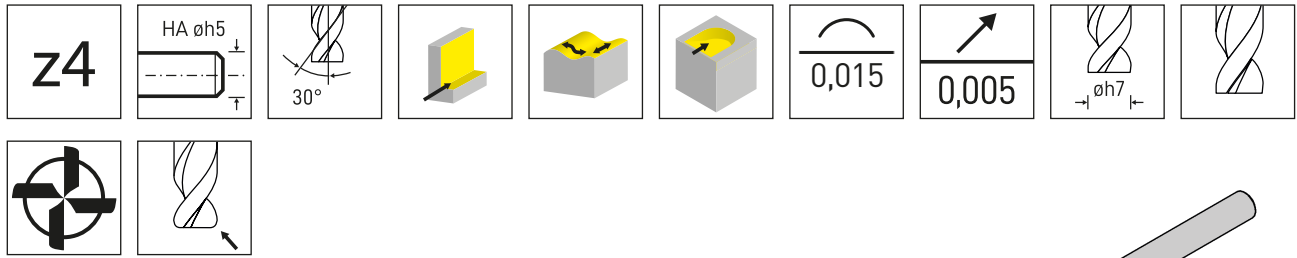
d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
0.2	4°	0.6	0.6	0.6	0.7	0.8	0.004	0.02	0.04	0.006	0.01	0.02
0.2	4°	1.0	1	1	1.1	1.1	0.004	0.02	0.03	0.005	0.01	0.02
0.2	3°	1.4	1.4	1.4	1.5	1.6	0.003	0.02	0.02	0.004	0.01	0.01
0.3	4°	0.9	0.9	0.9	1.1	1.2	0.005	0.03	0.06	0.006	0.02	0.03
0.3	3°	2.1	2.1	2.2	2.3	2.4	0.004	0.03	0.03	0.005	0.02	0.02
0.4	4°	1.2	1.2	1.2	1.4	1.5	0.005	0.04	0.08	0.007	0.02	0.04
0.4	4°	2.0	2	2	2.1	2.2	0.005	0.04	0.06	0.007	0.02	0.03
0.4	3°	2.8	2.8	2.9	3	3.1	0.004	0.04	0.04	0.006	0.02	0.02
0.5	4°	1.5	1.5	1.6	1.8	2.1	0.006	0.05	0.10	0.008	0.03	0.05
0.5	4°	2.5	2.5	2.6	2.7	2.9	0.005	0.05	0.08	0.007	0.03	0.04
0.5	3°	3.5	3.5	3.6	3.8	4	0.005	0.05	0.05	0.007	0.03	0.03
0.5	4°	1.5	1.5	1.6	1.8	2	0.006	0.05	0.10	0.008	0.03	0.05
0.5	4°	2.5	2.5	2.6	2.7	2.9	0.005	0.05	0.08	0.007	0.03	0.04
0.5	3°	3.5	3.5	3.6	3.8	4	0.005	0.05	0.05	0.007	0.03	0.03
0.6	4°	1.8	1.8	1.9	2.2	2.5	0.006	0.06	0.12	0.009	0.03	0.06
0.6	4°	3.0	3	3.1	3.3	3.5	0.006	0.06	0.09	0.008	0.03	0.05
0.6	3°	4.2	4.2	4.4	4.6	4.9	0.005	0.06	0.06	0.007	0.03	0.04
0.6	4°	1.8	1.8	1.9	2.2	2.5	0.006	0.06	0.12	0.009	0.03	0.06
0.6	4°	3.0	3	3.1	3.3	3.4	0.006	0.06	0.09	0.008	0.03	0.05
0.6	3°	4.2	4.2	4.4	4.6	4.8	0.005	0.06	0.06	0.007	0.03	0.04

圆角微型立铣刀 Torus End Mill Micro

DSTM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSTM.4.070.000.030	0.7	0	1.4	2.1	0.65	4	50	4	20°	-	▲
DSTM.4.070.000.050	0.7	0	1.4	3.5	0.65	4	50	4	40°	20°	▲
DSTM.4.070.010.030	0.7	0.1	1.4	2.1	0.65	4	50	4	20°	-	▲
DSTM.4.070.010.050	0.7	0.1	1.4	3.5	0.65	4	50	4	40°	20°	▲
DSTM.4.070.010.070	0.7	0.1	1.4	4.9	0.65	4	50	4	40°	20°	▲
DSTM.4.080.000.030	0.8	0	1.6	2.4	0.75	4	50	4	20°	-	▲
DSTM.4.080.000.050	0.8	0	1.6	4	0.75	4	50	4	40°	20°	▲
DSTM.4.080.000.070	0.8	0	1.6	5.6	0.75	4	50	4	40°	20°	▲
DSTM.4.080.010.030	0.8	0.1	1.6	2.4	0.75	4	50	4	20°	-	▲
DSTM.4.080.010.050	0.8	0.1	1.6	4	0.75	4	50	4	40°	20°	▲
DSTM.4.080.010.070	0.8	0.1	1.6	5.6	0.75	4	50	4	40°	20°	▲
DSTM.4.090.000.030	0.9	0	1.8	2.7	0.85	4	50	4	20°	-	▲
DSTM.4.090.000.070	0.9	0	1.8	6.3	0.85	4	50	4	40°	20°	▲
DSTM.4.090.010.030	0.9	0.1	1.8	2.7	0.85	4	50	4	20°	-	▲
DSTM.4.100.000.030	1	0	2	3	0.95	4	50	4	20°	-	▲
DSTM.4.100.000.050	1	0	2	5	0.95	4	50	4	40°	20°	▲
DSTM.4.100.000.070	1	0	2	7	0.95	4	50	4	40°	20°	▲
DSTM.4.100.010.030	1	0.1	2	3	0.95	4	50	4	20°	-	▲
DSTM.4.100.010.050	1	0.1	2	5	0.95	4	50	4	40°	20°	▲
DSTM.4.100.010.070	1	0.1	2	7	0.95	4	50	4	40°	20°	▲
DSTM.4.100.020.030	1	0.2	2	3	0.95	4	50	4	20°	-	▲
DSTM.4.100.020.050	1	0.2	2	5	0.95	4	50	4	40°	20°	▲
DSTM.4.100.020.070	1	0.2	2	7	0.95	4	50	4	40°	20°	▲





P	●
M	○
K	○
N	-
S	○
H	○


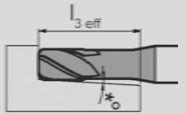


切削参数 DSTM Ø 0.7 - 1 mm

Cutting Data DSTM Ø 0.7 - 1 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	80	110
P3.1	130	160	S1.2	70	100
P3.2	130	160	S2.1	60	90
P4.1	130	160	S2.2	50	80
P4.2	130	160	S3.1	90	120
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

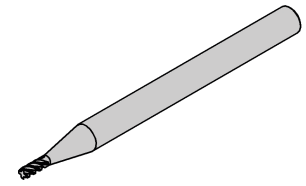
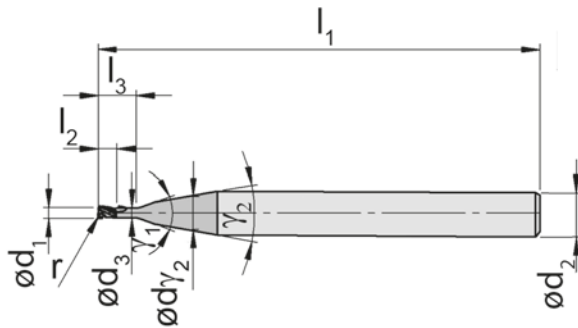
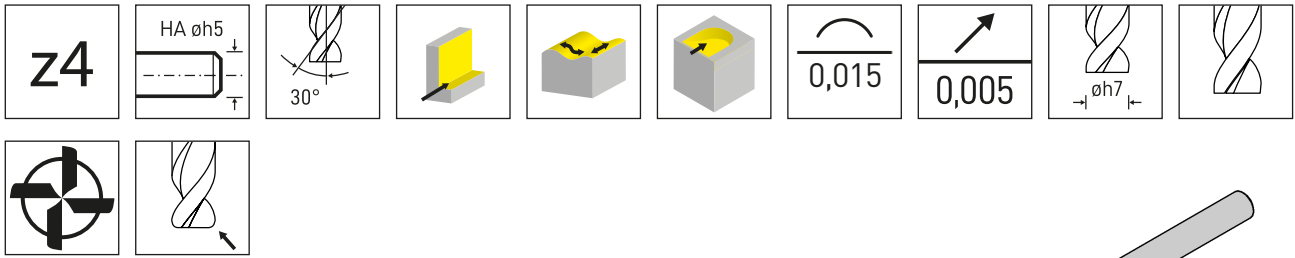
d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
0.7	4°	2.1	2.1	2.2	2.5	2.8	0.007	0.07	0.14	0.010	0.04	0.07
0.7	4°	3.5	3.5	3.6	3.8	3.9	0.006	0.07	0.11	0.009	0.04	0.06
0.7	4°	2.1	2.1	2.2	2.5	2.8	0.007	0.07	0.14	0.010	0.04	0.07
0.7	4°	3.5	3.5	3.6	3.8	3.9	0.006	0.07	0.11	0.009	0.04	0.06
0.7	3°	4.9	4.9	5.1	5.3	5.5	0.006	0.07	0.07	0.008	0.04	0.04
0.8	4°	2.4	2.5	2.6	2.9	3.3	0.008	0.08	0.16	0.011	0.04	0.08
0.8	4°	4.0	4	4.2	4.4	4.6	0.007	0.08	0.12	0.010	0.04	0.06
0.8	3°	5.6	5.7	5.8	6.1	6.5	0.006	0.08	0.08	0.009	0.04	0.05
0.8	4°	2.4	2.5	2.6	2.9	3.3	0.008	0.08	0.16	0.011	0.04	0.08
0.8	4°	4.0	4	4.2	4.4	4.6	0.007	0.08	0.12	0.010	0.04	0.06
0.8	3°	5.6	5.7	5.8	6.1	6.5	0.006	0.08	0.08	0.009	0.04	0.05
0.9	4°	2.7	2.8	2.9	3.2	3.6	0.008	0.09	0.18	0.012	0.05	0.09
0.9	3°	6.3	6.4	6.5	6.8	7.2	0.007	0.09	0.09	0.009	0.05	0.05
0.9	4°	2.7	2.8	2.9	3.2	3.6	0.008	0.09	0.18	0.012	0.05	0.09
1.0	4°	3.0	3.1	3.3	3.7	4.2	0.009	0.10	0.20	0.013	0.05	0.10
1.0	4°	5.0	5.1	5.2	5.5	5.8	0.008	0.10	0.15	0.011	0.05	0.08
1.0	3°	7.0	7.1	7.3	7.7	8.1	0.007	0.10	0.10	0.010	0.05	0.06
1.0	4°	3.0	3.1	3.3	3.7	4.2	0.009	0.10	0.20	0.013	0.05	0.10
1.0	4°	5.0	5.1	5.2	5.5	5.8	0.008	0.10	0.15	0.011	0.05	0.08
1.0	3°	7.0	7.1	7.3	7.7	8.1	0.007	0.10	0.10	0.010	0.05	0.06
1.0	4°	3.0	3.1	3.3	3.7	4.2	0.009	0.10	0.20	0.013	0.05	0.10
1.0	4°	5.0	5.1	5.2	5.5	5.8	0.008	0.10	0.15	0.011	0.05	0.08
1.0	3°	7.0	7.1	7.3	7.7	8.1	0.007	0.10	0.10	0.010	0.05	0.06

圆角微型立铣刀 Torus End Mill Micro

DSTM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSTM.4.120.000.030	1.2	0	2.4	3.6	1.15	4	50	4	20°	-	▲
DSTM.4.120.000.050	1.2	0	2.4	6	1.15	4	50	4	40°	20°	▲
DSTM.4.120.010.030	1.2	0.1	2.4	3.6	1.15	4	50	4	20°	-	▲
DSTM.4.120.010.050	1.2	0.1	2.4	6	1.15	4	50	4	40°	20°	▲
DSTM.4.120.020.030	1.2	0.2	2.4	3.6	1.15	4	50	4	20°	-	▲
DSTM.4.120.020.050	1.2	0.2	2.4	6	1.15	4	50	4	40°	20°	▲
DSTM.4.150.000.030	1.5	0	3	4.5	1.45	4	50	4	20°	-	▲
DSTM.4.150.000.050	1.5	0	3	7.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.000.070	1.5	0	3	10.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.010.030	1.5	0.1	3	4.5	1.45	4	50	4	20°	-	▲
DSTM.4.150.010.050	1.5	0.1	3	7.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.010.070	1.5	0.1	3	10.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.020.030	1.5	0.2	3	4.5	1.45	4	50	4	20°	-	▲
DSTM.4.150.020.050	1.5	0.2	3	7.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.020.070	1.5	0.2	3	10.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.050.030	1.5	0.5	3	4.5	1.45	4	50	4	20°	-	▲





P	●
M	○
K	○
N	-
S	○
H	○


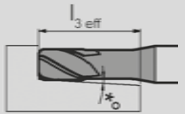


切削参数 DSTM Ø 1.2 - 1.5 mm

Cutting Data DSTM Ø 1.2 - 1.5 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	80	110
P3.1	130	160	S1.2	70	100
P3.2	130	160	S2.1	60	90
P4.1	130	160	S2.2	50	80
P4.2	130	160	S3.1	90	120
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

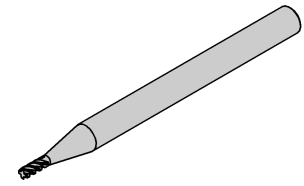
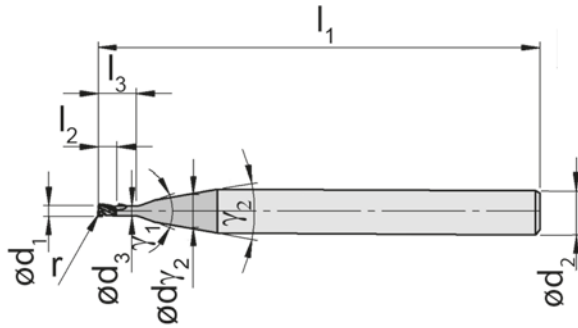
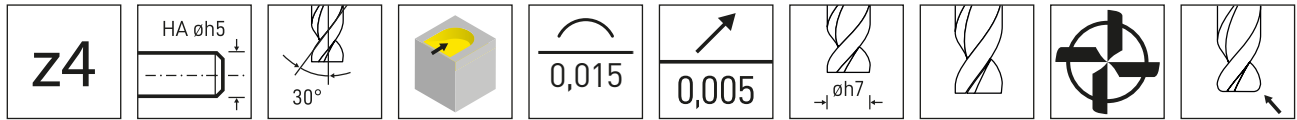
d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
1.2	4°	3.6	3.7	3.9	4.4	5.1	0.010	0.12	0.24	0.014	0.06	0.12
1.2	4°	6.0	6.1	6.3	6.6	7	0.009	0.12	0.18	0.013	0.06	0.10
1.2	4°	3.6	3.7	3.9	4.4	5	0.010	0.12	0.24	0.014	0.06	0.12
1.2	4°	6.0	6.1	6.3	6.6	6.9	0.009	0.12	0.18	0.013	0.06	0.10
1.2	4°	3.6	3.7	3.9	4.4	5	0.010	0.12	0.24	0.014	0.06	0.12
1.2	4°	6.0	6.1	6.2	6.6	6.9	0.009	0.12	0.18	0.013	0.06	0.10
1.5	4°	4.5	4.7	4.9	5.5	6.3	0.012	0.15	0.30	0.017	0.08	0.15
1.5	4°	7.5	7.6	7.8	8.2	8.7	0.011	0.15	0.23	0.015	0.08	0.12
1.5	3°	10.5	10.7	11	11.6	12.6	0.010	0.15	0.15	0.014	0.08	0.09
1.5	4°	4.5	4.7	4.9	5.5	6.3	0.012	0.15	0.30	0.017	0.08	0.15
1.5	4°	7.5	7.6	7.8	8.2	8.7	0.011	0.15	0.23	0.015	0.08	0.12
1.5	3°	10.5	10.7	11	11.6	12.6	0.010	0.15	0.15	0.014	0.08	0.09
1.5	4°	4.5	4.7	4.9	5.5	6.3	0.012	0.15	0.30	0.017	0.08	0.15
1.5	4°	7.5	7.6	7.8	8.2	8.7	0.011	0.15	0.23	0.015	0.08	0.12
1.5	3°	10.5	10.7	11	11.5	12.5	0.010	0.15	0.15	0.014	0.08	0.09
1.5	4°	4.5	4.7	4.9	5.4	6.2	0.012	0.15	0.30	0.017	0.08	0.15

圆角微型立铣刀 Torus End Mill Micro

DSTM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TSK
DSTM.4.200.000.030	2	0	4	6	1.9	4	50	4	20°	-	▲
DSTM.4.200.000.050	2	0	4	10	1.9	4	50	4	40°	20°	▲
DSTM.4.200.000.070	2	0	4	14	1.9	4	50	4	40°	20°	▲
DSTM.4.200.010.030	2	0.1	4	6	1.9	4	50	4	20°	-	▲
DSTM.4.200.010.050	2	0.1	4	10	1.9	4	50	4	40°	20°	▲
DSTM.4.200.010.070	2	0.1	4	14	1.9	4	50	4	40°	20°	▲
DSTM.4.200.020.030	2	0.2	4	6	1.9	4	50	4	20°	-	▲
DSTM.4.200.020.050	2	0.2	4	10	1.9	4	50	4	40°	20°	▲
DSTM.4.200.020.070	2	0.2	4	14	1.9	4	50	4	40°	20°	▲
DSTM.4.200.050.030	2	0.5	4	6	1.9	4	50	4	20°	-	▲
DSTM.4.200.050.050	2	0.5	4	10	1.9	4	50	4	40°	20°	▲
DSTM.4.200.050.070	2	0.5	4	14	1.9	4	50	4	40°	20°	▲
DSTM.4.250.000.030	2.5	0	5	7.5	2.4	4	50	4	20°	-	▲
DSTM.4.250.000.050	2.5	0	5	12.5	2.4	4	50	4	40°	20°	▲
DSTM.4.250.000.070	2.5	0	5	17.5	2.4	4	60	4	40°	20°	▲
DSTM.4.250.010.030	2.5	0.1	5	7.5	2.4	4	50	4	20°	-	▲
DSTM.4.250.010.050	2.5	0.1	5	12.5	2.4	4	50	4	40°	20°	▲
DSTM.4.250.010.070	2.5	0.1	5	17.5	2.4	4	60	4	40°	20°	▲
DSTM.4.250.020.030	2.5	0.2	5	7.5	2.4	4	50	4	20°	-	▲
DSTM.4.250.020.050	2.5	0.2	5	12.5	2.4	4	50	4	40°	20°	▲
DSTM.4.250.020.070	2.5	0.2	5	17.5	2.4	4	60	4	40°	20°	▲
DSTM.4.250.050.030	2.5	0.5	5	7.5	2.4	4	50	4	20°	-	▲
DSTM.4.250.050.050	2.5	0.5	5	12.5	2.4	4	50	4	40°	20°	▲





P	●
M	○
K	○
N	-
S	○
H	○

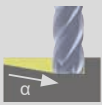



切削参数 DSTM Ø 2 - 2.5 mm

Cutting Data DSTM Ø 2 - 2.5 mm



B

	 vc = m/min	 vc = m/min		 vc = m/min	 vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	80	110
P3.1	130	160	S1.2	70	100
P3.2	130	160	S2.1	60	90
P4.1	130	160	S2.2	50	80
P4.2	130	160	S3.1	90	120
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

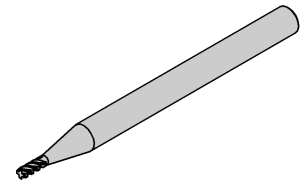
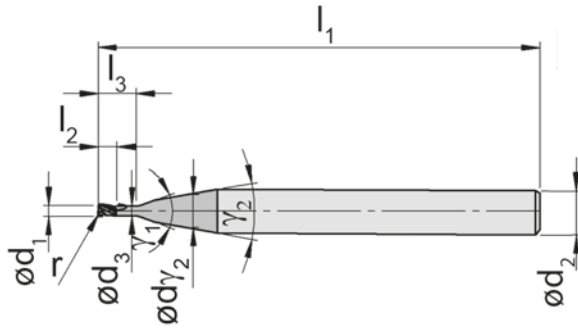
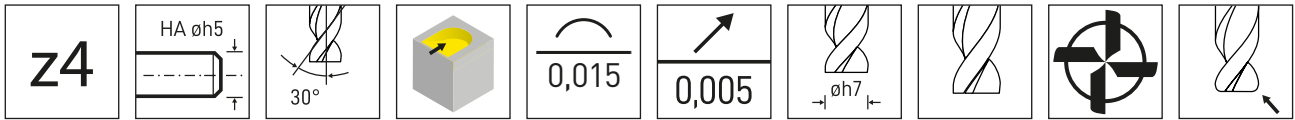
d ₁	 α	 l _{3 eff}										
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
2.0	4°	6.0	6.3	6.6	7.4	8.5	0.015	0.20	0.40	0.022	0.10	0.20
2.0	4°	10.0	10.2	10.5	11	11.9	0.014	0.20	0.30	0.019	0.10	0.16
2.0	3°	14.0	14.3	14.7	15.4	17.6	0.012	0.20	0.20	0.017	0.10	0.12
2.0	4°	6.0	6.3	6.6	7.4	8.5	0.015	0.20	0.40	0.022	0.10	0.20
2.0	4°	10.0	10.2	10.5	11	11.9	0.014	0.20	0.30	0.019	0.10	0.16
2.0	3°	14.0	14.3	14.7	15.4	17.6	0.012	0.20	0.20	0.017	0.10	0.12
2.0	4°	6.0	6.3	6.6	7.4	8.4	0.015	0.20	0.40	0.022	0.10	0.20
2.0	4°	10.0	10.2	10.4	11	11.8	0.014	0.20	0.30	0.019	0.10	0.16
2.0	3°	14.0	14.3	14.7	15.4	17.5	0.012	0.20	0.20	0.017	0.10	0.12
2.0	4°	6.0	6.2	6.6	7.3	8.3	0.015	0.20	0.40	0.022	0.10	0.20
2.0	4°	10.0	11.7	11	10.4	10.2	0.014	0.20	0.30	0.019	0.10	0.16
2.0	3°	14.0	14.3	14.6	15.4	17.4	0.012	0.20	0.20	0.017	0.10	0.12
2.5	4°	7.5	7.8	8.3	9.3	10.6	0.018	0.25	0.50	0.026	0.13	0.25
2.5	4°	12.5	12.8	13.1	13.8	∞	0.017	0.25	0.38	0.023	0.13	0.20
2.5	3°	17.5	17.9	18.3	19.8	∞	0.015	0.25	0.25	0.021	0.13	0.15
2.5	4°	7.5	7.8	8.3	9.3	10.6	0.018	0.25	0.50	0.026	0.13	0.25
2.5	4°	12.5	12.8	13.1	13.8	∞	0.017	0.25	0.38	0.023	0.13	0.20
2.5	3°	17.5	17.9	18.3	19.8	∞	0.015	0.25	0.25	0.021	0.13	0.15
2.5	4°	7.5	7.8	8.3	9.3	10.5	0.018	0.25	0.50	0.026	0.13	0.25
2.5	4°	12.5	12.8	13.1	13.8	∞	0.017	0.25	0.38	0.023	0.13	0.20
2.5	3°	17.5	17.9	18.3	19.7	∞	0.015	0.25	0.25	0.021	0.13	0.15
2.5	4°	7.5	7.8	8.2	9.2	10.4	0.018	0.25	0.50	0.026	0.13	0.25
2.5	4°	12.5	12.7	13.1	13.7	∞	0.017	0.25	0.38	0.023	0.13	0.20

圆角微型立铣刀 Torus End Mill Micro

DSTM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3K
DSTM.4.300.000.030	3	0	6	9	2.9	4	50	4	20°	-	▲
DSTM.4.300.000.050	3	0	6	15	2.9	4	50	4	40°	20°	▲
DSTM.4.300.000.070	3	0	6	21	2.9	4	60	4	40°	20°	▲
DSTM.4.300.010.030	3	0.1	6	9	2.9	4	50	4	20°	-	▲
DSTM.4.300.010.050	3	0.1	6	15	2.9	4	50	4	40°	20°	▲
DSTM.4.300.010.070	3	0.1	6	21	2.9	4	60	4	40°	20°	▲
DSTM.4.300.020.030	3	0.2	6	9	2.9	4	50	4	20°	-	▲
DSTM.4.300.020.050	3	0.2	6	15	2.9	4	50	4	40°	20°	▲
DSTM.4.300.020.070	3	0.2	6	21	2.9	4	60	4	40°	20°	▲
DSTM.4.300.050.030	3	0.5	6	9	2.9	4	50	4	20°	-	▲
DSTM.4.300.050.050	3	0.5	6	15	2.9	4	50	4	40°	20°	▲
DSTM.4.300.050.070	3	0.5	6	21	2.9	4	60	4	40°	20°	▲
DSTM.4.300.100.030	3	1	6	9	2.9	4	50	4	20°	-	▲
DSTM.4.300.100.050	3	1	6	15	2.9	4	50	4	40°	20°	▲
DSTM.4.300.100.070	3	1	6	21	2.9	4	60	4	40°	20°	▲





P	●
M	○
K	○
N	-
S	○
H	○


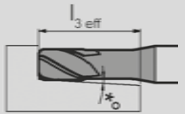


切削参数 DSTM Ø 3 mm

Cutting Data DSTM Ø 3 mm

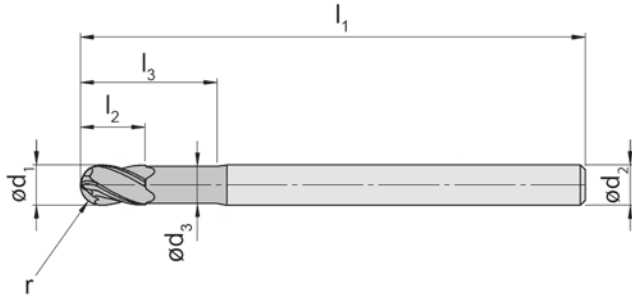
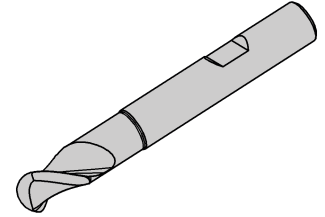
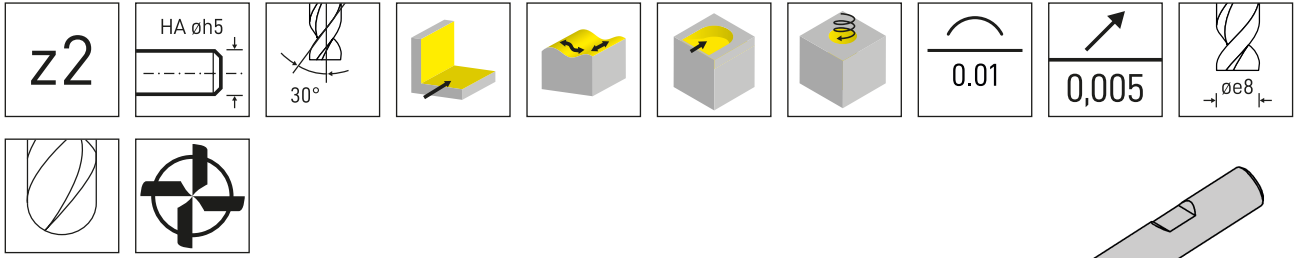


B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	80	110
P3.1	130	160	S1.2	70	100
P3.2	130	160	S2.1	60	90
P4.1	130	160	S2.2	50	80
P4.2	130	160	S3.1	90	120
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
3	4°	9.0	9.4	9.9	11.2	12.7	0.022	0.30	0.60	0.031	0.15	0.30
3	4°	15.0	15.3	15.7	∞	∞	0.019	0.30	0.45	0.028	0.15	0.24
3	3°	21.0	21.5	22.3	∞	∞	0.017	0.30	0.30	0.024	0.15	0.18
3	4°	9.0	9.4	9.9	11.2	12.7	0.022	0.30	0.60	0.031	0.15	0.30
3	4°	15.0	15.3	15.7	∞	∞	0.019	0.30	0.45	0.028	0.15	0.24
3	3°	21.0	21.5	22.3	∞	∞	0.017	0.30	0.30	0.024	0.15	0.18
3	4°	9.0	9.4	9.9	11.1	∞	0.022	0.30	0.60	0.031	0.15	0.30
3	4°	15.0	15.3	15.7	∞	∞	0.019	0.30	0.45	0.028	0.15	0.24
3	3°	21.0	21.5	22.3	∞	∞	0.017	0.30	0.30	0.024	0.15	0.18
3	4°	9.0	9.4	9.9	11.1	∞	0.022	0.30	0.60	0.031	0.15	0.30
3	4°	15.0	15.3	15.7	∞	∞	0.019	0.30	0.45	0.028	0.15	0.24
3	3°	21.0	21.5	22.2	∞	∞	0.017	0.30	0.30	0.024	0.15	0.18
3	4°	9.0	9.4	9.8	10.9	∞	0.022	0.30	0.60	0.031	0.15	0.30
3	4°	15.0	15.3	15.7	∞	∞	0.019	0.30	0.45	0.028	0.15	0.24
3	3°	21.0	21.4	22.2	∞	∞	0.017	0.30	0.30	0.024	0.15	0.18

B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	类型 Type	TS3K
DSK.2.035.030	3.5	1.75	7	10.5	3.4	6	64	2	40°	HA	▲
DSK.2.035.050	3.5	1.75	7	17.5	3.4	6	64	2	40°	HA	▲
DSK.2.040.030	4	2	8	12	3.8	6	64	2	40°	HA	▲
DSK.2.040.050	4	2	8	20	3.8	6	64	2	40°	HA	▲
DSK.2.040.070	4	2	8	28	3.8	6	78	2	40°	HA	▲
DSK.2.050.050	5	2.5	10	25	4.7	6	64	2	40°	HA	▲
DSK.2.050.070	5	2.5	10	35	4.7	6	78	2	40°	HA	▲
DSK.2.060.030	6	3	12	18	5.7	6	64	2	-	HA	▲
DSK.2.060.050	6	3	12	30	5.7	6	78	2	-	HA	▲
DSK.2.060.070	6	3	12	42	5.7	6	100	2	-	HA	▲
DSK.2.080.030	8	4	16	24	7.6	8	64	2	-	HA	▲
DSK.2.080.050	8	4	16	40	7.6	8	100	2	-	HA	▲
DSK.2.080.070	8	4	16	56	7.6	8	100	2	-	HA	▲
DSK.2.100.030	10	5	20	30	9.6	10	78	2	-	HA	▲
DSK.2.100.050	10	5	20	50	9.6	10	100	2	-	HA	▲
DSK.2.100.070	10	5	20	70	9.6	10	120	2	-	HA	▲
DSK.2.120.030	12	6	24	36	11.6	12	100	2	-	HA	▲
DSK.2.120.050	12	6	24	60	11.6	12	120	2	-	HA	▲
DSK.2.160.050	16	8	32	80	15.4	16	140	2	-	HA	▲





P	●
M	○
K	○
N	-
S	○
H	○

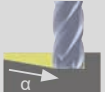
切削参数 DSK Ø 3.5 - 16 mm

Cutting Data DSK Ø 3.5 - 16 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

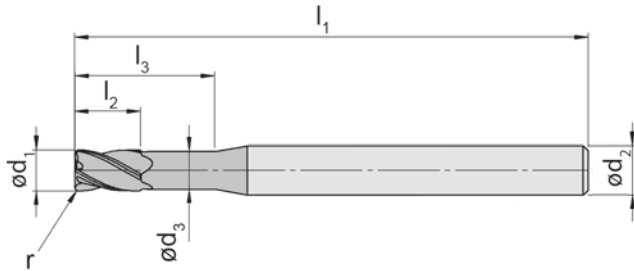
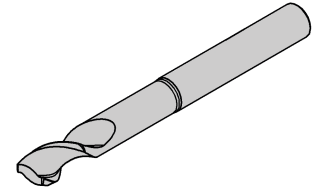
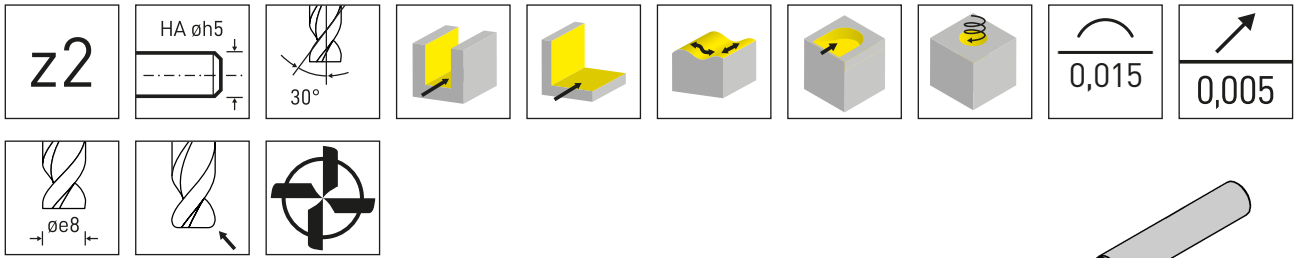
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
3.5	5°	0.03	0.35	0.70	0.04	0.18	0.35
3.5	5°	0.03	0.35	0.70	0.04	0.18	0.35
4.0	5°	0.03	0.40	0.80	0.04	0.20	0.40
4.0	5°	0.03	0.40	0.80	0.04	0.20	0.40
4.0	5°	0.03	0.50	1.00	0.05	0.25	0.50
5.0	5°	0.03	0.50	1.00	0.05	0.25	0.50
5.0	5°	0.03	0.50	1.00	0.05	0.25	0.50
6.0	5°	0.04	0.60	1.20	0.06	0.30	0.60
6.0	5°	0.04	0.60	1.20	0.06	0.30	0.60
6.0	5°	0.05	0.80	1.60	0.08	0.40	0.80
8.0	5°	0.05	0.80	1.60	0.08	0.40	0.80
8.0	5°	0.05	0.80	1.60	0.08	0.40	0.80
8.0	5°	0.05	0.80	1.60	0.08	0.40	0.80
10.0	5°	0.07	1.00	2.00	0.09	0.50	1.00
10.0	5°	0.07	1.00	2.00	0.09	0.50	1.00
10.0	5°	0.08	1.20	2.40	0.11	0.60	1.20
12.0	5°	0.08	1.20	2.40	0.11	0.60	1.20
12.0	5°	0.08	1.20	2.40	0.11	0.60	1.20
16.0	5°	0.10	1.60	3.20	0.15	0.80	1.60

圆角立铣刀 Torus End Mill

DST



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	类型 Type	TS3K
DST.2.035.020.050	3.5	0.2	7	17.5	3.4	6	64	2	40°	HA	▲
DST.2.035.020.070	3.5	0.2	7	24.5	3.4	6	64	2	40°	HA	▲
DST.2.035.050.030	3.5	0.5	7	10.5	3.4	6	64	2	40°	HA	▲
DST.2.035.050.050	3.5	0.5	7	17.5	3.4	6	64	2	40°	HA	▲
DST.2.035.050.070	3.5	0.5	7	24.5	3.4	6	64	2	40°	HA	▲
DST.2.035.100.070	3.5	1	7	24.5	3.4	6	64	2	40°	HA	▲
DST.2.040.020.030	4	0.2	8	12	3.8	6	64	2	40°	HA	▲
DST.2.040.020.050	4	0.2	8	20	3.8	6	64	2	40°	HA	▲
DST.2.040.020.070	4	0.2	8	28	3.8	6	78	2	40°	HA	▲
DST.2.040.050.030	4	0.5	8	12	3.8	6	64	2	40°	HA	▲
DST.2.040.100.050	4	1	8	20	3.8	6	64	2	40°	HA	▲
DST.2.050.020.030	5	0.2	10	15	4.7	6	64	2	40°	HA	▲
DST.2.050.020.050	5	0.2	10	25	4.7	6	64	2	40°	HA	▲
DST.2.050.020.070	5	0.2	10	35	4.7	6	78	2	40°	HA	▲
DST.2.050.050.050	5	0.5	10	25	4.7	6	64	2	40°	HA	▲
DST.2.050.050.070	5	0.5	10	35	4.7	6	78	2	40°	HA	▲
DST.2.050.100.050	5	1	10	25	4.7	6	64	2	40°	HA	▲
DST.2.050.100.070	5	1	10	35	4.7	6	78	2	40°	HA	▲





P	●
M	○
K	○
N	-
S	○
H	○

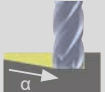


切削参数 DST Ø 3.5 - 5 mm

Cutting Data DST Ø 3.5 - 5 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

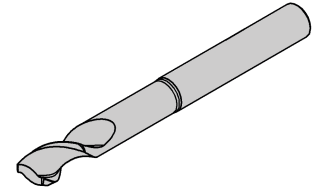
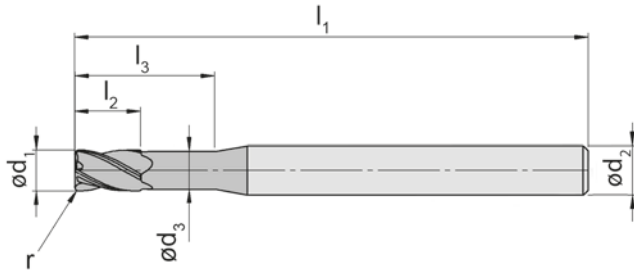
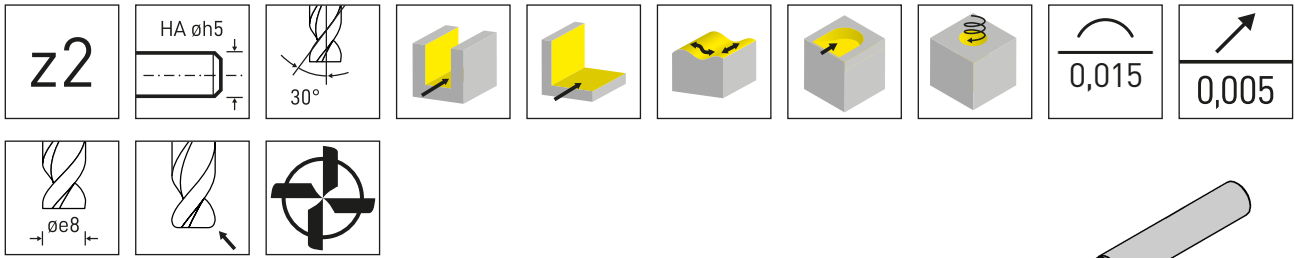
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
3.5	5°	0.025	0.35	0.70	0.036	0.18	0.35
3.5	5°	0.025	0.35	0.70	0.036	0.18	0.35
3.5	5°	0.025	0.35	0.70	0.036	0.18	0.35
3.5	5°	0.025	0.35	0.70	0.036	0.18	0.35
3.5	5°	0.025	0.35	0.70	0.036	0.18	0.35
4.0	5°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	5°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	5°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	5°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	5°	0.028	0.40	0.80	0.040	0.20	0.40
5.0	5°	0.035	0.50	1.00	0.049	0.25	0.50
5.0	5°	0.035	0.50	1.00	0.049	0.25	0.50
5.0	5°	0.035	0.50	1.00	0.049	0.25	0.50
5.0	5°	0.035	0.50	1.00	0.049	0.25	0.50
5.0	5°	0.035	0.50	1.00	0.049	0.25	0.50

圆角立铣刀 Torus End Mill

DST



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	类型 Type	TS3K
DST.2.060.020.030	6	0.2	12	18	5.7	6	64	2	HA	▲
DST.2.060.020.070	6	0.2	12	42	5.7	6	100	2	HA	▲
DST.2.060.050.050	6	0.5	12	30	5.7	6	78	2	HA	▲
DST.2.060.100.070	6	1	12	42	5.7	6	100	2	HA	▲
DST.2.060.200.030	6	2	12	18	5.7	6	64	2	HA	▲
DST.2.060.200.070	6	2	12	42	5.7	6	100	2	HA	▲
DST.2.080.020.070	8	0.2	16	56	7.6	8	100	2	HA	▲
DST.2.080.050.030	8	0.5	16	24	7.6	8	64	2	HA	▲
DST.2.080.050.050	8	0.5	16	40	7.6	8	100	2	HA	▲
DST.2.080.050.070	8	0.5	16	56	7.6	8	100	2	HA	▲
DST.2.080.100.070	8	1	16	56	7.6	8	100	2	HA	▲
DST.2.080.200.050	8	2	16	40	7.6	8	100	2	HA	▲
DST.2.080.200.070	8	2	16	56	7.6	8	100	2	HA	▲





P	●
M	○
K	○
N	-
S	○
H	○

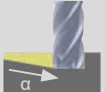


切削参数 DST Ø 6 - 8 mm

Cutting Data DST Ø 6 - 8 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

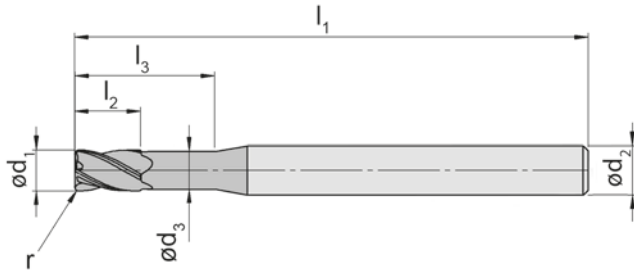
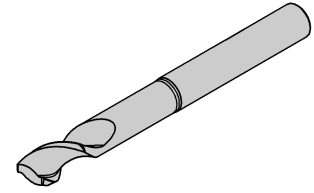
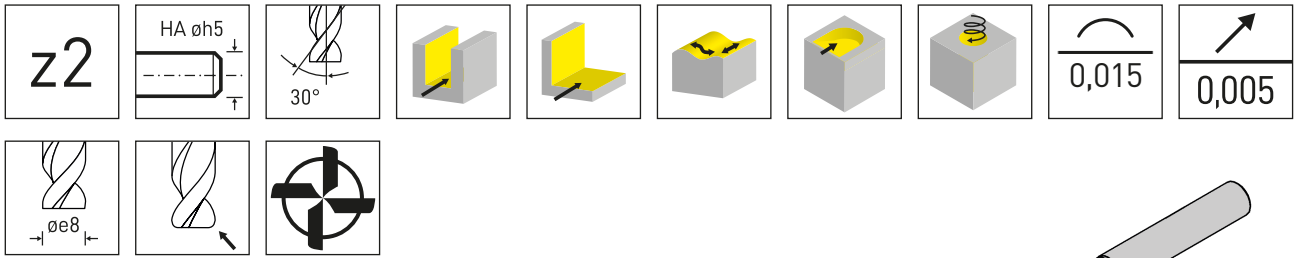
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
6	5°	0.041	0.60	1.20	0.058	0.30	0.60
6	5°	0.041	0.60	1.20	0.058	0.30	0.60
6	5°	0.041	0.60	1.20	0.058	0.30	0.60
6	5°	0.041	0.60	1.20	0.058	0.30	0.60
6	5°	0.041	0.60	1.20	0.058	0.30	0.60
6	5°	0.041	0.60	1.20	0.058	0.30	0.60
8	5°	0.054	0.80	1.60	0.076	0.40	0.80
8	5°	0.054	0.80	1.60	0.076	0.40	0.80
8	5°	0.054	0.80	1.60	0.076	0.40	0.80
8	5°	0.054	0.80	1.60	0.076	0.40	0.80
8	5°	0.054	0.80	1.60	0.076	0.40	0.80
8	5°	0.054	0.80	1.60	0.076	0.40	0.80

圆角立铣刀 Torus End Mill

DST



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	类型 Type	TS3K
DST.2.100.020.030	10	0.2	20	30	9.6	10	78	2	HA	▲
DST.2.100.020.070	10	0.2	20	70	9.6	10	120	2	HA	▲
DST.2.120.020.030	12	0.2	24	36	11.6	12	100	2	HA	▲
DST.2.120.020.070	12	0.2	24	84	11.6	12	140	2	HA	▲
DST.2.120.050.050	12	0.5	24	60	11.6	12	120	2	HA	▲
DST.2.120.200.050	12	2	24	60	11.6	12	120	2	HA	▲





P	●
M	○
K	○
N	-
S	○
H	○

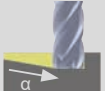


切削参数 DST Ø 10 - 12 mm

Cutting Data DST Ø 10 - 12 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

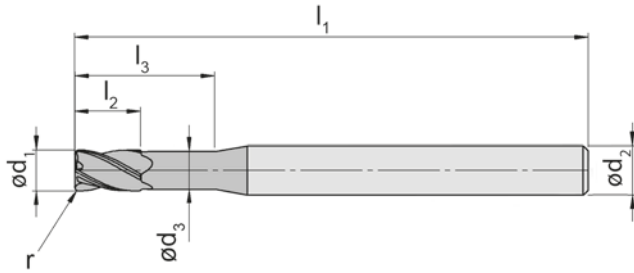
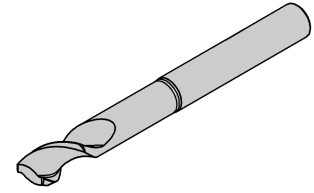
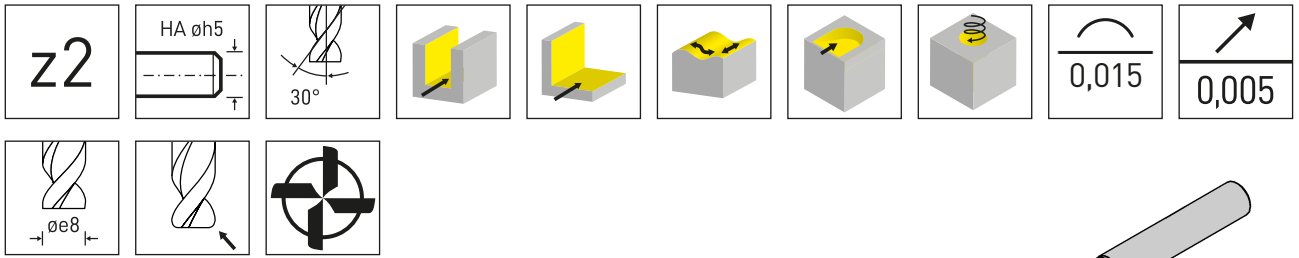
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
10	5°	0.066	1.00	2.00	0.094	0.50	1.00
10	5°	0.066	1.00	2.00	0.094	0.50	1.00
12	5°	0.079	1.20	2.40	0.112	0.60	1.20
12	5°	0.079	1.20	2.40	0.112	0.60	1.20
12	5°	0.079	1.20	2.40	0.112	0.60	1.20
12	5°	0.079	1.20	2.40	0.112	0.60	1.20

圆角立铣刀 Torus End Mill

DST



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks





产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	类型 Type	TS3K
DST.2.160.020.070	16	0.2	32	112	15.4	16	163	2	HA	▲
										P ●
										M ○
										K ○
										N -
										S ○
										H ○

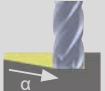


切削参数 DST Ø 16 mm

Cutting Data DST Ø 16 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

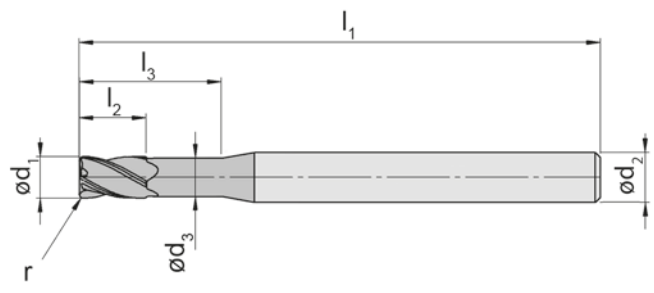
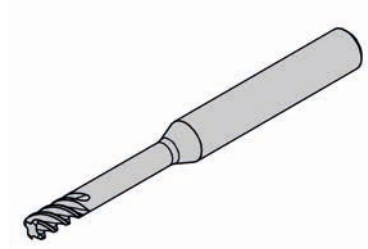
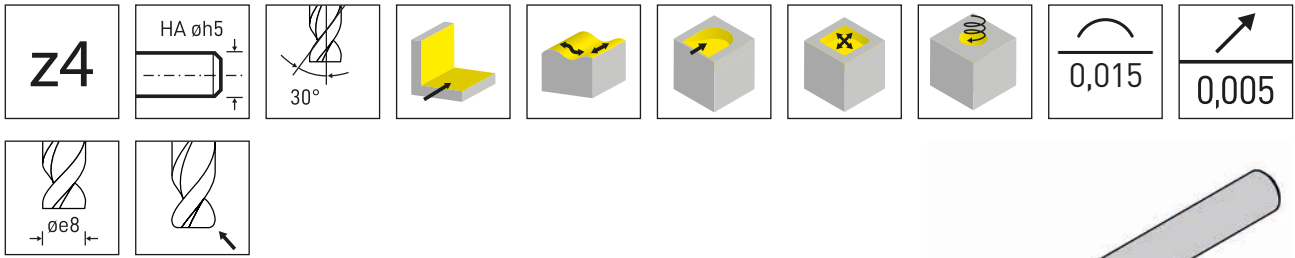
							
d_1	f_z	a_e	a_p	f_z	a_e	a_p	
16	5°	0.104	1.60	3.20	0.147	0.80	1.60

圆角立铣刀 Torus End Mill

DST



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	类型 Type	TS3K
DST.4.035.020.030	3.5	0.2	7	10.5	3.4	6	64	4	40°	HA	▲
DST.4.035.020.050	3.5	0.2	7	17.5	3.4	6	64	4	40°	HA	▲
DST.4.035.020.070	3.5	0.2	7	24.5	3.4	6	64	4	40°	HA	▲
DST.4.035.050.030	3.5	0.5	7	10.5	3.4	6	64	4	40°	HA	▲
DST.4.035.050.050	3.5	0.5	7	17.5	3.4	6	64	4	40°	HA	▲
DST.4.035.050.070	3.5	0.5	7	24.5	3.4	6	64	4	40°	HA	▲
DST.4.035.100.030	3.5	1	7	10.5	3.4	6	64	4	40°	HA	▲
DST.4.035.100.070	3.5	1	7	24.5	3.4	6	64	4	40°	HA	▲
DST.4.040.020.030	4	0.2	8	12	3.8	6	64	4	40°	HA	▲
DST.4.040.020.050	4	0.2	8	20	3.8	6	64	4	40°	HA	▲
DST.4.040.020.070	4	0.2	8	28	3.8	6	78	4	40°	HA	▲
DST.4.040.050.030	4	0.5	8	12	3.8	6	64	4	40°	HA	▲
DST.4.040.050.050	4	0.5	8	20	3.8	6	64	4	40°	HA	▲
DST.4.040.050.070	4	0.5	8	28	3.8	6	78	4	40°	HA	▲
DST.4.040.100.030	4	1	8	12	3.8	6	64	4	40°	HA	▲
DST.4.040.100.050	4	1	8	20	3.8	6	64	4	40°	HA	▲
DST.4.040.100.070	4	1	8	28	3.8	6	78	4	40°	HA	▲





P	●
M	○
K	○
N	-
S	○
H	○

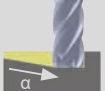


切削参数 DST Ø 3.5 - 4 mm

Cutting Data DST Ø 3.5 - 4 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

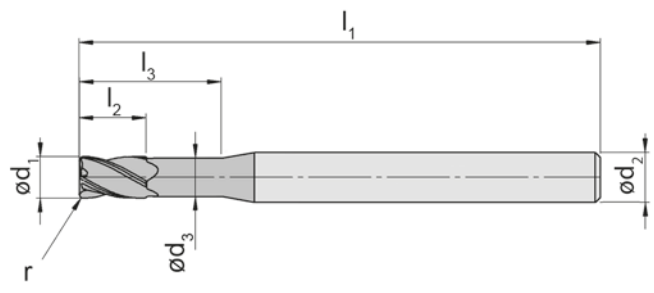
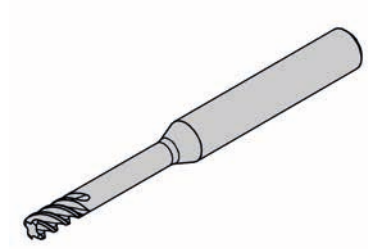
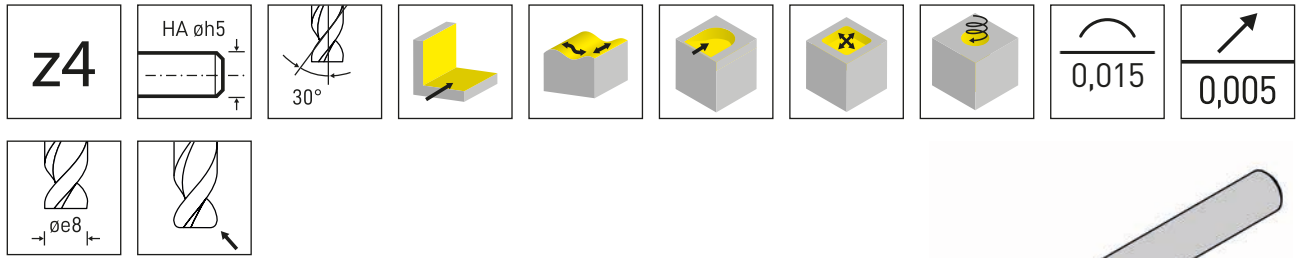
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
3.5	4°	0.025	0.35	0.70	0.035	0.18	0.35
3.5	4°	0.025	0.35	0.70	0.035	0.18	0.35
3.5	4°	0.025	0.35	0.70	0.035	0.18	0.35
3.5	4°	0.025	0.35	0.70	0.035	0.18	0.35
3.5	4°	0.025	0.35	0.70	0.035	0.18	0.35
3.5	4°	0.025	0.35	0.70	0.035	0.18	0.35
3.5	4°	0.025	0.35	0.70	0.035	0.18	0.35
3.5	4°	0.025	0.35	0.70	0.035	0.18	0.35
4.0	4°	0.025	0.35	0.70	0.035	0.18	0.35
4.0	4°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	4°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	4°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	4°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	4°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	4°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	4°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	4°	0.028	0.40	0.80	0.040	0.20	0.40
4.0	4°	0.028	0.40	0.80	0.040	0.20	0.40

圆角立铣刀 Torus End Mill

DST



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	类型 Type	TS3K
DST.4.050.020.030	5	0.2	10	15	4.7	6	64	4	40°	HA	▲
DST.4.050.020.050	5	0.2	10	25	4.7	6	64	4	40°	HA	▲
DST.4.050.020.070	5	0.2	10	35	4.7	6	78	4	40°	HA	▲
DST.4.050.050.050	5	0.5	10	25	4.7	6	64	4	40°	HA	▲
DST.4.050.050.070	5	0.5	10	35	4.7	6	78	4	40°	HA	▲
DST.4.050.100.030	5	1	10	15	4.7	6	64	4	40°	HA	▲
DST.4.050.100.050	5	1	10	25	4.7	6	64	4	40°	HA	▲
DST.4.050.100.070	5	1	10	35	4.7	6	78	4	40°	HA	▲
DST.4.060.020.030	6	0.2	12	18	5.7	6	64	4	-	HA	▲
DST.4.060.020.050	6	0.2	12	30	5.7	6	78	4	-	HA	▲
DST.4.060.020.070	6	0.2	12	42	5.7	6	100	4	-	HA	▲
DST.4.060.050.030	6	0.5	12	18	5.7	6	64	4	-	HA	▲
DST.4.060.050.050	6	0.5	12	30	5.7	6	78	4	-	HA	▲
DST.4.060.050.070	6	0.5	12	42	5.7	6	100	4	-	HA	▲
DST.4.060.100.030	6	1	12	18	5.7	6	64	4	-	HA	▲
DST.4.060.100.050	6	1	12	30	5.7	6	78	4	-	HA	▲
DST.4.060.200.030	6	2	12	18	5.7	6	64	4	-	HA	▲
DST.4.060.200.050	6	2	12	30	5.7	6	78	4	-	HA	▲





P	●
M	○
K	○
N	-
S	○
H	○

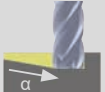
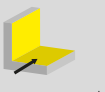

切削参数 DST Ø 5 - 6 mm

Cutting Data DST Ø 5 - 6 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

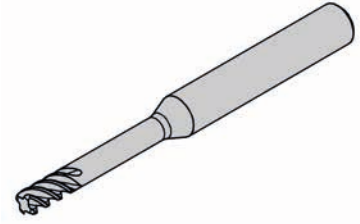
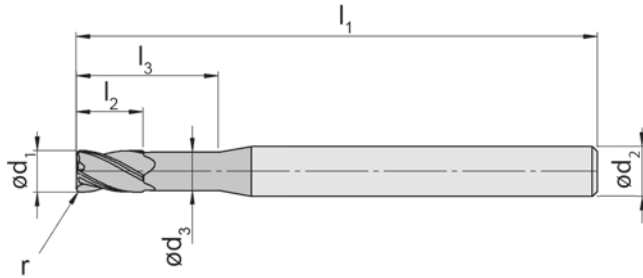
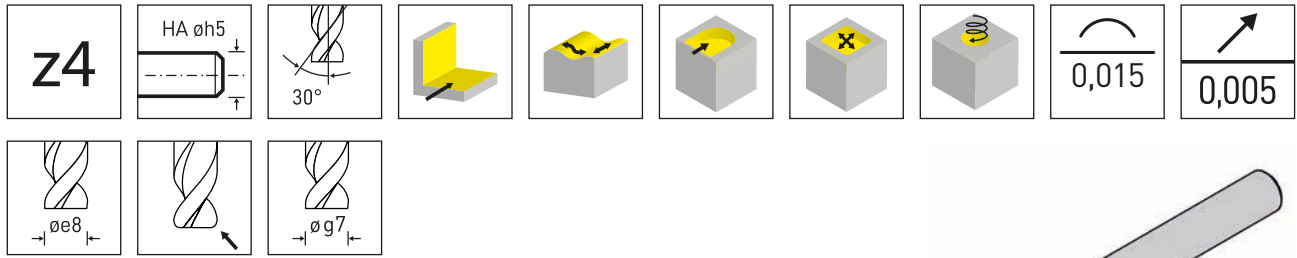
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
5	4°	0.034	0.50	1.00	0.048	0.25	0.50
5	4°	0.034	0.50	1.00	0.048	0.25	0.50
5	4°	0.034	0.50	1.00	0.048	0.25	0.50
5	4°	0.034	0.50	1.00	0.048	0.25	0.50
5	4°	0.034	0.50	1.00	0.048	0.25	0.50
5	4°	0.034	0.50	1.00	0.048	0.25	0.50
5	4°	0.034	0.50	1.00	0.048	0.25	0.50
5	4°	0.034	0.50	1.00	0.048	0.25	0.50
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60
6	4°	0.041	0.60	1.20	0.057	0.30	0.60

