

车槽 • 切断 • 铣槽 • 插削 • 仿形铣削 • 钻孔 • 铰削



整体硬质合金立铣刀 Solid Carbide Mills

2020



GROOVING • PARTING OFF • GROOVE MILLING • BROACHING • PROFILE MILLING • DRILLING • REAMING



HORN 全新样本 – 以高效作为标杆

我们的刀具为您提供,快速,经济高质量的解决方案. 从系列产品到单个零件,从标准到非标的应用.

- 槽加工
- Supermini 和 Mini 内孔加工
- 模块化系统
- 硬材料加工
- 铣削系统
- 钻孔/铰削
- 整体硬质合金立铣刀
- Boehlerit 铣削
- Boehlerit 车削

在每一个目录里,根据不同切削工艺区分,让您能快速的找到产品描述.
当您选定了特定的切削参数时,您会发现许多经验的数值表格.

Lothar Horn
首席执行官

Paul Horn GmbH

Markus Horn
首席执行官

Paul Horn GmbH

New catalogues from HORN - benchmarks for productivity

Our tools provide you with fast, economical, high quality solutions, from single part to series production, for standard or special applications.

Our complete range of standard tools is summarised in the new catalogues

- Grooving
- Supermini & Mini Internal Machining
- Modular Holder Systems
- Ultra Hard Cutting Materials
- Milling Systems
- Drilling / Reaming
- Solid Carbide Mills
- Milling Catalogue Boehlerit
- Turning Catalogue Boehlerit

In each catalogue, the breakdown into the type of cutting process makes it easier for you to quickly find the products described. When choosing the individual cutting parameters, you will find numerous tables with proven empirical values.

Lothar Horn, CEO
Paul Horn GmbH

Markus Horn, GmbH
Paul Horn GmbH

A 系列 / System DP

整体硬质合金立铣刀用于常规钢件

Solid Carbide End Mills for all common steel materials

B 系列 / System DS

整体硬质合金立铣刀用于

- 高强度钢件
- 高硬度钢件
- 钴铬合金
- 钛合金
- 铝合金

Solid Carbide End Mills for:

- high tensile steels
- hardened steels
- Cobalt Chromium Steels
- Titanium
- Aluminium

C 系列 / System DG

铣刀杆安装可换刀头用于

- 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 shanks with exchangeable cutter heads for:

- Centre Cutting and Groove Milling
- Chamfering and Centering
- Copy Milling
- High Feed Milling
- Gear Milling

D Toodle 高速轴

Toodle High Speed Spindle

	材料	Material			硬度 / Hardness
P1.1	碳钢	Carbon steel	0,2% C		140 HB
P1.2	碳钢	Carbon steel	0,4% C		180 HB
P1.3	碳钢	Carbon steel	0,6% C		200 HB
P2.1	合金钢	Alloyed steel	退火	annealed	180 HB
P2.2	合金钢	Alloyed steel	淬火	quenched	280 HB
P2.3	合金钢	Alloyed steel	淬火	quenched	350 HB
P3.1	高合金钢	high alloyed steel	退火	annealed	200 HB
P3.2	高合金钢	high alloyed steel	淬火	quenched	325 HB
M1.1	不锈钢	Stainless steel	马氏体，铁素体	martensitic, ferritic	200 HB
M2.1	不锈钢	Stainless steel	奥氏体	austenitic	180 HB
M3.1	不锈钢	Stainless steel	奥氏体，铁素体	austenitic, ferritic	260 HB
K1.1	灰口铸铁	Grey cast iron	低强度	low tensile strength	180 HB
K1.2	灰口铸铁	Grey cast iron	高强度	high tensile strength	250 HB
K2.1	球墨铸铁	Spheroidal graphite cast iron	铁素体	ferritic	160 HB
K2.2	球墨铸铁	Spheroidal graphite cast iron	珠光体	perlitic	250 HB
K3.1	可锻铸铁	Malleable cast iron	铁素体	ferritic	125 HB
K3.2	可锻铸铁	Malleable cast iron	珠光体	perlitic	225 HB
N1.1	铝合金	Aluminum alloys	不可热处理	not heat treatable	80 HB
N1.2	铝合金	Aluminum alloys	可热处理	heat treatable	120 HB
N2.1	铸铝	cast Aluminum	< 6% Si	< 6% Si	
N2.2	铸铝	cast Aluminum	6 - 10% Si	6 - 10% Si	
N2.3	铸铝	cast Aluminum	10 - 15% Si	10 - 15% Si	
N3.1	铜合金	Copper alloys	不可热处理	not heat treatable	90 HB
N3.2	铜合金	Copper alloys	可热处理	heat treatable	100 HB
N4.1	有机材料	Synthetics			
S1.1	钛合金	Titanium alloys			280 HB
S2.1	镍基合金	Nickel-base alloys			450 HB
S3.1	钴基合金	Cobalt-base alloys			450 HB
H1.1	超硬钢件	hardened steels			50-55 HRC
H1.2	超硬钢件	hardened steels			56-59 HRC
H1.3	超硬钢件	hardened steels			60-63 HRC
H1.4	超硬钢件	hardened steels			> 63 HRC



刃口过中心切削
Centre cutting



齿数
Number of teeth



动平衡
Balance quality



螺旋角
Helix angle



刀尖圆角
Corner radius



理论圆角
Radius theoretic



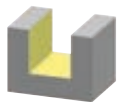
刀尖倒角
Corner chamfer



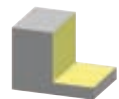
球头铣刀
Full radius



平头铣刀 Sharp



槽铣削
Slot milling



方肩铣削
Corner milling



仿形铣削
Copy milling



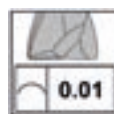
水平铣削
Diving horizontal



水平铣削，坡走铣，螺旋插补铣，
Diving, ramping, helical,



水平铣削，坡走铣，螺旋插补铣，插铣
Diving, ramping, helical, vertical



轮廓公差
Form tolerance



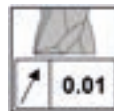
公差
Tolerance



刀柄按 DIN 6535 HA
Shank DIN 6535 HA



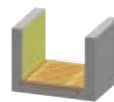
刀柄按 DIN 6535 HA
Shank DIN 6535 HB



跳动
Concentricity



内冷
Internal cooling



摆线铣削
Trochoidal milling



坡走铣
Diving



有效颈部长度
Effective neck length

整体硬质合金立铣刀

Solid Carbide End Mills



	DPSG.3	开粗立铣刀 Roughing End Mill	Ø 2.0 – Ø 20.0	Z 3	A4 – A5
	DPSG.4	开粗立铣刀 Roughing End Mill	Ø 2.0 – Ø 20.0	Z 4	A6 – A7
	DPSV	立铣刀 HPC End Mill HPC	Ø 4.0 – Ø 20.0	Z 4	A8 – A9
	DPX	立铣刀 HPC End Mill HPC	Ø 3.0 – Ø 16.0	Z 4	A10 – A13
	DPSB	开粗立铣刀, 带断屑槽 Roughing End Mill, chip breaker	Ø 4.0 – Ø 20.0	Z 4	A14 – A15
	DPS	开粗立铣刀, 锯齿轮廓 Roughing End Mill with ripper profile	Ø 4.0 – Ø 20.0	Z 3-6	A16 – A17
	DPT	立铣刀, 平头 End Mill, sharp	Ø 1.0 – Ø 16.0	Z 4	A18 – A19
	DPTR.2	环面立铣刀 Torus End Mill	Ø 3.0 – Ø 20.0	Z 2	A20 – A21
	DPTR.4	环面立铣刀 Torus End Mill	Ø 3.0 – Ø 20.0	Z 4	A22 – A23
	DPM	多刃立铣刀 End Mill multiple luted	Ø 6.0 – Ø 20.0	Z 6-8	A24 – A25
	DPK.2	球头立铣刀 Ball Nose End Mill	Ø 1.0 – Ø 16.0	Z 2	A26 – A27
	DPK.3	球头立铣刀 Ball Nose End Mill	Ø 1.5 – Ø 20.0	Z 3	A28 – A29
	DPK.4	球头立铣刀 Ball Nose End Mill	Ø 1.0 – Ø 20.0	Z 4	A30 – A31
	DPFF	倒角立铣刀 60°, 90°, 120° Chamfering End Mill 60°, 90°, 120°	Ø 4.0 – Ø 12.0	Z 4	A32 – A33



整体硬质合金立铣刀

设计用于:

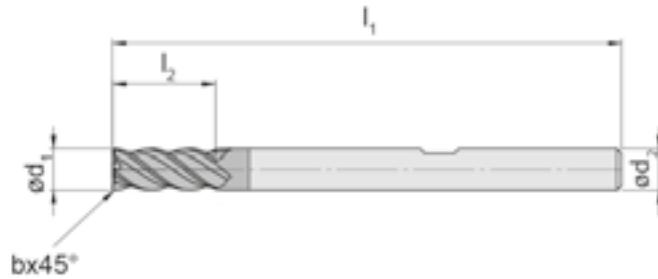
- 设计用于

Solid Carbide End Mills

designed for:

- all common steel materials

DPSG



产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	类型 Version	TF2K
DPSG.3.02.010.03.08	2	0.10	8	3	40	3	HA	▲
DPSG.3.03.010.03.10	3	0.10	10	3	40	3	HA	▲
DPSG.3.04.010.04.12	4	0.10	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	0.20	20	8	65	3	HB	▲
DPSG.3.10.020.10.22	10	0.20	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	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	•
M	o
K	o
N	o
S	o
H	-

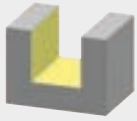
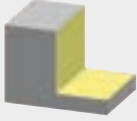
硬质合金牌号
Carbide grades

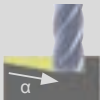
切削参数 DPSG Ø 2.0 - 20.0 mm

Cutting Data DPSG Ø 2.0 - 20.0 mm



A

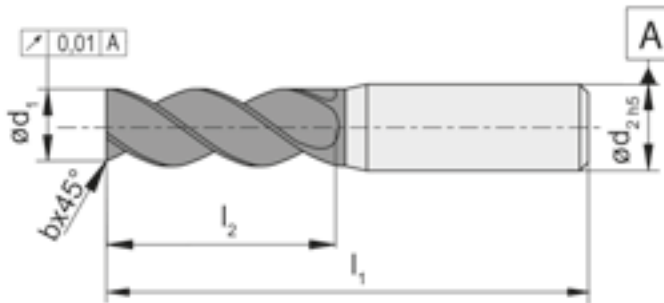
		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

d_1							
		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

尺寸单位 : mm

Dimensions in mm

DPSG



产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	类型 Version	TF2K
DPSG.4.03.010.03.10	3	0.10	10	3	40	4	HA	▲
DPSG.4.04.010.04.12	4	0.10	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	0.20	20	8	65	4	HB	▲
DPSG.4.10.020.10.22	10	0.20	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	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	○
S	○
H	-

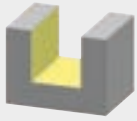
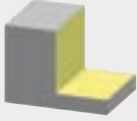
硬质合金牌号
Carbide grades

切削参数 DPSG Ø 3.0 - 20.0 mm

Cutting Data DPSG Ø 3.0 - 20.0 mm



A

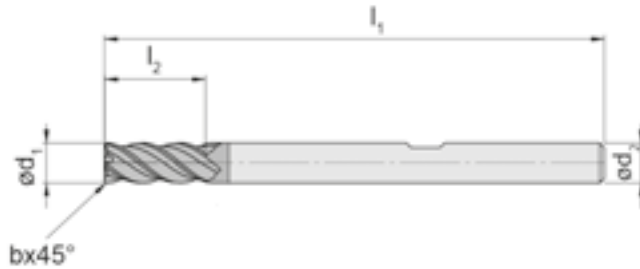
		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

d_1							
		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
20	5°	0.079	20	20	0.127	5.00	40.00

尺寸单位 : mm

Dimensions in mm

DPSV



产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	类型 Version	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	0.40	38	20	104	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	o
K	o
N	o
S	o
H	-

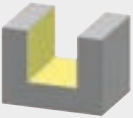
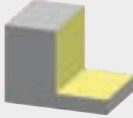
硬质合金牌号
Carbide grades

切削参数 DPSV Ø 4.0 - 20.0 mm

Cutting Data DPSV Ø 4.0 - 20.0 mm



A

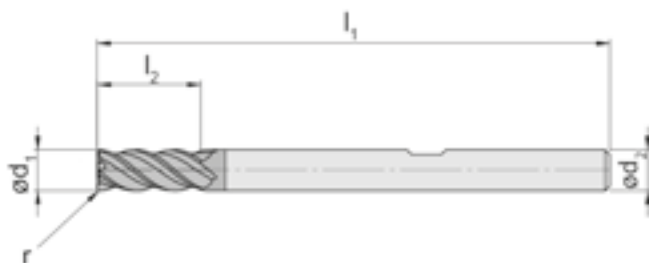
		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	150	180
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	110	130
P3.1	110	130
P3.2	110	130

d_1							
		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

尺寸单位 : mm

Dimensions in mm

DPX



产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Version	TF2K
DPX.4.03.025.06.11	3	0.25	11	6	57	4	HB	▲
DPX.4.03.050.06.13	3	0.50	13	6	57	4	HB	▲
DPX.4.04.050.06.13	4	0.50	13	6	57	4	HB	▲
DPX.4.05.050.06.13	5	0.50	13	6	57	4	HB	▲
DPX.4.06.050.06.13	6	0.50	13	6	57	4	HB	▲
DPX.4.06.100.06.13	6	1.00	13	6	57	4	HB	▲
DPX.4.06.150.06.13	6	1.50	13	6	57	4	HB	▲
DPX.4.08.050.08.19	8	0.50	19	8	63	4	HB	▲
DPX.4.08.100.08.19	8	1.00	19	8	63	4	HB	▲
DPX.4.08.150.08.19	8	1.50	19	8	63	4	HB	▲
DPX.4.10.050.10.22	10	0.50	22	10	72	4	HB	▲
DPX.4.10.100.10.22	10	1.00	22	10	72	4	HB	▲
DPX.4.10.150.10.22	10	1.50	22	10	72	4	HB	▲
DPX.4.12.050.12.26	12	0.50	26	12	83	4	HB	▲
DPX.4.12.150.12.26	12	1.50	26	12	83	4	HB	▲
DPX.4.16.150.16.32	16	1.50	32	16	92	4	HB	▲
DPX.4.16.300.16.32	16	3.00	32	16	92	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	○
S	○
H	-

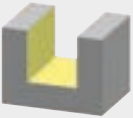
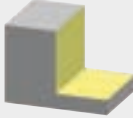
硬质合金牌号
Carbide grades

切削参数 DPX Ø 3.0 - 16.0 mm

Cutting Data DPX Ø 3.0 - 16.0 mm



A

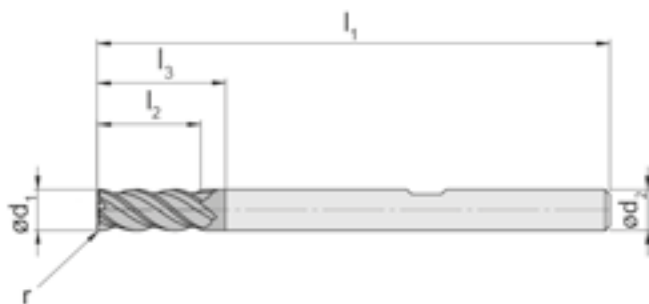
		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	150	180
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	110	130
P3.1	110	130
P3.2	110	130

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

尺寸单位 : mm

Dimensions in mm

DPX



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₂	l ₁	Z	类型 Version	TF2K
DPX.4.03.025.06.A21	3	0.25	11	21	6	57	4	HB	▲
DPX.4.03.050.06.A21	3	0.50	13	21	6	57	4	HB	▲
DPX.4.04.050.06.A21	4	0.50	13	21	6	57	4	HB	▲
DPX.4.05.050.06.A21	5	0.50	13	21	6	57	4	HB	▲
DPX.4.06.050.06.A21	6	0.50	13	21	6	57	4	HB	▲
DPX.4.06.100.06.A21	6	1.00	13	21	6	57	4	HB	▲
DPX.4.06.150.06.A21	6	1.50	13	21	6	57	4	HB	▲
DPX.4.08.050.08.A28	8	0.50	19	28	8	63	4	HB	▲
DPX.4.08.100.08.A28	8	1.00	19	28	8	63	4	HB	▲
DPX.4.08.150.08.A28	8	1.50	19	28	8	63	4	HB	▲
DPX.4.10.050.10.A32	10	0.50	22	32	10	72	4	HB	▲
DPX.4.10.100.10.A32	10	1.00	22	32	10	72	4	HB	▲
DPX.4.10.150.10.A32	10	1.50	22	32	10	72	4	HB	▲
DPX.4.12.050.12.A38	12	0.50	26	38	12	83	4	HB	▲
DPX.4.12.150.12.A38	12	1.50	26	38	12	83	4	HB	▲
DPX.4.16.150.16.A44	16	1.50	32	44	16	92	4	HB	▲
DPX.4.16.300.16.A44	16	3.00	32	44	16	92	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	○
S	○
H	-

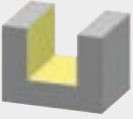
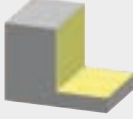
硬质合金牌号
Carbide grades

切削参数 DPX Ø 3.0 - 16.0 mm

Cutting Data DPX Ø 3.0 - 16.0 mm



A

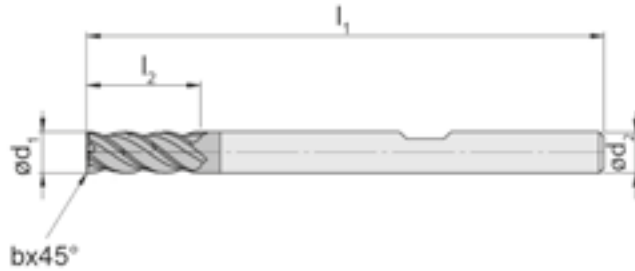
	 $v_c = \text{m/min}$	 $v_c = \text{m/min}$
P1.1	150	180
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	110	130
P3.1	110	130
P3.2	110	130

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

尺寸单位 : mm

Dimensions in mm

DPSB



产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	类型 Version	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	0.40	38	20	104	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	o
K	o
N	o
S	o
H	-

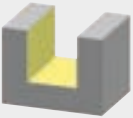
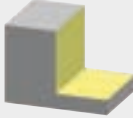
硬质合金牌号
Carbide grades

切削参数 DPSB Ø 4.0 - 20.0 mm

Cutting Data DPSB Ø 4.0 - 20.0 mm



A

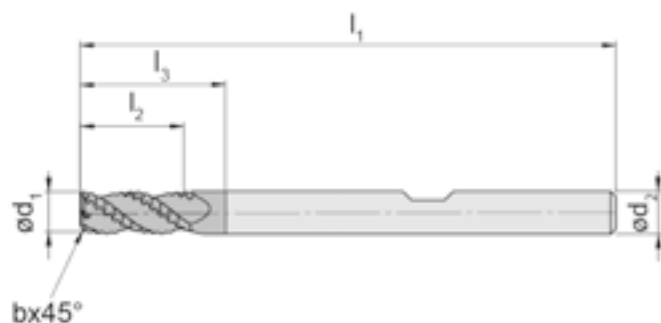
		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

d_1							
		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

尺寸单位 : mm

Dimensions in mm

DPS



产品型号 Part number	d ₁	b	l ₂	l ₃	d ₂	l ₁	Z	类型 Version	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	0.40	38	-	20	104	6	HB	▲
DPS.6.20.040.20.A54	20	0.40	38	54	20	104	6	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	•
M	o
K	o
N	o
S	o
H	-

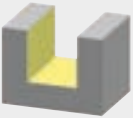
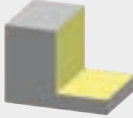
硬质合金牌号
Carbide grades

切削参数 DPS Ø 4.0 - 20.0 mm

Cutting Data DPS Ø 4.0 - 20.0 mm



A

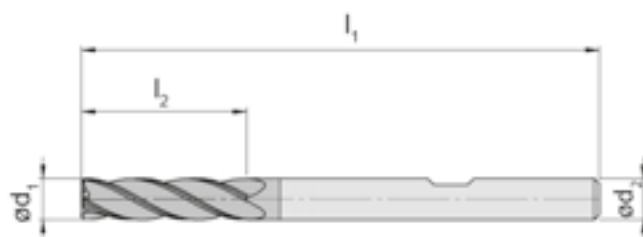
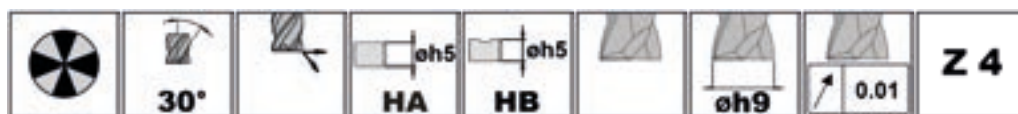
		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

d_1							
		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

尺寸单位 : mm

Dimensions in mm

DPT



产品型号 Part number	d ₁	l ₂	d ₂	l ₁	Z	类型 Version	TF2K
DPT.4.01.00.03.03	1.0	3	3	40	4	HA	▲
DPT.4.15.00.03.05	1.5	5	3	40	4	HA	▲
DPT.4.02.00.03.07	2.0	7	3	40	4	HA	▲
DPT.4.25.00.03.07	2.5	7	3	40	4	HA	▲
DPT.4.03.00.03.10	3.0	10	3	40	4	HA	▲
DPT.4.35.00.04.12	3.5	12	4	50	4	HA	▲
DPT.4.04.00.04.15	4.0	15	4	50	4	HA	▲
DPT.4.45.00.05.15	4.5	15	5	50	4	HA	▲
DPT.4.05.00.05.15	5.0	15	5	50	4	HA	▲
DPT.4.06.00.06.20	6.0	20	6	65	4	HB	▲
DPT.4.07.00.08.20	7.0	20	8	65	4	HB	▲
DPT.4.08.00.08.20	8.0	20	8	65	4	HB	▲
DPT.4.09.00.10.22	9.0	22	10	70	4	HB	▲
DPT.4.10.00.10.22	10.0	22	10	70	4	HB	▲
DPT.4.11.00.11.25	11.0	25	11	70	4	HA	▲
DPT.4.12.00.12.25	12.0	25	12	80	4	HB	▲
DPT.4.14.00.14.30	14.0	30	14	90	4	HA	▲
DPT.4.16.00.16.32	16.0	32	16	90	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	○
S	○
H	-

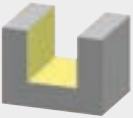
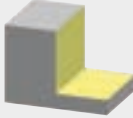
硬质合金牌号
Carbide grades

切削参数 DPT Ø 1.0 - 16.0 mm

Cutting Data DPT Ø 1.0 - 16.0 mm



A

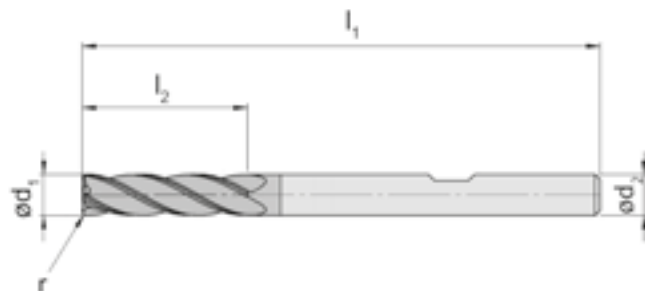
		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

d_1							
		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

尺寸单位 : mm

Dimensions in mm

DPTR



产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Version	TF2K
DPTR.2.03.03.06.12	3	0.3	12	6	50	2	HB	▲
DPTR.2.04.03.06.15	4	0.3	15	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.2.06.03.06.20	6	0.3	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	1.0	20	6	60	2	HB	▲
DPTR.2.08.03.08.25	8	0.3	25	8	70	2	HB	▲
DPTR.2.08.05.08.25	8	0.5	25	8	70	2	HB	▲
DPTR.2.08.10.08.25	8	1.0	25	8	70	2	HB	▲
DPTR.2.08.15.08.25	8	1.5	25	8	70	2	HB	▲
DPTR.2.08.20.08.25	8	2.0	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	1.0	30	10	90	2	HB	▲
DPTR.2.10.15.10.30	10	1.5	30	10	90	2	HB	▲
DPTR.2.10.20.10.30	10	2.0	30	10	90	2	HB	▲
DPTR.2.12.05.12.30	12	0.5	30	12	90	2	HB	▲
DPTR.2.12.10.12.30	12	1.0	30	12	90	2	HB	▲
DPTR.2.12.15.12.30	12	1.5	30	12	90	2	HB	▲
DPTR.2.12.20.12.30	12	2.0	30	12	90	2	HB	▲
DPTR.2.16.05.16.50	16	0.5	50	16	110	2	HB	▲
DPTR.2.16.10.16.50	16	1.0	50	16	110	2	HB	▲
DPTR.2.16.15.16.50	16	1.5	50	16	110	2	HB	▲
DPTR.2.16.20.16.50	16	2.0	50	16	110	2	HB	▲
DPTR.2.20.05.20.50	20	0.5	50	20	110	2	HB	▲
DPTR.2.20.10.20.50	20	1.0	50	20	110	2	HB	▲
DPTR.2.20.15.20.50	20	1.5	50	20	110	2	HB	▲
DPTR.2.20.20.20.50	20	2.0	50	20	110	2	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	○
S	○
H	-

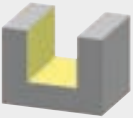
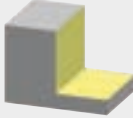
硬质合金牌号
Carbide grades

切削参数 DPTR Ø 3.0 - 20.0 mm

Cutting Data DPTR Ø 3.0 - 20.0 mm



A

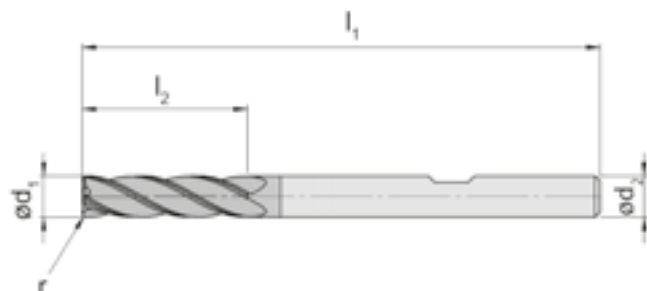
		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

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
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
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
8	5°	0.036	8	8	0.063	2.00	16.00
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
10	5°	0.043	10	10	0.074	2.50	20.00
10	5°	0.043	10	10	0.074	2.50	20.00
12	5°	0.049	12	12	0.086	3.00	24.00
12	5°	0.049	12	12	0.086	3.00	24.00
12	5°	0.049	12	12	0.086	3.00	24.00
12	5°	0.049	12	12	0.086	3.00	24.00
16	5°	0.063	16	16	0.108	4.00	32.00
16	5°	0.063	16	16	0.108	4.00	32.00
16	5°	0.063	16	16	0.108	4.00	32.00
16	5°	0.063	16	16	0.108	4.00	32.00
20	5°	0.076	20	20	0.130	5.00	40.00
20	5°	0.076	20	20	0.130	5.00	40.00
20	5°	0.076	20	20	0.130	5.00	40.00
20	5°	0.076	20	20	0.130	5.00	40.00

尺寸单位 : mm

Dimensions in mm

DPTR



产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Version	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	1.0	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	1.0	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	2.0	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	1.0	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	2.0	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	1.0	30	12	90	4	HB	▲
DPTR.4.12.15.12.30	12	1.5	30	12	90	4	HB	▲
DPTR.4.12.20.12.30	12	2.0	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	1.0	50	16	110	4	HB	▲
DPTR.4.16.15.16.50	16	1.5	50	16	110	4	HB	▲
DPTR.4.16.20.16.50	16	2.0	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	1.0	50	20	110	4	HB	▲
DPTR.4.20.15.20.50	20	1.5	50	20	110	4	HB	▲
DPTR.4.20.20.20.50	20	2.0	50	20	110	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	○
S	○
H	-

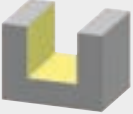
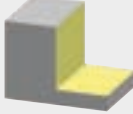
硬质合金牌号
Carbide grades

切削参数 DPTR Ø 3.0 - 20.0 mm

Cutting Data DPTR Ø 3.0 - 20.0 mm



A

		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

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
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
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
20	4°	0.069	20	20	0.116	5.00	40.00

尺寸单位 : mm

Dimensions in mm

DPM



产品型号 Part number	d ₁	l ₂	d ₂	l ₁	Z	类型 Version	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	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	•
M	o
K	o
N	o
S	o
H	-

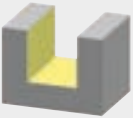
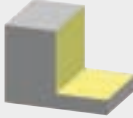
硬质合金牌号
Carbide grades

切削参数 DPM Ø 6.0 - 20.0 mm

Cutting Data DPM Ø 6.0 - 20.0 mm



A

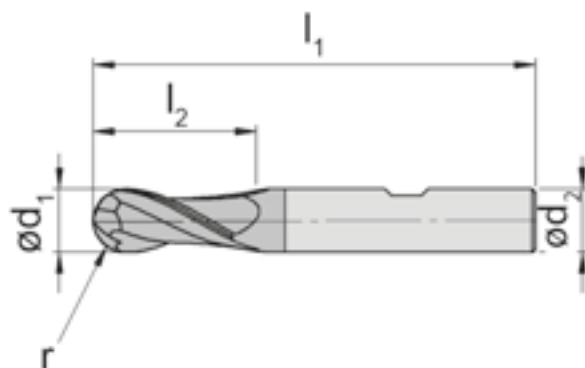
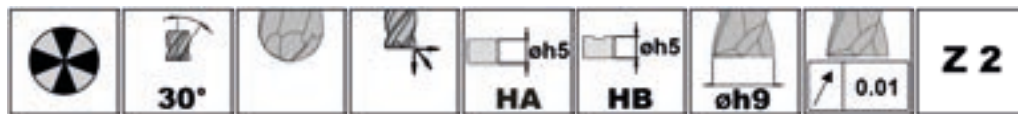
		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
6	3°	0.010	0.60	12.00	0.018	0.06	12.00
8	3°	0.015	0.80	16.00	0.035	0.08	16.00
10	3°	0.021	1.00	20.00	0.053	0.10	20.00
12	3°	0.027	1.20	24.00	0.070	0.12	24.00
16	3°	0.038	1.60	32.00	0.104	0.16	32.00
20	3°	0.040	2.00	40.00	0.110	0.20	38.00

尺寸单位 : mm

Dimensions in mm

DPK



产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Version	TF2K
DPK.2.010.03.03	1.0	0.50	3	3	40	2	HA	▲
DPK.2.015.03.05	1.5	0.75	5	3	40	2	HA	▲
DPK.2.020.03.07	2.0	1.00	7	3	40	2	HA	▲
DPK.2.025.03.07	2.5	1.25	7	3	40	2	HA	▲
DPK.2.030.03.10	3.0	1.50	10	3	40	2	HA	▲
DPK.2.035.04.12	3.5	1.75	12	4	50	2	HA	▲
DPK.2.040.04.15	4.0	2.00	15	4	50	2	HA	▲
DPK.2.045.05.15	4.5	2.25	15	5	50	2	HA	▲
DPK.2.050.05.15	5.0	2.50	15	5	50	2	HA	▲
DPK.2.060.06.20	6.0	3.00	20	6	65	2	HB	▲
DPK.2.080.08.20	8.0	4.00	20	8	65	2	HB	▲
DPK.2.100.10.22	10.0	5.00	22	10	70	2	HB	▲
DPK.2.120.12.25	12.0	6.00	25	12	80	2	HB	▲
DPK.2.160.16.32	16.0	8.00	32	16	90	2	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	○
S	○
H	-

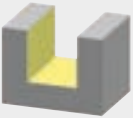
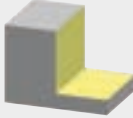
硬质合金牌号
Carbide grades

切削参数 DPK Ø 1.0 - 16.0 mm

Cutting Data DPK Ø 1.0 - 16.0 mm



A

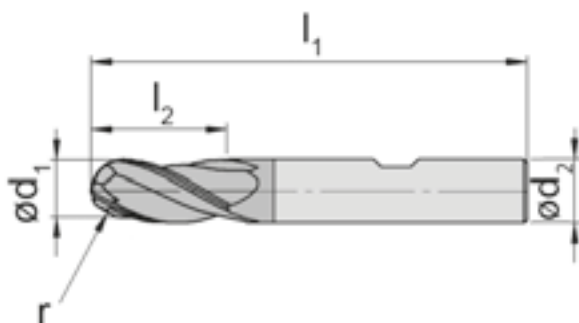
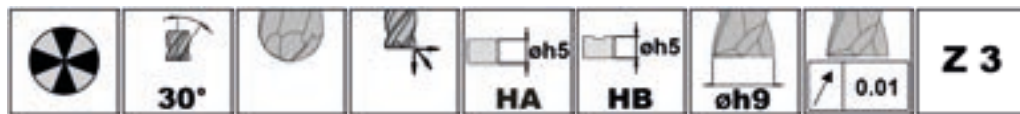
		
	$v_c = \text{m/min}$	$v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

d ₁							
		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

尺寸单位 : mm

Dimensions in mm

DPK



产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Version	TF2K
DPK.3.015.03.05	1.5	0.75	5	3	40	3	HA	▲
DPK.3.020.03.07	2.0	1.00	7	3	40	3	HA	▲
DPK.3.025.03.07	2.5	1.25	7	3	40	3	HA	▲
DPK.3.030.03.10	3.0	1.50	10	3	40	3	HA	▲
DPK.3.035.04.12	3.5	1.75	12	4	50	3	HA	▲
DPK.3.040.04.15	4.0	2.00	15	4	50	3	HA	▲
DPK.3.045.05.15	4.5	2.25	15	5	50	3	HA	▲
DPK.3.050.05.15	5.0	2.50	15	5	50	3	HA	▲
DPK.3.060.06.20	6.0	3.00	20	6	65	3	HB	▲
DPK.3.080.08.20	8.0	4.00	20	8	65	3	HB	▲
DPK.3.100.10.22	10.0	5.00	22	10	70	3	HB	▲
DPK.3.120.12.25	12.0	6.00	25	12	80	3	HB	▲
DPK.3.140.14.30	14.0	7.00	30	14	90	3	HA	▲
DPK.3.160.16.32	16.0	8.00	32	16	90	3	HB	▲
DPK.3.200.20.38	20.0	10.00	38	20	100	3	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	○
S	○
H	-

硬质合金牌号

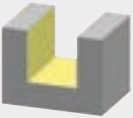
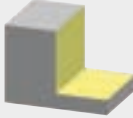
Carbide grades

切削参数 DPK Ø 1.5 - 20.0 mm

Cutting Data DPK Ø 1.5 - 20.0 mm



A

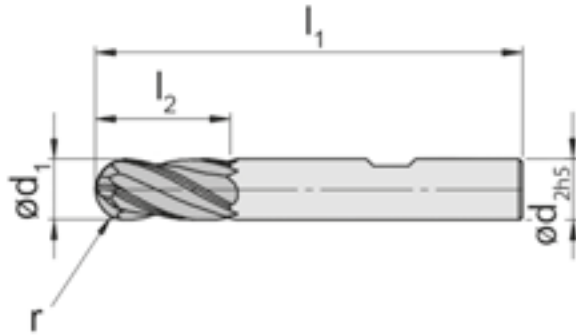
	 $v_c = \text{m/min}$	 $v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

d_1							
		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

尺寸单位 : mm

Dimensions in mm

DPK



产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	类型 Version	TF2K
DPK.4.010.03.03	1.0	0.50	3	3	40	4	HA	▲
DPK.4.015.03.05	1.5	0.75	5	3	40	4	HA	▲
DPK.4.020.03.07	2.0	1.00	7	3	40	4	HA	▲
DPK.4.025.03.07	2.5	1.25	7	3	40	4	HA	▲
DPK.4.030.03.10	3.0	1.50	10	3	40	4	HA	▲
DPK.4.035.04.12	3.5	1.75	12	4	50	4	HA	▲
DPK.4.040.04.15	4.0	2.00	15	4	50	4	HA	▲
DPK.4.050.05.15	5.0	2.50	15	5	50	4	HA	▲
DPK.4.060.06.20	6.0	3.00	20	6	65	4	HB	▲
DPK.4.080.08.20	8.0	4.00	20	8	65	4	HB	▲
DPK.4.100.10.22	10.0	5.00	22	10	70	4	HB	▲
DPK.4.120.12.25	12.0	6.00	25	12	80	4	HB	▲
DPK.4.160.16.32	16.0	8.00	32	16	90	4	HB	▲
DPK.4.200.20.38	20.0	10.00	38	20	100	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	○
S	○
H	-

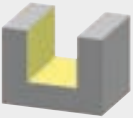
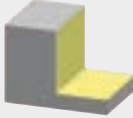
硬质合金牌号
Carbide grades

切削参数 DPK Ø 1.0 - 20.0 mm

Cutting Data DPK Ø 1.0 - 20.0 mm



A

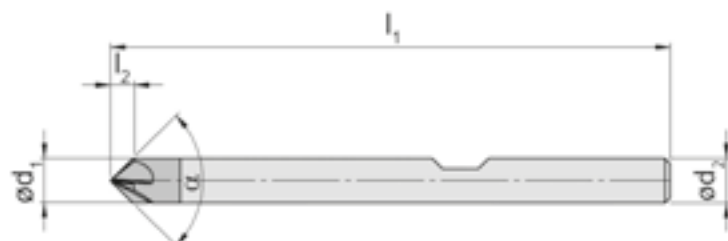
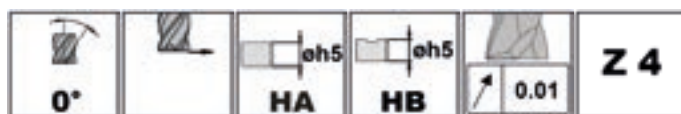
	 $v_c = \text{m/min}$	 $v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

d_1							
		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

尺寸单位 : mm

Dimensions in mm

DPFF



产品型号 Part number	d ₁	α	l ₂	l ₃	d ₂	l ₁	Z	类型 Version	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°	2.0	2.0	4	51	4	HA	▲
DPFF.4.06.030.090	6	90°	3.0	3.0	6	64	4	HB	▲
DPFF.4.08.040.090	8	90°	4.0	4.0	8	64	4	HB	▲
DPFF.4.10.050.090	10	90°	5.0	5.0	10	70	4	HB	▲
DPFF.4.12.060.090	12	90°	6.0	6.0	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	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	○
S	○
H	-

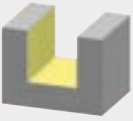
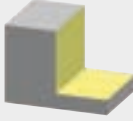
硬质合金牌号
Carbide grades