圆角立铣刀 Torus End Mill

DST



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	类型 Type	TS3K
DST.4.080.020.030	8	0.2	16	24	7.6	8	64	4	HA	▲
DST.4.080.020.050	8	0.2	16	40	7.6	8	100	4	HA	▲
DST.4.080.020.070	8	0.2	16	56	7.6	8	100	4	HA	▲
DST.4.080.050.030	8	0.5	16	24	7.6	8	64	4	HA	▲
DST.4.080.050.050	8	0.5	16	40	7.6	8	100	4	HA	▲
DST.4.080.050.070	8	0.5	16	56	7.6	8	100	4	HA	▲
DST.4.080.100.030	8	1	16	24	7.6	8	64	4	HA	▲
DST.4.080.100.050	8	1	16	40	7.6	8	100	4	HA	▲
DST.4.080.100.070	8	1	16	56	7.6	8	100	4	HA	▲
DST.4.080.200.030	8	2	16	24	7.6	8	64	4	HA	▲
DST.4.080.200.050	8	2	16	40	7.6	8	100	4	HA	▲
DST.4.100.020.030	10	0.2	20	30	9.6	10	78	4	HA	▲
DST.4.100.020.070	10	0.2	20	70	9.6	10	120	4	HA	▲
DST.4.100.050.030	10	0.5	20	30	9.6	10	78	4	HA	▲
DST.4.100.050.050	10	0.5	20	50	9.6	10	100	4	HA	▲
DST.4.100.050.070	10	0.5	20	70	9.6	10	120	4	HA	▲
DST.4.100.100.030	10	1	20	30	9.6	10	78	4	HA	▲
DST.4.100.100.050	10	1	20	50	9.6	10	100	4	HA	▲
DST.4.100.200.030	10	2	20	30	9.6	10	78	4	HA	▲
DST.4.100.200.050	10	2	20	50	9.6	10	100	4	HA	▲





P	●
M	○
K	○
N	-
S	○
H	○

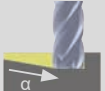


切削参数 DST Ø 8 - 10 mm

Cutting Data DST Ø 8 - 10 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

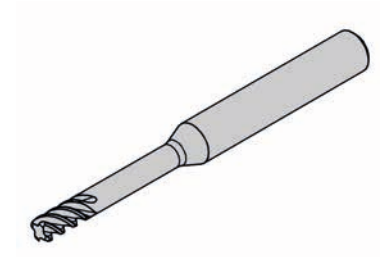
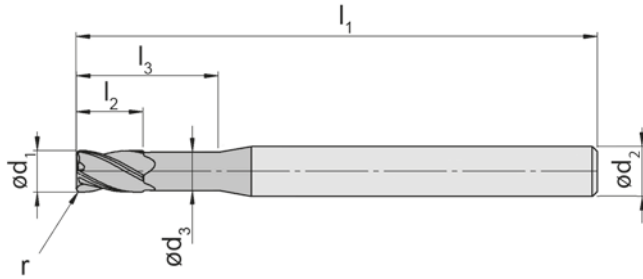
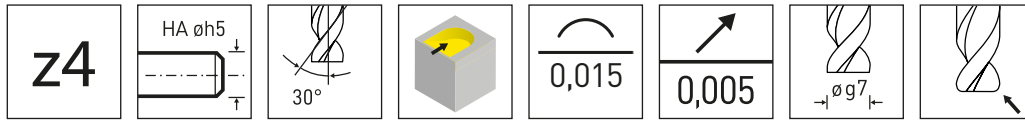
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
8	4°	0.053	0.80	1.60	0.075	0.40	0.80
8	4°	0.053	0.80	1.60	0.075	0.40	0.80
8	4°	0.053	0.80	1.60	0.075	0.40	0.80
8	4°	0.053	0.80	1.60	0.075	0.40	0.80
8	4°	0.053	0.80	1.60	0.075	0.40	0.80
8	4°	0.053	0.80	1.60	0.075	0.40	0.80
8	4°	0.053	0.80	1.60	0.075	0.40	0.80
8	4°	0.053	0.80	1.60	0.075	0.40	0.80
8	4°	0.053	0.80	1.60	0.075	0.40	0.80
8	4°	0.053	0.80	1.60	0.075	0.40	0.80
10	4°	0.066	1.00	2.00	0.093	0.50	1.00
10	4°	0.066	1.00	2.00	0.093	0.50	1.00
10	4°	0.066	1.00	2.00	0.093	0.50	1.00
10	4°	0.066	1.00	2.00	0.093	0.50	1.00
10	4°	0.066	1.00	2.00	0.093	0.50	1.00
10	4°	0.066	1.00	2.00	0.093	0.50	1.00
10	4°	0.066	1.00	2.00	0.093	0.50	1.00
10	4°	0.066	1.00	2.00	0.093	0.50	1.00
10	4°	0.066	1.00	2.00	0.093	0.50	1.00

圆角立铣刀 Torus End Mill

DST



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	类型 Type	TS3K
DST.4.120.020.030	12	0.2	24	36	11.6	12	100	4	HA	▲
DST.4.120.020.050	12	0.2	24	60	11.6	12	120	4	HA	▲
DST.4.120.020.070	12	0.2	24	84	11.6	12	140	4	HA	▲
DST.4.120.050.030	12	0.5	24	36	11.6	12	100	4	HA	▲
DST.4.120.050.050	12	0.5	24	60	11.6	12	120	4	HA	▲
DST.4.120.050.070	12	0.5	24	84	11.6	12	140	4	HA	▲
DST.4.120.200.030	12	2	24	36	11.6	12	100	4	HA	▲
DST.4.120.200.050	12	2	24	60	11.6	12	120	4	HA	▲
DST.4.160.020.030	16	0.2	32	48	15.4	16	100	4	HA	▲
DST.4.160.020.050	16	0.2	32	80	15.4	16	140	4	HA	▲
DST.4.160.020.070	16	0.2	32	112	15.4	16	163	4	HA	▲
DST.4.160.050.030	16	0.5	32	48	15.4	16	100	4	HA	▲
DST.4.160.050.050	16	0.5	32	80	15.4	16	140	4	HA	▲
DST.4.160.100.050	16	1	32	80	15.4	16	140	4	HA	▲
DST.4.160.200.030	16	2	32	48	15.4	16	100	4	HA	▲





P	●
M	○
K	○
N	-
S	○
H	○

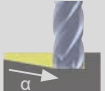


切削参数 DST Ø 12 - 16 mm

Cutting Data DST Ø 12 - 16 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	140	170	K1.1	130	160
P1.2	140	170	K1.2	130	160
P1.3	140	170	K2.1	120	150
P1.4	140	170	K2.2	110	140
P1.5	140	170	K3.1	110	140
P1.6	140	170	K3.2	110	140
P2.1	140	170	K4.1	100	130
P2.2	140	170	K4.2	100	130
P2.3	140	170	K4.3	100	130
P2.4	140	170	S1.1	90	120
P3.1	130	160	S1.2	80	110
P3.2	130	160	S2.1	70	100
P4.1	130	160	S2.2	60	90
P4.2	130	160	S3.1	100	130
P5.1	110	140	S3.2	100	130
M1.1	100	130	S3.3	80	110
M1.2	90	120	H1.1	110	140
M1.3	80	110			

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
12	4°	0.066	1.00	2.00	0.093	0.50	1.00
12	4°	0.079	1.20	2.40	0.111	0.60	1.20
12	4°	0.079	1.20	2.40	0.111	0.60	1.20
12	4°	0.079	1.20	2.40	0.111	0.60	1.20
12	4°	0.079	1.20	2.40	0.111	0.60	1.20
12	4°	0.079	1.20	2.40	0.111	0.60	1.20
12	4°	0.079	1.20	2.40	0.111	0.60	1.20
12	4°	0.079	1.20	2.40	0.111	0.60	1.20
16	4°	0.104	1.60	3.20	0.147	0.80	1.60
16	4°	0.104	1.60	3.20	0.147	0.80	1.60
16	4°	0.104	1.60	3.20	0.147	0.80	1.60
16	4°	0.104	1.60	3.20	0.147	0.80	1.60
16	4°	0.104	1.60	3.20	0.147	0.80	1.60
16	4°	0.104	1.60	3.20	0.147	0.80	1.60
16	4°	0.104	1.60	3.20	0.147	0.80	1.60

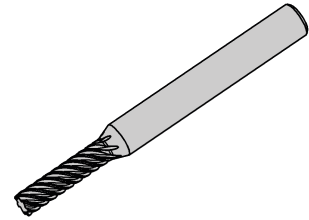
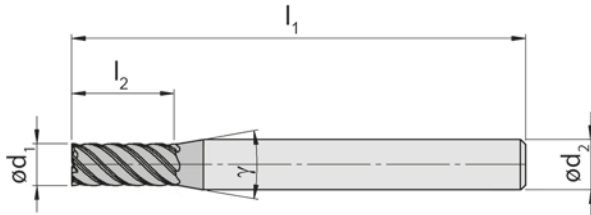
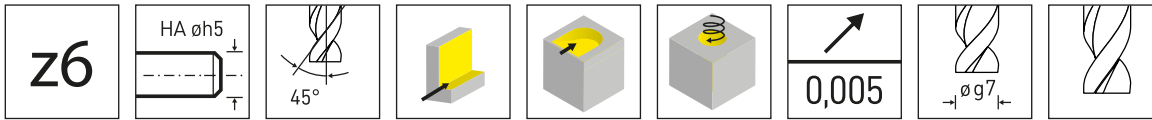
多刃立铣刀

End Mill multiple fluted

DSM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	l ₂	d ₂	l ₁	Z	γ	TS3K
DSM.6.020.20	2	4	6	57	6	40°	▲
DSM.6.020.30	2	6	6	57	6	40°	▲
DSM.6.020.40	2	8	6	57	6	40°	▲
DSM.6.030.20	3	6	6	57	6	40°	▲
DSM.6.030.30	3	9	6	57	6	40°	▲
DSM.6.030.40	3	12	6	57	6	40°	▲
DSM.6.040.20	4	8	6	57	6	40°	▲
DSM.6.040.30	4	12	6	57	6	40°	▲
DSM.6.040.40	4	16	6	57	6	40°	▲
DSM.6.050.20	5	10	6	57	6	40°	▲
DSM.6.050.30	5	15	6	57	6	40°	▲
DSM.6.050.40	5	20	6	57	6	40°	▲
DSM.6.060.20	6	12	6	50	6	-	▲
DSM.6.060.30	6	18	6	57	6	-	▲
DSM.6.060.40	6	24	6	64	6	-	▲


P	●
M	○
K	○
N	-
S	○
H	○

切削参数 DSM Ø 2 - 6 mm

Cutting Data DSM Ø 2 - 6 mm




B



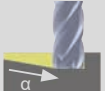

vc = m/min

P1.1	130
P1.2	130
P1.3	130
P1.4	130
P1.5	130
P1.6	130
P2.1	130
P2.2	130
P2.3	130
P2.4	130
P3.1	120
P3.2	120
P4.1	120
P4.2	120
P5.1	100
M1.1	90
M1.2	80
M1.3	70



vc = m/min

K1.1	120
K1.2	120
K2.1	110
K2.2	100
K3.1	100
K3.2	100
K4.1	90
K4.2	90
K4.3	90
S1.1	80
S1.2	70
S2.1	60
S2.2	50
S3.1	90
S3.2	80
S3.3	70
H1.1	90

d_1	α	f_z	a_e	a_p
2	2°	0.007	0.20	4.00
2	2°	0.007	0.20	4.00
2	2°	0.007	0.20	4.00
3	2°	0.011	0.30	6.00
3	2°	0.011	0.30	6.00
3	2°	0.011	0.30	6.00
4	2°	0.015	0.40	8.00
4	2°	0.015	0.40	8.00
4	2°	0.008	0.40	8.00
5	2°	0.012	0.50	10.00
5	2°	0.012	0.50	10.00
5	2°	0.012	0.50	10.00
6	2°	0.016	0.60	12.00
6	2°	0.016	0.60	12.00
6	2°	0.016	0.60	12.00

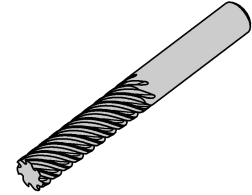
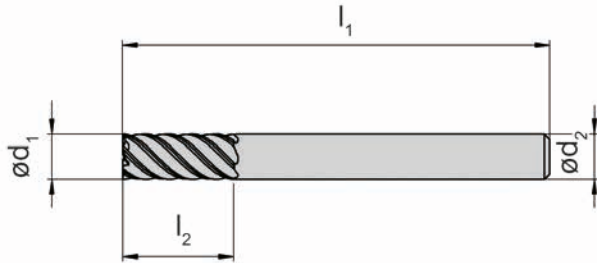
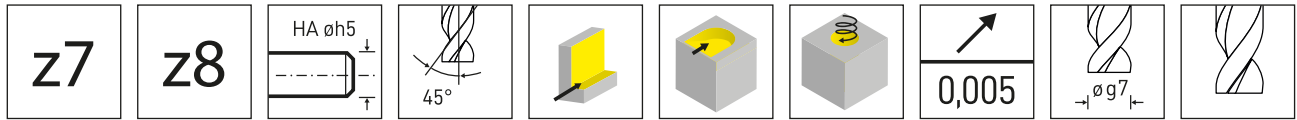
多刃立铣刀

End Mill multiple fluted

DSM



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	l ₂	d ₂	l ₁	Z	TS3K
DSM.7.080.20	8	16	8	54	7	▲
DSM.7.080.30	8	24	8	64	7	▲
DSM.7.080.40	8	32	8	78	7	▲
DSM.7.100.20	10	20	10	60	7	▲
DSM.7.100.30	10	30	10	70	7	▲
DSM.7.100.40	10	40	10	89	7	▲
DSM.7.120.20	12	24	12	78	7	▲
DSM.7.120.30	12	36	12	83	7	▲
DSM.7.120.40	12	48	12	100	7	▲
DSM.8.160.20	16	32	16	89	8	▲
DSM.8.160.30	16	48	16	100	8	▲
DSM.8.160.40	16	64	16	120	8	▲
DSM.8.200.20	20	40	20	102	8	▲
DSM.8.200.30	20	60	20	125	8	▲
DSM.8.200.40	20	80	20	150	8	▲


P	●
M	○
K	○
N	-
S	○
H	○

切削参数 DSM Ø 8 - 20 mm

Cutting Data DSM Ø 8 - 20 mm




B



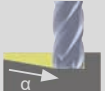

vc = m/min

P1.1	130
P1.2	130
P1.3	130
P1.4	130
P1.5	130
P1.6	130
P2.1	130
P2.2	130
P2.3	130
P2.4	130
P3.1	120
P3.2	120
P4.1	120
P4.2	120
P5.1	100
M1.1	90
M1.2	80
M1.3	70



vc = m/min

K1.1	120
K1.2	120
K2.1	110
K2.2	100
K3.1	100
K3.2	100
K4.1	90
K4.2	90
K4.3	90
S1.1	80
S1.2	70
S2.1	60
S2.2	50
S3.1	90
S3.2	80
S3.3	70
H1.1	90

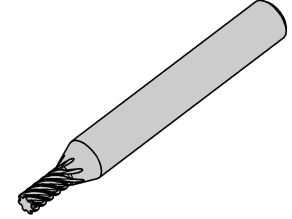
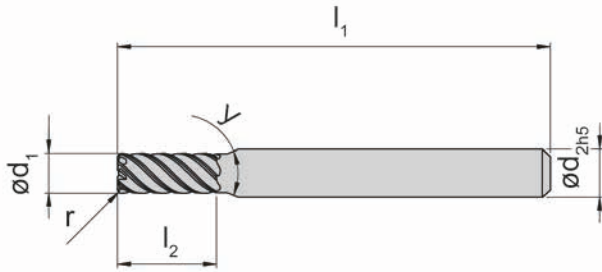
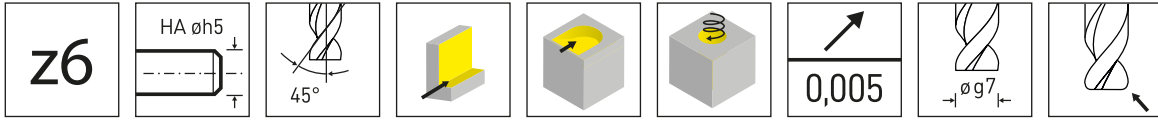
d_1	α	f_z	a_e	a_p
8	2°	0.019	0.80	16.00
8	2°	0.019	0.80	16.00
8	2°	0.019	0.80	16.00
10	2°	0.027	1.00	20.00
10	2°	0.027	1.00	20.00
10	2°	0.027	1.00	20.00
12	2°	0.035	1.20	24.00
12	2°	0.035	1.20	24.00
12	2°	0.035	1.20	24.00
16	2°	0.047	1.60	32.00
16	2°	0.047	1.60	32.00
16	2°	0.047	1.60	32.00
20	2°	0.062	2.00	40.00
20	2°	0.062	2.00	40.00
20	2°	0.062	2.00	40.00

多刃立铣刀 End Mill multiple fluted

DSMR



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	γ	TS3K
DSMR.6.020.020.20	2	0.2	4	6	57	6	40°	▲
DSMR.6.020.020.30	2	0.2	6	6	57	6	40°	▲
DSMR.6.020.020.40	2	0.2	8	6	57	6	40°	▲
DSMR.6.030.020.20	3	0.2	6	6	57	6	40°	▲
DSMR.6.030.020.30	3	0.2	9	6	57	6	40°	▲
DSMR.6.030.050.30	3	0.5	9	6	57	6	40°	▲
DSMR.6.040.020.20	4	0.2	8	6	57	6	40°	▲
DSMR.6.040.020.30	4	0.2	12	6	57	6	40°	▲
DSMR.6.040.020.40	4	0.2	16	6	57	6	40°	▲
DSMR.6.040.050.20	4	0.5	8	6	57	6	40°	▲
DSMR.6.040.050.40	4	0.5	16	6	57	6	40°	▲
DSMR.6.050.020.20	5	0.2	10	6	57	6	40°	▲
DSMR.6.050.020.40	5	0.2	20	6	57	6	40°	▲
DSMR.6.050.050.20	5	0.5	10	6	57	6	40°	▲
DSMR.6.050.050.40	5	0.5	20	6	57	6	40°	▲


P	●
M	○
K	○
N	-
S	○
H	○

切削参数 DSMR Ø 2 - 5 mm

Cutting Data DSM Ø 2 - 5 mm




B



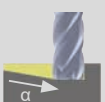

vc = m/min

P1.1	130
P1.2	130
P1.3	130
P1.4	130
P1.5	130
P1.6	130
P2.1	130
P2.2	130
P2.3	130
P2.4	130
P3.1	120
P3.2	120
P4.1	120
P4.2	120
P5.1	100
M1.1	90
M1.2	80
M1.3	70



vc = m/min

K1.1	120
K1.2	120
K2.1	110
K2.2	100
K3.1	100
K3.2	100
K4.1	90
K4.2	90
K4.3	90
S1.1	80
S1.2	70
S2.1	60
S2.2	50
S3.1	90
S3.2	80
S3.3	70
H1.1	90

d_1	α	f_z	a_e	a_p
2	3°	0.000	0.20	4.00
2	3°	0.000	0.20	4.00
2	3°	0.000	0.20	4.00
3	3°	0.004	0.30	6.00
3	3°	0.004	0.30	6.00
3	3°	0.004	0.30	6.00
4	3°	0.008	0.40	8.00
4	3°	0.008	0.40	8.00
4	3°	0.008	0.40	8.00
4	3°	0.008	0.40	8.00
4	3°	0.008	0.40	8.00
5	3°	0.012	0.50	10.00
5	3°	0.012	0.50	10.00
5	3°	0.012	0.50	10.00
5	3°	0.012	0.50	10.00

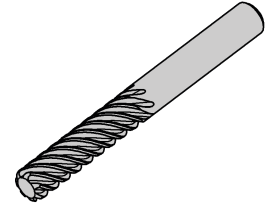
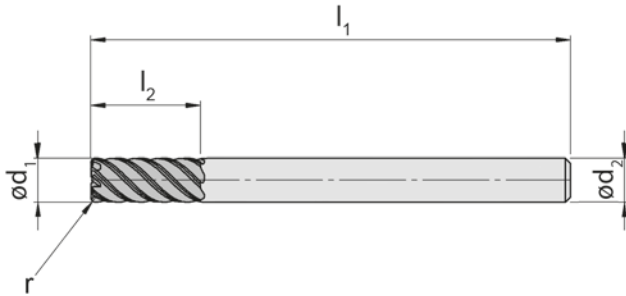
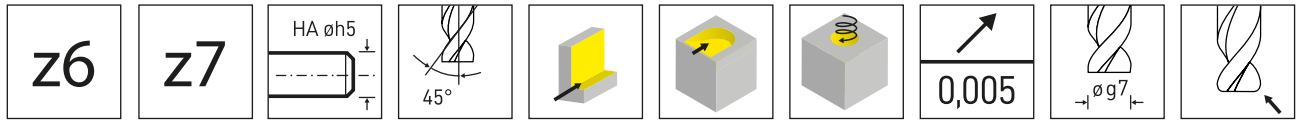
多刃立铣刀

End Mill multiple fluted

DSMR



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	TS3K
DSMR.6.060.020.20	6	0.2	12	6	50	6	▲
DSMR.6.060.020.30	6	0.2	18	6	57	6	▲
DSMR.6.060.020.40	6	0.2	24	6	64	6	▲
DSMR.6.060.050.30	6	0.5	18	6	57	6	▲
DSMR.6.060.050.40	6	0.5	24	6	64	6	▲
DSMR.6.060.100.30	6	1	18	6	57	6	▲
DSMR.6.060.100.40	6	1	24	6	64	6	▲
DSMR.7.080.020.20	8	0.2	16	8	54	7	▲
DSMR.7.080.020.30	8	0.2	24	8	64	7	▲
DSMR.7.080.020.40	8	0.2	32	8	78	7	▲
DSMR.7.080.050.20	8	0.5	16	8	54	7	▲
DSMR.7.080.050.30	8	0.5	24	8	64	7	▲
DSMR.7.080.050.40	8	0.5	32	8	78	7	▲
DSMR.7.080.100.20	8	1	16	8	54	7	▲


P	●
M	○
K	○
N	-
S	○
H	○

切削参数 DSMR Ø 6 - 8 mm

Cutting Data DSMR Ø 6 - 8 mm




B



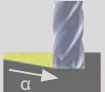

vc = m/min

P1.1	130
P1.2	130
P1.3	130
P1.4	130
P1.5	130
P1.6	130
P2.1	130
P2.2	130
P2.3	130
P2.4	130
P3.1	120
P3.2	120
P4.1	120
P4.2	120
P5.1	100
M1.1	90
M1.2	80
M1.3	70



vc = m/min

K1.1	120
K1.2	120
K2.1	110
K2.2	100
K3.1	100
K3.2	100
K4.1	90
K4.2	90
K4.3	90
S1.1	80
S1.2	70
S2.1	60
S2.2	50
S3.1	90
S3.2	80
S3.3	70
H1.1	90

d_1	α	f_z	a_e	a_p
6	3°	0.016	0.60	12.00
6	3°	0.016	0.60	12.00
6	3°	0.016	0.60	12.00
6	3°	0.016	0.60	12.00
6	3°	0.016	0.60	12.00
6	3°	0.016	0.60	12.00
8	3°	0.019	0.80	16.00
8	3°	0.019	0.80	16.00
8	3°	0.019	0.80	16.00
8	3°	0.019	0.80	16.00
8	3°	0.019	0.80	16.00
8	3°	0.019	0.80	16.00
8	3°	0.019	0.80	16.00

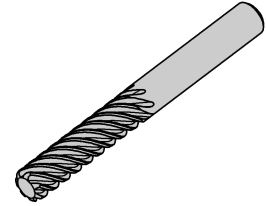
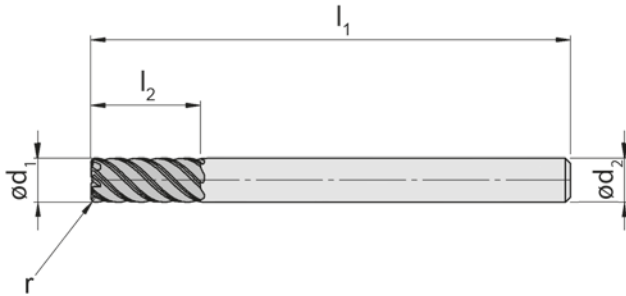
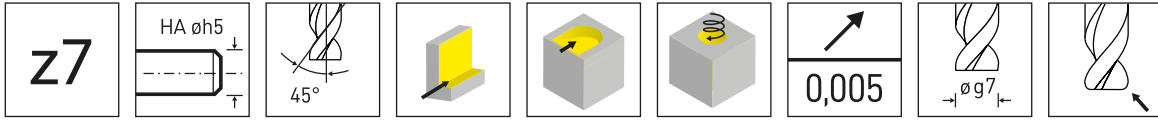
多刃立铣刀

End Mill multiple fluted

DSMR



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d_1	r	l_2	d_2	l_1	Z	TS3K
DSMR.7.100.020.20	10	0.2	20	10	60	7	▲
DSMR.7.100.020.40	10	0.2	40	10	89	7	▲
DSMR.7.100.050.20	10	0.5	20	10	60	7	▲
DSMR.7.100.050.30	10	0.5	30	10	70	7	▲
DSMR.7.100.050.40	10	0.5	40	10	89	7	▲
DSMR.7.100.100.20	10	1	20	10	60	7	▲
DSMR.7.120.020.20	12	0.2	24	12	70	7	▲
DSMR.7.120.020.30	12	0.2	36	12	83	7	▲
DSMR.7.120.020.40	12	0.2	48	12	100	7	▲
DSMR.7.120.050.20	12	0.5	24	12	70	7	▲
DSMR.7.120.050.30	12	0.5	36	12	83	7	▲
DSMR.7.120.050.40	12	0.5	48	12	100	7	▲
DSMR.7.120.100.20	12	1	24	12	70	7	▲
DSMR.7.120.100.40	12	1	48	12	100	7	▲


P	●
M	○
K	○
N	-
S	○
H	○

切削参数 DSMR Ø 10 - 12 mm

Cutting Data DSMR Ø 10 - 12 mm




B



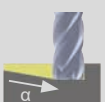

vc = m/min

P1.1	130
P1.2	130
P1.3	130
P1.4	130
P1.5	130
P1.6	130
P2.1	130
P2.2	130
P2.3	130
P2.4	130
P3.1	120
P3.2	120
P4.1	120
P4.2	120
P5.1	100
M1.1	90
M1.2	80
M1.3	70



vc = m/min

K1.1	120
K1.2	120
K2.1	110
K2.2	100
K3.1	100
K3.2	100
K4.1	90
K4.2	90
K4.3	90
S1.1	80
S1.2	70
S2.1	60
S2.2	50
S3.1	90
S3.2	80
S3.3	70
H1.1	90

d_1	α	f_z	a_e	a_p
10	3°	0.027	1.00	20.00
10	3°	0.027	1.00	20.00
10	3°	0.027	1.00	20.00
10	3°	0.027	1.00	20.00
10	3°	0.027	1.00	20.00
10	3°	0.027	1.00	20.00
12	3°	0.035	1.20	24.00
12	3°	0.035	1.20	36.00
12	3°	0.035	1.20	48.00
12	3°	0.035	1.20	24.00
12	3°	0.035	1.20	36.00
12	3°	0.035	1.20	48.00
12	3°	0.035	1.20	24.00
12	3°	0.035	1.20	48.00

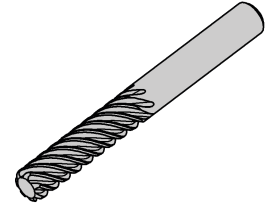
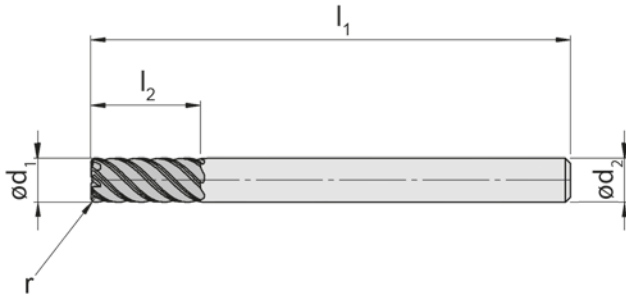
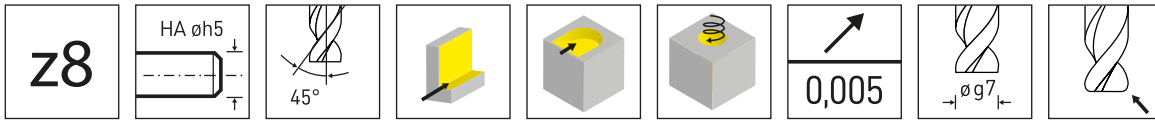
多刃立铣刀

End Mill multiple fluted

DSMR



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	TS3K
DSMR.8.160.020.30	16	0.2	48	16	100	8	▲
DSMR.8.160.020.40	16	0.2	64	16	120	8	▲
DSMR.8.160.050.20	16	0.5	32	16	89	8	▲
DSMR.8.160.050.30	16	0.5	48	16	100	8	▲
DSMR.8.160.100.30	16	1	48	16	100	8	▲
DSMR.8.160.100.40	16	1	64	16	120	8	▲
DSMR.8.200.020.20	20	0.2	40	20	102	8	▲
DSMR.8.200.020.30	20	0.2	60	20	125	8	▲
DSMR.8.200.050.20	20	0.5	40	20	102	8	▲
DSMR.8.200.050.30	20	0.5	60	20	125	8	▲
DSMR.8.200.100.20	20	1	40	20	102	8	▲
DSMR.8.200.100.30	20	1	60	20	125	8	▲
DSMR.8.200.100.40	20	1	80	20	150	8	▲


P	●
M	○
K	○
N	-
S	○
H	○

切削参数 DSMR Ø 16 - 20 mm

Cutting Data DSMR Ø 16 - 20 mm




B



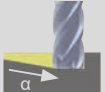

vc = m/min

P1.1	130
P1.2	130
P1.3	130
P1.4	130
P1.5	130
P1.6	130
P2.1	130
P2.2	130
P2.3	130
P2.4	130
P3.1	120
P3.2	120
P4.1	120
P4.2	120
P5.1	100
M1.1	90
M1.2	80
M1.3	70



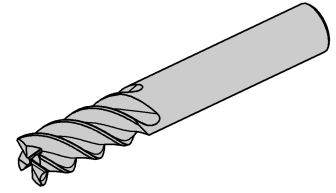
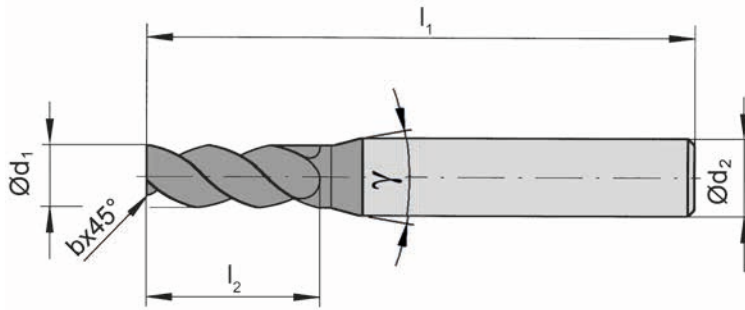
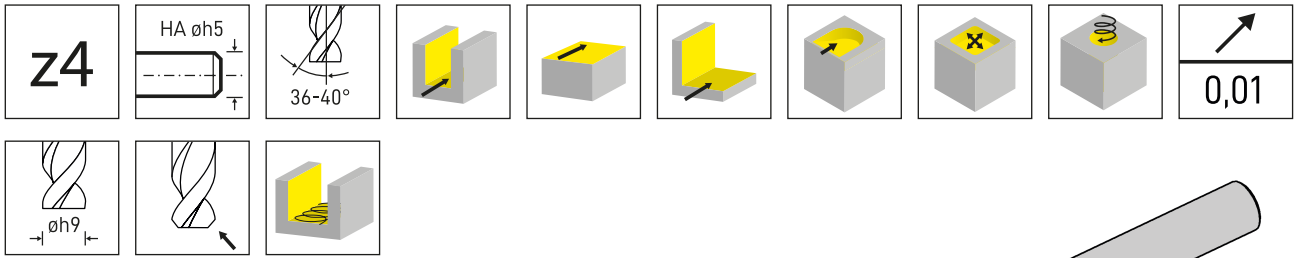
vc = m/min

K1.1	120
K1.2	120
K2.1	110
K2.2	100
K3.1	100
K3.2	100
K4.1	90
K4.2	90
K4.3	90
S1.1	80
S1.2	70
S2.1	60
S2.2	50
S3.1	90
S3.2	80
S3.3	70
H1.1	90

d_1	α	f_z	a_e	a_p
16	3°	0.047	1.60	48.00
16	3°	0.047	1.60	64.00
16	3°	0.047	1.60	32.00
16	3°	0.047	1.60	48.00
16	3°	0.047	1.60	64.00
20	3°	0.062	2.00	40.00
20	3°	0.062	2.00	60.00
20	3°	0.062	2.00	40.00
20	3°	0.062	2.00	60.00
20	3°	0.062	2.00	40.00
20	3°	0.062	2.00	60.00
20	3°	0.062	2.00	80.00

B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	γ	ES3P
DSHPC.4.020.008.25	2	0.07	5	6	50	4	40°	▲
DSHPC.4.030.010.23	3	0.1	7	6	50	4	40°	▲
DSHPC.4.040.010.22	4	0.1	9	6	50	4	40°	▲
DSHPC.4.050.010.22	5	0.1	11	6	54	4	40°	▲
DSHPC.4.060.015.21	6	0.15	13	6	54	4	-	▲
DSHPC.4.080.015.21	8	0.15	17	8	63	4	-	▲
DSHPC.4.100.020.21	10	0.2	21	10	66	4	-	▲
DSHPC.4.120.030.21	12	0.3	26	12	83	4	-	▲
DSHPC.4.160.050.21	16	0.5	34	16	92	4	-	▲
DSHPC.4.200.050.21	20	0.5	42	20	104	4	-	▲
								P ●
								M ●
								K ●
								N -
								S o
								H -




切削参数 DSHPC Ø 2 - 20 mm





Cutting Data DSHPC Ø 2 - 20 mm



B

	 $vc = m/min$	 $vc = m/min$	 $vc = m/min$
P1.1	130	160	180
P1.2	130	160	180
P1.3	130	160	180
P1.4	130	160	180
P1.5	130	160	180
P1.6	130	160	180
P2.1	130	160	180
P2.2	130	160	180
P2.3	130	160	180
P2.4	130	160	180
P3.1	120	150	170
P3.2	120	150	170
P4.1	120	150	170
P4.2	120	150	170
P5.1	100	130	140
M1.1	90	120	130
M1.2	80	110	120
M1.3	70	100	110

	 $vc = m/min$	 $vc = m/min$	 $vc = m/min$
K1.1	130	160	170
K1.2	130	160	170
K2.1	120	150	160
K2.2	110	140	150
K3.1	110	140	150
K3.2	110	140	150
K4.1	100	130	140
K4.2	100	130	140
K4.3	100	130	140

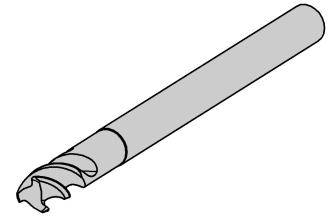
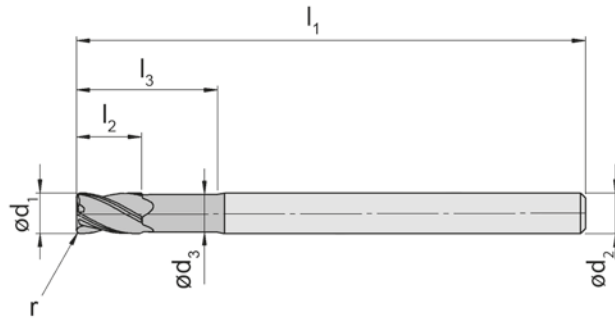
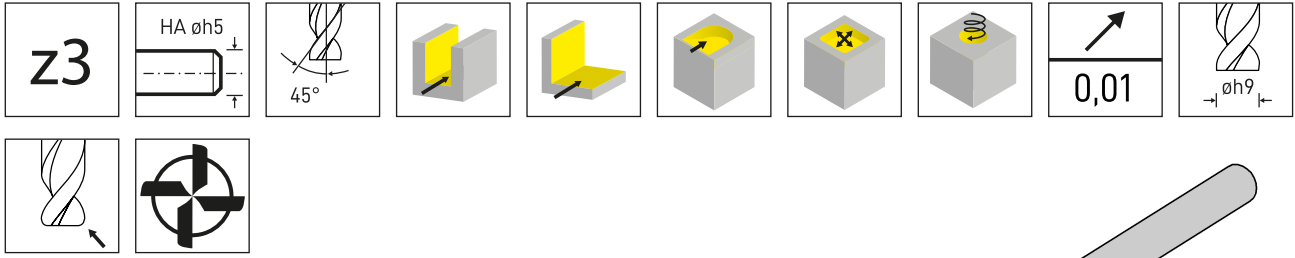
d_1										
		fz	ae	ap	fz	ae	ap	fz	ae	ap
2	3°	0.010	2	2	0.013	0.50	4	0.019	0.26	5
3	3°	0.016	3	3	0.022	0.75	6	0.03	0.39	7
4	3°	0.022	4	4	0.030	1.00	8	0.041	0.52	9
5	4°	0.029	5	5	0.038	1.25	10	0.053	0.65	11
6	4°	0.035	6	6	0.047	1.50	12	0.065	0.78	13
8	5°	0.047	8	8	0.063	2.00	16	0.088	1.04	17
10	5°	0.060	10	10	0.080	2.50	20	0.111	1.30	21
12	5°	0.070	12	12	0.093	3.00	24	0.129	1.56	26
16	5°	0.095	16	16	0.126	4.00	32	0.175	2.08	34
20	5°	0.120	20	20	0.160	5.00	40	0.222	2.60	42

粗加工立铣刀 Roughing End Mill

DSR



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TS3K
DSR.3.020.38.03	2	0.2	3	10.5	1.9	3	38	3	▲
DSR.3.030.38.03	3	0.2	4	10.5	2.9	3	38	3	▲
DSR.3.040.50.06	4	0.2	5	12.5	3.8	6	50	3	▲
DSR.3.050.50.06	5	0.2	6	14.5	4.7	6	50	3	▲
DSR.3.050.63.06	5	0.2	6	14.5	4.7	6	63	3	▲
DSR.3.060.63.06	6	0.3	7	16.5	5.6	6	63	3	▲
DSR.3.080.63.08	8	0.5	9	20.5	7.4	8	63	3	▲
DSR.3.100.69.10	10	0.5	12	25.5	9.4	10	69	3	▲





P	●
M	○
K	○
N	-
S	○
H	○




切削参数 DSR Ø 2 - 10 mm

Cutting Data DSR Ø 2 - 10 mm



B

						
	vc = m/min		vc = m/min		vc = m/min	
P1.1	120	140	K1.1	120	140	
P1.2	120	140	K1.2	120	140	
P1.3	120	140	K2.1	110	130	
P1.4	120	140	K2.2	100	120	
P1.5	120	140	K3.1	100	120	
P1.6	120	140	K3.2	100	120	
P2.1	120	140	K4.1	90	110	
P2.2	120	140	K4.2	90	110	
P2.3	120	140	K4.3	90	110	
P2.4	120	140				
P3.1	110	130				
P3.2	110	130				
P4.1	110	130				
P4.2	110	130				
P5.1	80	100				
M1.1	90	120				

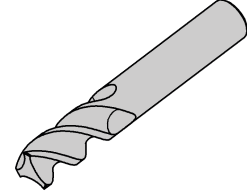
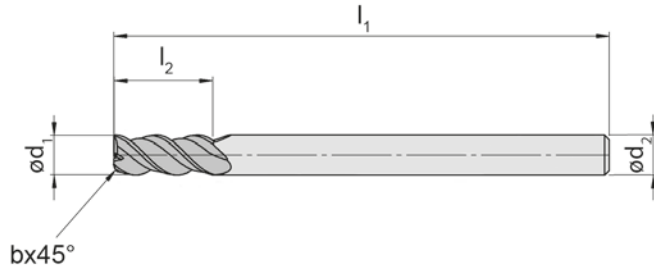
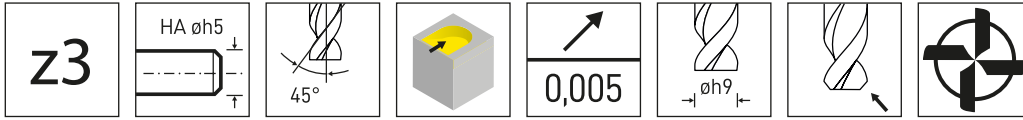
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
2	5°	0.007	2	2	0.014	0.50	2.00
3	5°	0.011	3	3	0.022	0.75	3.00
4	5°	0.015	4	4	0.030	1.00	4.00
5	5°	0.019	5	5	0.038	1.25	5.00
5	5°	0.019	5	5	0.038	1.25	5.00
6	5°	0.023	6	6	0.046	1.50	6.00
8	5°	0.031	8	8	0.062	2.00	8.00
10	5°	0.039	10	10	0.078	2.50	10.00

粗加工立铣刀 Roughing End Mill

DSF



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d_1	b	l_2	d_2	l_1	Z	TS3K
DSF.3.020.38.03	2	0.1	8	3	38	3	▲
DSF.3.030.38.03	3	0.1	10	3	38	3	▲
DSF.3.040.50.04	4	0.1	12	4	50	3	▲
DSF.3.050.50.05	5	0.15	14	5	50	3	▲
DSF.3.060.63.06	6	0.15	16	6	63	3	▲
DSF.3.080.63.08	8	0.2	20	8	63	3	▲
DSF.3.100.69.10	10	0.2	22	10	69	3	▲
DSF.3.120.77.12	12	0.25	25	12	77	3	▲
DSF.3.160.88.16	16	-	35	16	88	3	▲



P	●
M	○
K	○
N	-
S	○
H	○



切削参数 DSF Ø 2 - 16 mm




Cutting Data DSF Ø 2 - 16 mm



B

	 vc = m/min	 vc = m/min
P1.1	120	140
P1.2	120	140
P1.3	120	140
P1.4	120	140
P1.5	120	140
P1.6	120	140
P2.1	120	140
P2.2	120	140
P2.3	120	140
P2.4	120	140
P3.1	110	130
P3.2	110	130
P4.1	110	130
P4.2	110	130
P5.1	80	100

	 vc = m/min	 vc = m/min
K1.1	120	140
K1.2	120	140
K2.1	110	130
K2.2	100	120
K3.1	100	120
K3.2	100	120
K4.1	90	110
K4.2	90	110
K4.3	90	110

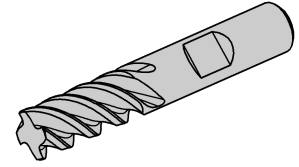
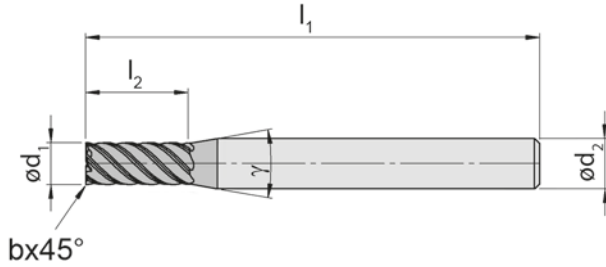
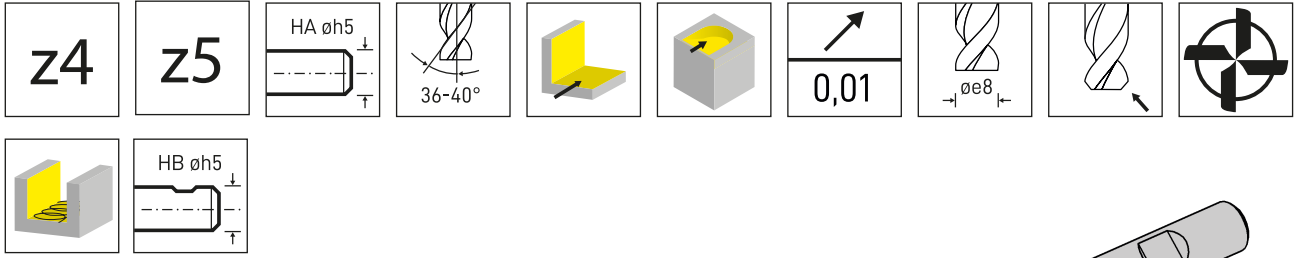
d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
2	5°	0.008	2	2	0.016	0.50	4.00
3	5°	0.012	3	3	0.024	0.75	6.00
4	5°	0.016	4	4	0.032	1.00	8.00
5	5°	0.020	5	5	0.040	1.25	10.00
6	5°	0.024	6	6	0.048	1.50	12.00
8	5°	0.032	8	8	0.064	2.00	16.00
10	5°	0.040	10	10	0.080	2.50	20.00
12	5°	0.048	12	12	0.096	3.00	24.00
16	5°	0.064	16	16	0.128	4.00	32.00

摆线铣立铣刀 Trochoidal End Mill

DSFT



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	γ	类型 Type	TS3K
DSFT.4.020.010.20	2	0.1	5	6	50	4	40°	HA	▲
DSFT.4.020.010.30	2	0.1	7	6	50	4	40°	HA	▲
DSFT.4.020.010.40	2	0.1	9	6	54	4	40°	HA	▲
DSFT.4.030.010.20	3	0.1	7	6	50	4	40°	HA	▲
DSFT.4.030.010.30	3	0.1	10	6	54	4	40°	HA	▲
DSFT.4.030.010.40	3	0.1	13	6	57	4	40°	HA	▲
DSFT.4.040.010.20	4	0.1	9	6	50	4	40°	HA	▲
DSFT.4.040.010.30	4	0.1	13	6	57	4	40°	HA	▲
DSFT.4.040.010.40	4	0.1	17	6	60	4	40°	HA	▲
DSFT.4.050.010.20	5	0.1	11	6	50	4	40°	HA	▲
DSFT.4.050.010.30	5	0.1	16	6	57	4	40°	HA	▲
DSFT.4.050.010.40	5	0.1	21	6	64	4	40°	HA	▲
DSFT.5.060.010.20	6	0.1	13	6	57	5	-	HA	▲
DSFT.5.060.010.30	6	0.1	19	6	64	5	-	HA	▲
DSFT.5.060.010.40	6	0.1	25	6	64	5	-	HA	▲
DSFT.5.080.015.20	8	0.15	17	8	57	5	-	HA	▲
DSFT.5.080.015.30	8	0.15	25	8	64	5	-	HA	▲
DSFT.5.080.015.40	8	0.15	33	8	72	5	-	HA	▲
DSFT.5.100.020.20	10	0.2	21	10	64	5	-	HA	▲
DSFT.5.100.020.20B	10	0.2	21	10	64	5	-	HB	▲
DSFT.5.100.020.30	10	0.2	31	10	78	5	-	HA	▲
DSFT.5.100.020.30B	10	0.2	31	10	78	5	-	HB	▲
DSFT.5.100.020.40	10	0.2	41	10	89	5	-	HA	▲
DSFT.5.100.020.40B	10	0.2	41	10	89	5	-	HB	▲

P	●
M	○
K	○
N	-
S	○
H	○




切削参数 DSFT Ø 2 - 10 mm

Cutting Data DSF Ø 2 - 10 mm



B

	 $vc = m/min$	 $vc = m/min$		 $vc = m/min$	 $vc = m/min$
P1.1	160	180	K1.1	160	170
P1.2	160	180	K1.2	160	170
P1.3	160	180	K2.1	150	160
P1.4	160	180	K2.2	140	150
P1.5	160	180	K3.1	140	150
P1.6	160	180	K3.2	140	150
P2.1	160	180	K4.1	130	140
P2.2	160	180	K4.2	130	140
P2.3	160	180	K4.3	130	140
P2.4	160	180			
P3.1	150	170			
P3.2	150	170			
P4.1	150	170			
P4.2	150	170			
P5.1	130	140			
M1.1	120	130			
M1.2	110	120			
M1.3	100	110			

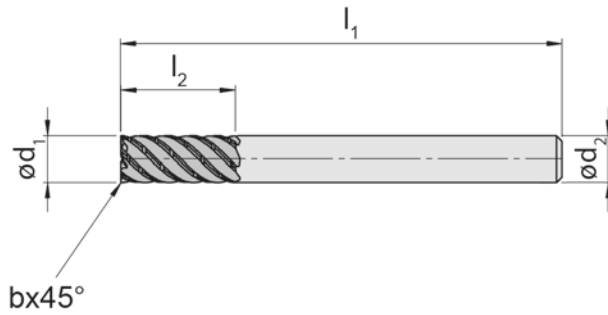
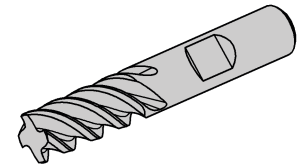
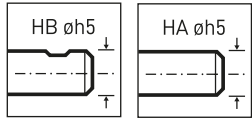
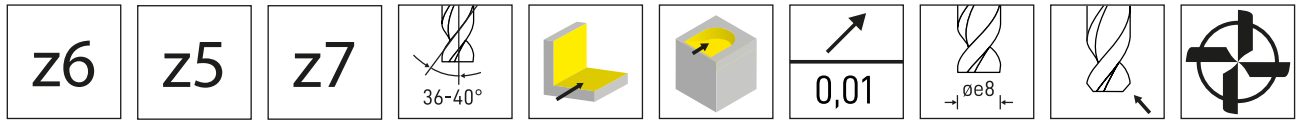
d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
2	3°	0.017	0.40	4.0	0.030	0.20	4.0
2	3°	0.016	0.36	6.0	0.029	0.18	6.0
2	3°	0.015	0.32	8.0	0.027	0.16	8.0
3	3°	0.029	0.60	6.0	0.048	0.30	6.0
3	3°	0.028	0.54	9.0	0.045	0.27	9.0
3	3°	0.026	0.48	12.0	0.043	0.24	12.0
4	3°	0.042	0.80	8.0	0.065	0.40	8.0
4	3°	0.040	0.72	12.0	0.062	0.36	12.0
4	3°	0.037	0.64	16.0	0.059	0.32	16.0
5	3°	0.054	1.00	10.0	0.083	0.50	10.0
5	3°	0.051	0.90	15.0	0.079	0.45	15.0
5	3°	0.048	0.80	20.0	0.074	0.40	20.0
6	3°	0.062	1.20	12.0	0.094	0.60	12.0
6	3°	0.059	1.08	18.0	0.089	0.54	18.0
6	3°	0.055	0.96	24.0	0.084	0.48	24.0
8	3°	0.087	1.60	16.0	0.129	0.80	16.0
8	3°	0.082	1.44	24.0	0.122	0.72	24.0
8	3°	0.078	1.28	32.0	0.115	0.64	32.0
10	3°	0.112	2.00	20.0	0.164	1.00	20.0
10	3°	0.106	1.80	30.0	0.156	0.90	30.0
10	3°	0.100	1.60	40.0	0.147	0.80	40.0
10	3°	0.112	2.00	20.0	0.164	1.00	20.0
10	3°	0.106	1.80	30.0	0.156	0.90	30.0
10	3°	0.100	1.60	40.0	0.147	0.80	40.0

摆线铣立铣刀 Trochoidal End Mill

DSFT



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	类型 Type	TS3K
DSFT.6.120.020.20	12	0.2	26	12	78	6	HA	▲
DSFT.6.120.020.20B	12	0.2	26	12	78	6	HB	▲
DSFT.6.120.020.30	12	0.2	38	12	100	6	HA	▲
DSFT.6.120.020.30B	12	0.2	38	12	100	6	HB	▲
DSFT.5.120.020.40	12	0.2	50	12	110	5	HA	▲
DSFT.5.120.020.40B	12	0.2	50	12	110	5	HB	▲
DSFT.6.160.030.20	16	0.3	34	16	100	6	HA	▲
DSFT.6.160.030.20B	16	0.3	34	16	100	6	HB	▲
DSFT.6.160.030.30	16	0.3	50	16	120	6	HA	▲
DSFT.6.160.030.30B	16	0.3	50	16	120	6	HB	▲
DSFT.5.160.030.40	16	0.3	66	16	130	5	HA	▲
DSFT.5.160.030.40B	16	0.3	66	16	130	5	HB	▲
DSFT.7.200.040.20	20	0.4	42	20	100	7	HA	▲
DSFT.7.200.040.20B	20	0.4	42	20	100	7	HB	▲
DSFT.7.200.040.30	20	0.4	62	20	120	7	HA	▲
DSFT.7.200.040.30B	20	0.4	62	20	120	7	HB	▲
DSFT.5.200.040.40	20	0.4	82	20	140	5	HA	▲
DSFT.5.200.040.40B	20	0.4	82	20	140	5	HB	▲


P	●
M	○
K	○
N	-
S	○
H	○




切削参数 DSFT Ø 12 - 20 mm

Cutting Data DSF Ø 12 - 20 mm

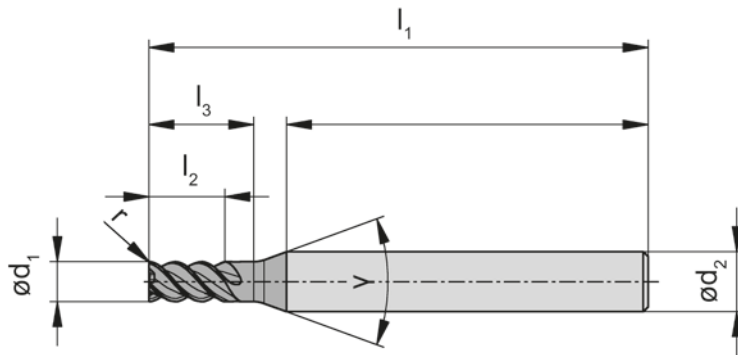
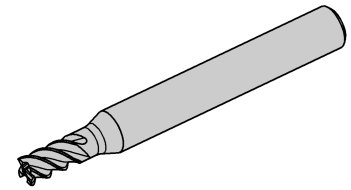
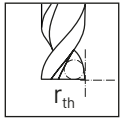
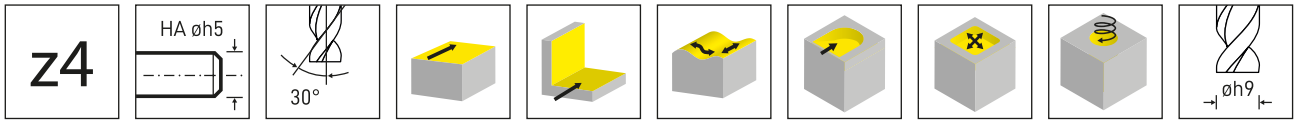


B

				
	vc = m/min	vc = m/min	vc = m/min	vc = m/min
P1.1	160	180	K1.1	160
P1.2	160	180	K1.2	160
P1.3	160	180	K2.1	150
P1.4	160	180	K2.2	140
P1.5	160	180	K3.1	140
P1.6	160	180	K3.2	140
P2.1	160	180	K4.1	130
P2.2	160	180	K4.2	130
P2.3	160	180	K4.3	130
P2.4	160	180		
P3.1	150	170		
P3.2	150	170		
P4.1	150	170		
P4.2	150	170		
P5.1	130	140		
M1.1	120	130		
M1.2	110	120		
M1.3	100	110		

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
12	3°	0.133	2.40	24.0	0.195	1.20	24.0
12	3°	0.127	2.16	36.0	0.185	1.08	36.0
12	3°	0.119	1.92	48.0	0.174	0.96	48.0
12	3°	0.133	2.40	24.0	0.195	1.20	24.0
12	3°	0.127	2.16	36.0	0.185	1.08	36.0
12	3°	0.119	1.92	48.0	0.174	0.96	48.0
16	3°	0.183	3.20	32.0	0.265	1.60	32.0
16	3°	0.174	2.88	48.0	0.252	1.44	48.0
16	3°	0.164	2.56	64.0	0.237	1.28	64.0
16	3°	0.183	3.20	32.0	0.265	1.60	32.0
16	3°	0.174	2.88	48.0	0.252	1.44	48.0
16	3°	0.164	2.56	64.0	0.237	1.28	64.0
20	3°	0.231	4.00	40.0	0.332	2.00	40.0
20	3°	0.219	3.60	60.0	0.315	1.80	60.0
20	3°	0.206	3.20	80.0	0.297	1.60	80.0
20	3°	0.231	4.00	40.0	0.332	2.00	40.0
20	3°	0.219	3.60	60.0	0.315	1.80	60.0
20	3°	0.206	3.20	80.0	0.297	1.60	80.0

B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	l ₃	d ₃	d ₂	l ₁	Z	γ	TS3K
DSH.4.020.035.020	2	4	1.8	6	50	4	40°	▲
DSH.4.020.035.030	2	6	1.8	6	50	4	40°	▲
DSH.4.030.050.020	3	6	2.7	6	50	4	40°	▲
DSH.4.030.050.030	3	9	2.7	6	50	4	40°	▲
DSH.4.040.070.020	4	8	3.6	6	50	4	40°	▲
DSH.4.040.070.030	4	12	3.6	6	57	4	40°	▲
DSH.4.050.080.020	5	10	4.5	6	50	4	40°	▲
DSH.4.060.080.020	6	12	5.4	6	50	4	40°	▲
DSH.4.060.080.030	6	18	5.4	6	64	4	40°	▲
DSH.4.080.140.020	8	16	7.2	8	60	4	40°	▲
DSH.4.080.140.030	8	24	7.2	8	63	4	40°	▲
DSH.4.100.200.020	10	20	9	10	70	4	40°	▲
DSH.4.100.200.030	10	30	9	10	78	4	40°	▲
DSH.4.120.210.020	12	24	10.8	12	78	4	40°	▲
DSH.4.120.210.030	12	36	10.8	12	89	4	40°	▲
DSH.4.160.280.020	16	32	-	16	89	4	40°	▲
DSH.4.160.280.030	16	48	-	16	100	4	40°	▲





P	●
M	○
K	○
N	-
S	○
H	○




切削参数 DSH Ø 2 - 16 mm

Cutting Data DSH Ø 2 - 16 mm



B

					
	vc = m/min	vc = m/min		vc = m/min	vc = m/min
P1.1	170	200	K1.1	160	180
P1.2	170	200	K1.2	160	180
P1.3	160	190	K2.1	150	170
P1.4	160	190	K2.2	140	160
P1.5	160	190	K3.1	140	160
P1.6	160	190	K3.2	140	160
P2.1	160	190	K4.1	130	150
P2.2	160	190	K4.2	130	150
P2.3	160	190	K4.3	130	150
P2.4	160	190	S1.1	90	110
P3.1	150	180	S1.2	80	100
P3.2	150	180	S2.1	60	80
P4.1	150	180	S2.2	50	70
P4.2	150	180	S3.1	80	100
P5.1	130	150	S3.2	80	100
M1.1	120	140	S3.3	80	100
M1.2	110	130			
M1.3	100	120			