切削参数 DPT Ø 4.0 - 12.0 mm

Cutting Data DPT Ø 4.0 - 12.0 mm



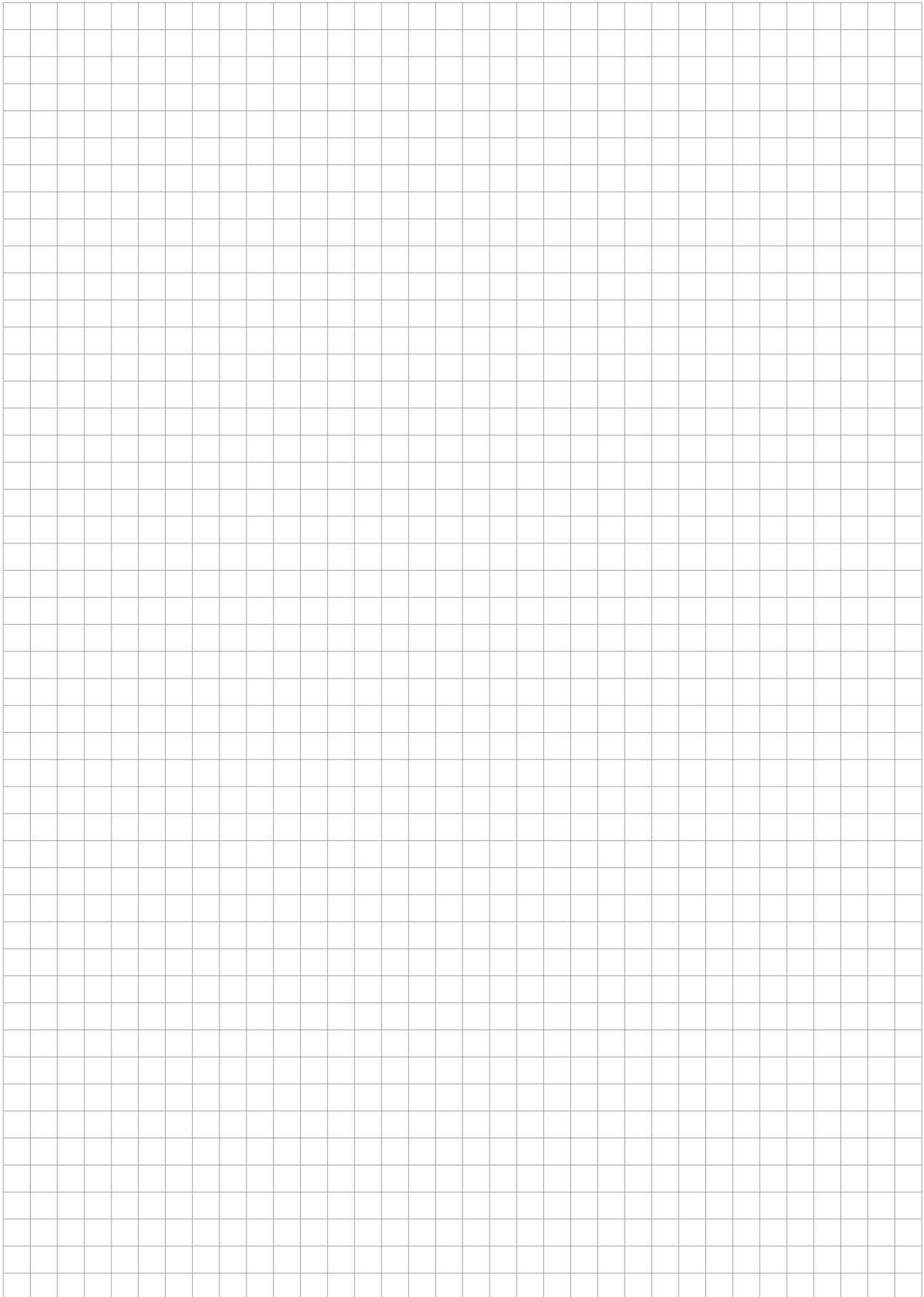
A

	 $v_c = \text{m/min}$	 $v_c = \text{m/min}$
P1.1	130	160
P1.2	120	140
P1.3	120	140
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120

						
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

尺寸单位 : mm

Dimensions in mm





设计用于:/designed for:

页/page

高强度钢件
high tensile steels

B2-B71

淬硬钢件
hardened steels

B72-B115

钴铬合金钢
Cobalt Chromium Steels

B116-B125

钛合金
Titanium

B126-B151

铝合金
Aluminum

B152-B187

整体硬质合金立铣刀

Solid Carbide End Mills



B

	DSKM	圆头微型立铣刀 Ball Nose End Mill Micro	Ø 0.1 – Ø 3.0	Z 2	B4 – B7
	DSTM.2	圆角微型立铣刀 Torus End Mill Micro	Ø 0.1 – Ø 3.0	Z 2	B8 – B17
	DSTM.4	圆角微型立铣刀 Torus End Mill Micro	Ø 0.2 – Ø 3.0	Z 4	B18 – B27
	DSK	圆头立铣刀 Ball Nose End Mill	Ø 3.5 – Ø 16.0	Z 2	B28 – B29
	DST.2	圆角立铣刀 Torus End Mill	Ø 3.5 – Ø 16.0	Z 2	B30 – B37
	DST.4	圆角立铣刀 Torus End Mill	Ø 3.5 – Ø 16.0	Z 4	B38 – B45
	DSM	多刃立铣刀 End Mill multiple luted	Ø 2.0 – Ø 20.0	Z 6-8	B46 – B49
	DSMR	多刃立铣刀, 刀尖为圆角 End Mill multiple fluted, corner radius	Ø 2.0 – Ø 20.0	Z 6-8	B50– B57
	DSR.3	开粗立铣刀, 刀尖为圆角 Roughing End Mill, corner radius	Ø 2.0 – Ø 16.0	Z 3	B58 – B59
	DSF.3	开粗立铣刀, 刀尖为倒角 Roughing End Mill, chamfer	Ø 2.0 – Ø 16.0	Z 3	B60 – B61
	DSF.4	开粗立铣刀, 刀尖为倒角 Roughing End Mill, chamfer	Ø 4.0 – Ø 16.0	Z 4	B62 – B63
	DSFT	摆线铣立铣刀 End Mill Trochoidal Milling	Ø 2.0 – Ø 20.0	Z 4-7	B64 – B67
	DSH	高进给立铣刀 High Feed End Mill	Ø 2.0 – Ø 16.0	Z 4	B68 – B69
	DSFF	90°铣削倒角刀 Chamfering End Mill 90°	Ø 4.0 – Ø 12.0	Z 4	B70 – B71

DS

B



设计用于:

- 高强度钢件

designed for:

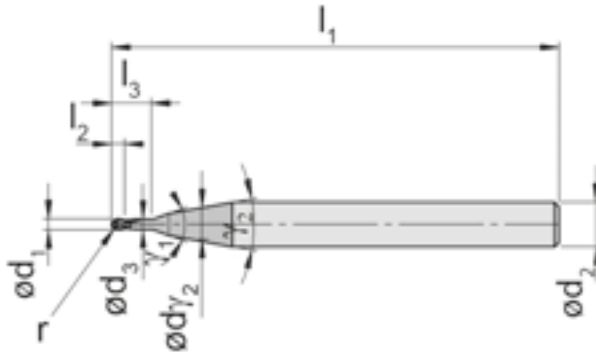
- high tensile steels

球头微型立铣刀

Ball Nose End Mill Micro



DSKM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.2.010.070	0.1	0.05	0.2	0.7	0.08	4	50	2	40°	20°	▲
DSKM.2.020.030	0.2	0.10	0.4	0.6	0.18	4	50	2	20°	-	▲
DSKM.2.020.050	0.2	0.10	0.4	1.0	0.18	4	50	2	40°	20°	▲
DSKM.2.020.070	0.2	0.10	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	0.20	0.8	1.2	0.35	4	50	2	20°	-	▲
DSKM.2.040.050	0.4	0.20	0.8	2.0	0.35	4	50	2	40°	20°	▲
DSKM.2.040.070	0.4	0.20	0.8	2.8	0.35	4	50	2	40°	20°	▲
DSKM.2.050.030	0.5	0.25	1.0	1.5	0.47	4	50	2	20°	-	▲
DSKM.2.050.050	0.5	0.25	1.0	2.5	0.47	4	50	2	40°	20°	▲
DSKM.2.050.070	0.5	0.25	1.0	3.5	0.47	4	50	2	40°	20°	▲
DSKM.2.060.030	0.6	0.30	1.2	1.8	0.55	4	50	2	20°	-	▲
DSKM.2.060.050	0.6	0.30	1.2	3.0	0.55	4	50	2	40°	20°	▲
DSKM.2.060.070	0.6	0.30	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.2.070.070	0.7	0.35	1.4	4.9	0.65	4	50	2	40°	20°	▲
DSKM.2.080.030	0.8	0.40	1.6	2.4	0.75	4	50	2	20°	-	▲
DSKM.2.080.050	0.8	0.40	1.6	4.0	0.75	4	50	2	40°	20°	▲
DSKM.2.080.070	0.8	0.40	1.6	5.6	0.75	4	50	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSKM Ø 0.1 - 0.8 mm

Cutting Data DSKM Ø 0.1 - 0.8 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

												
	d_1		0°	0.5°	1°	2°	3°	f_z	a_e	a_p	f_z	a_e
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
0.1	3°	0.7	0.7	0.7	0.7	0.8	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	1.0	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
0.7	3°	4.9	5.0	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	3.2	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
0.8	3°	5.6	5.7	5.8	6.1	6.4	0.006	0.08	0.08	0.009	0.04	0.05

尺寸单位 : mm
Dimensions in mm

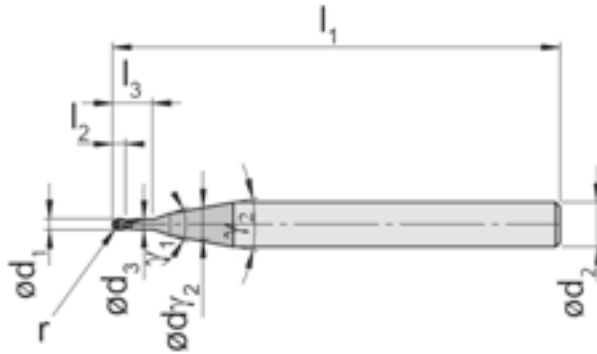
B

球头微型立铣刀

Ball Nose End Mill Micro



DSKM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.2.090.070	0.9	0.45	1.8	6.3	0.85	4	50	2	40°	20°	▲
DSKM.2.100.030	1.0	0.50	2.0	3.0	0.95	4	50	2	20°	-	▲
DSKM.2.100.050	1.0	0.50	2.0	5.0	0.95	4	50	2	40°	20°	▲
DSKM.2.100.070	1.0	0.50	2.0	7.0	0.95	4	50	2	40°	20°	▲
DSKM.2.120.030	1.2	0.60	2.4	3.6	1.15	4	50	2	20°	-	▲
DSKM.2.120.050	1.2	0.60	2.4	6.0	1.15	4	50	2	40°	20°	▲
DSKM.2.120.070	1.2	0.60	2.4	8.4	1.15	4	50	2	40°	20°	▲
DSKM.2.150.030	1.5	0.75	3.0	4.5	1.45	4	50	2	20°	-	▲
DSKM.2.150.050	1.5	0.75	3.0	7.5	1.45	4	50	2	40°	20°	▲
DSKM.2.150.070	1.5	0.75	3.0	10.5	1.45	4	50	2	40°	20°	▲
DSKM.2.200.030	2.0	1.00	4.0	6.0	1.90	4	50	2	20°	-	▲
DSKM.2.200.050	2.0	1.00	4.0	10.0	1.90	4	50	2	40°	20°	▲
DSKM.2.200.070	2.0	1.00	4.0	14.0	1.90	4	50	2	40°	20°	▲
DSKM.2.250.030	2.5	1.25	5.0	7.5	2.40	4	50	2	20°	-	▲
DSKM.2.250.050	2.5	1.25	5.0	12.5	2.40	4	50	2	40°	20°	▲
DSKM.2.250.070	2.5	1.25	5.0	17.5	2.40	4	60	2	40°	20°	▲
DSKM.2.300.030	3.0	1.50	6.0	9.0	2.90	4	50	2	20°	-	▲
DSKM.2.300.050	3.0	1.50	6.0	15.0	2.90	4	50	2	40°	20°	▲
DSKM.2.300.070	3.0	1.50	6.0	21.0	2.90	4	60	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

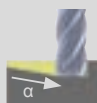
切削参数 DSKM Ø 0.9 - 3.0 mm

Cutting Data DSKM Ø 0.9 - 3.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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
0.9	3°	6.3	6.4	6.5	6.8	7.1	0.007	0.09	0.09	0.010	0.05	0.05
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

尺寸单位 : mm

Dimensions in mm

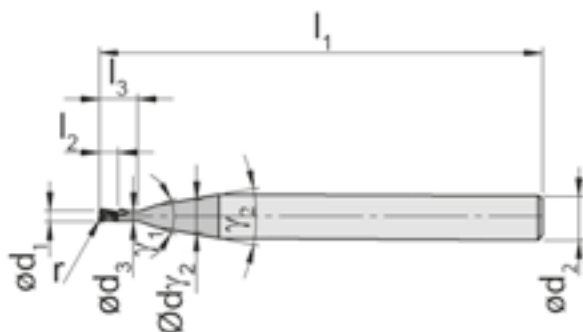
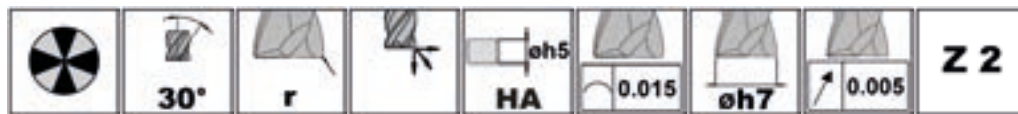
B

圆角微型立铣刀

Torus End Mill Micro



DSTM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ1	γ2	TS3K
DSTM.2.010.000.030	0.1	0	0.2	0.3	0.08	4	50	2	20°	-	▲
DSTM.2.010.000.050	0.1	0	0.2	0.5	0.08	4	50	2	40°	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	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	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	1.0	1.5	0.47	4	50	2	20°	-	▲
DSTM.2.050.000.050	0.5	0	1.0	2.5	0.47	4	50	2	40°	20°	▲
DSTM.2.050.000.070	0.5	0	1.0	3.5	0.47	4	50	2	40°	20°	▲
DSTM.2.050.010.030	0.5	0.1	1.0	1.5	0.47	4	50	2	20°	-	▲
DSTM.2.050.010.050	0.5	0.1	1.0	2.5	0.47	4	50	2	40°	20°	▲
DSTM.2.050.010.070	0.5	0.1	1.0	3.5	0.47	4	50	2	40°	20°	▲
DSTM.2.060.000.030	0.6	0	1.2	1.8	0.60	4	50	2	20°	-	▲
DSTM.2.060.000.050	0.6	0	1.2	3.0	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.2.060.010.030	0.6	0.1	1.2	1.8	0.55	4	50	2	20°	-	▲
DSTM.2.060.010.050	0.6	0.1	1.2	3.0	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°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSTM Ø 0.1 - 0.6 mm

Cutting Data DSTM Ø 0.1 - 0.6 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

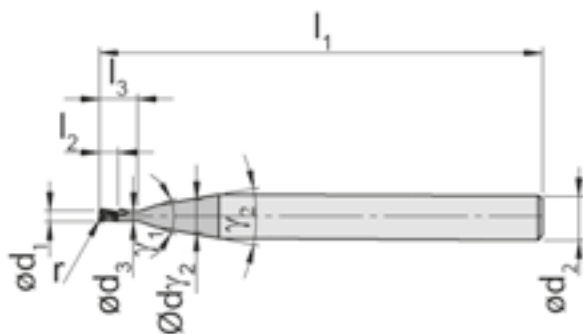
		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

												
	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	5°	0.5	0.5	0.5	0.5	0.5	0.003	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°	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	3.4	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

尺寸单位：mm
Dimensions in mm

B

DSTM



用于高速轴预安装立铣刀直径可达 $\varnothing 3$ mm (见D2)

Pre-assembled available up to $\varnothing 3$ mm for Toodle high-speed spindle (see page D2)

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.2.070.000.050	0.7	0	1.4	3.5	0.65	4	50	2	40°	20°	▲
DSTM.2.070.000.070	0.7	0	1.4	4.9	0.65	4	50	2	40°	20°	▲
DSTM.2.070.010.030	0.7	0.1	1.4	2.1	0.65	4	50	2	20°	-	▲
DSTM.2.070.010.050	0.7	0.1	1.4	3.5	0.65	4	50	2	40°	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	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.2.080.010.030	0.8	0.1	1.6	2.4	0.75	4	50	2	20°	-	▲
DSTM.2.080.010.050	0.8	0.1	1.6	4.0	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.2.090.000.070	0.9	0	1.8	6.3	0.85	4	50	2	40°	20°	▲
DSTM.2.090.010.030	0.9	0.1	1.8	2.7	0.85	4	50	2	20°	-	▲
DSTM.2.090.010.050	0.9	0.1	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	0	2.0	3.0	0.95	4	50	2	20°	-	▲
DSTM.2.100.000.050	1.0	0	2.0	5.0	0.95	4	50	2	40°	20°	▲
DSTM.2.100.000.070	1.0	0	2.0	7.0	0.95	4	50	2	40°	20°	▲
DSTM.2.100.010.030	1.0	0.1	2.0	3.0	0.95	4	50	2	20°	-	▲
DSTM.2.100.010.050	1.0	0.1	2.0	5.0	0.95	4	50	2	40°	20°	▲
DSTM.2.100.010.070	1.0	0.1	2.0	7.0	0.95	4	50	2	40°	20°	▲
DSTM.2.100.020.030	1.0	0.2	2.0	3.0	0.95	4	50	2	20°	-	▲
DSTM.2.100.020.050	1.0	0.2	2.0	5.0	0.95	4	50	2	40°	20°	▲
DSTM.2.100.020.070	1.0	0.2	2.0	7.0	0.95	4	50	2	40°	20°	▲

▲ 库存 / on stock △ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

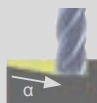
切削参数 DSTM Ø 0.7 - 1.0 mm

Cutting Data DSTM Ø 0.7 - 1.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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°	3.5	3.5	3.6	3.8	3.9	0.007	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
0.7	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°	3.5	3.5	3.6	3.8	3.9	0.007	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	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	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
0.9	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
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	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	3°	7.0	7.1	7.3	7.7	8.1	0.007	0.10	0.10	0.011	0.05	0.06

尺寸单位 : mm
Dimensions in mm

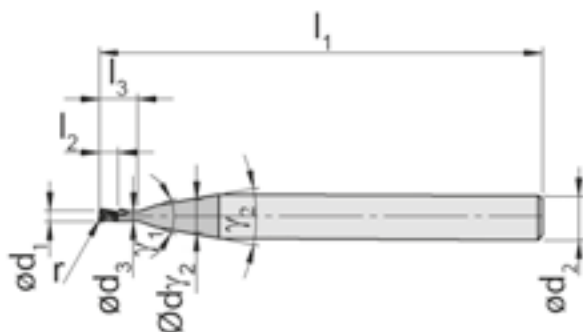
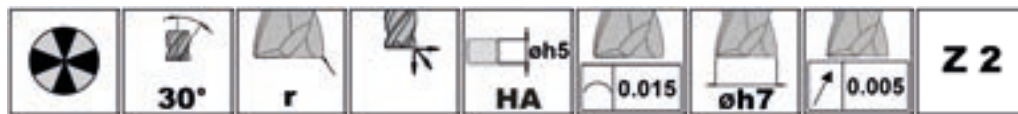
B

圆角微型立铣刀

Torus End Mill Micro



DSTM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.2.120.000.050	1.2	0	2.4	6.0	1.15	4	50	2	40°	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	6.0	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	6.0	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	3.0	4.5	1.45	4	50	2	20°	-	▲
DSTM.2.150.000.050	1.5	0	3.0	7.5	1.45	4	50	2	40°	20°	▲
DSTM.2.150.000.070	1.5	0	3.0	10.5	1.45	4	50	2	40°	20°	▲
DSTM.2.150.010.030	1.5	0.1	3.0	4.5	1.45	4	50	2	20°	-	▲
DSTM.2.150.010.050	1.5	0.1	3.0	7.5	1.45	4	50	2	40°	20°	▲
DSTM.2.150.010.070	1.5	0.1	3.0	10.5	1.45	4	50	2	40°	20°	▲
DSTM.2.150.020.030	1.5	0.2	3.0	4.5	1.45	4	50	2	20°	-	▲
DSTM.2.150.020.050	1.5	0.2	3.0	7.5	1.45	4	50	2	40°	20°	▲
DSTM.2.150.020.070	1.5	0.2	3.0	10.5	1.45	4	50	2	40°	20°	▲
DSTM.2.150.050.030	1.5	0.5	3.0	4.5	1.45	4	50	2	20°	-	▲
DSTM.2.150.050.050	1.5	0.5	3.0	7.5	1.45	4	50	2	40°	20°	▲
DSTM.2.150.050.070	1.5	0.5	3.0	10.5	1.45	4	50	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号

Carbide grades

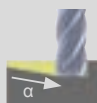
切削参数 DSTM Ø 1.2 - 1.5 mm

Cutting Data DSTM Ø 1.2 - 1.5 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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	5°	6.0	6.1	6.3	6.6	7	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	6.3	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	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°	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°	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	11.5	12.5	0.010	0.15	0.15	0.014	0.08	0.09
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	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	11	11.5	12.4	0.010	0.15	0.15	0.014	0.08	0.09

尺寸单位 : mm

Dimensions in mm

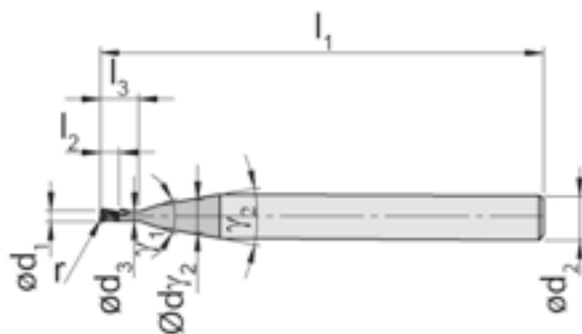
B

圆角微型立铣刀

Torus End Mill Micro



DSTM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ1	γ2	TS3K
DSTM.2.200.000.030	2.0	0	4	6.0	1.9	4	50	2	20°	-	▲
DSTM.2.200.000.050	2.0	0	4	10.0	1.9	4	50	2	40°	20°	▲
DSTM.2.200.000.070	2.0	0	4	14.0	1.9	4	50	2	40°	20°	▲
DSTM.2.200.010.030	2.0	0.1	4	6.0	1.9	4	50	2	20°	-	▲
DSTM.2.200.010.050	2.0	0.1	4	10.0	1.9	4	50	2	40°	20°	▲
DSTM.2.200.010.070	2.0	0.1	4	14.0	1.9	4	50	2	40°	20°	▲
DSTM.2.200.020.030	2.0	0.2	4	6.0	1.9	4	50	2	20°	-	▲
DSTM.2.200.020.050	2.0	0.2	4	10.0	1.9	4	50	2	40°	20°	▲
DSTM.2.200.020.070	2.0	0.2	4	14.0	1.9	4	50	2	40°	20°	▲
DSTM.2.200.050.030	2.0	0.5	4	6.0	1.9	4	50	2	20°	-	▲
DSTM.2.200.050.050	2.0	0.5	4	10.0	1.9	4	50	2	40°	20°	▲
DSTM.2.200.050.070	2.0	0.5	4	14.0	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°	-	▲
DSTM.2.250.020.050	2.5	0.2	5	12.5	2.4	4	50	2	40°	20°	▲
DSTM.2.250.020.070	2.5	0.2	5	17.5	2.4	4	60	2	40°	20°	▲
DSTM.2.250.050.030	2.5	0.5	5	7.5	2.4	4	50	2	20°	-	▲
DSTM.2.250.050.050	2.5	0.5	5	12.5	2.4	4	50	2	40°	20°	▲
DSTM.2.250.050.070	2.5	0.5	5	17.5	2.4	4	60	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

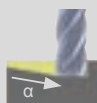
切削参数 DSTM Ø 2.0 - 2.5 mm

Cutting Data DSTM Ø 2.0 - 2.5 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

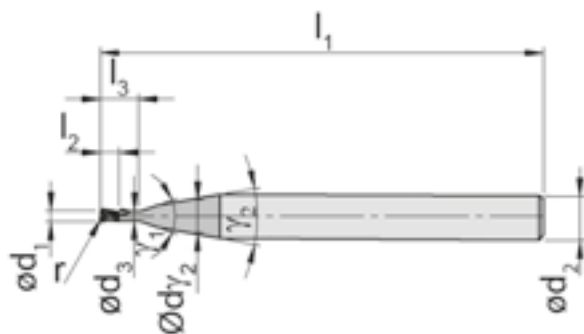
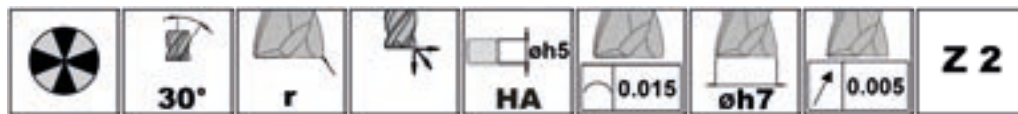
		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

d ₁												
		0°	0.5°	1°	2°	3°	f _z	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
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	19.7	∞	0.015	0.25	0.25	0.021	0.13	0.15
2.5	5°	7.5	7.8	8.2	9.2	10.4	0.019	0.25	0.50	0.027	0.13	0.25
2.5	5°	12.5	12.7	13.1	13.7	∞	0.017	0.25	0.38	0.024	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

尺寸单位 : mm
Dimensions in mm

B

DSTM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.2.300.020.050	3	0.2	6	15	2.9	4	50	2	40°	20°	▲
DSTM.2.300.020.070	3	0.2	6	21	2.9	4	60	2	40°	20°	▲
DSTM.2.300.050.030	3	0.5	6	9	2.9	4	50	2	20°	-	▲
DSTM.2.300.050.050	3	0.5	6	15	2.9	4	50	2	40°	20°	▲
DSTM.2.300.050.070	3	0.5	6	21	2.9	4	60	2	40°	20°	▲
DSTM.2.300.100.030	3	1.0	6	9	2.9	4	50	2	20°	-	▲
DSTM.2.300.100.050	3	1.0	6	15	2.9	4	50	2	40°	20°	▲
DSTM.2.300.100.070	3	1.0	6	21	2.9	4	60	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号

Carbide grades

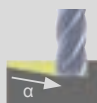
切削参数 DSTM Ø 3.0 mm

Cutting Data DSTM Ø 3.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

												
		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°	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°	15.0	15.3	15.7	∞	∞	0.020	0.30	0.45	0.028	0.15	0.24
3	3°	21.0	21.5	22.2	∞	∞	0.018	0.30	0.30	0.025	0.15	0.18
3	5°	9.0	9.4	9.8	10.9	∞	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	21.4	22.2	∞	∞	0.018	0.30	0.30	0.025	0.15	0.18

尺寸单位 : mm
Dimensions in mm

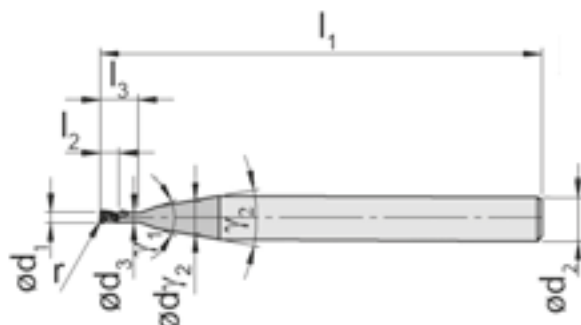
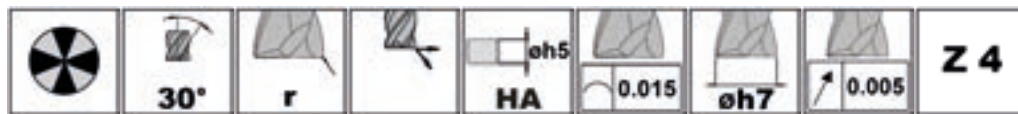
B

圆角微型立铣刀

Torus End Mill Micro



DSTM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ1	γ2	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	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.4.030.000.050	0.3	0	0.6	1.5	0.28	4	50	4	40°	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	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	1.0	1.5	0.47	4	50	4	20°	-	▲
DSTM.4.050.000.050	0.5	0	1.0	2.5	0.47	4	50	4	40°	20°	▲
DSTM.4.050.000.070	0.5	0	1.0	3.5	0.47	4	50	4	40°	20°	▲
DSTM.4.050.010.030	0.5	0.1	1.0	1.5	0.47	4	50	4	20°	-	▲
DSTM.4.050.010.050	0.5	0.1	1.0	2.5	0.47	4	50	4	40°	20°	▲
DSTM.4.050.010.070	0.5	0.1	1.0	3.5	0.47	4	50	4	40°	20°	▲
DSTM.4.060.000.030	0.6	0	1.2	1.8	0.60	4	50	4	20°	-	▲
DSTM.4.060.000.050	0.6	0	1.2	3.0	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	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°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号

Carbide grades

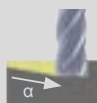
切削参数 DSTM Ø 0.2 - 0.6 mm

Cutting Data DSTM Ø 0.2 - 0.6 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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	4°	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	0.005	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

尺寸单位：mm

Dimensions in mm

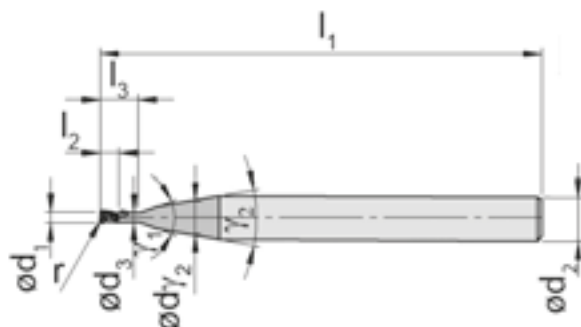
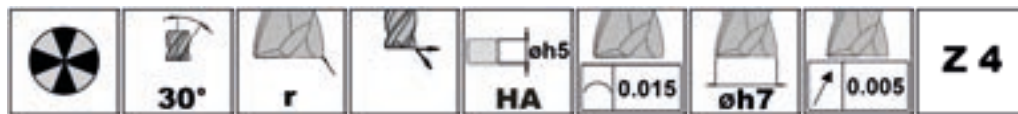
B

圆角微型立铣刀

Torus End Mill Micro



DSTM



用于高速轴预安装立铣刀直径可达 $\varnothing 3\text{ mm}$ (见D2)

Pre-assembled available up to $\varnothing 3\text{ mm}$ for Toodle high-speed spindle (see page D2)

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.4.070.000.070	0.7	0	1.4	4.9	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	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	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.4.090.000.050	0.9	0	1.8	4.5	0.85	4	50	4	40°	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.4.090.010.050	0.9	0.1	1.8	4.5	0.85	4	50	4	40°	20°	▲
DSTM.4.090.010.070	0.9	0.1	1.8	6.3	0.85	4	50	4	40°	20°	▲
DSTM.4.100.000.030	1.0	0	2.0	3.0	0.95	4	50	4	20°	-	▲
DSTM.4.100.000.050	1.0	0	2.0	5.0	0.95	4	50	4	40°	20°	▲
DSTM.4.100.000.070	1.0	0	2.0	7.0	0.95	4	50	4	40°	20°	▲
DSTM.4.100.010.030	1.0	0.1	2.0	3.0	0.95	4	50	4	20°	-	▲
DSTM.4.100.010.050	1.0	0.1	2.0	5.0	0.95	4	50	4	40°	20°	▲
DSTM.4.100.010.070	1.0	0.1	2.0	7.0	0.95	4	50	4	40°	20°	▲
DSTM.4.100.020.030	1.0	0.2	2.0	3.0	0.95	4	50	4	20°	-	▲
DSTM.4.100.020.050	1.0	0.2	2.0	5.0	0.95	4	50	4	40°	20°	▲
DSTM.4.100.020.070	1.0	0.2	2.0	7.0	0.95	4	50	4	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

P	●
M	○
K	○
N	-
S	○
H	○

尺寸单位 : mm

Dimensions in mm

B20

硬质合金牌号

Carbide grades

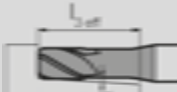
切削参数 DSTM Ø 0.7 - 1.0 mm

Cutting Data DSTM Ø 0.7 - 1.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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	3°	4.9	4.9	5.1	5.3	5.5	0.006	0.07	0.07	0.008	0.04	0.04
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	4°	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	0.009	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
0.9	4°	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	0.009	0.05	0.05
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

尺寸单位：mm
Dimensions in mm

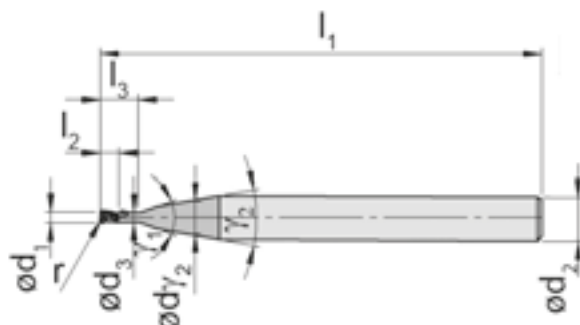
B

圆角微型立铣刀

Torus End Mill Micro



DSTM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	6.0	1.15	4	50	4	40°	20°	▲
DSTM.4.120.000.070	1.2	0	2.4	8.4	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	6.0	1.15	4	50	4	40°	20°	▲
DSTM.4.120.010.070	1.2	0.1	2.4	8.4	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	6.0	1.15	4	50	4	40°	20°	▲
DSTM.4.120.020.070	1.2	0.2	2.4	8.4	1.15	4	50	4	40°	20°	▲
DSTM.4.150.000.030	1.5	0	3.0	4.5	1.45	4	50	4	20°	-	▲
DSTM.4.150.000.050	1.5	0	3.0	7.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.000.070	1.5	0	3.0	10.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.010.030	1.5	0.1	3.0	4.5	1.45	4	50	4	20°	-	▲
DSTM.4.150.010.050	1.5	0.1	3.0	7.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.010.070	1.5	0.1	3.0	10.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.020.030	1.5	0.2	3.0	4.5	1.45	4	50	4	20°	-	▲
DSTM.4.150.020.050	1.5	0.2	3.0	7.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.020.070	1.5	0.2	3.0	10.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.050.030	1.5	0.5	3.0	4.5	1.45	4	50	4	20°	-	▲
DSTM.4.150.050.050	1.5	0.5	3.0	7.5	1.45	4	50	4	40°	20°	▲
DSTM.4.150.050.070	1.5	0.5	3.0	10.5	1.45	4	50	4	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号

Carbide grades

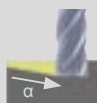
切削参数 DSTM Ø 1.2 - 1.5 mm

Cutting Data DSTM Ø 1.2 - 1.5 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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	3°	8.4	8.6	8.8	9.2	10	0.008	0.12	0.12	0.012	0.06	0.07
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	3°	8.4	8.6	8.8	9.2	10	0.008	0.12	0.12	0.012	0.06	0.07
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
1.2	3°	8.4	8.5	8.8	9.2	10	0.008	0.12	0.12	0.012	0.06	0.07
1.5	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
1.5	4°	7.5	7.6	7.8	8.2	8.6	0.011	0.15	0.23	0.015	0.08	0.12
1.5	3°	10.5	10.7	11	11.5	12.4	0.010	0.15	0.15	0.014	0.08	0.09

尺寸单位：mm

Dimensions in mm

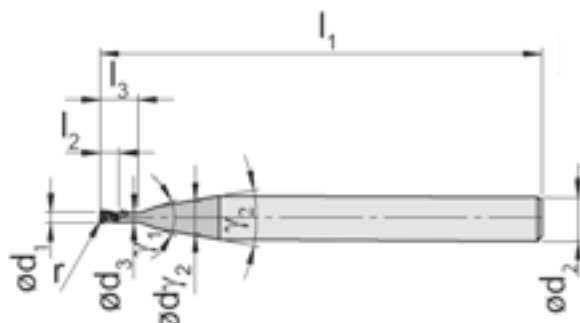
B

圆角微型立铣刀

Torus End Mill Micro



DSTM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ1	γ2	TS3K
DSTM.4.200.000.030	2.0	0	4	6.0	1.9	4	50	4	20°	-	▲
DSTM.4.200.000.050	2.0	0	4	10.0	1.9	4	50	4	40°	20°	▲
DSTM.4.200.000.070	2.0	0	4	14.0	1.9	4	50	4	40°	20°	▲
DSTM.4.200.010.030	2.0	0.1	4	6.0	1.9	4	50	4	20°	-	▲
DSTM.4.200.010.050	2.0	0.1	4	10.0	1.9	4	50	4	40°	20°	▲
DSTM.4.200.010.070	2.0	0.1	4	14.0	1.9	4	50	4	40°	20°	▲
DSTM.4.200.020.030	2.0	0.2	4	6.0	1.9	4	50	4	20°	-	▲
DSTM.4.200.020.050	2.0	0.2	4	10.0	1.9	4	50	4	40°	20°	▲
DSTM.4.200.020.070	2.0	0.2	4	14.0	1.9	4	50	4	40°	20°	▲
DSTM.4.200.050.030	2.0	0.5	4	6.0	1.9	4	50	4	20°	-	▲
DSTM.4.200.050.050	2.0	0.5	4	10.0	1.9	4	50	4	40°	20°	▲
DSTM.4.200.050.070	2.0	0.5	4	14.0	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°	▲
DSTM.4.250.050.070	2.5	0.5	5	17.5	2.4	4	60	4	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

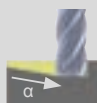
切削参数 DSTM Ø 2.0 - 2.5 mm

Cutting Data DSTM Ø 2.0 - 2.5 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

d ₁												
		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
2.5	3°	17.5	17.9	18.3	19.7	∞	0.015	0.25	0.25	0.021	0.13	0.15

尺寸单位 : mm
Dimensions in mm

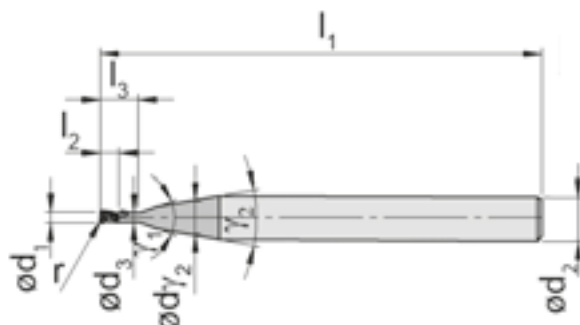
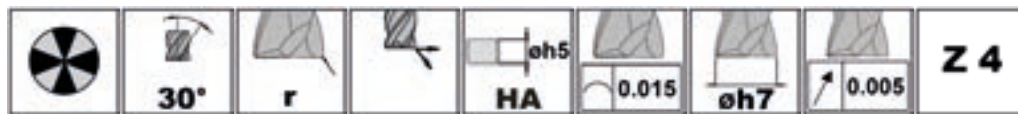
B

圆角微型立铣刀

Torus End Mill Micro



DSTM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ1	γ2	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	1.0	6	9	2.9	4	50	4	20°	-	▲
DSTM.4.300.100.050	3	1.0	6	15	2.9	4	50	4	40°	20°	▲
DSTM.4.300.100.070	3	1.0	6	21	2.9	4	60	4	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

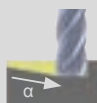
切削参数 DSTM Ø 3.0 mm

Cutting Data DSTM Ø 3.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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

尺寸单位 : mm
Dimensions in mm

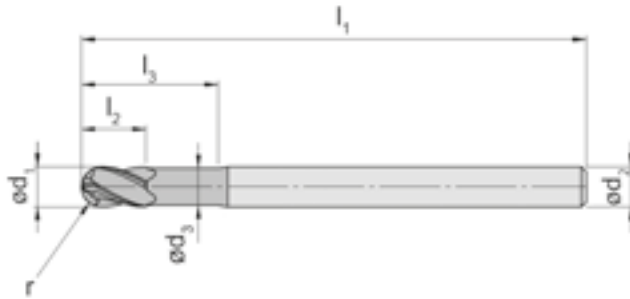
B

球头立铣刀

Ball Nose End Mill



DSK



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.2.035.070	3.5	1.75	7	24.5	3.4	6	64	2	40°	HA	▲
DSK.2.040.030	4.0	2.00	8	12.0	3.8	6	64	2	40°	HA	▲
DSK.2.040.050	4.0	2.00	8	20.0	3.8	6	64	2	40°	HA	▲
DSK.2.040.070	4.0	2.00	8	28.0	3.8	6	78	2	40°	HA	▲
DSK.2.050.030	5.0	2.50	10	15.0	4.7	6	64	2	40°	HA	▲
DSK.2.050.050	5.0	2.50	10	25.0	4.7	6	64	2	40°	HA	▲
DSK.2.050.070	5.0	2.50	10	35.0	4.7	6	78	2	40°	HA	▲
DSK.2.060.030	6.0	3.00	12	18.0	5.7	6	64	2	-	HA	▲
DSK.2.060.050	6.0	3.00	12	30.0	5.7	6	78	2	-	HA	▲
DSK.2.060.070	6.0	3.00	12	42.0	5.7	6	100	2	-	HA	▲
DSK.2.080.030	8.0	4.00	16	24.0	7.6	8	64	2	-	HA	▲
DSK.2.080.050	8.0	4.00	16	40.0	7.6	8	100	2	-	HA	▲
DSK.2.080.070	8.0	4.00	16	56.0	7.6	8	100	2	-	HA	▲
DSK.2.100.030	10.0	5.00	20	30.0	9.6	10	78	2	-	HA	▲
DSK.2.100.050	10.0	5.00	20	50.0	9.6	10	100	2	-	HA	▲
DSK.2.100.070	10.0	5.00	20	70.0	9.6	10	120	2	-	HA	▲
DSK.2.120.030	12.0	6.00	24	36.0	11.6	12	100	2	-	HA	▲
DSK.2.120.050	12.0	6.00	24	60.0	11.6	12	120	2	-	HA	▲
DSK.2.120.070	12.0	6.00	24	84.0	11.6	12	140	2	-	HA	▲
DSK.2.160.030	16.0	8.00	32	48.0	15.4	16	100	2	-	HA	▲
DSK.2.160.050	16.0	8.00	32	80.0	15.4	16	140	2	-	HA	▲
DSK.2.160.070	16.0	8.00	32	112.0	15.4	16	163	2	-	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSK Ø 3.5 - 16.0 mm

Cutting Data DSK Ø 3.5 - 16.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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
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
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
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
16.0	5°	0.10	1.60	3.20	0.15	0.80	1.60
16.0	5°	0.10	1.60	3.20	0.15	0.80	1.60

尺寸单位 : mm

Dimensions in mm

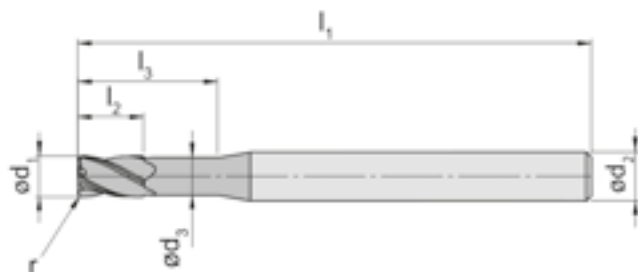
B

圆角立铣刀

Torus End Mill



DST



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.2.035.020.030	3.5	0.2	7	10.5	3.4	6	64	2	40°	HA	▲
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.2.035.100.030	3.5	1.0	7	10.5	3.4	6	64	2	40°	HA	▲
DST.2.035.100.050	3.5	1.0	7	17.5	3.4	6	64	2	40°	HA	▲
DST.2.035.100.070	3.5	1.0	7	24.5	3.4	6	64	2	40°	HA	▲
DST.2.040.020.030	4.0	0.2	8	12.0	3.8	6	64	2	40°	HA	▲
DST.2.040.020.050	4.0	0.2	8	20.0	3.8	6	64	2	40°	HA	▲
DST.2.040.020.070	4.0	0.2	8	28.0	3.8	6	78	2	40°	HA	▲
DST.2.040.050.030	4.0	0.5	8	12.0	3.8	6	64	2	40°	HA	▲
DST.2.040.050.050	4.0	0.5	8	20.0	3.8	6	64	2	40°	HA	▲
DST.2.040.050.070	4.0	0.5	8	28.0	3.8	6	78	2	40°	HA	▲
DST.2.040.100.030	4.0	1.0	8	12.0	3.8	6	64	2	40°	HA	▲
DST.2.040.100.050	4.0	1.0	8	20.0	3.8	6	64	2	40°	HA	▲
DST.2.040.100.070	4.0	1.0	8	28.0	3.8	6	78	2	40°	HA	▲
DST.2.050.020.030	5.0	0.2	10	15.0	4.7	6	64	2	40°	HA	▲
DST.2.050.020.050	5.0	0.2	10	25.0	4.7	6	64	2	40°	HA	▲
DST.2.050.020.070	5.0	0.2	10	35.0	4.7	6	78	2	40°	HA	▲
DST.2.050.050.030	5.0	0.5	10	15.0	4.7	6	64	2	40°	HA	▲
DST.2.050.050.050	5.0	0.5	10	25.0	4.7	6	64	2	40°	HA	▲
DST.2.050.050.070	5.0	0.5	10	35.0	4.7	6	78	2	40°	HA	▲
DST.2.050.100.030	5.0	1.0	10	15.0	4.7	6	64	2	40°	HA	▲
DST.2.050.100.050	5.0	1.0	10	25.0	4.7	6	64	2	40°	HA	▲
DST.2.050.100.070	5.0	1.0	10	35.0	4.7	6	78	2	40°	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

P	●
M	○
K	○
N	-
S	○
H	○

切削参数 DST Ø 3.5 - 5.0 mm

Cutting Data DST Ø 3.5 - 5.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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
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
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
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

尺寸单位：mm

Dimensions in mm

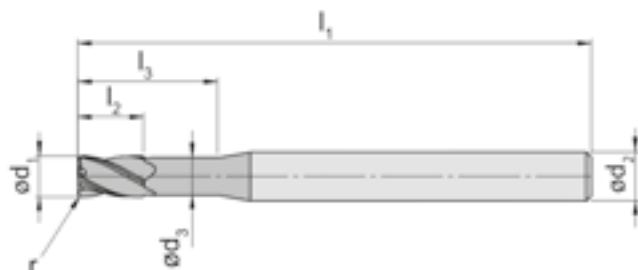
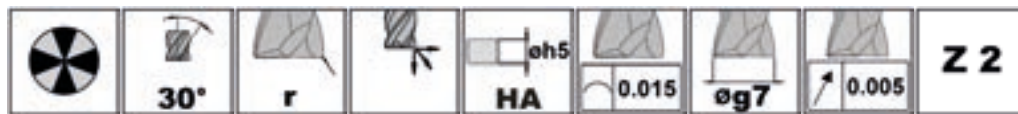
B

圆角立铣刀

Torus End Mill



DST



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.2.060.020.050	6	0.2	12	30	5.7	6	78	2	HA	▲
DST.2.060.020.070	6	0.2	12	42	5.7	6	100	2	HA	▲
DST.2.060.050.030	6	0.5	12	18	5.7	6	64	2	HA	▲
DST.2.060.050.050	6	0.5	12	30	5.7	6	78	2	HA	▲
DST.2.060.050.070	6	0.5	12	42	5.7	6	100	2	HA	▲
DST.2.060.100.030	6	1.0	12	18	5.7	6	64	2	HA	▲
DST.2.060.100.050	6	1.0	12	30	5.7	6	78	2	HA	▲
DST.2.060.100.070	6	1.0	12	42	5.7	6	100	2	HA	▲
DST.2.060.200.030	6	2.0	12	18	5.7	6	64	2	HA	▲
DST.2.060.200.050	6	2.0	12	30	5.7	6	78	2	HA	▲
DST.2.060.200.070	6	2.0	12	42	5.7	6	100	2	HA	▲
DST.2.080.020.030	8	0.2	16	24	7.6	8	64	2	HA	▲
DST.2.080.020.050	8	0.2	16	40	7.6	8	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.2.080.100.030	8	1.0	16	24	7.6	8	64	2	HA	▲
DST.2.080.100.050	8	1.0	16	40	7.6	8	100	2	HA	▲
DST.2.080.100.070	8	1.0	16	56	7.6	8	100	2	HA	▲
DST.2.080.200.030	8	2.0	16	24	7.6	8	64	2	HA	▲
DST.2.080.200.050	8	2.0	16	40	7.6	8	100	2	HA	▲
DST.2.080.200.070	8	2.0	16	56	7.6	8	100	2	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DST Ø 6.0 - 8.0 mm

Cutting Data DST Ø 6.0 - 8.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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
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
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
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

尺寸单位 : mm
Dimensions in mm

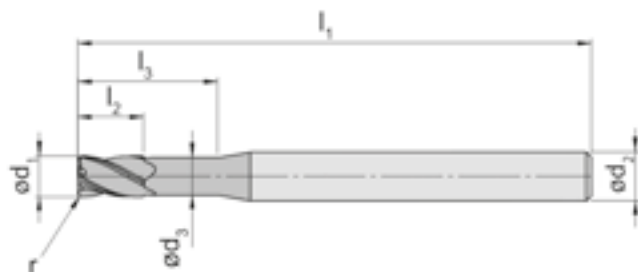
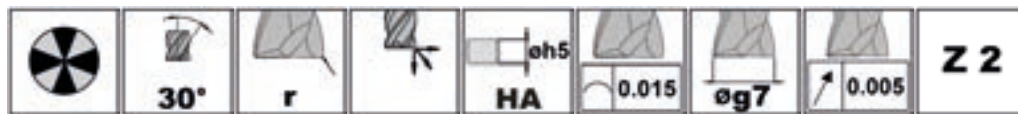
B

圆角立铣刀

Torus End Mill



DST



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.2.100.020.050	10	0.2	20	50	9.6	10	100	2	HA	▲
DST.2.100.020.070	10	0.2	20	70	9.6	10	120	2	HA	▲
DST.2.100.050.030	10	0.5	20	30	9.6	10	78	2	HA	▲
DST.2.100.050.050	10	0.5	20	50	9.6	10	100	2	HA	▲
DST.2.100.050.070	10	0.5	20	70	9.6	10	120	2	HA	▲
DST.2.100.100.030	10	1.0	20	30	9.6	10	78	2	HA	▲
DST.2.100.100.050	10	1.0	20	50	9.6	10	100	2	HA	▲
DST.2.100.100.070	10	1.0	20	70	9.6	10	120	2	HA	▲
DST.2.100.200.030	10	2.0	20	30	9.6	10	78	2	HA	▲
DST.2.100.200.050	10	2.0	20	50	9.6	10	100	2	HA	▲
DST.2.100.200.070	10	2.0	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.2.120.020.050	12	0.2	24	60	11.6	12	120	2	HA	▲
DST.2.120.020.070	12	0.2	24	84	11.6	12	140	2	HA	▲
DST.2.120.050.030	12	0.5	24	36	11.6	12	100	2	HA	▲
DST.2.120.050.050	12	0.5	24	60	11.6	12	120	2	HA	▲
DST.2.120.050.070	12	0.5	24	84	11.6	12	140	2	HA	▲
DST.2.120.100.030	12	1.0	24	36	11.6	12	100	2	HA	▲
DST.2.120.100.050	12	1.0	24	60	11.6	12	120	2	HA	▲
DST.2.120.100.070	12	1.0	24	84	11.6	12	140	2	HA	▲
DST.2.120.200.030	12	2.0	24	36	11.6	12	100	2	HA	▲
DST.2.120.200.050	12	2.0	24	60	11.6	12	120	2	HA	▲
DST.2.120.200.070	12	2.0	24	84	11.6	12	140	2	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

硬质合金牌号
Carbide grades

P	●
M	○
K	○
N	-
S	○
H	○

切削参数 DST Ø 10.0 - 12.0 mm

Cutting Data DST Ø 10.0 - 12.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

B

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
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
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
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
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
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
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
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
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
12	5°	0.079	1.20	2.40	0.112	0.60	1.20

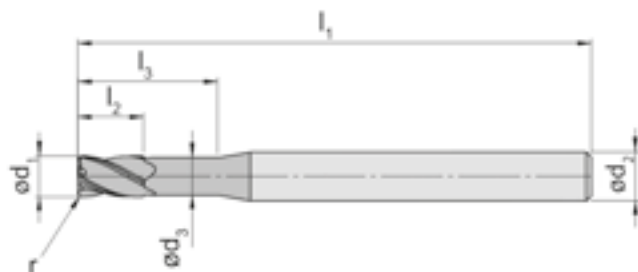
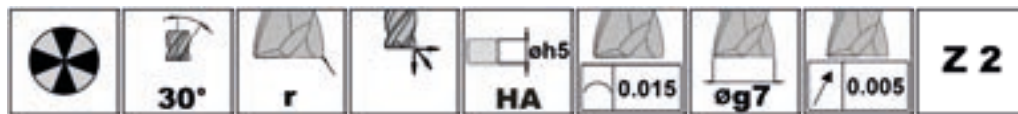
尺寸单位 : mm
Dimensions in mm

圆角立铣刀

Torus End Mill



DST



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.2.160.020.030	16	0.2	32	48	15.4	16	100	2	HA	▲
DST.2.160.020.050	16	0.2	32	80	15.4	16	140	2	HA	▲
DST.2.160.020.070	16	0.2	32	112	15.4	16	163	2	HA	▲
DST.2.160.050.030	16	0.5	32	48	15.4	16	100	2	HA	▲
DST.2.160.050.050	16	0.5	32	80	15.4	16	140	2	HA	▲
DST.2.160.050.070	16	0.5	32	112	15.4	16	163	2	HA	▲
DST.2.160.100.030	16	1.0	32	48	15.4	16	100	2	HA	▲
DST.2.160.100.050	16	1.0	32	80	15.4	16	140	2	HA	▲
DST.2.160.100.070	16	1.0	32	112	15.4	16	163	2	HA	▲
DST.2.160.200.030	16	2.0	32	48	15.4	16	100	2	HA	▲
DST.2.160.200.050	16	2.0	32	80	15.4	16	140	2	HA	▲
DST.2.160.200.070	16	2.0	32	112	15.4	16	163	2	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DST Ø 16.0 mm

Cutting Data DST Ø 16.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

B

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
16	5°	0.104	1.60	3.20	0.147	0.80	1.60
16	5°	0.104	1.60	3.20	0.147	0.80	1.60
16	5°	0.104	1.60	3.20	0.147	0.80	1.60
16	5°	0.104	1.60	3.20	0.147	0.80	1.60
16	5°	0.104	1.60	3.20	0.147	0.80	1.60
16	5°	0.104	1.60	3.20	0.147	0.80	1.60
16	5°	0.104	1.60	3.20	0.147	0.80	1.60
16	5°	0.104	1.60	3.20	0.147	0.80	1.60
16	5°	0.104	1.60	3.20	0.147	0.80	1.60
16	5°	0.104	1.60	3.20	0.147	0.80	1.60
16	5°	0.104	1.60	3.20	0.147	0.80	1.60

尺寸单位 : mm

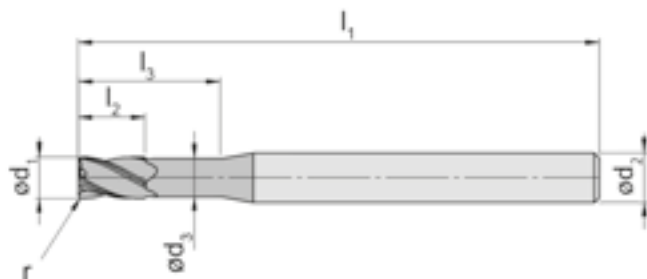
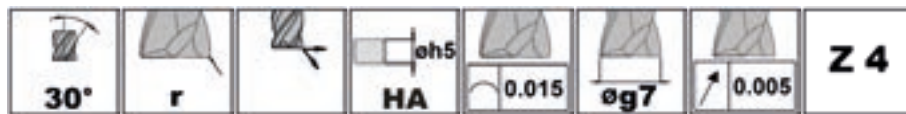
Dimensions in mm

圆角立铣刀

Torus End Mill



DST



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	1.0	7	10.5	3.4	6	64	4	40°	HA	▲
DST.4.035.100.050	3.5	1.0	7	17.5	3.4	6	64	4	40°	HA	▲
DST.4.035.100.070	3.5	1.0	7	24.5	3.4	6	64	4	40°	HA	▲
DST.4.040.020.030	4.0	0.2	8	12.0	3.8	6	64	4	40°	HA	▲
DST.4.040.020.050	4.0	0.2	8	20.0	3.8	6	64	4	40°	HA	▲
DST.4.040.020.070	4.0	0.2	8	28.0	3.8	6	78	4	40°	HA	▲
DST.4.040.050.030	4.0	0.5	8	12.0	3.8	6	64	4	40°	HA	▲
DST.4.040.050.050	4.0	0.5	8	20.0	3.8	6	64	4	40°	HA	▲
DST.4.040.050.070	4.0	0.5	8	28.0	3.8	6	78	4	40°	HA	▲
DST.4.040.100.030	4.0	1.0	8	12.0	3.8	6	64	4	40°	HA	▲
DST.4.040.100.050	4.0	1.0	8	20.0	3.8	6	64	4	40°	HA	▲
DST.4.040.100.070	4.0	1.0	8	28.0	3.8	6	78	4	40°	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号

Carbide grades

切削参数 DST Ø 3.5 - 4.0 mm

Cutting Data DST Ø 3.5 - 4.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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
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

尺寸单位 : mm

Dimensions in mm

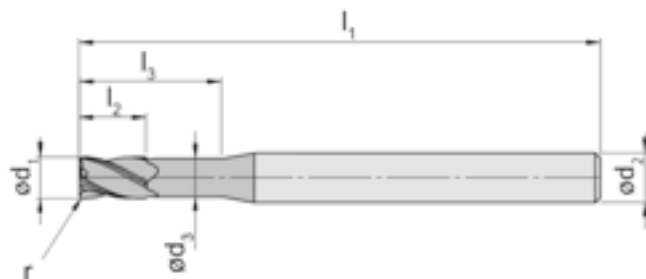
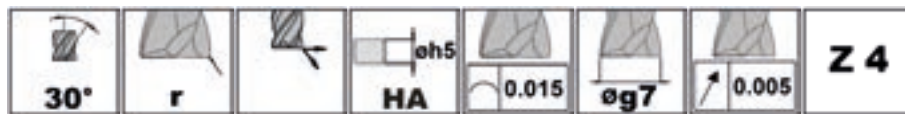
B

圆角立铣刀

Torus End Mill



DST



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.4.050.050.030	5	0.5	10	15	4.7	6	64	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	1.0	10	15	4.7	6	64	4	40°	HA	▲
DST.4.050.100.050	5	1.0	10	25	4.7	6	64	4	40°	HA	▲
DST.4.050.100.070	5	1.0	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	1.0	12	18	5.7	6	64	4	-	HA	▲
DST.4.060.100.050	6	1.0	12	30	5.7	6	78	4	-	HA	▲
DST.4.060.100.070	6	1.0	12	42	5.7	6	100	4	-	HA	▲
DST.4.060.200.030	6	2.0	12	18	5.7	6	64	4	-	HA	▲
DST.4.060.200.050	6	2.0	12	30	5.7	6	78	4	-	HA	▲
DST.4.060.200.070	6	2.0	12	42	5.6	6	100	4	-	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号

Carbide grades

切削参数 DST Ø 5.0 - 6.0 mm

Cutting Data DST Ø 5.0 - 6.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

d ₁			
	α	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
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
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

尺寸单位 : mm

Dimensions in mm

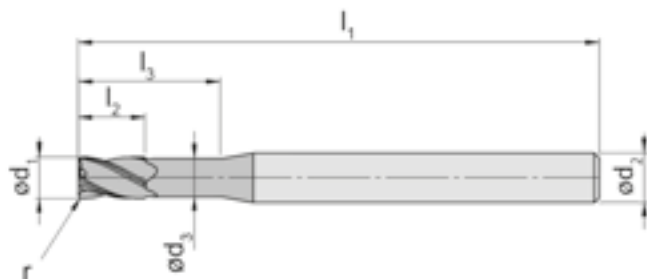
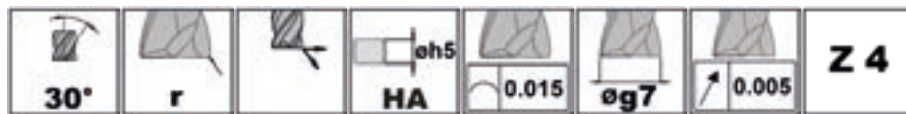
B

圆角立铣刀

Torus End Mill



DST



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	1.0	16	24	7.6	8	64	4	HA	▲
DST.4.080.100.050	8	1.0	16	40	7.6	8	100	4	HA	▲
DST.4.080.100.070	8	1.0	16	56	7.6	8	100	4	HA	▲
DST.4.080.200.030	8	2.0	16	24	7.6	8	64	4	HA	▲
DST.4.080.200.050	8	2.0	16	40	7.6	8	100	4	HA	▲
DST.4.080.200.070	8	2.0	16	56	7.6	8	100	4	HA	▲
DST.4.100.020.030	10	0.2	20	30	9.6	10	78	4	HA	▲
DST.4.100.020.050	10	0.2	20	50	9.6	10	100	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	1.0	20	30	9.6	10	78	4	HA	▲
DST.4.100.100.050	10	1.0	20	50	9.6	10	100	4	HA	▲
DST.4.100.100.070	10	1.0	20	70	9.6	10	120	4	HA	▲
DST.4.100.200.030	10	2.0	20	30	9.6	10	78	4	HA	▲
DST.4.100.200.050	10	2.0	20	50	9.6	10	100	4	HA	▲
DST.4.100.200.070	10	2.0	20	70	9.6	10	120	4	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DST Ø 8.0 - 10.0 mm

Cutting Data DST Ø 8.0 - 10.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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
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
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

尺寸单位 : mm
Dimensions in mm

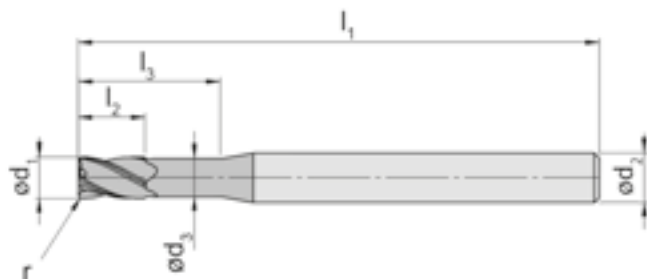
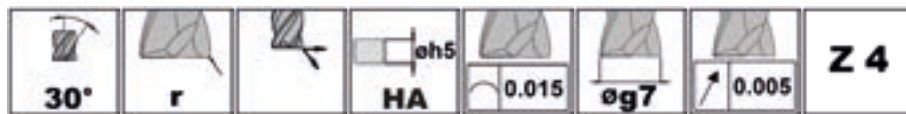
B

圆角立铣刀

Torus End Mill



DST



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.4.120.100.030	12	1.0	24	36	11.6	12	100	4	HA	▲
DST.4.120.100.050	12	1.0	24	60	11.6	12	120	4	HA	▲
DST.4.120.100.070	12	1.0	24	84	11.6	12	140	4	HA	▲
DST.4.120.200.030	12	2.0	24	36	11.6	12	100	4	HA	▲
DST.4.120.200.050	12	2.0	24	60	11.6	12	120	4	HA	▲
DST.4.120.200.070	12	2.0	24	84	11.6	12	140	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.4.160.050.070	16	0.5	32	112	15.4	16	163	4	HA	▲
DST.4.160.100.030	16	1.0	32	48	15.4	16	100	4	HA	▲
DST.4.160.100.050	16	1.0	32	80	15.4	16	140	4	HA	▲
DST.4.160.100.070	16	1.0	32	112	15.4	16	163	4	HA	▲
DST.4.160.200.030	16	2.0	32	48	15.4	16	100	4	HA	▲
DST.4.160.200.050	16	2.0	32	80	15.4	16	140	4	HA	▲
DST.4.160.200.070	16	2.0	32	112	15.4	16	163	4	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DST Ø 12.0 - 16.0 mm

Cutting Data DST Ø 12.0 - 16.0 mm



		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130
M1.1	90	110
M2.1	80	100
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	130	160
K2.1	120	140
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1	70	80
S2	55	70
S3	40	50
-	-	-
-	-	-

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
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
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

尺寸单位 : mm
Dimensions in mm

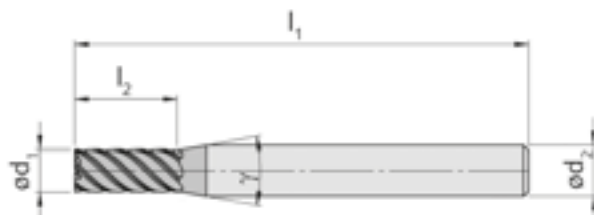
B

多刃立铣刀

End Mill multiple fluted



DSM



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	-	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSM Ø 2.0 - 6.0 mm

Cutting Data DSM Ø 2.0 - 6.0 mm



		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	45	50

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	80	100
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	35	40
-	-	-
-	-	-

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
2	2°	0.007	0.20	4.00	0.004	0.06	4.00
2	2°	0.007	0.20	4.00	0.004	0.06	4.00
2	2°	0.007	0.20	4.00	0.004	0.06	4.00
3	2°	0.011	0.30	6.00	0.011	0.09	6.00
3	2°	0.011	0.30	6.00	0.011	0.09	6.00
3	2°	0.011	0.30	6.00	0.011	0.09	6.00
4	2°	0.015	0.40	8.00	0.017	0.12	8.00
4	2°	0.015	0.40	8.00	0.017	0.12	8.00
4	2°	0.008	0.40	8.00	0.017	0.12	8.00
5	2°	0.012	0.50	10.00	0.024	0.15	10.00
5	2°	0.012	0.50	10.00	0.024	0.15	10.00
5	2°	0.012	0.50	10.00	0.024	0.15	10.00
6	2°	0.016	0.60	12.00	0.030	0.18	12.00
6	2°	0.016	0.60	12.00	0.030	0.18	12.00
6	2°	0.016	0.60	12.00	0.030	0.18	12.00

尺寸单位 : mm

Dimensions in mm

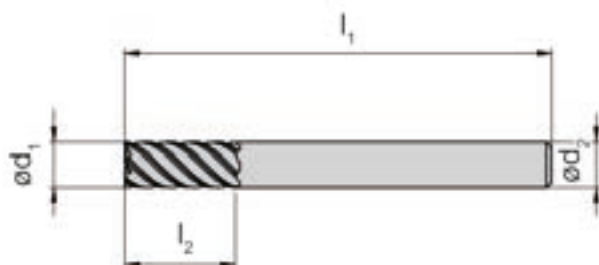
B

多刃立铣刀

End Mill multiple fluted



DSM



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	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSM Ø 8.0 - 20.0 mm

Cutting Data DSM Ø 8.0 - 20.0 mm



		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	45	50

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	80	100
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	35	40
-	-	-
-	-	-

B

d ₁		f _z	a _e	a _p	f _z	a _e	a _p
8	2°	0.019	0.80	16.00	0.038	0.24	16.00
8	2°	0.019	0.80	16.00	0.038	0.24	16.00
8	2°	0.019	0.80	16.00	0.038	0.24	16.00
10	2°	0.027	1.00	20.00	0.050	0.30	20.00
10	2°	0.027	1.00	20.00	0.050	0.30	20.00
10	2°	0.027	1.00	20.00	0.050	0.30	20.00
12	2°	0.035	1.20	24.00	0.063	0.36	24.00
12	2°	0.035	1.20	24.00	0.063	0.36	24.00
12	2°	0.035	1.20	24.00	0.063	0.36	24.00
16	2°	0.047	1.60	32.00	0.085	0.48	32.00
16	2°	0.047	1.60	32.00	0.085	0.48	32.00
16	2°	0.047	1.60	32.00	0.085	0.48	32.00
20	2°	0.062	2.00	40.00	0.110	0.60	40.00
20	2°	0.062	2.00	40.00	0.110	0.60	40.00
20	2°	0.062	2.00	40.00	0.110	0.60	40.00

尺寸单位 : mm

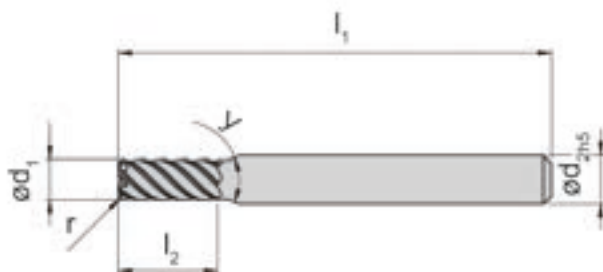
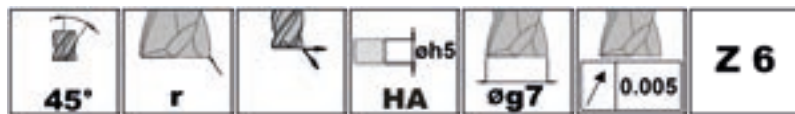
Dimensions in mm

多刃立铣刀，刀尖为圆角

End Mill multiple fluted, corner radius



DSMR



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.6.030.020.40	3	0.2	12	6	57	6	40°	▲
DSMR.6.030.050.20	3	0.5	6	6	57	6	40°	▲
DSMR.6.030.050.30	3	0.5	9	6	57	6	40°	▲
DSMR.6.030.050.40	3	0.5	12	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.6.040.050.30	4	0.5	12	6	57	6	40°	▲
DSMR.6.040.050.40	4	0.5	20	6	57	6	40°	▲
DSMR.6.050.020.20	5	0.2	10	6	57	6	40°	▲
DSMR.6.050.020.30	5	0.2	15	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.6.050.050.30	5	0.5	15	6	57	6	40°	▲
DSMR.6.050.050.40	5	0.5	20	6	57	6	40°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号

Carbide grades

切削参数 DSMR Ø 2.0 - 5.0 mm

Cutting Data DSM Ø 2.0 - 5.0 mm



		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	45	50

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	80	100
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	35	40
-	-	-
-	-	-

d ₁		f _z	a _e	a _p	f _z	a _e	a _p
2	3°	0.000	0.20	4.00	0.004	0.06	4.00
2	3°	0.000	0.20	4.00	0.004	0.06	4.00
2	3°	0.000	0.20	4.00	0.004	0.06	4.00
3	3°	0.004	0.30	6.00	0.011	0.09	6.00
3	3°	0.004	0.30	6.00	0.011	0.09	6.00
3	3°	0.004	0.30	6.00	0.011	0.09	6.00
3	3°	0.004	0.30	6.00	0.011	0.09	6.00
3	3°	0.004	0.30	6.00	0.011	0.09	6.00
3	3°	0.004	0.30	6.00	0.011	0.09	6.00
3	3°	0.004	0.30	6.00	0.011	0.09	6.00
4	3°	0.008	0.40	8.00	0.017	0.12	8.00
4	3°	0.008	0.40	8.00	0.017	0.12	8.00
4	3°	0.008	0.40	8.00	0.017	0.12	8.00
4	3°	0.008	0.40	8.00	0.017	0.12	8.00
4	3°	0.008	0.40	8.00	0.017	0.12	8.00
4	3°	0.008	0.40	8.00	0.017	0.12	8.00
5	3°	0.012	0.50	10.00	0.024	0.15	10.00
5	3°	0.012	0.50	10.00	0.024	0.15	10.00
5	3°	0.012	0.50	10.00	0.024	0.15	10.00
5	3°	0.012	0.50	10.00	0.024	0.15	10.00
5	3°	0.012	0.50	10.00	0.024	0.15	10.00
5	3°	0.012	0.50	10.00	0.024	0.15	10.00

尺寸单位 : mm

Dimensions in mm

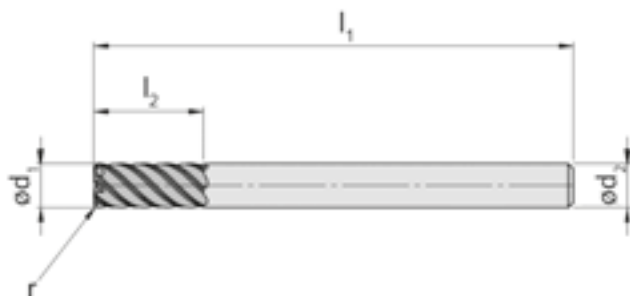
B

多刃立铣刀，刀尖为圆角

End Mill multiple fluted, corner radius



DSMR



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.6.060.050.20	6	0.5	12	6	50	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.6.060.100.20	6	1.0	12	6	50	6	▲
DSMR.6.060.100.30	6	1.0	18	6	57	6	▲
DSMR.6.060.100.40	6	1.0	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	1.0	16	8	54	7	▲
DSMR.7.080.100.30	8	1.0	24	8	64	7	▲
DSMR.7.080.100.40	8	1.0	32	8	78	7	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号

Carbide grades

切削参数 DSMR Ø 6.0 - 8.0 mm

Cutting Data DSMR Ø 6.0 - 8.0 mm



		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	45	50

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	80	100
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	35	40
-	-	-
-	-	-

B

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
6	3°	0.016	0.60	12.00	0.030	0.18	12.00
6	3°	0.016	0.60	12.00	0.030	0.18	12.00
6	3°	0.016	0.60	12.00	0.030	0.18	12.00
6	3°	0.016	0.60	12.00	0.030	0.18	12.00
6	3°	0.016	0.60	12.00	0.030	0.18	12.00
6	3°	0.016	0.60	12.00	0.030	0.18	12.00
6	3°	0.016	0.60	12.00	0.030	0.18	12.00
6	3°	0.016	0.60	12.00	0.030	0.18	12.00
6	3°	0.016	0.60	12.00	0.030	0.18	12.00
8	3°	0.019	0.80	16.00	0.038	0.24	16.00
8	3°	0.019	0.80	16.00	0.038	0.24	16.00
8	3°	0.019	0.80	16.00	0.038	0.24	16.00
8	3°	0.019	0.80	16.00	0.038	0.24	16.00
8	3°	0.019	0.80	16.00	0.038	0.24	16.00
8	3°	0.019	0.80	16.00	0.038	0.24	16.00
8	3°	0.019	0.80	16.00	0.038	0.24	16.00
8	3°	0.019	0.80	16.00	0.038	0.24	16.00
8	3°	0.019	0.80	16.00	0.038	0.24	16.00
8	3°	0.019	0.80	16.00	0.038	0.24	16.00

尺寸单位 : mm

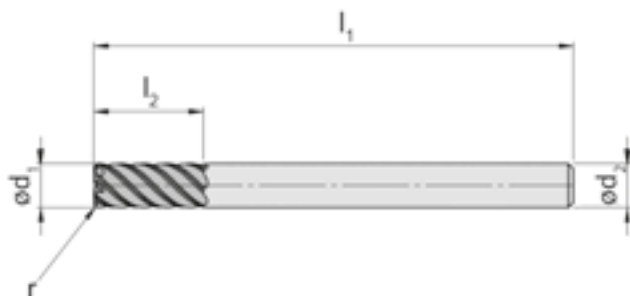
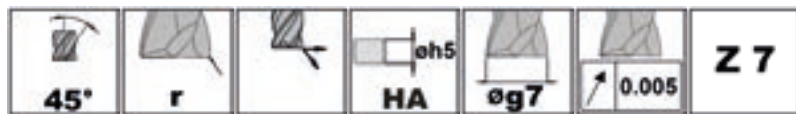
Dimensions in mm

多刃立铣刀，刀尖为圆角

End Mill multiple fluted, corner radius



DSMR



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.7.100.020.30	10	0.2	30	10	70	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	1.0	20	10	60	7	▲
DSMR.7.100.100.30	10	1.0	30	10	70	7	▲
DSMR.7.100.100.40	10	1.0	40	10	89	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	1.0	24	12	70	7	▲
DSMR.7.120.100.30	12	1.0	36	12	83	7	▲
DSMR.7.120.100.40	12	1.0	48	12	100	7	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSMR Ø 10.0 - 12.0 mm

Cutting Data DSMR Ø 10.0 - 12.0 mm



		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	45	50

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	80	100
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	35	40
-	-	-
-	-	-

d ₁		f _z	a _e	a _p	f _z	a _e	a _p
10	3°	0.027	1.00	20.00	0.050	0.30	20.00
10	3°	0.027	1.00	20.00	0.050	0.30	20.00
10	3°	0.027	1.00	20.00	0.050	0.30	20.00
10	3°	0.027	1.00	20.00	0.050	0.30	20.00
10	3°	0.027	1.00	20.00	0.050	0.30	20.00
10	3°	0.027	1.00	20.00	0.050	0.30	20.00
10	3°	0.027	1.00	20.00	0.050	0.30	20.00
10	3°	0.027	1.00	20.00	0.050	0.30	20.00
10	3°	0.027	1.00	20.00	0.050	0.30	20.00
10	3°	0.027	1.00	20.00	0.050	0.30	20.00
12	3°	0.035	1.20	24.00	0.063	0.36	24.00
12	3°	0.035	1.20	36.00	0.063	0.36	36.00
12	3°	0.035	1.20	48.00	0.063	0.36	48.00
12	3°	0.035	1.20	24.00	0.063	0.36	24.00
12	3°	0.035	1.20	36.00	0.063	0.36	36.00
12	3°	0.035	1.20	48.00	0.063	0.36	48.00
12	3°	0.035	1.20	24.00	0.063	0.36	24.00
12	3°	0.035	1.20	36.00	0.063	0.36	36.00
12	3°	0.035	1.20	48.00	0.063	0.36	48.00