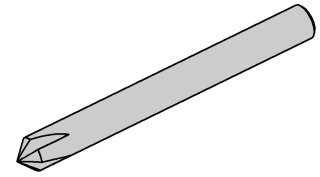
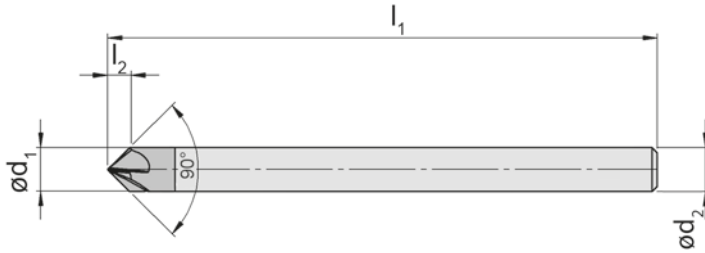
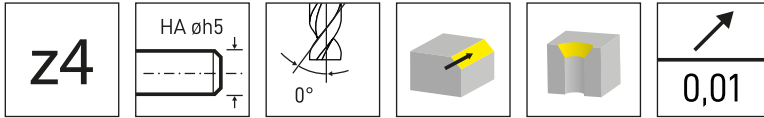
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
2	3°	0.070	2	0.15	0.081	1.50	0.17
2	3°	0.070	2	0.14	0.081	1.50	0.15
3	3°	0.110	3	0.20	0.128	2.25	0.23
3	3°	0.110	3	0.20	0.128	2.25	0.23
4	3°	0.150	4	0.24	0.174	3.00	0.27
4	3°	0.150	4	0.24	0.174	3.00	0.27
5	3°	0.190	5	0.26	0.220	3.75	0.29
6	3°	0.230	6	0.27	0.266	4.50	0.31
6	3°	0.230	6	0.27	0.266	4.50	0.31
8	3°	0.310	8	0.34	0.359	6.00	0.38
8	3°	0.310	8	0.34	0.359	6.00	0.38
10	3°	0.390	10	0.47	0.451	7.50	0.54
10	3°	0.390	10	0.47	0.451	7.50	0.54
12	3°	0.470	12	0.54	0.543	9.00	0.61
12	3°	0.470	12	0.54	0.543	9.00	0.61
16	3°	0.630	16	0.68	0.728	12.00	0.77
16	3°	0.630	16	0.68	0.728	12.00	0.77

铣削倒角刀 Chamfer Milling Cutter

DSFF



B



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks


产品型号 Part number	d ₁	l ₂	d ₂	l ₁	Z	TS3K
DSFF.4.04.50.04.45	4	2	4	50	4	▲
DSFF.4.06.63.06.45	6	3	6	63	4	▲
DSFF.4.08.63.08.45	8	4	8	63	4	▲
DSFF.4.10.69.10.45	10	5	10	69	4	▲
DSFF.4.12.77.12.45	12	6	12	77	4	▲
						P ●
						M ○
						K ○
						N -
						S ○
						H ○

切削参数 DSFF Ø 4 - 12 mm

Cutting Data DSFF Ø 4 - 12 mm



B




vc = m/min

P1.1	120
P1.2	120
P1.3	120
P1.4	120
P1.5	120
P1.6	120
P2.1	120
P2.2	120
P2.3	120
P2.4	120
P3.1	110
P3.2	110
P4.1	110
P4.2	110
P5.1	80
M1.1	120
M1.2	110
M1.3	100




vc = m/min

K1.1	120
K1.2	120
K2.1	120
K2.2	120
K3.1	120
K3.2	110
K4.1	110
K4.2	110
K4.3	110
N1.1	180
N1.2	180
N2.1	160
N2.2	110
N3.1	160
N3.2	160
N3.3	140
N3.4	120



vc = m/min

S1.1	80
S1.2	70
S2.1	50
S2.2	40
S3.1	70
S3.2	70
S3.3	70



d_1	f_z	a_e	a_p
4	0.030	0.60	0.60
6	0.040	0.75	0.75
8	0.045	1.00	1.00
10	0.050	1.25	1.25
12	0.060	1.50	1.50

整体硬质合金立铣刀

Solid Carbide End Mills



C



DSKMH 圆头微型立铣刀
Ball Nose End Mill Micro

Ø 0.2 - Ø 3

Z 2

114 - 117



DSKH.2 圆头立铣刀
Ball Nose End Mill

Ø 4 - Ø 12

Z 2

118 - 119



DSKH.4 圆头立铣刀
Ball Nose End Mill

Ø 4 - Ø 12

Z 4

120 - 121



DSTMH 圆角微型立铣刀
Torus End Mill Micro

Ø 0.1 - Ø 3

Z 2

122 - 129



DSTH.2 圆角立铣刀
Torus End Mill

Ø 4 - Ø 10

Z 2

130 - 139



DSTH.4 圆角立铣刀
Torus End Mill

Ø 4 - Ø 12

Z 4

140 - 149



DSMH 多刃立铣刀
End Mill multiple fluted

Ø 3 - Ø 16

Z 6

150 - 151



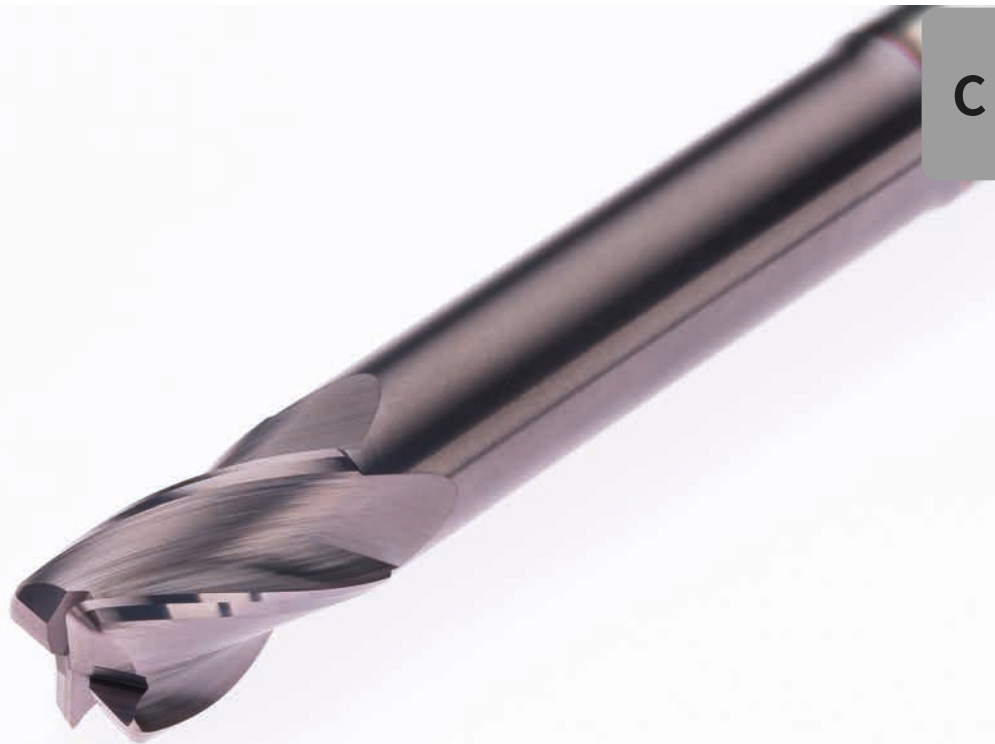
DSMRH 多刃立铣刀
End Mill multiple fluted

Ø 3 - Ø 12

Z 6

152 - 153

DS

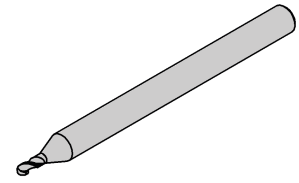
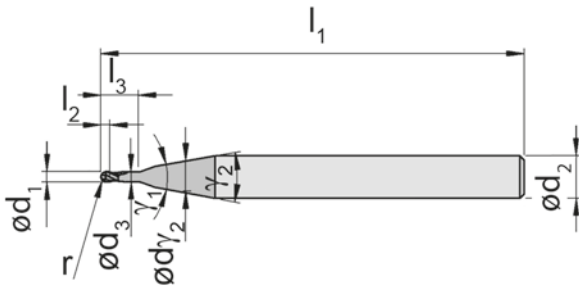
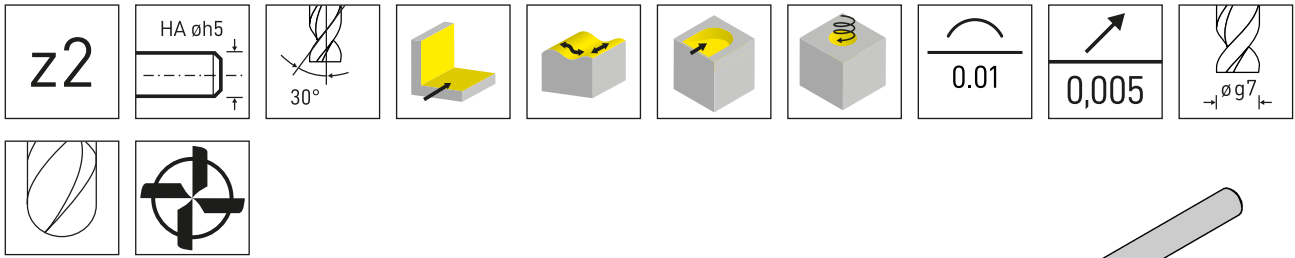


整体硬质合金立铣刀

设计用于：
- 淬硬钢件

Solid Carbide End Mills

designed for:
- hardened steels



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TSSE
DSKMH.020.015	0.2	0.1	0.3	-	-	4	50	2	20°	-°	▲
DSKMH.020.030	0.2	0.1	0.3	0.6	0.18	4	50	2	40°	20°	▲
DSKMH.030.015	0.3	0.15	0.45	-	-	4	50	2	20°	-°	▲
DSKMH.030.030	0.3	0.15	0.45	0.9	0.28	4	50	2	40°	20°	▲
DSKMH.030.050	0.3	0.15	0.45	1.5	0.28	4	50	2	40°	20°	▲
DSKMH.040.015	0.4	0.2	0.6	-	-	4	50	2	20°	-°	▲
DSKMH.040.030	0.4	0.2	0.6	1.2	0.38	4	50	2	40°	20°	▲
DSKMH.040.050	0.4	0.2	0.6	2	0.38	4	50	2	40°	20°	▲
DSKMH.050.015	0.5	0.25	0.75	-	-	4	50	2	20°	-°	▲
DSKMH.050.030	0.5	0.25	0.75	1.5	0.47	4	50	2	40°	20°	▲
DSKMH.050.050	0.5	0.25	0.75	2.5	0.47	4	50	2	40°	20°	▲
DSKMH.050.070	0.5	0.25	0.75	3.5	0.47	4	50	2	40°	20°	▲
DSKMH.060.015	0.6	0.3	0.9	-	-	4	50	2	20°	-°	▲
DSKMH.060.030	0.6	0.3	0.9	1.8	0.56	4	50	2	40°	20°	▲
DSKMH.060.070	0.6	0.3	0.9	4.2	0.56	4	50	2	40°	20°	▲
DSKMH.080.015	0.8	0.4	-	1.2	-	4	50	2	20°	-°	▲
DSKMH.080.030	0.8	0.4	1.2	2.4	0.75	4	50	2	40°	20°	▲
DSKMH.080.050	0.8	0.4	1.2	4	0.75	4	50	2	40°	20°	▲
DSKMH.080.070	0.8	0.4	1.2	5.6	0.75	4	50	2	40°	20°	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSKMH Ø 0.2 - 0.8 mm



Cutting Data DSKMH Ø 0.2 - 0.8 mm


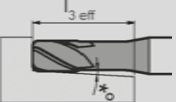




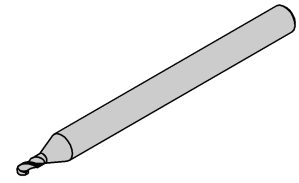
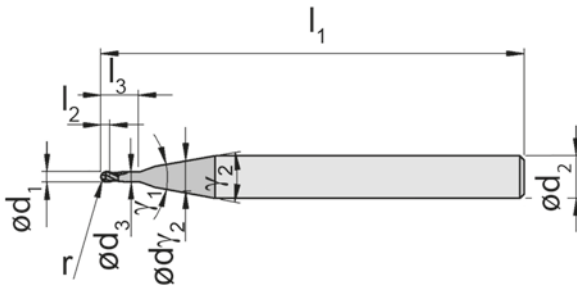
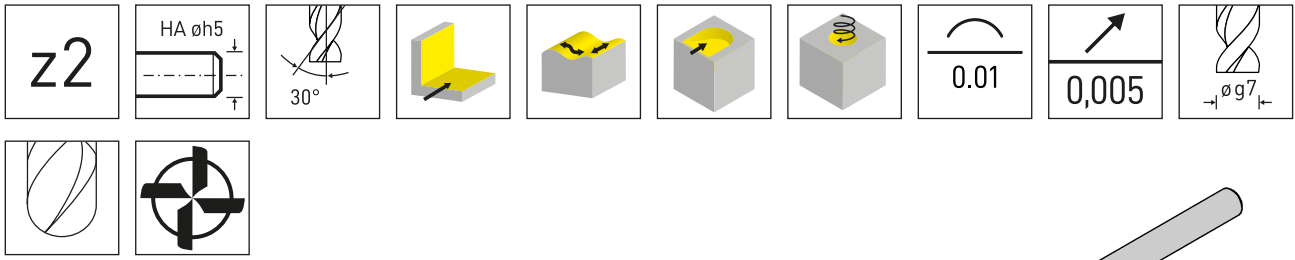
常规铣削 / Conventional milling

HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	130	160
H1.2	120	150
H1.3	90	120
H1.4	70	100

		
	vc = m/min	vc = m/min
H1.1	180	210
H1.2	170	200
H1.3	140	170
H1.4	120	150

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
0.2	5°	0.30	0.50	0.50	0.60	0.60	0.004	0.04	0.03	0.008	0.01	0.02
0.2	4°	0.60	0.70	0.70	0.80	0.90	0.004	0.04	0.03	0.008	0.01	0.02
0.3	5°	0.45	1.10	1.10	1.20	1.50	0.005	0.06	0.05	0.010	0.02	0.03
0.3	4°	0.90	1.30	1.30	1.40	1.80	0.005	0.06	0.04	0.010	0.02	0.03
0.3	3°	1.50	1.50	1.50	1.60	2.10	0.005	0.06	0.03	0.009	0.02	0.02
0.4	5°	0.60	1.70	1.70	1.80	2.40	0.007	0.08	0.06	0.012	0.02	0.04
0.4	4°	1.20	1.90	1.90	2.00	2.70	0.007	0.08	0.05	0.012	0.02	0.04
0.4	3°	2.00	2.10	2.10	2.20	3.00	0.006	0.08	0.04	0.011	0.02	0.03
0.5	5°	0.75	2.30	2.30	2.40	3.30	0.008	0.10	0.08	0.014	0.03	0.05
0.5	4°	1.50	2.50	2.50	2.60	3.60	0.008	0.10	0.07	0.014	0.03	0.05
0.5	3°	2.50	2.70	2.70	2.80	3.90	0.007	0.10	0.06	0.013	0.03	0.04
0.5	2°	3.50	2.90	2.90	3.00	4.20	0.006	0.10	0.05	0.011	0.03	0.03
0.6	5°	0.90	3.10	3.10	3.20	4.50	0.009	0.12	0.09	0.016	0.03	0.06
0.6	4°	1.80	3.30	3.30	3.40	4.80	0.009	0.12	0.08	0.016	0.03	0.06
0.6	2°	4.20	3.70	3.70	3.80	5.40	0.007	0.12	0.05	0.013	0.03	0.04
0.8	5°	1.20	3.90	3.90	4.00	5.70	0.011	0.16	0.12	0.020	0.04	0.08
0.8	4°	2.40	4.10	4.10	4.20	6.00	0.011	0.16	0.10	0.020	0.04	0.08
0.8	3°	4.00	4.30	4.30	4.40	6.30	0.010	0.16	0.09	0.018	0.04	0.06
0.8	2°	5.60	4.50	4.50	4.60	6.60	0.009	0.16	0.07	0.016	0.04	0.05



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3E
DSKMH.100.015	1	0.5	1.5	-	-	4	50	2	20°	-°	▲
DSKMH.100.030	1	0.5	1.5	3	0.95	4	50	2	40°	20°	▲
DSKMH.100.050	1	0.5	1.5	5	0.95	4	50	2	40°	20°	▲
DSKMH.100.070	1	0.5	1.5	7	0.95	4	50	2	40°	20°	▲
DSKMH.120.015	1.2	0.6	1.8	-	-	4	50	2	20°	-°	▲
DSKMH.120.030	1.2	0.6	1.8	3.6	1.15	4	50	2	40°	20°	▲
DSKMH.120.050	1.2	0.6	1.8	6	1.15	4	50	2	40°	20°	▲
DSKMH.120.070	1.2	0.6	1.8	8.4	1.15	4	50	2	40°	20°	▲
DSKMH.150.015	1.5	0.75	2.25	-	-	4	50	2	20°	-°	▲
DSKMH.150.030	1.5	0.75	2.25	4.5	1.45	4	50	2	40°	20°	▲
DSKMH.150.070	1.5	0.75	2.25	10.5	1.45	4	50	2	40°	20°	▲
DSKMH.200.015	2	1	3	-	-	4	50	2	20°	-°	▲
DSKMH.200.030	2	1	3	6	1.9	4	50	2	40°	20°	▲
DSKMH.200.050	2	1	3	10	1.9	4	50	2	40°	20°	▲
DSKMH.200.070	2	1	3	14	1.9	4	50	2	40°	20°	▲
DSKMH.250.015	2.5	1.25	3.75	-	-	4	50	2	20°	-°	▲
DSKMH.300.015	3	1.5	4.5	-	-	4	50	2	20°	-°	▲
DSKMH.300.030	3	1.5	4.5	9	2.9	4	50	2	40°	20°	▲
DSKMH.300.050	3	1.5	4.5	15	2.9	4	50	2	40°	20°	▲
DSKMH.300.070	3	1.5	4.5	21	2.9	4	60	2	40°	20°	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSKMH Ø 1 - 3 mm



Cutting Data DST Ø 1 - 3 mm


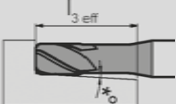




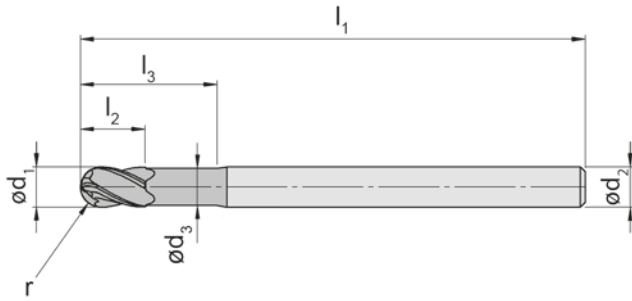
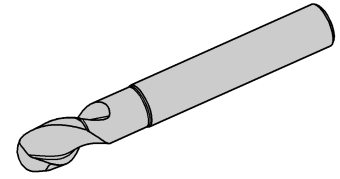
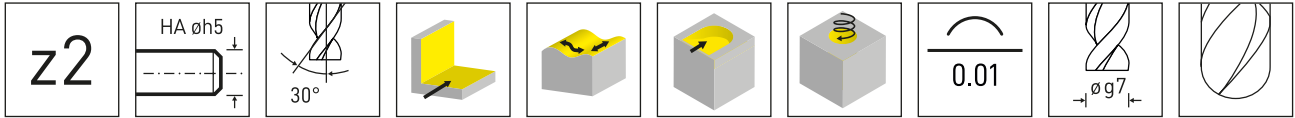
常规铣削 / Conventional milling

HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	130	160
H1.2	120	150
H1.3	90	120
H1.4	70	100

		
	vc = m/min	vc = m/min
H1.1	180	210
H1.2	170	200
H1.3	140	170
H1.4	120	150

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
1.0	5°	1.50	4.70	4.70	4.80	6.90	0.013	0.20	0.15	0.024	0.05	0.10
1.0	4°	3.00	4.90	4.90	5.00	7.20	0.013	0.20	0.13	0.024	0.05	0.10
1.0	3°	5.00	5.10	5.10	5.20	7.50	0.012	0.20	0.11	0.021	0.05	0.08
1.0	2°	7.00	5.30	5.30	5.40	7.80	0.011	0.20	0.09	0.019	0.05	0.06
1.2	5°	1.80	2.00	2.10	2.30	2.60	0.016	0.24	0.18	0.028	0.06	0.12
1.2	4°	3.60	3.90	4.00	4.20	4.40	0.016	0.24	0.16	0.028	0.06	0.12
1.2	3°	6.00	6.30	6.50	6.80	7.20	0.014	0.24	0.13	0.025	0.06	0.10
1.2	2°	8.40	8.80	9.00	9.50	10.00	0.012	0.24	0.11	0.022	0.06	0.07
1.5	5°	2.25	2.50	2.60	2.80	3.10	0.019	0.30	0.23	0.033	0.08	0.15
1.5	4°	4.50	4.80	4.90	5.10	5.40	0.019	0.30	0.20	0.033	0.08	0.15
1.5	2°	10.50	11.00	11.20	11.80	12.90	0.015	0.30	0.14	0.027	0.08	0.09
2.0	5°	3.00	3.30	3.40	3.70	4.10	0.024	0.40	0.30	0.043	0.10	0.20
2.0	4°	6.00	6.40	6.50	6.80	7.20	0.024	0.40	0.26	0.043	0.10	0.20
2.0	3°	10.00	10.50	10.70	11.30	12.10	0.022	0.40	0.22	0.039	0.10	0.16
2.0	2°	14.00	14.60	14.90	14.70	17.80	0.020	0.40	0.18	0.034	0.10	0.12
2.5	5°	3.75	4.00	4.20	4.60	5.10	0.030	0.50	0.38	0.053	0.13	0.25
3.0	5°	4.50	4.80	5.00	5.50	6.00	0.036	0.60	0.45	0.063	0.15	0.30
3.0	4°	9.00	9.40	9.70	10.30	∞	0.036	0.60	0.39	0.063	0.15	0.30
3.0	3°	15.00	15.60	16.00	∞	∞	0.032	0.60	0.33	0.056	0.15	0.24
3.0	2°	21.00	21.80	22.60	∞	∞	0.029	0.60	0.27	0.050	0.15	0.18



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	TS3E
DSKH.2.040.015	4	2	6	6	-	6	64	2	20°	▲
DSKH.2.040.030	4	2	6	12	3.8	6	64	2	20°	▲
DSKH.2.040.050	4	2	6	20	3.8	6	64	2	20°	▲
DSKH.2.040.070	4	2	6	28	3.8	6	64	2	20°	▲
DSKH.2.050.015	5	2.5	7.5	7.5	-	6	64	2	20°	▲
DSKH.2.050.030	5	2.5	7.5	15	4.7	6	64	2	20°	▲
DSKH.2.050.050	5	2.5	7.5	25	4.7	6	64	2	20°	▲
DSKH.2.050.070	5	2.5	7.5	35	4.7	6	78	2	20°	▲
DSKH.2.060.015	6	3	9	9	-	6	64	2	-°	▲
DSKH.2.060.030	6	3	9	18	5.7	6	64	2	-°	▲
DSKH.2.060.050	6	3	9	30	5.7	6	78	2	-°	▲
DSKH.2.060.070	6	3	9	42	5.7	6	78	2	-°	▲
DSKH.2.080.015	8	4	12	12	-	8	64	2	-°	▲
DSKH.2.080.050	8	4	12	40	7.6	8	78	2	-°	▲
DSKH.2.080.070	8	4	12	56	7.6	8	100	2	-°	▲
DSKH.2.100.015	10	5	15	15	-	10	78	2	-°	▲
DSKH.2.100.030	10	5	15	30	9.6	10	78	2	-°	▲
DSKH.2.100.050	10	5	15	50	9.6	10	100	2	-°	▲
DSKH.2.100.070	10	5	15	70	9.6	10	120	2	-°	▲
DSKH.2.120.015	12	6	18	18	-	12	78	2	-°	▲
DSKH.2.120.050	12	6	18	60	11.6	12	120	2	-°	▲
DSKH.2.120.070	12	6	18	84	11.6	12	140	2	-°	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSKH Ø 4 - 12 mm



Cutting Data DST Ø 4 - 12 mm






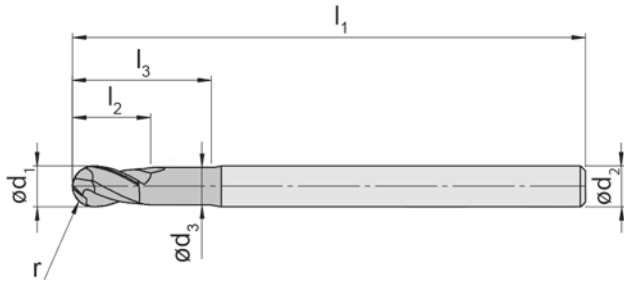
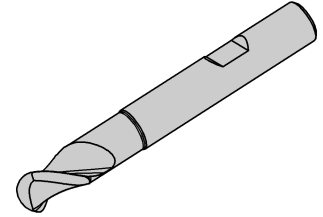
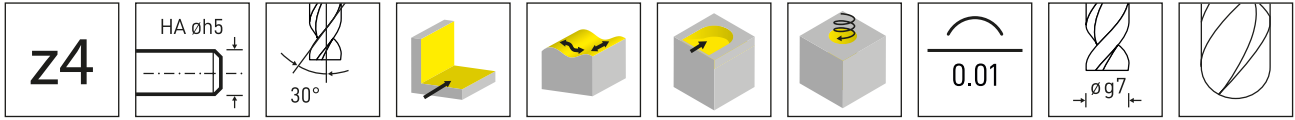
常规铣削 / Conventional milling

HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	130	160
H1.2	120	150
H1.3	90	120
H1.4	70	100

		
	vc = m/min	vc = m/min
H1.1	180	210
H1.2	170	200
H1.3	140	170
H1.4	120	150

d ₁							
	α	f _z	a _e	a _p	f _z	a _e	a _p
4	5°	0.013	0.20	0.15	0.024	0.05	0.10
4	4°	0.013	0.20	0.13	0.024	0.05	0.10
4	3°	0.012	0.20	0.11	0.021	0.05	0.08
4	2°	0.011	0.20	0.09	0.019	0.05	0.06
5	5°	0.016	0.24	0.18	0.028	0.06	0.12
5	4°	0.016	0.24	0.16	0.028	0.06	0.12
5	3°	0.014	0.24	0.13	0.025	0.06	0.10
5	2°	0.012	0.24	0.11	0.022	0.06	0.07
6	5°	0.019	0.30	0.23	0.033	0.08	0.15
6	4°	0.019	0.30	0.20	0.033	0.08	0.15
6	3°	0.017	0.30	0.17	0.030	0.08	0.12
6	2°	0.015	0.30	0.14	0.027	0.08	0.09
8	5°	0.024	0.40	0.30	0.043	0.10	0.20
8	3°	0.022	0.40	0.22	0.039	0.10	0.16
8	2°	0.020	0.40	0.18	0.034	0.10	0.12
10	5°	0.030	0.50	0.38	0.053	0.13	0.25
10	4°	0.030	0.50	0.33	0.053	0.13	0.25
10	3°	0.027	0.50	0.28	0.048	0.13	0.20
10	2°	0.024	0.50	0.23	0.042	0.13	0.15
12	5°	0.036	0.60	0.45	0.063	0.15	0.30
12	3°	0.032	0.60	0.33	0.056	0.15	0.24
12	2°	0.029	0.60	0.27	0.050	0.15	0.18



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	TS3E
DSKH.4.040.015	4	2	6	6	-	6	64	4	20°	▲
DSKH.4.040.030	4	2	6	12	3.8	6	64	4	20°	▲
DSKH.4.040.050	4	2	6	20	3.8	6	64	4	20°	▲
DSKH.4.050.015	5	2.5	7.5	7.5	-	6	64	4	20°	▲
DSKH.4.050.070	5	2.5	7.5	35	4.7	6	64	4	20°	▲
DSKH.4.060.015	6	3	9	9	-	6	64	4	-°	▲
DSKH.4.060.030	6	3	9	18	5.7	6	64	4	-°	▲
DSKH.4.060.050	6	3	9	30	5.7	6	78	4	-°	▲
DSKH.4.060.070	6	3	9	42	5.7	6	78	4	-°	▲
DSKH.4.080.015	8	4	12	12	-	8	64	4	-°	▲
DSKH.4.080.030	8	4	12	24	7.6	8	64	4	-°	▲
DSKH.4.080.070	8	4	12	56	7.6	8	100	4	-°	▲
DSKH.4.100.015	10	5	15	15	-	10	78	4	-°	▲
DSKH.4.100.030	10	5	15	30	9.6	10	78	4	-°	▲
DSKH.4.120.015	12	6	18	18	-	12	78	4	-°	▲
DSKH.4.120.030	12	6	18	36	11.6	12	100	4	-°	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSKH Ø 4 - 12 mm



Cutting Data DST Ø 4 - 12 mm

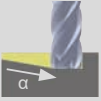




常规铣削 / Conventional milling

HSC 铣削 / HSC milling

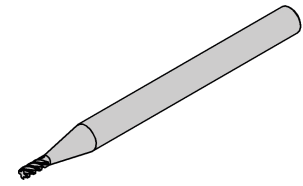
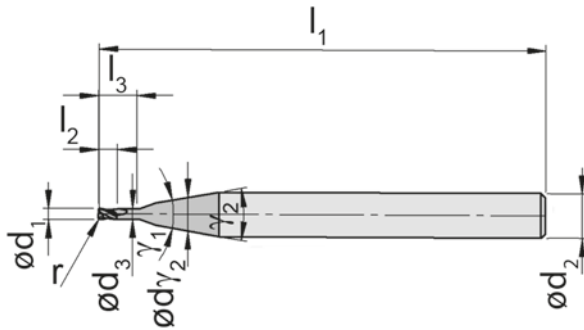
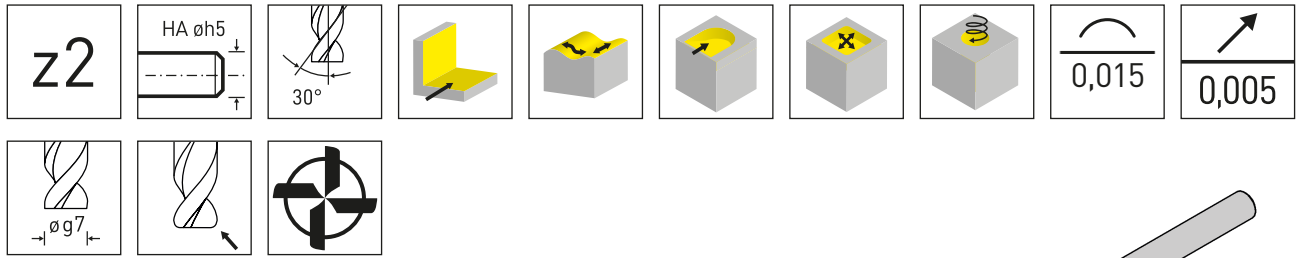
		
	vc = m/min	vc = m/min
H1.1	130	160
H1.2	120	150
H1.3	90	120
H1.4	70	100

		
	vc = m/min	vc = m/min
H1.1	180	210
H1.2	170	200
H1.3	140	170
H1.4	120	150

d ₁							
	α	f _z	a _e	a _p	f _z	a _e	a _p
4	5°	0.023	0.80	0.60	0.035	0.20	0.40
4	4°	0.023	0.80	0.52	0.035	0.20	0.40
4	3°	0.021	0.80	0.44	0.032	0.20	0.32
5	5°	0.035	1.00	0.75	0.055	0.25	0.50
5	2°	0.028	1.00	0.45	0.044	0.25	0.30
6	5°	0.046	1.20	0.90	0.074	0.30	0.60
6	4°	0.046	1.20	0.78	0.074	0.30	0.60
6	3°	0.041	1.20	0.66	0.067	0.30	0.48
6	2°	0.037	1.20	0.54	0.059	0.30	0.36
8	5°	0.068	1.60	1.20	0.113	0.40	0.80
8	4°	0.068	1.60	1.04	0.113	0.40	0.80
8	2°	0.055	1.60	0.72	0.090	0.40	0.48
10	5°	0.090	2.00	1.50	0.152	0.50	1.00
10	4°	0.090	2.00	1.30	0.152	0.50	1.00
12	5°	0.113	2.40	1.80	0.191	0.60	1.20
12	4°	0.113	2.40	1.56	0.191	0.60	1.20

圆角微型立铣刀 Torus End Mill Micro

DSTMH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3E
DSTMH.010.000.030	0.1	0	0.15	0.3	0.084	4	50	2	20°	-°	▲
DSTMH.020.000.030	0.2	0	0.3	0.6	0.18	4	50	2	40°	20°	▲
DSTMH.020.000.050	0.2	0	0.3	1	0.18	4	50	2	40°	20°	▲
DSTMH.030.005.015	0.3	0.05	0.45	0.45	-	4	50	2	20°	-°	▲
DSTMH.030.005.030	0.3	0.05	0.45	0.9	0.28	4	50	2	40°	20°	▲
DSTMH.030.005.050	0.3	0.05	0.45	1.5	0.28	4	50	2	40°	20°	▲
DSTMH.040.005.015	0.4	0.05	0.6	0.6	-	4	50	2	20°	-°	▲
DSTMH.040.005.030	0.4	0.05	0.6	1.2	0.38	4	50	2	40°	20°	▲
DSTMH.040.005.050	0.4	0.05	0.6	2	0.38	4	50	2	40°	20°	▲
DSTMH.050.005.015	0.5	0.05	0.75	0.75	-	4	50	2	20°	-°	▲
DSTMH.050.005.030	0.5	0.05	0.75	1.5	0.47	4	50	2	40°	20°	▲
DSTMH.050.005.050	0.5	0.05	0.75	2.5	0.47	4	50	2	40°	20°	▲
DSTMH.050.005.070	0.5	0.05	0.75	3.5	0.47	4	50	2	40°	20°	▲
DSTMH.050.010.015	0.5	0.1	0.75	0.75	-	4	50	2	20°	-°	▲
DSTMH.050.010.030	0.5	0.1	0.75	1.5	0.47	4	50	2	40°	20°	▲
DSTMH.050.010.050	0.5	0.1	0.75	2.5	0.47	4	50	2	40°	20°	▲
DSTMH.050.010.070	0.5	0.1	0.75	3.5	0.47	4	50	2	40°	20°	▲
DSTMH.060.005.015	0.6	0.05	0.9	0.9	-	4	50	2	20°	-°	▲
DSTMH.060.010.015	0.6	0.1	0.9	0.9	-	4	50	2	20°	-°	▲
DSTMH.060.010.030	0.6	0.1	0.9	1.8	0.56	4	50	2	40°	20°	▲
DSTMH.060.010.050	0.6	0.1	0.9	3	0.56	4	50	2	40°	20°	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSTMH Ø 0.1 - 0.6 mm



Cutting Data DSTMH Ø 0.1 - 0.6 mm


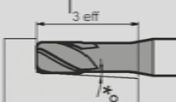




常规铣削 / Conventional milling

HSC 铣削 / HSC milling

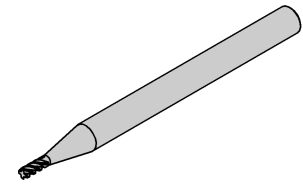
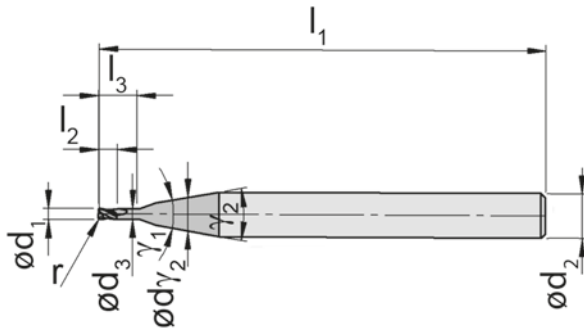
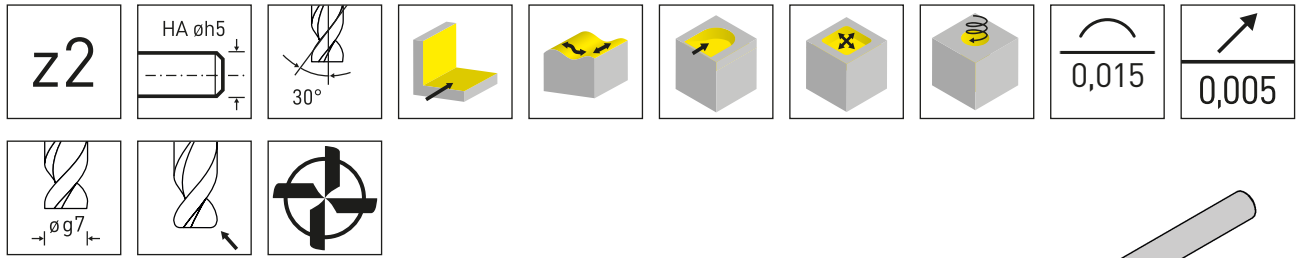
		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
0.1	4°	0.30	0.50	0.50	0.60	0.70	0.003	0.02	0.01	0.005	0.01	0.01
0.2	4°	0.60	0.70	0.70	0.80	0.90	0.004	0.04	0.03	0.007	0.02	0.02
0.2	3°	1.00	1.10	1.20	1.30	1.40	0.004	0.04	0.02	0.006	0.02	0.02
0.3	5°	0.45	0.60	0.70	0.80	0.90	0.005	0.06	0.05	0.008	0.02	0.03
0.3	4°	0.90	1.00	1.10	1.20	1.20	0.005	0.06	0.04	0.008	0.02	0.03
0.3	3°	1.50	1.60	1.70	1.80	1.90	0.005	0.06	0.03	0.007	0.02	0.02
0.4	5°	0.60	0.80	0.80	0.90	1.10	0.007	0.08	0.06	0.010	0.03	0.04
0.4	4°	1.20	1.40	1.40	1.50	1.60	0.007	0.08	0.05	0.010	0.03	0.04
0.4	3°	2.00	2.20	2.30	2.40	2.50	0.006	0.08	0.04	0.009	0.03	0.03
0.5	5°	0.75	1.00	1.00	1.10	1.30	0.008	0.10	0.08	0.011	0.04	0.05
0.5	4°	1.50	1.70	1.70	1.90	2.00	0.008	0.10	0.07	0.011	0.04	0.05
0.5	3°	2.50	2.70	2.80	3.00	3.10	0.007	0.10	0.06	0.010	0.04	0.04
0.5	2°	3.50	3.70	3.90	4.10	4.30	0.006	0.10	0.05	0.009	0.04	0.03
0.5	5°	0.75	1.00	1.00	1.10	1.30	0.008	0.10	0.08	0.011	0.04	0.05
0.5	4°	1.50	1.70	1.70	1.90	2.00	0.008	0.10	0.07	0.011	0.04	0.05
0.5	3°	2.50	2.70	2.80	3.00	3.10	0.007	0.10	0.06	0.010	0.04	0.04
0.5	2°	3.50	3.70	3.90	4.10	4.30	0.006	0.10	0.05	0.009	0.04	0.03
0.6	5°	0.90	1.10	1.20	1.30	1.50	0.009	0.12	0.09	0.013	0.05	0.06
0.6	5°	0.90	1.10	1.20	1.30	1.50	0.009	0.12	0.09	0.013	0.05	0.06
0.6	4°	1.80	2.00	2.10	2.20	2.30	0.009	0.12	0.08	0.013	0.05	0.06
0.6	3°	3.00	3.30	3.30	3.50	3.70	0.008	0.12	0.07	0.012	0.05	0.05

圆角微型立铣刀 Torus End Mill Micro

DSTMH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3E
DSTMH.080.005.015	0.8	0.05	1.2	1.2	-	4	50	2	20°	-°	▲
DSTMH.080.005.030	0.8	0.05	1.2	2.4	0.75	4	50	2	40°	20°	▲
DSTMH.080.005.050	0.8	0.05	1.2	4	0.75	4	50	2	40°	20°	▲
DSTMH.080.005.070	0.8	0.05	1.2	5.6	0.75	4	50	2	40°	20°	▲
DSTMH.080.010.050	0.8	0.1	1.2	4	0.75	4	50	2	40°	20°	▲
DSTMH.080.010.070	0.8	0.1	1.2	5.6	0.75	4	50	2	40°	20°	▲
DSTMH.100.005.015	1	0.05	1.5	1.5	-	4	50	2	20°	-°	▲
DSTMH.100.005.030	1	0.05	1.5	3	0.95	4	50	2	40°	20°	▲
DSTMH.100.005.050	1	0.05	1.5	5	0.95	4	50	2	40°	20°	▲
DSTMH.100.005.070	1	0.05	1.5	7	0.95	4	50	2	40°	20°	▲
DSTMH.100.010.015	1	0.1	1.5	1.5	-	4	50	2	20°	-°	▲
DSTMH.100.010.030	1	0.1	1.5	3	0.95	4	50	2	40°	20°	▲
DSTMH.100.010.050	1	0.1	1.5	5	0.95	4	50	2	40°	20°	▲
DSTMH.100.010.070	1	0.1	1.5	7	0.95	4	50	2	40°	20°	▲
DSTMH.120.010.015	1.2	0.1	1.8	1.8	-	4	50	2	20°	-°	▲
DSTMH.120.010.030	1.2	0.1	1.8	3.6	1.15	4	50	2	40°	20°	▲
DSTMH.120.010.050	1.2	0.1	1.8	6	1.15	4	50	2	40°	20°	▲
DSTMH.120.010.070	1.2	0.1	1.8	8.4	1.15	4	50	2	40°	20°	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSTMH Ø 0.8 - 1.2 mm



Cutting Data DSTMH Ø 0.8 - 1.2 mm







常规铣削 / Conventional milling

HSC 铣削 / HSC milling

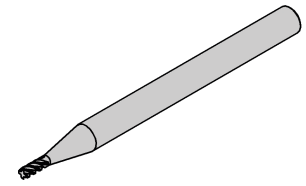
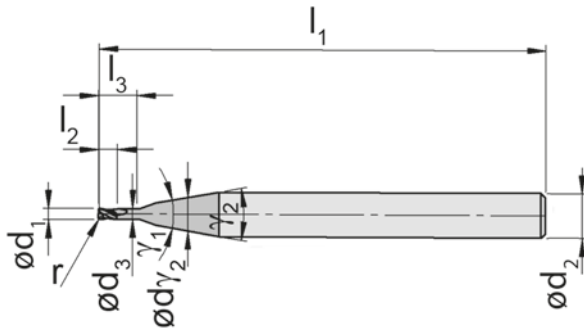
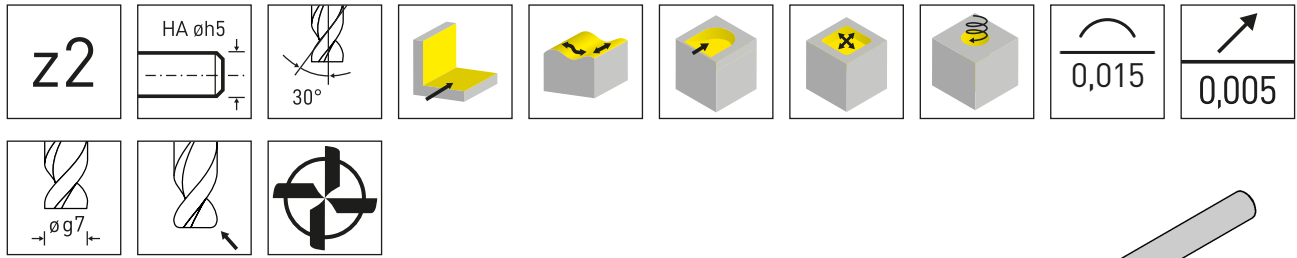
		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
0.8	5°	1.20	1.40	1.50	1.70	1.90	0.011	0.16	0.12	0.016	0.06	0.08
0.8	4°	2.40	2.70	2.70	2.90	3.00	0.011	0.16	0.10	0.016	0.06	0.08
0.8	5°	4.00	4.30	4.40	4.70	4.90	0.010	0.16	0.09	0.015	0.06	0.06
0.8	4°	5.60	5.90	6.10	6.40	6.80	0.009	0.16	0.07	0.013	0.06	0.05
0.8	4°	4.00	4.30	4.40	4.60	4.90	0.010	0.16	0.09	0.015	0.06	0.06
0.8	3°	5.60	5.90	6.10	6.40	6.80	0.009	0.16	0.07	0.013	0.06	0.05
1.0	5°	1.50	1.70	1.80	2.10	2.40	0.013	0.20	0.15	0.019	0.08	0.10
1.0	4°	3.00	3.30	3.40	3.50	3.70	0.013	0.20	0.13	0.019	0.08	0.10
1.0	3°	5.00	5.30	5.50	5.80	6.10	0.012	0.20	0.11	0.017	0.08	0.08
1.0	5°	7.00	7.40	7.60	8.00	8.40	0.011	0.20	0.09	0.015	0.08	0.06
1.0	4°	1.50	1.70	1.80	2.10	2.30	0.013	0.20	0.15	0.019	0.08	0.10
1.0	3°	3.00	3.30	3.40	3.50	3.70	0.013	0.20	0.13	0.019	0.08	0.10
1.0	2°	5.00	5.30	5.50	5.80	6.10	0.012	0.20	0.11	0.017	0.08	0.08
1.0	5°	7.00	7.40	7.60	8.00	8.40	0.011	0.20	0.09	0.015	0.08	0.06
1.2	4°	1.80	2.10	2.20	2.40	2.70	0.016	0.24	0.18	0.022	0.09	0.12
1.2	3°	3.60	3.90	4.00	4.20	4.40	0.016	0.24	0.16	0.022	0.09	0.12
1.2	2°	6.00	6.40	6.50	6.90	7.20	0.014	0.24	0.13	0.020	0.09	0.10
1.2	5°	8.40	8.80	9.00	8.50	10.60	0.012	0.24	0.11	0.018	0.09	0.07

圆角微型立铣刀 Torus End Mill Micro

DSTMH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3E
DSTMH.150.010.015	1.5	0.1	2.25	2.25	-	4	50	2	20°	-°	▲
DSTMH.150.010.030	1.5	0.1	2.25	4.5	1.45	4	50	2	40°	20°	▲
DSTMH.150.010.050	1.5	0.1	2.25	7.5	1.45	4	50	2	40°	20°	▲
DSTMH.150.010.070	1.5	0.1	2.25	10.5	1.45	4	50	2	40°	20°	▲
DSTMH.150.020.015	1.5	0.2	2.25	2.25	-	4	50	2	20°	-°	▲
DSTMH.150.020.050	1.5	0.2	2.25	7.5	1.45	4	50	2	40°	20°	▲
DSTMH.150.020.070	1.5	0.2	2.25	10.5	1.45	4	50	2	40°	20°	▲
DSTMH.150.050.015	1.5	0.5	2.25	2.25	-	4	50	2	20°	-°	▲
DSTMH.150.050.030	1.5	0.5	2.25	4.5	1.45	4	50	2	40°	20°	▲
DSTMH.150.050.050	1.5	0.5	2.25	7.5	1.45	4	50	2	40°	20°	▲
DSTMH.200.010.015	2	0.1	3	3	-	4	50	2	20°	-°	▲
DSTMH.200.010.030	2	0.1	3	6	1.9	4	50	2	40°	20°	▲
DSTMH.200.010.050	2	0.1	3	10	1.9	4	50	2	40°	20°	▲
DSTMH.200.010.070	2	0.1	3	14	1.9	4	50	2	40°	20°	▲
DSTMH.200.020.015	2	0.2	3	3	-	4	50	2	20°	-°	▲
DSTMH.200.020.030	2	0.2	3	6	1.9	4	50	2	40°	20°	▲
DSTMH.200.020.050	2	0.2	3	10	1.9	4	50	2	40°	20°	▲
DSTMH.200.020.070	2	0.2	3	14	1.9	4	50	2	40°	20°	▲
DSTMH.200.050.015	2	0.5	3	3	-	4	50	2	20°	-°	▲
DSTMH.200.050.050	2	0.5	3	10	1.9	4	50	2	40°	20°	▲
DSTMH.200.050.070	2	0.5	3	14	1.9	4	50	2	40°	20°	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSTMH Ø 1.5 - 2 mm



Cutting Data DSTMH Ø 1.5 - 2 mm


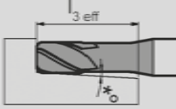




常规铣削 / Conventional milling

HSC 铣削 / HSC milling

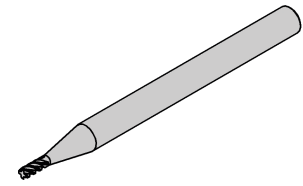
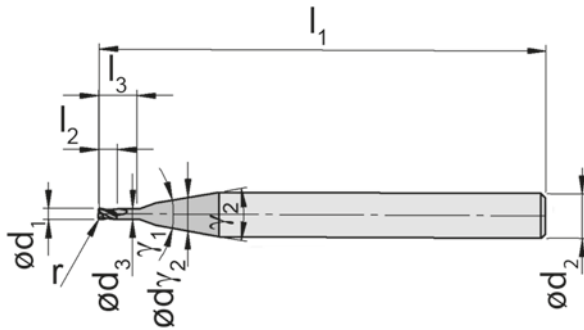
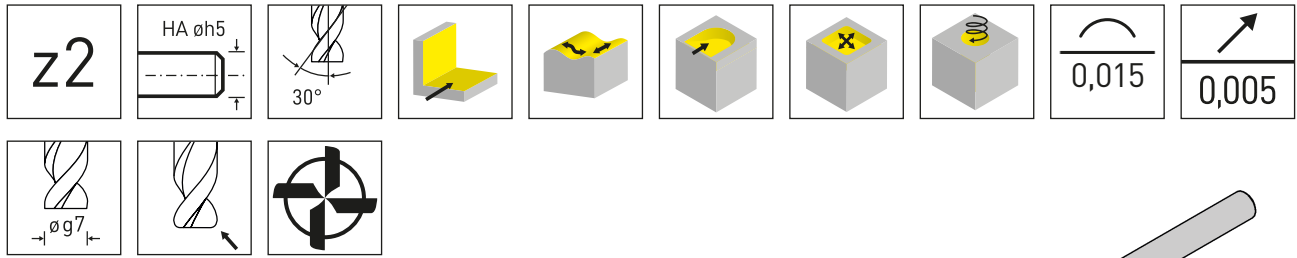
		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
1.5	5°	2.25	2.50	2.70	3.00	3.40	0.019	0.30	0.23	0.027	0.11	0.15
1.5	4°	4.50	4.80	4.90	5.20	5.50	0.019	0.30	0.20	0.027	0.11	0.15
1.5	3°	7.50	7.90	8.10	8.50	9.00	0.017	0.30	0.17	0.025	0.11	0.12
1.5	2°	10.50	11.00	11.20	11.80	13.10	0.015	0.30	0.14	0.022	0.11	0.09
1.5	5°	2.25	2.50	2.70	3.00	3.40	0.019	0.30	0.23	0.027	0.11	0.15
1.5	3°	7.50	7.90	8.10	8.50	9.00	0.017	0.30	0.17	0.025	0.11	0.12
1.5	2°	10.50	11.00	11.20	11.80	13.10	0.015	0.30	0.14	0.022	0.11	0.09
1.5	5°	2.25	2.50	2.60	2.90	3.20	0.019	0.30	0.23	0.027	0.11	0.15
1.5	4°	4.50	4.80	4.90	5.20	5.40	0.019	0.30	0.20	0.027	0.11	0.15
1.5	3°	7.50	7.90	8.10	8.50	8.90	0.017	0.30	0.17	0.025	0.11	0.12
2.0	5°	3.00	3.30	3.50	3.90	4.50	0.024	0.40	0.30	0.035	0.15	0.20
2.0	4°	6.00	6.40	6.60	6.90	7.30	0.024	0.40	0.26	0.035	0.15	0.20
2.0	3°	10.00	10.50	10.80	11.30	12.50	0.022	0.40	0.22	0.032	0.15	0.16
2.0	2°	14.00	14.60	15.00	16.00	18.20	0.020	0.40	0.18	0.028	0.15	0.12
2.0	5°	3.00	3.30	3.50	3.90	4.40	0.024	0.40	0.30	0.035	0.15	0.20
2.0	4°	6.00	6.40	6.60	6.90	7.30	0.024	0.40	0.26	0.035	0.15	0.20
2.0	3°	10.00	10.50	10.80	11.30	12.50	0.022	0.40	0.22	0.032	0.15	0.16
2.0	2°	14.00	14.60	15.00	15.90	18.20	0.020	0.40	0.18	0.028	0.15	0.12
2.0	5°	3.00	3.30	3.50	3.80	4.30	0.024	0.40	0.30	0.035	0.15	0.20
2.0	3°	10.00	10.50	10.80	11.30	12.30	0.022	0.40	0.22	0.032	0.15	0.16
2.0	2°	14.00	14.60	15.00	15.90	18.00	0.020	0.40	0.18	0.028	0.15	0.12

圆角微型立铣刀 Torus End Mill Micro

DSTMH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	TS3E
DSTMH.250.010.030	2.5	0.1	3.75	7.5	2.4	4	50	2	40°	20°	▲
DSTMH.250.010.050	2.5	0.1	3.75	12.5	2.4	4	50	2	40°	20°	▲
DSTMH.250.020.015	2.5	0.2	3.75	3.75	-	4	50	2	20°	-°	▲
DSTMH.250.020.030	2.5	0.2	3.75	7.5	2.4	4	50	2	40°	20°	▲
DSTMH.250.020.070	2.5	0.2	3.75	17.5	2.4	4	50	2	40°	20°	▲
DSTMH.250.050.030	2.5	0.5	3.75	7.5	2.4	4	50	2	40°	20°	▲
DSTMH.300.010.015	3	0.1	4.5	4.5	-	4	50	2	20°	-°	▲
DSTMH.300.010.030	3	0.1	4.5	9	2.9	4	50	2	40°	20°	▲
DSTMH.300.010.050	3	0.1	4.5	15	2.9	4	50	2	40°	20°	▲
DSTMH.300.010.070	3	0.1	4.5	21	2.9	4	60	2	40°	20°	▲
DSTMH.300.020.015	3	0.2	4.5	4.5	-	4	50	2	20°	-°	▲
DSTMH.300.020.030	3	0.2	4.5	9	2.9	4	50	2	40°	20°	▲
DSTMH.300.020.050	3	0.2	4.5	15	2.9	4	50	2	40°	20°	▲
DSTMH.300.050.015	3	0.5	4.5	4.5	-	4	50	2	20°	-°	▲
DSTMH.300.050.070	3	0.5	4.5	21	2.9	4	60	2	40°	20°	▲
DSTMH.300.100.030	3	1	4.5	9	2.9	4	50	2	40°	20°	▲
DSTMH.300.100.070	3	1	4.5	21	2.9	4	60	2	40°	20°	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSTMH Ø 2.5 - 3 mm



Cutting Data DSTMH Ø 2.5 - 3 mm


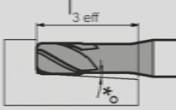




常规铣削 / Conventional milling

HSC 铣削 / HSC milling

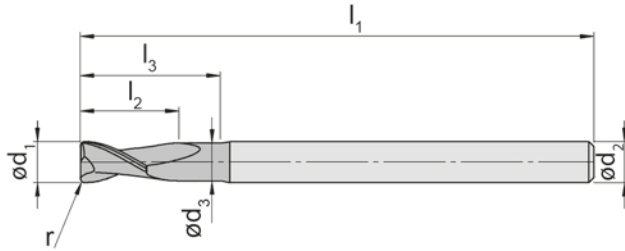
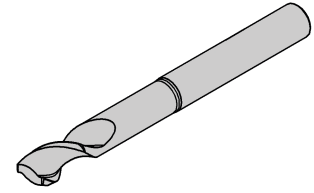
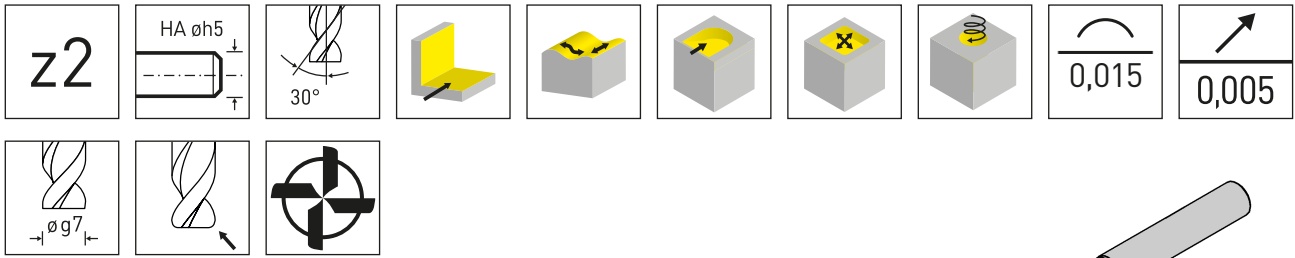
		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
2.5	4°	7.50	8.00	8.20	8.60	9.10	0.030	0.50	0.33	0.043	0.19	0.25
2.5	3°	12.50	13.10	13.40	14.10	∞	0.027	0.50	0.28	0.039	0.19	0.20
2.5	5°	3.75	4.10	4.30	4.80	5.50	0.030	0.50	0.38	0.043	0.19	0.25
2.5	4°	7.50	8.00	8.20	8.60	9.10	0.030	0.50	0.33	0.043	0.19	0.25
2.5	2°	17.50	18.20	18.70	20.30	∞	0.024	0.50	0.23	0.035	0.19	0.15
2.5	4°	7.50	8.00	8.10	8.60	9.00	0.030	0.50	0.33	0.043	0.19	0.25
3.0	5°	4.50	4.90	5.20	5.80	6.60	0.036	0.60	0.45	0.051	0.23	0.30
3.0	4°	9.00	9.50	9.70	10.60	∞	0.036	0.60	0.39	0.051	0.23	0.30
3.0	3°	15.00	15.70	16.10	∞	∞	0.032	0.60	0.33	0.046	0.23	0.24
3.0	2°	21.00	21.80	22.80	∞	∞	0.029	0.60	0.27	0.041	0.23	0.18
3.0	5°	4.50	4.90	5.20	5.80	6.60	0.036	0.60	0.45	0.051	0.23	0.30
3.0	4°	9.00	9.50	9.70	10.60	∞	0.036	0.60	0.39	0.051	0.23	0.30
3.0	3°	15.00	15.60	16.10	∞	∞	0.032	0.60	0.33	0.046	0.23	0.24
3.0	5°	4.50	4.90	5.10	5.70	6.40	0.036	0.60	0.45	0.051	0.23	0.30
3.0	2°	21.00	21.80	22.80	∞	∞	0.029	0.60	0.27	0.041	0.23	0.18
3.0	4°	9.00	9.50	9.70	10.40	∞	0.036	0.60	0.39	0.051	0.23	0.30
3.0	2°	21.00	21.80	22.70	∞	∞	0.029	0.60	0.27	0.041	0.23	0.18