尺寸单位 : mm
Dimensions in mm

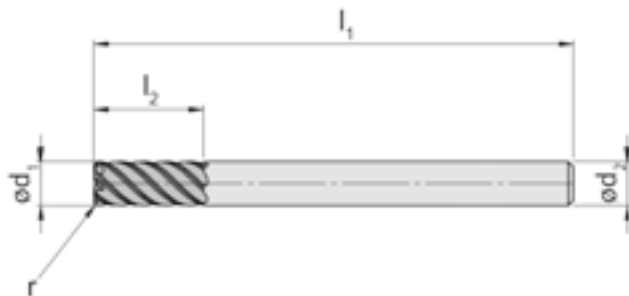
B

多刃立铣刀，刀尖为圆角

End Mill multiple fluted, corner radius



DSMR



产品型号 Part number	d ₁	r	l ₂	d ₂	l ₁	Z	TS3K
DSMR.8.160.020.20	16	0.2	32	16	89	8	▲
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.8.160.050.40	16	0.5	64	16	120	8	▲
DSMR.8.160.100.20	16	1.0	32	16	89	8	▲
DSMR.8.160.100.30	16	1.0	48	16	100	8	▲
DSMR.8.160.100.40	16	1.0	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.8.200.020.40	20	0.2	80	20	150	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.8.200.050.40	20	0.5	80	20	150	8	▲
DSMR.8.200.100.20	20	1.0	40	20	102	8	▲
DSMR.8.200.100.30	20	1.0	60	20	125	8	▲
DSMR.8.200.100.40	20	1.0	80	20	150	8	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSMR Ø 16.0 - 20.0 mm

Cutting Data DSMR Ø 16.0 - 20.0 mm



		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	45	50

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	80	100
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	35	40
-	-	-
-	-	-

d ₁		f _z	a _e	a _p	f _z	a _e	a _p
16	3°	0.047	1.60	32.00	0.085	0.48	32.00
16	3°	0.047	1.60	48.00	0.085	0.48	48.00
16	3°	0.047	1.60	64.00	0.085	0.48	64.00
16	3°	0.047	1.60	32.00	0.085	0.48	32.00
16	3°	0.047	1.60	48.00	0.085	0.48	48.00
16	3°	0.047	1.60	64.00	0.085	0.48	64.00
16	3°	0.047	1.60	32.00	0.085	0.48	32.00
16	3°	0.047	1.60	48.00	0.085	0.48	48.00
16	3°	0.047	1.60	64.00	0.085	0.48	64.00
20	3°	0.062	2.00	40.00	0.110	0.60	40.00
20	3°	0.062	2.00	60.00	0.110	0.60	60.00
20	3°	0.062	2.00	80.00	0.110	0.60	80.00
20	3°	0.062	2.00	40.00	0.110	0.60	40.00
20	3°	0.062	2.00	60.00	0.110	0.60	60.00
20	3°	0.062	2.00	80.00	0.110	0.60	80.00
20	3°	0.062	2.00	40.00	0.110	0.60	40.00
20	3°	0.062	2.00	60.00	0.110	0.60	60.00
20	3°	0.062	2.00	80.00	0.110	0.60	80.00

尺寸单位 : mm

Dimensions in mm

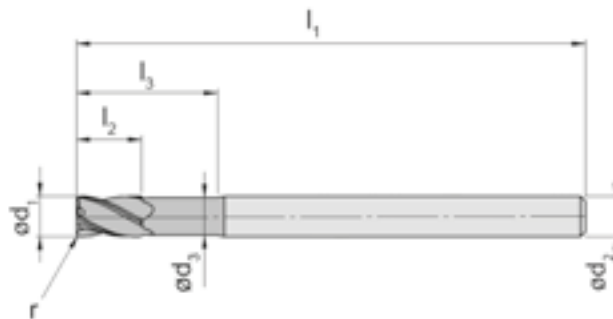
B

开粗立铣刀，刀尖为圆角

Roughing End Mill, corner radius



DSR



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.3.040.63.06	4	0.2	5	12.5	3.8	6	63	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	▲
DSR.3.120.77.12	12	0.5	15	30.5	11.4	12	77	3	▲
DSR.3.160.88.16	16	0.5	18	38.0	15.4	16	88	3	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

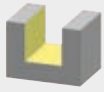
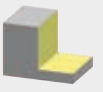
硬质合金牌号
Carbide grades

切削参数 DSMR Ø 2.0 - 16.0 mm

Cutting Data DSMR Ø 2.0 - 16.0 mm



B

		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130

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
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
12	5°	0.047	12	12	0.094	3.00	12.00
16	5°	0.063	16	16	0.126	4.00	16.00

尺寸单位 : mm

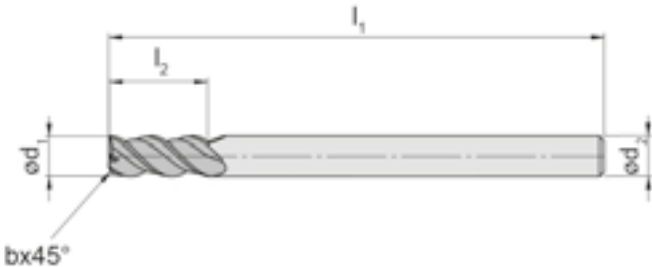
Dimensions in mm

开粗立铣刀，带刀尖处理

Roughing End Mill, corner bevel



DSF



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)
Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	TS3K
DSF.3.020.38.03	2	0.10	8	3	38	3	▲
DSF.3.030.38.03	3	0.10	10	3	38	3	▲
DSF.3.040.50.04	4	0.10	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	0.20	20	8	63	3	▲
DSF.3.100.69.10	10	0.20	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	▲

- ▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
- 推荐 / recommended
- o 次推荐 / alternative recommendation
- 不合适 / not suitable
- 非涂层 / uncoated grades
- 涂层 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm
Dimensions in mm

P	•
M	o
K	o
N	-
S	o
H	o

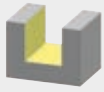
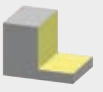
硬质合金牌号
Carbide grades

切削参数 DSF Ø 2.0 - 16.0 mm

Cutting Data DSF Ø 2.0 - 16.0 mm



B

		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130

d ₁							
		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

尺寸单位 : mm

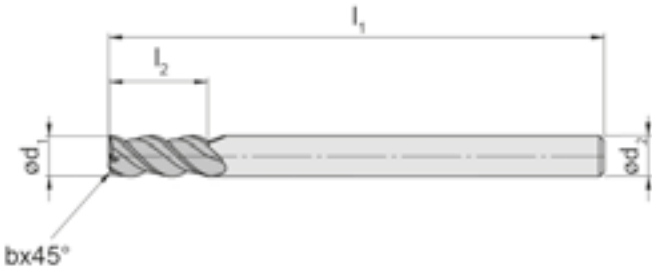
Dimensions in mm

开粗立铣刀，带刀尖处理

Roughing End Mill, corner bevel



DSF



产品型号 Part number	d ₁	b	l ₂	d ₂	l ₁	Z	TS3K
DSF.4.040.50.04	4	0.10	12	4	50	4	▲
DSF.4.060.63.06	6	0.15	16	6	63	4	▲
DSF.4.080.63.08	8	0.20	20	8	63	4	▲
DSF.4.100.69.10	10	0.20	22	10	69	4	▲
DSF.4.120.77.12	12	0.25	25	12	77	4	▲
DSF.4.160.88.16	16	-	35	16	88	4	▲

- ▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
- 推荐 / recommended
- o 次推荐 / alternative recommendation
- 不合适 / not suitable
- 非涂层 / uncoated grades
- 涂层 / coated grades
- 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm
Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

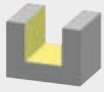
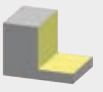
硬质合金牌号
Carbide grades

切削参数 DSF Ø 4.0 - 16.0 mm

Cutting Data DSF Ø 4.0 - 16.0 mm



B

		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	150	180
P2.1	140	170
P2.2	140	170
P2.3	140	170
P3.1	120	140
P3.2	110	130

d_1							
		f_z	a_e	a_p	f_z	a_e	a_p
4	4°	0.012	4	4	0.025	1.00	8.00
6	4°	0.020	6	6	0.041	1.50	12.00
8	4°	0.028	8	8	0.057	2.00	16.00
10	4°	0.036	10	10	0.073	2.50	20.00
12	4°	0.044	12	12	0.089	3.00	24.00
16	4°	0.060	16	16	0.121	4.00	32.00

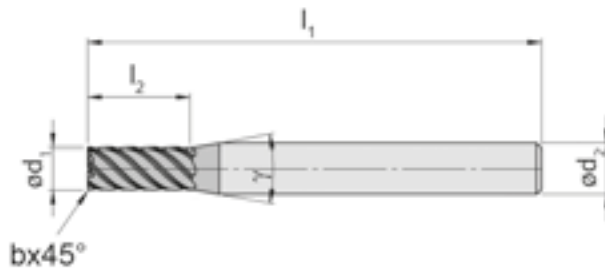
尺寸单位 : mm
Dimensions in mm

摆线铣立铣刀

End Mill Trochoidal Milling



DSFT



用于高速轴预安装立铣刀直径可达 $\varnothing 3$ mm (见D2)

Pre-assembled available up to $\varnothing 3$ mm for Toodle high-speed spindle (see page D2)

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	0.10	5	6	50	4	40°	HA	▲
DSFT.4.020.010.30	2	0.10	7	6	50	4	40°	HA	▲
DSFT.4.020.010.40	2	0.10	9	6	54	4	40°	HA	▲
DSFT.4.030.010.20	3	0.10	7	6	50	4	40°	HA	▲
DSFT.4.030.010.30	3	0.10	10	6	54	4	40°	HA	▲
DSFT.4.030.010.40	3	0.10	13	6	57	4	40°	HA	▲
DSFT.4.040.010.20	4	0.10	9	6	50	4	40°	HA	▲
DSFT.4.040.010.30	4	0.10	13	6	57	4	40°	HA	▲
DSFT.4.040.010.40	4	0.10	17	6	60	4	40°	HA	▲
DSFT.4.050.010.20	5	0.10	11	6	50	4	40°	HA	▲
DSFT.4.050.010.30	5	0.10	16	6	57	4	40°	HA	▲
DSFT.4.050.010.40	5	0.10	21	6	64	4	40°	HA	▲
DSFT.5.060.010.20	6	0.10	13	6	57	5	-	HA	▲
DSFT.5.060.010.30	6	0.10	19	6	64	5	-	HA	▲
DSFT.5.060.010.40	6	0.10	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	0.20	21	10	64	5	-	HA	▲
DSFT.5.100.020.20B	10	0.20	21	10	64	5	-	HB	▲
DSFT.5.100.020.30	10	0.20	31	10	78	5	-	HA	▲
DSFT.5.100.020.30B	10	0.20	31	10	78	5	-	HB	▲
DSFT.5.100.020.40	10	0.20	41	10	89	5	-	HA	▲
DSFT.5.100.020.40B	10	0.20	41	10	89	5	-	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSFT Ø 2.0 - 10.0 mm

Cutting Data DSF Ø 2.0 - 10.0 mm



B

		
	vc = m/min	vc = m/min
P1.1	170	200
P1.2	170	200
P1.3	160	190
P2.1	160	190
P2.2	150	180
P2.3	150	180
P3.1	140	170
P3.2	140	170

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

尺寸单位：mm

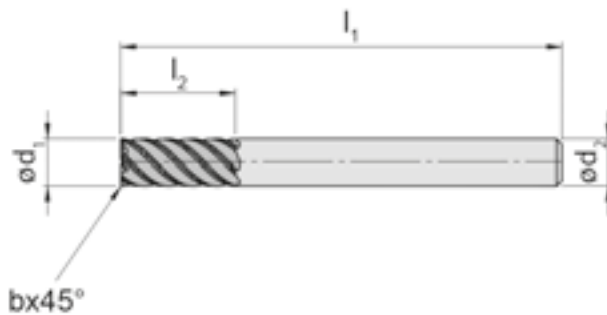
Dimensions in mm

摆线铣立铣刀

End Mill Trochoidal Milling



DSFT



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	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSFT Ø 12.0 - 20.0 mm

Cutting Data DSF Ø 12.0 - 20.0 mm



B

		
	vc = m/min	vc = m/min
P1.1	170	200
P1.2	170	200
P1.3	160	190
P2.1	160	190
P2.2	150	180
P2.3	150	180
P3.1	140	170
P3.2	140	170

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

尺寸单位 : mm

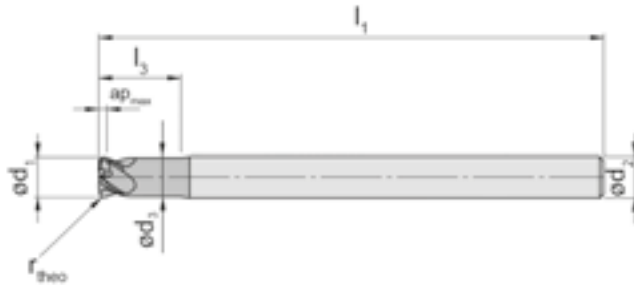
Dimensions in mm

高进给立铣刀

High Feed Mill



DSH



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r _{theo}	l ₃	d ₃	d ₂	l ₁	Z	类型 Type	a _p	TS3K
DSH.4.020.035.020	2	0.35	4	1.8	6	50	4	HA	0.20	▲
DSH.4.020.035.030	2	0.35	6	1.8	6	50	4	HA	0.20	▲
DSH.4.030.050.020	3	0.50	6	2.7	6	50	4	HA	0.30	▲
DSH.4.030.050.030	3	0.50	9	2.7	6	50	4	HA	0.30	▲
DSH.4.040.070.020	4	0.70	8	3.6	6	50	4	HA	0.35	▲
DSH.4.040.070.030	4	0.70	12	3.6	6	57	4	HA	0.35	▲
DSH.4.050.080.020	5	0.80	10	4.5	6	50	4	HA	0.38	▲
DSH.4.050.080.030	5	0.80	15	4.5	6	57	4	HA	0.38	▲
DSH.4.060.080.020	6	0.80	12	5.4	6	50	4	HA	0.40	▲
DSH.4.060.080.030	6	0.80	18	5.4	6	64	4	HA	0.40	▲
DSH.4.080.140.020	8	1.40	16	7.2	8	60	4	HA	0.50	▲
DSH.4.080.140.030	8	1.40	24	7.2	8	63	4	HA	0.50	▲
DSH.4.100.200.020	10	2.00	20	9.0	10	70	4	HA	0.70	▲
DSH.4.100.200.030	10	2.00	30	9.0	10	78	4	HA	0.70	▲
DSH.4.120.210.020	12	2.10	24	10.8	12	78	4	HA	0.80	▲
DSH.4.120.210.030	12	2.10	36	10.8	12	89	4	HA	0.80	▲
DSH.4.160.280.020	16	2.80	32	-	16	89	4	HA	1.00	▲
DSH.4.160.280.030	16	2.80	48	-	16	100	4	HA	1.00	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	•
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSH Ø 2.0 - 16.0 mm

Cutting Data DSH Ø 2.0 - 16.0 mm



		
	vc = m/min	vc = m/min
P1.1	170	200
P1.2	170	200
P1.3	160	190
P2.1	160	190
P2.2	150	180
P2.3	150	180
P3.1	140	170
P3.2	140	170
M1.1	120	140
M2.1	110	130
M3.1	100	120

		
	vc = m/min	vc = m/min
K1.1	140	170
K1.2	140	170
K2.1	130	160
K2.2	130	160
K3.1	120	140
K3.2	120	140
S1	100	120
S2	80	100
S3	70	80
-	-	-
-	-	-

B

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
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

尺寸单位 : mm

Dimensions in mm

铣削倒角刀
Chamfer Milling Cutter



DSFF



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	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	○
K	○
N	-
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DSFF Ø 2.0 - 4.0 mm

Cutting Data DSFF Ø 2.0 - 4.0 mm



		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	45	50

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	80	100
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	35	40
-	-	-
-	-	-

						
d ₁	f _z	a _e	a _p	f _z	a _e	a _p
2	0.030	0.60	0.60	0.050	0.10	0.10
2	0.040	0.75	0.75	0.060	0.15	0.15
3	0.450	1.00	1.00	0.070	0.20	0.20
3	0.050	1.25	1.25	0.080	0.25	0.25
4	0.060	1.50	1.50	0.080	0.30	0.30

尺寸单位 : mm

Dimensions in mm

B

整体硬质合金立铣刀

Solid Carbide End Mills



B

	DSKMH	圆头微型立铣刀 Ball Nose End Mill Micro	Ø 0.2 – Ø 3.0	Z 2	B74 – B77
	DSK.2	圆头立铣刀 Ball nose End Mill	Ø 4.0 – Ø 16.0	Z 2	B78 – B79
	DSK.4	圆头立铣刀 Ball nose End Mill	Ø 4.0 – Ø 12.0	Z 4	B80 – B81
	DSTMH	圆角微型立铣刀 Torus End Mill Micro	Ø 0.1 – Ø 3.0	Z 2	B82 – B89
	DSTH.2	圆角立铣刀 Torus End Mill	Ø 4.0 – Ø 12.0	Z 2	B90 – B101
	DSTH.4	圆角立铣刀 Torus End Mill	Ø 4.0 – Ø 12.0	Z 4	B102 – B111
	DSMH	多刃立铣刀 End Mill multiple luted	Ø 3.0 – Ø 12.0	Z 6	B112 – B113
	DSMRH	多刃立铣刀, 刀尖为圆角 End Mill multiple fluted, corner radius	Ø 3.0 – Ø 12.0	Z 6	B114–115

DS



B

设计用于:

- 淬硬钢件

designed for:

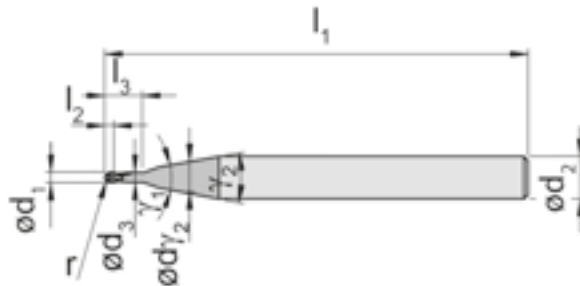
- hardened Steels

球头微型立铣刀

Ball Nose End Mill Micro



DSKMH



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.020.015	0.2	0.10	0.30	-	-	4	50	2	20°	-°	▲
DSKMH.020.030	0.2	0.10	0.30	0.6	0.18	4	50	2	40°	20°	▲
DSKMH.020.050	0.2	0.10	0.30	1.0	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	0.20	0.60	-	-	4	50	2	20°	-°	▲
DSKMH.040.030	0.4	0.20	0.60	1.2	0.38	4	50	2	40°	20°	▲
DSKMH.040.050	0.4	0.20	0.60	2.0	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	0.30	0.90	-	-	4	50	2	20°	-°	▲
DSKMH.060.030	0.6	0.30	0.90	1.8	0.56	4	50	2	40°	20°	▲
DSKMH.060.050	0.6	0.30	0.90	3.0	0.56	4	50	2	40°	20°	▲
DSKMH.060.070	0.6	0.30	0.90	4.2	0.56	4	50	2	40°	20°	▲
DSKMH.080.015	0.8	0.40	-	1.2	-	4	50	2	20°	-°	▲
DSKMH.080.030	0.8	0.40	1.20	2.4	0.75	4	50	2	40°	20°	▲
DSKMH.080.050	0.8	0.40	1.20	4.0	0.75	4	50	2	40°	20°	▲
DSKMH.080.070	0.8	0.40	1.20	5.6	0.75	4	50	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSKMH Ø 0.2 - 0.8 mm

Cutting Data DSKMH Ø 0.2 - 0.8 mm



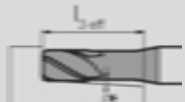
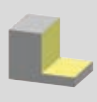
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

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
0.2	3°	1.00	0.90	0.90	1.00	1.20	0.004	0.04	0.02	0.007	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	3°	3.00	3.50	3.50	3.60	5.10	0.008	0.12	0.07	0.014	0.03	0.05
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

尺寸单位 : mm

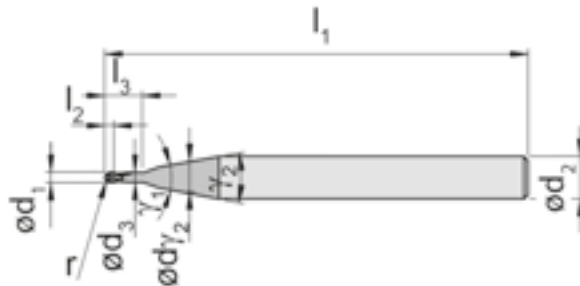
Dimensions in mm

球头微型立铣刀

Ball Nose End Mill Micro



DSKMH



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	0.50	1.50	-	-	4	50	2	20°	-°	▲
DSKMH.100.030	1.0	0.50	1.50	3.0	0.95	4	50	2	40°	20°	▲
DSKMH.100.050	1.0	0.50	1.50	5.0	0.95	4	50	2	40°	20°	▲
DSKMH.100.070	1.0	0.50	1.50	7.0	0.95	4	50	2	40°	20°	▲
DSKMH.120.015	1.2	0.60	1.80	-	-	4	50	2	20°	-°	▲
DSKMH.120.030	1.2	0.60	1.80	3.6	1.15	4	50	2	40°	20°	▲
DSKMH.120.050	1.2	0.60	1.80	6.0	1.15	4	50	2	40°	20°	▲
DSKMH.120.070	1.2	0.60	1.80	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.150.050	1.5	0.75	2.25	7.5	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	2.0	1.00	3.00	-	-	4	50	2	20°	-°	▲
DSKMH.200.030	2.0	1.00	3.00	6.0	1.90	4	50	2	40°	20°	▲
DSKMH.200.050	2.0	1.00	3.00	10.0	1.90	4	50	2	40°	20°	▲
DSKMH.200.070	2.0	1.00	3.00	14.0	1.90	4	50	2	40°	20°	▲
DSKMH.250.015	2.5	1.25	3.75	-	-	4	50	2	20°	-°	▲
DSKMH.250.030	2.5	1.25	3.75	7.5	2.40	4	50	2	40°	20°	▲
DSKMH.250.050	2.5	1.25	3.75	12.5	2.40	4	50	2	40°	20°	▲
DSKMH.250.070	2.5	1.25	3.75	17.5	2.40	4	50	2	40°	20°	▲
DSKMH.300.015	3.0	1.50	4.50	-	-	4	50	2	20°	-°	▲
DSKMH.300.030	3.0	1.50	4.50	9.0	2.90	4	50	2	40°	20°	▲
DSKMH.300.050	3.0	1.50	4.50	15.0	2.90	4	50	2	40°	20°	▲
DSKMH.300.070	3.0	1.50	4.50	21.0	2.90	4	60	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSKMH Ø 1.0 - 3.0 mm

Cutting Data DST Ø 1.0 - 3.0 mm



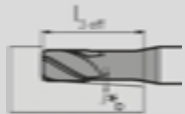
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

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	3°	7.50	7.90	8.10	8.50	8.90	0.017	0.30	0.17	0.030	0.08	0.12
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
2.5	4°	7.50	7.90	8.10	8.50	8.90	0.030	0.50	0.33	0.053	0.13	0.25
2.5	3°	12.50	13.10	13.40	14.00	15.60	0.027	0.50	0.28	0.048	0.13	0.20
2.5	2°	17.50	18.20	18.60	20.00	∞	0.024	0.50	0.23	0.042	0.13	0.15
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

尺寸单位 : mm

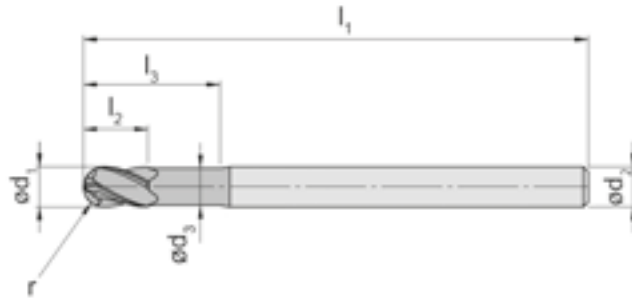
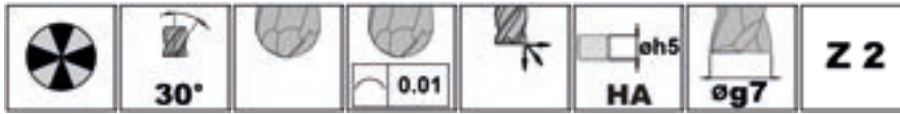
Dimensions in mm

球头立铣刀

Ball Nose End Mill



DSKH



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	2.0	6.0	6.0	-	6	64	2	20°	▲
DSKH.2.040.030	4	2.0	6.0	12.0	3.8	6	64	2	20°	▲
DSKH.2.040.050	4	2.0	6.0	20.0	3.8	6	64	2	20°	▲
DSKH.2.040.070	4	2.0	6.0	28.0	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	15.0	4.7	6	64	2	20°	▲
DSKH.2.050.050	5	2.5	7.5	25.0	4.7	6	64	2	20°	▲
DSKH.2.050.070	5	2.5	7.5	35.0	4.7	6	78	2	20°	▲
DSKH.2.060.015	6	3.0	9.0	9.0	-	6	64	2	-°	▲
DSKH.2.060.030	6	3.0	9.0	18.0	5.7	6	64	2	-°	▲
DSKH.2.060.050	6	3.0	9.0	30.0	5.7	6	78	2	-°	▲
DSKH.2.060.070	6	3.0	9.0	42.0	5.7	6	78	2	-°	▲
DSKH.2.080.015	8	4.0	12.0	12.0	-	8	64	2	-°	▲
DSKH.2.080.030	8	4.0	12.0	24.0	7.6	8	64	2	-°	▲
DSKH.2.080.050	8	4.0	12.0	40.0	7.6	8	78	2	-°	▲
DSKH.2.080.070	8	4.0	12.0	56.0	7.6	8	100	2	-°	▲
DSKH.2.100.015	10	5.0	15.0	15.0	-	10	78	2	-°	▲
DSKH.2.100.030	10	5.0	15.0	30.0	9.6	10	78	2	-°	▲
DSKH.2.100.050	10	5.0	15.0	50.0	9.6	10	100	2	-°	▲
DSKH.2.100.070	10	5.0	15.0	70.0	9.6	10	120	2	-°	▲
DSKH.2.120.015	12	6.0	18.0	18.0	-	12	78	2	-°	▲
DSKH.2.120.030	12	6.0	18.0	36.0	11.6	12	100	2	-°	▲
DSKH.2.120.050	12	6.0	18.0	60.0	11.6	12	120	2	-°	▲
DSKH.2.120.070	12	6.0	18.0	84.0	11.6	12	140	2	-°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSKH Ø 4.0 - 12.0 mm

Cutting Data DST Ø 4.0 - 12.0 mm



传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

							
d ₁		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	4°	0.024	0.40	0.26	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	4°	0.036	0.60	0.39	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

尺寸单位 : mm

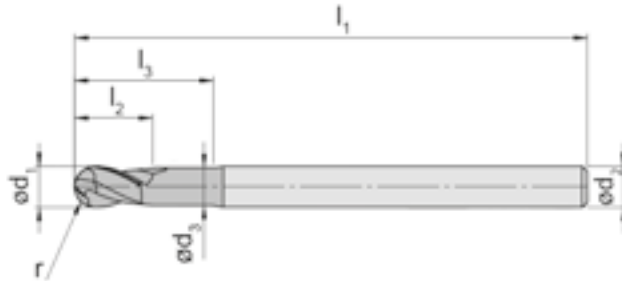
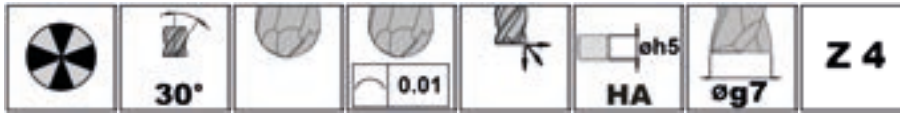
Dimensions in mm

球头立铣刀

Ball Nose End Mill



DSKH



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	2.0	6.0	6.0	-	6	64	4	20°	▲
DSKH.4.040.030	4	2.0	6.0	12.0	3.8	6	64	4	20°	▲
DSKH.4.040.050	4	2.0	6.0	20.0	3.8	6	64	4	20°	▲
DSKH.4.040.070	4	2.0	6.0	28.0	3.8	6	64	4	20°	▲
DSKH.4.050.015	5	2.5	7.5	7.5	-	6	64	4	20°	▲
DSKH.4.050.030	5	2.5	7.5	15.0	4.7	6	64	4	20°	▲
DSKH.4.050.050	5	2.5	7.5	25.0	4.7	6	64	4	20°	▲
DSKH.4.050.070	5	2.5	7.5	35.0	4.7	6	64	4	20°	▲
DSKH.4.060.015	6	3.0	9.0	9.0	-	6	64	4	-°	▲
DSKH.4.060.030	6	3.0	9.0	18.0	5.7	6	64	4	-°	▲
DSKH.4.060.050	6	3.0	9.0	30.0	5.7	6	78	4	-°	▲
DSKH.4.060.070	6	3.0	9.0	42.0	5.7	6	78	4	-°	▲
DSKH.4.080.015	8	4.0	12.0	12.0	-	8	64	4	-°	▲
DSKH.4.080.030	8	4.0	12.0	24.0	7.6	8	64	4	-°	▲
DSKH.4.080.050	8	4.0	12.0	40.0	7.6	8	78	4	-°	▲
DSKH.4.080.070	8	4.0	12.0	56.0	7.6	8	100	4	-°	▲
DSKH.4.100.015	10	5.0	15.0	15.0	-	10	78	4	-°	▲
DSKH.4.100.030	10	5.0	15.0	30.0	9.6	10	78	4	-°	▲
DSKH.4.100.050	10	5.0	15.0	50.0	9.6	10	100	4	-°	▲
DSKH.4.100.070	10	5.0	15.0	70.0	9.6	10	120	4	-°	▲
DSKH.4.120.015	12	6.0	18.0	18.0	-	12	78	4	-°	▲
DSKH.4.120.030	12	6.0	18.0	36.0	11.6	12	100	4	-°	▲
DSKH.4.120.050	12	6.0	18.0	60.0	11.6	12	120	4	-°	▲
DSKH.4.120.070	12	6.0	18.0	84.0	11.6	12	140	4	-°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	●

硬质合金牌号
Carbide grades

切削参数 DSKH Ø 4.0 - 12.0 mm

Cutting Data DST Ø 4.0 - 12.0 mm



传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

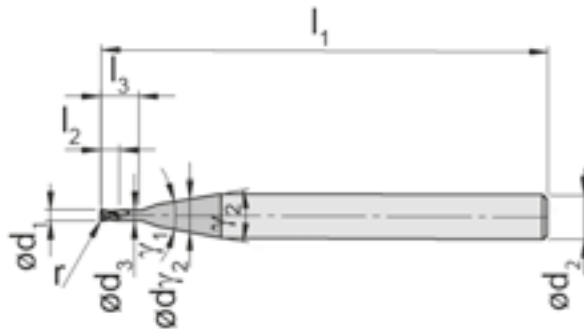
B

							
d ₁		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
4	2°	0.019	0.80	0.36	0.028	0.20	0.24
5	5°	0.035	1.00	0.75	0.055	0.25	0.50
5	4°	0.035	1.00	0.65	0.055	0.25	0.50
5	3°	0.031	1.00	0.55	0.049	0.25	0.40
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	3°	0.061	1.60	0.88	0.102	0.40	0.64
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
10	3°	0.081	2.00	1.10	0.137	0.50	0.80
10	2°	0.072	2.00	0.90	0.121	0.50	0.60
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
12	3°	0.102	2.40	1.32	0.172	0.60	0.96
12	2°	0.090	2.40	1.08	0.153	0.60	0.72

尺寸单位 : mm

Dimensions in mm

DSTMH



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ1	γ2	TS3E
DSTMH.010.000.015	0.1	0	0.15	0.15	-	4	50	2	20°	-°	▲
DSTMH.010.000.030	0.1	0	0.15	0.30	0.084	4	50	2	20°	-°	▲
DSTMH.020.000.015	0.2	0	0.30	0.30	-	4	50	2	20°	-°	▲
DSTMH.020.000.030	0.2	0	0.30	0.60	0.180	4	50	2	40°	20°	▲
DSTMH.020.000.050	0.2	0	0.30	1.00	0.180	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	0.90	0.280	4	50	2	40°	20°	▲
DSTMH.030.005.050	0.3	0.05	0.45	1.50	0.280	4	50	2	40°	20°	▲
DSTMH.040.005.015	0.4	0.05	0.60	0.60	-	4	50	2	20°	-°	▲
DSTMH.040.005.030	0.4	0.05	0.60	1.20	0.380	4	50	2	40°	20°	▲
DSTMH.040.005.050	0.4	0.05	0.60	2.00	0.380	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	1.50	0.470	4	50	2	40°	20°	▲
DSTMH.050.005.050	0.5	0.05	0.75	2.50	0.470	4	50	2	40°	20°	▲
DSTMH.050.005.070	0.5	0.05	0.75	3.50	0.470	4	50	2	40°	20°	▲
DSTMH.050.010.015	0.5	0.10	0.75	0.75	-	4	50	2	20°	-°	▲
DSTMH.050.010.030	0.5	0.10	0.75	1.50	0.470	4	50	2	40°	20°	▲
DSTMH.050.010.050	0.5	0.10	0.75	2.50	0.470	4	50	2	40°	20°	▲
DSTMH.050.010.070	0.5	0.10	0.75	3.50	0.470	4	50	2	40°	20°	▲
DSTMH.060.005.015	0.6	0.05	0.90	0.90	-	4	50	2	20°	-°	▲
DSTMH.060.005.030	0.6	0.05	0.90	1.80	0.560	4	50	2	40°	20°	▲
DSTMH.060.005.050	0.6	0.05	0.90	3.00	0.560	4	50	2	40°	20°	▲
DSTMH.060.005.070	0.6	0.05	0.90	4.20	0.560	4	50	2	40°	20°	▲
DSTMH.060.010.015	0.6	0.10	0.90	0.90	-	4	50	2	20°	-°	▲
DSTMH.060.010.030	0.6	0.10	0.90	1.80	0.560	4	50	2	40°	20°	▲
DSTMH.060.010.050	0.6	0.10	0.90	3.00	0.560	4	50	2	40°	20°	▲
DSTMH.060.010.070	0.6	0.10	0.90	4.20	0.560	4	50	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTMH Ø 0.1 - 0.6 mm

Cutting Data DSTMH Ø 0.1 - 0.6 mm



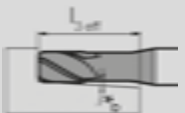
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

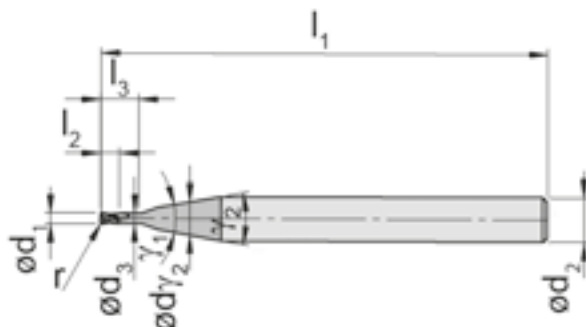
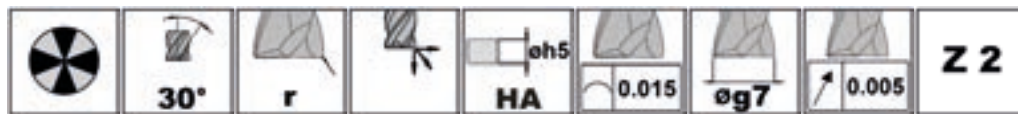
B

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
0.1	5°	0.15	0.30	0.30	0.40	0.40	0.003	0.02	0.02	0.005	0.01	0.01
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	5°	0.30	0.50	0.50	0.60	0.70	0.004	0.04	0.03	0.007	0.02	0.02
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	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	3.40	3.50	3.70	0.008	0.12	0.07	0.012	0.05	0.05
0.6	2°	4.20	4.50	4.60	4.90	5.10	0.007	0.12	0.05	0.010	0.05	0.04
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
0.6	2°	4.20	4.50	4.60	4.90	5.10	0.007	0.12	0.05	0.010	0.05	0.04

尺寸单位 : mm

Dimensions in mm

DSTMH



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	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.080.010.015	0.8	0.10	1.2	1.2	-	4	50	2	20°	-°	▲
DSTMH.080.010.030	0.8	0.10	1.2	2.4	0.75	4	50	2	40°	20°	▲
DSTMH.080.010.050	0.8	0.10	1.2	4.0	0.75	4	50	2	40°	20°	▲
DSTMH.080.010.070	0.8	0.10	1.2	5.6	0.75	4	50	2	40°	20°	▲
DSTMH.100.005.015	1.0	0.05	1.5	1.5	-	4	50	2	20°	-°	▲
DSTMH.100.005.030	1.0	0.05	1.5	3.0	0.95	4	50	2	40°	20°	▲
DSTMH.100.005.050	1.0	0.05	1.5	5.0	0.95	4	50	2	40°	20°	▲
DSTMH.100.005.070	1.0	0.05	1.5	7.0	0.95	4	50	2	40°	20°	▲
DSTMH.100.010.015	1.0	0.10	1.5	1.5	-	4	50	2	20°	-°	▲
DSTMH.100.010.030	1.0	0.10	1.5	3.0	0.95	4	50	2	40°	20°	▲
DSTMH.100.010.050	1.0	0.10	1.5	5.0	0.95	4	50	2	40°	20°	▲
DSTMH.100.010.070	1.0	0.10	1.5	7.0	0.95	4	50	2	40°	20°	▲
DSTMH.120.010.015	1.2	0.10	1.8	1.8	-	4	50	2	20°	-°	▲
DSTMH.120.010.030	1.2	0.10	1.8	3.6	1.15	4	50	2	40°	20°	▲
DSTMH.120.010.050	1.2	0.10	1.8	6.0	1.15	4	50	2	40°	20°	▲
DSTMH.120.010.070	1.2	0.10	1.8	8.4	1.15	4	50	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号

Carbide grades

切削参数 DSTMH Ø 0.8 - 1.2 mm

Cutting Data DSTMH Ø 0.8 - 1.2 mm



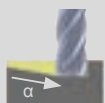
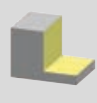
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

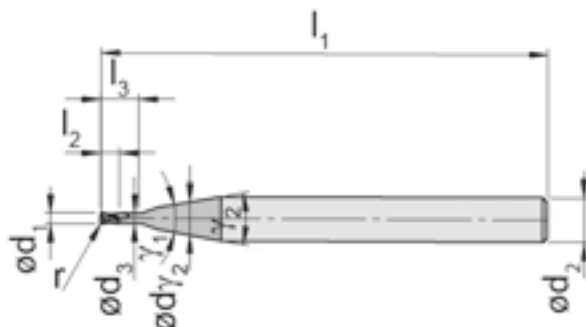
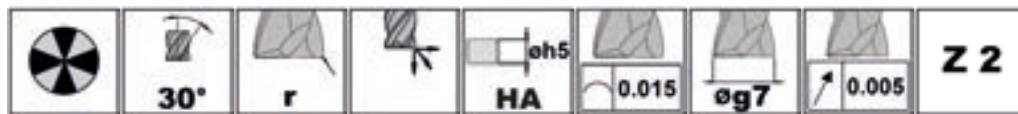
B

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	3°	1.20	1.40	1.50	1.70	1.90	0.011	0.16	0.12	0.016	0.06	0.08
0.8	5°	2.40	2.60	2.70	2.90	3.00	0.011	0.16	0.10	0.016	0.06	0.08
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

尺寸单位 : mm

Dimensions in mm

DSTMH



用于高速轴预安装立铣刀直径可达 $\varnothing 3$ mm (见D2)

Pre-assembled available up to $\varnothing 3$ mm for Toodle high-speed spindle (see page D2)

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	4.50	1.45	4	50	2	40°	20°	▲
DSTMH.150.010.050	1.5	0.1	2.25	7.50	1.45	4	50	2	40°	20°	▲
DSTMH.150.010.070	1.5	0.1	2.25	10.50	1.45	4	50	2	40°	20°	▲
DSTMH.150.020.015	1.5	0.2	2.25	2.25	-	4	50	2	20°	-°	▲
DSTMH.150.020.030	1.5	0.2	2.25	4.50	1.45	4	50	2	40°	20°	▲
DSTMH.150.020.050	1.5	0.2	2.25	7.50	1.45	4	50	2	40°	20°	▲
DSTMH.150.020.070	1.5	0.2	2.25	10.50	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	4.50	1.45	4	50	2	40°	20°	▲
DSTMH.150.050.050	1.5	0.5	2.25	7.50	1.45	4	50	2	40°	20°	▲
DSTMH.150.050.070	1.5	0.5	2.25	10.50	1.45	4	50	2	40°	20°	▲
DSTMH.200.010.015	2.0	0.1	3.00	3.00	-	4	50	2	20°	-°	▲
DSTMH.200.010.030	2.0	0.1	3.00	6.00	1.90	4	50	2	40°	20°	▲
DSTMH.200.010.050	2.0	0.1	3.00	10.00	1.90	4	50	2	40°	20°	▲
DSTMH.200.010.070	2.0	0.1	3.00	14.00	1.90	4	50	2	40°	20°	▲
DSTMH.200.020.015	2.0	0.2	3.00	3.00	-	4	50	2	20°	-°	▲
DSTMH.200.020.030	2.0	0.2	3.00	6.00	1.90	4	50	2	40°	20°	▲
DSTMH.200.020.050	2.0	0.2	3.00	10.00	1.90	4	50	2	40°	20°	▲
DSTMH.200.020.070	2.0	0.2	3.00	14.00	1.90	4	50	2	40°	20°	▲
DSTMH.200.050.015	2.0	0.5	3.00	3.00	-	4	50	2	20°	-°	▲
DSTMH.200.050.030	2.0	0.5	3.00	6.00	1.90	4	50	2	40°	20°	▲
DSTMH.200.050.050	2.0	0.5	3.00	10.00	1.90	4	50	2	40°	20°	▲
DSTMH.200.050.070	2.0	0.5	3.00	14.00	1.90	4	50	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTMH Ø 1.5 - 2.0 mm

Cutting Data DSTMH Ø 1.5 - 2.0 mm



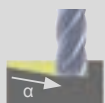
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

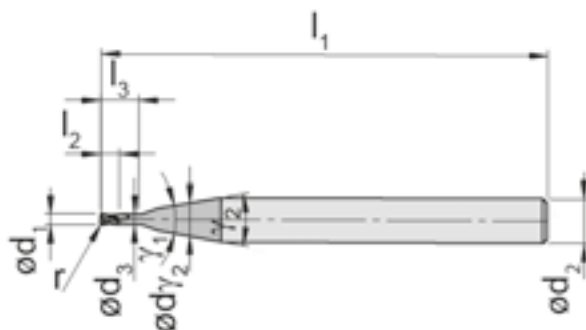
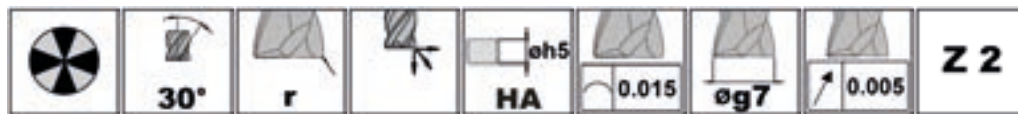
B

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	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	2.60	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
1.5	2°	10.50	11.00	11.20	11.80	13.00	0.015	0.30	0.14	0.022	0.11	0.09
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	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	12.30	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

尺寸单位 : mm

Dimensions in mm

DSTMH



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.250.010.015	2.5	0.1	3.75	3.75	-	4	50	2	20°	-°	▲
DSTMH.250.010.030	2.5	0.1	3.75	7.50	2.4	4	50	2	40°	20°	▲
DSTMH.250.010.050	2.5	0.1	3.75	12.50	2.4	4	50	2	40°	20°	▲
DSTMH.250.010.070	2.5	0.1	3.75	17.50	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	7.50	2.4	4	50	2	40°	20°	▲
DSTMH.250.020.050	2.5	0.2	3.75	12.50	2.4	4	50	2	40°	20°	▲
DSTMH.250.020.070	2.5	0.2	3.75	17.50	2.4	4	50	2	40°	20°	▲
DSTMH.250.050.015	2.5	0.5	3.75	3.75	-	4	50	2	20°	-°	▲
DSTMH.250.050.030	2.5	0.5	3.75	7.50	2.4	4	50	2	40°	20°	▲
DSTMH.250.050.050	2.5	0.5	3.75	12.50	2.4	4	50	2	40°	20°	▲
DSTMH.250.050.070	2.5	0.5	3.75	17.50	2.4	4	50	2	40°	20°	▲
DSTMH.300.010.015	3.0	0.1	4.50	4.50	-	4	50	2	20°	-°	▲
DSTMH.300.010.030	3.0	0.1	4.50	9.00	2.9	4	50	2	40°	20°	▲
DSTMH.300.010.050	3.0	0.1	4.50	15.00	2.9	4	50	2	40°	20°	▲
DSTMH.300.010.070	3.0	0.1	4.50	21.00	2.9	4	60	2	40°	20°	▲
DSTMH.300.020.015	3.0	0.2	4.50	4.50	-	4	50	2	20°	-°	▲
DSTMH.300.020.030	3.0	0.2	4.50	9.00	2.9	4	50	2	40°	20°	▲
DSTMH.300.020.050	3.0	0.2	4.50	15.00	2.9	4	50	2	40°	20°	▲
DSTMH.300.020.070	3.0	0.2	4.50	21.00	2.9	4	60	2	40°	20°	▲
DSTMH.300.050.015	3.0	0.5	4.50	4.50	-	4	50	2	20°	-°	▲
DSTMH.300.050.030	3.0	0.5	4.50	9.00	2.9	4	50	2	40°	20°	▲
DSTMH.300.050.050	3.0	0.5	4.50	15.00	2.9	4	50	2	40°	20°	▲
DSTMH.300.050.070	3.0	0.5	4.50	21.00	2.9	4	60	2	40°	20°	▲
DSTMH.300.100.015	3.0	1.0	4.50	4.50	-	4	50	2	20°	-°	▲
DSTMH.300.100.030	3.0	1.0	4.50	9.00	2.9	4	50	2	40°	20°	▲
DSTMH.300.100.050	3.0	1.0	4.50	15.00	2.9	4	50	2	40°	20°	▲
DSTMH.300.100.070	3.0	1.0	4.50	21.00	2.9	4	60	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

P	-
M	-
K	-
N	-
S	-
H	•

切削参数 DSTMH Ø 2.5 - 3.0 mm

Cutting Data DSTMH Ø 2.5 - 3.0 mm



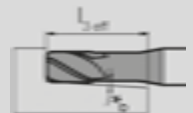
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

d ₁												
		0°	0.5°	1°	2°	3°	f _z	a _e	a _p	f _z	a _e	a _p
2.5	5°	3.75	4.10	4.30	4.90	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	3°	12.50	13.10	13.40	14.10	∞	0.027	0.50	0.28	0.039	0.19	0.20
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	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	3°	12.50	13.10	13.40	14.10	∞	0.027	0.50	0.28	0.039	0.19	0.20
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	5°	3.75	4.10	4.30	4.80	5.40	0.030	0.50	0.38	0.043	0.19	0.25
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
2.5	3°	12.50	13.10	13.40	14.00	∞	0.027	0.50	0.28	0.039	0.19	0.20
2.5	2°	17.50	18.20	18.60	20.20	∞	0.024	0.50	0.23	0.035	0.19	0.15
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	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	5.10	5.70	6.40	0.036	0.60	0.45	0.051	0.23	0.30
3.0	4°	9.00	9.50	9.70	10.50	∞	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	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	5.10	5.60	6.20	0.036	0.60	0.45	0.051	0.23	0.30
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	3°	15.00	15.60	16.00	∞	∞	0.032	0.60	0.33	0.046	0.23	0.24
3.0	2°	21.00	21.80	22.70	∞	∞	0.029	0.60	0.27	0.041	0.23	0.18

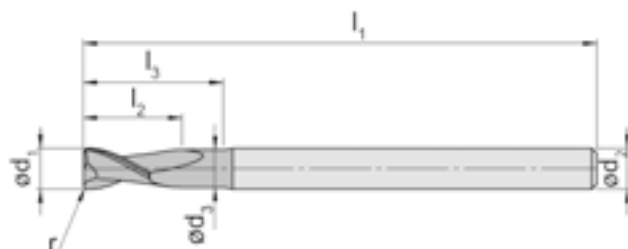
尺寸单位 : mm
Dimensions in mm

圆角立铣刀

Torus End Mill



DSTH



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.2.040.050.015	4	0.5	6	6	-	6	64	2	20°	▲
DSTH.2.040.050.030	4	0.5	6	12	3.8	6	64	2	20°	▲
DSTH.2.040.050.050	4	0.5	6	20	3.8	6	64	2	20°	▲
DSTH.2.040.050.070	4	0.5	6	28	3.8	6	78	2	20°	▲
DSTH.2.040.100.015	4	1.0	6	6	-	6	64	2	20°	▲
DSTH.2.040.100.030	4	1.0	6	12	3.8	6	64	2	20°	▲
DSTH.2.040.100.050	4	1.0	6	20	3.8	6	64	2	20°	▲
DSTH.2.040.100.070	4	1.0	6	28	3.8	6	78	2	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTH Ø 4.0 mm

Cutting Data DSTH Ø 4.0 mm



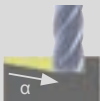
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

							
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	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	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

尺寸单位 : mm

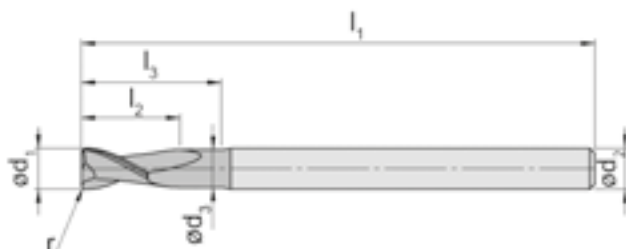
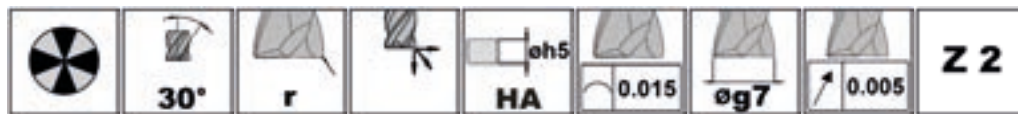
Dimensions in mm

圆角立铣刀

Torus End Mill



DSTH



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.2.050.020.030	5	0.2	7.5	15.0	4.7	6	64	2	20°	▲
DSTH.2.050.020.050	5	0.2	7.5	25.0	4.7	6	64	2	20°	▲
DSTH.2.050.020.070	5	0.2	7.5	35.0	4.7	6	78	2	20°	▲
DSTH.2.050.050.015	5	0.5	7.5	7.5	-	6	64	2	20°	▲
DSTH.2.050.050.030	5	0.5	7.5	15.0	4.7	6	64	2	20°	▲
DSTH.2.050.050.050	5	0.5	7.5	25.0	4.7	6	64	2	20°	▲
DSTH.2.050.050.070	5	0.5	7.5	35.0	4.7	6	78	2	20°	▲
DSTH.2.050.100.015	5	1.0	7.5	7.5	-	6	64	2	20°	▲
DSTH.2.050.100.030	5	1.0	7.5	15.0	4.7	6	64	2	20°	▲
DSTH.2.050.100.050	5	1.0	7.5	25.0	4.7	6	64	2	20°	▲
DSTH.2.050.100.070	5	1.0	7.5	35.0	4.7	6	78	2	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTH Ø 5.0 mm

Cutting Data DSTH Ø 5.0 mm



传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

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	4°	0.058	1.00	0.65	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
5	4°	0.058	1.00	0.65	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
5	4°	0.058	1.00	0.65	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

尺寸单位 : mm

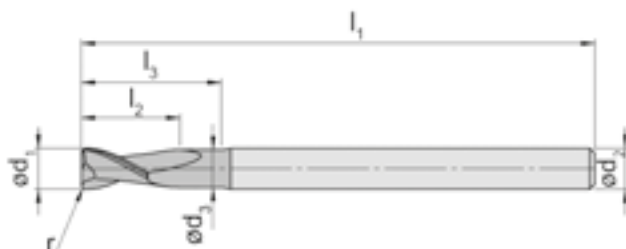
Dimensions in mm

圆角立铣刀

Torus End Mill



DSTH



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.2.060.020.070	6	0.2	9	42	5.7	6	78	2	▲
DSTH.2.060.050.015	6	0.5	9	9	-	6	64	2	▲
DSTH.2.060.050.030	6	0.5	9	18	5.7	6	64	2	▲
DSTH.2.060.050.050	6	0.5	9	30	5.7	6	78	2	▲
DSTH.2.060.050.070	6	0.5	9	42	5.7	6	78	2	▲
DSTH.2.060.100.015	6	1.0	9	9	-	6	64	2	▲
DSTH.2.060.100.030	6	1.0	9	18	5.7	6	64	2	▲
DSTH.2.060.100.050	6	1.0	9	30	5.7	6	78	2	▲
DSTH.2.060.100.070	6	1.0	9	42	5.7	6	78	2	▲
DSTH.2.060.200.015	6	2.0	9	9	-	6	64	2	▲
DSTH.2.060.200.030	6	2.0	9	18	5.7	6	64	2	▲
DSTH.2.060.200.050	6	2.0	9	30	5.7	6	78	2	▲
DSTH.2.060.200.070	6	2.0	9	42	5.7	6	78	2	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTH Ø 6.0 mm

Cutting Data DSTH Ø 6.0 mm



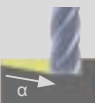
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

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	2°	0.055	1.20	0.54	0.079	0.45	0.36
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	2°	0.055	1.20	0.54	0.079	0.45	0.36
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	2°	0.055	1.20	0.54	0.079	0.45	0.36
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	2°	0.055	1.20	0.54	0.079	0.45	0.36

尺寸单位 : mm

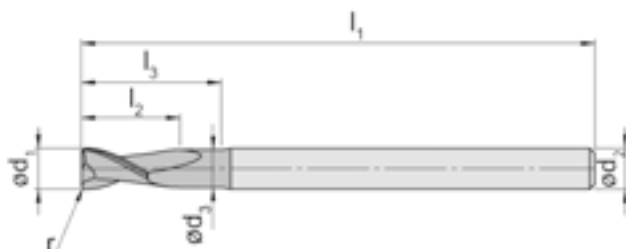
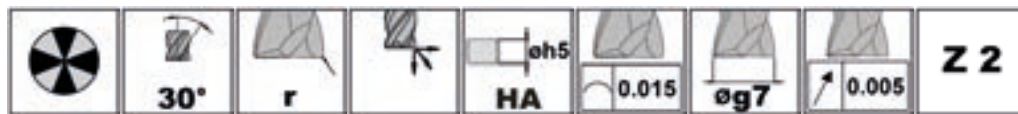
Dimensions in mm

圆角立铣刀

Torus End Mill



DSTH



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TS3E
DSTH.2.080.020.015	8	0.2	12	12	-	8	64	2	▲
DSTH.2.080.020.030	8	0.2	12	24	7.6	8	64	2	▲
DSTH.2.080.020.050	8	0.2	12	40	7.6	8	78	2	▲
DSTH.2.080.020.070	8	0.2	12	56	7.6	8	100	2	▲
DSTH.2.080.050.015	8	0.5	12	12	-	8	64	2	▲
DSTH.2.080.050.030	8	0.5	12	24	7.6	8	64	2	▲
DSTH.2.080.050.050	8	0.5	12	40	7.6	8	78	2	▲
DSTH.2.080.050.070	8	0.5	12	56	7.6	8	100	2	▲
DSTH.2.080.100.015	8	1.0	12	12	-	8	64	2	▲
DSTH.2.080.100.030	8	1.0	12	24	7.6	8	64	2	▲
DSTH.2.080.100.050	8	1.0	12	40	7.6	8	78	2	▲
DSTH.2.080.100.070	8	1.0	12	56	7.6	8	100	2	▲
DSTH.2.080.200.015	8	2.0	12	12	-	8	64	2	▲
DSTH.2.080.200.030	8	2.0	12	24	7.6	8	64	2	▲
DSTH.2.080.200.050	8	2.0	12	40	7.6	8	78	2	▲
DSTH.2.080.200.070	8	2.0	12	56	7.6	8	100	2	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTH Ø 8.0 mm

Cutting Data DSTH Ø 8.0 mm



传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

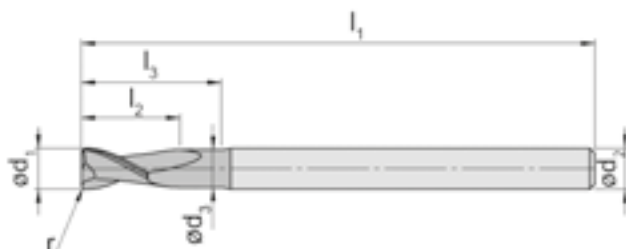
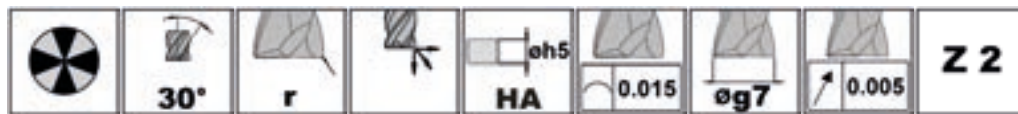
B

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
8	5°	0.092	1.60	1.20	0.130	0.60	0.80
8	4°	0.092	1.60	1.04	0.130	0.60	0.80
8	3°	0.082	1.60	0.88	0.117	0.60	0.64
8	2°	0.073	1.60	0.72	0.104	0.60	0.48
8	5°	0.092	1.60	1.20	0.130	0.60	0.80
8	4°	0.092	1.60	1.04	0.130	0.60	0.80
8	3°	0.082	1.60	0.88	0.117	0.60	0.64
8	2°	0.073	1.60	0.72	0.104	0.60	0.48
8	5°	0.092	1.60	1.20	0.130	0.60	0.80
8	4°	0.092	1.60	1.04	0.130	0.60	0.80
8	3°	0.082	1.60	0.88	0.117	0.60	0.64
8	2°	0.073	1.60	0.72	0.104	0.60	0.48
8	5°	0.092	1.60	1.20	0.130	0.60	0.80
8	4°	0.092	1.60	1.04	0.130	0.60	0.80
8	3°	0.082	1.60	0.88	0.117	0.60	0.64
8	2°	0.073	1.60	0.72	0.104	0.60	0.48

尺寸单位 : mm

Dimensions in mm

DSTH



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.2.100.020.030	10	0.2	15	30	9.6	10	78	2	▲
DSTH.2.100.020.050	10	0.2	15	50	9.6	10	100	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.2.100.050.030	10	0.5	15	30	9.6	10	78	2	▲
DSTH.2.100.050.050	10	0.5	15	50	9.6	10	100	2	▲
DSTH.2.100.050.070	10	0.5	15	70	9.6	10	120	2	▲
DSTH.2.100.100.015	10	1.0	15	15	-	10	78	2	▲
DSTH.2.100.100.030	10	1.0	15	30	9.6	10	78	2	▲
DSTH.2.100.100.050	10	1.0	15	50	9.6	10	100	2	▲
DSTH.2.100.100.070	10	1.0	15	70	9.6	10	120	2	▲
DSTH.2.100.200.015	10	2.0	15	15	-	10	78	2	▲
DSTH.2.100.200.030	10	2.0	15	30	9.6	10	78	2	▲
DSTH.2.100.200.050	10	2.0	15	50	9.6	10	100	2	▲
DSTH.2.100.200.070	10	2.0	15	70	9.6	10	120	2	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号

Carbide grades

切削参数 DSTH Ø 10.0 mm

Cutting Data DSTH Ø 10.0 mm



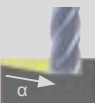
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

d ₁							
		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	4°	0.114	2.00	1.30	0.162	0.75	1.00
10	3°	0.103	2.00	1.10	0.146	0.75	0.80
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	4°	0.114	2.00	1.30	0.162	0.75	1.00
10	3°	0.103	2.00	1.10	0.146	0.75	0.80
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	4°	0.114	2.00	1.30	0.162	0.75	1.00
10	3°	0.103	2.00	1.10	0.146	0.75	0.80
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	4°	0.114	2.00	1.30	0.162	0.75	1.00
10	3°	0.103	2.00	1.10	0.146	0.75	0.80
10	2°	0.091	2.00	0.90	0.130	0.75	0.60

尺寸单位 : mm

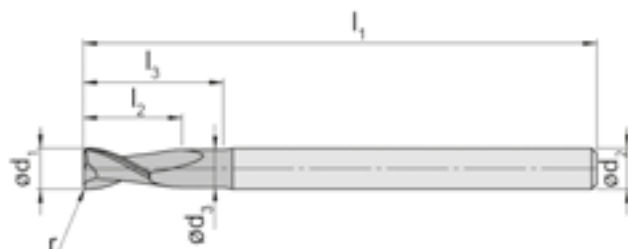
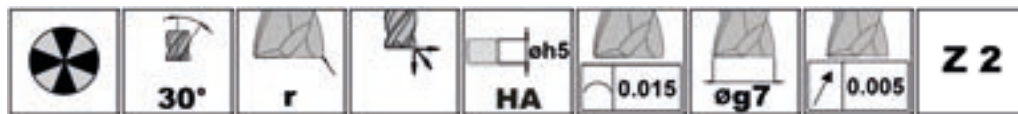
Dimensions in mm

圆角立铣刀

Torus End Mill



DSTH



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	TS3E
DSTH.2.120.020.015	12	0.2	18	18	-	12	78	2	▲
DSTH.2.120.020.030	12	0.2	18	36	11.6	12	100	2	▲
DSTH.2.120.020.050	12	0.2	18	60	11.6	12	120	2	▲
DSTH.2.120.020.070	12	0.2	18	84	11.6	12	140	2	▲
DSTH.2.120.050.015	12	0.5	18	18	-	12	78	2	▲
DSTH.2.120.050.030	12	0.5	18	36	11.6	12	100	2	▲
DSTH.2.120.050.050	12	0.5	18	60	11.6	12	120	2	▲
DSTH.2.120.050.070	12	0.5	18	84	11.6	12	140	2	▲
DSTH.2.120.100.015	12	1.0	18	18	-	12	78	2	▲
DSTH.2.120.100.030	12	1.0	18	36	11.6	12	100	2	▲
DSTH.2.120.100.050	12	1.0	18	60	11.6	12	120	2	▲
DSTH.2.120.100.070	12	1.0	18	84	11.6	12	140	2	▲
DSTH.2.120.200.015	12	2.0	18	18	-	12	78	2	▲
DSTH.2.120.200.030	12	2.0	18	36	11.6	12	100	2	▲
DSTH.2.120.200.050	12	2.0	18	60	11.6	12	120	2	▲
DSTH.2.120.200.070	12	2.0	18	84	11.6	12	140	2	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号

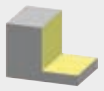
Carbide grades

切削参数 DSTH Ø 12.0 mm

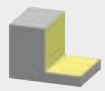
Cutting Data DSTH Ø 12.0 mm



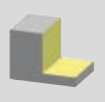
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
12	5°	0.136	2.40	1.80	0.194	0.90	1.20
12	4°	0.136	2.40	1.56	0.194	0.90	1.20
12	3°	0.123	2.40	1.32	0.175	0.90	0.96
12	2°	0.109	2.40	1.08	0.155	0.90	0.72
12	5°	0.136	2.40	1.80	0.194	0.90	1.20
12	4°	0.136	2.40	1.56	0.194	0.90	1.20
12	3°	0.123	2.40	1.32	0.175	0.90	0.96
12	2°	0.109	2.40	1.08	0.155	0.90	0.72
12	5°	0.136	2.40	1.80	0.194	0.90	1.20
12	4°	0.136	2.40	1.56	0.194	0.90	1.20
12	3°	0.123	2.40	1.32	0.175	0.90	0.96
12	2°	0.109	2.40	1.08	0.155	0.90	0.72
12	5°	0.136	2.40	1.80	0.194	0.90	1.20
12	4°	0.136	2.40	1.56	0.194	0.90	1.20
12	3°	0.123	2.40	1.32	0.175	0.90	0.96
12	2°	0.109	2.40	1.08	0.155	0.90	0.72

尺寸单位 : mm

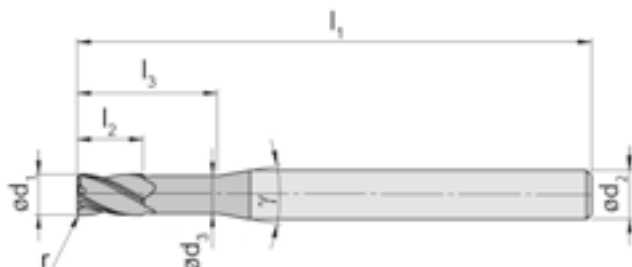
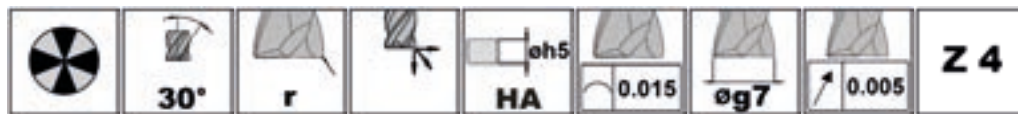
Dimensions in mm

圆角立铣刀

Torus End Mill



DSTH



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	TS3E
DSTH.4.040.020.015	4	0.2	6.0	6.0	-	6	64	4	20°	▲
DSTH.4.040.020.030	4	0.2	6.0	12.0	3.8	6	64	4	20°	▲
DSTH.4.040.020.050	4	0.2	6.0	20.0	3.8	6	64	4	20°	▲
DSTH.4.040.020.070	4	0.2	6.0	28.0	3.8	6	78	4	20°	▲
DSTH.4.040.050.015	4	0.5	6.0	6.0	-	6	64	4	20°	▲
DSTH.4.040.050.030	4	0.5	6.0	12.0	3.8	6	64	4	20°	▲
DSTH.4.040.050.050	4	0.5	6.0	20.0	3.8	6	64	4	20°	▲
DSTH.4.040.050.070	4	0.5	6.0	28.0	3.8	6	78	4	20°	▲
DSTH.4.040.100.015	4	1.0	6.0	6.0	-	6	64	4	20°	▲
DSTH.4.040.100.030	4	1.0	6.0	12.0	3.8	6	64	4	20°	▲
DSTH.4.040.100.050	4	1.0	6.0	20.0	3.8	6	64	4	20°	▲
DSTH.4.040.100.070	4	1.0	6.0	28.0	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	15.0	4.7	6	64	4	20°	▲
DSTH.4.050.020.050	5	0.2	7.5	25.0	4.7	6	64	4	20°	▲
DSTH.4.050.020.070	5	0.2	7.5	35.0	4.7	6	78	4	20°	▲
DSTH.4.050.050.015	5	0.5	7.5	7.5	-	6	64	4	20°	▲
DSTH.4.050.050.030	5	0.5	7.5	15.0	4.7	6	64	4	20°	▲
DSTH.4.050.050.050	5	0.5	7.5	25.0	4.7	6	64	4	20°	▲
DSTH.4.050.050.070	5	0.5	7.5	35.0	4.7	6	78	4	20°	▲
DSTH.4.050.100.015	5	1.0	7.5	7.5	-	6	64	4	20°	▲
DSTH.4.050.100.030	5	1.0	7.5	15.0	4.7	6	64	4	20°	▲
DSTH.4.050.100.050	5	1.0	7.5	25.0	4.7	6	64	4	20°	▲
DSTH.4.050.100.070	5	1.0	7.5	35.0	4.7	6	78	4	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTH Ø 4.0 - 5.0 mm

Cutting Data DSTH Ø 4.0 - 5.0 mm



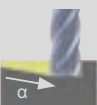
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

							
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	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	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	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	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

尺寸单位：mm

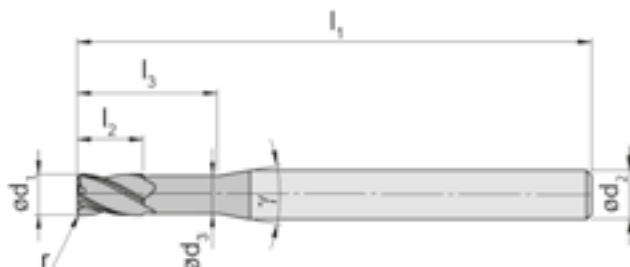
Dimensions in mm

圆角立铣刀

Torus End Mill



DSTH



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.4.060.020.070	6	0.2	9	42	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	1.0	9	9	-	6	64	4	▲
DSTH.4.060.100.030	6	1.0	9	18	5.7	6	64	4	▲
DSTH.4.060.100.050	6	1.0	9	30	5.7	6	78	4	▲
DSTH.4.060.100.070	6	1.0	9	42	5.7	6	78	4	▲
DSTH.4.060.200.015	6	2.0	9	9	-	6	64	4	▲
DSTH.4.060.200.030	6	2.0	9	18	5.7	6	64	4	▲
DSTH.4.060.200.050	6	2.0	9	30	5.7	6	78	4	▲
DSTH.4.060.200.070	6	2.0	9	42	5.7	6	78	4	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTH Ø 6.0 mm

Cutting Data DSTH Ø 6.0 mm



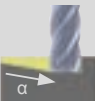
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

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	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
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
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
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

尺寸单位 : mm

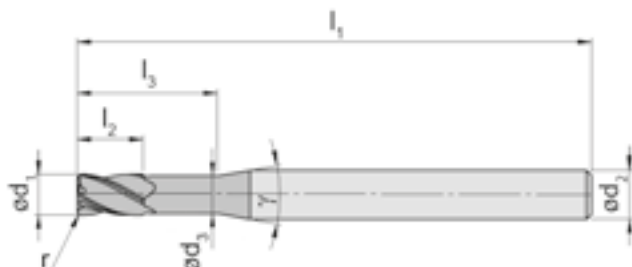
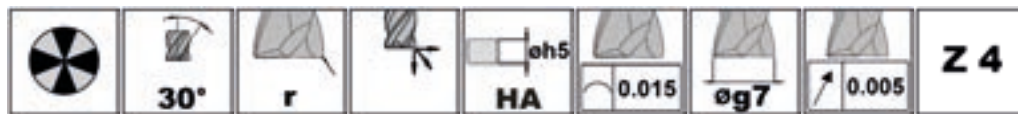
Dimensions in mm

圆角立铣刀

Torus End Mill



DSTH



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.4.080.020.070	8	0.2	12	56	7.6	8	100	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.4.080.050.070	8	0.5	12	56	7.6	8	100	4	▲
DSTH.4.080.100.015	8	1.0	12	12	-	8	64	4	▲
DSTH.4.080.100.030	8	1.0	12	24	7.6	8	64	4	▲
DSTH.4.080.100.050	8	1.0	12	40	7.6	8	78	4	▲
DSTH.4.080.100.070	8	1.0	12	56	7.6	8	100	4	▲
DSTH.4.080.200.015	8	2.0	12	12	-	8	64	4	▲
DSTH.4.080.200.030	8	2.0	12	24	7.6	8	64	4	▲
DSTH.4.080.200.050	8	2.0	12	40	7.6	8	78	4	▲
DSTH.4.080.200.070	8	2.0	12	56	7.6	8	100	4	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTH Ø 8.0 mm

Cutting Data DSTH Ø 8.0 mm



传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

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	2°	0.048	1.60	0.72	0.067	0.60	0.48
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
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
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

尺寸单位 : mm

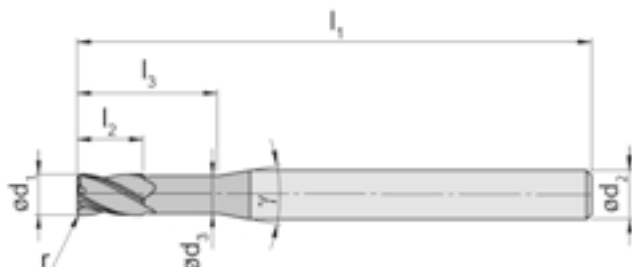
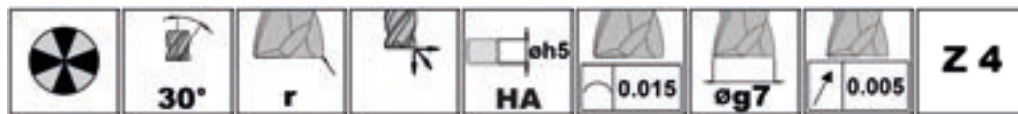
Dimensions in mm

圆角立铣刀

Torus End Mill



DSTH



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.4.100.020.070	10	0.2	15	70	9.6	10	120	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.4.100.050.070	10	0.5	15	70	9.6	10	120	4	▲
DSTH.4.100.100.015	10	1.0	15	15	-	10	78	4	▲
DSTH.4.100.100.030	10	1.0	15	30	9.6	10	78	4	▲
DSTH.4.100.100.050	10	1.0	15	50	9.6	10	100	4	▲
DSTH.4.100.100.070	10	1.0	15	70	9.6	10	120	4	▲
DSTH.4.100.200.015	10	2.0	15	15	-	10	78	4	▲
DSTH.4.100.200.030	10	2.0	15	30	9.6	10	78	4	▲
DSTH.4.100.200.050	10	2.0	15	50	9.6	10	100	4	▲
DSTH.4.100.200.070	10	2.0	15	70	9.6	10	120	4	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTH Ø 10.0 mm

Cutting Data DSTH Ø 10.0 mm



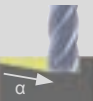
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

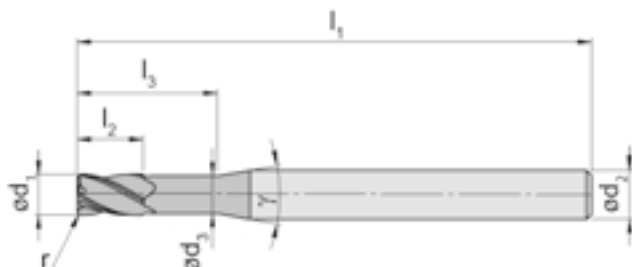
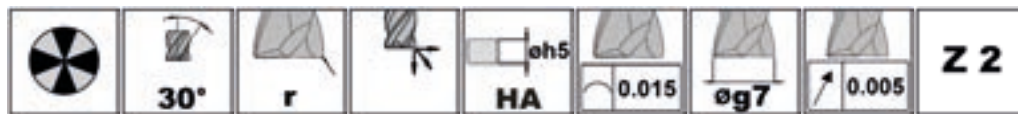
B

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	2°	0.064	2.00	0.90	0.091	0.75	0.60
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	2°	0.064	2.00	0.90	0.091	0.75	0.60
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	2°	0.064	2.00	0.90	0.091	0.75	0.60
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	2°	0.064	2.00	0.90	0.091	0.75	0.60

尺寸单位 : mm

Dimensions in mm

DSTH



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.4.120.020.050	12	0.2	18	60	11.6	12	120	4	▲
DSTH.4.120.020.070	12	0.2	18	84	11.6	12	140	4	▲
DSTH.4.120.050.015	12	0.5	18	18	-	12	78	4	▲
DSTH.4.120.050.030	12	0.5	18	36	11.6	12	100	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	1.0	18	18	-	12	78	4	▲
DSTH.4.120.100.030	12	1.0	18	36	11.6	12	100	4	▲
DSTH.4.120.100.050	12	1.0	18	60	11.6	12	120	4	▲
DSTH.4.120.100.070	12	1.0	18	84	11.6	12	140	4	▲
DSTH.4.120.200.015	12	2.0	18	18	-	12	78	4	▲
DSTH.4.120.200.030	12	2.0	18	36	11.6	12	100	4	▲
DSTH.4.120.200.050	12	2.0	18	60	11.6	12	120	4	▲
DSTH.4.120.200.070	12	2.0	18	84	11.6	12	140	4	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSTH Ø 12.0 mm

Cutting Data DSTH Ø 12.0 mm



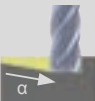
传统铣削 / Conventional milling

		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

高速铣 / HSC milling

		
	vc = m/min	vc = m/min
H1.1	180	220
H1.2	160	190
H1.3	140	170
H1.4	120	140

B

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	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	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	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	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

尺寸单位 : mm

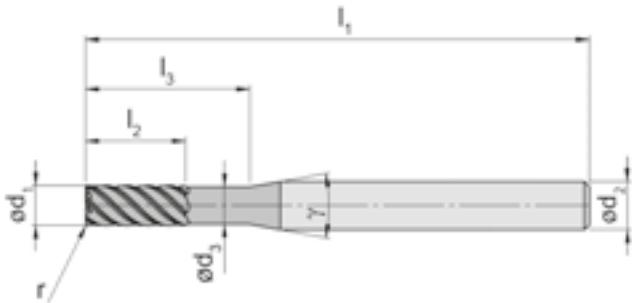
Dimensions in mm

多刃立铣刀

End Mill multiple fluted



DSMH



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)
Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	10.0	16	3.80	6	64	6	20°	▲
DSMH.6.05.040	5	12.5	20	4.70	6	64	6	20°	▲
DSMH.6.06.040	6	15.0	24	5.70	6	64	6	-°	▲
DSMH.6.08.040	8	20.0	32	7.60	8	78	6	-°	▲
DSMH.6.10.040	10	25.0	40	9.40	10	78	6	-°	▲
DSMH.6.12.040	12	30.0	48	11.40	12	100	6	-°	▲
DSMH.6.16.040	16	40.0	64	15.40	16	120	6	-°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号
Carbide grades