环面立铣刀 Torus End Mill

DSTH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	TS3E
DSTH.2.040.020.015	4	0.2	6	6	-	6	64	2	20°	▲
DSTH.2.040.020.030	4	0.2	6	12	3.8	6	64	2	20°	▲
DSTH.2.040.020.050	4	0.2	6	20	3.8	6	64	2	20°	▲
DSTH.2.040.020.070	4	0.2	6	28	3.8	6	78	2	20°	▲
DSTH.2.040.050.070	4	0.5	6	28	3.8	6	78	2	20°	▲
DSTH.2.040.100.015	4	1	6	6	-	6	64	2	20°	▲
										P -
										M -
										K -
										N -
										S -
										H ●

切削参数 DSTH Ø 4 mm



Cutting Data DSTH Ø 4 mm






常规铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

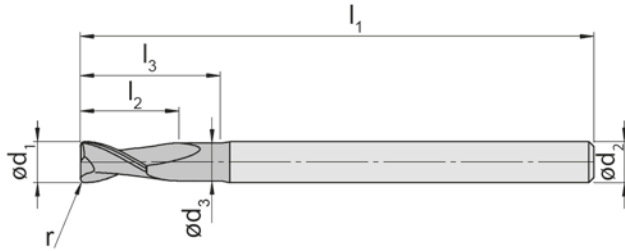
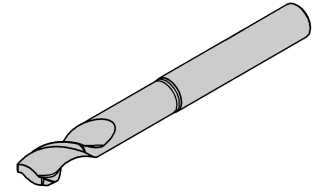
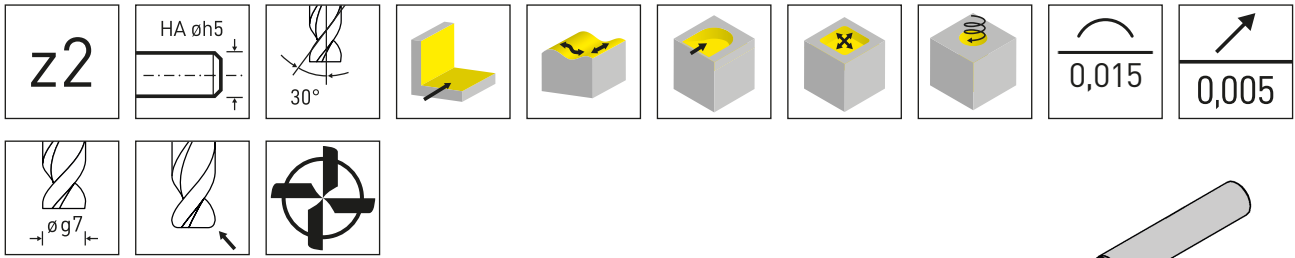
HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
4	5°	0.047	0.80	0.60	0.067	0.30	0.40
4	4°	0.047	0.80	0.52	0.067	0.30	0.40
4	3°	0.042	0.80	0.44	0.060	0.30	0.32
4	2°	0.037	0.80	0.36	0.054	0.30	0.24
4	2°	0.037	0.80	0.36	0.054	0.30	0.24
4	5°	0.047	0.80	0.60	0.067	0.30	0.40

环面立铣刀 Torus End Mill

DSTH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	TS3E
DSTH.2.050.020.015	5	0.2	7.5	7.5	-	6	64	2	20°	▲
DSTH.2.050.020.050	5	0.2	7.5	25	4.7	6	64	2	20°	▲
DSTH.2.050.020.070	5	0.2	7.5	35	4.7	6	78	2	20°	▲
DSTH.2.050.050.015	5	0.5	7.5	7.5	-	6	64	2	20°	▲
										P -
										M -
										K -
										N -
										S -
										H ●



切削参数 DSTH Ø 5 mm



Cutting Data DSTH Ø 5 mm

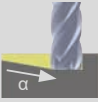




常规铣削 / Conventional milling

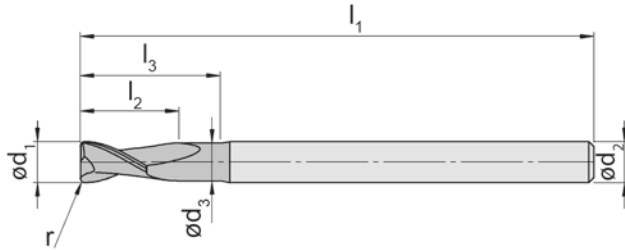
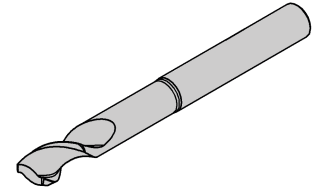
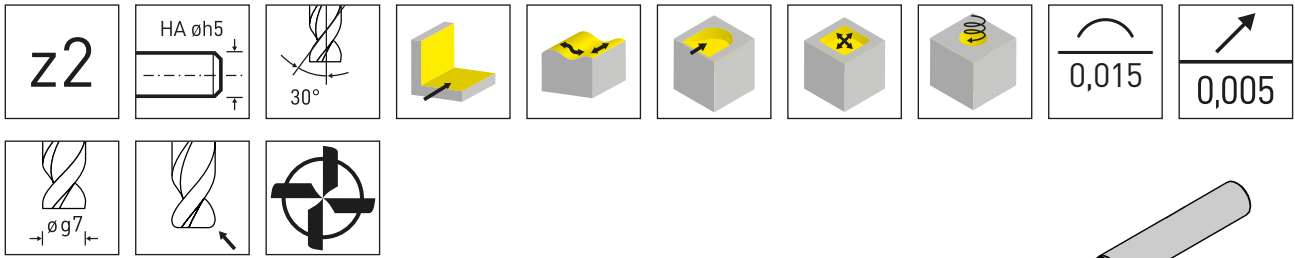
HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
5	5°	0.058	1.00	0.75	0.083	0.38	0.50
5	3°	0.052	1.00	0.55	0.075	0.38	0.40
5	2°	0.046	1.00	0.45	0.066	0.38	0.30
5	5°	0.058	1.00	0.75	0.083	0.38	0.50





硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d_1	r	l_2	l_3	d_3	d_2	l_1	Z	TS3E
DSTH.2.060.020.015	6	0.2	9	9	-	6	64	2	▲
DSTH.2.060.020.030	6	0.2	9	18	5.7	6	64	2	▲
DSTH.2.060.020.050	6	0.2	9	30	5.7	6	78	2	▲
DSTH.2.060.050.015	6	0.5	9	9	-	6	64	2	▲
DSTH.2.060.100.015	6	1	9	9	-	6	64	2	▲
DSTH.2.060.100.030	6	1	9	18	5.7	6	64	2	▲
DSTH.2.060.200.050	6	2	9	30	5.7	6	78	2	▲
									P -
									M -
									K -
									N -
									S -
									H ●

切削参数 DSTH Ø 6 mm



Cutting Data DSTH Ø 6 mm






常规铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

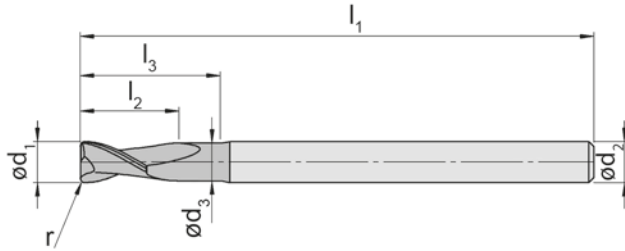
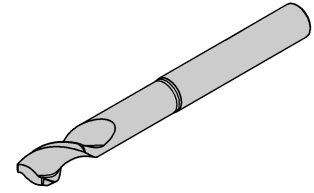
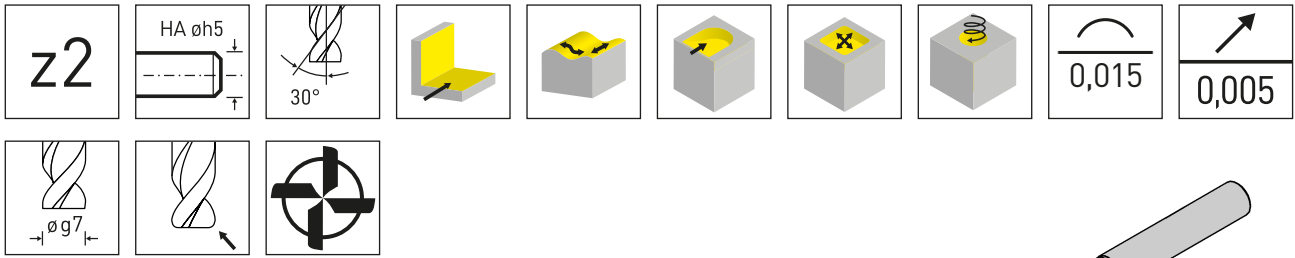
HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
6	5°	0.069	1.20	0.90	0.099	0.45	0.60
6	4°	0.069	1.20	0.78	0.099	0.45	0.60
6	3°	0.062	1.20	0.66	0.089	0.45	0.48
6	5°	0.069	1.20	0.90	0.099	0.45	0.60
6	5°	0.069	1.20	0.90	0.099	0.45	0.60
6	4°	0.069	1.20	0.78	0.099	0.45	0.60
6	3°	0.062	1.20	0.66	0.089	0.45	0.48

环面立铣刀 Torus End Mill

DSTH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TS3E
DSTH.2.080.050.070	8	0.5	12	56	7.6	8	100	2	▲
DSTH.2.080.100.030	8	1	12	24	7.6	8	64	2	▲
DSTH.2.080.100.070	8	1	12	56	7.6	8	100	2	▲
									P -
									M -
									K -
									N -
									S -
									H ●



切削参数 DSTH Ø 8 mm



Cutting Data DSTH Ø 8 mm






常规铣削 / Conventional milling

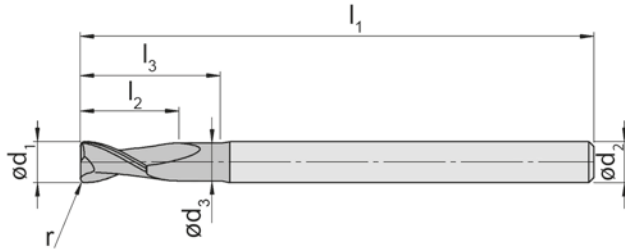
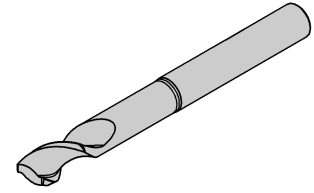
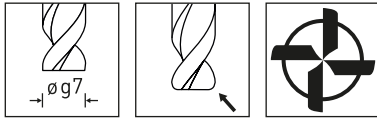
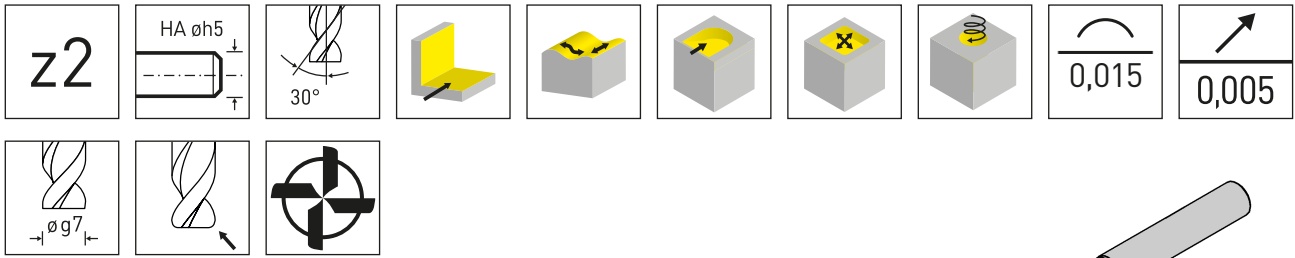
HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
8	2°	0.073	1.60	0.72	0.104	0.60	0.48
8	4°	0.092	1.60	1.04	0.130	0.60	0.80
8	2°	0.073	1.60	0.72	0.104	0.60	0.48





硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TS3E
DSTH.2.100.020.015	10	0.2	15	15	-	10	78	2	▲
DSTH.2.100.020.070	10	0.2	15	70	9.6	10	120	2	▲
DSTH.2.100.050.015	10	0.5	15	15	-	10	78	2	▲
DSTH.2.100.050.070	10	0.5	15	70	9.6	10	120	2	▲
DSTH.2.100.100.015	10	1	15	15	-	10	78	2	▲
DSTH.2.100.100.070	10	1	15	70	9.6	10	120	2	▲
DSTH.2.100.200.015	10	2	15	15	-	10	78	2	▲
									P -
									M -
									K -
									N -
									S -
									H ●

切削参数 DSTH Ø 10 mm



Cutting Data DSTH Ø 10 mm






常规铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

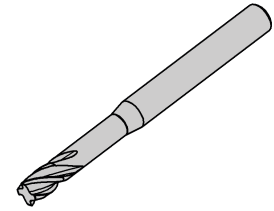
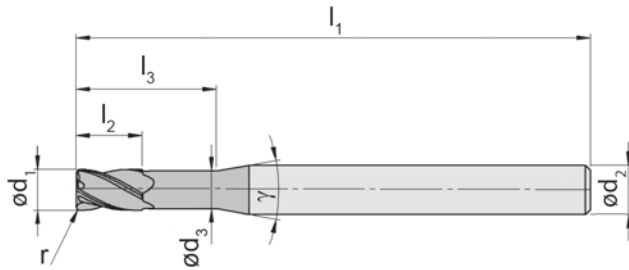
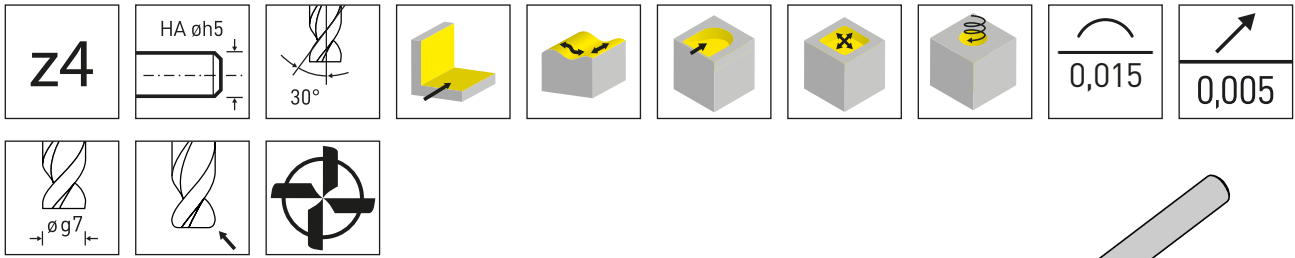
HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d_1							
	α	f_z	a_e	a_p	f_z	a_e	a_p
10	5°	0.114	2.00	1.50	0.162	0.75	1.00
10	2°	0.091	2.00	0.90	0.130	0.75	0.60
10	5°	0.114	2.00	1.50	0.162	0.75	1.00
10	2°	0.091	2.00	0.90	0.130	0.75	0.60
10	5°	0.114	2.00	1.50	0.162	0.75	1.00
10	2°	0.091	2.00	0.90	0.130	0.75	0.60
10	5°	0.114	2.00	1.50	0.162	0.75	1.00

环面立铣刀 Torus End Mill

DSTH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	TSSE
DSTH.4.040.020.015	4	0.2	6	6	-	6	64	4	20°	▲
DSTH.4.040.020.030	4	0.2	6	12	3.8	6	64	4	20°	▲
DSTH.4.040.020.050	4	0.2	6	20	3.8	6	64	4	20°	▲
DSTH.4.040.020.070	4	0.2	6	28	3.8	6	78	4	20°	▲
DSTH.4.040.050.015	4	0.5	6	6	-	6	64	4	20°	▲
DSTH.4.040.050.050	4	0.5	6	20	3.8	6	64	4	20°	▲
DSTH.4.040.050.070	4	0.5	6	28	3.8	6	78	4	20°	▲
DSTH.4.040.100.030	4	1	6	12	3.8	6	64	4	20°	▲
DSTH.4.040.100.050	4	1	6	20	3.8	6	64	4	20°	▲
DSTH.4.040.100.070	4	1	6	28	3.8	6	78	4	20°	▲
DSTH.4.050.020.015	5	0.2	7.5	7.5	-	6	64	4	20°	▲
DSTH.4.050.020.030	5	0.2	7.5	15	4.7	6	64	4	20°	▲
DSTH.4.050.020.050	5	0.2	7.5	25	4.7	6	64	4	20°	▲
DSTH.4.050.020.070	5	0.2	7.5	35	4.7	6	78	4	20°	▲
DSTH.4.050.050.030	5	0.5	7.5	15	4.7	6	64	4	20°	▲
DSTH.4.050.050.050	5	0.5	7.5	25	4.7	6	64	4	20°	▲
DSTH.4.050.050.070	5	0.5	7.5	35	4.7	6	78	4	20°	▲
DSTH.4.050.100.030	5	1	7.5	15	4.7	6	64	4	20°	▲
DSTH.4.050.100.070	5	1	7.5	35	4.7	6	78	4	20°	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSTH Ø 4 - 5 mm



Cutting Data DSTH Ø 4 - 5 mm

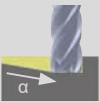




常规铣削 / Conventional milling

HSC 铣削 / HSC milling

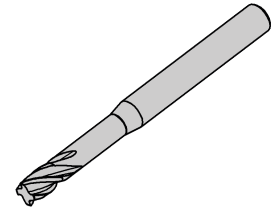
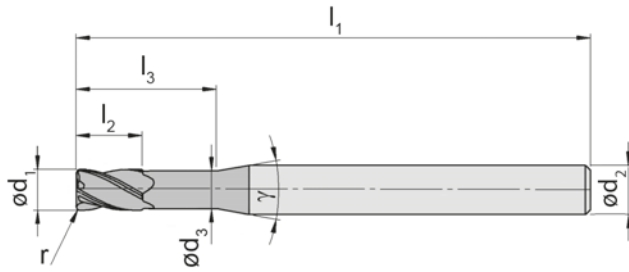
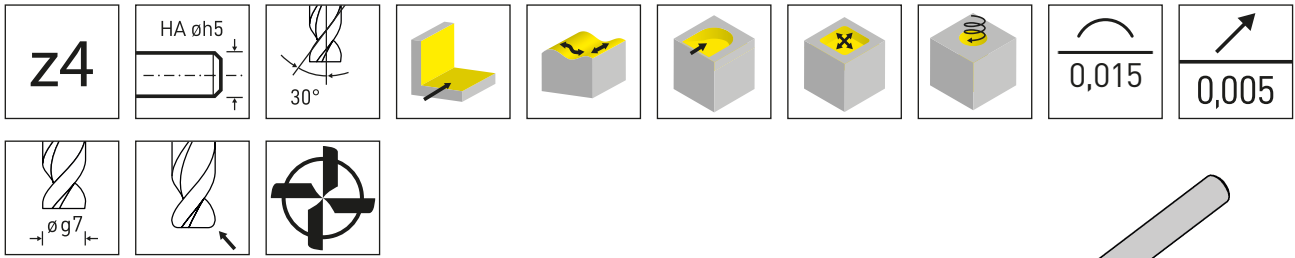
		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
4	5°	0.019	0.80	0.60	0.022	0.30	0.40
4	4°	0.019	0.80	0.52	0.022	0.30	0.40
4	3°	0.017	0.80	0.44	0.020	0.30	0.32
4	2°	0.015	0.80	0.36	0.018	0.30	0.24
4	5°	0.019	0.80	0.60	0.022	0.30	0.40
4	3°	0.017	0.80	0.44	0.020	0.30	0.32
4	2°	0.015	0.80	0.36	0.018	0.30	0.24
4	4°	0.019	0.80	0.52	0.022	0.30	0.40
4	3°	0.017	0.80	0.44	0.020	0.30	0.32
4	2°	0.015	0.80	0.36	0.018	0.30	0.24
5	5°	0.030	1.00	0.75	0.038	0.38	0.50
5	4°	0.030	1.00	0.65	0.038	0.38	0.50
5	3°	0.027	1.00	0.55	0.034	0.38	0.40
5	2°	0.024	1.00	0.45	0.030	0.38	0.30
5	4°	0.030	1.00	0.65	0.038	0.38	0.50
5	3°	0.027	1.00	0.55	0.034	0.38	0.40
5	2°	0.024	1.00	0.45	0.030	0.38	0.30
5	4°	0.030	1.00	0.65	0.038	0.38	0.50
5	2°	0.024	1.00	0.45	0.030	0.38	0.30

环面立铣刀 Torus End Mill

DSTH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TS3E
DSTH.4.060.020.015	6	0.2	9	9	-	6	64	4	▲
DSTH.4.060.020.030	6	0.2	9	18	5.7	6	64	4	▲
DSTH.4.060.020.050	6	0.2	9	30	5.7	6	78	4	▲
DSTH.4.060.050.015	6	0.5	9	9	-	6	64	4	▲
DSTH.4.060.050.030	6	0.5	9	18	5.7	6	64	4	▲
DSTH.4.060.050.050	6	0.5	9	30	5.7	6	78	4	▲
DSTH.4.060.050.070	6	0.5	9	42	5.7	6	78	4	▲
DSTH.4.060.100.015	6	1	9	9	-	6	64	4	▲
DSTH.4.060.100.030	6	1	9	18	5.7	6	64	4	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSTH Ø 6 mm



Cutting Data DSTH Ø 6 mm






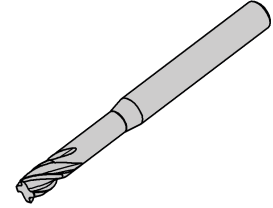
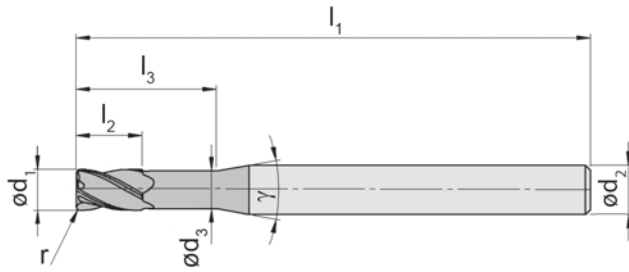
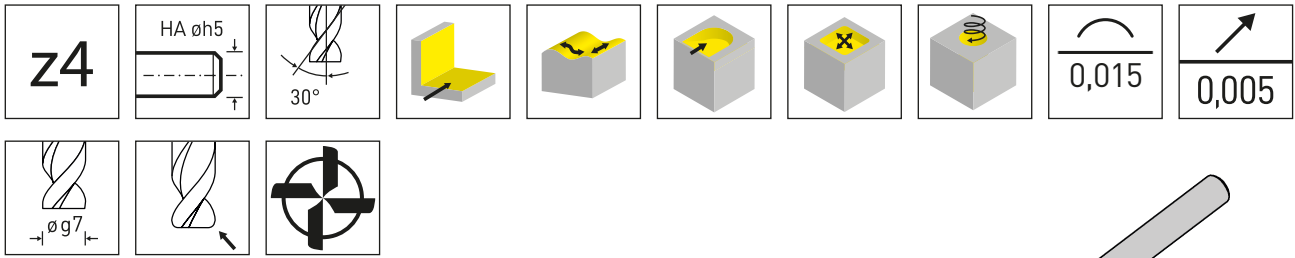
常规铣削 / Conventional milling

HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
6	5°	0.040	1.20	0.90	0.053	0.45	0.60
6	4°	0.040	1.20	0.78	0.053	0.45	0.60
6	3°	0.036	1.20	0.66	0.048	0.45	0.48
6	5°	0.040	1.20	0.90	0.053	0.45	0.60
6	4°	0.040	1.20	0.78	0.053	0.45	0.60
6	3°	0.036	1.20	0.66	0.048	0.45	0.48
6	2°	0.032	1.20	0.54	0.042	0.45	0.36
6	5°	0.040	1.20	0.90	0.053	0.45	0.60
6	4°	0.040	1.20	0.78	0.053	0.45	0.60



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TS3E
DSTH.4.080.020.015	8	0.2	12	12	-	8	64	4	▲
DSTH.4.080.020.030	8	0.2	12	24	7.6	8	64	4	▲
DSTH.4.080.020.050	8	0.2	12	40	7.6	8	78	4	▲
DSTH.4.080.050.015	8	0.5	12	12	-	8	64	4	▲
DSTH.4.080.050.030	8	0.5	12	24	7.6	8	64	4	▲
DSTH.4.080.050.050	8	0.5	12	40	7.6	8	78	4	▲
DSTH.4.080.100.030	8	1	12	24	7.6	8	64	4	▲
DSTH.4.080.100.050	8	1	12	40	7.6	8	78	4	▲
DSTH.4.080.200.015	8	2	12	12	-	8	64	4	▲
DSTH.4.080.200.030	8	2	12	24	7.6	8	64	4	▲
DSTH.4.080.200.050	8	2	12	40	7.6	8	78	4	▲
DSTH.4.080.200.070	8	2	12	56	7.6	8	100	4	▲

P	-
M	-
K	-
N	-
S	-
H	●



切削参数 DSTH Ø 8 mm



Cutting Data DSTH Ø 8 mm






常规铣削 / Conventional milling

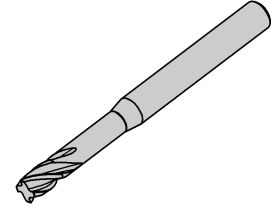
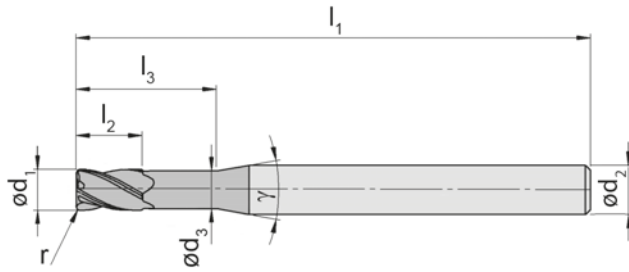
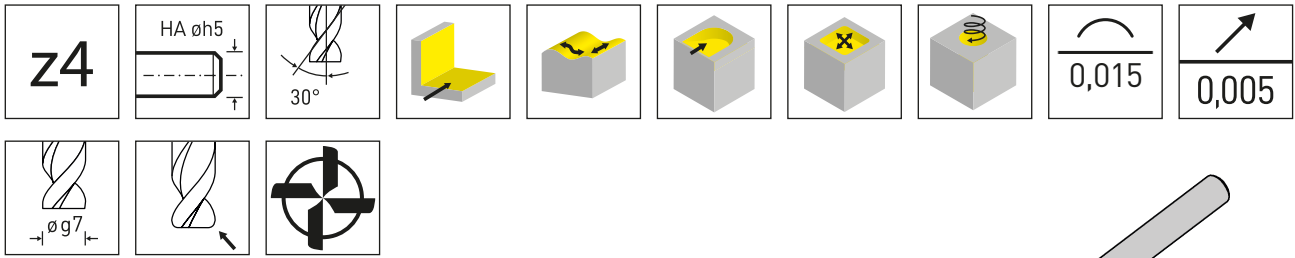
HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
8	5°	0.060	1.60	1.20	0.083	0.60	0.80
8	4°	0.060	1.60	1.04	0.083	0.60	0.80
8	3°	0.054	1.60	0.88	0.075	0.60	0.64
8	5°	0.060	1.60	1.20	0.083	0.60	0.80
8	4°	0.060	1.60	1.04	0.083	0.60	0.80
8	3°	0.054	1.60	0.88	0.075	0.60	0.64
8	4°	0.060	1.60	1.04	0.083	0.60	0.80
8	3°	0.054	1.60	0.88	0.075	0.60	0.64
8	5°	0.060	1.60	1.20	0.083	0.60	0.80
8	4°	0.060	1.60	1.04	0.083	0.60	0.80
8	3°	0.054	1.60	0.88	0.075	0.60	0.64
8	2°	0.048	1.60	0.72	0.067	0.60	0.48





硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TS3E
DSTH.4.100.020.015	10	0.2	15	15	-	10	78	4	▲
DSTH.4.100.020.030	10	0.2	15	30	9.6	10	78	4	▲
DSTH.4.100.020.050	10	0.2	15	50	9.6	10	100	4	▲
DSTH.4.100.050.015	10	0.5	15	15	-	10	78	4	▲
DSTH.4.100.050.030	10	0.5	15	30	9.6	10	78	4	▲
DSTH.4.100.050.050	10	0.5	15	50	9.6	10	100	4	▲
DSTH.4.100.100.015	10	1	15	15	-	10	78	4	▲
DSTH.4.100.100.030	10	1	15	30	9.6	10	78	4	▲
DSTH.4.100.200.015	10	2	15	15	-	10	78	4	▲
DSTH.4.100.200.030	10	2	15	30	9.6	10	78	4	▲
									P -
									M -
									K -
									N -
									S -
									H ●



切削参数 DSTH Ø 10 mm



Cutting Data DSTH Ø 10 mm






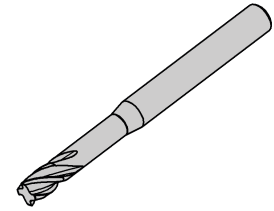
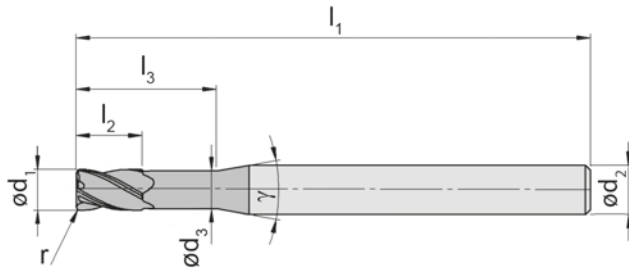
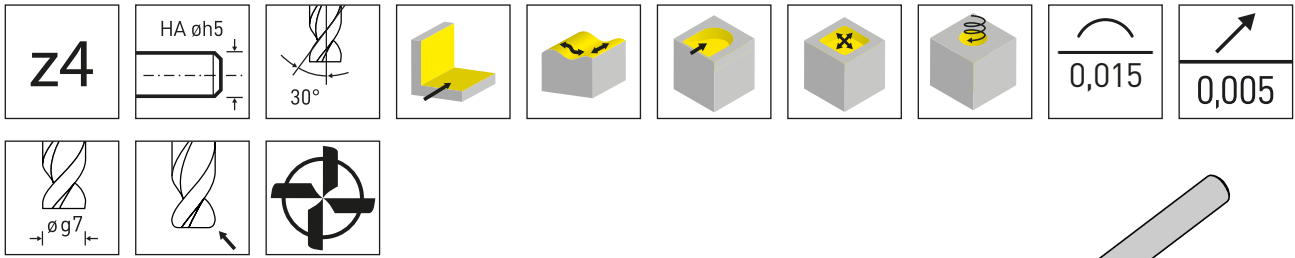
常规铣削 / Conventional milling

HSC 铣削 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
10	5°	0.080	2.00	1.50	0.114	0.75	1.00
10	4°	0.080	2.00	1.30	0.114	0.75	1.00
10	3°	0.072	2.00	1.10	0.102	0.75	0.80
10	5°	0.080	2.00	1.50	0.114	0.75	1.00
10	4°	0.080	2.00	1.30	0.114	0.75	1.00
10	3°	0.072	2.00	1.10	0.102	0.75	0.80
10	5°	0.080	2.00	1.50	0.114	0.75	1.00
10	4°	0.080	2.00	1.30	0.114	0.75	1.00
10	5°	0.080	2.00	1.50	0.114	0.75	1.00
10	4°	0.080	2.00	1.30	0.114	0.75	1.00



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TS3E
DSTH.4.120.020.015	12	0.2	18	18	-	12	78	4	▲
DSTH.4.120.020.030	12	0.2	18	36	11.6	12	100	4	▲
DSTH.4.120.050.015	12	0.5	18	18	-	12	78	4	▲
DSTH.4.120.050.050	12	0.5	18	60	11.6	12	120	4	▲
DSTH.4.120.050.070	12	0.5	18	84	11.6	12	140	4	▲
DSTH.4.120.100.015	12	1	18	18	-	12	78	4	▲
DSTH.4.120.100.030	12	1	18	36	11.6	12	100	4	▲
DSTH.4.120.200.030	12	2	18	36	11.6	12	100	4	▲
DSTH.4.120.200.050	12	2	18	60	11.6	12	120	4	▲
DSTH.4.120.200.070	12	2	18	84	11.6	12	140	4	▲



P	-
M	-
K	-
N	-
S	-
H	●

切削参数 DSTH Ø 12 mm



Cutting Data DSTH Ø 12 mm






常规铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	110	140
H1.2	100	130
H1.3	70	100
H1.4	50	80

HSC 铣削 / HSC milling

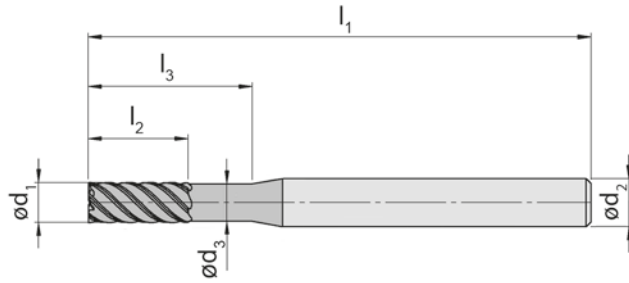
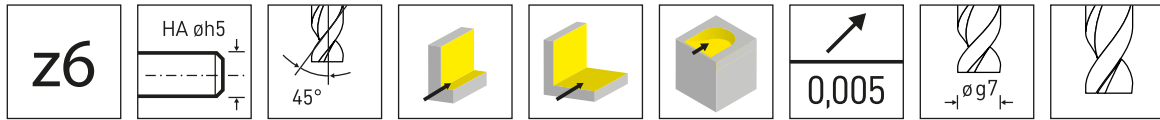
		
	vc = m/min	vc = m/min
H1.1	160	190
H1.2	150	180
H1.3	120	150
H1.4	100	130

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
12	5°	0.101	2.40	1.80	0.144	0.90	1.20
12	4°	0.101	2.40	1.56	0.144	0.90	1.20
12	5°	0.101	2.40	1.80	0.144	0.90	1.20
12	3°	0.091	2.40	1.32	0.130	0.90	0.96
12	2°	0.081	2.40	1.08	0.115	0.90	0.72
12	5°	0.101	2.40	1.80	0.144	0.90	1.20
12	4°	0.101	2.40	1.56	0.144	0.90	1.20
12	4°	0.101	2.40	1.56	0.144	0.90	1.20
12	3°	0.091	2.40	1.32	0.130	0.90	0.96
12	2°	0.081	2.40	1.08	0.115	0.90	0.72

多刃立铣刀

End Mill multiple fluted

DSMH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	TS3E
DSMH.6.03.040	3	7.5	12	2.86	6	64	6	20°	▲
DSMH.6.04.040	4	10	16	3.8	6	64	6	20°	▲
DSMH.6.05.040	5	12.5	20	4.7	6	64	6	20°	▲
DSMH.6.06.040	6	15	24	5.7	6	64	6	-°	▲
DSMH.6.08.040	8	20	32	7.6	8	78	6	-°	▲
DSMH.6.10.040	10	25	40	9.4	10	78	6	-°	▲
DSMH.6.12.040	12	30	48	11.4	12	100	6	-°	▲
DSMH.6.16.040	16	40	64	15.4	16	120	6	-°	▲
									P -
									M -
									K -
									N -
									S -
									H ●




切削参数 DSMH Ø 3 - 16 mm

Cutting Data DSMH Ø 3 - 16 mm



常规铣削 / Conventional milling

	 vc = m/min	 vc = m/min
H1.1	110	130
H1.2	100	120
H1.3	70	90
H1.4	50	70

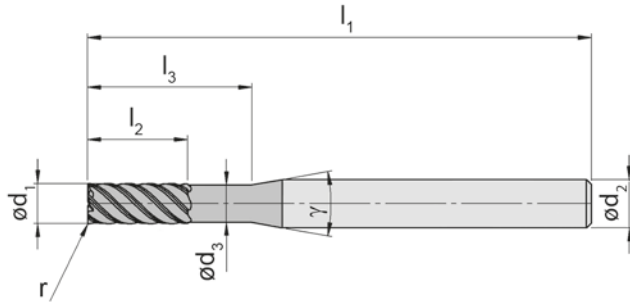
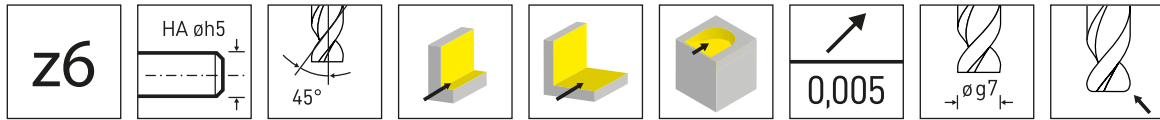
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
3	2°	0.009	0.30	6.00	0.009	0.06	6.00
4	2°	0.016	0.40	8.00	0.019	0.08	8.00
5	2°	0.022	0.50	10.00	0.029	0.10	10.00
6	2°	0.028	0.60	12.00	0.039	0.12	12.00
8	2°	0.041	0.80	16.00	0.059	0.16	16.00
10	2°	0.054	1.00	20.00	0.080	0.20	20.00
12	2°	0.066	1.20	24.00	0.100	0.24	24.00
16	2°	0.092	1.60	32.00	0.140	0.32	32.00



多刃立铣刀

End Mill multiple fluted

DSMRH



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	TS3E
DSMRH.6.03.020.040	3	0.2	7.5	12	2.86	6	64	6	20°	▲
DSMRH.6.03.100.040	3	1	7.5	12	2.86	6	64	6	20°	▲
DSMRH.6.04.020.040	4	0.2	10	16	3.8	6	64	6	20°	▲
DSMRH.6.04.100.040	4	1	10	16	3.8	6	64	6	20°	▲
DSMRH.6.05.020.040	5	0.2	12.5	20	4.7	6	64	6	20°	▲
DSMRH.6.05.050.040	5	0.5	12.5	20	4.7	6	64	6	20°	▲
DSMRH.6.05.100.040	5	1	12.5	20	4.7	6	64	6	20°	▲
DSMRH.6.06.020.040	6	0.2	15	24	5.7	6	64	6	-°	▲
DSMRH.6.06.050.040	6	0.5	15	24	5.7	6	64	6	-°	▲
DSMRH.6.06.100.040	6	1	15	24	5.7	6	64	6	-°	▲
DSMRH.6.08.020.040	8	0.2	20	32	7.6	8	78	6	-°	▲
DSMRH.6.08.050.040	8	0.5	20	32	7.6	8	78	6	-°	▲
DSMRH.6.08.100.040	8	1	20	32	7.6	8	78	6	-°	▲
DSMRH.6.10.020.040	10	0.2	25	40	9.4	10	78	6	-°	▲
DSMRH.6.10.050.040	10	0.5	25	40	9.4	10	78	6	-°	▲
DSMRH.6.10.100.040	10	1	25	40	9.4	10	78	6	-°	▲
DSMRH.6.12.020.040	12	0.2	30	48	11.4	12	100	6	-°	▲
DSMRH.6.12.050.040	12	0.5	30	48	11.4	12	100	6	-°	▲
DSMRH.6.12.100.040	12	1	30	48	11.4	12	100	6	-°	▲
DSMRH.6.12.200.040	12	2	30	48	11.4	12	100	6	-°	▲



P	-
M	-
K	-
N	-
S	-
H	●




切削参数 DSMRH Ø 3 - 12 mm

Cutting Data DSMH Ø 3 - 12 mm



常规铣削 / Conventional milling

	 vc = m/min	 vc = m/min
H1.1	110	130
H1.2	100	120
H1.3	70	90
H1.4	50	70

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
3	2°	0.009	0.30	6.00	0.009	0.06	6.00
3	2°	0.009	0.30	6.00	0.009	0.06	6.00
4	2°	0.016	0.40	8.00	0.019	0.08	8.00
4	2°	0.016	0.40	8.00	0.019	0.08	8.00
5	2°	0.022	0.50	10.00	0.029	0.10	10.00
5	2°	0.022	0.50	10.00	0.029	0.10	10.00
5	2°	0.022	0.50	10.00	0.029	0.10	10.00
6	2°	0.028	0.60	12.00	0.039	0.12	12.00
6	2°	0.028	0.60	12.00	0.039	0.12	12.00
6	2°	0.028	0.60	12.00	0.039	0.12	12.00
8	2°	0.041	0.80	16.00	0.059	0.16	16.00
8	2°	0.041	0.80	16.00	0.059	0.16	16.00
8	2°	0.041	0.80	16.00	0.059	0.16	16.00
10	2°	0.054	1.00	20.00	0.080	0.20	20.00
10	2°	0.054	1.00	20.00	0.080	0.20	20.00
10	2°	0.054	1.00	20.00	0.080	0.20	20.00
12	2°	0.066	1.20	24.00	0.100	0.24	24.00
12	2°	0.066	1.20	24.00	0.100	0.24	24.00
12	2°	0.066	1.20	24.00	0.100	0.24	24.00
12	2°	0.066	1.20	24.00	0.100	0.24	24.00



整体硬质合金立铣刀

Solid Carbide End Mills



DSKC

圆头立铣刀
Ball Nose End Mill

Ø 1 - Ø 16

Z2-Z7 156 - 157



DSKC

220°球头立铣刀
Ball Nose End Mill 220°

Ø 3 - Ø 12

Z2-Z7 158 - 159



DSTC

圆角立铣刀
Torus End Mill

Ø 1.5 - Ø 12

Z2-Z5 160 - 161



DSMRC

多刃立铣刀
End Mill multiple fluted

Ø 3 - Ø 16

Z2-Z5 162 - 163

D

DS



整体硬质合金立铣刀

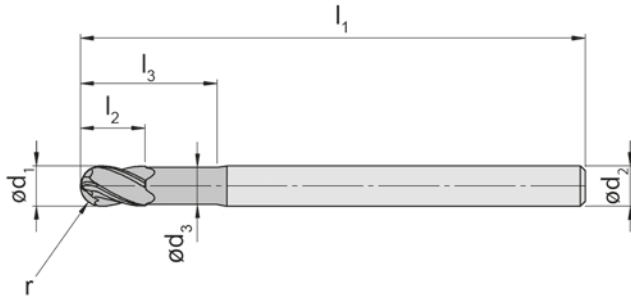
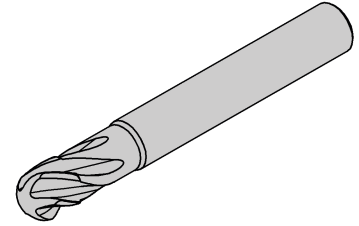
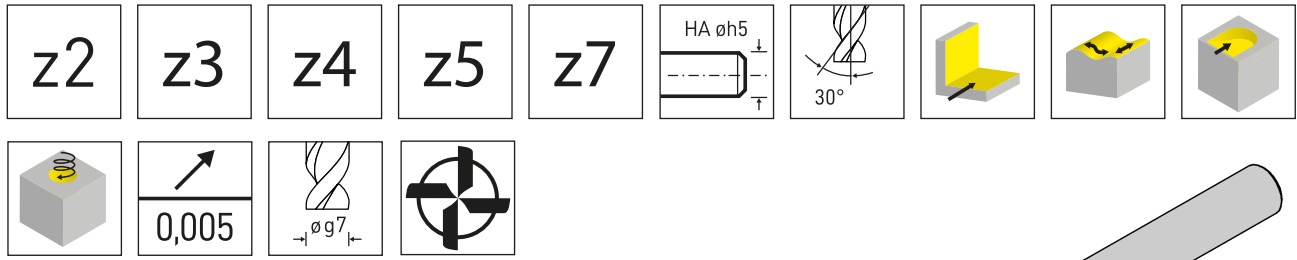
设计用于：
- 钴铬合金钢

Solid Carbide End Mills

designed for:
- Cobalt Chromium Steels

球头立铣刀 Ball Nose End Mill

DSKC



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TSCC
DSKC.2.010.063.06	1	0.5	2	3	0.9	6	63	2	▲
DSKC.2.015.063.06	1.5	0.75	2	4.5	1.4	6	63	2	▲
DSKC.2.020.063.06	2	1	3	5	1.9	6	63	2	▲
DSKC.2.020.077.06	2	1	3	8	1.9	6	77	2	▲
DSKC.2.030.063.06	3	1.5	4	7.5	2.9	6	63	2	▲
DSKC.2.030.077.06	3	1.5	4	12	2.9	6	77	2	▲
DSKC.3.040.063.06	4	2	5	10	3.8	6	63	3	▲
DSKC.3.040.077.06	4	2	5	16	3.8	6	77	3	▲
DSKC.4.050.063.06	5	2.5	5	12.5	4.7	6	63	4	▲
DSKC.4.050.077.06	5	2.5	5	20	4.7	6	77	4	▲
DSKC.4.060.063.06	6	3	6	15	5.6	6	63	4	▲
DSKC.4.060.077.06	6	3	6	24	5.6	6	77	4	▲
DSKC.4.060.099.08	6	3	6	36	5.6	8	99	4	▲
DSKC.5.080.063.08	8	4	8	20	7.4	8	63	5	▲
DSKC.5.080.077.08	8	4	8	32	7.4	8	77	5	▲
DSKC.5.080.099.08	8	4	8	48	7.4	8	99	5	△
DSKC.5.100.077.10	10	5	10	25	9.4	10	77	5	▲
DSKC.5.100.099.10	10	5	10	40	9.4	10	99	5	△
DSKC.7.120.077.12	12	6	12	30	11.4	12	77	7	▲
DSKC.7.120.099.12	12	6	12	48	11.4	12	99	7	▲
DSKC.7.160.099.16	16	8	20	50	15.4	16	99	7	△




P	-
M	-
K	-
N	-
S	●
H	○

切削参数 DSKC Ø 1 - 16 mm

Cutting Data DSKC Ø 1 - 16 mm



	 vc = m/min	 vc = m/min
S1.1	80	100
S1.2	70	90
S2.1	50	70
S2.2	40	60
S3.1	-	-
S3.2	-	-
S3.3	80	100
H1.1	120	150
H1.2	100	130

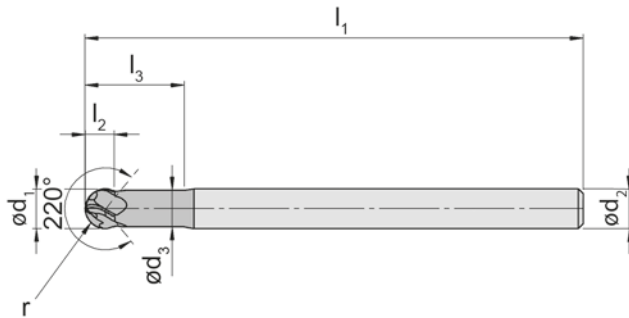
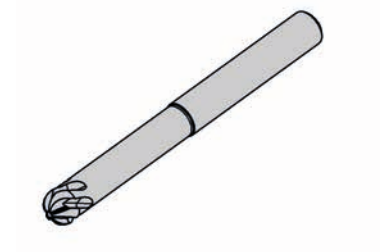
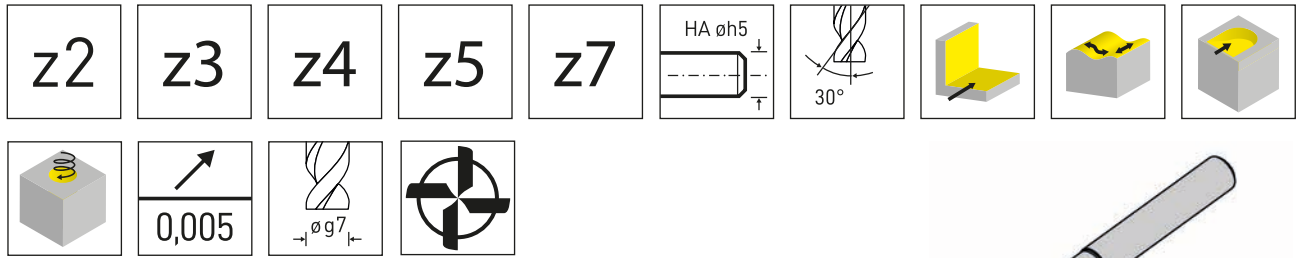
d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
1.0	5°	0.011	0.20	0.50	0.017	0.05	0.10
1.5	5°	0.013	0.30	0.75	0.022	0.08	0.15
2.0	5°	0.015	0.40	1.00	0.026	0.10	0.20
2.0	5°	0.015	0.40	1.00	0.026	0.10	0.20
3.0	5°	0.020	0.60	1.50	0.035	0.15	0.30
3.0	5°	0.020	0.60	1.50	0.035	0.15	0.30
4.0	5°	0.018	0.80	2.00	0.032	0.20	0.40
4.0	5°	0.018	0.80	2.00	0.032	0.20	0.40
5.0	4°	0.020	1.00	2.50	0.035	0.25	0.50
5.0	4°	0.020	1.00	2.50	0.035	0.25	0.50
6.0	4°	0.024	1.20	3.00	0.044	0.30	0.60
6.0	4°	0.024	1.20	3.00	0.044	0.30	0.60
6.0	4°	0.024	1.20	3.00	0.044	0.30	0.60
8.0	3°	0.032	1.60	4.00	0.059	0.40	0.80
8.0	3°	0.032	1.60	4.00	0.059	0.40	0.80
8.0	3°	0.032	1.60	4.00	0.059	0.40	0.80
10.0	3°	0.041	2.00	5.00	0.077	0.50	1.00
10.0	3°	0.041	2.00	5.00	0.077	0.50	1.00
12.0	3°	0.048	2.40	6.00	0.091	0.60	1.20
12.0	3°	0.048	2.40	6.00	0.091	0.60	1.20
16.0	3°	0.065	3.20	8.00	0.126	0.80	1.60

D

220°球头立铣刀

Ball Nose End Mill 220°

DSKC



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TSCC
DSKC.2.030.063.06.2	3	1.5	2	15	2.8	6	63	2	▲
DSKC.3.040.063.06.2	4	2	2.6	20	3.75	6	63	3	▲
DSKC.4.050.063.06.2	5	2.5	3.3	25	4.7	6	63	4	▲
DSKC.4.060.063.06.2	6	3	4	30	5.65	6	63	4	▲
DSKC.5.080.088.08.2	8	4	5.3	40	7.5	8	88	5	▲
DSKC.5.100.101.10.2	10	5	6.7	50	9.4	10	101	5	▲
DSKC.7.120.119.12.2	12	6	8	60	11.3	12	119	7	▲
									P -
									M -
									K -
									N -
									S ●
									H ○

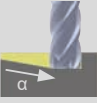


D

切削参数 DSKC Ø 3 - 12 mm

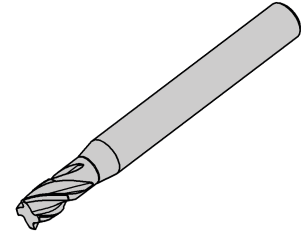
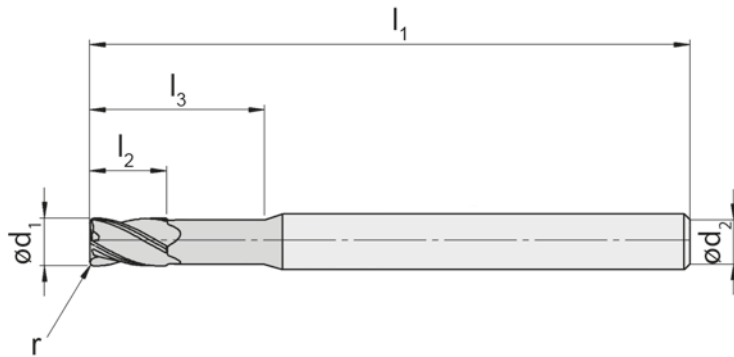
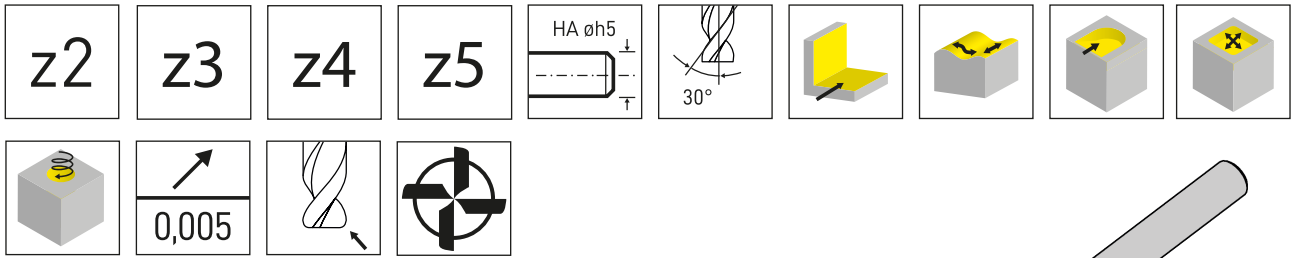
Cutting Data DSKC Ø 3 - 12 mm



	 vc = m/min	 vc = m/min
S1.1	80	100
S1.2	70	90
S2.1	50	70
S2.2	40	60
S3.1	-	-
S3.2	-	-
S3.3	80	100
H1.1	120	150
H1.2	100	130

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
3	5°	0.015	0.60	1.50	0.026	0.15	0.30
4	5°	0.014	0.80	2.00	0.023	0.20	0.40
5	4°	0.015	1.00	2.50	0.027	0.25	0.50
6	4°	0.020	1.20	3.00	0.035	0.30	0.60
8	3°	0.027	1.60	4.00	0.050	0.40	0.80
10	3°	0.036	2.00	5.00	0.068	0.50	1.00
12	3°	0.043	2.40	6.00	0.082	0.60	1.20

D



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TSCC
DSTC.2.15.01.055.06	1.5	0.1	2.5	5.5	1.4	6	55	2	▲
DSTC.2.02.02.055.06	2	0.2	3	5.5	1.9	6	55	2	▲
DSTC.2.03.02.055.06	3	0.2	4	7.5	2.9	6	55	2	▲
DSTC.2.03.05.055.06	3	0.5	4	7.5	2.9	6	55	2	▲
DSTC.3.04.02.055.06	4	0.2	5	8.5	3.8	6	55	3	▲
DSTC.3.04.05.055.06	4	0.5	5	8.5	3.8	6	55	3	▲
DSTC.4.05.02.055.06	5	0.2	6	12.5	4.7	6	55	4	▲
DSTC.4.05.05.055.06	5	0.5	6	12.5	4.7	6	55	4	▲
DSTC.4.06.02.055.06	6	0.2	6	15.5	5.6	6	55	4	▲
DSTC.4.06.05.055.06	6	0.5	6	15.5	5.6	6	55	4	▲
DSTC.4.06.10.055.06	6	1	6	15.5	5.6	6	55	4	▲
DSTC.5.08.02.063.08	8	0.2	10	20.5	7.4	8	63	5	▲
DSTC.5.08.05.063.08	8	0.5	10	20.5	7.4	8	63	5	▲
DSTC.5.08.10.063.08	8	1	10	20.5	7.4	8	63	5	▲
DSTC.5.08.15.063.08	8	1.5	10	20.5	7.4	8	63	5	▲
DSTC.5.10.02.077.10	10	0.2	15	25.5	9.4	10	77	5	▲
DSTC.5.10.05.077.10	10	0.5	15	25.5	9.4	10	77	5	▲
DSTC.5.10.10.077.10	10	1	15	25.5	9.4	10	77	5	▲
DSTC.5.10.15.077.10	10	1.5	15	25.5	9.4	10	77	5	▲
DSTC.5.12.02.077.12	12	0.2	18	30.5	11.4	12	77	5	▲
DSTC.5.12.05.077.12	12	0.5	18	30.5	11.4	12	77	5	▲
DSTC.5.12.10.077.12	12	1	18	30.5	11.4	12	77	5	▲
DSTC.5.12.15.077.12	12	1.5	18	30.5	11.4	12	77	5	▲
DSTC.5.12.20.077.12	12	2	18	30.5	11.4	12	77	5	▲




P	-
M	-
K	-
N	-
S	•
H	o

切削参数 DSTC Ø 1.5 - 12 mm

Cutting Data DSTC Ø 1.5 - 12 mm



	 vc = m/min	 vc = m/min
S1.1	80	100
S1.2	70	90
S2.1	50	70
S2.2	40	60
S3.1	-	-
S3.2	-	-
S3.3	80	100
H1.1	110	140
H1.2	90	120

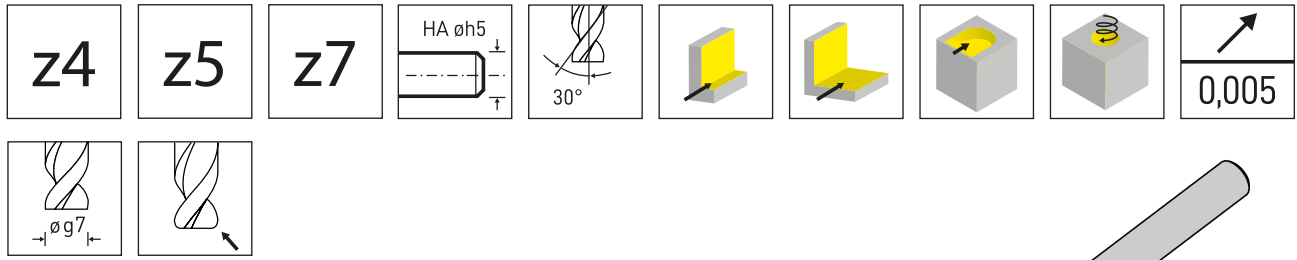
d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
1.5	5°	0.014	0.30	1.50	0.019	0.08	0.15
2.0	5°	0.017	0.40	2.00	0.025	0.10	0.20
3.0	5°	0.023	0.60	3.00	0.038	0.15	0.30
3.0	5°	0.023	0.60	3.00	0.038	0.15	0.30
4.0	5°	0.024	0.80	4.00	0.039	0.20	0.40
4.0	5°	0.024	0.80	4.00	0.039	0.20	0.40
5.0	4°	0.027	1.00	5.00	0.046	0.25	0.50
5.0	4°	0.027	1.00	5.00	0.046	0.25	0.50
6.0	4°	0.034	1.20	6.00	0.058	0.30	0.60
6.0	4°	0.034	1.20	6.00	0.058	0.30	0.60
6.0	4°	0.034	1.20	6.00	0.058	0.30	0.60
8.0	3°	0.045	1.60	8.00	0.080	0.40	0.80
8.0	3°	0.045	1.60	8.00	0.080	0.40	0.80
8.0	3°	0.045	1.60	8.00	0.080	0.40	0.80
8.0	3°	0.045	1.60	8.00	0.080	0.40	0.80
10.0	3°	0.057	2.00	10.00	0.106	0.50	1.00
10.0	3°	0.057	2.00	10.00	0.106	0.50	1.00
10.0	3°	0.057	2.00	10.00	0.106	0.50	1.00
10.0	3°	0.057	2.00	10.00	0.106	0.50	1.00
12.0	3°	0.070	2.40	12.00	0.132	0.60	1.20
12.0	3°	0.070	2.40	12.00	0.132	0.60	1.20
12.0	3°	0.070	2.40	12.00	0.132	0.60	1.20
12.0	3°	0.070	2.40	12.00	0.132	0.60	1.20

D

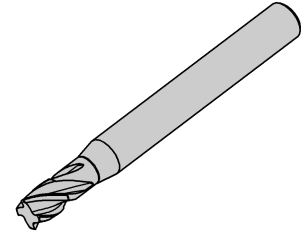
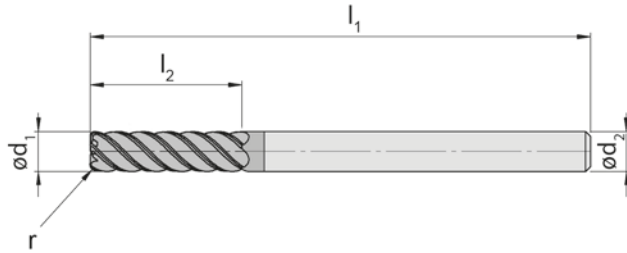
多刃立铣刀

End Mill multiple fluted

DSMRC



D



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TSCC
DSMRC.4.03.55.06.02	3	0.2	9.5	9.5	-	6	55	4	▲
DSMRC.4.03.55.06.3S	3	0.3	3	9.5	2.9	6	55	4	▲
DSMRC.4.04.55.06.02	4	0.2	12.5	12.5	-	6	55	4	▲
DSMRC.4.04.55.06.3S	4	0.3	4	12.5	3.9	6	55	4	▲
DSMRC.4.05.55.06.02	5	0.2	15.5	15.5	-	6	55	4	▲
DSMRC.4.05.55.06.5S	5	0.5	5	15.5	4.8	6	55	4	▲
DSMRC.5.06.63.06.02	6	0.2	18.5	18.5	-	6	63	5	▲
DSMRC.5.06.63.06.5S	6	0.5	6	18.5	5.8	6	63	5	▲
DSMRC.5.08.63.08.10	8	1	24.5	24.5	-	8	63	5	▲
DSMRC.5.08.63.08.5S	8	0.5	8	24.5	7.8	8	63	5	▲
DSMRC.5.10.77.10.10	10	1	30.5	30.5	-	10	77	5	▲
DSMRC.5.10.77.10.5S	10	0.5	10	30.5	9.8	10	77	5	▲
DSMRC.7.12.88.12.10	12	1	36.5	36.5	-	12	88	7	▲
DSMRC.7.12.88.12.2S	12	0.2	12	36.5	11.8	12	88	7	▲
DSMRC.7.16.99.16.05	16	0.5	48.5	48.5	-	16	99	7	▲
DSMRC.7.16.99.16.20	16	2	48.5	48.5	-	16	99	7	▲




P	-
M	-
K	-
N	-
S	●
H	○

切削参数 DSMRC Ø 3 - 16 mm

Cutting Data DSTC Ø 3 - 16 mm



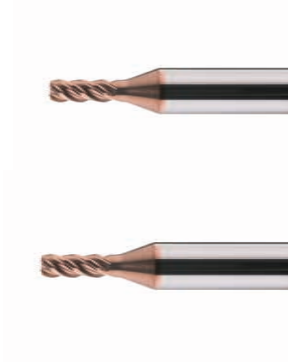
	 vc = m/min	 vc = m/min
S1.1	70	90
S1.2	60	80
S2.1	40	60
S2.2	35	55
S3.1	-	-
S3.2	-	-
S3.3	70	90
H1.1	110	140
H1.2	90	120

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
3	3°	0.010	0.45	9.00	0.013	0.15	0.30
3	3°	0.010	0.45	3.00	0.013	0.15	0.30
4	3°	0.015	0.60	12.00	0.022	0.20	0.40
4	3°	0.015	0.60	4.00	0.022	0.20	0.40
5	3°	0.020	0.75	15.00	0.031	0.25	0.50
5	3°	0.020	0.75	5.00	0.031	0.25	0.50
6	3°	0.024	0.90	18.00	0.036	0.30	0.60
6	3°	0.024	0.90	6.00	0.036	0.30	0.60
8	3°	0.034	1.20	24.00	0.054	0.40	0.80
8	3°	0.034	1.20	8.00	0.054	0.40	0.80
10	3°	0.044	1.50	30.00	0.072	0.50	1.00
10	3°	0.044	1.50	10.00	0.072	0.50	1.00
12	3°	0.052	1.80	36.00	0.086	0.60	1.20
12	3°	0.052	1.80	12.00	0.086	0.60	1.20
16	3°	0.073	2.40	48.00	0.122	0.80	1.60
16	3°	0.073	2.40	48.00	0.122	0.80	1.60

D

整体硬质合金立铣刀

Solid Carbide End Mills



DSRV.4	立铣刀 End Mill	Ø 2 - Ø 20	Z4	166 - 177
DSRV.5	立铣刀 End Mill	Ø 2 - Ø 20	Z5	178 - 189

E

DS



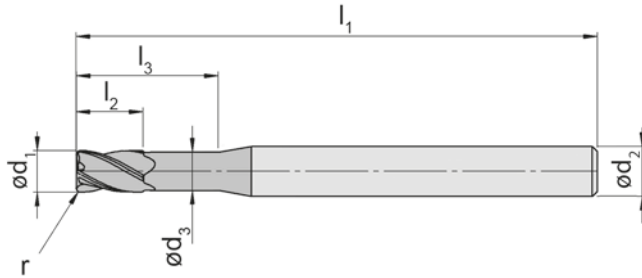
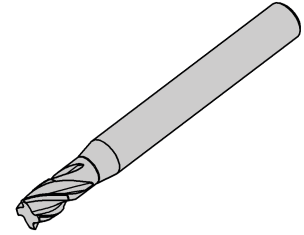
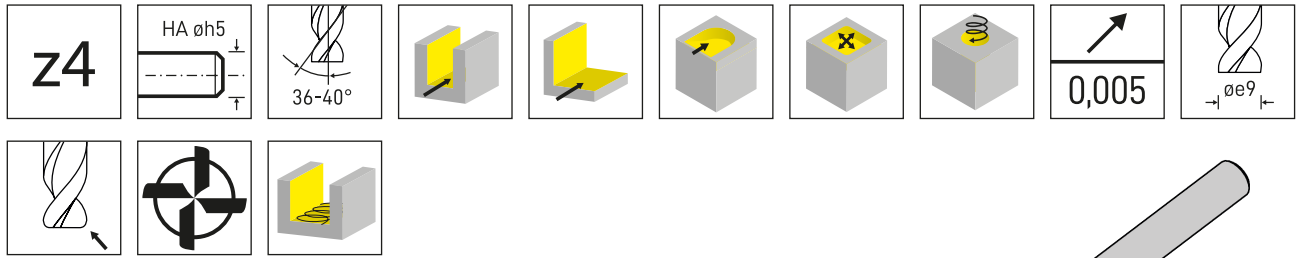
E

整体硬质合金立铣刀

设计用于:
- 钛合金

Solid Carbide End Mills

designed for:
- Titan



E

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks




产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	形式 Form	IG3I
DSRV.4.020.010.20	2	0.1	3	4	1.9	6	50	4	40°	HA	▲
DSRV.4.020.010.30	2	0.1	5	6	1.9	6	50	4	40°	HA	▲
DSRV.4.020.020.20	2	0.2	3	4	1.9	6	50	4	40°	HA	▲
DSRV.4.020.020.30	2	0.2	5	6	1.9	6	50	4	40°	HA	▲
DSRV.4.030.010.20	3	0.1	5	6	2.85	6	50	4	40°	HA	▲
DSRV.4.030.010.30	3	0.1	7	9	2.85	6	50	4	40°	HA	▲
DSRV.4.030.020.20	3	0.2	5	6	2.85	6	50	4	40°	HA	▲
DSRV.4.030.020.30	3	0.2	7	9	2.85	6	50	4	40°	HA	▲
DSRV.4.030.050.20	3	0.5	5	6	2.85	6	50	4	40°	HA	▲
DSRV.4.030.050.30	3	0.5	7	9	2.85	6	50	4	40°	HA	▲
DSRV.4.040.010.20	4	0.1	6	8	3.8	6	50	4	40°	HA	▲
DSRV.4.040.010.30	4	0.1	9	12	3.8	6	57	4	40°	HA	▲
DSRV.4.040.020.20	4	0.2	6	8	3.8	6	50	4	40°	HA	▲
DSRV.4.040.020.30	4	0.2	9	12	3.8	6	57	4	40°	HA	▲
DSRV.4.040.050.20	4	0.5	6	8	3.8	6	50	4	40°	HA	▲
DSRV.4.040.050.30	4	0.5	9	12	3.8	6	57	4	40°	HA	▲
DSRV.4.050.010.20	5	0.1	8	10	4.75	6	50	4	40°	HA	▲
DSRV.4.050.010.30	5	0.1	11	15	4.75	6	57	4	40°	HA	▲
DSRV.4.050.020.20	5	0.2	8	10	4.75	6	50	4	40°	HA	▲
DSRV.4.050.020.30	5	0.2	11	15	4.75	6	57	4	40°	HA	▲
DSRV.4.050.050.20	5	0.5	8	10	4.75	6	50	4	40°	HA	▲
DSRV.4.050.050.30	5	0.5	8	10	4.75	6	50	4	40°	HA	▲
DSRV.4.050.100.20	5	1	8	10	4.75	6	50	4	40°	HA	▲
DSRV.4.050.100.30	5	1	11	15	4.75	6	57	4	40°	HA	▲

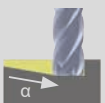



P	o
M	•
K	-
N	-
S	•
H	-

切削参数 DSRV Ø 2 - 5 mm

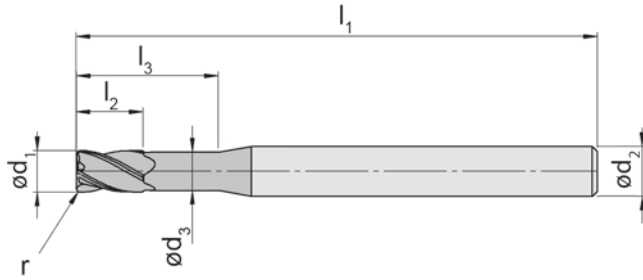
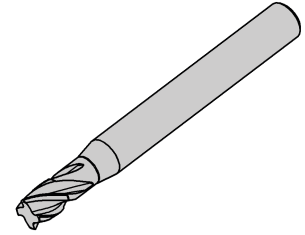
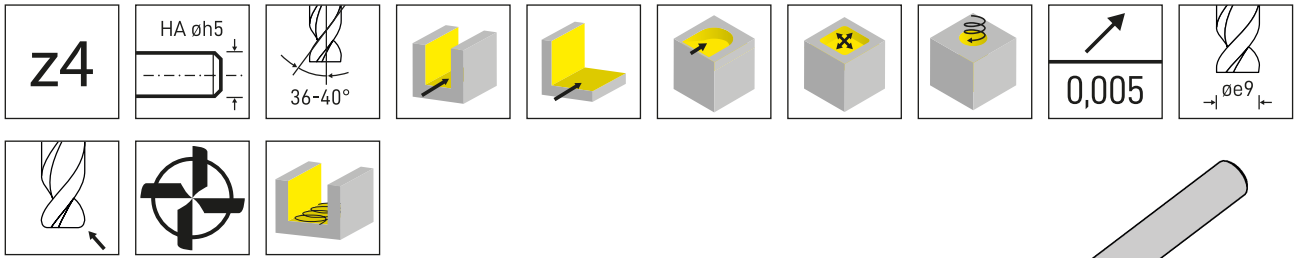
Cutting Data DSRV Ø 2 - 5 mm



	 vc = m/min	 vc = m/min	 vc = m/min
M1.1	90	120	140
M1.2	80	110	130
M1.3	70	100	120
S1.1	60	80	100
S1.2	50	70	90
S2.1	40	60	80
S2.2	35	55	75
S3.1	70	90	110
S3.2	60	80	100
S3.3	50	70	90

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
2	5°	0.008	2.00	2.00	0.009	0.40	3.00	0.038	0.10	3.00
2	5°	0.007	2.00	2.00	0.008	0.40	4.00	0.040	0.10	4.00
2	5°	0.008	2.00	2.00	0.009	0.40	3.00	0.045	0.10	3.00
2	5°	0.007	2.00	2.00	0.008	0.40	4.00	0.040	0.10	4.00
3	5°	0.012	3.00	3.00	0.016	0.60	4.50	0.066	0.15	4.50
3	5°	0.010	3.00	3.00	0.014	0.60	6.00	0.059	0.15	6.00
3	5°	0.012	3.00	3.00	0.016	0.60	4.50	0.066	0.15	4.50
3	5°	0.010	3.00	3.00	0.014	0.60	6.00	0.059	0.15	6.00
3	5°	0.012	3.00	3.00	0.016	0.60	4.50	0.066	0.15	4.50
3	5°	0.010	3.00	3.00	0.014	0.60	6.00	0.059	0.15	6.00
4	5°	0.016	4.00	4.00	0.022	0.80	6.00	0.087	0.20	6.00
4	5°	0.013	4.00	4.00	0.020	0.80	8.00	0.079	0.20	8.00
4	5°	0.016	4.00	4.00	0.022	0.80	6.00	0.087	0.20	6.00
4	5°	0.013	4.00	4.00	0.020	0.80	8.00	0.079	0.20	8.00
4	5°	0.016	4.00	4.00	0.022	0.80	6.00	0.087	0.20	6.00
4	5°	0.013	4.00	4.00	0.020	0.80	8.00	0.079	0.20	8.00
5	5°	0.020	5.00	5.00	0.029	1.00	7.50	0.109	0.25	7.50
5	5°	0.016	5.00	5.00	0.026	1.00	10.00	0.098	0.25	10.00
5	5°	0.020	5.00	5.00	0.029	1.00	7.50	0.109	0.25	7.50
5	5°	0.016	5.00	5.00	0.026	1.00	10.00	0.098	0.25	10.00
5	5°	0.020	5.00	5.00	0.029	1.00	7.50	0.109	0.25	7.50
5	5°	0.016	5.00	5.00	0.026	1.00	10.00	0.098	0.25	10.00
5	5°	0.020	5.00	5.00	0.029	1.00	7.50	0.109	0.25	7.50
5	5°	0.016	5.00	5.00	0.026	1.00	10.00	0.098	0.25	10.00

E



E

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks




产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	IG3I
DSRV.4.060.010.20	6	0.1	9	12	5.7	6	50	4	HA	▲
DSRV.4.060.010.30	6	0.1	13	18	5.7	6	57	4	HA	▲
DSRV.4.060.020.20	6	0.2	9	12	5.7	6	50	4	HA	▲
DSRV.4.060.020.30	6	0.2	13	18	5.7	6	57	4	HA	▲
DSRV.4.060.050.20	6	0.5	9	12	5.7	6	50	4	HA	▲
DSRV.4.060.050.30	6	0.5	13	18	5.7	6	57	4	HA	▲
DSRV.4.060.100.20	6	1	9	12	5.7	6	50	4	HA	▲
DSRV.4.060.100.30	6	1	13	18	5.7	6	57	4	HA	▲
DSRV.4.080.010.20	8	0.1	12	16	7.6	8	58	4	HA	▲
DSRV.4.080.010.30	8	0.1	17	24	7.6	8	63	4	HA	▲
DSRV.4.080.020.20	8	0.2	12	16	7.6	8	58	4	HA	▲
DSRV.4.080.020.30	8	0.2	17	24	7.6	8	63	4	HA	▲
DSRV.4.080.050.20	8	0.5	12	16	7.6	8	58	4	HA	▲
DSRV.4.080.050.30	8	0.5	17	24	7.6	8	63	4	HA	▲
DSRV.4.080.100.20	8	1	12	16	7.6	8	58	4	HA	▲
DSRV.4.080.100.30	8	1	17	24	7.6	8	63	4	HA	▲
DSRV.4.080.150.20	8	1.5	12	16	7.6	8	58	4	HA	▲
DSRV.4.080.150.30	8	1.5	17	24	7.6	8	63	4	HA	▲





P	o
M	•
K	-
N	-
S	•
H	-

切削参数 DSRV Ø 6 - 8 mm

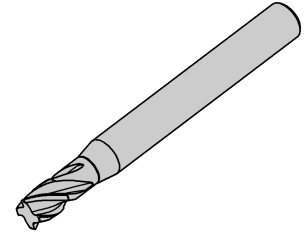
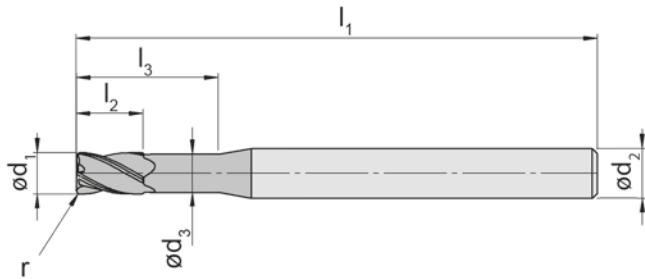
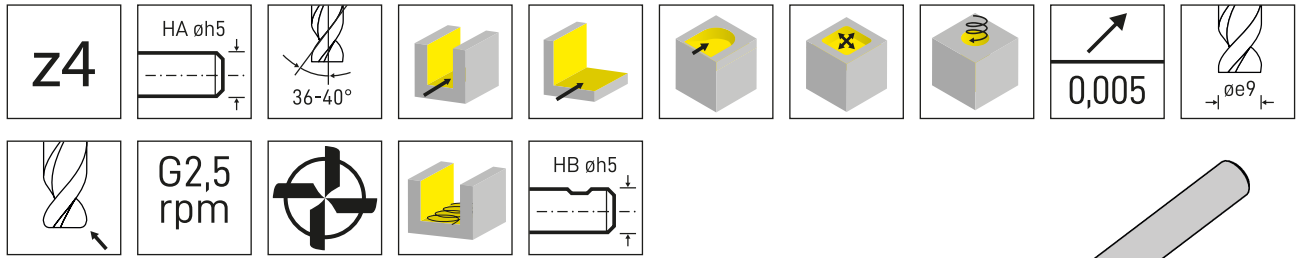
Cutting Data DSRV Ø 6 - 8 mm



	 vc = m/min	 vc = m/min	 vc = m/min
M1.1	90	120	140
M1.2	80	110	130
M1.3	70	100	120
S1.1	60	80	100
S1.2	50	70	90
S2.1	40	60	80
S2.2	35	55	75
S3.1	70	90	110
S3.2	60	80	100
S3.3	50	70	90

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
6	5°	0.024	6.00	6.00	0.035	1.20	9.00	0.130	0.30	9.00
6	5°	0.020	6.00	6.00	0.031	1.20	12.00	0.117	0.30	12.00
6	5°	0.024	6.00	6.00	0.035	1.20	9.00	0.130	0.30	9.00
6	5°	0.020	6.00	6.00	0.031	1.20	12.00	0.117	0.30	12.00
6	5°	0.024	6.00	6.00	0.035	1.20	9.00	0.130	0.30	9.00
6	5°	0.020	6.00	6.00	0.031	1.20	12.00	0.117	0.30	12.00
6	5°	0.024	6.00	6.00	0.035	1.20	9.00	0.130	0.30	9.00
6	5°	0.020	6.00	6.00	0.031	1.20	12.00	0.117	0.30	12.00
8	5°	0.032	8.00	8.00	0.048	1.60	12.00	0.172	0.40	12.00
8	5°	0.026	8.00	8.00	0.043	1.60	16.00	0.155	0.40	16.00
8	5°	0.032	8.00	8.00	0.048	1.60	12.00	0.172	0.40	12.00
8	5°	0.026	8.00	8.00	0.043	1.60	16.00	0.155	0.40	16.00
8	5°	0.032	8.00	8.00	0.048	1.60	12.00	0.172	0.40	12.00
8	5°	0.026	8.00	8.00	0.043	1.60	16.00	0.155	0.40	16.00
8	5°	0.032	8.00	8.00	0.048	1.60	12.00	0.172	0.40	12.00
8	5°	0.026	8.00	8.00	0.043	1.60	16.00	0.155	0.40	16.00
8	5°	0.032	8.00	8.00	0.048	1.60	12.00	0.172	0.40	12.00
8	5°	0.026	8.00	8.00	0.043	1.60	16.00	0.155	0.40	16.00

E



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

E




产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	IC31
DSRV.4.100.010.20	10	0.1	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.010.20B	10	0.1	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.010.30	10	0.1	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.010.30B	10	0.1	21	30	9.5	10	72	4	HB	▲
DSRV.4.100.020.20	10	0.2	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.020.20B	10	0.2	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.020.30	10	0.2	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.020.30B	10	0.2	21	30	9.5	10	72	4	HB	▲
DSRV.4.100.050.20	10	0.5	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.050.20B	10	0.5	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.050.30	10	0.5	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.050.30B	10	0.5	21	30	9.5	10	72	4	HB	▲
DSRV.4.100.100.20	10	1	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.100.20B	10	1	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.100.30	10	1	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.100.30B	10	1	21	30	9.5	10	72	4	HB	▲
DSRV.4.100.150.20	10	1.5	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.150.20B	10	1.5	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.150.30	10	1.5	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.150.30B	10	1.5	21	30	9.5	10	72	4	HB	▲
DSRV.4.100.200.20	10	2	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.200.20B	10	2	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.200.30	10	2	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.200.30B	10	2	21	30	9.5	10	72	4	HB	▲
DSRV.4.100.250.20	10	2.5	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.250.20B	10	2.5	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.250.30	10	2.5	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.250.30B	10	2.5	21	30	9.5	10	72	4	HB	▲
DSRV.4.100.300.20	10	3	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.300.20B	10	3	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.300.30	10	3	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.300.30B	10	3	21	30	9.5	10	72	4	HB	▲

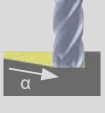



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S	●
H	-

切削参数 DSRV Ø 10 mm

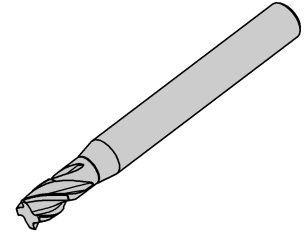
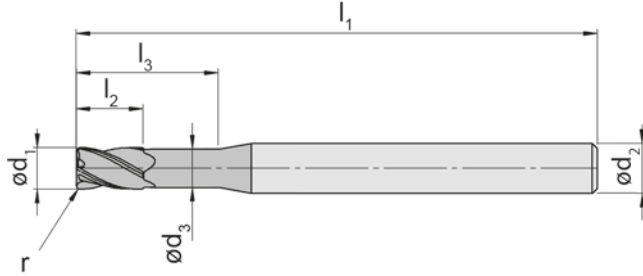
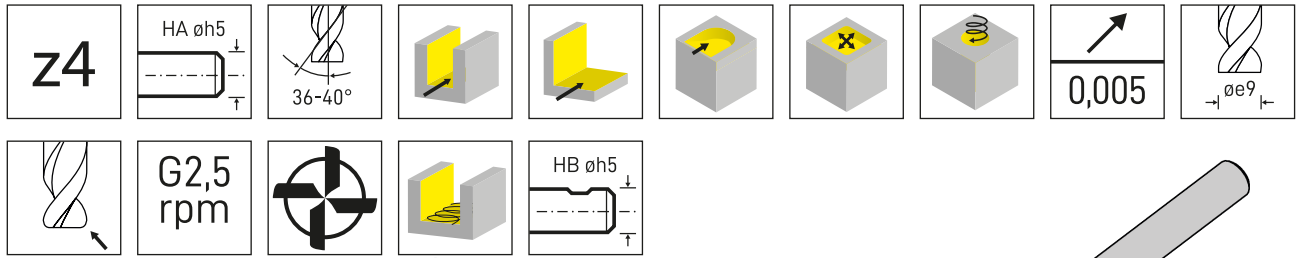
Cutting Data DSRV Ø 10 mm



	 vc = m/min	 vc = m/min	 vc = m/min
M1.1	90	120	140
M1.2	80	110	130
M1.3	70	100	120
S1.1	60	80	100
S1.2	50	70	90
S2.1	40	60	80
S2.2	35	55	75
S3.1	70	90	110
S3.2	60	80	100
S3.3	50	70	90

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00

E



E

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks




产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	IG3I
DSRV.4.120.020.20	12	0.2	18	24	11.4	12	73	4	HA	▲
DSRV.4.120.020.20B	12	0.2	18	24	11.4	12	73	4	HB	▲
DSRV.4.120.020.30	12	0.2	26	36	11.4	12	83	4	HA	▲
DSRV.4.120.020.30B	12	0.2	26	36	11.4	12	83	4	HB	▲
DSRV.4.120.050.20	12	0.5	18	24	11.4	12	73	4	HA	▲
DSRV.4.120.050.20B	12	0.5	18	24	11.4	12	73	4	HB	▲
DSRV.4.120.050.30	12	0.5	26	36	11.4	12	83	4	HA	▲
DSRV.4.120.050.30B	12	0.5	26	36	11.4	12	83	4	HB	▲
DSRV.4.120.100.20	12	1	18	24	11.4	12	73	4	HA	▲
DSRV.4.120.100.20B	12	1	18	24	11.4	12	73	4	HB	▲
DSRV.4.120.100.30	12	1	26	36	11.4	12	83	4	HA	▲
DSRV.4.120.100.30B	12	1	26	36	11.4	12	83	4	HB	▲
DSRV.4.120.150.20	12	1.5	18	24	11.4	12	73	4	HA	▲
DSRV.4.120.150.20B	12	1.5	18	24	11.4	12	73	4	HB	▲
DSRV.4.120.150.30	12	1.5	26	36	11.4	12	83	4	HA	▲
DSRV.4.120.150.30B	12	1.5	26	36	11.4	12	83	4	HB	▲
DSRV.4.120.200.20	12	2	18	24	11.4	12	73	4	HA	▲
DSRV.4.120.200.20B	12	2	18	24	11.4	12	73	4	HB	▲
DSRV.4.120.200.30	12	2	26	36	11.4	12	83	4	HA	▲
DSRV.4.120.200.30B	12	2	26	36	11.4	12	83	4	HB	▲
DSRV.4.120.250.20	12	2.5	18	24	11.4	12	73	4	HA	▲
DSRV.4.120.250.20B	12	2.5	18	24	11.4	12	73	4	HB	▲
DSRV.4.120.250.30	12	2.5	26	36	11.4	12	83	4	HA	▲
DSRV.4.120.250.30B	12	2.5	26	36	11.4	12	83	4	HB	▲
DSRV.4.120.300.20	12	3	18	24	11.4	12	73	4	HA	▲
DSRV.4.120.300.20B	12	3	18	24	11.4	12	73	4	HB	▲
DSRV.4.120.300.30	12	3	26	36	11.4	12	83	4	HA	▲
DSRV.4.120.300.30B	12	3	26	36	11.4	12	83	4	HB	▲

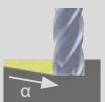



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切削参数 DSRV Ø 12 mm

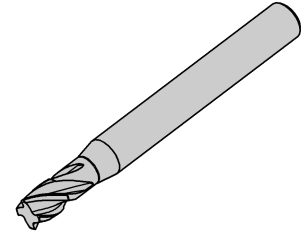
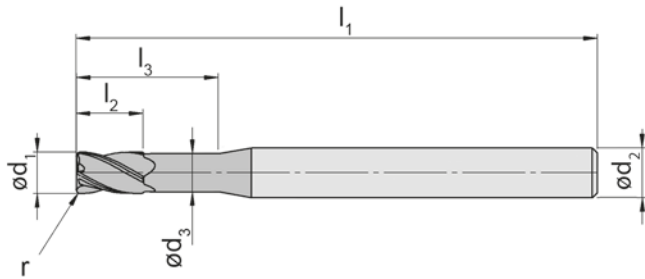
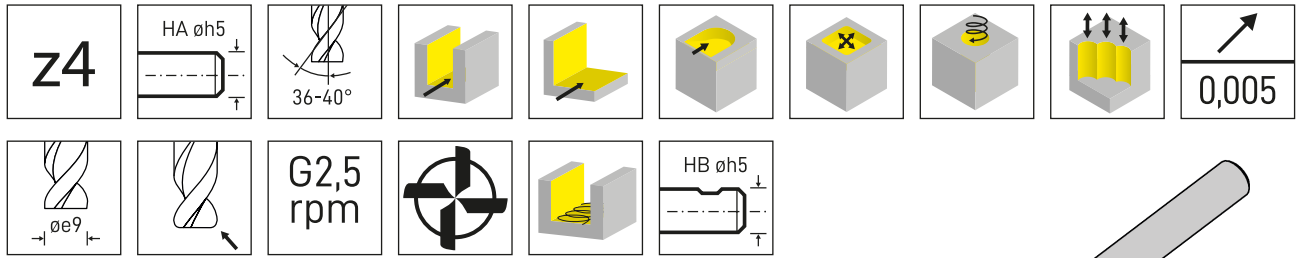
Cutting Data DSRV Ø 12 mm



	 vc = m/min	 vc = m/min	 vc = m/min
M1.1	90	120	140
M1.2	80	110	130
M1.3	70	100	120
S1.1	60	80	100
S1.2	50	70	90
S2.1	40	60	80
S2.2	35	55	75
S3.1	70	90	110
S3.2	60	80	100
S3.3	50	70	90

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.048	12.00	12.00	0.073	2.40	18.00	0.258	0.60	18.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00
12	5°	0.039	12.00	12.00	0.066	2.40	24.00	0.232	0.60	24.00





硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

E




产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	IC31
DSRV.4.160.020.20	16	0.2	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.020.20B	16	0.2	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.020.30	16	0.2	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.020.30B	16	0.2	34	48	15.2	16	100	4	HB	▲
DSRV.4.160.050.20	16	0.5	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.050.20B	16	0.5	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.050.30	16	0.5	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.050.30B	16	0.5	34	48	15.2	16	100	4	HB	▲
DSRV.4.160.100.20	16	1	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.100.20B	16	1	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.100.30	16	1	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.100.30B	16	1	34	48	15.2	16	100	4	HB	▲
DSRV.4.160.150.20	16	1.5	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.150.20B	16	1.5	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.150.30	16	1.5	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.150.30B	16	1.5	34	48	15.2	16	100	4	HB	▲
DSRV.4.160.200.20	16	2	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.200.20B	16	2	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.200.30	16	2	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.200.30B	16	2	34	48	15.2	16	100	4	HB	▲
DSRV.4.160.250.20	16	2.5	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.250.20B	16	2.5	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.250.30	16	2.5	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.250.30B	16	2.5	34	48	15.2	16	100	4	HB	▲
DSRV.4.160.300.20	16	3	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.300.20B	16	3	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.300.30	16	3	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.300.30B	16	3	34	48	15.2	16	100	4	HB	▲
DSRV.4.160.400.20	16	4	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.400.20B	16	4	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.400.30	16	4	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.400.30B	16	4	34	48	15.2	16	100	4	HB	▲

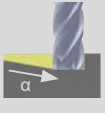


P	○
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切削参数 DSRV Ø 16 mm

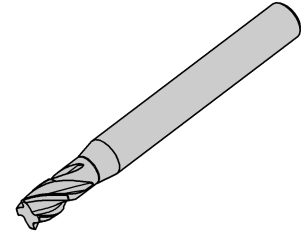
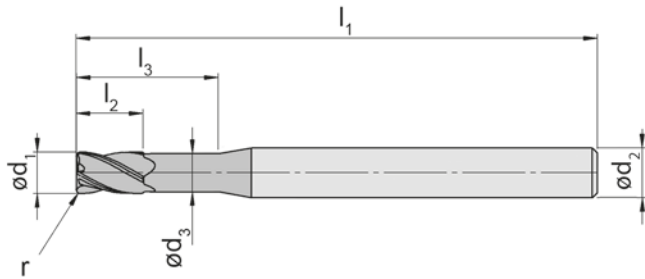
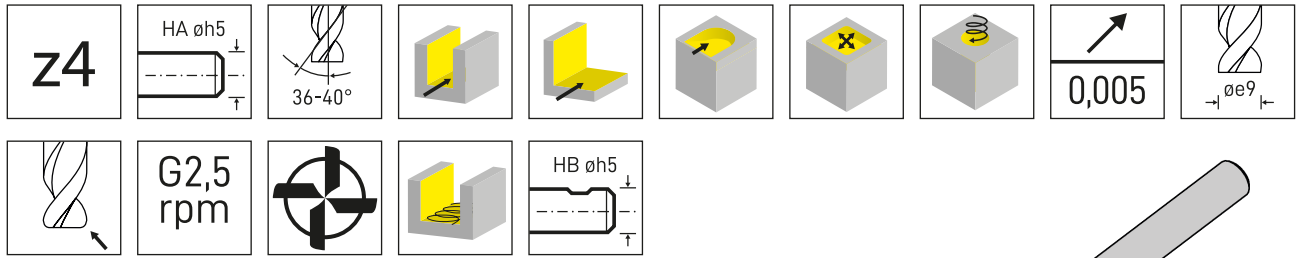
Cutting Data DSRV Ø 16 mm



	 vc = m/min	 vc = m/min	 vc = m/min
M1.1	90	120	140
M1.2	80	110	130
M1.3	70	100	120
S1.1	60	80	100
S1.2	50	70	90
S2.1	40	60	80
S2.2	35	55	75
S3.1	70	90	110
S3.2	60	80	100
S3.3	50	70	90

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.064	16.00	16.00	0.099	3.20	24.00	0.343	0.80	24.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00
16	5°	0.052	16.00	16.00	0.089	3.20	32.00	0.309	0.80	32.00

E



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

E




产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	IC31
DSRV.4.200.020.20	20	0.2	30	40	19	20	92	4	HA	▲
DSRV.4.200.020.20B	20	0.2	30	40	19	20	92	4	HB	▲
DSRV.4.200.020.30	20	0.2	42	60	19	20	120	4	HA	▲
DSRV.4.200.020.30B	20	0.2	42	60	19	20	120	4	HB	▲
DSRV.4.200.050.20	20	0.5	30	40	19	20	92	4	HA	▲
DSRV.4.200.050.20B	20	0.5	30	40	19	20	92	4	HB	▲
DSRV.4.200.050.30	20	0.5	42	60	19	20	120	4	HA	▲
DSRV.4.200.050.30B	20	0.5	42	60	19	20	120	4	HB	▲
DSRV.4.200.100.20	20	1	30	40	19	20	92	4	HA	▲
DSRV.4.200.100.20B	20	1	30	40	19	20	92	4	HB	▲
DSRV.4.200.100.30	20	1	42	60	19	20	120	4	HA	▲
DSRV.4.200.100.30B	20	1	42	60	19	20	120	4	HB	▲
DSRV.4.200.150.20	20	1.5	30	40	19	20	92	4	HA	▲
DSRV.4.200.150.20B	20	1.5	30	40	19	20	92	4	HB	▲
DSRV.4.200.150.30	20	1.5	42	60	19	20	120	4	HA	▲
DSRV.4.200.150.30B	20	1.5	42	60	19	20	120	4	HB	▲
DSRV.4.200.200.20	20	2	30	40	19	20	92	4	HA	▲
DSRV.4.200.200.20B	20	2	30	40	19	20	92	4	HB	▲
DSRV.4.200.200.30	20	2	42	60	19	20	120	4	HA	▲
DSRV.4.200.200.30B	20	2	42	60	19	20	120	4	HB	▲
DSRV.4.200.250.20	20	2.5	30	40	19	20	92	4	HA	▲
DSRV.4.200.250.20B	20	2.5	30	40	19	20	92	4	HB	▲
DSRV.4.200.250.30	20	2.5	42	60	19	20	120	4	HA	▲
DSRV.4.200.250.30B	20	2.5	42	60	19	20	120	4	HB	▲
DSRV.4.200.300.20	20	3	30	40	19	20	92	4	HA	▲
DSRV.4.200.300.20B	20	3	30	40	19	20	92	4	HB	▲
DSRV.4.200.300.30	20	3	42	60	19	20	120	4	HA	▲
DSRV.4.200.300.30B	20	3	42	60	19	20	120	4	HB	▲
DSRV.4.200.400.20	20	4	30	40	19	20	92	4	HB	▲
DSRV.4.200.400.20B	20	4	30	40	19	20	92	4	HB	▲
DSRV.4.200.400.30	20	4	42	60	19	20	120	4	HA	▲
DSRV.4.200.400.30B	20	4	42	60	19	20	120	4	HB	▲

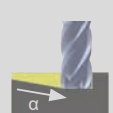



P	○
M	●
K	-
N	-
S	●
H	-

切削参数 DSRV Ø 20 mm

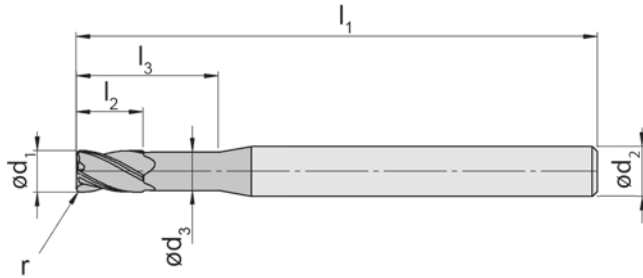
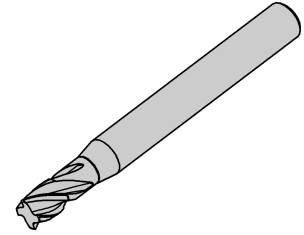
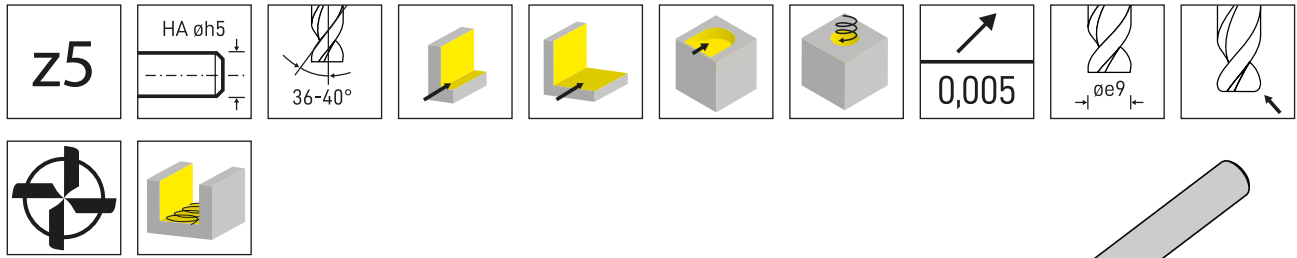
Cutting Data DSRV Ø 20 mm



	 vc = m/min	 vc = m/min	 vc = m/min
M1.1	90	120	140
M1.2	80	110	130
M1.3	70	100	120
S1.1	60	80	100
S1.2	50	70	90
S2.1	40	60	80
S2.2	35	55	75
S3.1	70	90	110
S3.2	60	80	100
S3.3	50	70	90

d ₁	 α									
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.080	20.00	20.00	0.124	4.00	30.00	0.428	1.00	30.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.385	1.00	40.00
20	5°	0.064	20.00	20.00	0.112	4.00	40.00	0.404	1.00	40.00

E



E

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	形式 Form	IG3I
DSRV.5.020.010.20	2	0.1	3	4	1.9	6	50	5	40°	HA	▲
DSRV.5.020.010.30	2	0.1	5	6	1.9	6	50	5	40°	HA	▲
DSRV.5.020.020.20	2	0.2	3	4	1.9	6	50	5	40°	HA	▲
DSRV.5.020.020.30	2	0.2	5	6	1.9	6	50	5	40°	HA	▲
DSRV.5.030.010.20	3	0.1	5	6	2.85	6	50	5	40°	HA	▲
DSRV.5.030.010.30	3	0.1	7	9	2.85	6	50	5	40°	HA	▲
DSRV.5.030.020.20	3	0.2	5	6	2.85	6	50	5	40°	HA	▲
DSRV.5.030.020.30	3	0.2	7	9	2.85	6	50	5	40°	HA	▲
DSRV.5.030.050.20	3	0.5	5	6	2.85	6	50	5	40°	HA	▲
DSRV.5.030.050.30	3	0.5	7	9	2.85	6	50	5	40°	HA	▲
DSRV.5.040.010.20	4	0.1	6	8	3.8	6	50	5	40°	HA	▲
DSRV.5.040.010.30	4	0.1	9	12	3.8	6	57	5	40°	HA	▲
DSRV.5.040.020.20	4	0.2	6	8	3.8	6	50	5	40°	HA	▲
DSRV.5.040.020.30	4	0.2	9	12	3.8	6	57	5	40°	HA	▲
DSRV.5.040.050.20	4	0.5	6	8	3.8	6	50	5	40°	HA	▲
DSRV.5.040.050.30	4	0.5	9	12	3.8	6	57	5	40°	HA	▲
DSRV.5.050.010.20	5	0.1	8	10	4.75	6	50	5	40°	HA	▲
DSRV.5.050.010.30	5	0.1	11	15	4.75	6	57	5	40°	HA	▲
DSRV.5.050.020.20	5	0.2	8	10	4.75	6	50	5	40°	HA	▲
DSRV.5.050.020.30	5	0.2	11	15	4.75	6	57	5	40°	HA	▲
DSRV.5.050.050.20	5	0.5	8	10	4.75	6	50	5	40°	HA	▲
DSRV.5.050.050.30	5	0.5	11	15	4.75	6	57	5	40°	HA	▲
DSRV.5.050.100.20	5	1	8	10	4.75	6	50	5	40°	HA	▲
DSRV.5.050.100.30	5	1	11	15	4.75	6	57	5	40°	HA	▲




P	o
M	•
K	-
N	-
S	•
H	-

切削参数 DSRV Ø 2 - 5 mm

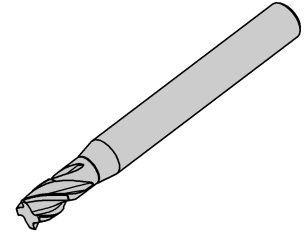
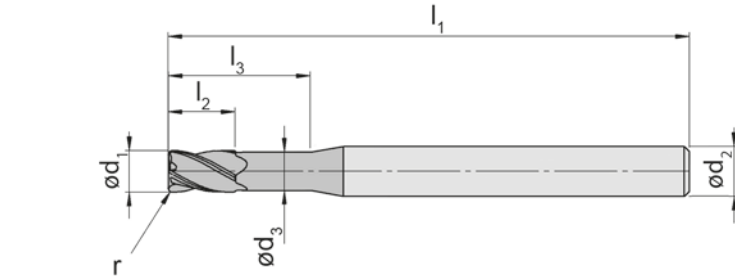
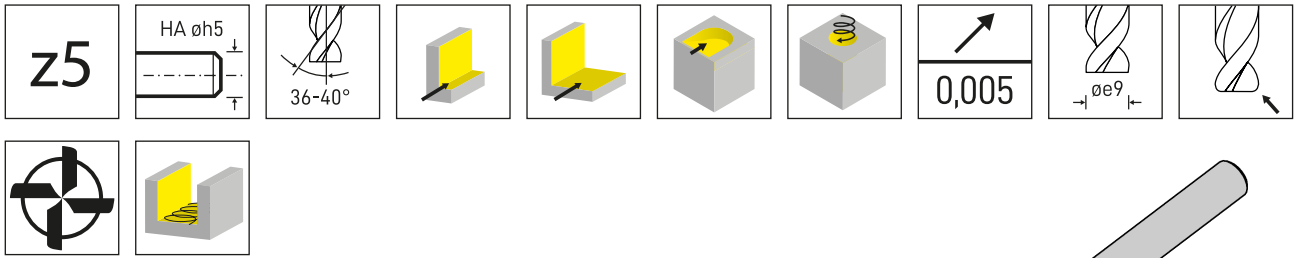
Cutting Data DSRV Ø 2 - 5 mm



	 vc = m/min	 vc = m/min
M1.1	120	140
M1.2	110	130
M1.3	100	120
S1.1	80	100
S1.2	70	90
S2.1	60	80
S2.2	55	75
S3.1	90	110
S3.2	80	100
S3.3	70	90

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
2	3°	0.009	0.40	3.00	0.035	0.10	3.00
2	3°	0.004	0.40	4.00	0.032	0.10	4.00
2	3°	0.009	0.40	3.00	0.035	0.10	3.00
2	3°	0.004	0.40	4.00	0.032	0.10	4.00
3	3°	0.016	0.60	4.50	0.057	0.15	4.50
3	3°	0.010	0.60	6.00	0.051	0.15	6.00
3	3°	0.016	0.60	4.50	0.057	0.15	4.50
3	3°	0.010	0.60	6.00	0.051	0.15	6.00
3	3°	0.016	0.60	4.50	0.057	0.15	4.50
3	3°	0.010	0.60	6.00	0.051	0.15	6.00
4	3°	0.022	0.80	6.00	0.078	0.20	6.00
4	3°	0.016	0.80	8.00	0.070	0.20	8.00
4	3°	0.022	0.80	6.00	0.078	0.20	6.00
4	3°	0.016	0.80	8.00	0.070	0.20	8.00
4	3°	0.022	0.80	6.00	0.078	0.20	6.00
4	3°	0.016	0.80	8.00	0.070	0.20	8.00
5	3°	0.028	1.00	7.50	0.099	0.25	7.50
5	3°	0.021	1.00	10.00	0.089	0.25	10.00
5	3°	0.028	1.00	7.50	0.099	0.25	7.50
5	3°	0.021	1.00	10.00	0.089	0.25	10.00
5	3°	0.028	1.00	7.50	0.099	0.25	7.50
5	3°	0.021	1.00	10.00	0.089	0.25	10.00
5	3°	0.028	1.00	7.50	0.099	0.25	7.50
5	3°	0.021	1.00	10.00	0.089	0.25	10.00

E



E

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	IG3I
DSRV.5.060.010.20	6	0.1	9	12	5.7	6	50	5	HA	▲
DSRV.5.060.010.30	6	0.1	13	18	5.7	6	57	5	HA	▲
DSRV.5.060.020.20	6	0.2	9	12	5.7	6	50	5	HA	▲
DSRV.5.060.020.30	6	0.2	13	18	5.7	6	57	5	HA	▲
DSRV.5.060.050.20	6	0.5	9	12	5.7	6	50	5	HA	▲
DSRV.5.060.050.30	6	0.5	13	18	5.7	6	57	5	HA	▲
DSRV.5.060.100.20	6	1	9	12	5.7	6	50	5	HA	▲
DSRV.5.060.100.30	6	1	13	18	5.7	6	57	5	HA	▲
DSRV.5.080.010.20	8	0.1	12	16	7.6	8	58	5	HA	▲
DSRV.5.080.010.30	8	0.1	17	24	7.6	8	63	5	HA	▲
DSRV.5.080.020.20	8	0.2	12	16	7.6	8	58	5	HA	▲
DSRV.5.080.020.30	8	0.2	17	24	7.6	8	63	5	HA	▲
DSRV.5.080.050.20	8	0.5	12	16	7.6	8	58	5	HA	▲
DSRV.5.080.050.30	8	0.5	17	24	7.6	8	63	5	HA	▲
DSRV.5.080.100.20	8	1	12	16	7.6	8	58	5	HA	▲
DSRV.5.080.100.30	8	1	17	24	7.6	8	63	5	HA	▲
DSRV.5.080.150.20	8	1.5	12	16	7.6	8	58	5	HA	▲
DSRV.5.080.150.30	8	1.5	17	24	7.6	8	63	5	HA	▲

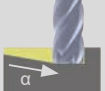


P	o
M	•
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H	-

切削参数 DSRV Ø 6 - 8 mm

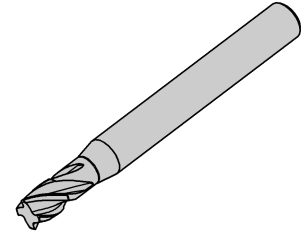
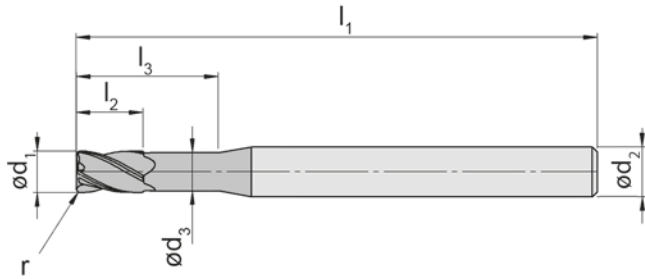
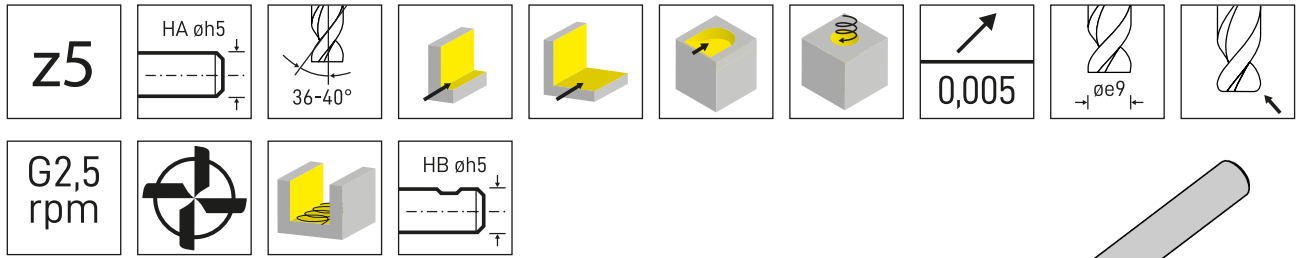
Cutting Data DSRV Ø 6 - 8 mm



	 vc = m/min	 vc = m/min
M1.1	120	140
M1.2	110	130
M1.3	100	120
S1.1	80	100
S1.2	70	90
S2.1	60	80
S2.2	55	75
S3.1	90	110
S3.2	80	100
S3.3	70	90

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
6	3°	0.035	1.20	9.00	0.121	0.30	9.00
6	3°	0.027	1.20	12.00	0.108	0.30	12.00
6	3°	0.035	1.20	9.00	0.121	0.30	9.00
6	3°	0.027	1.20	12.00	0.108	0.30	12.00
6	3°	0.035	1.20	9.00	0.121	0.30	9.00
6	3°	0.027	1.20	12.00	0.108	0.30	12.00
6	3°	0.035	1.20	9.00	0.121	0.30	9.00
6	3°	0.027	1.20	12.00	0.108	0.30	12.00
8	3°	0.047	1.60	12.00	0.163	0.40	12.00
8	3°	0.039	1.60	16.00	0.147	0.40	16.00
8	3°	0.047	1.60	12.00	0.163	0.40	12.00
8	3°	0.039	1.60	16.00	0.147	0.40	16.00
8	3°	0.047	1.60	12.00	0.163	0.40	12.00
8	3°	0.039	1.60	16.00	0.147	0.40	16.00
8	3°	0.047	1.60	12.00	0.163	0.40	12.00
8	3°	0.039	1.60	16.00	0.147	0.40	16.00
8	3°	0.047	1.60	12.00	0.163	0.40	12.00
8	3°	0.039	1.60	16.00	0.147	0.40	16.00

E



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

E



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	IG3I
DSRV.5.100.010.20	10	0.1	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.010.20B	10	0.1	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.010.30	10	0.1	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.010.30B	10	0.1	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.020.20	10	0.2	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.020.20B	10	0.2	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.020.30	10	0.2	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.020.30B	10	0.2	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.050.20	10	0.5	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.050.20B	10	0.5	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.050.30	10	0.5	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.050.30B	10	0.5	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.100.20	10	1	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.100.20B	10	1	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.100.30	10	1	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.100.30B	10	1	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.150.20	10	1.5	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.150.20B	10	1.5	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.150.30	10	1.5	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.150.30B	10	1.5	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.200.20	10	2	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.200.20B	10	2	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.200.30	10	2	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.200.30B	10	2	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.250.20	10	2.5	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.250.20B	10	2.5	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.250.30	10	2.5	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.250.30B	10	2.5	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.300.20	10	3	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.300.20B	10	3	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.300.30	10	3	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.300.30B	10	3	21	30	9.5	10	72	5	HB	▲




P	o
M	•
K	-
N	-
S	•
H	-

切削参数 DSRV Ø 10 mm

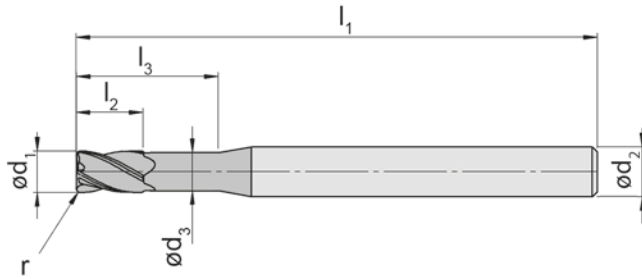
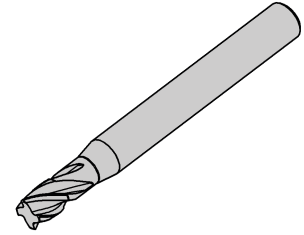
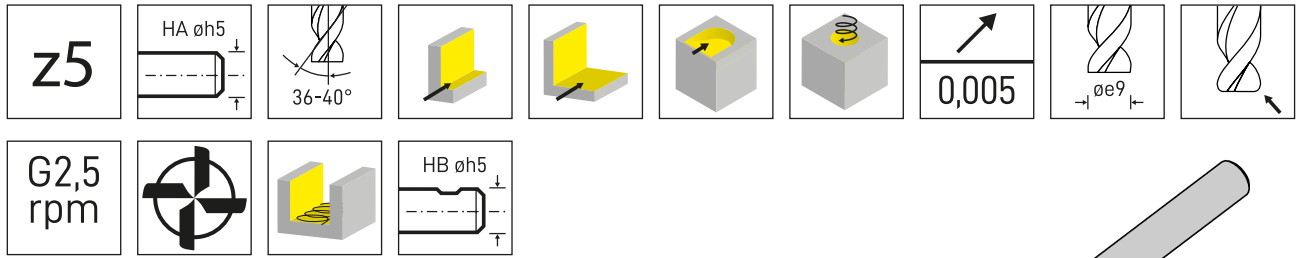
Cutting Data DSRV Ø 10 mm



	 $vc = m/min$	 $vc = m/min$
M1.1	120	140
M1.2	110	130
M1.3	100	120
S1.1	80	100
S1.2	70	90
S2.1	60	80
S2.2	55	75
S3.1	90	110
S3.2	80	100
S3.3	70	90

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
10	3°	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.050	2.00	20.00	0.185	0.50	20.00

E



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	IG31
DSRV.5.120.020.20	12	0.2	18	24	11.4	12	73	5	HA	▲
DSRV.5.120.020.20B	12	0.2	18	24	11.4	12	73	5	HB	▲
DSRV.5.120.020.30	12	0.2	26	36	11.4	12	83	5	HA	▲
DSRV.5.120.020.30B	12	0.2	26	36	11.4	12	83	5	HB	▲
DSRV.5.120.050.20	12	0.5	18	24	11.4	12	73	5	HA	▲
DSRV.5.120.050.20B	12	0.5	18	24	11.4	12	73	5	HB	▲
DSRV.5.120.050.30	12	0.5	26	36	11.4	12	83	5	HA	▲
DSRV.5.120.050.30B	12	0.5	26	36	11.4	12	83	5	HB	▲
DSRV.5.120.100.20	12	1	18	24	11.4	12	73	5	HA	▲
DSRV.5.120.100.20B	12	1	18	24	11.4	12	73	5	HB	▲
DSRV.5.120.100.30	12	1	26	36	11.4	12	83	5	HA	▲
DSRV.5.120.100.30B	12	1	26	36	11.4	12	83	5	HB	▲
DSRV.5.120.150.20	12	1.5	18	24	11.4	12	73	5	HA	▲
DSRV.5.120.150.20B	12	1.5	18	24	11.4	12	73	5	HB	▲
DSRV.5.120.150.30	12	1.5	26	36	11.4	12	83	5	HA	▲
DSRV.5.120.150.30B	12	1.5	26	36	11.4	12	83	5	HB	▲
DSRV.5.120.200.20	12	2	18	24	11.4	12	73	5	HA	▲
DSRV.5.120.200.20B	12	2	18	24	11.4	12	73	5	HB	▲
DSRV.5.120.200.30	12	2	26	36	11.4	12	83	5	HA	▲
DSRV.5.120.200.30B	12	2	26	36	11.4	12	83	5	HB	▲
DSRV.5.120.250.20	12	2.5	18	24	11.4	12	73	5	HA	▲
DSRV.5.120.250.20B	12	2.5	18	24	11.4	12	73	5	HB	▲
DSRV.5.120.250.30	12	2.5	26	36	11.4	12	83	5	HA	▲
DSRV.5.120.250.30B	12	2.5	26	36	11.4	12	83	5	HB	▲
DSRV.5.120.300.20	12	3	18	24	11.4	12	73	5	HA	▲
DSRV.5.120.300.20B	12	3	18	24	11.4	12	73	5	HB	▲
DSRV.5.120.300.30	12	3	26	36	11.4	12	83	5	HA	▲
DSRV.5.120.300.30B	12	3	26	36	11.4	12	83	5	HB	▲




P	○
M	●
K	-
N	-
S	●
H	-

切削参数 DSRV Ø 12 mm

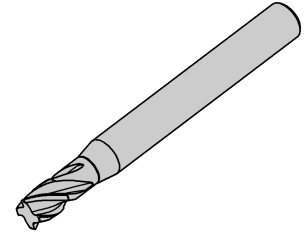
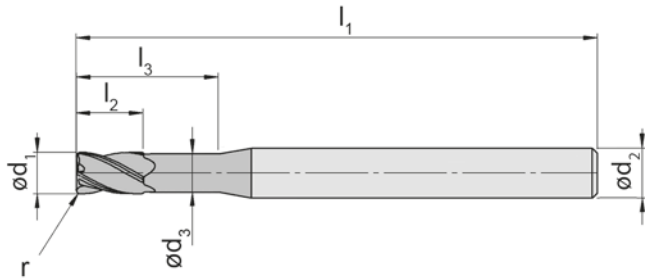
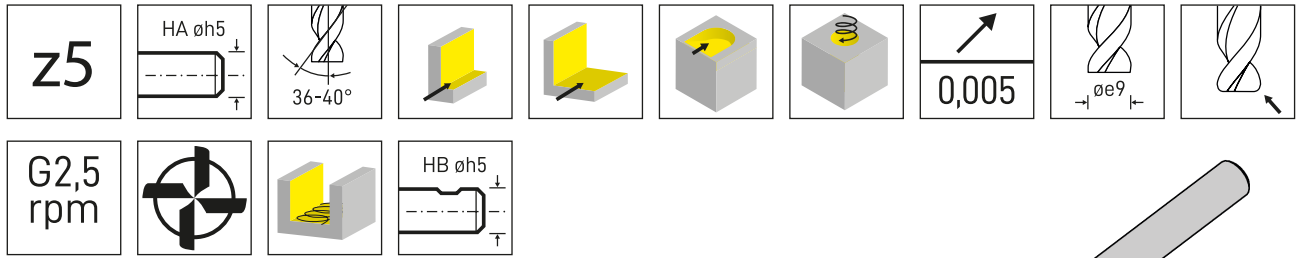
Cutting Data DSRV Ø 12 mm