切削参数 DSMH Ø 3.0 -16.0 mm

Cutting Data DSMH Ø 3.0 - 16.0 mm



		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

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

尺寸单位 : mm
Dimensions in mm

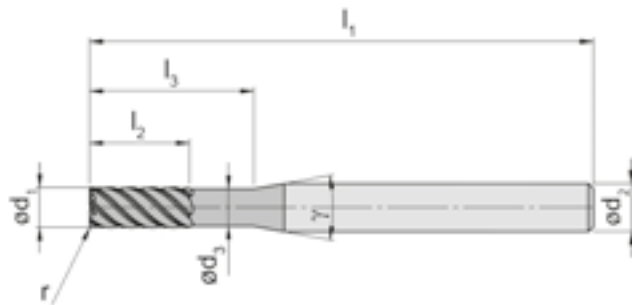
B

多刃立铣刀，刀尖为圆角

End Mill multiple fluted, corner radius



DSMRH



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.6.03.050.040	3	0.5	7.5	12	2.86	6	64	6	20°	▲
DSMRH.6.03.100.040	3	1.0	7.5	12	2.86	6	64	6	20°	▲
DSMRH.6.04.020.040	4	0.2	10.0	16	3.80	6	64	6	20°	▲
DSMRH.6.04.050.040	4	0.5	10.0	16	3.80	6	64	6	20°	▲
DSMRH.6.04.100.040	4	1.0	10.0	16	3.80	6	64	6	20°	▲
DSMRH.6.05.020.040	5	0.2	12.5	20	4.70	6	64	6	20°	▲
DSMRH.6.05.050.040	5	0.5	12.5	20	4.70	6	64	6	20°	▲
DSMRH.6.05.100.040	5	1.0	12.5	20	4.70	6	64	6	20°	▲
DSMRH.6.06.020.040	6	0.2	15.0	24	5.70	6	64	6	-°	▲
DSMRH.6.06.050.040	6	0.5	15.0	24	5.70	6	64	6	-°	▲
DSMRH.6.06.100.040	6	1.0	15.0	24	5.70	6	64	6	-°	▲
DSMRH.6.08.020.040	8	0.2	20.0	32	7.60	8	78	6	-°	▲
DSMRH.6.08.050.040	8	0.5	20.0	32	7.60	8	78	6	-°	▲
DSMRH.6.08.100.040	8	1.0	20.0	32	7.60	8	78	6	-°	▲
DSMRH.6.10.020.040	10	0.2	25.0	40	9.40	10	78	6	-°	▲
DSMRH.6.10.050.040	10	0.5	25.0	40	9.40	10	78	6	-°	▲
DSMRH.6.10.100.040	10	1.0	25.0	40	9.40	10	78	6	-°	▲
DSMRH.6.10.200.040	10	2.0	25.0	40	9.40	10	78	6	-°	▲
DSMRH.6.12.020.040	12	0.2	30.0	48	11.40	12	100	6	-°	▲
DSMRH.6.12.050.040	12	0.5	30.0	48	11.40	12	100	6	-°	▲
DSMRH.6.12.100.040	12	1.0	30.0	48	11.40	12	100	6	-°	▲
DSMRH.6.12.200.040	12	2.0	30.0	48	11.40	12	100	6	-°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	-
H	•

硬质合金牌号

Carbide grades

切削参数 DSMRH Ø 3.0 - 12.0 mm

Cutting Data DSMH Ø 3.0 - 12.0 mm



		
	vc = m/min	vc = m/min
H1.1	120	150
H1.2	100	130
H1.3	80	100
H1.4	70	90

							
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
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
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
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

尺寸单位 : mm

Dimensions in mm

B

整体硬质合金立铣刀

Solid Carbide End Mills



DSKC

圆头立铣刀
Ball Nose End Mill

Ø 1,0 – Ø 16,0

Z2-Z7

B118 – B119



DSKC.220°

220°球头立铣刀
Ball Nose End Mill 220°

Ø 3,0 – Ø 12,0

Z2-Z7

B120 – B121



DSTC

圆角立铣刀
Torus End Mill

Ø 1,5 – Ø 12,0

Z2-Z5

B122 – B123



DSMRC

多刃立铣刀, 刀尖为圆角
End Mill multiple fluted, corner radius

Ø 3,0 – Ø 16,0

Z2-Z5

B124 – B125

B

DS



B

设计用于:

- 钴铬合金钢

designed for:

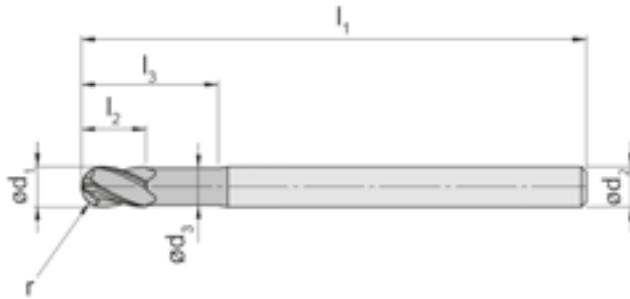
- Cobalt Chromium Steels

球头立铣刀

Ball Nose End Mill



DSKC



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)
Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	0.50	2	3.0	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	2.0	1.00	3	5.0	1.9	6	63	2	▲
DSKC.2.020.077.06	2.0	1.00	3	8.0	1.9	6	77	2	▲
DSKC.2.030.063.06	3.0	1.50	4	7.5	2.9	6	63	2	▲
DSKC.2.030.077.06	3.0	1.50	4	12.0	2.9	6	77	2	▲
DSKC.3.040.063.06	4.0	2.00	5	10.0	3.8	6	63	3	▲
DSKC.3.040.077.06	4.0	2.00	5	16.0	3.8	6	77	3	▲
DSKC.4.050.063.06	5.0	2.50	5	12.5	4.7	6	63	4	▲
DSKC.4.050.077.06	5.0	2.50	5	20.0	4.7	6	77	4	▲
DSKC.4.060.063.06	6.0	3.00	6	15.0	5.6	6	63	4	▲
DSKC.4.060.077.06	6.0	3.00	6	24.0	5.6	6	77	4	▲
DSKC.4.060.099.08	6.0	3.00	6	36.0	5.6	8	99	4	▲
DSKC.5.080.063.08	8.0	4.00	8	20.0	7.4	8	63	5	▲
DSKC.5.080.077.08	8.0	4.00	8	32.0	7.4	8	77	5	▲
DSKC.5.080.099.08	8.0	4.00	8	48.0	7.4	8	99	5	▲
DSKC.5.100.077.10	10.0	5.00	10	25.0	9.4	10	77	5	▲
DSKC.5.100.099.10	10.0	5.00	10	40.0	9.4	10	99	5	▲
DSKC.7.120.077.12	12.0	6.00	12	30.0	11.4	12	77	7	▲
DSKC.7.120.099.12	12.0	6.00	12	48.0	11.4	12	99	7	▲
DSKC.7.160.099.16	16.0	8.00	20	50.0	15.4	16	99	7	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	•
H	○

硬质合金牌号
Carbide grades

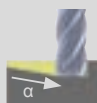
切削参数 DSKC Ø 1.0 - 16.0 mm

Cutting Data DSKC Ø 1.0 - 16.0 mm



	 vc = m/min	 vc = m/min
S1	-	-
S2	45	60
S3	40	50

B

d ₁								
	α	0°	f _z	a _e	a _p	f _z	a _e	a _p
1.0	5°	0.3	0.011	0.20	0.50	0.017	0.05	0.10
1.5	5°	0.3	0.013	0.30	0.75	0.022	0.08	0.15
2.0	5°	0.3	0.015	0.40	1.00	0.026	0.10	0.20
2.0	5°	0.3	0.015	0.40	1.00	0.026	0.10	0.20
3.0	5°	0.3	0.020	0.60	1.50	0.035	0.15	0.30
3.0	5°	0.3	0.020	0.60	1.50	0.035	0.15	0.30
4.0	5°	0.3	0.018	0.80	2.00	0.032	0.20	0.40
4.0	5°	0.3	0.018	0.80	2.00	0.032	0.20	0.40
5.0	4°	0.3	0.020	1.00	2.50	0.035	0.25	0.50
5.0	4°	0.3	0.020	1.00	2.50	0.035	0.25	0.50
6.0	4°	0.3	0.024	1.20	3.00	0.044	0.30	0.60
6.0	4°	0.3	0.024	1.20	3.00	0.044	0.30	0.60
6.0	4°	0.3	0.024	1.20	3.00	0.044	0.30	0.60
8.0	3°	0.3	0.032	1.60	4.00	0.059	0.40	0.80
8.0	3°	0.3	0.032	1.60	4.00	0.059	0.40	0.80
8.0	3°	0.3	0.032	1.60	4.00	0.059	0.40	0.80
10.0	3°	0.3	0.041	2.00	5.00	0.077	0.50	1.00
10.0	3°	0.3	0.041	2.00	5.00	0.077	0.50	1.00
12.0	3°	0.3	0.048	2.40	6.00	0.091	0.60	1.20
12.0	3°	0.3	0.048	2.40	6.00	0.091	0.60	1.20
16.0	3°	0.3	0.065	3.20	8.00	0.126	0.80	1.60

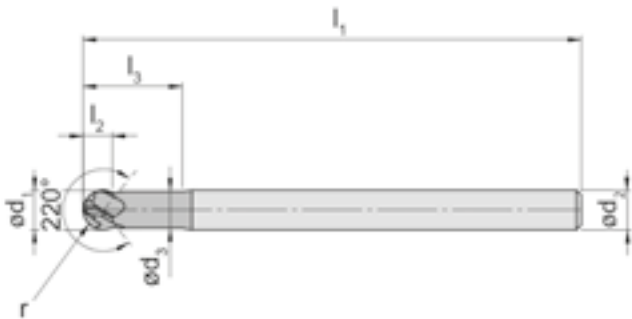
尺寸单位 : mm

Dimensions in mm

220°球头立铣刀
Ballnose End Mill 220°



DSKC 220°



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)
Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	2.0	15	2.80	6	63	2	▲
DSKC.3.040.063.06.2	4	2.0	2.6	20	3.75	6	63	3	▲
DSKC.4.050.063.06.2	5	2.5	3.3	25	4.70	6	63	4	▲
DSKC.4.060.063.06.2	6	3.0	4.0	30	5.65	6	63	4	▲
DSKC.5.080.088.08.2	8	4.0	5.3	40	7.50	8	88	5	▲
DSKC.5.100.101.10.2	10	5.0	6.7	50	9.40	10	101	5	▲
DSKC.7.120.119.12.2	12	6.0	8.0	60	11.30	12	119	7	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request
● 推荐 / recommended
o 次推荐 / alternative recommendation
- 不合适 / not suitable
■ 非涂层 / uncoated grades
■ 涂层 / coated grades
■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm
Dimensions in mm

P	-
M	-
K	-
N	-
S	•
H	o

硬质合金牌号
Carbide grades

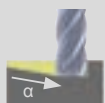
切削参数 DSKC Ø 3.0 - 12.0 mm

Cutting Data DSKC Ø 3.0 - 12.0 mm



	 vc = m/min	 vc = m/min
S1	-	-
S2	45	60
S3	40	50

B

d ₁								
	α	0°	f _z	a _e	a _p	f _z	a _e	a _p
3	5°	0.3	0.015	0.60	1.50	0.026	0.15	0.30
4	5°	0.3	0.014	0.80	2.00	0.023	0.20	0.40
5	4°	0.3	0.015	1.00	2.50	0.027	0.25	0.50
6	4°	0.3	0.020	1.20	3.00	0.035	0.30	0.60
8	3°	0.3	0.027	1.60	4.00	0.050	0.40	0.80
10	3°	0.3	0.036	2.00	5.00	0.068	0.50	1.00
12	3°	0.3	0.043	2.40	6.00	0.082	0.60	1.20

尺寸单位 : mm

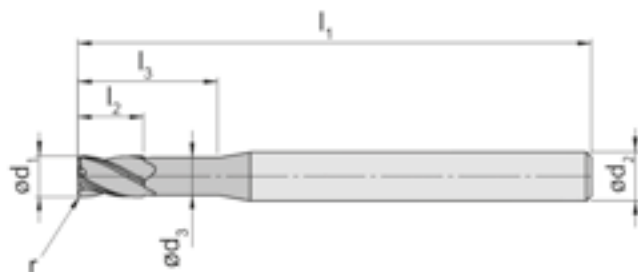
Dimensions in mm

圆角立铣刀

Torus End Mill



DSTC



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

Bestellnummer 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	0.2	3.0	5.5	1.9	6	55	2	▲
DSTC.2.03.02.055.06	3.0	0.2	4.0	7.5	2.9	6	55	2	▲
DSTC.2.03.05.055.06	3.0	0.5	4.0	7.5	2.9	6	55	2	▲
DSTC.3.04.02.055.06	4.0	0.2	5.0	8.5	3.8	6	55	3	▲
DSTC.3.04.05.055.06	4.0	0.5	5.0	8.5	3.8	6	55	3	▲
DSTC.4.05.02.055.06	5.0	0.2	6.0	12.5	4.7	6	55	4	▲
DSTC.4.05.05.055.06	5.0	0.5	6.0	12.5	4.7	6	55	4	▲
DSTC.4.05.10.055.06	5.0	1.0	6.0	12.5	4.7	6	55	4	▲
DSTC.4.06.02.055.06	6.0	0.2	6.0	15.5	5.6	6	55	4	▲
DSTC.4.06.05.055.06	6.0	0.5	6.0	15.5	5.6	6	55	4	▲
DSTC.4.06.10.055.06	6.0	1.0	6.0	15.5	5.6	6	55	4	▲
DSTC.5.08.02.063.08	8.0	0.2	10.0	20.5	7.4	8	63	5	▲
DSTC.5.08.05.063.08	8.0	0.5	10.0	20.5	7.4	8	63	5	▲
DSTC.5.08.10.063.08	8.0	1.0	10.0	20.5	7.4	8	63	5	▲
DSTC.5.08.15.063.08	8.0	1.5	10.0	20.5	7.4	8	63	5	▲
DSTC.5.10.02.077.10	10.0	0.2	15.0	25.5	9.4	10	77	5	▲
DSTC.5.10.05.077.10	10.0	0.5	15.0	25.5	9.4	10	77	5	▲
DSTC.5.10.10.077.10	10.0	1.0	15.0	25.5	9.4	10	77	5	▲
DSTC.5.10.15.077.10	10.0	1.5	15.0	25.5	9.4	10	77	5	▲
DSTC.5.12.02.077.12	12.0	0.2	18.0	30.5	11.4	12	77	5	▲
DSTC.5.12.05.077.12	12.0	0.5	18.0	30.5	11.4	12	77	5	▲
DSTC.5.12.10.077.12	12.0	1.0	18.0	30.5	11.4	12	77	5	▲
DSTC.5.12.15.077.12	12.0	1.5	18.0	30.5	11.4	12	77	5	▲
DSTC.5.12.20.077.12	12.0	2.0	18.0	30.5	11.4	12	77	5	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	•
H	○

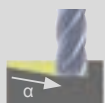
硬质合金牌号
Carbide grades

切削参数 DSTC Ø 1.5 - 12.0 mm

Cutting Data DSTC Ø 1.5 - 12.0 mm



	 vc = m/min	 vc = m/min
S1	-	-
S2	45	60
S3	40	50

d ₁								
	α	0°	f _z	a _e	a _p	f _z	a _e	a _p
1.5	5°	0.3	0.014	0.30	1.50	0.019	0.08	0.15
2.0	5°	0.3	0.017	0.40	2.00	0.025	0.10	0.20
3.0	5°	0.3	0.023	0.60	3.00	0.038	0.15	0.30
3.0	5°	0.3	0.023	0.60	3.00	0.038	0.15	0.30
4.0	5°	0.3	0.024	0.80	4.00	0.039	0.20	0.40
4.0	5°	0.3	0.024	0.80	4.00	0.039	0.20	0.40
5.0	4°	0.3	0.027	1.00	5.00	0.046	0.25	0.50
5.0	4°	0.3	0.027	1.00	5.00	0.046	0.25	0.50
5.0	4°	0.3	0.027	1.00	5.00	0.046	0.25	0.50
6.0	4°	0.3	0.034	1.20	6.00	0.058	0.30	0.60
6.0	4°	0.3	0.034	1.20	6.00	0.058	0.30	0.60
6.0	4°	0.3	0.034	1.20	6.00	0.058	0.30	0.60
8.0	3°	0.3	0.045	1.60	8.00	0.080	0.40	0.80
8.0	3°	0.3	0.045	1.60	8.00	0.080	0.40	0.80
8.0	3°	0.3	0.045	1.60	8.00	0.080	0.40	0.80
8.0	3°	0.3	0.045	1.60	8.00	0.080	0.40	0.80
10.0	3°	0.3	0.057	2.00	10.00	0.106	0.50	1.00
10.0	3°	0.3	0.057	2.00	10.00	0.106	0.50	1.00
10.0	3°	0.3	0.057	2.00	10.00	0.106	0.50	1.00
10.0	3°	0.3	0.057	2.00	10.00	0.106	0.50	1.00
12.0	3°	0.3	0.070	2.40	12.00	0.132	0.60	1.20
12.0	3°	0.3	0.070	2.40	12.00	0.132	0.60	1.20
12.0	3°	0.3	0.070	2.40	12.00	0.132	0.60	1.20
12.0	3°	0.3	0.070	2.40	12.00	0.132	0.60	1.20

尺寸单位 : mm
Dimensions in mm

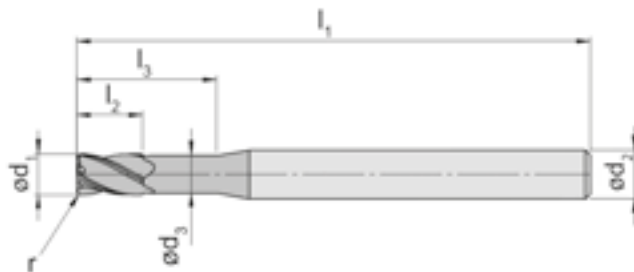
B

多刃立铣刀，刀尖为圆角

End Mill multiple fluted, corner radius



DSMRC



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	3.0	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	4.0	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	5.0	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	6.0	18.5	5.8	6	63	5	▲
DSMRC.5.08.63.08.10	8	1.0	24.5	24.5	-	8	63	5	▲
DSMRC.5.08.63.08.5S	8	0.5	8.0	24.5	7.8	8	63	5	▲
DSMRC.5.10.77.10.10	10	1.0	30.5	30.5	-	10	77	5	▲
DSMRC.5.10.77.10.5S	10	0.5	10.0	30.5	9.8	10	77	5	▲
DSMRC.7.12.88.12.10	12	1.0	36.5	36.5	-	12	88	7	▲
DSMRC.7.12.88.12.2S	12	0.2	12.0	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	2.0	48.5	48.5	-	16	99	7	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	-
S	•
H	○

硬质合金牌号

Carbide grades

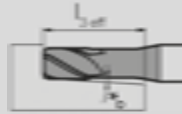
切削参数 DSMRC Ø 3.0 - 16.0 mm

Cutting Data DSTC Ø 3.0 - 16.0 mm



	 vc = m/min	 vc = m/min
S1	-	-
S2	45	60
S3	40	50

B

d ₁								
			f _z	a _e	a _p	f _z	a _e	a _p
3	3°	0.3	0.010	0.45	9.00	0.013	0.15	0.30
3	3°	0.3	0.010	0.45	3.00	0.013	0.15	0.30
4	3°	0.3	0.015	0.60	12.00	0.022	0.20	0.40
4	3°	0.3	0.015	0.60	4.00	0.022	0.20	0.40
5	3°	0.3	0.020	0.75	15.00	0.031	0.25	0.50
5	3°	0.3	0.020	0.75	5.00	0.031	0.25	0.50
6	3°	0.3	0.024	0.90	18.00	0.036	0.30	0.60
6	3°	0.3	0.024	0.90	6.00	0.036	0.30	0.60
8	3°	0.3	0.034	1.20	24.00	0.054	0.40	0.80
8	3°	0.3	0.034	1.20	8.00	0.054	0.40	0.80
10	3°	0.3	0.044	1.50	30.00	0.072	0.50	1.00
10	3°	0.3	0.044	1.50	10.00	0.072	0.50	1.00
12	3°	0.3	0.052	1.80	36.00	0.086	0.60	1.20
12	3°	0.3	0.052	1.80	12.00	0.086	0.60	1.20
16	3°	0.3	0.073	2.40	48.00	0.122	0.80	1.60
16	3°	0.3	0.073	2.40	48.00	0.122	0.80	1.60

尺寸单位 : mm
Dimensions in mm

整体硬质合金立铣刀

Solid Carbide End Mills



DSRV.4

立铣刀，刀尖为圆角
End Mill, corner radius

Ø 2,0 – Ø 20.0

Z4

B128 – B139



DSRV.5

立铣刀，刀尖为圆角
End Mill, corner radius

Ø 2,0 – Ø 20.0

Z5

B140 – B151

B

DS



B

设计用于:

- 钛合金

designed for:

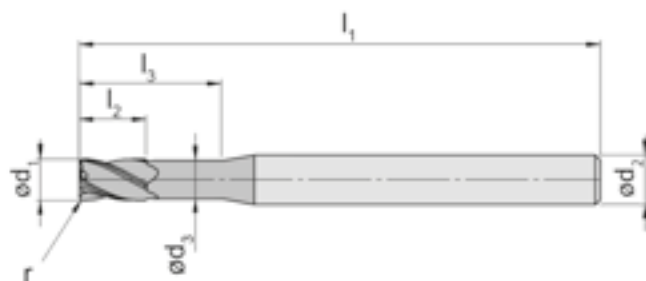
- Titanium

立铣刀, 带圆角

End Mill, corner radius



DSRV



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	形式 Form	TSTK
DSRV.4.020.010.20	2	0.1	3	4	1.90	6	50	4	40°	HA	▲
DSRV.4.020.010.30	2	0.1	5	6	1.90	6	50	4	40°	HA	▲
DSRV.4.020.020.20	2	0.2	3	4	1.90	6	50	4	40°	HA	▲
DSRV.4.020.020.30	2	0.2	5	6	1.90	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	3.80	6	50	4	40°	HA	▲
DSRV.4.040.010.30	4	0.1	9	12	3.80	6	57	4	40°	HA	▲
DSRV.4.040.020.20	4	0.2	6	8	3.80	6	50	4	40°	HA	▲
DSRV.4.040.020.30	4	0.2	9	12	3.80	6	57	4	40°	HA	▲
DSRV.4.040.050.20	4	0.5	6	8	3.80	6	50	4	40°	HA	▲
DSRV.4.040.050.30	4	0.5	9	12	3.80	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	11	15	4.75	6	57	4	40°	HA	▲
DSRV.4.050.100.20	5	1.0	8	10	4.75	6	50	4	40°	HA	▲
DSRV.4.050.100.30	5	1.0	11	15	4.75	6	57	4	40°	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

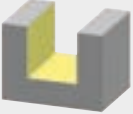
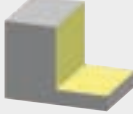
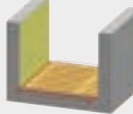
P	●
M	●
K	○
N	-
S	●
H	-

硬质合金牌号
Carbide grades

切削参数 DSRV Ø 2.0 - 5.0 mm

Cutting Data DSRV Ø 2.0 - 5.0 mm



	 vc = m/min	 vc = m/min	 vc = m/min
M1.1	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

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

尺寸单位 : mm
Dimensions in mm

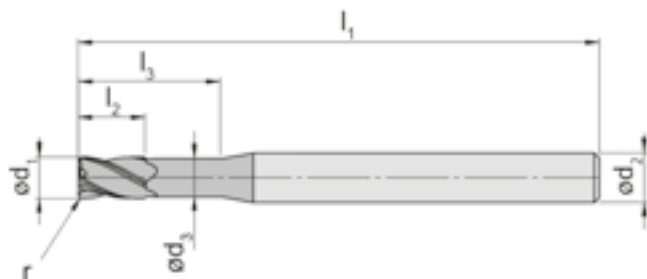
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



B

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	TSTK
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.4.060.100.30	6	1.0	13	18	5.7	6	57	4	HA	▲
DSRV.4.060.100.20	6	1.0	9	12	5.7	6	50	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	1.0	12	16	7.6	8	58	4	HA	▲
DSRV.4.080.100.30	8	1.0	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	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

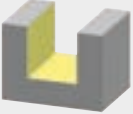
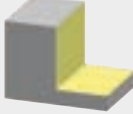
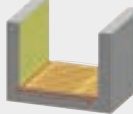
P	•
M	•
K	•
N	-
S	•
H	-

硬质合金牌号
Carbide grades

切削参数 DSRV Ø 6.0 - 8.0 mm

Cutting Data DSRV Ø 6.0 - 8.0 mm



			
	vc = m/min	vc = m/min	vc = m/min
M1.1	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

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

尺寸单位 : mm
Dimensions in mm

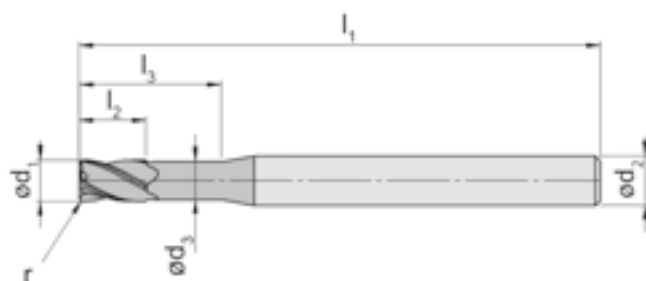
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	TSTK
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	1.0	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.100.20B	10	1.0	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.100.30	10	1.0	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.100.30B	10	1.0	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	2.0	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.200.20B	10	2.0	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.200.30	10	2.0	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.200.30B	10	2.0	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	3.0	15	20	9.5	10	66	4	HA	▲
DSRV.4.100.300.20B	10	3.0	15	20	9.5	10	66	4	HB	▲
DSRV.4.100.300.30	10	3.0	21	30	9.5	10	72	4	HA	▲
DSRV.4.100.300.30B	10	3.0	21	30	9.5	10	72	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	•
M	•
K	•
N	-
S	•
H	-

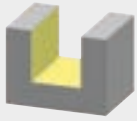
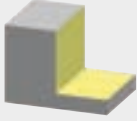
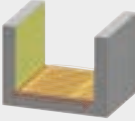
硬质合金牌号

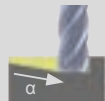
Carbide grades

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	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

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

尺寸单位 : mm
Dimensions in mm

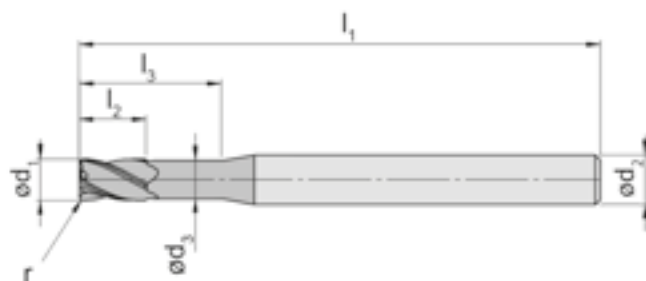
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



B

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	TSTK
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	1.0	18	24	11.4	12	73	4	HA	▲
DSRV.4.120.100.20B	12	1.0	18	24	11.4	12	73	4	HB	▲
DSRV.4.120.100.30	12	1.0	26	36	11.4	12	83	4	HA	▲
DSRV.4.120.100.30B	12	1.0	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	2.0	18	24	11.4	12	73	4	HA	▲
DSRV.4.120.200.20B	12	2.0	18	24	11.4	12	73	4	HB	▲
DSRV.4.120.200.30	12	2.0	26	36	11.4	12	83	4	HA	▲
DSRV.4.120.200.30B	12	2.0	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.4.120.300.30	12	3.0	26	36	11.4	12	83	4	HA	▲
DSRV.4.120.300.30B	12	3.0	26	36	11.4	12	83	4	HB	▲
DSRV.4.120.300.20	12	3.0	18	24	11.4	12	73	4	HA	▲
DSRV.4.120.300.20B	12	3.0	18	24	11.4	12	73	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

硬质合金牌号

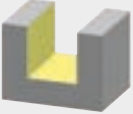
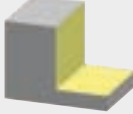
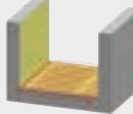
Carbide grades

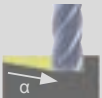
P	●
M	●
K	○
N	-
S	●
H	-

切削参数 DSRV Ø 12 mm

Cutting Data DSRV Ø 12 mm



			
	vc = m/min	vc = m/min	vc = m/min
M1.1	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

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

尺寸单位：mm
Dimensions in mm

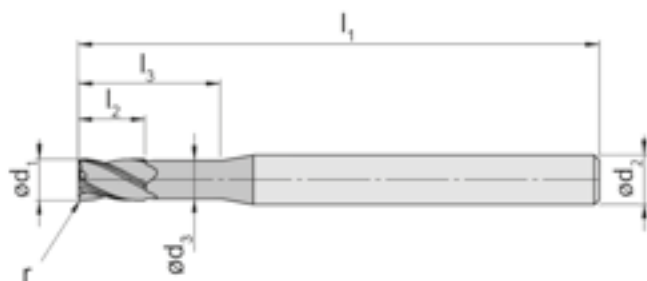
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	TSTK
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	1.0	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.100.20B	16	1.0	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.100.30	16	1.0	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.100.30B	16	1.0	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.4.160.150.30	16	1.5	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.150.20B	16	1.5	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.150.30B	16	1.5	34	48	15.2	16	100	4	HB	▲
DSRV.4.160.200.20	16	2.0	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.200.20B	16	2.0	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.200.30	16	2.0	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.200.30B	16	2.0	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	3.0	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.300.20B	16	3.0	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.300.30	16	3.0	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.300.30B	16	3.0	34	48	15.2	16	100	4	HB	▲
DSRV.4.160.400.20	16	4.0	24	32	15.2	16	82	4	HA	▲
DSRV.4.160.400.20B	16	4.0	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.400.30	16	4.0	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.400.30B	16	4.0	34	48	15.2	16	100	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	●
K	○
N	-
S	●
H	-

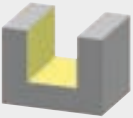
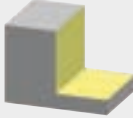
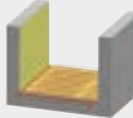
硬质合金牌号

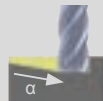
Carbide grades

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	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

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

尺寸单位 : mm
Dimensions in mm

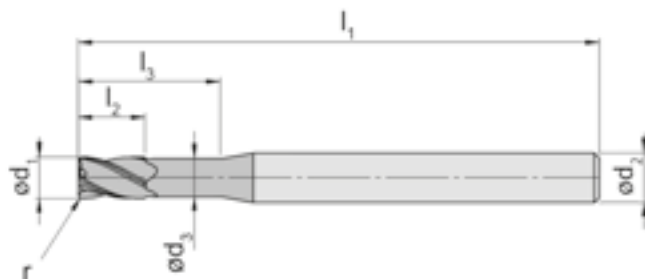
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	TSTK
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	1.0	30	40	19	20	92	4	HA	▲
DSRV.4.200.100.20B	20	1.0	30	40	19	20	92	4	HB	▲
DSRV.4.200.100.30	20	1.0	42	60	19	20	120	4	HA	▲
DSRV.4.200.100.30B	20	1.0	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	2.0	30	40	19	20	92	4	HA	▲
DSRV.4.200.200.20B	20	2.0	30	40	19	20	92	4	HB	▲
DSRV.4.200.200.30	20	2.0	42	60	19	20	120	4	HA	▲
DSRV.4.200.200.30B	20	2.0	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	3.0	30	40	19	20	92	4	HA	▲
DSRV.4.200.300.20B	20	3.0	30	40	19	20	92	4	HB	▲
DSRV.4.200.300.30	20	3.0	42	60	19	20	120	4	HA	▲
DSRV.4.200.300.30B	20	3.0	42	60	19	20	120	4	HB	▲
DSRV.4.200.400.20	20	4.0	30	40	19	20	92	4	HA	▲
DSRV.4.200.400.20B	20	4.0	30	40	19	20	92	4	HB	▲
DSRV.4.200.400.30	20	4.0	42	60	19	20	120	4	HA	▲
DSRV.4.200.400.30B	20	4.0	42	60	19	20	120	4	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

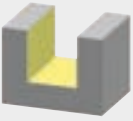
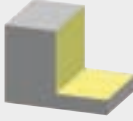
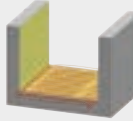
P	●
M	●
K	○
N	-
S	●
H	-

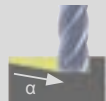
硬质合金牌号
Carbide grades

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	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

d ₁										
		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

尺寸单位 : mm
Dimensions in mm

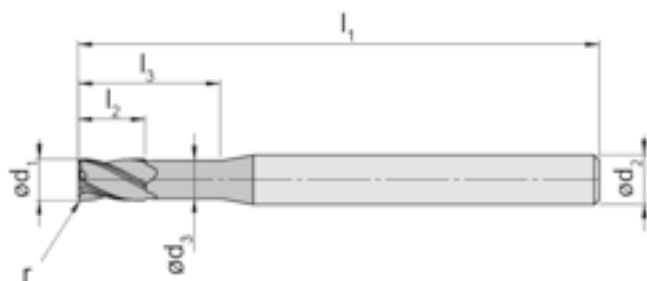
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ	形式 Form	TSTK
DSRV.5.020.010.20	2	0.1	3	4	1.90	6	50	5	40°	HA	▲
DSRV.5.020.010.30	2	0.1	5	6	1.90	6	50	5	40°	HA	▲
DSRV.5.020.020.20	2	0.2	3	4	1.90	6	50	5	40°	HA	▲
DSRV.5.020.020.30	2	0.2	5	6	1.90	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	3.80	6	50	5	40°	HA	▲
DSRV.5.040.010.30	4	0.1	9	12	3.80	6	57	5	40°	HA	▲
DSRV.5.040.020.20	4	0.2	6	8	3.80	6	50	5	40°	HA	▲
DSRV.5.040.020.30	4	0.2	9	12	3.80	6	57	5	40°	HA	▲
DSRV.5.040.050.20	4	0.5	6	8	3.80	6	50	5	40°	HA	▲
DSRV.5.040.050.30	4	0.5	9	12	3.80	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	1.0	8	10	4.75	6	50	5	40°	HA	▲
DSRV.5.050.100.30	5	1.0	11	15	4.75	6	57	5	40°	HA	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

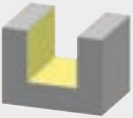
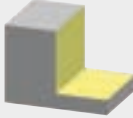
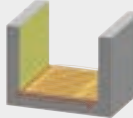
P	●
M	●
K	○
N	-
S	●
H	-

硬质合金牌号
Carbide grades

切削参数 DSRV Ø 2.0 - 4.0 mm

Cutting Data DSRV Ø 2.0 - 4.0 mm



	 vc = m/min	 vc = m/min	 vc = m/min
M1.1	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
2	3°	0.007	2.00	2.00	0.009	0.40	3.00	0.035	0.10	3.00
2	3°	0.005	2.00	2.00	0.004	0.40	4.00	0.032	0.10	4.00
2	3°	0.007	2.00	2.00	0.009	0.40	3.00	0.035	0.10	3.00
2	3°	0.005	2.00	2.00	0.004	0.40	4.00	0.032	0.10	4.00
3	3°	0.011	3.00	3.00	0.016	0.60	4.50	0.057	0.15	4.50
3	3°	0.008	3.00	3.00	0.010	0.60	6.00	0.051	0.15	6.00
3	3°	0.011	3.00	3.00	0.016	0.60	4.50	0.057	0.15	4.50
3	3°	0.008	3.00	3.00	0.010	0.60	6.00	0.051	0.15	6.00
3	3°	0.011	3.00	3.00	0.016	0.60	4.50	0.057	0.15	4.50
3	3°	0.008	3.00	3.00	0.010	0.60	6.00	0.051	0.15	6.00
4	3°	0.015	4.00	4.00	0.022	0.80	6.00	0.078	0.20	6.00
4	3°	0.012	4.00	4.00	0.016	0.80	8.00	0.070	0.20	8.00
4	3°	0.015	4.00	4.00	0.022	0.80	6.00	0.078	0.20	6.00
4	3°	0.012	4.00	4.00	0.016	0.80	8.00	0.070	0.20	8.00
4	3°	0.015	4.00	4.00	0.022	0.80	6.00	0.078	0.20	6.00
4	3°	0.012	4.00	4.00	0.016	0.80	8.00	0.070	0.20	8.00

尺寸单位 : mm
Dimensions in mm

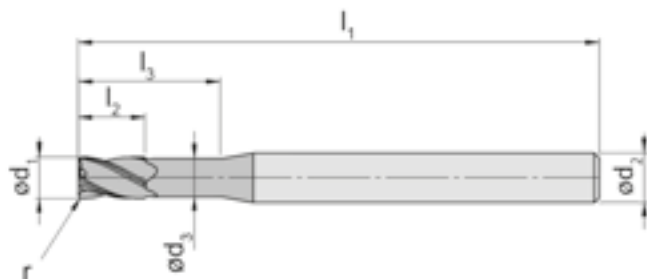
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



B

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	TSTK
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	1.0	9	12	5.7	6	50	5	HA	▲
DSRV.5.060.100.30	6	1.0	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	1.0	12	16	7.6	8	58	5	HA	▲
DSRV.5.080.100.30	8	1.0	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	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

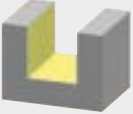
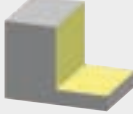
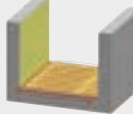
P	•
M	•
K	•
N	-
S	•
H	-