	 $vc = m/min$	 $vc = m/min$
M1.1	120	140
M1.2	110	130
M1.3	100	120
S1.1	80	100
S1.2	70	90
S2.1	60	80
S2.2	55	75
S3.1	90	110
S3.2	80	100
S3.3	70	90

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
12	3°	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.062	2.40	24.00	0.223	0.60	24.00

E



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

E



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	IC31
DSRV.5.160.020.20	16	0.2	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.020.20B	16	0.2	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.020.30	16	0.2	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.020.30B	16	0.2	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.050.20	16	0.5	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.050.20B	16	0.5	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.050.30	16	0.5	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.050.30B	16	0.5	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.100.20	16	1	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.100.20B	16	1	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.100.30	16	1	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.100.30B	16	1	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.150.20	16	1.5	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.150.20B	16	1.5	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.150.30	16	1.5	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.150.30B	16	1.5	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.200.20	16	2	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.200.20B	16	2	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.200.30	16	2	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.200.30B	16	2	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.250.20	16	2.5	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.250.20B	16	2.5	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.250.30	16	2.5	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.250.30B	16	2.5	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.300.20	16	3	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.300.20B	16	3	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.300.30	16	3	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.300.30B	16	3	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.400.20	16	4	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.400.20B	16	4	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.400.30	16	4	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.400.30B	16	4	34	48	15.2	16	100	5	HB	▲

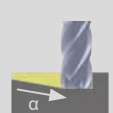


P	○
M	●
K	-
N	-
S	●
H	-

切削参数 DSRV Ø 16 mm

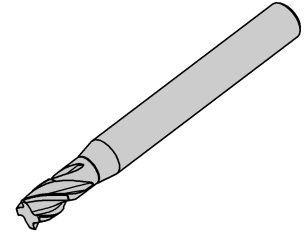
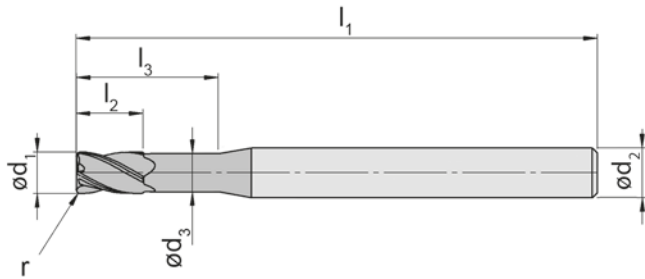
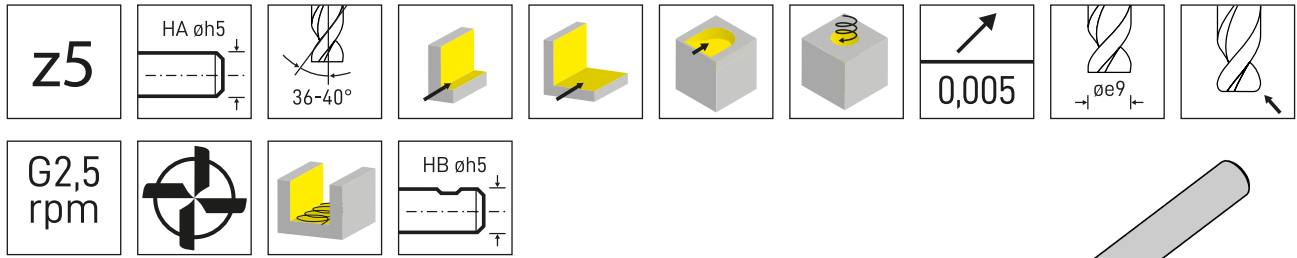
Cutting Data DSRV Ø 16 mm



	 vc = m/min	 vc = m/min
M1.1	120	140
M1.2	110	130
M1.3	100	120
S1.1	80	100
S1.2	70	90
S2.1	60	80
S2.2	55	75
S3.1	90	110
S3.2	80	100
S3.3	70	90

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
16	3°	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.085	3.20	32.00	0.300	0.80	32.00

E



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

E



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	IC31
DSRV.5.200.020.20	20	0.2	30	40	19	20	92	5	HA	▲
DSRV.5.200.020.20B	20	0.2	30	40	19	20	92	5	HB	▲
DSRV.5.200.020.30	20	0.2	42	60	19	20	120	5	HA	▲
DSRV.5.200.020.30B	20	0.2	42	60	19	20	120	5	HB	▲
DSRV.5.200.050.20	20	0.5	30	40	19	20	92	5	HA	▲
DSRV.5.200.050.20B	20	0.5	30	40	19	20	92	5	HB	▲
DSRV.5.200.050.30	20	0.5	42	60	19	20	120	5	HA	▲
DSRV.5.200.050.30B	20	0.5	42	60	19	20	120	5	HB	▲
DSRV.5.200.100.20	20	1	30	40	19	20	92	5	HA	▲
DSRV.5.200.100.20B	20	1	30	40	19	20	92	5	HB	▲
DSRV.5.200.100.30	20	1	42	60	19	20	120	5	HA	▲
DSRV.5.200.100.30B	20	1	42	60	19	20	120	5	HB	▲
DSRV.5.200.150.20	20	1.5	30	40	19	20	92	5	HA	▲
DSRV.5.200.150.20B	20	1.5	30	40	19	20	92	5	HB	▲
DSRV.5.200.150.30	20	1.5	42	60	19	20	120	5	HA	▲
DSRV.5.200.150.30B	20	1.5	42	60	19	20	120	5	HB	▲
DSRV.5.200.200.20	20	2	30	40	19	20	92	5	HA	▲
DSRV.5.200.200.20B	20	2	30	40	19	20	92	5	HB	▲
DSRV.5.200.200.30	20	2	42	60	19	20	120	5	HA	▲
DSRV.5.200.200.30B	20	2	42	60	19	20	120	5	HB	▲
DSRV.5.200.250.20	20	2.5	30	40	19	20	92	5	HA	▲
DSRV.5.200.250.20B	20	2.5	30	40	19	20	92	5	HB	▲
DSRV.5.200.250.30	20	2.5	42	60	19	20	120	5	HA	▲
DSRV.5.200.250.30B	20	2.5	42	60	19	20	120	5	HB	▲
DSRV.5.200.300.20	20	3	30	40	19	20	92	5	HA	▲
DSRV.5.200.300.20B	20	3	30	40	19	20	92	5	HB	▲
DSRV.5.200.300.30	20	3	42	60	19	20	120	5	HA	▲
DSRV.5.200.300.30B	20	3	42	60	19	20	120	5	HB	▲
DSRV.5.200.400.20	20	4	30	40	19	20	92	5	HA	▲
DSRV.5.200.400.20B	20	4	30	40	19	20	92	5	HB	▲
DSRV.5.200.400.30	20	4	42	60	19	20	120	5	HA	▲
DSRV.5.200.400.30B	20	4	42	60	19	20	120	5	HB	▲

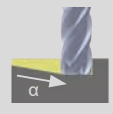


P	o
M	•
K	-
N	-
S	•
H	-

切削参数 DSRV Ø 20 mm

Cutting Data DSRV Ø 20 mm



	 vc = m/min	 vc = m/min
M1.1	120	140
M1.2	110	130
M1.3	100	120
S1.1	80	100
S1.2	70	90
S2.1	60	80
S2.2	55	75
S3.1	90	110
S3.2	80	100
S3.3	70	90

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
20	3°	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.108	4.00	40.00	0.377	1.00	40.00

E

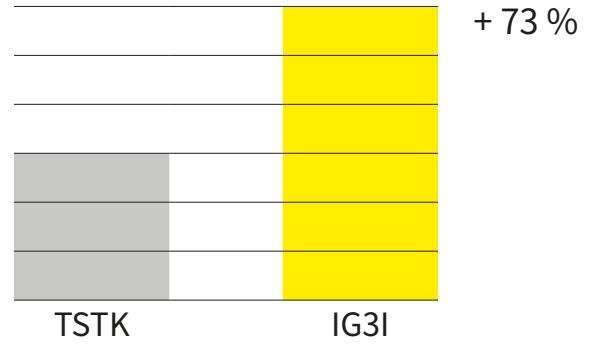
刀具寿命测试

Tool life test

立铣刀: DSRV
Milling Cutter: Ø 12 mm
Z4

材料: Ti6Al4V
Material:

切削参数: v_c 80 m/min
Cutting data: f_z 0.085 mm
 a_e 3 mm
 a_p 24 mm



E

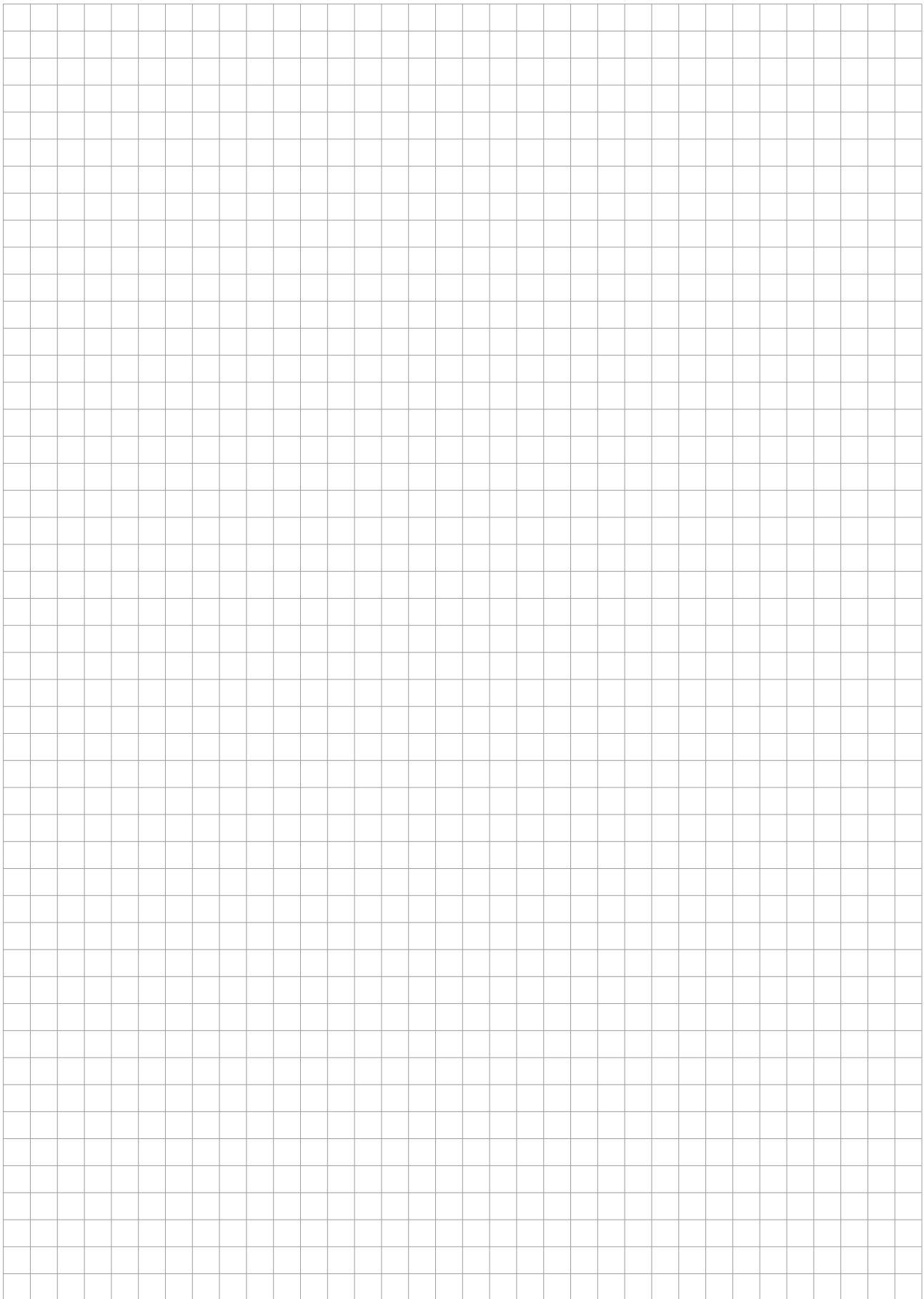


技术参数

- 抛光切削刃
- 正前角
- 大间隙角
- 变螺距设计
- 轻快切削, 低震动趋势

Technical data

- polished edges
- positive rake angle
- large clearance angle
- variable angles of twist and tooth pitch
- smooth cut and low tendency to vibrate



E

整体硬质合金立铣刀

Solid Carbide End Mills



	DSKMA	圆头微型立铣刀 Ball Nose End Mill Micro	Ø 0,1 – Ø 3	Z 2	194 – 197
	DSMA	微型立铣刀 End Mill Micro	Ø 0,1 – Ø 3	Z 2	198 – 201
	DSTMA	圆角微型立铣刀 Torus End Mill Micro	Ø 0,1 – Ø 3	Z 2	202 – 207
	DSA.1	单刃立铣刀 End Mill single fluted	Ø 0,3 – Ø 12	Z 1	208 – 211
	DSKA	圆头立铣刀 Ball Nose End Mill	Ø 4 – Ø 20	Z 2	212 – 213
	DSA.3	精加工立铣刀 Finishing End Mill	Ø 4 – Ø 20	Z 3	214 – 215
	DSRA.3	立铣刀 End Mill	Ø 4 – Ø 20	Z 3	216 – 223
	DSFA.3	HPC立铣刀 End Mill HPC	Ø 6 – Ø 20	Z 3	224 – 225
	DSFRA.3	粗加工立铣刀 Roughing End Mill with ripper profile	Ø 6 – Ø 20	Z 3	226 – 227

F

DS



F

整体硬质合金立铣刀

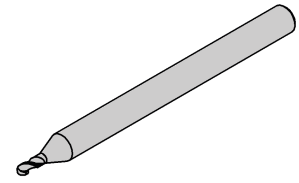
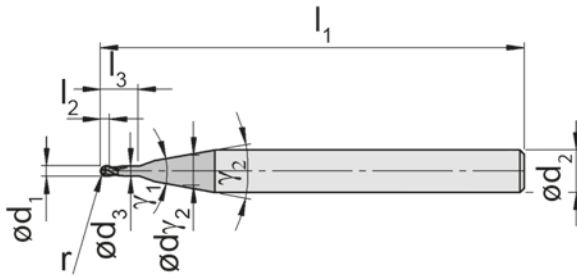
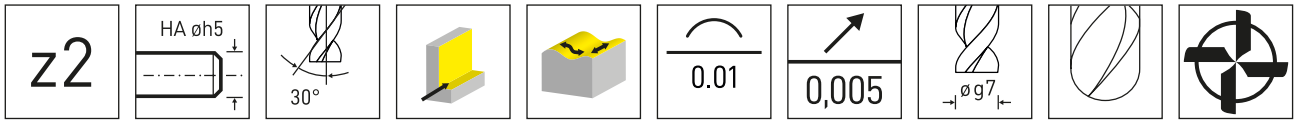
设计用于:

- 铝合金
- 合成纤维材料

Solid Carbide End Mills

designed for:

- Aluminium
- Synthetics



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ1	γ2	MG3K
DSKMA.020.030	0.2	0.1	0.5	0.6	0.18	4	50	2	20°	-°	▲
DSKMA.020.070	0.2	0.1	0.5	1.4	0.18	4	50	2	40°	20°	▲
DSKMA.030.030	0.3	0.15	0.75	0.9	0.28	4	50	2	20°	-°	▲
DSKMA.030.050	0.3	0.15	0.75	1.5	0.28	4	50	2	40°	20°	▲
DSKMA.030.070	0.3	0.15	0.75	2.1	0.28	4	50	2	40°	20°	▲
DSKMA.050.030	0.5	0.25	1.25	1.5	0.47	4	50	2	20°	-°	▲
DSKMA.050.050	0.5	0.25	1.25	2.5	0.47	4	50	2	40°	20°	▲
DSKMA.050.070	0.5	0.25	1.25	3.5	0.47	4	50	2	40°	20°	▲
DSKMA.060.030	0.6	0.3	1.5	1.8	0.56	4	50	2	20°	-°	▲
DSKMA.060.050	0.6	0.3	1.5	3	0.56	4	50	2	40°	20°	▲
DSKMA.060.070	0.6	0.3	1.5	4.2	0.56	4	50	2	40°	20°	▲
DSKMA.080.030	0.8	0.4	2	2.4	0.75	4	50	2	20°	-°	▲
DSKMA.080.050	0.8	0.4	2	4	0.75	4	50	2	40°	20°	▲
DSKMA.080.070	0.8	0.4	2	5.6	0.75	4	50	2	40°	20°	▲


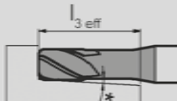


P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSKMA Ø 0.1 - 0.8 mm

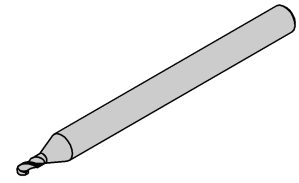
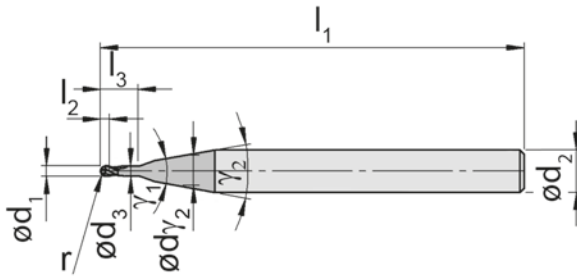
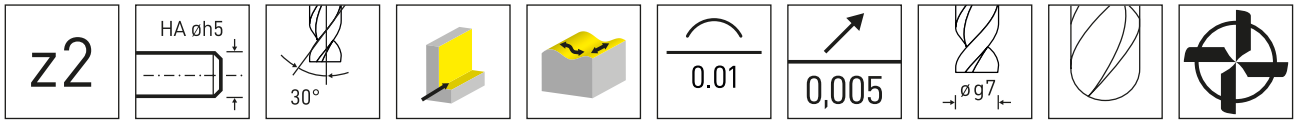
Cutting Data DSKMA Ø 0.1 - 0.8 mm



	 vc = m/min	 vc = m/min
N1.1	450	480
N1.2	450	480
N2.1	350	380
N2.2	350	380
N2.3	200	230
N3.1	250	280
N3.2	300	330
N3.3	200	230
N3.4	200	230

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
0.2	7°	0.6	0.6	0.6	0.7	0.8	0.006	0.06	0.20	0.007	0.01	0.02
0.2	3°	1.4	1.4	1.4	1.5	1.6	0.004	0.06	0.20	0.006	0.01	0.01
0.3	7°	0.9	0.9	0.9	1.0	1.2	0.007	0.09	0.30	0.009	0.02	0.03
0.3	5°	1.5	1.5	1.5	1.6	1.7	0.006	0.09	0.30	0.008	0.02	0.02
0.3	3°	2.1	2.1	2.2	2.3	2.4	0.005	0.09	0.30	0.007	0.02	0.02
0.5	7°	1.5	1.5	1.6	1.8	2.0	0.009	0.15	0.50	0.012	0.03	0.05
0.5	5°	2.5	2.5	2.6	2.7	2.8	0.008	0.15	0.50	0.011	0.03	0.04
0.5	3°	3.5	3.5	3.6	3.8	4.0	0.007	0.15	0.50	0.009	0.03	0.03
0.6	7°	1.8	1.8	1.9	2.1	2.4	0.010	0.18	0.60	0.013	0.03	0.06
0.6	5°	3.0	3.0	3.1	3.2	3.4	0.009	0.18	0.60	0.012	0.03	0.05
0.6	3°	4.2	4.3	4.4	4.6	4.8	0.008	0.18	0.60	0.011	0.03	0.04
0.8	7°	2.4	2.5	2.6	2.9	3.2	0.012	0.24	0.80	0.016	0.04	0.08
0.8	5°	4.0	4.0	4.1	4.3	4.6	0.010	0.24	0.80	0.015	0.04	0.06
0.8	3°	5.6	5.7	5.8	6.1	6.4	0.009	0.24	0.80	0.013	0.04	0.05

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	MG3K
DSKMA.100.030	1	0.5	2.5	3	0.95	4	50	2	20°	-°	▲
DSKMA.100.050	1	0.5	2.5	5	0.95	4	50	2	40°	20°	▲
DSKMA.100.070	1	0.5	2.5	7	0.95	4	50	2	40°	20°	▲
DSKMA.120.030	1.2	0.6	3	3.6	1.15	4	50	2	20°	-°	▲
DSKMA.120.050	1.2	0.6	3	6	1.15	4	50	2	40°	20°	▲
DSKMA.120.070	1.2	0.6	3	8.4	1.15	4	50	2	40°	20°	▲
DSKMA.150.030	1.5	0.75	3.75	4.5	1.45	4	50	2	20°	-°	▲
DSKMA.150.050	1.5	0.75	3.75	7.5	1.45	4	50	2	40°	20°	▲
DSKMA.150.070	1.5	0.75	3.75	10.5	1.45	4	50	2	40°	20°	▲
DSKMA.200.030	2	1	5	6	1.9	4	50	2	20°	-°	▲
DSKMA.200.050	2	1	5	10	1.9	4	50	2	40°	20°	▲
DSKMA.200.070	2	1	5	14	1.9	4	50	2	40°	20°	▲
DSKMA.250.030	2.5	1.25	6.25	7.5	2.4	4	50	2	20°	-°	▲
DSKMA.250.050	2.5	1.25	6.25	12.5	2.4	4	50	2	40°	20°	▲
DSKMA.250.070	2.5	1.25	6.25	17.5	2.4	4	50	2	40°	20°	▲
DSKMA.300.030	3	1.5	7.5	9	2.9	4	50	2	20°	-°	▲
DSKMA.300.050	3	1.5	7.5	15	2.9	4	50	2	40°	20°	▲
DSKMA.300.070	3	1.5	7.5	21	2.9	4	64	2	40°	20°	▲


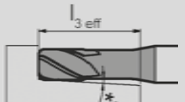


P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSKMA Ø 1 - 3 mm

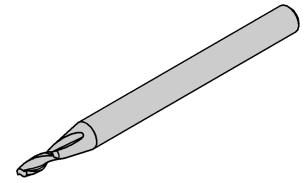
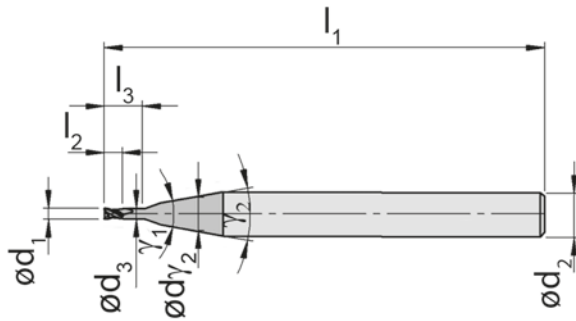
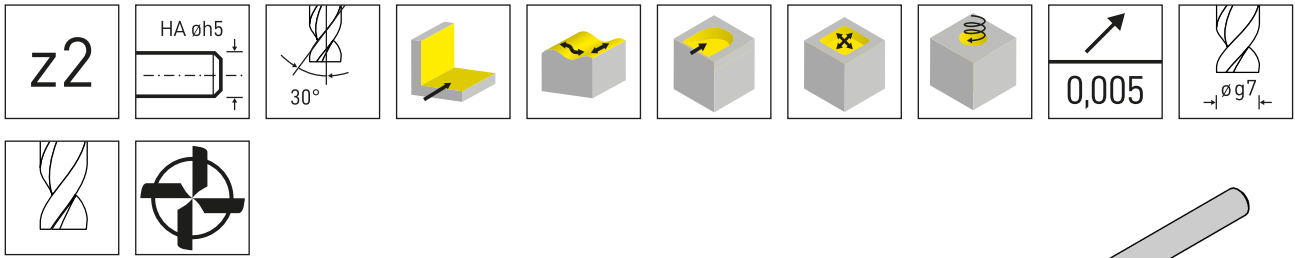
Cutting Data DSKMA Ø 1 - 3 mm



	 vc = m/min	 vc = m/min
N1.1	450	480
N1.2	450	480
N2.1	350	380
N2.2	350	380
N2.3	200	230
N3.1	250	280
N3.2	300	330
N3.3	200	230
N3.4	200	230

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
1.0	7°	3.0	3.1	3.2	3.6	4.0	0.014	0.30	1.00	0.019	0.05	0.10
1.0	5°	5.0	5.1	5.2	5.4	5.7	0.012	0.30	1.00	0.017	0.05	0.08
1.0	3°	7.0	7.1	7.3	7.6	8.1	0.011	0.30	1.00	0.015	0.05	0.06
1.2	7°	3.6	3.7	3.9	4.3	4.8	0.016	0.36	1.20	0.022	0.06	0.12
1.2	5°	6.0	6.1	6.2	6.5	6.9	0.014	0.36	1.20	0.020	0.06	0.10
1.2	3°	8.4	8.5	8.7	9.2	9.8	0.013	0.36	1.20	0.018	0.06	0.07
1.5	7°	4.5	4.7	4.9	5.4	6.1	0.019	0.45	1.50	0.027	0.08	0.15
1.5	5°	7.5	7.6	7.8	8.2	8.6	0.017	0.45	1.50	0.024	0.08	0.12
1.5	3°	10.5	10.7	10.9	11.5	12.3	0.015	0.45	1.50	0.021	0.08	0.09
2.0	7°	6.0	6.2	6.5	7.2	8.1	0.024	0.60	2.00	0.034	0.10	0.20
2.0	5°	10.0	10.2	10.4	10.9	11.5	0.021	0.60	2.00	0.031	0.10	0.16
2.0	3°	14.0	14.3	14.6	15.3	17.2	0.019	0.60	2.00	0.027	0.10	0.12
2.5	7°	7.5	7.8	8.1	9.0	10.1	0.029	0.75	2.50	0.041	0.13	0.25
2.5	5°	12.5	12.7	13.0	13.7	∞	0.026	0.75	2.50	0.037	0.13	0.20
2.5	3°	17.5	17.9	18.3	19.5	∞	0.023	0.75	2.50	0.033	0.13	0.15
3.0	7°	9.0	9.3	9.8	10.8	∞	0.034	0.90	3.00	0.049	0.15	0.30
3.0	5°	15.0	15.3	15.6	∞	∞	0.031	0.90	3.00	0.044	0.15	0.24
3.0	3°	21.0	21.4	22.1	∞	∞	0.027	0.90	3.00	0.039	0.15	0.18

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	MG3K
DSMA.010.030	0.1	0.25	0.3	0.084	4	50	2	20°	-°	▲
DSMA.010.050	0.1	0.25	0.5	0.084	4	50	2	40°	20°	▲
DSMA.010.070	0.1	0.25	0.7	0.084	4	50	2	40°	20°	▲
DSMA.020.030	0.2	0.5	0.6	0.18	4	50	2	20°	-°	▲
DSMA.020.050	0.2	0.5	1	0.18	4	50	2	40°	20°	▲
DSMA.020.070	0.2	0.5	1.4	0.18	4	50	2	40°	20°	▲
DSMA.030.030	0.3	0.75	0.9	0.28	4	50	2	20°	-°	▲
DSMA.030.050	0.3	0.75	1.5	0.28	4	50	2	40°	20°	▲
DSMA.030.070	0.3	0.75	2.1	0.28	4	50	2	40°	20°	▲
DSMA.050.030	0.5	1.25	1.5	0.47	4	50	2	20°	-°	▲
DSMA.050.050	0.5	1.25	2.5	0.47	4	50	2	40°	20°	▲
DSMA.050.070	0.5	1.25	3.5	0.47	4	50	2	40°	20°	▲
DSMA.060.030	0.6	1.5	1.8	0.56	4	50	2	20°	-°	▲
DSMA.060.050	0.6	1.5	3	0.56	4	50	2	40°	20°	▲
DSMA.060.070	0.6	1.5	4.2	0.56	4	50	2	40°	20°	▲
DSMA.080.030	0.8	2	2.4	0.75	4	50	2	20°	-°	▲
DSMA.080.050	0.8	2	4	0.75	4	50	2	40°	20°	▲
DSMA.080.070	0.8	2	5.6	0.75	4	50	2	40°	20°	▲
DSMA.100.030	1	2.5	3	0.95	4	50	2	20°	-°	▲
DSMA.100.050	1	2.5	5	0.95	4	50	2	40°	20°	▲
DSMA.100.070	1	2.5	7	0.95	4	50	2	40°	20°	▲


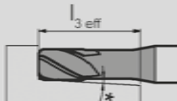


P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSMA Ø 0.1 - 1 mm

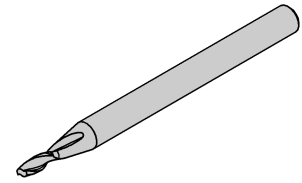
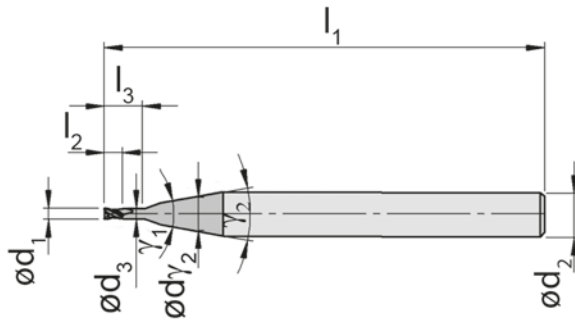
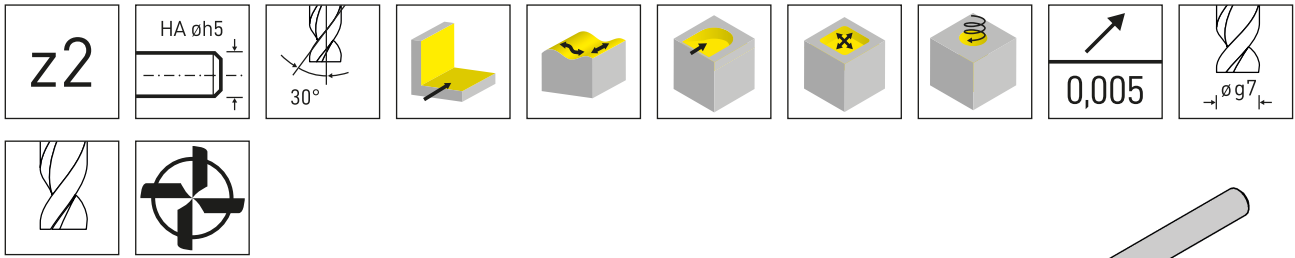
Cutting Data DSMA Ø 0.1 - 1 mm



	 vc = m/min	 vc = m/min
N1.1	450	480
N1.2	450	480
N2.1	350	380
N2.2	350	380
N2.3	200	230
N3.1	250	280
N3.2	300	330
N3.3	200	230
N3.4	200	230

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
0.1	7°	0.3	0.3	0.3	0.3	0.4	0.005	0.03	0.10	0.006	0.01	0.01
0.1	5°	0.5	0.5	0.5	0.5	0.5	0.004	0.03	0.10	0.005	0.01	0.01
0.1	3°	0.7	0.7	0.7	0.7	0.8	0.004	0.03	0.10	0.005	0.01	0.01
0.2	7°	0.6	0.6	0.6	0.7	0.8	0.006	0.06	0.20	0.007	0.01	0.02
0.2	5°	1.0	1.0	1.0	1.1	1.1	0.005	0.06	0.20	0.006	0.01	0.02
0.2	3°	1.4	1.4	1.4	1.5	1.6	0.004	0.06	0.20	0.006	0.01	0.01
0.3	7°	0.9	0.9	1.0	1.2	1.2	0.007	0.09	0.30	0.009	0.02	0.03
0.3	5°	1.5	1.5	1.5	1.6	1.7	0.006	0.09	0.30	0.008	0.02	0.02
0.3	3°	2.1	2.1	2.2	2.3	2.4	0.005	0.09	0.30	0.007	0.02	0.02
0.5	7°	1.5	1.5	1.6	1.8	2.1	0.009	0.15	0.50	0.012	0.03	0.05
0.5	5°	2.5	2.5	2.6	2.7	2.9	0.008	0.15	0.50	0.011	0.03	0.04
0.5	3°	3.5	3.5	3.6	3.8	4.0	0.007	0.15	0.50	0.009	0.03	0.03
0.6	7°	1.8	1.8	2.0	2.2	2.5	0.010	0.18	0.60	0.013	0.03	0.06
0.6	5°	3.0	3.0	3.1	3.3	3.5	0.009	0.18	0.60	0.012	0.03	0.05
0.6	3°	4.2	4.3	4.4	4.6	4.9	0.008	0.18	0.60	0.011	0.03	0.04
0.8	7°	2.4	2.5	2.6	2.9	3.4	0.012	0.24	0.80	0.016	0.04	0.08
0.8	5°	4.0	4.1	4.2	4.4	4.6	0.010	0.24	0.80	0.015	0.04	0.06
0.8	3°	5.6	5.7	5.8	6.1	6.5	0.009	0.24	0.80	0.013	0.04	0.05
1.0	7°	3.0	3.1	3.3	3.7	4.2	0.014	0.30	1.00	0.019	0.05	0.10
1.0	5°	5.0	5.1	5.2	5.5	5.8	0.012	0.30	1.00	0.017	0.05	0.08
1.0	3°	7.0	7.1	7.3	7.7	8.1	0.011	0.30	1.00	0.015	0.05	0.06

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



F


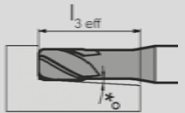


产品型号 Part number	d ₁	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	MG3K
DSMA.120.030	1.2	3	3.6	1.15	4	50	2	20°	-°	▲
DSMA.120.050	1.2	3	6	1.15	4	50	2	40°	20°	▲
DSMA.120.070	1.2	3	8.4	1.15	4	50	2	40°	20°	▲
DSMA.150.030	1.5	3.75	4.5	1.45	4	50	2	20°	-°	▲
DSMA.150.050	1.5	3.75	7.5	1.45	4	50	2	40°	20°	▲
DSMA.150.070	1.5	3.75	10.5	1.45	4	50	2	40°	20°	▲
DSMA.200.030	2	5	6	1.9	4	50	2	20°	-°	▲
DSMA.200.050	2	5	10	1.9	4	50	2	40°	20°	▲
DSMA.200.070	2	5	14	1.9	4	50	2	40°	20°	▲
DSMA.250.030	2.5	6.25	7.5	2.4	4	50	2	20°	-°	▲
DSMA.250.050	2.5	6.25	12.5	2.4	4	50	2	40°	20°	▲
DSMA.250.070	2.5	6.25	17.5	2.4	4	50	2	40°	20°	▲
DSMA.300.030	3	7.5	9	2.9	4	50	2	20°	-°	▲
DSMA.300.050	3	7.5	15	2.9	4	50	2	40°	20°	▲
DSMA.300.070	3	7.5	21	2.9	4	64	2	40°	20°	▲
P	-									
M	-									
K	-									
N	●									
S	-									
H	-									

切削参数 DSMA Ø 1.2 - 3 mm

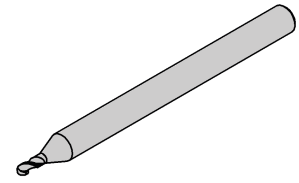
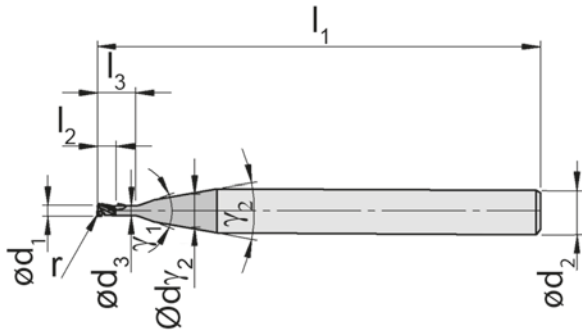
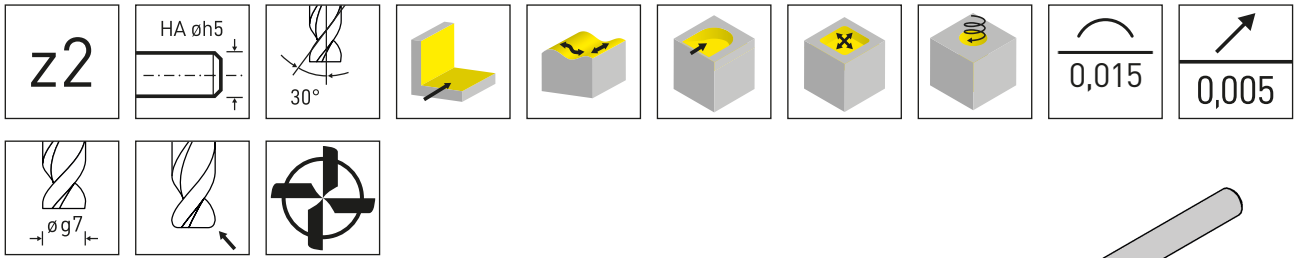
Cutting Data DSMA Ø 1.2 - 3 mm



	 vc = m/min	 vc = m/min
N1.1	450	480
N1.2	450	480
N2.1	350	380
N2.2	350	380
N2.3	200	230
N3.1	250	280
N3.2	300	330
N3.3	200	230
N3.4	200	230

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
1.2	7°	3.6	3.7	3.9	4.4	5.1	0.016	0.36	1.20	0.022	0.06	0.12
1.2	5°	6.0	6.1	6.3	6.6	7.0	0.014	0.36	1.20	0.020	0.06	0.10
1.2	3°	8.4	8.6	8.8	9.2	10.0	0.013	0.36	1.20	0.018	0.06	0.07
1.5	7°	4.5	4.7	4.9	5.6	6.4	0.019	0.45	1.50	0.027	0.08	0.15
1.5	5°	7.5	7.6	7.8	8.2	8.7	0.017	0.45	1.50	0.024	0.08	0.12
1.5	3°	10.5	10.7	11.0	11.6	12.6	0.015	0.45	1.50	0.021	0.08	0.09
2.0	7°	6.0	6.3	6.6	7.4	8.5	0.024	0.60	2.00	0.034	0.10	0.20
2.0	5°	10.0	10.2	10.5	11.0	11.9	0.021	0.60	2.00	0.031	0.10	0.16
2.0	3°	14.0	14.3	14.7	15.4	17.6	0.019	0.60	2.00	0.027	0.10	0.12
2.5	7°	7.5	7.8	8.3	9.3	10.6	0.029	0.75	2.50	0.041	0.13	0.25
2.5	5°	12.5	12.8	13.1	13.8	∞	0.026	0.75	2.50	0.037	0.13	0.20
2.5	3°	17.5	17.9	18.3	19.8	∞	0.023	0.75	2.50	0.033	0.13	0.15
3.0	7°	9.0	9.4	9.9	11.2	∞	0.034	0.90	3.00	0.049	0.15	0.30
3.0	5°	15.0	15.3	15.7	∞	∞	0.031	0.90	3.00	0.044	0.15	0.24
3.0	3°	21.0	21.5	22.0	∞	∞	0.027	0.90	3.00	0.039	0.15	0.18

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	MG3K
DSTMA.010.003.070	0.1	0.03	0.25	0.7	0.084	4	50	2	40°	20°	▲
DSTMA.020.005.030	0.2	0.05	0.5	0.6	0.18	4	50	2	20°	-°	▲
DSTMA.020.005.070	0.2	0.05	0.5	1.4	0.18	4	50	2	40°	20°	▲
DSTMA.030.005.030	0.3	0.05	0.75	0.9	0.28	4	50	2	20°	-°	▲
DSTMA.030.005.050	0.3	0.05	0.75	1.5	0.28	4	50	2	40°	20°	▲
DSTMA.030.005.070	0.3	0.05	0.75	2.1	0.28	4	50	2	40°	20°	▲
DSTMA.050.005.030	0.5	0.05	1.25	1.5	0.47	4	50	2	20°	-°	▲
DSTMA.050.005.050	0.5	0.05	1.25	2.5	0.47	4	50	2	40°	20°	▲
DSTMA.050.005.070	0.5	0.05	1.25	3.5	0.47	4	50	2	40°	20°	▲
DSTMA.050.010.050	0.5	0.1	1.25	2.5	0.47	4	50	2	40°	20°	▲
DSTMA.050.010.070	0.5	0.1	1.25	3.5	0.47	4	50	2	40°	20°	▲
DSTMA.060.005.050	0.6	0.05	1.5	3	0.56	4	50	2	40°	20°	▲
DSTMA.080.005.030	0.8	0.05	2	2.4	0.75	4	50	2	20°	-°	▲
DSTMA.080.005.050	0.8	0.05	2	4	0.75	4	50	2	40°	20°	▲
DSTMA.080.010.030	0.8	0.1	2	2.4	0.75	4	50	2	20°	-°	▲
DSTMA.080.010.070	0.8	0.1	2	5.6	0.75	4	50	2	40°	20°	▲


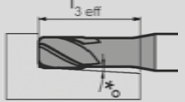


P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSTMA Ø 0.1 - 0.8 mm

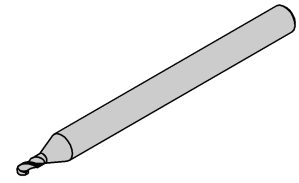
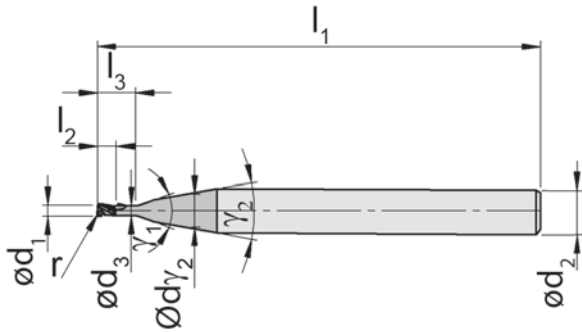
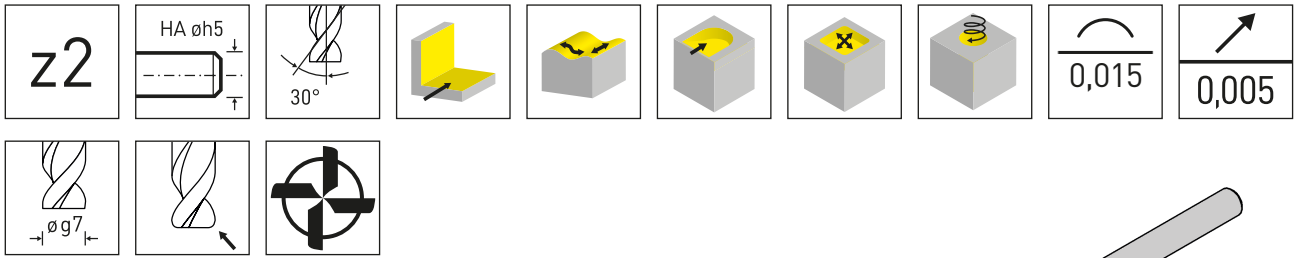
Cutting Data DSTMA Ø 0.1 - 0.8 mm



	 $vc = m/min$	 $vc = m/min$
N1.1	450	480
N1.2	450	480
N2.1	350	380
N2.2	350	380
N2.3	200	230
N3.1	250	280
N3.2	300	330
N3.3	200	230
N3.4	200	230

d_1												
		0°	0.5°	1°	2°	3°	f_z	a_e	a_p	f_z	a_e	a_p
0.1	3°	0.7	0.7	0.7	0.8	0.9	0.004	0.03	0.10	0.005	0.01	0.01
0.2	7°	0.6	0.6	0.6	0.7	0.8	0.006	0.06	0.20	0.007	0.01	0.02
0.2	3°	1.4	1.4	1.4	1.5	1.6	0.004	0.06	0.20	0.006	0.01	0.01
0.3	7°	0.9	0.9	0.9	1.1	1.2	0.007	0.09	0.30	0.009	0.02	0.03
0.3	5°	1.5	1.5	1.5	1.6	1.7	0.006	0.09	0.30	0.008	0.02	0.02
0.3	3°	2.1	2.1	2.2	2.3	2.4	0.005	0.09	0.30	0.007	0.02	0.02
0.5	7°	1.5	1.5	1.6	1.8	2.1	0.009	0.15	0.50	0.012	0.03	0.05
0.5	5°	2.5	2.5	2.6	2.7	2.9	0.008	0.15	0.50	0.011	0.03	0.04
0.5	3°	3.5	3.5	3.6	3.8	4.0	0.007	0.15	0.50	0.009	0.03	0.03
0.5	5°	2.5	2.5	2.6	2.7	2.9	0.008	0.15	0.50	0.011	0.03	0.04
0.5	3°	3.5	3.5	3.6	3.8	4.0	0.007	0.15	0.50	0.009	0.03	0.03
0.6	5°	3.0	3.0	3.1	3.3	3.5	0.009	0.18	0.60	0.012	0.03	0.05
0.8	7°	2.4	2.5	2.6	2.9	3.3	0.012	0.24	0.80	0.016	0.04	0.08
0.8	5°	4.0	4.0	4.2	4.4	4.6	0.010	0.24	0.80	0.015	0.04	0.06
0.8	7°	2.4	2.5	2.6	2.9	3.3	0.012	0.24	0.80	0.016	0.04	0.08
0.8	3°	5.6	5.7	5.8	6.1	6.5	0.009	0.24	0.80	0.013	0.04	0.05

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	MG3K
DSTMA.100.005.030	1	0.05	2.5	3	0.95	4	50	2	20°	-°	▲
DSTMA.100.005.050	1	0.05	2.5	5	0.95	4	50	2	40°	20°	▲
DSTMA.100.010.030	1	0.1	2.5	3	0.95	4	50	2	20°	-°	▲
DSTMA.100.010.050	1	0.1	2.5	5	0.95	4	50	2	40°	20°	▲
DSTMA.100.010.070	1	0.1	2.5	7	0.95	4	50	2	40°	20°	▲
DSTMA.120.005.030	1.2	0.05	3	3.6	1.15	4	50	2	20°	-°	▲
DSTMA.120.005.070	1.2	0.05	3	8.4	1.15	4	50	2	40°	20°	▲
DSTMA.120.010.030	1.2	0.1	3	3.6	1.15	4	50	2	20°	-°	▲
DSTMA.120.010.050	1.2	0.1	3	6	1.15	4	50	2	40°	20°	▲
DSTMA.120.010.070	1.2	0.1	3	8.4	1.15	4	50	2	40°	20°	▲
DSTMA.150.010.030	1.5	0.1	3.75	4.5	1.45	4	50	2	20°	-°	▲
DSTMA.150.010.050	1.5	0.1	3.75	7.5	1.45	4	50	2	40°	20°	▲
DSTMA.150.010.070	1.5	0.1	3.75	10.5	1.45	4	50	2	40°	20°	▲
DSTMA.150.020.030	1.5	0.2	3.75	4.5	1.45	4	50	2	20°	-°	▲
DSTMA.150.020.050	1.5	0.2	3.75	7.5	1.45	4	50	2	40°	20°	▲
DSTMA.150.020.070	1.5	0.2	3.75	10.5	1.45	4	50	2	40°	20°	▲
DSTMA.150.050.030	1.5	0.5	3.75	4.5	1.45	4	50	2	20°	-°	▲
DSTMA.150.050.050	1.5	0.5	3.75	7.5	1.45	4	50	2	40°	20°	▲
DSTMA.150.050.070	1.5	0.5	3.75	10.5	1.45	4	50	2	40°	20°	▲
DSTMA.200.010.030	2	0.1	5	6	1.9	4	50	2	20°	-°	▲
DSTMA.200.010.050	2	0.1	5	10	1.9	4	50	2	40°	20°	▲
DSTMA.200.010.070	2	0.1	5	14	1.9	4	50	2	40°	20°	▲
DSTMA.200.020.030	2	0.2	5	6	1.9	4	50	2	20°	-°	▲
DSTMA.200.020.050	2	0.2	5	10	1.9	4	50	2	40°	20°	▲
DSTMA.200.020.070	2	0.2	5	14	1.9	4	50	2	40°	20°	▲
DSTMA.200.050.030	2	0.5	5	6	1.9	4	50	2	20°	-°	▲
DSTMA.200.050.050	2	0.5	5	10	1.9	4	50	2	40°	20°	▲
DSTMA.200.050.070	2	0.5	5	14	1.9	4	50	2	40°	20°	▲


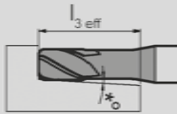


P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSTMA Ø 1 - 2 mm

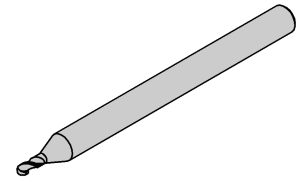
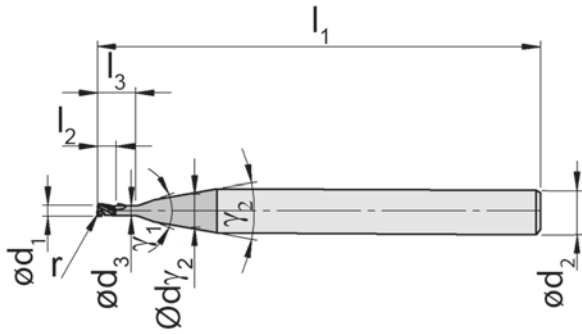
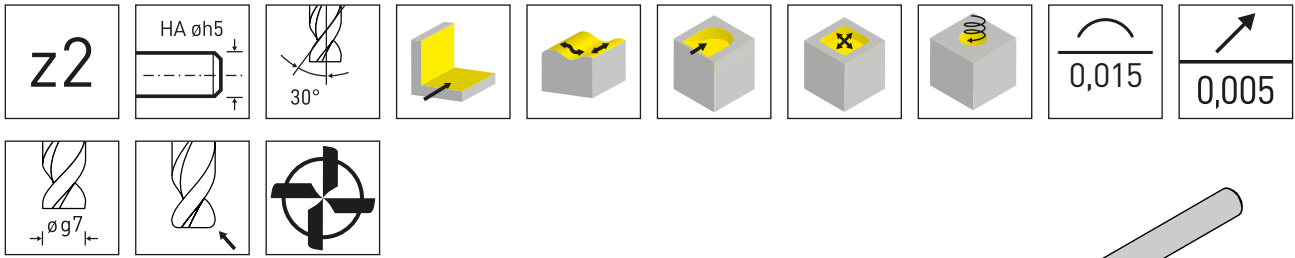
Cutting Data DSTMA Ø 1 - 2 mm



	 $vc = m/min$	 $vc = m/min$
N1.1	450	480
N1.2	450	480
N2.1	350	380
N2.2	350	380
N2.3	200	230
N3.1	250	280
N3.2	300	330
N3.3	200	230
N3.4	200	230

d_1												
		0°	0.5°	1°	2°	3°	f_z	a_e	a_p	f_z	a_e	a_p
1.0	7°	3.0	3.1	3.3	3.7	4.2	0.014	0.30	1.00	0.019	0.05	0.10
1.0	5°	5.0	5.1	5.2	5.5	5.8	0.012	0.30	1.00	0.017	0.05	0.08
1.0	7°	3.0	3.1	3.3	3.7	4.2	0.014	0.30	1.00	0.019	0.05	0.10
1.0	5°	5.0	5.1	5.2	5.5	5.8	0.012	0.30	1.00	0.017	0.05	0.08
1.0	3°	7.0	7.1	7.3	7.7	8.1	0.011	0.30	1.00	0.015	0.05	0.06
1.2	7°	3.6	3.7	3.9	4.4	5.1	0.016	0.36	1.20	0.022	0.06	0.12
1.2	3°	8.4	8.6	8.8	9.2	10.0	0.013	0.36	1.20	0.018	0.06	0.07
1.2	7°	3.6	3.7	3.9	4.4	5.0	0.016	0.36	1.20	0.022	0.06	0.12
1.2	5°	6.0	6.1	6.3	6.6	6.9	0.014	0.36	1.20	0.020	0.06	0.10
1.2	3°	8.4	8.6	8.8	9.2	10.0	0.013	0.36	1.20	0.018	0.06	0.07
1.5	7°	4.5	4.7	4.9	5.5	6.3	0.019	0.45	1.50	0.027	0.08	0.15
1.5	5°	7.5	7.6	7.8	8.2	8.7	0.017	0.45	1.50	0.024	0.08	0.12
1.5	3°	10.5	10.7	11.0	11.6	12.6	0.015	0.45	1.50	0.021	0.08	0.09
1.5	7°	4.5	4.7	4.9	5.5	6.3	0.019	0.45	1.50	0.027	0.08	0.15
1.5	5°	7.5	7.6	7.8	8.2	8.7	0.017	0.45	1.50	0.024	0.08	0.12
1.5	3°	10.5	10.7	11.0	11.5	12.5	0.015	0.45	1.50	0.021	0.08	0.09
1.5	7°	4.5	4.7	4.9	5.4	6.2	0.019	0.45	1.50	0.027	0.08	0.15
1.5	5°	7.5	7.6	7.8	8.2	8.6	0.017	0.45	1.50	0.024	0.08	0.12
1.5	3°	10.5	10.7	11.0	11.5	12.4	0.015	0.45	1.50	0.021	0.08	0.09
2.0	7°	6.0	6.3	6.6	7.4	8.5	0.024	0.60	2.00	0.034	0.10	0.20
2.0	5°	10.0	10.2	10.5	11.0	11.9	0.021	0.60	2.00	0.031	0.10	0.16
2.0	3°	14.0	14.3	14.7	15.4	17.6	0.019	0.60	2.00	0.027	0.10	0.12
2.0	7°	6.0	6.3	6.6	7.4	8.4	0.024	0.60	2.00	0.034	0.10	0.20
2.0	5°	10.0	10.2	10.4	11.0	11.8	0.021	0.60	2.00	0.031	0.10	0.16
2.0	3°	14.0	14.3	14.7	15.4	17.5	0.019	0.60	2.00	0.027	0.10	0.12
2.0	7°	6.0	6.2	6.6	7.3	8.3	0.024	0.60	2.00	0.034	0.10	0.20
2.0	5°	10.0	11.7	11.0	10.4	10.2	0.021	0.60	2.00	0.031	0.10	0.16
2.0	3°	14.0	14.3	14.6	15.4	17.4	0.019	0.60	2.00	0.027	0.10	0.12

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	MG3K
DSTMA.250.010.030	2.5	0.1	6.25	7.5	2.4	4	50	2	20°	-°	▲
DSTMA.250.010.050	2.5	0.1	6.25	12.5	2.4	4	50	2	40°	20°	▲
DSTMA.250.010.070	2.5	0.1	6.25	17.5	2.4	4	50	2	40°	20°	▲
DSTMA.250.020.030	2.5	0.2	6.25	7.5	2.4	4	50	2	20°	-°	▲
DSTMA.250.020.050	2.5	0.2	6.25	12.5	2.4	4	50	2	40°	20°	▲
DSTMA.250.020.070	2.5	0.2	6.25	17.5	2.4	4	50	2	40°	20°	▲
DSTMA.250.050.030	2.5	0.5	6.25	7.5	2.4	4	50	2	20°	-°	▲
DSTMA.250.050.050	2.5	0.5	6.25	12.5	2.4	4	50	2	40°	20°	▲
DSTMA.250.050.070	2.5	0.5	6.25	17.5	2.4	4	50	2	40°	20°	▲
DSTMA.300.010.030	3	0.1	7.5	9	2.9	4	50	2	20°	-°	▲
DSTMA.300.010.050	3	0.1	7.5	15	2.9	4	50	2	40°	20°	▲
DSTMA.300.010.070	3	0.1	7.5	21	2.9	4	64	2	40°	20°	▲
DSTMA.300.020.030	3	0.2	7.5	9	2.9	4	50	2	20°	-°	▲
DSTMA.300.020.050	3	0.2	7.5	15	2.9	4	50	2	40°	20°	▲
DSTMA.300.020.070	3	0.2	7.5	21	2.9	4	64	2	40°	20°	▲
DSTMA.300.050.030	3	0.5	7.5	9	2.9	4	50	2	20°	-°	▲
DSTMA.300.050.050	3	0.5	7.5	15	2.9	4	50	2	40°	20°	▲
DSTMA.300.050.070	3	0.5	7.5	21	2.9	4	64	2	40°	20°	▲
DSTMA.300.100.030	3	1	7.5	9	2.9	4	50	2	20°	-°	▲
DSTMA.300.100.050	3	1	7.5	15	2.9	4	50	2	40°	20°	▲
DSTMA.300.100.070	3	1	7.5	21	2.9	4	64	2	40°	20°	▲


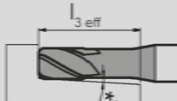


P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSTMA Ø 2.5 - 3 mm

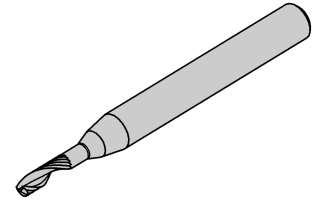
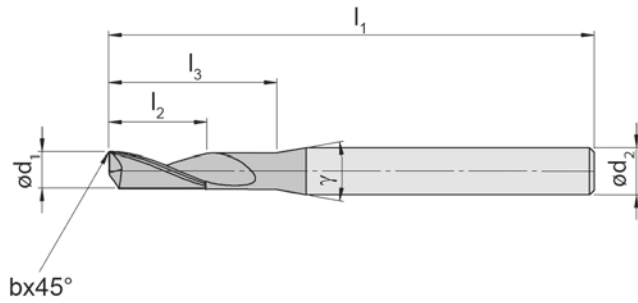
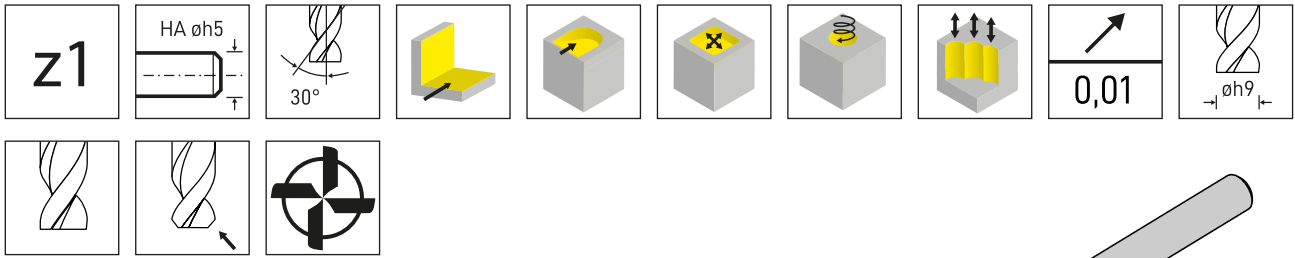
Cutting Data DSTMA Ø 2.5 - 3 mm



	 vc = m/min	 vc = m/min
N1.1	450	480
N1.2	450	480
N2.1	350	380
N2.2	350	380
N2.3	200	230
N3.1	250	280
N3.2	300	330
N3.3	200	230
N3.4	200	230

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
2.5	7°	7.5	7.8	8.3	9.3	10.6	0.029	0.75	2.50	0.041	0.13	0.25
2.5	5°	12.5	12.8	13.1	13.8	∞	0.026	0.75	2.50	0.037	0.13	0.20
2.5	3°	17.5	17.9	18.3	19.8	∞	0.023	0.75	2.50	0.033	0.13	0.15
2.5	7°	7.5	7.8	8.3	9.3	10.5	0.029	0.75	2.50	0.041	0.13	0.25
2.5	5°	12.5	12.8	13.1	13.8	∞	0.026	0.75	2.50	0.037	0.13	0.20
2.5	3°	17.5	17.9	18.3	19.7	∞	0.023	0.75	2.50	0.033	0.13	0.15
2.5	7°	7.5	7.8	8.2	9.2	10.4	0.029	0.75	2.50	0.041	0.13	0.25
2.5	5°	12.5	12.7	13.1	13.7	∞	0.026	0.75	2.50	0.037	0.13	0.20
2.5	3°	17.5	17.9	18.3	19.7	∞	0.023	0.75	2.50	0.033	0.13	0.15
3.0	7°	9.0	9.4	9.9	11.2	12.7	0.034	0.90	3.00	0.049	0.15	0.30
3.0	5°	15.0	15.3	15.7	∞	∞	0.031	0.90	3.00	0.044	0.15	0.24
3.0	3°	21.0	21.5	22.3	∞	∞	0.027	0.90	3.00	0.039	0.15	0.18
3.0	7°	9.0	9.4	9.9	11.1	∞	0.034	0.90	3.00	0.049	0.15	0.30
3.0	5°	15.0	15.3	15.7	∞	∞	0.031	0.90	3.00	0.044	0.15	0.24
3.0	3°	21.0	21.5	22.3	∞	∞	0.027	0.90	3.00	0.039	0.15	0.18
3.0	7°	9.0	9.4	9.9	11.1	∞	0.034	0.90	3.00	0.049	0.15	0.30
3.0	5°	15.0	15.3	15.7	∞	19.9	0.031	0.90	3.00	0.044	0.15	0.24
3.0	3°	21.0	21.5	22.2	∞	28.4	0.027	0.90	3.00	0.039	0.15	0.18
3.0	7°	9.0	9.4	9.8	10.9	∞	0.034	0.90	3.00	0.049	0.15	0.30
3.0	5°	15.0	15.3	15.7	∞	∞	0.031	0.90	3.00	0.044	0.15	0.24
3.0	3°	21.0	21.4	22.2	∞	∞	0.027	0.90	3.00	0.039	0.15	0.18

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	MG3K
DSA.1.003.050	0.3	1.05	1.5	0.28	4	50	1	40°	20°	▲
DSA.1.004.030	0.4	1	1.2	0.38	4	50	1	20°	-°	▲
DSA.1.005.050	0.5	1.75	2.5	0.47	4	50	1	40°	20°	▲
DSA.1.005.053	0.5	2.5	2.65	0.47	4	50	1	40°	20°	▲
DSA.1.006.053	0.6	3	3.18	0.56	4	50	1	40°	20°	▲
DSA.1.008.030	0.8	2	2.4	0.75	4	50	1	20°	-°	▲
DSA.1.008.053	0.8	4	4.24	0.75	4	50	1	40°	20°	▲
DSA.1.010.030	1	2.5	3	0.95	4	50	1	20°	-°	▲
DSA.1.010.050	1	3.5	5	0.95	4	50	1	40°	20°	▲
DSA.1.010.053	1	5	5.3	0.95	4	50	1	40°	20°	▲
DSA.1.012.030	1.2	3	3.6	1.15	4	50	1	20°	-°	▲
DSA.1.012.050	1.2	4.2	6	1.15	4	50	1	40°	20°	▲
DSA.1.012.053	1.2	6	6.36	1.15	4	50	1	40°	20°	▲
DSA.1.015.030	1.5	3.75	4.5	1.45	4	50	1	20°	-°	▲
DSA.1.015.050	1.5	5.25	7.5	1.45	4	50	1	40°	20°	▲
DSA.1.015.053	1.5	7.5	7.95	1.45	4	50	1	40°	20°	▲
DSA.1.018.030	1.8	4.5	5.4	1.75	4	50	1	20°	-°	▲
DSA.1.018.050	1.8	6.3	9	1.75	4	50	1	40°	20°	▲
DSA.1.018.053	1.8	9	9.54	1.75	4	50	1	40°	20°	▲




P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSA Ø 0.3 - 1.8 mm

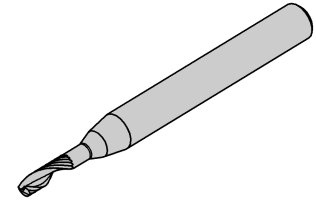
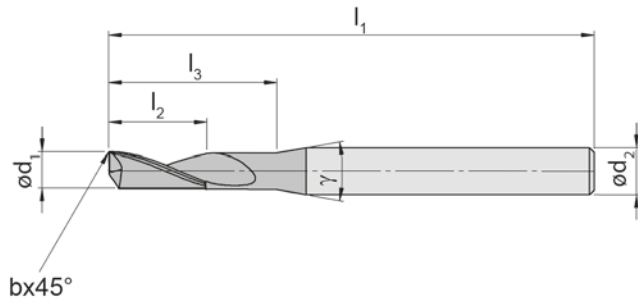
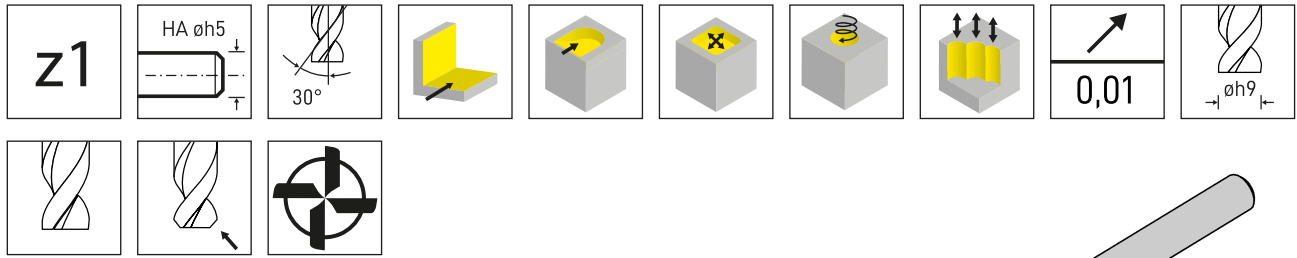
Cutting Data DSA Ø 0.3 - 1.8 mm



	 vc = m/min	 vc = m/min
N1.1	300	380
N1.2	300	380
N2.1	250	330
N2.2	200	280
N2.3	-	-
N3.1	250	330
N3.2	300	380
N3.3	-	-
N3.4	-	-

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
0.3	5°	0.016	0.30	0.45	0.031	0.08	0.75
0.4	7°	0.022	0.40	0.60	0.045	0.10	1.00
0.5	5°	0.016	0.50	0.75	0.032	0.13	1.25
0.5	3°	0.016	0.50	0.75	0.032	0.13	2.50
0.6	3°	0.016	0.60	0.90	0.032	0.15	3.00
0.8	7°	0.023	0.80	1.20	0.046	0.20	2.00
0.8	3°	0.016	0.80	1.20	0.032	0.20	4.00
1.0	7°	0.023	1.00	1.50	0.046	0.25	2.50
1.0	5°	0.016	1.00	1.50	0.032	0.25	2.50
1.0	3°	0.016	1.00	1.50	0.032	0.25	5.00
1.2	7°	0.023	1.20	1.80	0.047	0.30	3.00
1.2	5°	0.016	1.20	1.80	0.033	0.30	3.00
1.2	3°	0.016	1.20	1.80	0.033	0.30	6.00
1.5	7°	0.024	1.50	2.25	0.048	0.38	3.75
1.5	5°	0.017	1.50	2.25	0.033	0.38	3.75
1.5	3°	0.017	1.50	2.25	0.033	0.38	7.50
1.8	7°	0.024	1.80	2.70	0.048	0.45	4.50
1.8	5°	0.017	1.80	2.70	0.034	0.45	4.50
1.8	3°	0.017	1.80	2.70	0.034	0.45	9.00

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	b	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ ₁	γ ₂	MG3K
DSA.1.020.030	2	-	5	6	1.9	4	50	1	20°	-°	▲
DSA.1.020.050	2	-	7	10	1.9	4	50	1	40°	20°	▲
DSA.1.020.053	2	-	10	10.6	1.9	4	50	1	40°	20°	▲
DSA.1.025.030	2.5	-	6.25	7.5	2.4	4	50	1	20°	-°	▲
DSA.1.025.050	2.5	-	8.75	12.5	2.4	4	50	1	40°	20°	▲
DSA.1.025.053	2.5	-	12.5	13.25	2.4	4	64	1	40°	20°	▲
DSA.1.030.030	3	0.1	7.5	9	2.9	4	50	1	20°	-°	▲
DSA.1.030.050	3	0.1	10.5	15	2.9	4	64	1	40°	20°	▲
DSA.1.030.053	3	0.1	15	15.9	2.9	4	64	1	40°	20°	▲
DSA.1.040.030	4	0.1	10	12	3.8	6	54	1	20°	-°	▲
DSA.1.040.050	4	0.1	14	20	3.8	6	64	1	20°	-°	▲
DSA.1.040.053	4	0.1	20	21.2	3.8	6	64	1	20°	-°	▲
DSA.1.050.030	5	0.1	12.5	15	4.7	6	64	1	20°	-°	▲
DSA.1.050.050	5	0.1	17.5	25	4.7	6	64	1	20°	-°	▲
DSA.1.050.053	5	0.1	25	26.5	4.7	6	64	1	20°	-°	▲
DSA.1.060.030	6	0.2	15	18	5.6	6	64	1	-°	-°	▲
DSA.1.060.050	6	0.2	21	30	5.6	6	82	1	-°	-°	▲
DSA.1.060.053	6	0.2	30	31.8	5.6	6	82	1	-°	-°	▲
DSA.1.080.030	8	0.2	20	24	7.5	8	64	1	-°	-°	▲
DSA.1.080.050	8	0.2	28	40	7.5	8	82	1	-°	-°	▲
DSA.1.080.053	8	0.2	40	42.4	7.5	8	82	1	-°	-°	▲
DSA.1.100.030	10	0.2	25	30	9.5	10	82	1	-°	-°	▲
DSA.1.100.050	10	0.2	35	50	9.5	10	108	1	-°	-°	▲
DSA.1.100.053	10	0.2	50	53	9.5	10	108	1	-°	-°	▲
DSA.1.120.030	12	0.2	30	36	11.5	12	82	1	-°	-°	▲
DSA.1.120.050	12	0.2	42	60	11.5	12	108	1	-°	-°	▲
DSA.1.120.053	12	0.2	60	63.6	11.5	12	108	1	-°	-°	▲

P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSA Ø 2 - 12 mm

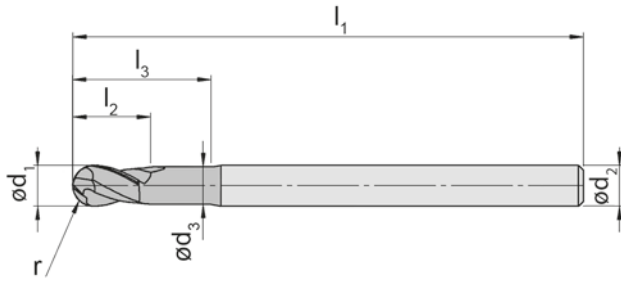
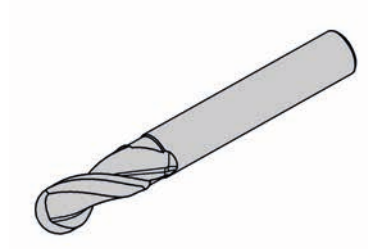
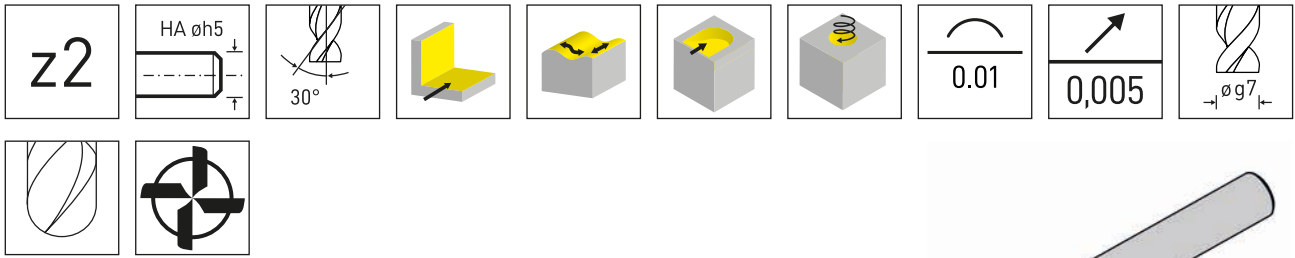
Cutting Data DSA Ø 2 - 12 mm



	 $vc = m/min$	 $vc = m/min$
N1.1	300	380
N1.2	300	380
N2.1	250	330
N2.2	200	280
N2.3	-	-
N3.1	250	330
N3.2	300	380
N3.3	-	-
N3.4	-	-

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
2.0	7°	0.027	2.00	3.00	0.045	0.50	5.00
2.0	5°	0.019	2.00	3.00	0.031	0.50	5.00
2.0	3°	0.019	2.00	3.00	0.031	0.50	10.00
2.5	7°	0.032	2.50	3.75	0.052	0.63	6.25
2.5	5°	0.022	2.50	3.75	0.037	0.63	6.25
2.5	3°	0.022	2.50	3.75	0.037	0.63	12.50
3.0	7°	0.037	3.00	4.50	0.060	0.75	7.50
3.0	5°	0.026	3.00	4.50	0.042	0.75	7.50
3.0	3°	0.026	3.00	4.50	0.042	0.75	15.00
4.0	7°	0.047	4.00	6.00	0.075	1.00	10.00
4.0	5°	0.033	4.00	6.00	0.053	1.00	10.00
4.0	3°	0.033	4.00	6.00	0.053	1.00	20.00
5.0	7°	0.057	5.00	7.50	0.091	1.25	12.50
5.0	5°	0.040	5.00	7.50	0.063	1.25	12.50
5.0	3°	0.040	5.00	7.50	0.063	1.25	25.00
6.0	7°	0.067	6.00	9.00	0.106	1.50	15.00
6.0	5°	0.047	6.00	9.00	0.074	1.50	15.00
6.0	3°	0.047	6.00	9.00	0.074	1.50	30.00
8.0	7°	0.087	8.00	12.00	0.137	2.00	20.00
8.0	5°	0.061	8.00	12.00	0.096	2.00	20.00
8.0	3°	0.061	8.00	12.00	0.096	2.00	40.00
10.0	7°	0.107	10.00	15.00	0.168	2.50	25.00
10.0	5°	0.075	10.00	15.00	0.117	2.50	25.00
10.0	3°	0.075	10.00	15.00	0.117	2.50	50.00
12.0	7°	0.127	12.00	18.00	0.198	3.00	30.00
12.0	5°	0.089	12.00	18.00	0.139	3.00	30.00
12.0	3°	0.089	12.00	18.00	0.139	3.00	60.00

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	MG3K
DSKA.2.040.030	4	2	10	12	3.8	6	64	2	20°	▲
DSKA.2.040.050	4	2	10	20	3.8	6	64	2	20°	▲
DSKA.2.040.070	4	2	10	28	3.8	6	70	2	20°	▲
DSKA.2.050.030	5	2.5	12.5	15	4.7	6	64	2	20°	▲
DSKA.2.050.050	5	2.5	12.5	25	4.7	6	64	2	20°	▲
DSKA.2.050.070	5	2.5	12.5	35	4.7	6	82	2	20°	▲
DSKA.2.060.030	6	3	15	18	5.6	6	64	2	-°	▲
DSKA.2.060.050	6	3	15	30	5.6	6	82	2	-°	▲
DSKA.2.060.070	6	3	15	42	5.6	6	82	2	-°	▲
DSKA.2.080.030	8	4	20	24	7.5	8	64	2	-°	▲
DSKA.2.080.050	8	4	20	40	7.5	8	82	2	-°	▲
DSKA.2.080.070	8	4	20	56	7.5	8	108	2	-°	▲
DSKA.2.100.030	10	5	25	30	9.5	10	82	2	-°	▲
DSKA.2.100.050	10	5	25	50	9.5	10	108	2	-°	▲
DSKA.2.100.070	10	5	25	70	9.5	10	120	2	-°	▲
DSKA.2.120.030	12	6	30	36	11.5	12	82	2	-°	▲
DSKA.2.120.050	12	6	30	60	11.5	12	108	2	-°	▲
DSKA.2.120.070	12	6	30	84	11.5	12	140	2	-°	▲
DSKA.2.160.030	16	8	40	48	15	16	108	2	-°	▲
DSKA.2.160.050	16	8	40	80	15	16	140	2	-°	▲
DSKA.2.200.030	20	10	50	60	19	20	120	2	-°	▲
DSKA.2.200.050	20	10	50	100	19	20	163	2	-°	▲

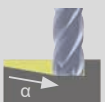


P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSKA Ø 4 - 20 mm

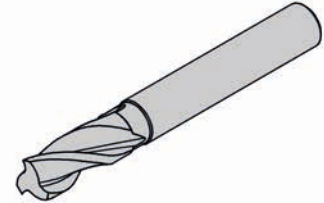
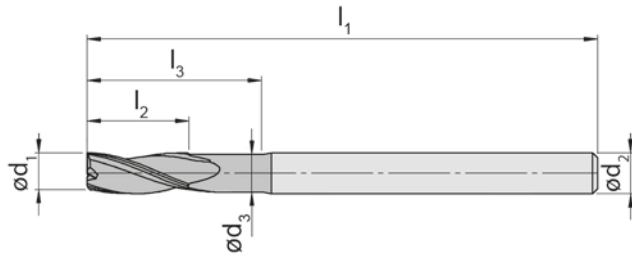
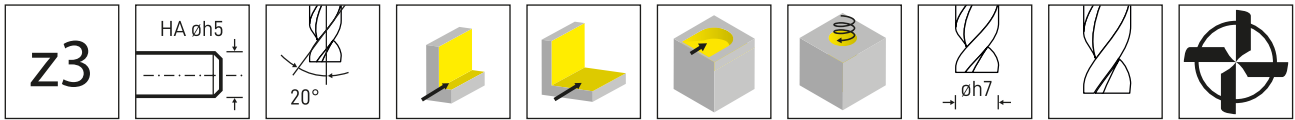
Cutting Data DSKA Ø 4 - 20 mm



	 vc = m/min	 vc = m/min
N1.1	450	500
N1.2	450	500
N2.1	350	400
N2.2	350	400
N2.3	200	250
N3.1	250	300
N3.2	300	350
N3.3	200	250
N3.4	200	250

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
4	15°	0.044	1.20	4.00	0.037	0.12	0.40
4	10°	0.040	1.20	4.00	0.033	0.12	0.32
4	5°	0.035	1.20	4.00	0.030	0.12	0.24
5	15°	0.054	1.50	5.00	0.047	0.13	0.50
5	10°	0.049	1.50	5.00	0.042	0.13	0.40
5	5°	0.043	1.50	5.00	0.037	0.13	0.30
6	15°	0.064	1.80	6.00	0.056	0.14	0.60
6	10°	0.058	1.80	6.00	0.051	0.14	0.48
6	5°	0.052	1.80	6.00	0.045	0.14	0.36
8	15°	0.085	2.40	8.00	0.077	0.16	0.80
8	10°	0.076	2.40	8.00	0.069	0.16	0.64
8	5°	0.068	2.40	8.00	0.061	0.16	0.48
10	15°	0.105	3.00	10.00	0.097	0.18	1.00
10	10°	0.094	3.00	10.00	0.088	0.18	0.80
10	5°	0.084	3.00	10.00	0.078	0.18	0.60
12	15°	0.125	3.60	12.00	0.118	0.20	1.20
12	10°	0.113	3.60	12.00	0.107	0.20	0.96
12	5°	0.100	3.60	12.00	0.095	0.20	0.72
16	15°	0.166	4.80	16.00	0.161	0.24	1.60
16	10°	0.149	4.80	16.00	0.145	0.24	1.28
20	15°	0.206	6.00	20.00	0.204	0.28	2.00
20	10°	0.186	6.00	20.00	0.184	0.28	1.60

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	MG3K
DSA.3.040.030	4	10	12	3.8	6	64	3	20°	▲
DSA.3.040.050	4	10	20	3.8	6	64	3	20°	▲
DSA.3.040.053	4	20	21.2	3.8	6	64	3	20°	▲
DSA.3.040.070	4	20	28	3.8	6	70	3	20°	▲
DSA.3.050.030	5	12.5	15	4.7	6	64	3	20°	▲
DSA.3.050.050	5	12.5	25	4.7	6	64	3	20°	▲
DSA.3.050.053	5	25	26.5	4.7	6	64	3	20°	▲
DSA.3.050.070	5	25	35	4.7	6	82	3	20°	▲
DSA.3.060.030	6	15	18	5.6	6	64	3	-°	▲
DSA.3.060.050	6	15	30	5.6	6	82	3	-°	▲
DSA.3.060.053	6	30	31.8	5.6	6	82	3	-°	▲
DSA.3.060.070	6	30	42	5.6	6	82	3	-°	▲
DSA.3.080.030	8	20	24	7.5	8	64	3	-°	▲
DSA.3.080.050	8	20	40	7.5	8	82	3	-°	▲
DSA.3.080.053	8	40	42.4	7.5	8	82	3	-°	▲
DSA.3.080.070	8	40	56	7.5	8	108	3	-°	▲
DSA.3.100.030	10	25	30	9.5	10	82	3	-°	▲
DSA.3.100.050	10	25	50	9.5	10	108	3	-°	▲
DSA.3.100.053	10	50	53	9.5	10	108	3	-°	▲
DSA.3.100.070	10	50	70	9.5	10	120	3	-°	▲
DSA.3.120.030	12	30	36	11.5	12	82	3	-°	▲
DSA.3.120.050	12	30	60	11.5	12	108	3	-°	▲
DSA.3.120.053	12	60	63.6	11.5	12	108	3	-°	▲
DSA.3.120.070	12	60	84	11.5	12	140	3	-°	▲
DSA.3.160.030	16	40	48	15	16	108	3	-°	▲
DSA.3.160.050	16	40	80	15	16	140	3	-°	▲
DSA.3.160.053	16	80	84.8	15	16	140	3	-°	▲
DSA.3.200.027	20	50	54	19	20	108	3	-°	▲
DSA.3.200.050	20	50	100	19	20	163	3	-°	▲
DSA.3.200.053	20	100	106	19	20	163	3	-°	▲




P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSA Ø 4 - 20 mm

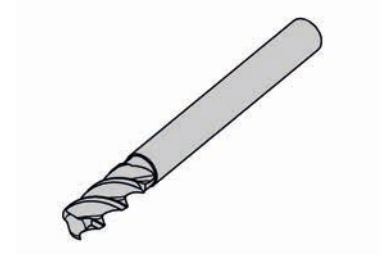
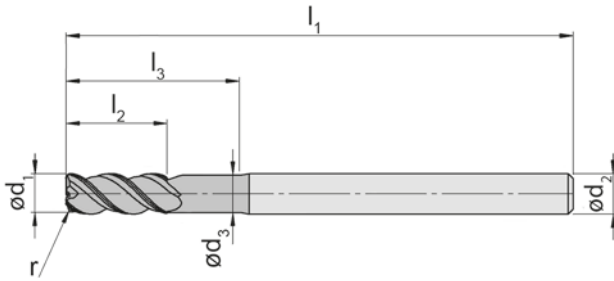
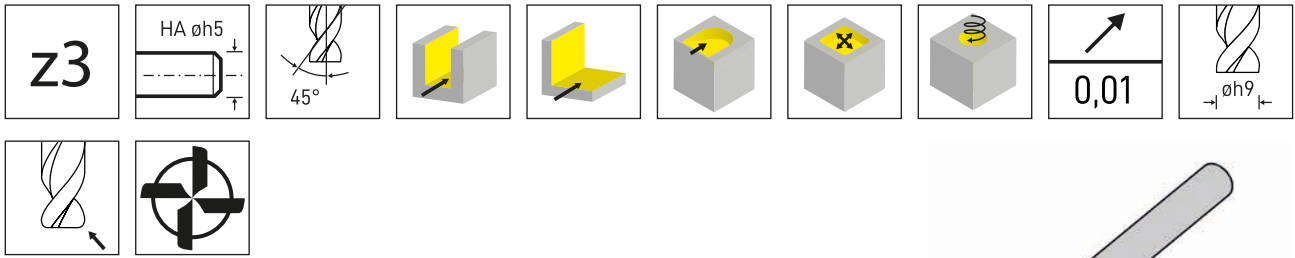
Cutting Data DSA Ø 4 - 20 mm



	 $vc = m/min$	 $vc = m/min$
N1.1	400	450
N1.2	400	450
N2.1	350	400
N2.2	350	400
N2.3	200	250
N3.1	250	300
N3.2	300	350
N3.3	200	250
N3.4	200	250

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
4	7°	0.020	1.00	10.00	0.018	0.20	10.00
4	5°	0.014	1.00	10.00	0.012	0.20	10.00
4	3°	0.014	1.00	20.00	0.012	0.20	20.00
4	3°	0.008	1.00	20.00	0.007	0.20	20.00
5	7°	0.028	1.25	12.50	0.027	0.25	12.50
5	5°	0.020	1.25	12.50	0.019	0.25	12.50
5	3°	0.020	1.25	25.00	0.019	0.25	25.00
5	3°	0.011	1.25	25.00	0.011	0.25	25.00
6	7°	0.036	1.50	15.00	0.036	0.30	15.00
6	5°	0.025	1.50	15.00	0.025	0.30	15.00
6	3°	0.025	1.50	30.00	0.025	0.30	30.00
6	3°	0.014	1.50	30.00	0.014	0.30	30.00
8	7°	0.052	2.00	20.00	0.053	0.40	20.00
8	5°	0.036	2.00	20.00	0.037	0.40	20.00
8	3°	0.036	2.00	40.00	0.037	0.40	40.00
8	3°	0.021	2.00	40.00	0.021	0.40	40.00
10	7°	0.068	2.50	25.00	0.071	0.50	25.00
10	5°	0.048	2.50	25.00	0.050	0.50	25.00
10	3°	0.048	2.50	50.00	0.050	0.50	50.00
10	3°	0.027	2.50	50.00	0.029	0.50	50.00
12	7°	0.084	3.00	30.00	0.089	0.60	30.00
12	5°	0.059	3.00	30.00	0.062	0.60	30.00
12	3°	0.059	3.00	60.00	0.062	0.60	60.00
12	3°	0.034	3.00	60.00	0.036	0.60	60.00
16	7°	0.116	4.00	40.00	0.125	0.80	40.00
16	5°	0.081	4.00	40.00	0.088	0.80	40.00
16	3°	0.081	4.00	80.00	0.088	0.80	80.00
20	7°	0.148	5.00	50.00	0.161	1.00	50.00
20	5°	0.104	5.00	50.00	0.113	1.00	50.00
20	3°	0.104	5.00	100.00	0.113	1.00	100.00

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	MG3K
DSRA.3.040.010.030	4	0.1	10	12	3.8	6	64	3	20°	▲
DSRA.3.040.010.050	4	0.1	10	20	3.8	6	64	3	20°	▲
DSRA.3.040.010.053	4	0.1	20	21.2	3.8	6	64	3	20°	▲
DSRA.3.040.010.070	4	0.1	20	28	3.8	6	70	3	20°	▲
DSRA.3.040.050.030	4	0.5	10	12	3.8	6	64	3	20°	▲
DSRA.3.040.050.050	4	0.5	10	20	3.8	6	64	3	20°	▲
DSRA.3.040.050.053	4	0.5	20	21.2	3.8	6	64	3	20°	▲
DSRA.3.040.050.070	4	0.5	20	28	3.8	6	70	3	20°	▲
DSRA.3.040.100.030	4	1	10	12	3.8	6	64	3	20°	▲
DSRA.3.040.100.050	4	1	10	20	3.8	6	64	3	20°	▲
DSRA.3.040.100.053	4	1	20	21.2	3.8	6	64	3	20°	▲
DSRA.3.040.100.070	4	1	20	28	3.8	6	70	3	20°	▲
DSRA.3.050.010.030	5	0.1	12.5	15	4.7	6	64	3	20°	▲
DSRA.3.050.010.050	5	0.1	12.5	25	4.7	6	64	3	20°	▲
DSRA.3.050.010.053	5	0.1	25	26.5	4.7	6	64	3	20°	▲
DSRA.3.050.010.070	5	0.1	25	35	4.7	6	82	3	20°	▲
DSRA.3.050.050.030	5	0.5	12.5	15	4.7	6	64	3	20°	▲
DSRA.3.050.050.050	5	0.5	12.5	25	4.7	6	64	3	20°	▲
DSRA.3.050.050.053	5	0.5	25	26.5	4.7	6	64	3	20°	▲
DSRA.3.050.050.070	5	0.5	25	35	4.7	6	82	3	20°	▲
DSRA.3.050.100.030	5	1	12.5	15	4.7	6	64	3	20°	▲
DSRA.3.050.100.050	5	1	12.5	25	4.7	6	64	3	20°	▲
DSRA.3.050.100.053	5	1	25	26.5	4.7	6	64	3	20°	▲
DSRA.3.050.100.070	5	1	25	35	4.7	6	82	3	20°	▲




P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSRA Ø 4 - 5 mm

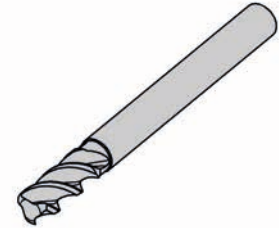
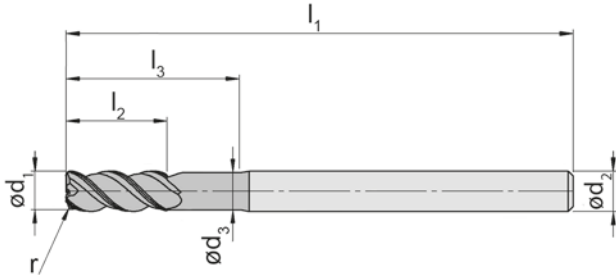
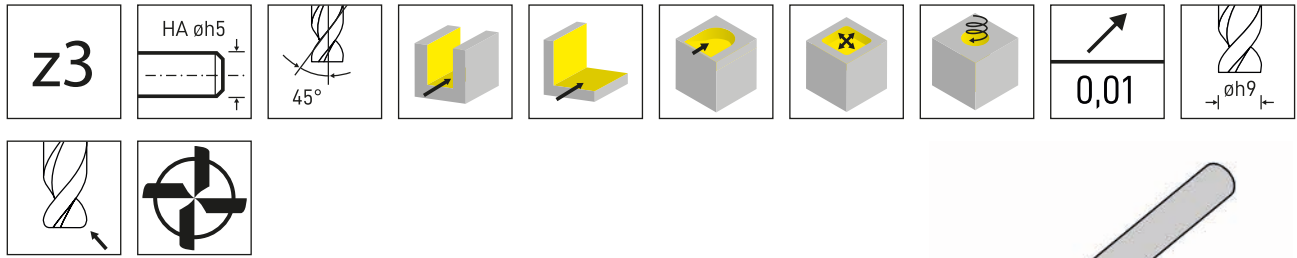
Cutting Data DSTMA Ø 4 - 5 mm



		
	vc = m/min	vc = m/min
N1.1	400	450
N1.2	400	450
N2.1	350	400
N2.2	350	400
N2.3	200	250
N3.1	250	300
N3.2	300	350
N3.3	200	250
N3.4	200	250

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
4	7°	0.014	4.00	6.00	0.007	0.80	10.00
4	5°	0.010	4.00	6.00	0.005	0.80	10.00
4	3°	0.010	4.00	6.00	0.005	0.80	20.00
4	3°	0.006	4.00	6.00	0.003	0.80	20.00
4	7°	0.014	4.00	6.00	0.007	0.80	10.00
4	5°	0.010	4.00	6.00	0.005	0.80	10.00
4	3°	0.010	4.00	6.00	0.005	0.80	20.00
4	3°	0.006	4.00	6.00	0.003	0.80	20.00
4	7°	0.014	4.00	6.00	0.007	0.80	10.00
4	5°	0.010	4.00	6.00	0.005	0.80	10.00
4	3°	0.010	4.00	6.00	0.005	0.80	20.00
4	3°	0.006	4.00	6.00	0.003	0.80	20.00
5	7°	0.019	5.00	7.50	0.011	1.00	12.50
5	5°	0.013	5.00	7.50	0.008	1.00	12.50
5	3°	0.013	5.00	7.50	0.008	1.00	25.00
5	3°	0.008	5.00	7.50	0.004	1.00	25.00
5	7°	0.019	5.00	7.50	0.011	1.00	12.50
5	5°	0.013	5.00	7.50	0.008	1.00	12.50
5	3°	0.013	5.00	7.50	0.008	1.00	25.00
5	3°	0.008	5.00	7.50	0.004	1.00	25.00
5	7°	0.019	5.00	7.50	0.011	1.00	12.50
5	5°	0.013	5.00	7.50	0.008	1.00	12.50
5	3°	0.013	5.00	7.50	0.008	1.00	25.00
5	3°	0.008	5.00	7.50	0.004	1.00	25.00

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



F




产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	MG3K
DSRA.3.060.010.030	6	0.1	15	18	5.6	6	64	3	▲
DSRA.3.060.010.050	6	0.1	15	30	5.6	6	82	3	▲
DSRA.3.060.010.053	6	0.1	30	31.8	5.6	6	82	3	▲
DSRA.3.060.010.070	6	0.1	30	42	5.6	6	82	3	▲
DSRA.3.060.050.030	6	0.5	15	18	5.6	6	64	3	▲
DSRA.3.060.050.050	6	0.5	15	30	5.6	6	82	3	▲
DSRA.3.060.050.053	6	0.5	30	31.8	5.6	6	82	3	▲
DSRA.3.060.050.070	6	0.5	30	42	5.6	6	82	3	▲
DSRA.3.060.100.030	6	1	15	18	5.6	6	64	3	▲
DSRA.3.060.100.050	6	1	15	30	5.6	6	82	3	▲
DSRA.3.060.100.053	6	1	30	31.8	5.6	6	82	3	▲
DSRA.3.060.100.070	6	1	30	42	5.6	6	82	3	▲
DSRA.3.060.250.030	6	2.5	15	18	5.6	6	64	3	▲
DSRA.3.060.250.050	6	2.5	15	30	5.6	6	82	3	▲
DSRA.3.060.250.053	6	2.5	30	31.8	5.6	6	82	3	▲
DSRA.3.060.250.070	6	2.5	30	42	5.6	6	82	3	▲
DSRA.3.080.010.030	8	0.1	20	24	7.5	8	64	3	▲
DSRA.3.080.010.050	8	0.1	20	40	7.5	8	82	3	▲
DSRA.3.080.010.053	8	0.1	40	42.4	7.5	8	82	3	▲
DSRA.3.080.010.070	8	0.1	40	56	7.5	8	108	3	▲
DSRA.3.080.050.030	8	0.5	20	24	7.5	8	64	3	▲
DSRA.3.080.050.050	8	0.5	20	40	7.5	8	82	3	▲
DSRA.3.080.050.053	8	0.5	40	42.4	7.5	8	82	3	▲
DSRA.3.080.050.070	8	0.5	40	56	7.5	8	108	3	▲
DSRA.3.080.100.030	8	1	20	24	7.5	8	64	3	▲
DSRA.3.080.100.050	8	1	20	40	7.5	8	82	3	▲
DSRA.3.080.100.053	8	1	40	42.4	7.5	8	82	3	▲
DSRA.3.080.100.070	8	1	40	56	7.5	8	108	3	▲
DSRA.3.080.250.030	8	2.5	20	24	7.5	8	64	3	▲
DSRA.3.080.250.050	8	2.5	20	40	7.5	8	82	3	▲
DSRA.3.080.250.053	8	2.5	40	42.4	7.5	8	82	3	▲
DSRA.3.080.250.070	8	2.5	40	56	7.5	8	108	3	▲
P	-	-	-	-	-	-	-	-	-
M	-	-	-	-	-	-	-	-	-
K	-	-	-	-	-	-	-	-	-
N	●	-	-	-	-	-	-	-	-
S	-	-	-	-	-	-	-	-	-
H	-	-	-	-	-	-	-	-	-

切削参数 DSRA Ø 6 - 8 mm

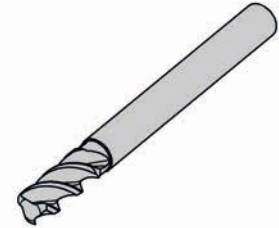
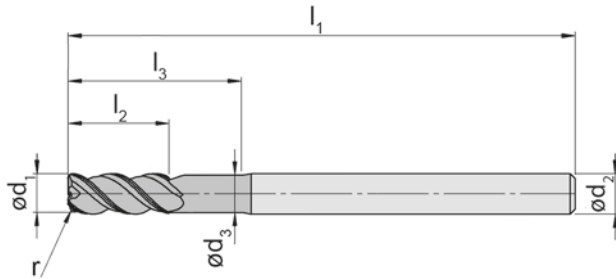
Cutting Data DSRA Ø 6 - 8 mm



	 $vc = m/min$	 $vc = m/min$
N1.1	400	450
N1.2	400	450
N2.1	350	400
N2.2	350	400
N2.3	200	250
N3.1	250	300
N3.2	300	350
N3.3	200	250
N3.4	200	250

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
6	7°	0.024	6.00	9.00	0.016	1.20	15.00
6	5°	0.017	6.00	9.00	0.011	1.20	15.00
6	3°	0.017	6.00	9.00	0.011	1.20	30.00
6	3°	0.010	6.00	9.00	0.006	1.20	30.00
6	7°	0.024	6.00	9.00	0.016	1.20	15.00
6	5°	0.017	6.00	9.00	0.011	1.20	15.00
6	3°	0.017	6.00	9.00	0.011	1.20	30.00
6	3°	0.010	6.00	9.00	0.006	1.20	30.00
6	7°	0.024	6.00	9.00	0.016	1.20	15.00
6	5°	0.017	6.00	9.00	0.011	1.20	15.00
6	3°	0.017	6.00	9.00	0.011	1.20	30.00
6	3°	0.010	6.00	9.00	0.006	1.20	30.00
6	7°	0.024	6.00	9.00	0.016	1.20	15.00
6	5°	0.017	6.00	9.00	0.011	1.20	15.00
6	3°	0.017	6.00	9.00	0.011	1.20	30.00
6	3°	0.010	6.00	9.00	0.006	1.20	30.00
8	7°	0.034	8.00	12.00	0.025	1.60	20.00
8	5°	0.024	8.00	12.00	0.017	1.60	20.00
8	3°	0.024	8.00	12.00	0.017	1.60	40.00
8	3°	0.014	8.00	12.00	0.010	1.60	40.00
8	7°	0.034	8.00	12.00	0.025	1.60	20.00
8	5°	0.024	8.00	12.00	0.017	1.60	20.00
8	3°	0.024	8.00	12.00	0.017	1.60	40.00
8	3°	0.014	8.00	12.00	0.010	1.60	40.00
8	7°	0.034	8.00	12.00	0.025	1.60	20.00
8	5°	0.024	8.00	12.00	0.017	1.60	20.00
8	3°	0.024	8.00	12.00	0.017	1.60	40.00
8	3°	0.014	8.00	12.00	0.010	1.60	40.00
8	7°	0.034	8.00	12.00	0.025	1.60	20.00
8	5°	0.024	8.00	12.00	0.017	1.60	20.00
8	3°	0.024	8.00	12.00	0.017	1.60	40.00
8	3°	0.014	8.00	12.00	0.010	1.60	40.00

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



F




产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	MG3K
DSRA.3.100.010.030	10	0.1	25	30	9.5	10	82	3	▲
DSRA.3.100.010.050	10	0.1	25	50	9.5	10	108	3	▲
DSRA.3.100.010.053	10	0.1	50	53	9.5	10	108	3	▲
DSRA.3.100.010.070	10	0.1	50	70	9.5	10	120	3	▲
DSRA.3.100.050.030	10	0.5	25	30	9.5	10	82	3	▲
DSRA.3.100.050.050	10	0.5	25	50	9.5	10	108	3	▲
DSRA.3.100.050.053	10	0.5	50	53	9.5	10	108	3	▲
DSRA.3.100.050.070	10	0.5	50	70	9.5	10	120	3	▲
DSRA.3.100.100.030	10	1	25	30	9.5	10	82	3	▲
DSRA.3.100.100.050	10	1	25	50	9.5	10	108	3	▲
DSRA.3.100.100.053	10	1	50	53	9.5	10	108	3	▲
DSRA.3.100.100.070	10	1	50	70	9.5	10	120	3	▲
DSRA.3.100.250.030	10	2.5	25	30	9.5	10	82	3	▲
DSRA.3.100.250.050	10	2.5	25	50	9.5	10	108	3	▲
DSRA.3.100.250.053	10	2.5	50	53	9.5	10	108	3	▲
DSRA.3.100.250.070	10	2.5	50	70	9.5	10	120	3	▲
DSRA.3.120.010.030	12	0.1	30	36	11.5	12	82	3	▲
DSRA.3.120.010.050	12	0.1	30	60	11.5	12	108	3	▲
DSRA.3.120.010.053	12	0.1	60	63.6	11.5	12	108	3	▲
DSRA.3.120.010.070	12	0.1	60	84	11.5	12	140	3	▲
DSRA.3.120.050.030	12	0.5	30	36	11.5	12	82	3	▲
DSRA.3.120.050.050	12	0.5	30	60	11.5	12	108	3	▲
DSRA.3.120.050.053	12	0.5	60	63.6	11.5	12	108	3	▲
DSRA.3.120.050.070	12	0.5	60	84	11.5	12	140	3	▲
DSRA.3.120.100.030	12	1	30	36	11.5	12	82	3	▲
DSRA.3.120.100.050	12	1	30	60	11.5	12	108	3	▲
DSRA.3.120.100.053	12	1	60	63.6	11.5	12	108	3	▲
DSRA.3.120.100.070	12	1	60	84	11.5	12	140	3	▲
DSRA.3.120.250.030	12	2.5	30	36	11.5	12	82	3	▲
DSRA.3.120.250.050	12	2.5	30	60	11.5	12	108	3	▲
DSRA.3.120.250.053	12	2.5	60	63.6	11.5	12	108	3	▲
DSRA.3.120.250.070	12	2.5	60	84	11.5	12	140	3	▲
P	-	-	-	-	-	-	-	-	-
M	-	-	-	-	-	-	-	-	-
K	-	-	-	-	-	-	-	-	-
N	●	-	-	-	-	-	-	-	-
S	-	-	-	-	-	-	-	-	-
H	-	-	-	-	-	-	-	-	-

切削参数 DSRA Ø 10 - 12 mm

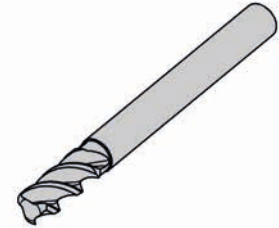
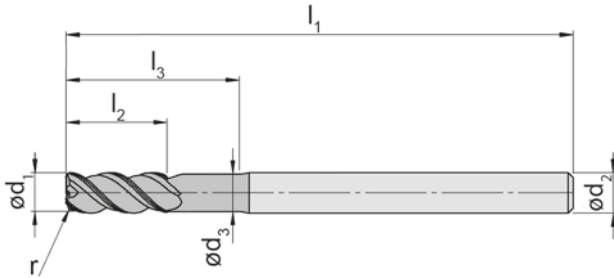
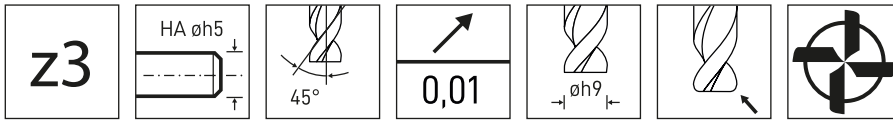
Cutting Data DSRA Ø 10 - 12 mm



	 $vc = m/min$	 $vc = m/min$
N1.1	400	450
N1.2	400	450
N2.1	350	400
N2.2	350	400
N2.3	200	250
N3.1	250	300
N3.2	300	350
N3.3	200	250
N3.4	200	250

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
10	7°	0.044	10.00	15.00	0.033	2.00	25.00
10	5°	0.031	10.00	15.00	0.023	2.00	25.00
10	3°	0.031	10.00	15.00	0.023	2.00	50.00
10	3°	0.018	10.00	15.00	0.013	2.00	50.00
10	7°	0.044	10.00	15.00	0.033	2.00	25.00
10	5°	0.031	10.00	15.00	0.023	2.00	25.00
10	3°	0.031	10.00	15.00	0.023	2.00	50.00
10	3°	0.018	10.00	15.00	0.013	2.00	50.00
10	7°	0.044	10.00	15.00	0.033	2.00	25.00
10	5°	0.031	10.00	15.00	0.023	2.00	25.00
10	3°	0.031	10.00	15.00	0.023	2.00	50.00
10	3°	0.018	10.00	15.00	0.013	2.00	50.00
10	7°	0.044	10.00	15.00	0.033	2.00	25.00
10	5°	0.031	10.00	15.00	0.023	2.00	25.00
10	3°	0.031	10.00	15.00	0.023	2.00	50.00
10	3°	0.018	10.00	15.00	0.013	2.00	50.00
12	7°	0.054	12.00	18.00	0.042	2.40	30.00
12	5°	0.038	12.00	18.00	0.030	2.40	30.00
12	3°	0.038	12.00	18.00	0.030	2.40	60.00
12	3°	0.022	12.00	18.00	0.017	2.40	60.00
12	7°	0.054	12.00	18.00	0.042	2.40	30.00
12	5°	0.038	12.00	18.00	0.030	2.40	30.00
12	3°	0.038	12.00	18.00	0.030	2.40	60.00
12	3°	0.022	12.00	18.00	0.017	2.40	60.00
12	7°	0.054	12.00	18.00	0.042	2.40	30.00
12	5°	0.038	12.00	18.00	0.030	2.40	30.00
12	3°	0.038	12.00	18.00	0.030	2.40	60.00
12	3°	0.022	12.00	18.00	0.017	2.40	60.00
12	7°	0.054	12.00	18.00	0.042	2.40	30.00
12	5°	0.038	12.00	18.00	0.030	2.40	30.00
12	3°	0.038	12.00	18.00	0.030	2.40	60.00
12	3°	0.022	12.00	18.00	0.017	2.40	60.00

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	MG3K
DSRA.3.160.010.030	16	0.1	40	48	15	16	108	3	▲
DSRA.3.160.010.050	16	0.1	40	80	15	16	140	3	▲
DSRA.3.160.010.053	16	0.1	80	84.8	15	16	140	3	▲
DSRA.3.160.050.030	16	0.5	40	48	15	16	108	3	▲
DSRA.3.160.050.050	16	0.5	40	80	15	16	140	3	▲
DSRA.3.160.050.053	16	0.5	80	84.8	15	16	140	3	▲
DSRA.3.160.100.030	16	1	40	48	15	16	108	3	▲
DSRA.3.160.100.050	16	1	40	80	15	16	140	3	▲
DSRA.3.160.100.053	16	1	80	84.8	15	16	140	3	▲
DSRA.3.160.250.030	16	2.5	40	48	15	16	108	3	▲
DSRA.3.160.250.050	16	2.5	40	80	15	16	140	3	▲
DSRA.3.160.250.053	16	2.5	80	84.8	15	16	140	3	▲
DSRA.3.160.400.030	16	4	40	48	15	16	108	3	▲
DSRA.3.160.400.050	16	4	40	80	15	16	140	3	▲
DSRA.3.160.400.053	16	4	80	84.8	15	16	140	3	▲
DSRA.3.200.010.027	20	0.1	50	54	19	20	108	3	▲
DSRA.3.200.010.050	20	0.1	50	100	19	20	163	3	▲
DSRA.3.200.010.053	20	0.1	100	106	19	20	163	3	▲
DSRA.3.200.050.027	20	0.5	50	54	19	20	108	3	▲
DSRA.3.200.050.053	20	0.5	100	106	19	20	163	3	▲
DSRA.3.200.100.027	20	1	50	54	19	20	108	3	▲
DSRA.3.200.100.053	20	1	100	106	19	20	163	3	▲
DSRA.3.200.250.027	20	2.5	50	54	19	20	108	3	▲
DSRA.3.200.250.050	20	2.5	50	100	19	20	163	3	▲
DSRA.3.200.250.053	20	2.5	100	106	19	20	163	3	▲
DSRA.3.200.400.027	20	4	50	54	19	20	108	3	△
DSRA.3.200.400.050	20	4	50	100	19	20	163	3	△

P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSRA Ø 16 - 20 mm

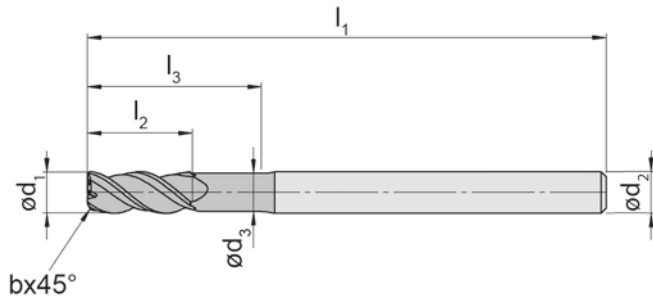
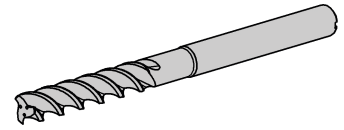
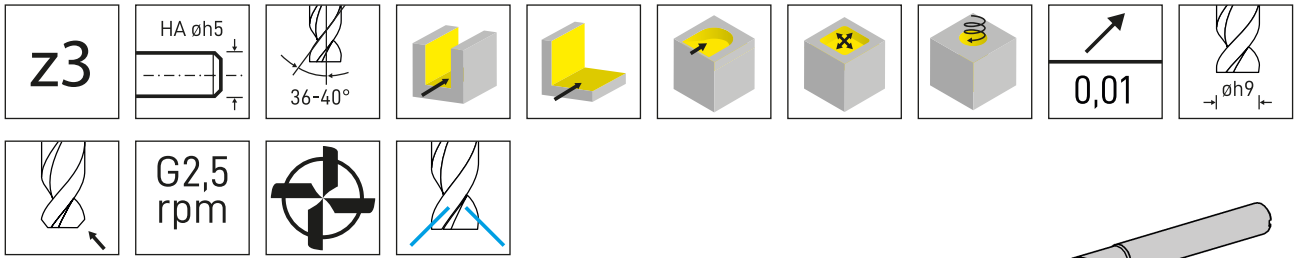
Cutting Data DSRA Ø 16 - 20 mm



	 $vc = m/min$	 $vc = m/min$
N1.1	400	450
N1.2	400	450
N2.1	350	400
N2.2	350	400
N2.3	200	250
N3.1	250	300
N3.2	300	350
N3.3	200	250
N3.4	200	250

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
16	7°	0.074	16.00	24.00	0.060	3.20	40.00
16	5°	0.052	16.00	24.00	0.042	3.20	40.00
16	3°	0.052	16.00	24.00	0.042	3.20	80.00
16	3°	0.074	16.00	24.00	0.060	3.20	40.00
16	7°	0.052	16.00	24.00	0.042	3.20	40.00
16	5°	0.052	16.00	24.00	0.042	3.20	80.00
16	3°	0.074	16.00	24.00	0.060	3.20	40.00
16	3°	0.052	16.00	24.00	0.042	3.20	40.00
16	7°	0.052	16.00	24.00	0.042	3.20	80.00
16	5°	0.074	16.00	24.00	0.060	3.20	40.00
16	3°	0.052	16.00	24.00	0.042	3.20	40.00
16	3°	0.052	16.00	24.00	0.042	3.20	80.00
16	7°	0.074	16.00	24.00	0.060	3.20	40.00
16	5°	0.052	16.00	24.00	0.042	3.20	40.00
16	3°	0.052	16.00	24.00	0.042	3.20	80.00
20	3°	0.094	20.00	30.00	0.078	4.00	50.00
20	7°	0.066	20.00	30.00	0.055	4.00	50.00
20	5°	0.066	20.00	30.00	0.055	4.00	100.00
20	3°	0.094	20.00	30.00	0.078	4.00	50.00
20	7°	0.066	20.00	30.00	0.055	4.00	100.00
20	5°	0.094	20.00	30.00	0.078	4.00	50.00
20	3°	0.066	20.00	30.00	0.055	4.00	100.00
20	7°	0.094	20.00	30.00	0.078	4.00	50.00
20	5°	0.066	20.00	30.00	0.055	4.00	50.00
20	3°	0.066	20.00	30.00	0.055	4.00	100.00
20	3°	0.094	20.00	30.00	0.078	4.00	50.00
20	7°	0.066	20.00	30.00	0.055	4.00	50.00

F



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	b	l ₂	l ₃	d ₃	d ₂	l ₁	Z	NEZK
DSFA.3.060.030	6	0.2	15	18	5.6	6	57	3	▲
DSFA.3.060.050	6	0.2	15	30	5.6	6	70	3	▲
DSFA.3.060.053	6	0.2	30	31.8	5.6	6	70	3	▲
DSFA.3.060.070	6	0.2	30	42	5.6	6	80	3	▲
DSFA.3.080.030	8	0.2	20	24	7.5	8	64	3	▲
DSFA.3.080.050	8	0.2	20	40	7.5	8	80	3	▲
DSFA.3.080.053	8	0.2	40	42.4	7.5	8	80	3	▲
DSFA.3.080.070	8	0.2	40	56	7.5	8	100	3	▲
DSFA.3.100.030	10	0.2	25	30	9.5	10	72	3	▲
DSFA.3.100.050	10	0.2	25	50	9.5	10	100	3	▲
DSFA.3.100.053	10	0.2	50	53	9.5	10	100	3	▲
DSFA.3.100.070	10	0.2	50	70	9.5	10	115	3	▲
DSFA.3.120.030	12	0.2	30	36	11.5	12	85	3	▲
DSFA.3.120.050	12	0.2	30	60	11.5	12	108	3	▲
DSFA.3.120.053	12	0.2	60	63.6	11.5	12	108	3	▲
DSFA.3.120.070	12	0.2	60	84	11.5	12	140	3	▲
DSFA.3.160.030	16	0.5	40	48	15	16	100	3	▲
DSFA.3.160.050	16	0.5	40	80	15	16	140	3	▲
DSFA.3.160.053	16	0.5	80	84.8	15	16	140	3	▲
DSFA.3.200.027	20	0.5	50	54	19	20	108	3	▲
DSFA.3.200.050	20	0.5	50	100	19	20	163	3	▲
DSFA.3.200.053	20	0.5	100	106	19	20	163	3	▲


P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSFA Ø 6 - 20 mm

Cutting Data DSFA Ø 6 - 20 mm



	 vc = m/min	 vc = m/min
N1.1	450	500
N1.2	450	500
N2.1	400	450
N2.2	400	450
N2.3	250	300
N3.1	300	350
N3.2	350	400
N3.3	200	250
N3.4	200	250

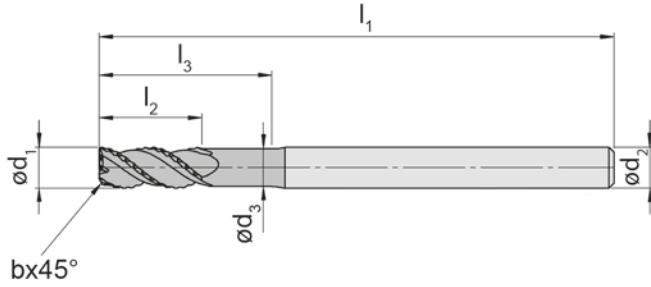
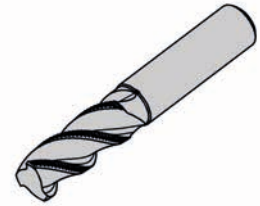
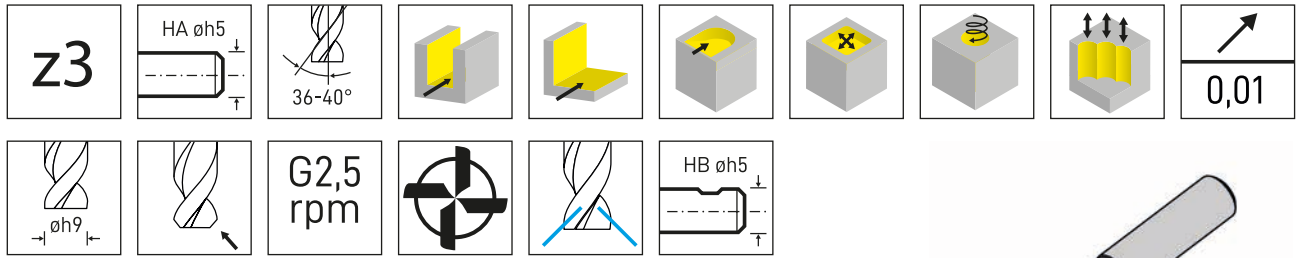
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
6	20°	0.026	6.00	9.00	0.047	1.20	15.00
6	10°	0.018	6.00	9.00	0.066	0.30	15.00
6	3°	0.018	6.00	9.00	0.066	0.30	30.00
6	3°	0.010	6.00	9.00	0.038	0.30	30.00
8	20°	0.035	8.00	12.00	0.128	0.40	20.00
8	10°	0.025	8.00	12.00	0.090	0.40	20.00
8	3°	0.025	8.00	12.00	0.090	0.40	40.00
8	3°	0.014	8.00	12.00	0.051	0.40	40.00
10	20°	0.044	10.00	15.00	0.161	0.50	25.00
10	10°	0.031	10.00	15.00	0.113	0.50	25.00
10	3°	0.031	10.00	15.00	0.113	0.50	50.00
10	3°	0.018	10.00	15.00	0.064	0.50	50.00
12	20°	0.054	12.00	18.00	0.194	0.60	30.00
12	10°	0.037	12.00	18.00	0.136	0.60	30.00
12	3°	0.037	12.00	18.00	0.136	0.60	60.00
12	3°	0.021	12.00	18.00	0.078	0.60	60.00
16	20°	0.072	16.00	24.00	0.260	0.80	40.00
16	10°	0.050	16.00	24.00	0.182	0.80	40.00
16	3°	0.050	16.00	24.00	0.182	0.80	80.00
20	20°	0.090	20.00	30.00	0.327	1.00	50.00
20	10°	0.063	20.00	30.00	0.229	1.00	50.00
20	3°	0.063	20.00	30.00	0.229	1.00	100.00