硬质合金牌号
Carbide grades

切削参数 DSRV Ø 6.0 - 8.0 mm

Cutting Data DSRV Ø 6.0 - 8.0 mm



			
	vc = m/min	vc = m/min	vc = m/min
M1.1	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
6	3°	0.023	6.00	6.00	0.035	1.20	9.00	0.121	0.30	9.00
6	3°	0.018	6.00	6.00	0.027	1.20	12.00	0.108	0.30	12.00
6	3°	0.023	6.00	6.00	0.035	1.20	9.00	0.121	0.30	9.00
6	3°	0.018	6.00	6.00	0.027	1.20	12.00	0.108	0.30	12.00
6	3°	0.023	6.00	6.00	0.035	1.20	9.00	0.121	0.30	9.00
6	3°	0.018	6.00	6.00	0.027	1.20	12.00	0.108	0.30	12.00
6	3°	0.023	6.00	6.00	0.035	1.20	9.00	0.121	0.30	9.00
6	3°	0.018	6.00	6.00	0.027	1.20	12.00	0.108	0.30	12.00
8	3°	0.031	8.00	8.00	0.047	1.60	12.00	0.163	0.40	12.00
8	3°	0.024	8.00	8.00	0.039	1.60	16.00	0.147	0.40	16.00
8	3°	0.031	8.00	8.00	0.047	1.60	12.00	0.163	0.40	12.00
8	3°	0.024	8.00	8.00	0.039	1.60	16.00	0.147	0.40	16.00
8	3°	0.031	8.00	8.00	0.047	1.60	12.00	0.163	0.40	12.00
8	3°	0.024	8.00	8.00	0.039	1.60	16.00	0.147	0.40	16.00
8	3°	0.031	8.00	8.00	0.047	1.60	12.00	0.163	0.40	12.00
8	3°	0.024	8.00	8.00	0.039	1.60	16.00	0.147	0.40	16.00
8	3°	0.031	8.00	8.00	0.047	1.60	12.00	0.163	0.40	12.00
8	3°	0.024	8.00	8.00	0.039	1.60	16.00	0.147	0.40	16.00

尺寸单位 : mm
Dimensions in mm

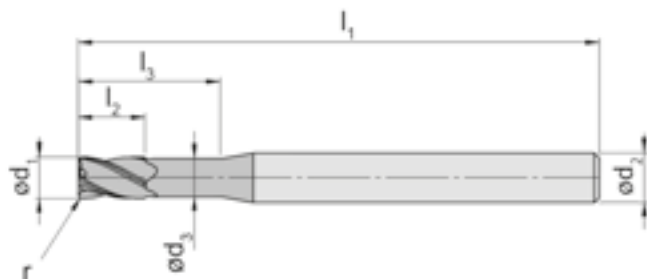
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	TSTK
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.5.100.050.30B	10	0.5	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.050.30	10	0.5	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.100.20	10	1.0	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.100.20B	10	1.0	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.100.30	10	1.0	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.100.30B	10	1.0	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	2.0	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.200.20B	10	2.0	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.200.30	10	2.0	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.200.30B	10	2.0	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	3.0	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.300.20B	10	3.0	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.300.30	10	3.0	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.300.30B	10	3.0	21	30	9.5	10	72	5	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	•
M	•
K	•
N	-
S	•
H	-

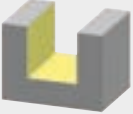
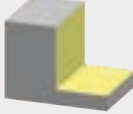
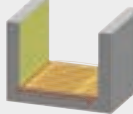
硬质合金牌号

Carbide grades

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	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
10	3°	0.039	10.00	10.00	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.038	10.00	10.00	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.032	10.00	10.00	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.031	10.00	10.00	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.039	10.00	10.00	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.038	10.00	10.00	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.032	10.00	10.00	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.031	10.00	10.00	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.039	10.00	10.00	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.038	10.00	10.00	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.032	10.00	10.00	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.031	10.00	10.00	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.039	10.00	10.00	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.038	10.00	10.00	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.032	10.00	10.00	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.031	10.00	10.00	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.039	10.00	10.00	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.038	10.00	10.00	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.032	10.00	10.00	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.031	10.00	10.00	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.039	10.00	10.00	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.038	10.00	10.00	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.032	10.00	10.00	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.031	10.00	10.00	0.050	2.00	20.00	0.185	0.50	20.00
10	3°	0.039	10.00	10.00	0.060	2.00	15.00	0.206	0.50	15.00
10	3°	0.038	10.00	10.00	0.056	2.00	15.00	0.206	0.50	15.00
10	3°	0.032	10.00	10.00	0.054	2.00	20.00	0.185	0.50	20.00
10	3°	0.031	10.00	10.00	0.050	2.00	20.00	0.185	0.50	20.00

尺寸单位 : mm

Dimensions in mm

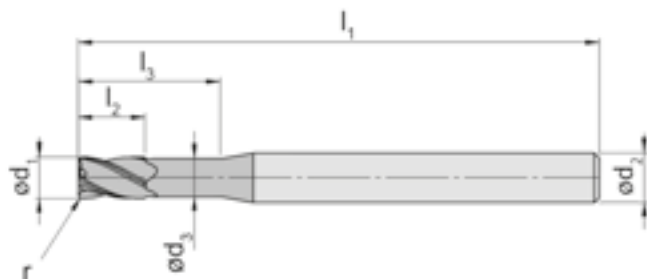
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



B

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	TSTK
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	1.0	18	24	11.4	12	73	5	HA	▲
DSRV.5.120.100.20B	12	1.0	18	24	11.4	12	73	5	HB	▲
DSRV.5.120.100.30	12	1.0	26	36	11.4	12	83	5	HA	▲
DSRV.5.120.100.30B	12	1.0	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	2.0	18	24	11.4	12	73	5	HA	▲
DSRV.5.120.200.20B	12	2.0	18	24	11.4	12	73	5	HB	▲
DSRV.5.120.200.30	12	2.0	26	36	11.4	12	83	5	HA	▲
DSRV.5.120.200.30B	12	2.0	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	3.0	18	24	11.4	12	73	5	HA	▲
DSRV.5.120.300.20B	12	3.0	18	24	11.4	12	73	5	HB	▲
DSRV.5.120.300.30	12	3.0	26	36	11.4	12	83	5	HA	▲
DSRV.5.120.300.30B	12	3.0	26	36	11.4	12	83	5	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

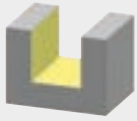
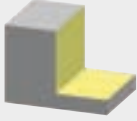
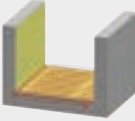
P	•
M	•
K	•
N	-
S	•
H	-

硬质合金牌号
Carbide grades

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	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
12	3°	0.047	12.00	12.00	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.046	12.00	12.00	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.038	12.00	12.00	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.037	12.00	12.00	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.047	12.00	12.00	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.046	12.00	12.00	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.038	12.00	12.00	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.037	12.00	12.00	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.047	12.00	12.00	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.046	12.00	12.00	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.038	12.00	12.00	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.037	12.00	12.00	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.047	12.00	12.00	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.046	12.00	12.00	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.038	12.00	12.00	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.037	12.00	12.00	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.047	12.00	12.00	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.046	12.00	12.00	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.038	12.00	12.00	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.037	12.00	12.00	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.047	12.00	12.00	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.046	12.00	12.00	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.038	12.00	12.00	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.037	12.00	12.00	0.062	2.40	24.00	0.223	0.60	24.00
12	3°	0.047	12.00	12.00	0.073	2.40	18.00	0.248	0.60	18.00
12	3°	0.046	12.00	12.00	0.069	2.40	18.00	0.248	0.60	18.00
12	3°	0.038	12.00	12.00	0.066	2.40	24.00	0.223	0.60	24.00
12	3°	0.037	12.00	12.00	0.062	2.40	24.00	0.223	0.60	24.00

尺寸单位：mm
Dimensions in mm

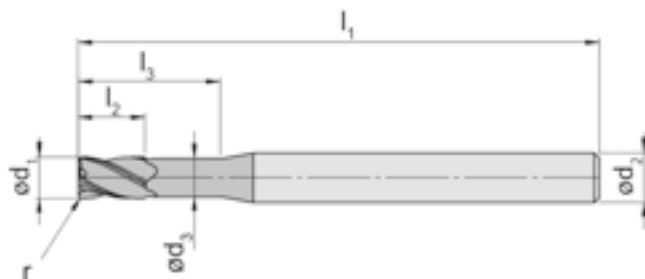
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	TSTK
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	1.0	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.100.20B	16	1.0	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.100.30	16	1.0	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.100.30B	16	1.0	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	2.0	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.200.20B	16	2.0	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.200.30B	16	2.0	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.200.30	16	2.0	34	48	15.2	16	100	5	HA	▲
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	3.0	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.300.20B	16	3.0	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.300.30	16	3.0	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.300.30B	16	3.0	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.400.20	16	4.0	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.400.20B	16	4.0	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.400.30	16	4.0	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.400.30B	16	4.0	34	48	15.2	16	100	5	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	●
K	○
N	-
S	●
H	-

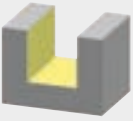
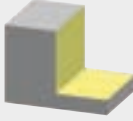
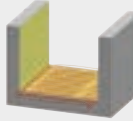
硬质合金牌号

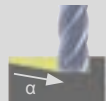
Carbide grades

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	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
16	3°	0.063	16.00	16.00	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.062	16.00	16.00	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.051	16.00	16.00	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.050	16.00	16.00	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.063	16.00	16.00	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.062	16.00	16.00	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.051	16.00	16.00	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.050	16.00	16.00	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.063	16.00	16.00	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.062	16.00	16.00	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.051	16.00	16.00	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.050	16.00	16.00	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.063	16.00	16.00	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.062	16.00	16.00	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.051	16.00	16.00	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.050	16.00	16.00	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.063	16.00	16.00	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.062	16.00	16.00	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.051	16.00	16.00	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.050	16.00	16.00	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.063	16.00	16.00	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.062	16.00	16.00	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.051	16.00	16.00	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.050	16.00	16.00	0.085	3.20	32.00	0.300	0.80	32.00
16	3°	0.063	16.00	16.00	0.099	3.20	24.00	0.333	0.80	24.00
16	3°	0.062	16.00	16.00	0.094	3.20	24.00	0.333	0.80	24.00
16	3°	0.051	16.00	16.00	0.089	3.20	32.00	0.300	0.80	32.00
16	3°	0.050	16.00	16.00	0.085	3.20	32.00	0.300	0.80	32.00

尺寸单位 : mm

Dimensions in mm

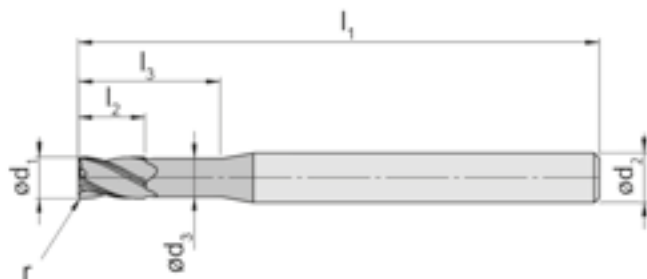
B

立铣刀, 带圆角

End Mill, corner radius



DSRV



产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	形式 Form	TSTK
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	1.0	30	40	19	20	92	5	HA	▲
DSRV.5.200.100.20B	20	1.0	30	40	19	20	92	5	HB	▲
DSRV.5.200.100.30	20	1.0	42	60	19	20	120	5	HA	▲
DSRV.5.200.100.30B	20	1.0	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	2.0	30	40	19	20	92	5	HA	▲
DSRV.5.200.200.20B	20	2.0	30	40	19	20	92	5	HB	▲
DSRV.5.200.200.30	20	2.0	42	60	19	20	120	5	HA	▲
DSRV.5.200.200.30B	20	2.0	42	60	19	20	120	5	HB	▲
DSRV.5.200.250.20B	20	2.5	30	40	19	20	92	5	HB	▲
DSRV.5.200.250.20	20	2.5	30	40	19	20	92	5	HA	▲
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	3.0	30	40	19	20	92	5	HA	▲
DSRV.5.200.300.20B	20	3.0	30	40	19	20	92	5	HB	▲
DSRV.5.200.300.30	20	3.0	42	60	19	20	120	5	HA	▲
DSRV.5.200.300.30B	20	3.0	42	60	19	20	120	5	HB	▲
DSRV.5.200.400.20	20	4.0	30	40	19	20	92	5	HA	▲
DSRV.5.200.400.20B	20	4.0	30	40	19	20	92	5	HB	▲
DSRV.5.200.400.30	20	4.0	42	60	19	20	120	5	HA	▲
DSRV.5.200.400.30B	20	4.0	42	60	19	20	120	5	HB	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

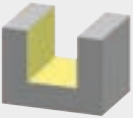
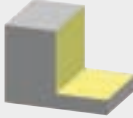
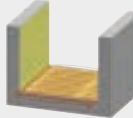
P	●
M	●
K	○
N	-
S	●
H	-

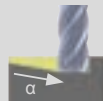
硬质合金牌号
Carbide grades

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	100	130	190
M2.1	80	100	150
M3.1	70	90	130
S1.1	60	80	120
S2.1	40	50	70
S3.1	33	40	60

d ₁										
		f _z	a _e	a _p	f _z	a _e	a _p	f _z	a _e	a _p
20	3°	0.079	20.00	20.00	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.078	20.00	20.00	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.064	20.00	20.00	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.063	20.00	20.00	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.079	20.00	20.00	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.078	20.00	20.00	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.064	20.00	20.00	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.063	20.00	20.00	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.079	20.00	20.00	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.078	20.00	20.00	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.064	20.00	20.00	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.063	20.00	20.00	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.079	20.00	20.00	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.078	20.00	20.00	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.064	20.00	20.00	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.063	20.00	20.00	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.079	20.00	20.00	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.078	20.00	20.00	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.064	20.00	20.00	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.063	20.00	20.00	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.079	20.00	20.00	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.078	20.00	20.00	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.064	20.00	20.00	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.063	20.00	20.00	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.079	20.00	20.00	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.078	20.00	20.00	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.064	20.00	20.00	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.063	20.00	20.00	0.108	4.00	40.00	0.377	1.00	40.00
20	3°	0.079	20.00	20.00	0.124	4.00	30.00	0.419	1.00	30.00
20	3°	0.078	20.00	20.00	0.120	4.00	30.00	0.419	1.00	30.00
20	3°	0.064	20.00	20.00	0.112	4.00	40.00	0.377	1.00	40.00
20	3°	0.063	20.00	20.00	0.108	4.00	40.00	0.377	1.00	40.00

尺寸单位 : mm
Dimensions in mm

B

整体硬质合金立铣刀

Solid Carbide End Mills



B

	DSKMA	圆头微型立铣刀 Ball Nose End Mill Micro	Ø 0.1 – Ø 3,0	Z 2	B154 – B157
	DSMA	微型立铣刀，锋利 End Mill Micro, sharp	Ø 0.1 – Ø 3,0	Z 2	B158 – B161
	DSTMA	圆角微型立铣刀 Torus End Mill Micro	Ø 0.1 – Ø 3,0	Z 2	B162 – B167
	DSA.1	单刃立铣刀 End Mill single luted	Ø 0.3 – Ø 20.0	Z 1	B168 – B171
	DSKA	圆头立铣刀 Ball Nose End Mill	Ø 4.0 – Ø 20.0	Z 2	B172 – B173
	DSA.3	立铣刀，锋利 End Mill, sharp	Ø 4.0 – Ø 20.0	Z 3	B174 – B175
	DSRA.3	立铣刀，刀尖为圆角 End Mill, Corner Radius	Ø 4.0 – Ø 20.0	Z 3	B176 – B183
	DSFA.3	HPC立铣刀，倒角 End Mill HPC, chamfer	Ø 6.0 – Ø 20.0	Z 3	B184 – B185
	DSFRA.3	锯齿状立铣刀 Roughing End Mill with ripper profile	Ø 6.0 – Ø 20.0	Z 3	B186 – B187

DS



B

设计用于:

- 铝合金
- 合成纤维材料

designed for:

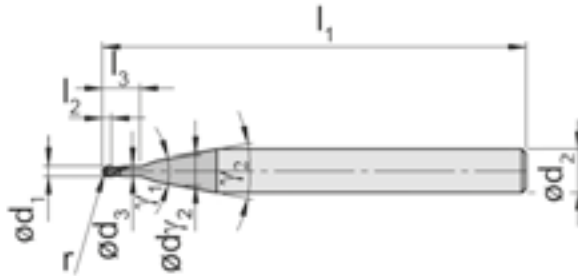
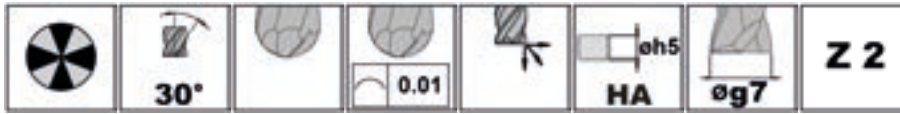
- Aluminium
- Synthetics

球头微型立铣刀

Ball Nose End Mill Micro



DSKMA



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.010.030	0.1	0.05	0.25	0.3	0.084	4	50	2	20°	-°	▲
DSKMA.010.050	0.1	0.05	0.25	0.5	0.084	4	50	2	40°	20°	▲
DSKMA.010.070	0.1	0.05	0.25	0.7	0.084	4	50	2	40°	20°	▲
DSKMA.020.030	0.2	0.10	0.50	0.6	0.180	4	50	2	20°	-°	▲
DSKMA.020.050	0.2	0.10	0.50	1.0	0.180	4	50	2	40°	20°	▲
DSKMA.020.070	0.2	0.10	0.50	1.4	0.180	4	50	2	40°	20°	▲
DSKMA.030.030	0.3	0.15	0.75	0.9	0.280	4	50	2	20°	-°	▲
DSKMA.030.050	0.3	0.15	0.75	1.5	0.280	4	50	2	40°	20°	▲
DSKMA.030.070	0.3	0.15	0.75	2.1	0.280	4	50	2	40°	20°	▲
DSKMA.050.030	0.5	0.25	1.25	1.5	0.470	4	50	2	20°	-°	▲
DSKMA.050.050	0.5	0.25	1.25	2.5	0.470	4	50	2	40°	20°	▲
DSKMA.050.070	0.5	0.25	1.25	3.5	0.470	4	50	2	40°	20°	▲
DSKMA.060.030	0.6	0.30	1.50	1.8	0.560	4	50	2	20°	-°	▲
DSKMA.060.050	0.6	0.30	1.50	3.0	0.560	4	50	2	40°	20°	▲
DSKMA.060.070	0.6	0.30	1.50	4.2	0.560	4	50	2	40°	20°	▲
DSKMA.080.030	0.8	0.40	2.00	2.4	0.750	4	50	2	20°	-°	▲
DSKMA.080.050	0.8	0.40	2.00	4.0	0.750	4	50	2	40°	20°	▲
DSKMA.080.070	0.8	0.40	2.00	5.6	0.750	4	50	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

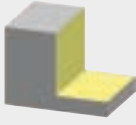
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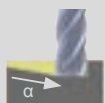
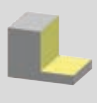
硬质合金牌号
Carbide grades

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	460	550
N1.2	480	580
N2.1	460	550
N2.2	390	470
N2.3	260	310
N3.1	330	400
N3.2	290	350
N4.1	330	400

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	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

尺寸单位 : mm
Dimensions in mm

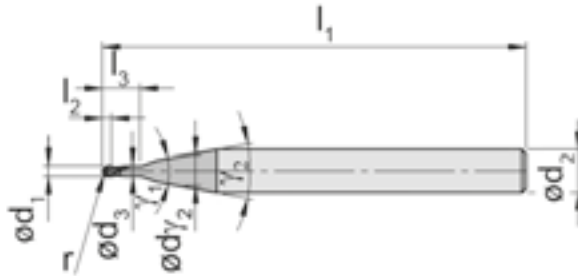
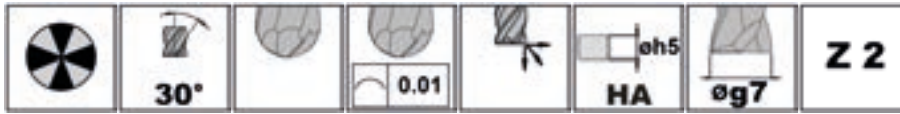
B

球头微型立铣刀

Ball Nose End Mill Micro



DSKMA



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	0.50	2.50	3.0	0.95	4	50	2	20°	-°	▲
DSKMA.100.050	1.0	0.50	2.50	5.0	0.95	4	50	2	40°	20°	▲
DSKMA.100.070	1.0	0.50	2.50	7.0	0.95	4	50	2	40°	20°	▲
DSKMA.120.030	1.2	0.60	3.00	3.6	1.15	4	50	2	20°	-°	▲
DSKMA.120.050	1.2	0.60	3.00	6.0	1.15	4	50	2	40°	20°	▲
DSKMA.120.070	1.2	0.60	3.00	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	2.0	1.00	5.00	6.0	1.90	4	50	2	20°	-°	▲
DSKMA.200.050	2.0	1.00	5.00	10.0	1.90	4	50	2	40°	20°	▲
DSKMA.200.070	2.0	1.00	5.00	14.0	1.90	4	50	2	40°	20°	▲
DSKMA.250.030	2.5	1.25	6.25	7.5	2.40	4	50	2	20°	-°	▲
DSKMA.250.050	2.5	1.25	6.25	12.5	2.40	4	50	2	40°	20°	▲
DSKMA.250.070	2.5	1.25	6.25	17.5	2.40	4	50	2	40°	20°	▲
DSKMA.300.030	3.0	1.50	7.50	9.0	2.90	4	50	2	20°	-°	▲
DSKMA.300.050	3.0	1.50	7.50	15.0	2.90	4	50	2	40°	20°	▲
DSKMA.300.070	3.0	1.50	7.50	21.0	2.90	4	64	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

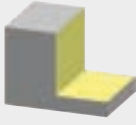
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M	-
K	-
N	•
S	-
H	-

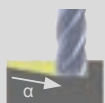
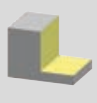
硬质合金牌号
Carbide grades

切削参数 DSKMA Ø 1.0 - 3.0 mm

Cutting Data DSKMA Ø 1.0 - 3.0 mm



		
	vc = m/min	vc = m/min
N1.1	460	550
N1.2	480	580
N2.1	460	550
N2.2	390	470
N2.3	260	310
N3.1	330	400
N3.2	290	350
N4.1	330	400

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

尺寸单位 : mm
Dimensions in mm

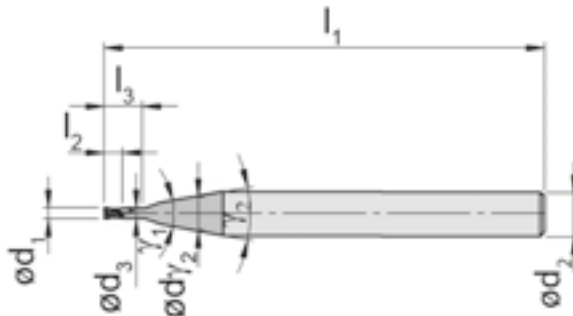
B

微型立铣刀，锋利

End Mill Micro, sharp



DSMA



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

B

产品型号 Part number	d ₁	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ1	γ2	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	0.50	0.6	0.180	4	50	2	20°	-°	▲
DSMA.020.050	0.2	0.50	1.0	0.180	4	50	2	40°	20°	▲
DSMA.020.070	0.2	0.50	1.4	0.180	4	50	2	40°	20°	▲
DSMA.030.030	0.3	0.75	0.9	0.280	4	50	2	20°	-°	▲
DSMA.030.050	0.3	0.75	1.5	0.280	4	50	2	40°	20°	▲
DSMA.030.070	0.3	0.75	2.1	0.280	4	50	2	40°	20°	▲
DSMA.050.030	0.5	1.25	1.5	0.470	4	50	2	20°	-°	▲
DSMA.050.050	0.5	1.25	2.5	0.470	4	50	2	40°	20°	▲
DSMA.050.070	0.5	1.25	3.5	0.470	4	50	2	40°	20°	▲
DSMA.060.030	0.6	1.50	1.8	0.560	4	50	2	20°	-°	▲
DSMA.060.050	0.6	1.50	3.0	0.560	4	50	2	40°	20°	▲
DSMA.060.070	0.6	1.50	4.2	0.560	4	50	2	40°	20°	▲
DSMA.080.030	0.8	2.00	2.4	0.750	4	50	2	20°	-°	▲
DSMA.080.050	0.8	2.00	4.0	0.750	4	50	2	40°	20°	▲
DSMA.080.070	0.8	2.00	5.6	0.750	4	50	2	40°	20°	▲
DSMA.100.030	1.0	2.50	3.0	0.950	4	50	2	20°	-°	▲
DSMA.100.050	1.0	2.50	5.0	0.950	4	50	2	40°	20°	▲
DSMA.100.070	1.0	2.50	7.0	0.950	4	50	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm

Dimensions in mm

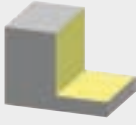
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M	-
K	-
N	•
S	-
H	-

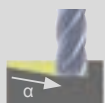
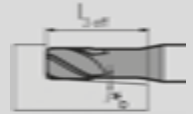
硬质合金牌号
Carbide grades

切削参数 DSMA Ø 0.1 - 1.0 mm

Cutting Data DSMA Ø 0.1 - 1.0 mm



		
	vc = m/min	vc = m/min
N1.1	460	550
N1.2	480	580
N2.1	460	550
N2.2	390	470
N2.3	260	310
N3.1	330	400
N3.2	290	350
N4.1	330	400

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

尺寸单位 : mm

Dimensions in mm

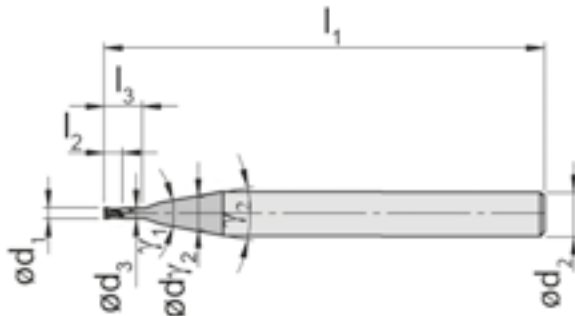
B

微型立铣刀，锋利

End Mill Micro, sharp



DSMA



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

B

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	3.00	3.6	1.15	4	50	2	20°	-°	▲
DSMA.120.050	1.2	3.00	6.0	1.15	4	50	2	40°	20°	▲
DSMA.120.070	1.2	3.00	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	2.0	5.00	6.0	1.90	4	50	2	20°	-°	▲
DSMA.200.050	2.0	5.00	10.0	1.90	4	50	2	40°	20°	▲
DSMA.200.070	2.0	5.00	14.0	1.90	4	50	2	40°	20°	▲
DSMA.250.030	2.5	6.25	7.5	2.40	4	50	2	20°	-°	▲
DSMA.250.050	2.5	6.25	12.5	2.40	4	50	2	40°	20°	▲
DSMA.250.070	2.5	6.25	17.5	2.40	4	50	2	40°	20°	▲
DSMA.300.030	3.0	7.50	9.0	2.90	4	50	2	20°	-°	▲
DSMA.300.050	3.0	7.50	15.0	2.90	4	50	2	40°	20°	▲
DSMA.300.070	3.0	7.50	21.0	2.90	4	64	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm

Dimensions in mm

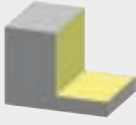
P	-
M	-
K	-
N	•
S	-
H	-

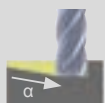
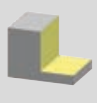
硬质合金牌号
Carbide grades

切削参数 DSMA Ø 1.2 - 3.0 mm

Cutting Data DSMA Ø 1.2 - 3.0 mm



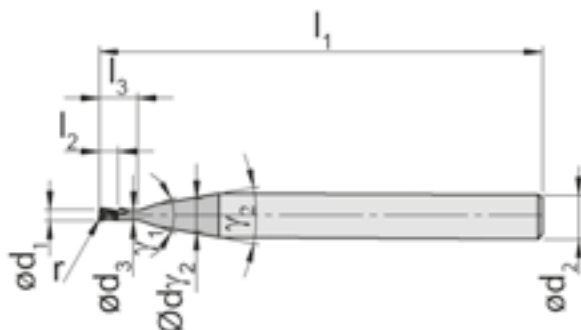
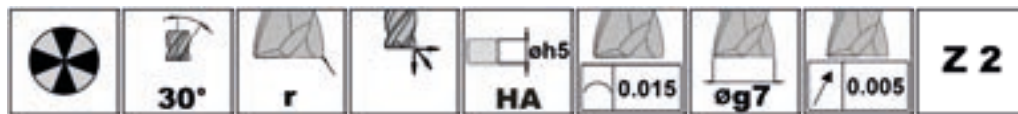
		
	vc = m/min	vc = m/min
N1.1	460	550
N1.2	480	580
N2.1	460	550
N2.2	390	470
N2.3	260	310
N3.1	330	400
N3.2	290	350
N4.1	330	400

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

尺寸单位 : mm
Dimensions in mm

B

DSTMA



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ1	γ2	MG3K
DSTMA.010.003.030	0.1	0.03	0.25	0.3	0.084	4	50	2	20°	-°	▲
DSTMA.010.003.050	0.1	0.03	0.25	0.5	0.084	4	50	2	40°	20°	▲
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	0.50	0.6	0.180	4	50	2	20°	-°	▲
DSTMA.020.005.050	0.2	0.05	0.50	1.0	0.180	4	50	2	40°	20°	▲
DSTMA.020.005.070	0.2	0.05	0.50	1.4	0.180	4	50	2	40°	20°	▲
DSTMA.030.005.030	0.3	0.05	0.75	0.9	0.280	4	50	2	20°	-°	▲
DSTMA.030.005.050	0.3	0.05	0.75	1.5	0.280	4	50	2	40°	20°	▲
DSTMA.030.005.070	0.3	0.05	0.75	2.1	0.280	4	50	2	40°	20°	▲
DSTMA.050.005.030	0.5	0.05	1.25	1.5	0.470	4	50	2	20°	-°	▲
DSTMA.050.005.050	0.5	0.05	1.25	2.5	0.470	4	50	2	40°	20°	▲
DSTMA.050.005.070	0.5	0.05	1.25	3.5	0.470	4	50	2	40°	20°	▲
DSTMA.050.010.030	0.5	0.10	1.25	1.5	0.470	4	50	2	20°	-°	▲
DSTMA.050.010.050	0.5	0.10	1.25	2.5	0.470	4	50	2	40°	20°	▲
DSTMA.050.010.070	0.5	0.10	1.25	3.5	0.470	4	50	2	40°	20°	▲
DSTMA.060.005.030	0.6	0.05	1.50	1.8	0.560	4	50	2	20°	-°	▲
DSTMA.060.005.050	0.6	0.05	1.50	3.0	0.560	4	50	2	40°	20°	▲
DSTMA.060.005.070	0.6	0.05	1.50	4.2	0.560	4	50	2	40°	20°	▲
DSTMA.060.010.030	0.6	0.10	1.50	1.8	0.560	4	50	2	20°	-°	▲
DSTMA.060.010.050	0.6	0.10	1.50	3.0	0.560	4	50	2	40°	20°	▲
DSTMA.060.010.070	0.6	0.10	1.50	4.2	0.560	4	50	2	40°	20°	▲
DSTMA.080.005.030	0.8	0.05	2.00	2.4	0.750	4	50	2	20°	-°	▲
DSTMA.080.005.050	0.8	0.05	2.00	4.0	0.750	4	50	2	40°	20°	▲
DSTMA.080.005.070	0.8	0.05	2.00	5.6	0.750	4	50	2	40°	20°	▲
DSTMA.080.010.030	0.8	0.10	2.00	2.4	0.750	4	50	2	20°	-°	▲
DSTMA.080.010.050	0.8	0.10	2.00	4.0	0.750	4	50	2	40°	20°	▲
DSTMA.080.010.070	0.8	0.10	2.00	5.6	0.750	4	50	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

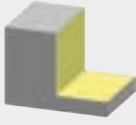
P	-
M	-
K	-
N	•
S	-
H	-

硬质合金牌号
Carbide grades

切削参数 DSTMA Ø 0.1 - 0.8 mm

Cutting Data DSTMA Ø 0.1 - 0.8 mm



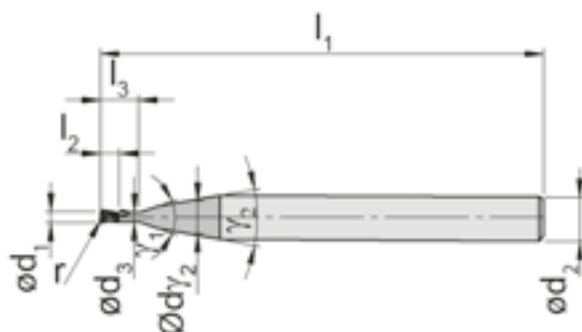
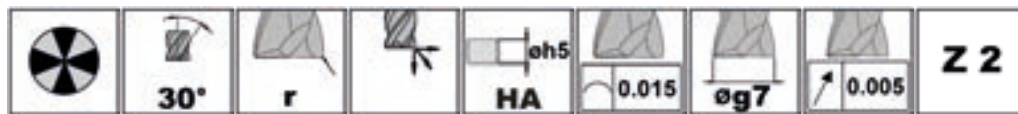
		
	vc = m/min	vc = m/min
N1.1	460	550
N1.2	480	580
N2.1	460	550
N2.2	390	470
N2.3	260	310
N3.1	330	400
N3.2	290	350
N4.1	330	400

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	0.8	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	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	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	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	2.9	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	1.9	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	4.2	4.4	4.6	4.9	0.008	0.18	0.60	0.011	0.03	0.04
0.6	7°	1.8	1.8	1.9	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	3.4	0.009	0.18	0.60	0.012	0.03	0.05
0.6	3°	4.2	4.2	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	3.3	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	3°	5.6	5.7	5.8	6.1	6.5	0.009	0.24	0.80	0.013	0.04	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	3°	5.6	5.7	5.8	6.1	6.5	0.009	0.24	0.80	0.013	0.04	0.05

尺寸单位 : mm
Dimensions in mm

B

DSTMA



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

产品型号 Part number	d ₁	r	l ₂	l ₃	d ₃	d ₂	l ₁	Z	γ1	γ2	MG3K
DSTMA.100.005.030	1.0	0.05	2.50	3.0	0.95	4	50	2	20°	-°	▲
DSTMA.100.005.050	1.0	0.05	2.50	5.0	0.95	4	50	2	40°	20°	▲
DSTMA.100.005.070	1.0	0.05	2.50	7.0	0.95	4	50	2	40°	20°	▲
DSTMA.100.010.030	1.0	0.10	2.50	3.0	0.95	4	50	2	20°	-°	▲
DSTMA.100.010.050	1.0	0.10	2.50	5.0	0.95	4	50	2	40°	20°	▲
DSTMA.100.010.070	1.0	0.10	2.50	7.0	0.95	4	50	2	40°	20°	▲
DSTMA.120.005.030	1.2	0.05	3.00	3.6	1.15	4	50	2	20°	-°	▲
DSTMA.120.005.050	1.2	0.05	3.00	6.0	1.15	4	50	2	40°	20°	▲
DSTMA.120.005.070	1.2	0.05	3.00	8.4	1.15	4	50	2	40°	20°	▲
DSTMA.120.010.030	1.2	0.10	3.00	3.6	1.15	4	50	2	20°	-°	▲
DSTMA.120.010.050	1.2	0.10	3.00	6.0	1.15	4	50	2	40°	20°	▲
DSTMA.120.010.070	1.2	0.10	3.00	8.4	1.15	4	50	2	40°	20°	▲
DSTMA.150.010.030	1.5	0.10	3.75	4.5	1.45	4	50	2	20°	-°	▲
DSTMA.150.010.050	1.5	0.10	3.75	7.5	1.45	4	50	2	40°	20°	▲
DSTMA.150.010.070	1.5	0.10	3.75	10.5	1.45	4	50	2	40°	20°	▲
DSTMA.150.020.030	1.5	0.20	3.75	4.5	1.45	4	50	2	20°	-°	▲
DSTMA.150.020.050	1.5	0.20	3.75	7.5	1.45	4	50	2	40°	20°	▲
DSTMA.150.020.070	1.5	0.20	3.75	10.5	1.45	4	50	2	40°	20°	▲
DSTMA.150.050.030	1.5	0.50	3.75	4.5	1.45	4	50	2	20°	-°	▲
DSTMA.150.050.050	1.5	0.50	3.75	7.5	1.45	4	50	2	40°	20°	▲
DSTMA.150.050.070	1.5	0.50	3.75	10.5	1.45	4	50	2	40°	20°	▲
DSTMA.200.010.030	2.0	0.10	5.00	6.0	1.90	4	50	2	20°	-°	▲
DSTMA.200.010.050	2.0	0.10	5.00	10.0	1.90	4	50	2	40°	20°	▲
DSTMA.200.010.070	2.0	0.10	5.00	14.0	1.90	4	50	2	40°	20°	▲
DSTMA.200.020.030	2.0	0.20	5.00	6.0	1.90	4	50	2	20°	-°	▲
DSTMA.200.020.050	2.0	0.20	5.00	10.0	1.90	4	50	2	40°	20°	▲
DSTMA.200.020.070	2.0	0.20	5.00	14.0	1.90	4	50	2	40°	20°	▲
DSTMA.200.050.030	2.0	0.50	5.00	6.0	1.90	4	50	2	20°	-°	▲
DSTMA.200.050.050	2.0	0.50	5.00	10.0	1.90	4	50	2	40°	20°	▲
DSTMA.200.050.070	2.0	0.50	5.00	14.0	1.90	4	50	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

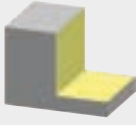
Dimensions in mm

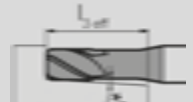
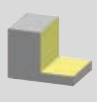
P	-
M	-
K	-
N	•
S	-
H	-

切削参数 DSTMA Ø 1.0 - 2.0 mm

Cutting Data DSTMA Ø 1.0 - 2.0 mm



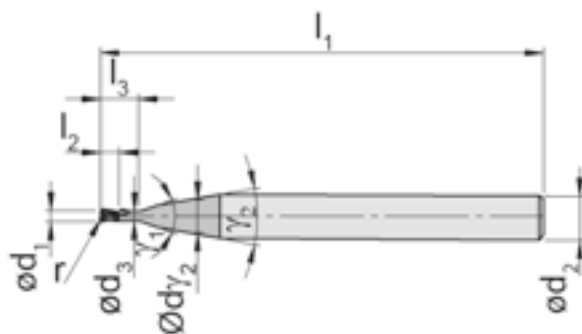
		
	vc = m/min	vc = m/min
N1.1	460	550
N1.2	480	580
N2.1	460	550
N2.2	390	470
N2.3	260	310
N3.1	330	400
N3.2	290	350
N4.1	330	400

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	3°	7.0	7.1	7.3	7.7	8.1	0.011	0.30	1.00	0.015	0.05	0.06
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	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
1.2	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

尺寸单位 : mm
Dimensions in mm

B

DSTMA



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	0.1	7.50	9.0	2.9	4	50	2	20°	-°	▲
DSTMA.300.010.050	3.0	0.1	7.50	15.0	2.9	4	50	2	40°	20°	▲
DSTMA.300.010.070	3.0	0.1	7.50	21.0	2.9	4	64	2	40°	20°	▲
DSTMA.300.020.030	3.0	0.2	7.50	9.0	2.9	4	50	2	20°	-°	▲
DSTMA.300.020.050	3.0	0.2	7.50	15.0	2.9	4	50	2	40°	20°	▲
DSTMA.300.020.070	3.0	0.2	7.50	21.0	2.9	4	64	2	40°	20°	▲
DSTMA.300.050.030	3.0	0.5	7.50	9.0	2.9	4	50	2	20°	-°	▲
DSTMA.300.050.050	3.0	0.5	7.50	15.0	2.9	4	50	2	40°	20°	▲
DSTMA.300.050.070	3.0	0.5	7.50	21.0	2.9	4	64	2	40°	20°	▲
DSTMA.300.100.030	3.0	1.0	7.50	9.0	2.9	4	50	2	20°	-°	▲
DSTMA.300.100.050	3.0	1.0	7.50	15.0	2.9	4	50	2	40°	20°	▲
DSTMA.300.100.070	3.0	1.0	7.50	21.0	2.9	4	64	2	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