F

粗加工立铣刀

Roughing End Mill with ripper profile

DSFRA



硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

F



产品型号 Part number	d ₁	b	l ₂	l ₃	d ₃	d ₂	l ₁	Z	类型 Type	NEZK
DSFRA.3.060.030	6	0.4	15	18	5.6	6	57	3	HA	▲
DSFRA.3.060.050	6	0.4	15	30	5.6	6	70	3	HA	▲
DSFRA.3.080.030	8	0.5	20	24	7.5	8	64	3	HA	▲
DSFRA.3.080.050	8	0.5	20	40	7.5	8	80	3	HA	▲
DSFRA.3.100.030	10	0.5	25	30	9.5	10	72	3	HA	▲
DSFRA.3.100.050	10	0.5	25	50	9.5	10	100	3	HA	▲
DSFRA.3.120.030	12	0.5	30	36	11.5	12	85	3	HA	▲
DSFRA.3.120.030.B	12	0.5	30	36	11.5	12	85	3	HB	▲
DSFRA.3.120.050	12	0.5	30	60	11.5	12	108	3	HA	▲
DSFRA.3.120.050.B	12	0.5	30	60	11.5	12	108	3	HB	▲
DSFRA.3.160.030	16	0.6	40	48	15	16	100	3	HA	▲
DSFRA.3.160.030.B	16	0.6	40	48	15	16	100	3	HB	▲
DSFRA.3.160.050	16	0.6	40	80	15	16	140	3	HA	▲
DSFRA.3.160.050.B	16	0.6	40	80	15	16	140	3	HB	▲
DSFRA.3.200.027	20	0.8	50	54	18.8	20	108	3	HA	▲
DSFRA.3.200.027.B	20	0.8	50	54	18.8	20	108	3	HB	▲
DSFRA.3.200.050	20	0.8	50	100	18.8	20	163	3	HA	▲
DSFRA.3.200.050.B	20	0.8	50	100	18.8	20	163	3	HB	▲




P	-
M	-
K	-
N	●
S	-
H	-

切削参数 DSFRA Ø 6 - 20 mm

Cutting Data DSFRA Ø 6 - 20 mm

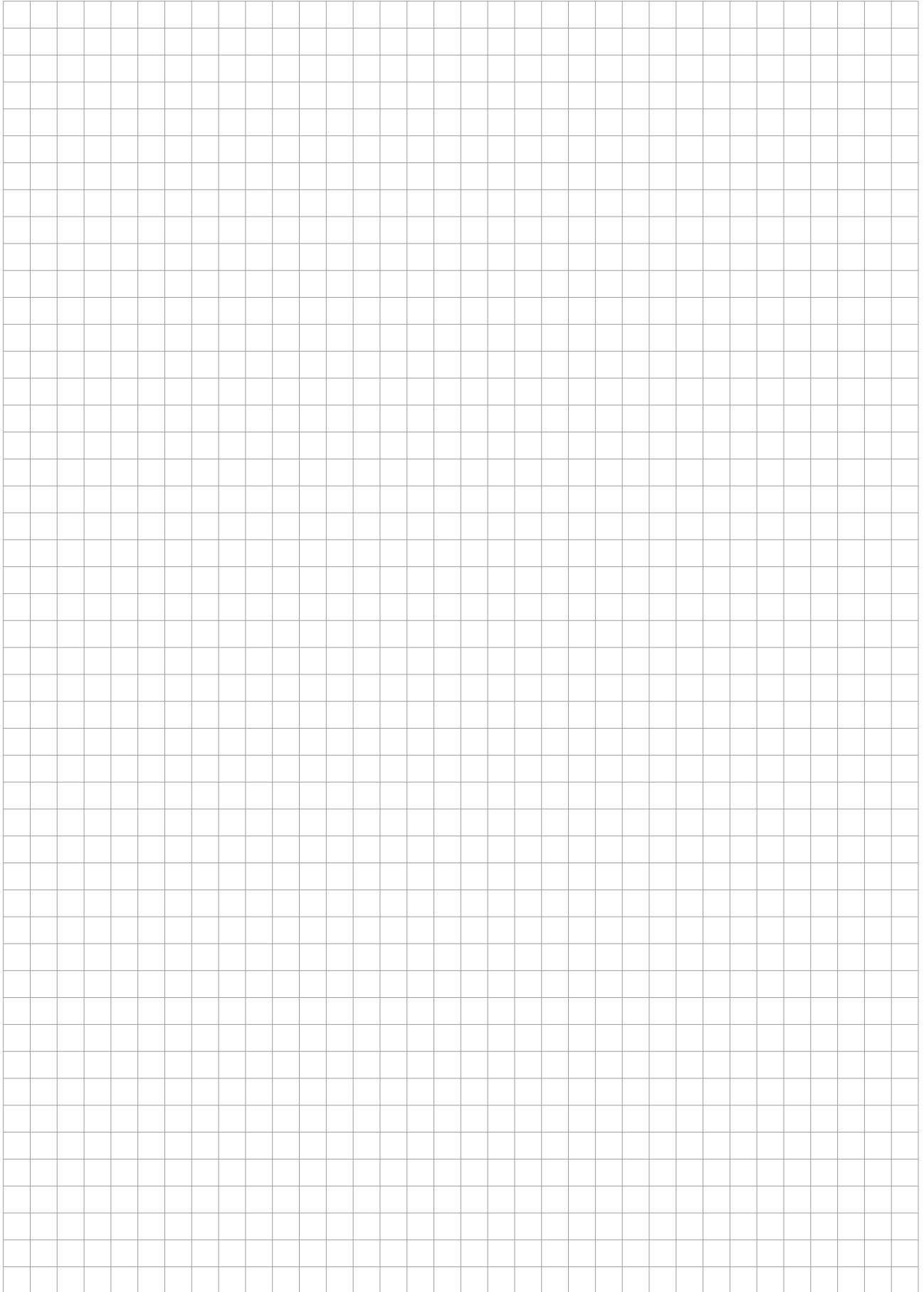


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N1.1	450	500
N1.2	450	500
N2.1	400	450
N2.2	400	450
N2.3	250	300
N3.1	300	350
N3.2	350	400
N3.3	200	250
N3.4	200	250

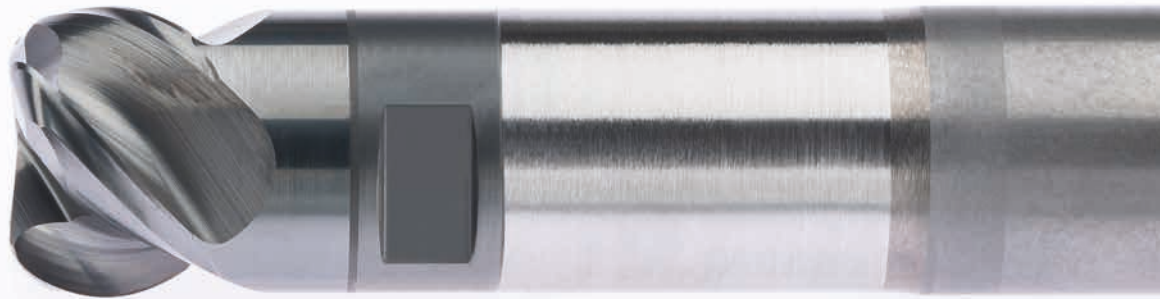
d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
6	20°	0.030	6.00	9.00	0.062	2.40	15.00
6	10°	0.021	6.00	9.00	0.043	2.40	15.00
8	20°	0.041	8.00	12.00	0.083	3.20	20.00
8	10°	0.029	8.00	12.00	0.058	3.20	20.00
10	20°	0.053	10.00	15.00	0.104	4.00	25.00
10	10°	0.037	10.00	15.00	0.073	4.00	25.00
12	20°	0.064	12.00	18.00	0.125	4.80	30.00
12	20°	0.064	12.00	18.00	0.125	4.80	30.00
12	10°	0.045	12.00	18.00	0.087	4.80	30.00
12	10°	0.045	12.00	18.00	0.087	4.80	30.00
16	20°	0.086	16.00	24.00	0.167	6.40	40.00
16	20°	0.086	16.00	24.00	0.167	6.40	40.00
16	10°	0.060	16.00	24.00	0.117	6.40	40.00
16	10°	0.060	16.00	24.00	0.117	6.40	40.00
20	20°	0.108	20.00	30.00	0.209	8.00	50.00
20	20°	0.108	20.00	30.00	0.209	8.00	50.00
20	10°	0.076	20.00	30.00	0.146	8.00	50.00
20	10°	0.076	20.00	30.00	0.146	8.00	50.00

F

F



DG



G

铣削系列 DG

用于

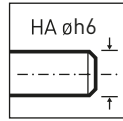
- 刃口过中心切削和槽铣削
- 倒角和中心铣削
- 仿形铣削
- 高进给铣削
- 齿轮铣削

Milling system DG

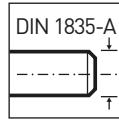
for

- Centre Cutting and Groove Milling
- Chamfering and centering
- Copy milling
- High feed milling
- Gear Milling

铣刀杆
Milling shank
MDG

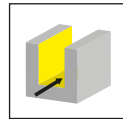


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231, 233-234

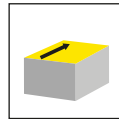


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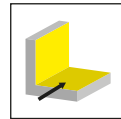
刀片
Cutter Head
DGR/DGF/DGRR/DGH
DGM/DGK/DGVZ/DGV/
DGFF



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236, 238, 240,
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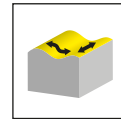
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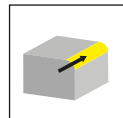
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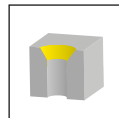
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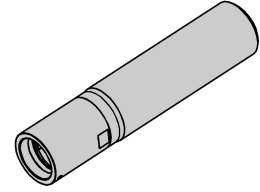
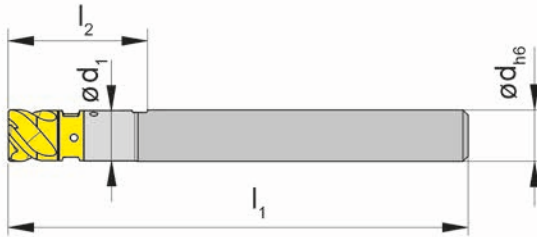
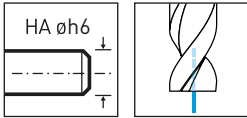
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产品型号 Part number	d	l ₁	l ₂	d ₁	系列 System	HMS
MDG.10.0010.90.00.A	10	72.8	30	9.8	DG10	DG0101
MDG.10.0010.90.01.A	10	101.8	56.8	9.8	DG10	DG0101
MDG.12.0012.90.00.A	12	83.3	36	11.7	DG12	DG0121
MDG.12.0012.90.01.A	12	114.3	59.3	11.7	DG12	DG0121
MDG.16.0016.90.00.A	16	98.8	48	15.6	DG16	DG0161
MDG.16.0016.90.01.A	16	129.8	64.8	15.6	DG16	DG0161
MDG.20.0020.90.00.A	20	112.3	60	19.5	DG20	DG0201
MDG.20.0020.90.01.A	20	150.3	70.3	19.5	DG20	DG0201

对于刀MDG10...请注意螺纹未分段。
For toolholders MDG10... Please note the threads are NOT segmented.

配件

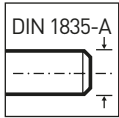
扳手和附加设备不包含在铣削刀杆中, 需另行订购!

Spare Parts

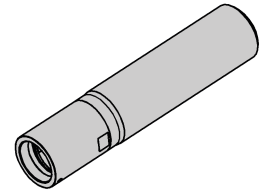
Wrenches and additional equipment are not combined with the milling shank. Separate order required!

HORN可以返修损坏的铣刀杆基座。

Milling cutter shanks with damaged seating can be repaired by HORN.



规格 2



产品型号 Part number	d	l ₁	l ₂	d ₁	形式 Form	HMS
MDG.10.ST10.90.01.A	10	91.8	36.8	9.8	1	DG0101
MDG.10.ST16.90.01.A	16	91.8	19.8	9.8	2	DG0101
MDG.12.ST12.90.01.A	12	109.3	44.3	11.7	1	DG0121
MDG.12.ST16.90.01.A	16	99.3	22.3	11.7	2	DG0121
MDG.16.ST16.90.01.A	16	134.8	49.8	15.6	1	DG0161
MDG.16.ST20.90.01.A	20	104.8	27.8	15.6	2	DG0161
MDG.20.ST20.90.01.A	20	150.3	60.3	19.5	1	DG0201
MDG.20.ST25.90.01.A	25	110.3	33.3	19.5	2	DG0201

对于刀MDG10...请注意螺纹未分段。
For toolholders MDG10... Please note the threads are NOT segmented.

配件

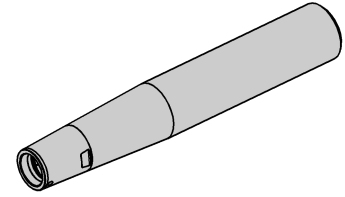
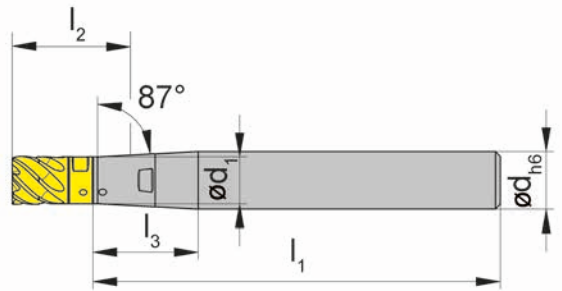
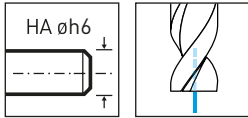
扳手和附加设备不包含在铣削刀杆中, 需另行订购!

Spare Parts

Wrenches and additional equipment are not combined with the milling shank. Separate order required!

HORN可以返修损坏的铣刀杆基座。

Milling cutter shanks with damaged seating can be repaired by HORN.



产品型号 Part number	d	l ₁	l ₂	d ₁	l ₃	HMS
MDG.10.0012.87.01.A	12	85	19.7	9.8	22	DG0101
MDG.12.0016.87.01.A	16	100	23.1	11.7	42	DG0121
MDG.16.0020.87.01.A	20	100	29.6	15.6	43	DG0161

对于刀MDG10...请注意螺纹未分段。
For toolholders MDG10... Please note the threads are NOT segmented.

配件

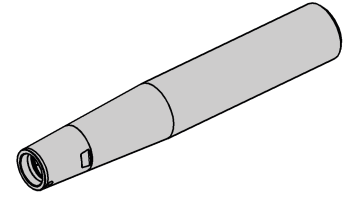
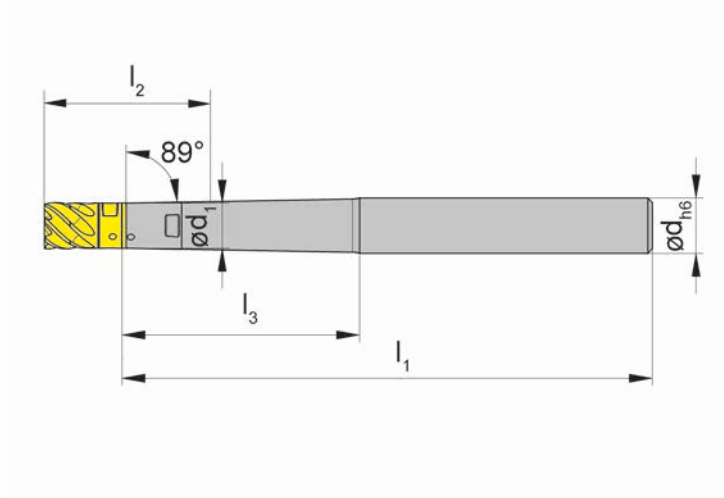
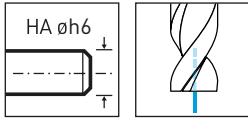
扳手和附加设备不包含在铣削刀杆中, 需另行订购!

Spare Parts

Wrenches and additional equipment are not combined with the milling shank. Separate order required!

HORN可以返修损坏的铣刀杆基座。

Milling cutter shanks with damaged seating can be repaired by HORN.



产品型号 Part number	d	l ₁	l ₂	d ₁	l ₃	HMS
MDG.10.0012.89.01.A	12	115	23.5	9.8	50	DG0101
MDG.12.0016.89.01.A	16	140	28.8	11.7	75	DG0121
MDG.16.0020.89.01.A	20	160	37.2	15.6	75	DG0161

对于刀MDG10...请注意螺纹未分段。
For toolholders MDG10... Please note the threads are NOT segmented.

配件

扳手和附加设备不包含在铣削刀杆中, 需另行订购!

Spare Parts

Wrenches and additional equipment are not combined with the milling shank. Separate order required!

HORN可以返修损坏的铣刀杆基座。

Milling cutter shanks with damaged seating can be repaired by HORN.

设定扭矩 Torque for setting

系列 System	设定扭矩 Torque for setting (Nm)	扳手尺寸 Wrench size SW	对应扳手 Combination wrench	扳手扭矩 Torque wrench		
				应用 Application	有效范围 Effective range	用于小系列 for small series
DG10	10	8	S.DG1012	D.DG1001	D0525VK	D1050VK 10 - 50 Nm
DG12	14	10		D.DG1201	5 - 25 Nm	
DG16	25	13	S.DG1620	D.DG1601	D20100VK	
DG20	35	17		D.DG2001	20 - 100 Nm	

安装说明

1. 清除刀片和刀杆接触面的灰尘。
2. 将刀柄固定在夹具里。
3. 分别对螺纹, 锥面和刀片座使用润滑剂。
4. 将刀头安装在刀柄里, 手动锁紧。
注意, 小心碰伤
5. 选择合适的扭矩扳手, 使用推荐的扭矩锁紧刀片。

注意:

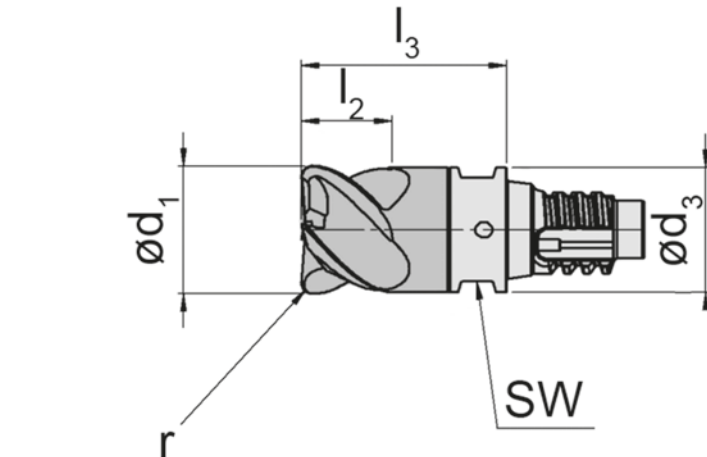
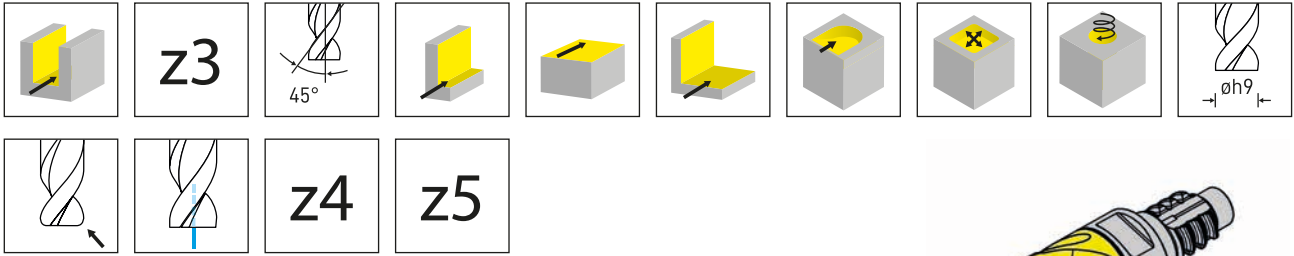
使用润滑剂可以减少刀片与刀杆的摩擦力。为保证轴向和径向跳动, 务必仔细清理定位座和接触面。
使用推荐的扭矩锁紧刀片, 能保证刀片正确安装。

Assembly instruction

1. Remove any dirt from the interface and seating surface of the milling cutter shank and cutting insert.
2. Grip milling cutter shank in jig.
3. Apply lubricant sparingly to thread, taper and seat surface of cutting insert.
4. Insert cutting insert into shank and clamp it manually according to mark.
Attention: risk of injury!
5. Tighten cutting insert in milling cutter shank with a torque wrench, using the recommended torque.

Note:

The use of lubricant reduces friction between cutting insert and tool holder. For optimum radial and axial run-out precision it is crucial that interfaces and seat surfaces are clean. Applying the recommended tightening torque for gripping cutting inserts guarantees the correct insert fit.



图示=右手型
Picture = right hand cutting version

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	系列 System	SW	Z	d_1	d	r	l_3	l_2	HIS	AN2P
DGR.3.10.1000.05.IK	DG10	8	3	10	9.8	0.5	16.8	5.5	DG0101	▲
DGR.3.10.1000.10.IK	DG10	8	3	10	9.8	1	16.8	5.5	DG0101	△
DGR.4.10.1000.05.IK	DG10	8	4	10	9.8	0.5	16.8	5.5	DG0101	▲
DGR.4.10.1000.10.IK	DG10	8	4	10	9.8	1	16.8	5.5	DG0101	▲
DGR.4.12.1200.05.IK	DG12	10	4	12	11.7	0.5	19.3	6.5	DG0121	▲
DGR.5.16.1600.10.IK	DG16	13	5	16	15.6	1	24.8	8.5	DG0161	▲
DGR.5.16.1600.20.IK	DG16	13	5	16	15.6	2	24.8	8.5	DG0161	▲



P	●
M	○
K	-
N	-
S	-
H	-



G

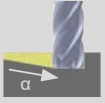


切削参数 DGR...IK

Cutting Data DGR...IK

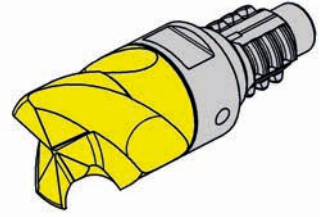
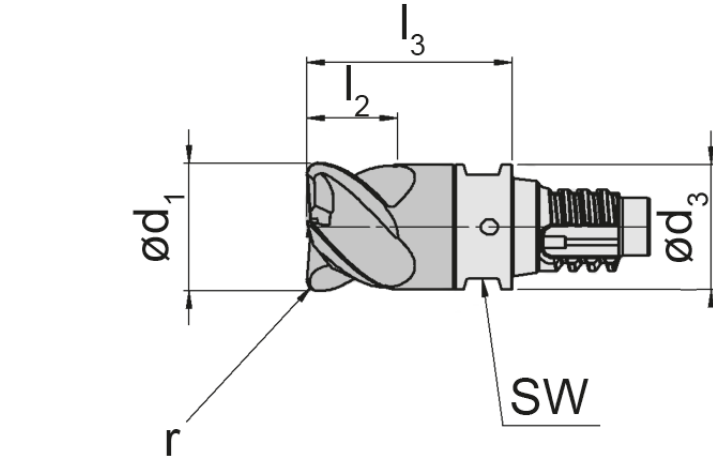
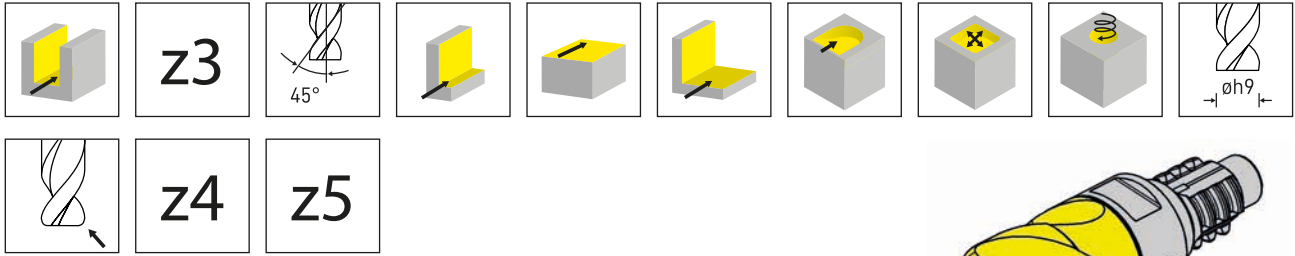


		
	vc = m/min	vc = m/min
P1.1	130	150
P1.2	130	150
P1.3	130	150
P1.4	130	150
P1.5	130	150
P1.6	140	160
P2.1	130	150
P2.2	130	150
P2.3	130	150
P2.4	130	150
P3.1	120	140
P3.2	110	130
P4.1	120	140
P4.2	120	140
P5.1	110	130

		
	vc = m/min	vc = m/min
M1.1	90	110
M1.2	70	90
M1.3	60	80
K1.1	130	150
K1.2	130	150
K2.1	120	140
K2.2	110	130
K3.1	110	130
K3.2	110	130
K4.1	100	120
K4.2	90	110
K4.3	90	110
S1.1	90	110
S1.2	80	100
S2.1	60	80
S2.2	50	70

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
10	5°	0.05	10	5	0.07	4	5
10	5°	0.05	10	5	0.07	4	5
10	4°	0.05	10	5	0.06	4	5
10	4°	0.05	10	5	0.06	4	5
12	5°	0.06	12	6	0.09	5	6
16	3°	0.08	16	8	0.11	6	8
16	3°	0.08	16	8	0.11	6	8





图示=右手型
Picture = right hand cutting version

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	系列 System	SW	Z	d_1	d_3	r	l_3	l_2	HIS	AN2P
DGR.3.10.1000.05.00	DG10	8	3	10	9.8	0.5	16.8	5.5	DG0101	▲
DGR.3.10.1000.10.00	DG10	8	3	10	9.8	1	16.8	5.5	DG0101	▲
DGR.4.10.1000.05.00	DG10	8	4	10	9.8	0.5	16.8	5.5	DG0101	▲
DGR.4.10.1000.10.00	DG10	8	4	10	9.8	1	16.8	5.5	DG0101	▲
DGR.3.12.1200.05.00	DG12	10	3	12	11.7	0.5	19.3	6.5	DG0121	▲
DGR.4.12.1200.05.00	DG12	10	4	12	11.7	0.5	19.3	6.5	DG0121	▲
DGR.4.12.1200.10.00	DG12	10	4	12	11.7	1	19.3	6.5	DG0121	▲
DGR.5.16.1600.05.00	DG16	13	5	16	15.6	0.5	24.8	8.5	DG0161	▲
DGR.5.16.1600.10.00	DG16	13	5	16	15.6	1	24.8	8.5	DG0161	▲
DGR.5.16.1600.15.00	DG16	13	5	16	15.6	1.5	24.8	8.5	DG0161	▲
DGR.5.16.1600.20.00	DG16	13	5	16	15.6	2	24.8	8.5	DG0161	▲
DGR.5.20.2000.05.00	DG20	17	5	20	19.5	0.5	30.3	12	DG0201	▲
DGR.5.20.2000.10.00	DG20	17	5	20	19.5	1	30.3	12	DG0201	▲
DGR.5.20.2000.15.00	DG20	17	5	20	19.5	1.5	30.3	12	DG0201	▲
DGR.5.20.2000.20.00	DG20	17	5	20	19.5	2	30.3	12	DG0201	▲



P	●
M	○
K	-
N	-
S	-
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G

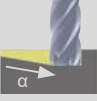


切削参数 DGR

Cutting Data DGR

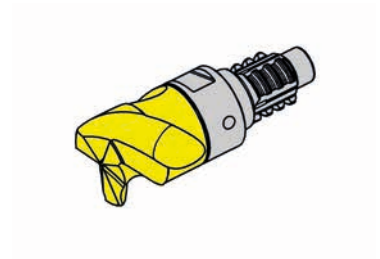
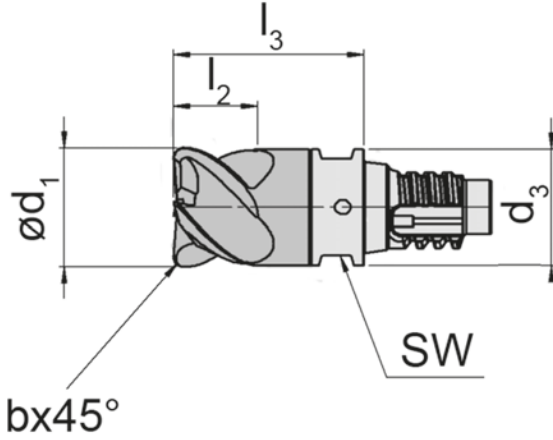
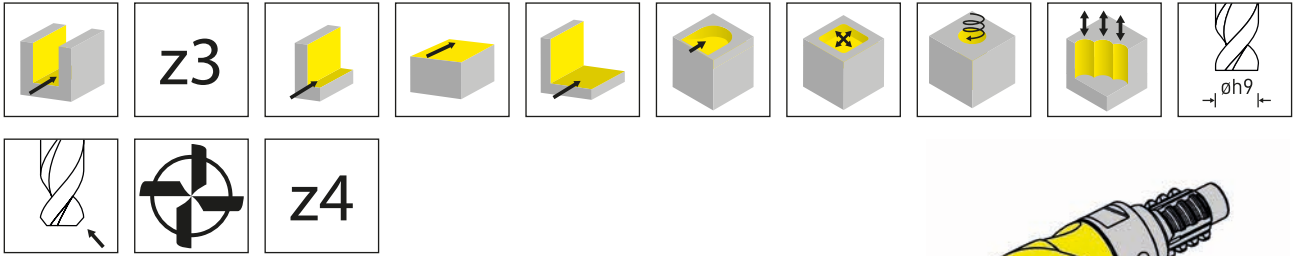


		
	vc = m/min	vc = m/min
P1.1	130	150
P1.2	130	150
P1.3	130	150
P1.4	130	150
P1.5	130	150
P1.6	140	160
P2.1	130	150
P2.2	130	150
P2.3	130	150
P2.4	130	150
P3.1	120	140
P3.2	110	130
P4.1	120	140
P4.2	120	140
P5.1	110	130

		
	vc = m/min	vc = m/min
M1.1	90	110
M1.2	70	90
M1.3	60	80
K1.1	130	150
K1.2	130	150
K2.1	120	140
K2.2	110	130
K3.1	110	130
K3.2	110	130
K4.1	100	120
K4.2	90	110
K4.3	90	110
S1.1	90	110
S1.2	80	100
S2.1	60	80
S2.2	50	70

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
10	5°	0.04	10	5	0.07	4	5
10	5°	0.04	10	5	0.07	4	5
10	4°	0.04	10	5	0.06	4	5
10	4°	0.04	10	5	0.06	4	5
12	5°	0.05	12	6	0.09	5	6
12	4°	0.05	12	6	0.08	5	6
12	4°	0.05	12	6	0.08	5	6
16	3°	0.07	16	8	0.11	6	8
16	3°	0.07	16	8	0.11	6	8
16	3°	0.07	16	8	0.11	6	8
16	3°	0.07	16	8	0.11	6	8
20	3°	0.09	20	10	0.14	8	10
20	3°	0.09	20	10	0.14	8	10
20	3°	0.09	20	10	0.14	8	10
20	3°	0.09	20	10	0.14	8	10





图示=右手型
Picture = right hand cutting version

▲ 库存
硬质合金牌号
Carbide grades

on stock 4 weeks



产品型号 Part number	系列 System	SW	Z	d ₁	d ₃	l ₃	l ₂	b	HIS	AN2P
DGF.3.10.1000.02.00	DG10	8	3	10	9.8	16.8	5.5	0.2	DG0101	▲
DGF.3.12.1200.02.00	DG12	10	3	12	11.7	19.3	6.5	0.2	DG0121	▲
DGF.4.16.1600.02.00	DG16	13	4	16	15.6	24.8	8.5	0.2	DG0161	▲
DGF.4.20.2000.03.00	DG20	17	4	20	19.5	30.3	12	0.25	DG0201	▲
										P ●
										M ○
										K -
										N -
										S -
										H -



G

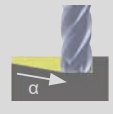


切削参数 DGF

Cutting Data DGF

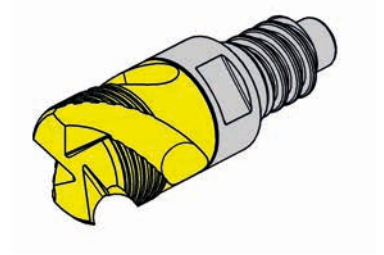
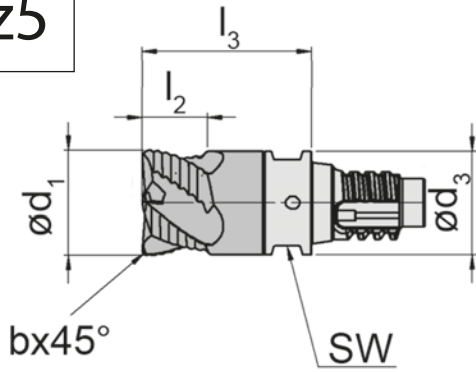
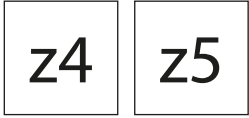
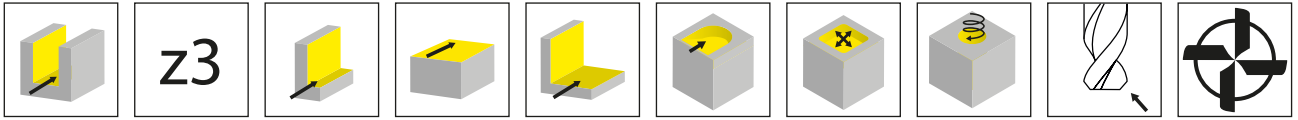


	 vc = m/min	 vc = m/min
P1.1	130	150
P1.2	130	150
P1.3	130	150
P1.4	130	150
P1.5	130	150
P1.6	140	160
P2.1	130	150
P2.2	130	150
P2.3	130	150
P2.4	130	150
P3.1	120	140
P3.2	110	130
P4.1	120	140
P4.2	120	140
P5.1	110	130

	 vc = m/min	 vc = m/min
M1.1	90	110
M1.2	70	90
M1.3	60	80
K1.1	130	150
K1.2	130	150
K2.1	120	140
K2.2	110	130
K3.1	110	130
K3.2	110	130
K4.1	100	120
K4.2	90	110
K4.3	90	110
S1.1	90	110
S1.2	80	100
S2.1	60	80
S2.2	50	70

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
10	5°	0.04	10	5	0.07	4	5
12	5°	0.05	12	6	0.09	5	6
16	4°	0.07	16	8	0.11	6	8
20	4°	0.09	20	10	0.14	8	10





图示=右手型
Picture = right hand cutting version

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	系列 System	SW	Z	d ₁	d ₃	l ₃	l ₂	b	HIS	AN2P
DGRR.3.10.1000.00	DG10	8	3	10	9.8	16.8	5.5	0.3	DG0101	▲
DGRR.4.10.1000.00	DG10	8	4	10	9.8	16.8	5.5	0.3	DG0101	▲
DGRR.3.12.1200.00	DG12	10	3	12	11.7	19.3	6.5	0.5	DG0121	▲
DGRR.4.12.1200.00	DG12	10	4	12	11.7	19.3	6.5	0.5	DG0121	▲
DGRR.5.16.1600.00	DG16	13	5	16	15.6	24.8	8.5	0.5	DG0161	▲
DGRR.5.20.2000.00	DG20	17	5	20	19.5	30.3	12	0.5	DG0201	▲
										P ●
										M ○
										K -
										N -
										S -
										H -



G




切削参数 DGRR

Cutting Data DGRR

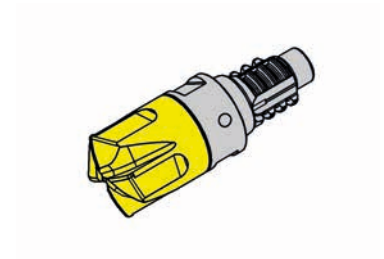
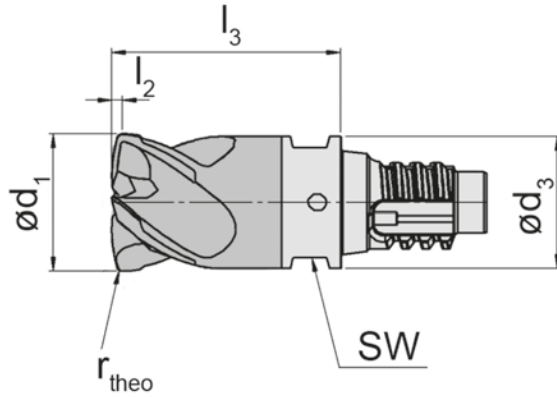
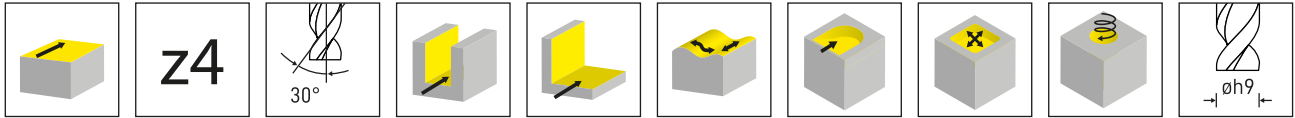


		
	vc = m/min	vc = m/min
P1.1	120	140
P1.2	120	140
P1.3	120	140
P1.4	120	140
P1.5	120	140
P1.6	130	150
P2.1	120	140
P2.2	120	140
P2.3	120	140
P2.4	120	140
P3.1	110	130
P3.2	100	120
P4.1	110	130
P4.2	110	130
P5.1	100	120

		
	vc = m/min	vc = m/min
M1.1	80	100
M1.2	60	80
M1.3	50	70
K1.1	120	140
K1.2	120	140
K2.1	110	130
K2.2	100	120
K3.1	100	120
K3.2	100	120
K4.1	90	110
K4.2	80	100
K4.3	80	100
S1.1	80	100
S1.2	70	90
S2.1	50	70
S2.2	40	60

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
10	5°	0.06	10	5	0.07	8	5
10	4°	0.05	10	5	0.06	8	5
12	3°	0.06	12	6	0.07	9	6
12	3°	0.06	12	6	0.07	9	6
16	3°	0.09	16	8	0.10	12	8
20	3°	0.11	20	10	0.13	15	10





图示=右手型
Picture = right hand cutting version

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks



产品型号 Part number	系列 System	SW	Z	d_1	d_3	l_3	l_2	r_{theo}	HIS	AN2P
DGH.4.10.1000.00	DG10	8	4	10	9.8	16.8	0.7	1.07	DG0101	▲
DGH.4.12.1200.00	DG12	10	4	12	11.7	19.3	0.8	1.18	DG0121	▲
DGH.4.16.1600.00	DG16	13	4	16	15.6	24.8	1	1.38	DG0161	▲
DGH.4.20.2000.00	DG20	17	4	20	19.5	30.3	1.2	1.96	DG0201	▲
										P ●
										M ○
										K -
										N -
										S -
										H -



G




切削参数 DGH

Cutting Data DGH

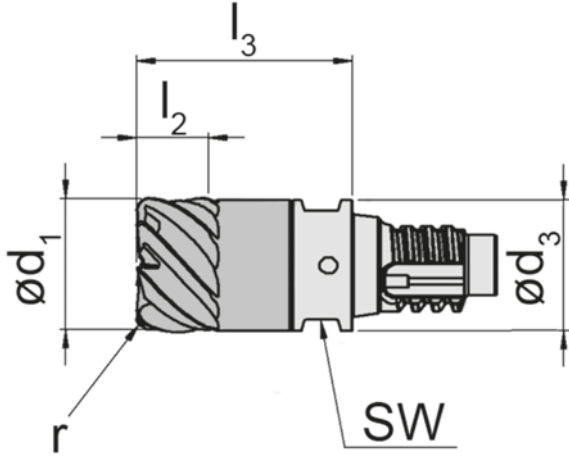
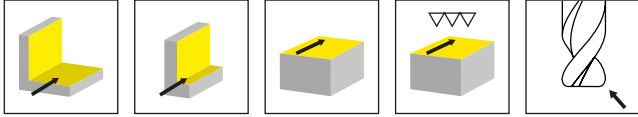


		
	vc = m/min	vc = m/min
P1.1	150	180
P1.2	150	180
P1.3	140	170
P1.4	140	170
P1.5	140	170
P1.6	140	170
P2.1	140	170
P2.2	140	170
P2.3	140	170
P2.4	140	170
P3.1	130	160
P3.2	130	160
P4.1	130	160
P4.2	130	160
P5.1	110	140

		
	vc = m/min	vc = m/min
M1.1	100	130
M1.2	90	120
M1.3	80	110
K1.1	140	170
K1.2	140	170
K2.1	130	160
K2.2	120	150
K3.1	120	150
K3.2	120	150
K4.1	110	140
K4.2	110	140
K4.3	110	140
S1.1	70	100
S1.2	60	90
S2.1	40	70
S2.2	30	60

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
10	4°	0.39	10	0.4	0.59	7	0.6
12	4°	0.47	12	0.5	0.71	8	0.7
16	4°	0.63	16	0.6	0.94	11	0.9
20	4°	0.79	20	0.8	1.18	14	1.1





图示=右手型
Picture = right hand cutting version

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	系列 System	SW	Z	d ₁	d ₃	r	l ₃	l ₂	HIS	AN2P
DGM.7.10.1000.02.0	DG10	8	7	10	9.8	0.2	16.8	5.5	DG0101	▲
DGM.7.10.1000.10.0	DG10	8	7	10	9.8	1	16.8	5.5	DG0101	▲
DGM.7.12.1200.02.0	DG12	10	7	12	11.7	0.2	19.3	6.5	DG0121	▲
DGM.7.12.1200.10.0	DG12	10	7	12	11.7	1	19.3	6.5	DG0121	▲
DGM.9.16.1600.02.0	DG16	13	9	16	15.6	0.2	24.8	9	DG0161	▲
DGM.9.16.1600.10.0	DG16	13	9	16	15.6	1	24.8	9	DG0161	▲
DGM.9.20.2000.02.0	DG20	17	9	20	19.5	0.2	30.3	11	DG0201	▲
DGM.9.20.2000.10.0	DG20	17	9	20	19.5	1	30.3	11	DG0201	▲



P	●
M	o
K	-
N	-
S	-
H	-



G

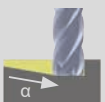


切削参数 DGM

Cutting Data DGM

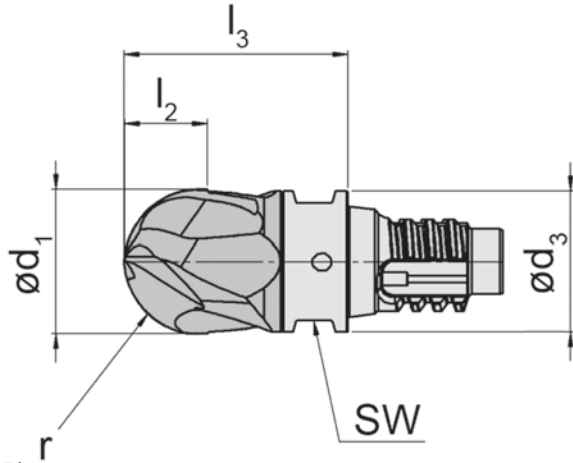
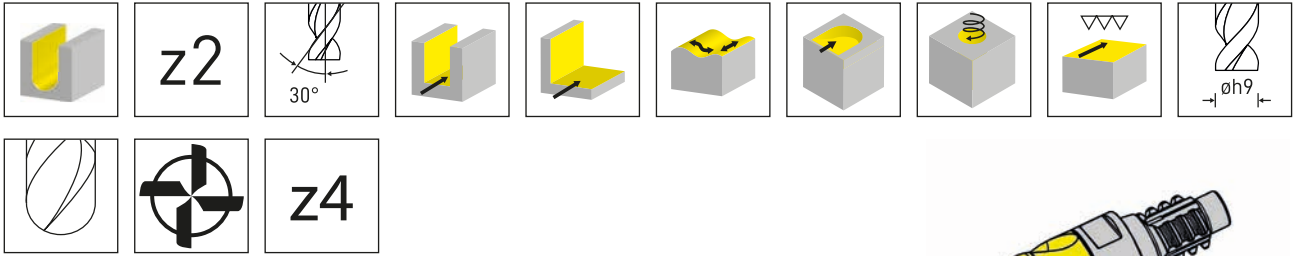


	 $vc = m/min$	 $vc = m/min$
P1.1	120	140
P1.2	120	140
P1.3	120	140
P1.4	120	140
P1.5	120	140
P1.6	130	150
P2.1	120	140
P2.2	120	140
P2.3	120	140
P2.4	120	140
P3.1	110	130
P3.2	100	120
P4.1	110	130
P4.2	110	130
P5.1	100	120

	 $vc = m/min$	 $vc = m/min$
M1.1	80	100
M1.2	60	80
M1.3	50	70
K1.1	120	140
K1.2	120	140
K2.1	110	130
K2.2	100	120
K3.1	100	120
K3.2	100	120
K4.1	90	110
K4.2	80	100
K4.3	80	100
S1.1	80	100
S1.2	70	90
S2.1	50	70
S2.2	40	60

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
10	2°	0.04	1.0	5.0	0.06	0.20	5.00
10	2°	0.04	1.0	5.0	0.06	0.20	5.00
12	2°	0.05	1.2	6.0	0.08	0.24	6.00
12	2°	0.05	1.2	6.0	0.08	0.24	6.00
16	2°	0.07	1.6	8.0	0.11	0.32	8.00
16	2°	0.07	1.6	8.0	0.11	0.32	8.00
20	2°	0.10	2.0	10.0	0.17	0.40	10.00
20	2°	0.10	2.0	10.0	0.17	0.40	10.00





图示=右手型
Picture = right hand cutting version



硬质合金牌号
Carbide grades



▲ 库存
on stock

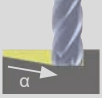


△ 4周
4 weeks

产品型号 Part number	系列 System	SW	Z	d ₁	d ₃	r	l ₃	l ₂	HIS	AN2P
DGK.2.10.1000.00	DG10	8	2	10	9.8	5	16.8	5.5	DG0101	▲
DGK.4.10.1000.00	DG10	8	4	10	9.8	5	16.8	5.5	DG0101	▲
DGK.2.12.1200.00	DG12	10	2	12	11.7	6	19.3	6.5	DG0121	▲
DGK.4.12.1200.00	DG12	10	4	12	11.7	6	19.3	6.5	DG0121	▲
DGK.2.16.1600.00	DG16	13	2	16	15.6	8	24.8	8.5	DG0161	▲
DGK.4.16.1600.00	DG16	13	4	16	15.6	8	24.8	8.5	DG0161	▲
DGK.4.20.2000.00	DG20	17	4	20	19.5	10	30.3	12	DG0201	▲
										P ●
										M ○
										K -
										N -
										S -
										H -

G

	 vc = m/min	 vc = m/min
P1.1	140	160
P1.2	140	160
P1.3	130	150
P1.4	130	150
P1.5	130	150
P1.6	130	150
P2.1	130	150
P2.2	130	150
P2.3	130	150
P2.4	130	150
P3.1	120	140
P3.2	120	140
P4.1	120	140
P4.2	120	140
P5.1	100	120

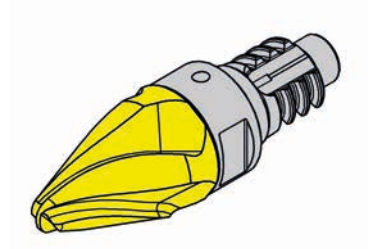
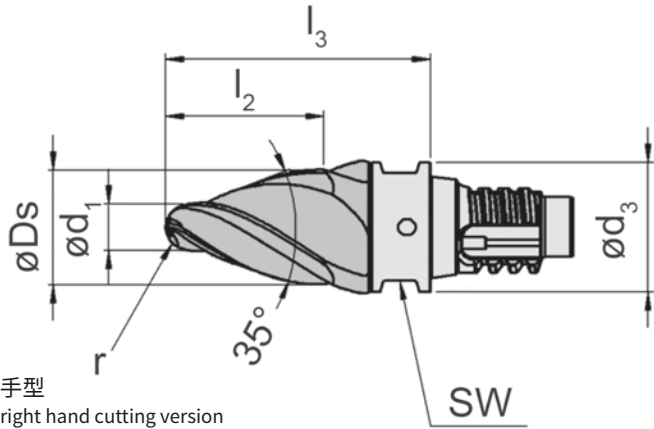
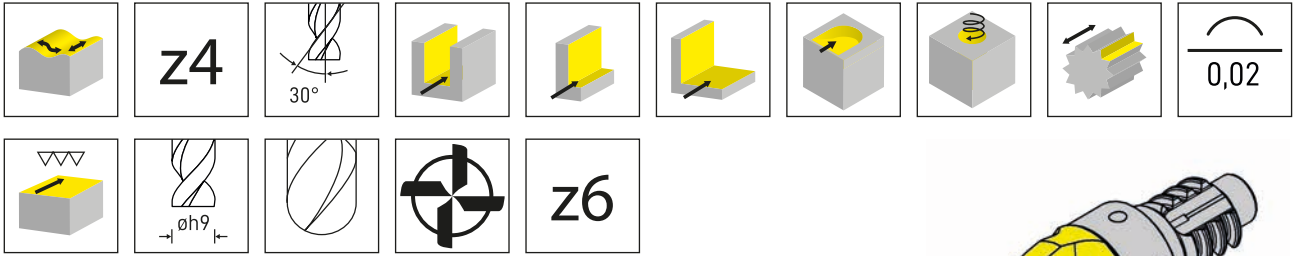
	 vc = m/min	 vc = m/min
M1.1	90	110
M1.2	80	100
M1.3	70	90
K1.1	130	150
K1.2	130	150
K2.1	120	140
K2.2	110	130
K3.1	110	130
K3.2	110	130
K4.1	100	120
K4.2	100	120
K4.3	100	120
S1.1	60	80
S1.2	50	70
S2.1	30	50
S2.2	20	40

d ₁	 α						
		f _z	a _e	a _p	f _z	a _e	a _p
10	5°	0.08	3	3	0.09	0.10	0.50
10	4°	0.05	3	3	0.07	0.10	0.50
12	5°	0.09	4	4	0.10	0.12	0.60
12	4°	0.06	4	4	0.08	0.12	0.60
16	5°	0.11	5	5	0.13	0.16	0.80
16	4°	0.08	5	5	0.11	0.16	0.80
20	5°	0.13	6	6	0.15	0.20	1.00
20	4°	0.10	6	6	0.13	0.20	1.00



刀片 Cutter Head

DGVZ



图示=右手型
Picture = right hand cutting version

硬质合金牌号
Carbide grades

▲ 库存
on stock

△ 4周
4 weeks

产品型号 Part number	系列 System	SW	Z	Ds	d	r	l_3	d_1	a_p	HIS	AN2P
DGVZ.4.10.35.15.00	DG10	8	4	10	9.8	1.5	21	2.86	12.3	DG0101	▲
DGVZ.4.12.35.20.00	DG12	10	4	12	11.7	2	24	3.82	14.3	DG0121	▲
DGVZ.6.16.35.30.00	DG16	13	6	16	15.6	3	32	5.72	18.4	DG0161	▲
DGVZ.6.20.35.50.00	DG20	17	6	20	19.5	5	37	9.54	20.09	DG0201	▲



P	●
M	○
K	-
N	-
S	-
H	-



G

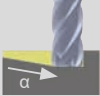


切削参数 DGVZ

Cutting Data DGVZ

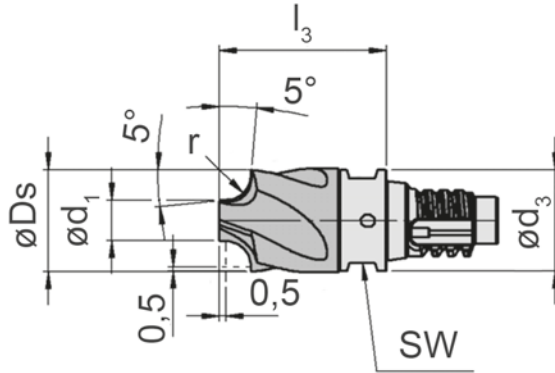
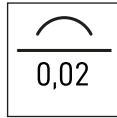
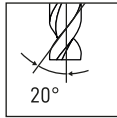
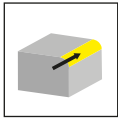


		
	vc = m/min	vc = m/min
P1.1	140	160
P1.2	140	160
P1.3	130	150
P1.4	130	150
P1.5	130	150
P1.6	130	150
P2.1	130	150
P2.2	130	150
P2.3	130	150
P2.4	130	150
P3.1	120	140
P3.2	120	140
P4.1	120	140
P4.2	120	140
P5.1	100	120

		
	vc = m/min	vc = m/min
M1.1	90	110
M1.2	80	100
M1.3	70	90
K1.1	130	150
K1.2	130	150
K2.1	120	140
K2.2	110	130
K3.1	110	130
K3.2	110	130
K4.1	100	120
K4.2	100	120
K4.3	100	120
S1.1	60	80
S1.2	50	70
S2.1	30	50
S2.2	20	40

Ds							
		f_z	a_e	a_p	f_z	a_e	a_p
10	4°	0.06	1.0	5.0	0.11	0.20	5.00
12	4°	0.06	1.0	5.0	0.11	0.20	5.00
16	2°	0.05	1.2	6.0	0.09	0.24	6.00
20	2°	0.05	1.2	6.0	0.09	0.24	6.00





图示=右手型
Picture = right hand cutting version

硬质合金牌号
Carbide grades

▲ 库存
on stock


△ 4周
4 weeks

产品型号 Part number	系列 System	SW	Z	Ds	d ₃	r	l ₃	d ₁	HIS	AN2P
DGV.4.10.R020.00	DG10	8	4	10	9.8	0.2	16.8	8.6	DG0101	▲
DGV.4.10.R050.00	DG10	8	4	10	9.8	0.5	16.8	8	DG0101	▲
DGV.4.10.R100.00	DG10	8	4	10	9.8	1	16.8	7	DG0101	▲
DGV.4.10.R125.00	DG10	8	4	10	9.8	1.25	16.8	6.5	DG0101	▲
DGV.4.10.R150.00	DG10	8	4	10	9.8	1.5	16.8	6	DG0101	▲
DGV.4.10.R200.00	DG10	8	4	10	9.8	2	16.8	5	DG0101	▲
DGV.4.10.R250.00	DG10	8	4	10	9.8	2.5	16.8	4	DG0101	▲
DGV.4.10.R300.00	DG10	8	4	10	9.8	3	16.8	3	DG0101	▲

P	●
M	○
K	-
N	-
S	-
H	-

切削参数 DGV

Cutting Data DGV

vc = m/min

P1.1	140
P1.2	140
P1.3	130
P1.4	130
P1.5	130
P1.6	130
P2.1	130
P2.2	130
P2.3	130
P2.4	130
P3.1	120
P3.2	120
P4.1	120
P4.2	120
P5.1	100



vc = m/min

M1.1	90
M1.2	80
M1.3	70
K1.1	130
K1.2	130
K2.1	120
K2.2	110
K3.1	110
K3.2	110
K4.1	100
K4.2	100
K4.3	100
S1.1	60
S1.2	50
S2.1	30
S2.2	20

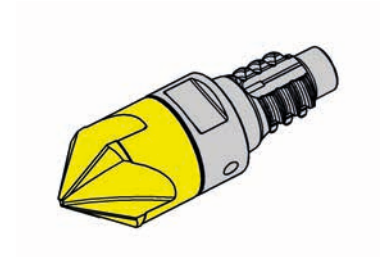
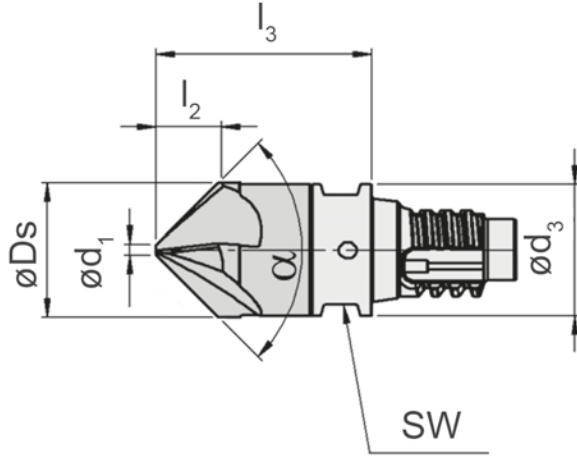


Ds	f_z	a_e	a_p
10	0.08	0.20	0.20
10	0.07	0.50	0.50
10	0.06	1.00	1.00
10	0.05	1.25	1.25
10	0.05	1.50	1.50
10	0.04	2.00	2.00
10	0.04	2.50	2.50
10	0.04	3.00	3.00



刀片 Cutter Head

DGFF



图示=右手型
Picture = right hand cutting version

硬质合金牌号
Carbide grades
▲ 库存
on stock
△ 4周
4 weeks


产品型号 Part number	系列 System	SW	Z	Ds	d ₃	l ₃	l ₂	d ₁	HIS	AN2P
DGFF.3.10.45.00	DG10	8	3	10	9.8	16.8	4	2	DG0101	▲
DGFF.4.10.45.00	DG10	8	4	10	9.8	16.8	4.5	1	DG0101	▲
DGFF.3.12.45.00	DG12	10	3	12	11.7	19.3	5	2	DG0121	▲
DGFF.4.12.45.00	DG12	10	4	12	11.7	19.3	5.5	1	DG0121	▲
DGFF.3.16.45.00	DG16	13	3	16	15.6	24.8	7	2	DG0161	▲
DGFF.6.16.45.00	DG16	13	6	16	15.6	24.8	7.5	1	DG0161	▲

P	●
M	○
K	-
N	-
S	-
H	-

G

切削参数 DGFF

Cutting Data DGFF


vc = m/min

P1.1	140
P1.2	140
P1.3	130
P1.4	130
P1.5	130
P1.6	130
P2.1	130
P2.2	130
P2.3	130
P2.4	130
P3.1	120
P3.2	120
P4.1	120
P4.2	120
P5.1	100



vc = m/min

M1.1	90
M1.2	80
M1.3	70
K1.1	130
K1.2	130
K2.1	120
K2.2	110
K3.1	110
K3.2	110
K4.1	100
K4.2	100
K4.3	100
S1.1	60
S1.2	50
S2.1	30
S2.2	20



Ds	f_z	a_e	a_p
10	0.05	2.5	2.5
10	0.04	2.5	2.5
12	0.05	3.0	3.0
12	0.04	3.0	3.0
16	0.06	4.0	4.0
16	0.04	4.0	4.0

G



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