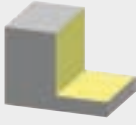
P	-
M	-
K	-
N	•
S	-
H	-

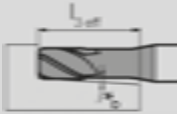
硬质合金牌号
Carbide grades

切削参数 DSTMA Ø 2.5 - 3.0 mm

Cutting Data DSTMA Ø 2.5 - 3.0 mm



		
	vc = m/min	vc = m/min
N1.1	460	550
N1.2	480	580
N2.1	460	550
N2.2	390	470
N2.3	260	310
N3.1	330	400
N3.2	290	350
N4.1	330	400

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	9.8	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

尺寸单位 : mm

Dimensions in mm

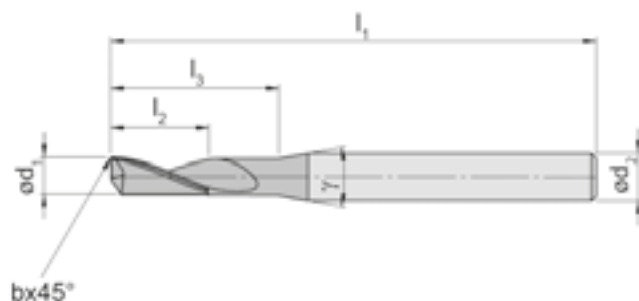
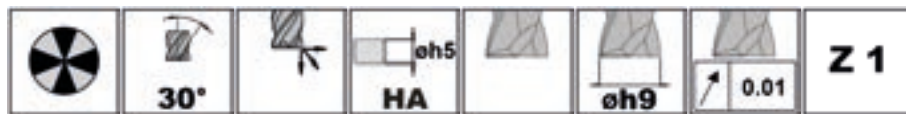
B

单刃立铣刀

End Mill single fluted



DSA



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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.1.003.030	0.3	0.75	0.90	0.28	4	50	1	20°	-°	▲
DSA.1.003.050	0.3	1.05	1.50	0.28	4	50	1	40°	20°	▲
DSA.1.003.053	0.3	1.50	1.59	0.28	4	50	1	40°	20°	▲
DSA.1.004.030	0.4	1.00	1.20	0.38	4	50	1	20°	-°	▲
DSA.1.004.050	0.4	1.40	2.00	0.38	4	50	1	40°	20°	▲
DSA.1.004.053	0.4	2.00	2.12	0.38	4	50	1	40°	20°	▲
DSA.1.005.030	0.5	1.25	1.50	0.47	4	50	1	20°	-°	▲
DSA.1.005.050	0.5	1.75	2.50	0.47	4	50	1	40°	20°	▲
DSA.1.005.053	0.5	2.50	2.65	0.47	4	50	1	40°	20°	▲
DSA.1.006.030	0.6	1.50	1.80	0.56	4	50	1	20°	-°	▲
DSA.1.006.050	0.6	2.10	3.00	0.56	4	50	1	40°	20°	▲
DSA.1.006.053	0.6	3.00	3.18	0.56	4	50	1	40°	20°	▲
DSA.1.008.030	0.8	2.00	2.40	0.75	4	50	1	20°	-°	▲
DSA.1.008.050	0.8	2.80	4.00	0.75	4	50	1	40°	20°	▲
DSA.1.008.053	0.8	4.00	4.24	0.75	4	50	1	40°	20°	▲
DSA.1.010.030	1.0	2.50	3.00	0.95	4	50	1	20°	-°	▲
DSA.1.010.050	1.0	3.50	5.00	0.95	4	50	1	40°	20°	▲
DSA.1.010.053	1.0	5.00	5.30	0.95	4	50	1	40°	20°	▲
DSA.1.012.030	1.2	3.00	3.60	1.15	4	50	1	20°	-°	▲
DSA.1.012.050	1.2	4.20	6.00	1.15	4	50	1	40°	20°	▲
DSA.1.012.053	1.2	6.00	6.36	1.15	4	50	1	40°	20°	▲
DSA.1.015.030	1.5	3.75	4.50	1.45	4	50	1	20°	-°	▲
DSA.1.015.050	1.5	5.25	7.50	1.45	4	50	1	40°	20°	▲
DSA.1.015.053	1.5	7.50	7.95	1.45	4	50	1	40°	20°	▲
DSA.1.018.030	1.8	4.50	5.40	1.75	4	50	1	20°	-°	▲
DSA.1.018.050	1.8	6.30	9.00	1.75	4	50	1	40°	20°	▲
DSA.1.018.053	1.8	9.00	9.54	1.75	4	50	1	40°	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

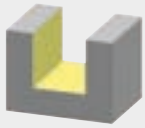
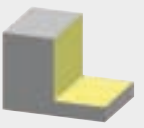
P	-
M	-
K	-
N	•
S	-
H	-

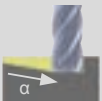
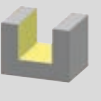
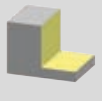
硬质合金牌号
Carbide grades

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	390
N1.2	320	420
N2.1	300	390
N2.2	250	330
N2.3	180	230
N3.1	200	260
N3.2	180	230
N4.1	200	260

d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
0.3	7°	0.022	0.30	0.45	0.045	0.08	0.75
0.3	5°	0.016	0.30	0.45	0.031	0.08	0.75
0.3	3°	0.016	0.30	0.45	0.031	0.08	1.50
0.4	7°	0.022	0.40	0.60	0.045	0.10	1.00
0.4	5°	0.016	0.40	0.60	0.031	0.10	1.00
0.4	3°	0.016	0.40	0.60	0.031	0.10	2.00
0.5	7°	0.023	0.50	0.75	0.045	0.13	1.25
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	7°	0.023	0.60	0.90	0.045	0.15	1.50
0.6	5°	0.016	0.60	0.90	0.032	0.15	1.50
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	5°	0.016	0.80	1.20	0.032	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

尺寸单位：mm

Dimensions in mm

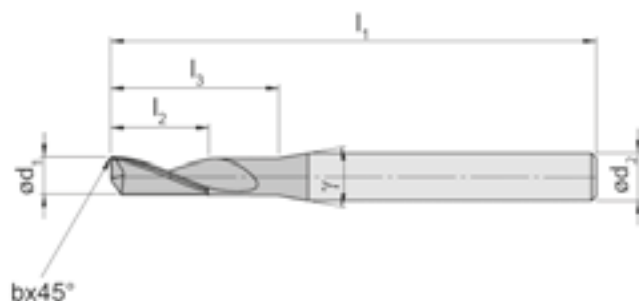
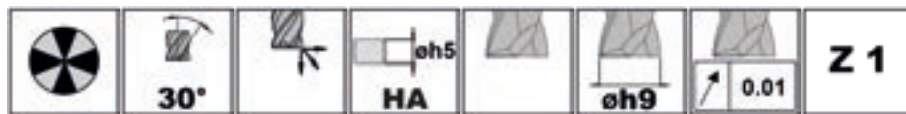
B

单刃立铣刀

End Mill single fluted



DSA



用于高速轴预安装立铣刀直径可达Ø 3 mm (见D2)

Pre-assembled available up to Ø 3 mm for Toodle high-speed spindle (see page D2)

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	2.0	-	5.00	6.00	1.9	4	50	1	20°	-°	▲
DSA.1.020.050	2.0	-	7.00	10.00	1.9	4	50	1	40°	20°	▲
DSA.1.020.053	2.0	-	10.00	10.60	1.9	4	50	1	40°	20°	▲
DSA.1.025.030	2.5	-	6.25	7.50	2.4	4	50	1	20°	-°	▲
DSA.1.025.050	2.5	-	8.75	12.50	2.4	4	50	1	40°	20°	▲
DSA.1.025.053	2.5	-	12.50	13.25	2.4	4	64	1	40°	20°	▲
DSA.1.030.030	3.0	0.1	7.50	9.00	2.9	4	50	1	20°	-°	▲
DSA.1.030.050	3.0	0.1	10.50	15.00	2.9	4	64	1	40°	20°	▲
DSA.1.030.053	3.0	0.1	15.00	15.90	2.9	4	64	1	40°	20°	▲
DSA.1.040.030	4.0	0.1	10.00	12.00	3.8	6	54	1	20°	-°	▲
DSA.1.040.050	4.0	0.1	14.00	20.00	3.8	6	64	1	20°	-°	▲
DSA.1.040.053	4.0	0.1	20.00	21.20	3.8	6	64	1	20°	-°	▲
DSA.1.050.030	5.0	0.1	12.50	15.00	4.7	6	64	1	20°	-°	▲
DSA.1.050.050	5.0	0.1	17.50	25.00	4.7	6	64	1	20°	-°	▲
DSA.1.050.053	5.0	0.1	25.00	26.50	4.7	6	64	1	20°	-°	▲
DSA.1.060.030	6.0	0.2	15.00	18.00	5.6	6	64	1	-°	-°	▲
DSA.1.060.050	6.0	0.2	21.00	30.00	5.6	6	82	1	-°	-°	▲
DSA.1.060.053	6.0	0.2	30.00	31.80	5.6	6	82	1	-°	-°	▲
DSA.1.080.030	8.0	0.2	20.00	24.00	7.5	8	64	1	-°	-°	▲
DSA.1.080.050	8.0	0.2	28.00	40.00	7.5	8	82	1	-°	-°	▲
DSA.1.080.053	8.0	0.2	40.00	42.40	7.5	8	82	1	-°	-°	▲
DSA.1.100.030	10.0	0.2	25.00	30.00	9.5	10	82	1	-°	-°	▲
DSA.1.100.050	10.0	0.2	35.00	50.00	9.5	10	108	1	-°	-°	▲
DSA.1.100.053	10.0	0.2	50.00	53.00	9.5	10	108	1	-°	-°	▲
DSA.1.120.030	12.0	0.2	30.00	36.00	11.5	12	82	1	-°	-°	▲
DSA.1.120.050	12.0	0.2	42.00	60.00	11.5	12	108	1	-°	-°	▲
DSA.1.120.053	12.0	0.2	60.00	63.60	11.5	12	108	1	-°	-°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	•
S	-
H	-

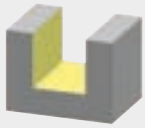
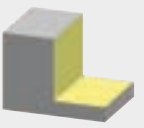
硬质合金牌号

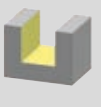
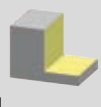
Carbide grades

切削参数 DSA Ø 2.0 - 12.0 mm

Cutting Data DSA Ø 2.0 - 12.0 mm



		
	vc = m/min	vc = m/min
N1.1	300	390
N1.2	320	420
N2.1	300	390
N2.2	250	330
N2.3	180	230
N3.1	200	260
N3.2	180	230
N4.1	200	260

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

尺寸单位 : mm

Dimensions in mm

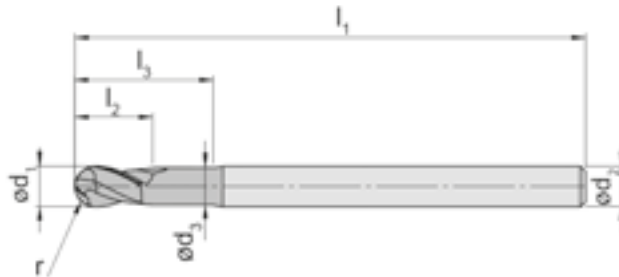
B

球头立铣刀

Ball Nose End Mill



DSKA



B

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	2.0	10.0	12	3.8	6	64	2	20°	▲
DSKA.2.040.050	4	2.0	10.0	20	3.8	6	64	2	20°	▲
DSKA.2.040.070	4	2.0	10.0	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	3.0	15.0	18	5.6	6	64	2	-°	▲
DSKA.2.060.050	6	3.0	15.0	30	5.6	6	82	2	-°	▲
DSKA.2.060.070	6	3.0	15.0	42	5.6	6	82	2	-°	▲
DSKA.2.080.030	8	4.0	20.0	24	7.5	8	64	2	-°	▲
DSKA.2.080.050	8	4.0	20.0	40	7.5	8	82	2	-°	▲
DSKA.2.080.070	8	4.0	20.0	56	7.5	8	108	2	-°	▲
DSKA.2.100.030	10	5.0	25.0	30	9.5	10	82	2	-°	▲
DSKA.2.100.050	10	5.0	25.0	50	9.5	10	108	2	-°	▲
DSKA.2.100.070	10	5.0	25.0	70	9.5	10	120	2	-°	▲
DSKA.2.120.030	12	6.0	30.0	36	11.5	12	82	2	-°	▲
DSKA.2.120.050	12	6.0	30.0	60	11.5	12	108	2	-°	▲
DSKA.2.120.070	12	6.0	30.0	84	11.5	12	140	2	-°	▲
DSKA.2.160.030	16	8.0	40.0	48	15.0	16	108	2	-°	▲
DSKA.2.160.050	16	8.0	40.0	80	15.0	16	140	2	-°	▲
DSKA.2.200.030	20	10.0	50.0	60	19.0	20	120	2	-°	▲
DSKA.2.200.050	20	10.0	50.0	100	19.0	20	163	2	-°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

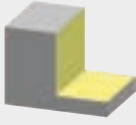
P	-
M	-
K	-
N	•
S	-
H	-

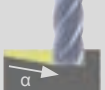
硬质合金牌号
Carbide grades

切削参数 DSKA Ø 4.0 - 20.0 mm

Cutting Data DSKA Ø 4.0 - 20.0 mm



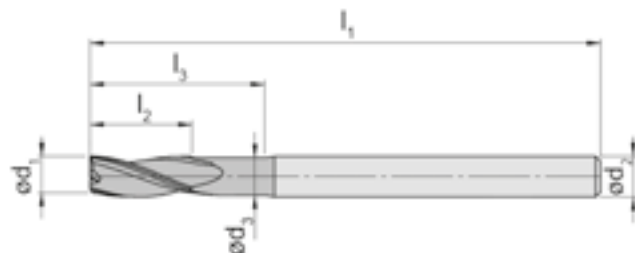
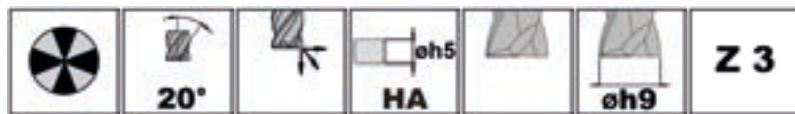
		
	vc = m/min	vc = m/min
N1.1	460	550
N1.2	480	580
N2.1	460	550
N2.2	390	470
N2.3	260	310
N3.1	330	400
N3.2	290	350
N4.1	330	400

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

尺寸单位 : mm
Dimensions in mm

B

DSA



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	10.0	12.0	3.8	6	64	3	20°	▲
DSA.3.040.050	4	10.0	20.0	3.8	6	64	3	20°	▲
DSA.3.040.053	4	20.0	21.2	3.8	6	64	3	20°	▲
DSA.3.040.070	4	20.0	28.0	3.8	6	70	3	20°	▲
DSA.3.050.030	5	12.5	15.0	4.7	6	64	3	20°	▲
DSA.3.050.050	5	12.5	25.0	4.7	6	64	3	20°	▲
DSA.3.050.053	5	25.0	26.5	4.7	6	64	3	20°	▲
DSA.3.050.070	5	25.0	35.0	4.7	6	82	3	20°	▲
DSA.3.060.030	6	15.0	18.0	5.6	6	64	3	-°	▲
DSA.3.060.050	6	15.0	30.0	5.6	6	82	3	-°	▲
DSA.3.060.053	6	30.0	31.8	5.6	6	82	3	-°	▲
DSA.3.060.070	6	30.0	42.0	5.6	6	82	3	-°	▲
DSA.3.080.030	8	20.0	24.0	7.5	8	64	3	-°	▲
DSA.3.080.050	8	20.0	40.0	7.5	8	82	3	-°	▲
DSA.3.080.053	8	40.0	42.4	7.5	8	82	3	-°	▲
DSA.3.080.070	8	40.0	56.0	7.5	8	108	3	-°	▲
DSA.3.100.030	10	25.0	30.0	9.5	10	82	3	-°	▲
DSA.3.100.050	10	25.0	50.0	9.5	10	108	3	-°	▲
DSA.3.100.053	10	50.0	53.0	9.5	10	108	3	-°	▲
DSA.3.100.070	10	50.0	70.0	9.5	10	120	3	-°	▲
DSA.3.120.030	12	30.0	36.0	11.5	12	82	3	-°	▲
DSA.3.120.050	12	30.0	60.0	11.5	12	108	3	-°	▲
DSA.3.120.053	12	60.0	63.6	11.5	12	108	3	-°	▲
DSA.3.120.070	12	60.0	84.0	11.5	12	140	3	-°	▲
DSA.3.160.030	16	40.0	48.0	15.0	16	108	3	-°	▲
DSA.3.160.050	16	40.0	80.0	15.0	16	140	3	-°	▲
DSA.3.160.053	16	80.0	84.8	15.0	16	140	3	-°	▲
DSA.3.200.027	20	50.0	54.0	19.0	20	108	3	-°	▲
DSA.3.200.050	20	50.0	100.0	19.0	20	163	3	-°	▲
DSA.3.200.053	20	100.0	106.0	19.0	20	163	3	-°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位：mm

Dimensions in mm

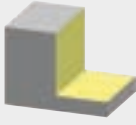
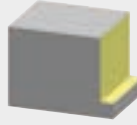
P	-
M	-
K	-
N	•
S	-
H	-

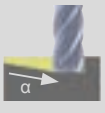
硬质合金牌号
Carbide grades

切削参数 DSA Ø 4.0 - 20.0 mm

Cutting Data DSA Ø 4.0 - 20.0 mm



	 vc = m/min	 vc = m/min
N1.1	420	500
N1.2	440	530
N2.1	420	500
N2.2	350	420
N2.3	230	280
N3.1	290	350
N3.2	250	300
N4.1	290	350

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

尺寸单位：mm

Dimensions in mm

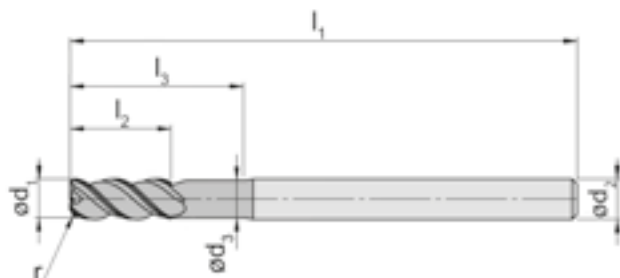
B

立铣刀, 带圆角

End Mill, corner radius



DSRA



B

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	10.0	12.0	3.8	6	64	3	20°	▲
DSRA.3.040.010.050	4	0.1	10.0	20.0	3.8	6	64	3	20°	▲
DSRA.3.040.010.053	4	0.1	20.0	21.2	3.8	6	64	3	20°	▲
DSRA.3.040.010.070	4	0.1	20.0	28.0	3.8	6	70	3	20°	▲
DSRA.3.040.050.030	4	0.5	10.0	12.0	3.8	6	64	3	20°	▲
DSRA.3.040.050.050	4	0.5	10.0	20.0	3.8	6	64	3	20°	▲
DSRA.3.040.050.053	4	0.5	20.0	21.2	3.8	6	64	3	20°	▲
DSRA.3.040.050.070	4	0.5	20.0	28.0	3.8	6	70	3	20°	▲
DSRA.3.040.100.030	4	1.0	10.0	12.0	3.8	6	64	3	20°	▲
DSRA.3.040.100.050	4	1.0	10.0	20.0	3.8	6	64	3	20°	▲
DSRA.3.040.100.053	4	1.0	20.0	21.2	3.8	6	64	3	20°	▲
DSRA.3.040.100.070	4	1.0	20.0	28.0	3.8	6	70	3	20°	▲
DSRA.3.050.010.030	5	0.1	12.5	15.0	4.7	6	64	3	20°	▲
DSRA.3.050.010.050	5	0.1	12.5	25.0	4.7	6	64	3	20°	▲
DSRA.3.050.010.053	5	0.1	25.0	26.5	4.7	6	64	3	20°	▲
DSRA.3.050.010.070	5	0.1	25.0	35.0	4.7	6	82	3	20°	▲
DSRA.3.050.050.030	5	0.5	12.5	15.0	4.7	6	64	3	20°	▲
DSRA.3.050.050.050	5	0.5	12.5	25.0	4.7	6	64	3	20°	▲
DSRA.3.050.050.053	5	0.5	25.0	26.5	4.7	6	64	3	20°	▲
DSRA.3.050.050.070	5	0.5	25.0	35.0	4.7	6	82	3	20°	▲
DSRA.3.050.100.030	5	1.0	12.5	15.0	4.7	6	64	3	20°	▲
DSRA.3.050.100.050	5	1.0	12.5	25.0	4.7	6	64	3	20°	▲
DSRA.3.050.100.053	5	1.0	25.0	26.5	4.7	6	64	3	20°	▲
DSRA.3.050.100.070	5	1.0	25.0	35.0	4.7	6	82	3	20°	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

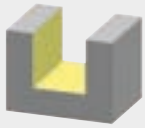
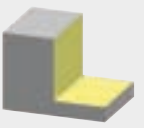
P	-
M	-
K	-
N	•
S	-
H	-

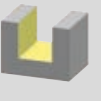
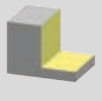
硬质合金牌号
Carbide grades

切削参数 DSRA Ø 4.0 - 5.0 mm

Cutting Data DSTMA Ø 4.0 - 5.0 mm



	 vc = m/min	 vc = m/min
N1.1	460	550
N1.2	480	580
N2.1	460	550
N2.2	390	470
N2.3	260	310
N3.1	330	400
N3.2	290	350
N4.1	330	400

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

尺寸单位 : mm

Dimensions in mm

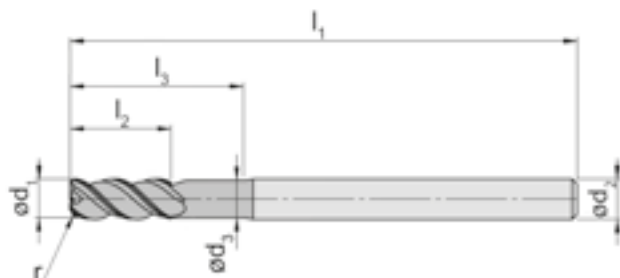
B

立铣刀, 带圆角

End Mill, corner radius



DSRA



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	18.0	5.6	6	64	3	▲
DSRA.3.060.010.050	6	0.1	15	30.0	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	42.0	5.6	6	82	3	▲
DSRA.3.060.050.030	6	0.5	15	18.0	5.6	6	64	3	▲
DSRA.3.060.050.050	6	0.5	15	30.0	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	42.0	5.6	6	82	3	▲
DSRA.3.060.100.030	6	1.0	15	18.0	5.6	6	64	3	▲
DSRA.3.060.100.050	6	1.0	15	30.0	5.6	6	82	3	▲
DSRA.3.060.100.053	6	1.0	30	31.8	5.6	6	82	3	▲
DSRA.3.060.100.070	6	1.0	30	42.0	5.6	6	82	3	▲
DSRA.3.060.250.030	6	2.5	15	18.0	5.6	6	64	3	▲
DSRA.3.060.250.050	6	2.5	15	30.0	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	42.0	5.6	6	82	3	▲
DSRA.3.080.010.030	8	0.1	20	24.0	7.5	8	64	3	▲
DSRA.3.080.010.050	8	0.1	20	40.0	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	56.0	7.5	8	108	3	▲
DSRA.3.080.050.030	8	0.5	20	24.0	7.5	8	64	3	▲
DSRA.3.080.050.050	8	0.5	20	40.0	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	56.0	7.5	8	108	3	▲
DSRA.3.080.100.030	8	1.0	20	24.0	7.5	8	64	3	▲
DSRA.3.080.100.050	8	1.0	20	40.0	7.5	8	82	3	▲
DSRA.3.080.100.053	8	1.0	40	42.4	7.5	8	82	3	▲
DSRA.3.080.100.070	8	1.0	40	56.0	7.5	8	108	3	▲
DSRA.3.080.250.030	8	2.5	20	24.0	7.5	8	64	3	▲
DSRA.3.080.250.050	8	2.5	20	40.0	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	56.0	7.5	8	108	3	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	-
M	-
K	-
N	•
S	-
H	-

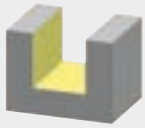
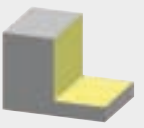
硬质合金牌号

Carbide grades

切削参数 DSRA Ø 6.0 - 8.0 mm

Cutting Data DSTMA Ø 6.0 - 8.0 mm



		
	vc = m/min	vc = m/min
N1.1	350	460
N1.2	370	480
N2.1	350	460
N2.2	300	390
N2.3	200	260
N3.1	250	330
N3.2	220	290
N4.1	250	330

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

尺寸单位：mm

Dimensions in mm

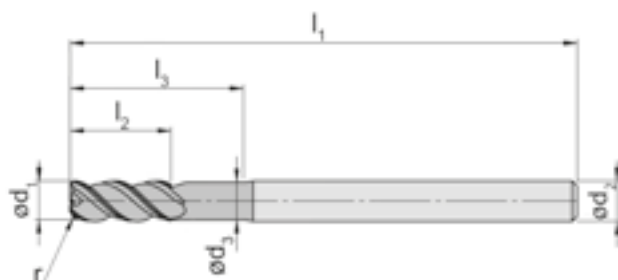
B

立铣刀, 带圆角

End Mill, corner radius



DSRA



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	30.0	9.5	10	82	3	▲
DSRA.3.100.010.050	10	0.1	25	50.0	9.5	10	108	3	▲
DSRA.3.100.010.053	10	0.1	50	53.0	9.5	10	108	3	▲
DSRA.3.100.010.070	10	0.1	50	70.0	9.5	10	120	3	▲
DSRA.3.100.050.030	10	0.5	25	30.0	9.5	10	82	3	▲
DSRA.3.100.050.050	10	0.5	25	50.0	9.5	10	108	3	▲
DSRA.3.100.050.053	10	0.5	50	53.0	9.5	10	108	3	▲
DSRA.3.100.050.070	10	0.5	50	70.0	9.5	10	120	3	▲
DSRA.3.100.100.030	10	1.0	25	30.0	9.5	10	82	3	▲
DSRA.3.100.100.050	10	1.0	25	50.0	9.5	10	108	3	▲
DSRA.3.100.100.053	10	1.0	50	53.0	9.5	10	108	3	▲
DSRA.3.100.100.070	10	1.0	50	70.0	9.5	10	120	3	▲
DSRA.3.100.250.030	10	2.5	25	30.0	9.5	10	82	3	▲
DSRA.3.100.250.050	10	2.5	25	50.0	9.5	10	108	3	▲
DSRA.3.100.250.053	10	2.5	50	53.0	9.5	10	108	3	▲
DSRA.3.100.250.070	10	2.5	50	70.0	9.5	10	120	3	▲
DSRA.3.120.010.030	12	0.1	30	36.0	11.5	12	82	3	▲
DSRA.3.120.010.050	12	0.1	30	60.0	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	84.0	11.5	12	140	3	▲
DSRA.3.120.050.030	12	0.5	30	36.0	11.5	12	82	3	▲
DSRA.3.120.050.050	12	0.5	30	60.0	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	84.0	11.5	12	140	3	▲
DSRA.3.120.100.030	12	1.0	30	36.0	11.5	12	82	3	▲
DSRA.3.120.100.050	12	1.0	30	60.0	11.5	12	108	3	▲
DSRA.3.120.100.053	12	1.0	60	63.6	11.5	12	108	3	▲
DSRA.3.120.100.070	12	1.0	60	84.0	11.5	12	140	3	▲
DSRA.3.120.250.030	12	2.5	30	36.0	11.5	12	82	3	▲
DSRA.3.120.250.050	12	2.5	30	60.0	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	84.0	11.5	12	140	3	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

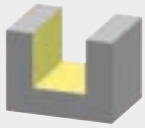
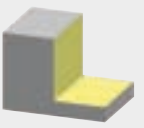
P	-
M	-
K	-
N	•
S	-
H	-

硬质合金牌号
Carbide grades

切削参数 DSRA Ø 10.0 mm

Cutting Data DSTMA Ø 10.0 mm



		
	vc = m/min	vc = m/min
N1.1	350	460
N1.2	370	480
N2.1	350	460
N2.2	300	390
N2.3	200	260
N3.1	250	330
N3.2	220	290
N4.1	250	330

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

尺寸单位：mm

Dimensions in mm

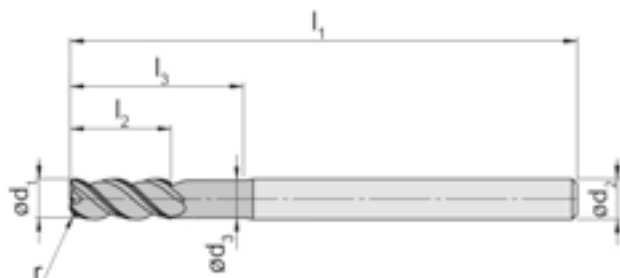
B

立铣刀, 带圆角

End Mill, corner radius



DSRA



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	48.0	15	16	108	3	▲
DSRA.3.160.010.050	16	0.1	40	80.0	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	48.0	15	16	108	3	▲
DSRA.3.160.050.050	16	0.5	40	80.0	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	1.0	40	48.0	15	16	108	3	▲
DSRA.3.160.100.050	16	1.0	40	80.0	15	16	140	3	▲
DSRA.3.160.100.053	16	1.0	80	84.8	15	16	140	3	▲
DSRA.3.160.250.030	16	2.5	40	48.0	15	16	108	3	▲
DSRA.3.160.250.050	16	2.5	40	80.0	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	4.0	40	48.0	15	16	108	3	▲
DSRA.3.160.400.050	16	4.0	40	80.0	15	16	140	3	▲
DSRA.3.160.400.053	16	4.0	80	84.8	15	16	140	3	▲
DSRA.3.200.010.027	20	0.1	50	54.0	19	20	108	3	▲
DSRA.3.200.010.050	20	0.1	50	100.0	19	20	163	3	▲
DSRA.3.200.010.053	20	0.1	100	106.0	19	20	163	3	▲
DSRA.3.200.050.027	20	0.5	50	54.0	19	20	108	3	▲
DSRA.3.200.050.050	20	0.5	50	100.0	19	20	163	3	▲
DSRA.3.200.050.053	20	0.5	100	106.0	19	20	163	3	▲
DSRA.3.200.100.027	20	1.0	50	54.0	19	20	108	3	▲
DSRA.3.200.100.050	20	1.0	50	100.0	19	20	163	3	▲
DSRA.3.200.100.053	20	1.0	100	106.0	19	20	163	3	▲
DSRA.3.200.250.027	20	2.5	50	54.0	19	20	108	3	▲
DSRA.3.200.250.050	20	2.5	50	100.0	19	20	163	3	▲
DSRA.3.200.250.053	20	2.5	100	106.0	19	20	163	3	▲
DSRA.3.200.400.027	20	4.0	50	54.0	19	20	108	3	▲
DSRA.3.200.400.050	20	4.0	50	100.0	19	20	163	3	▲
DSRA.3.200.400.053	20	4.0	100	106.0	19	20	163	3	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

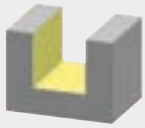
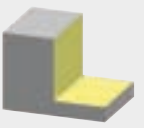
P	-
M	-
K	-
N	•
S	-
H	-

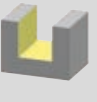
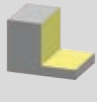
硬质合金牌号
Carbide grades

切削参数 DSRA Ø 16.0 - 20.0 mm

Cutting Data DSTMA Ø 16.0 - 20.0 mm



		
	vc = m/min	vc = m/min
N1.1	350	460
N1.2	370	480
N2.1	350	460
N2.2	300	390
N2.3	200	260
N3.1	250	330
N3.2	220	290
N4.1	250	330

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	3°	0.066	20.00	30.00	0.055	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	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
20	5°	0.066	20.00	30.00	0.055	4.00	100.00

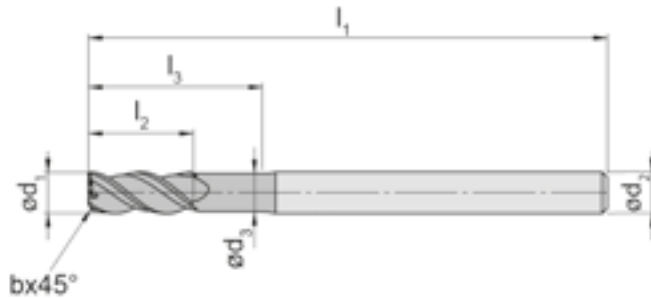
尺寸单位 : mm
Dimensions in mm

B

HPC立铣刀, 刀尖斜角 End Mill HPC, corner bevel



DSFA



产品型号 Part number	d ₁	b	l ₂	l ₃	d ₃	d ₂	l ₁	Z	NE2K
DSFA.3.060.030	6	0.2	15	18.0	5.6	6	57	3	▲
DSFA.3.060.050	6	0.2	15	30.0	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	42.0	5.6	6	80	3	▲
DSFA.3.080.030	8	0.2	20	24.0	7.5	8	64	3	▲
DSFA.3.080.050	8	0.2	20	40.0	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	56.0	7.5	8	100	3	▲
DSFA.3.100.030	10	0.2	25	30.0	9.5	10	72	3	▲
DSFA.3.100.050	10	0.2	25	50.0	9.5	10	100	3	▲
DSFA.3.100.053	10	0.2	50	53.0	9.5	10	100	3	▲
DSFA.3.100.070	10	0.2	50	70.0	9.5	10	115	3	▲
DSFA.3.120.030	12	0.2	30	36.0	11.5	12	85	3	▲
DSFA.3.120.050	12	0.2	30	60.0	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	84.0	11.5	12	140	3	▲
DSFA.3.160.030	16	0.5	40	48.0	15.0	16	100	3	▲
DSFA.3.160.050	16	0.5	40	80.0	15.0	16	140	3	▲
DSFA.3.160.053	16	0.5	80	84.8	15.0	16	140	3	▲
DSFA.3.200.027	20	0.5	50	54.0	19.0	20	108	3	▲
DSFA.3.200.050	20	0.5	50	100.0	19.0	20	163	3	▲
DSFA.3.200.053	20	0.5	100	106.0	19.0	20	163	3	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

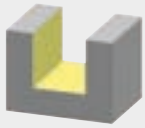
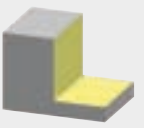
P	-
M	-
K	-
N	•
S	-
H	-

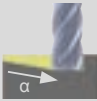
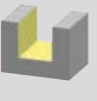
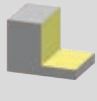
硬质合金牌号
Carbide grades

切削参数 DSFA Ø 6.0 - 20.0 mm

Cutting Data DSFA Ø 6.0 - 20.0 mm



		
	vc = m/min	vc = m/min
N1.1	450	540
N1.2	500	600
N2.1	450	540
N2.2	350	420
N2.3	280	340
N3.1	300	360
N3.2	280	340
N4.1	300	360

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

尺寸单位 : mm

Dimensions in mm

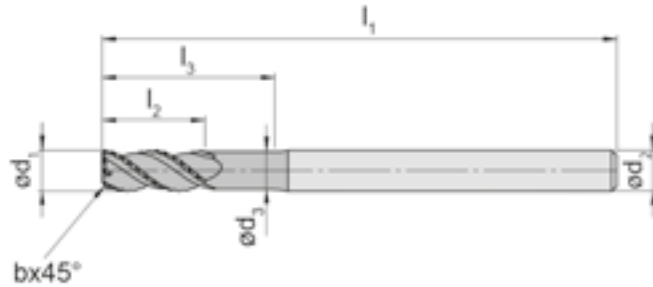
B

粗加工立铣刀, 锯齿刃

Roughing End Mill with ripper profile



DSFRA



产品型号 Part number	d ₁	b	l ₂	l ₃	d ₃	d ₂	l ₁	Z	类型 Type	NE2K
DSFRA.3.060.030	6	0.4	15	18	5.6	6	57	3	-	▲
DSFRA.3.060.050	6	0.4	15	30	5.6	6	70	3	-	▲
DSFRA.3.080.030	8	0.5	20	24	7.5	8	64	3	-	▲
DSFRA.3.080.050	8	0.5	20	40	7.5	8	80	3	-	▲
DSFRA.3.100.030	10	0.5	25	30	9.5	10	72	3	-	▲
DSFRA.3.100.050	10	0.5	25	50	9.5	10	100	3	-	▲
DSFRA.3.120.030	12	0.5	30	36	11.5	12	85	3	-	▲
DSFRA.3.120.030.B	12	0.5	30	36	11.5	12	85	3	Weldon	▲
DSFRA.3.120.050	12	0.5	30	60	11.5	12	108	3	-	▲
DSFRA.3.120.050.B	12	0.5	30	60	11.5	12	108	3	Weldon	▲
DSFRA.3.160.030	16	0.6	40	48	15.0	16	100	3	-	▲
DSFRA.3.160.030.B	16	0.6	40	48	15.0	16	100	3	Weldon	▲
DSFRA.3.160.050	16	0.6	40	80	15.0	16	140	3	-	▲
DSFRA.3.160.050.B	16	0.6	40	80	15.0	16	140	3	Weldon	▲
DSFRA.3.200.027	20	0.8	50	54	18.8	20	108	3	-	▲
DSFRA.3.200.027.B	20	0.8	50	54	18.8	20	108	3	Weldon	▲
DSFRA.3.200.050	20	0.8	50	100	18.8	20	163	3	-	▲
DSFRA.3.200.050.B	20	0.8	50	100	18.8	20	163	3	Weldon	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

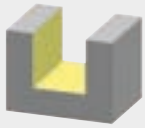
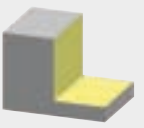
P	-
M	-
K	-
N	•
S	-
H	-

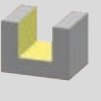
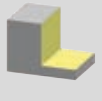
硬质合金牌号
Carbide grades

切削参数 DSFRA Ø 6.0 - 20.0 mm

Cutting Data DSFRA Ø 6.0 - 20.0 mm



		
	vc = m/min	vc = m/min
N1.1	450	540
N1.2	500	600
N2.1	450	540
N2.2	350	420
N2.3	280	340
N3.1	300	360
N3.2	280	340
N4.1	300	360

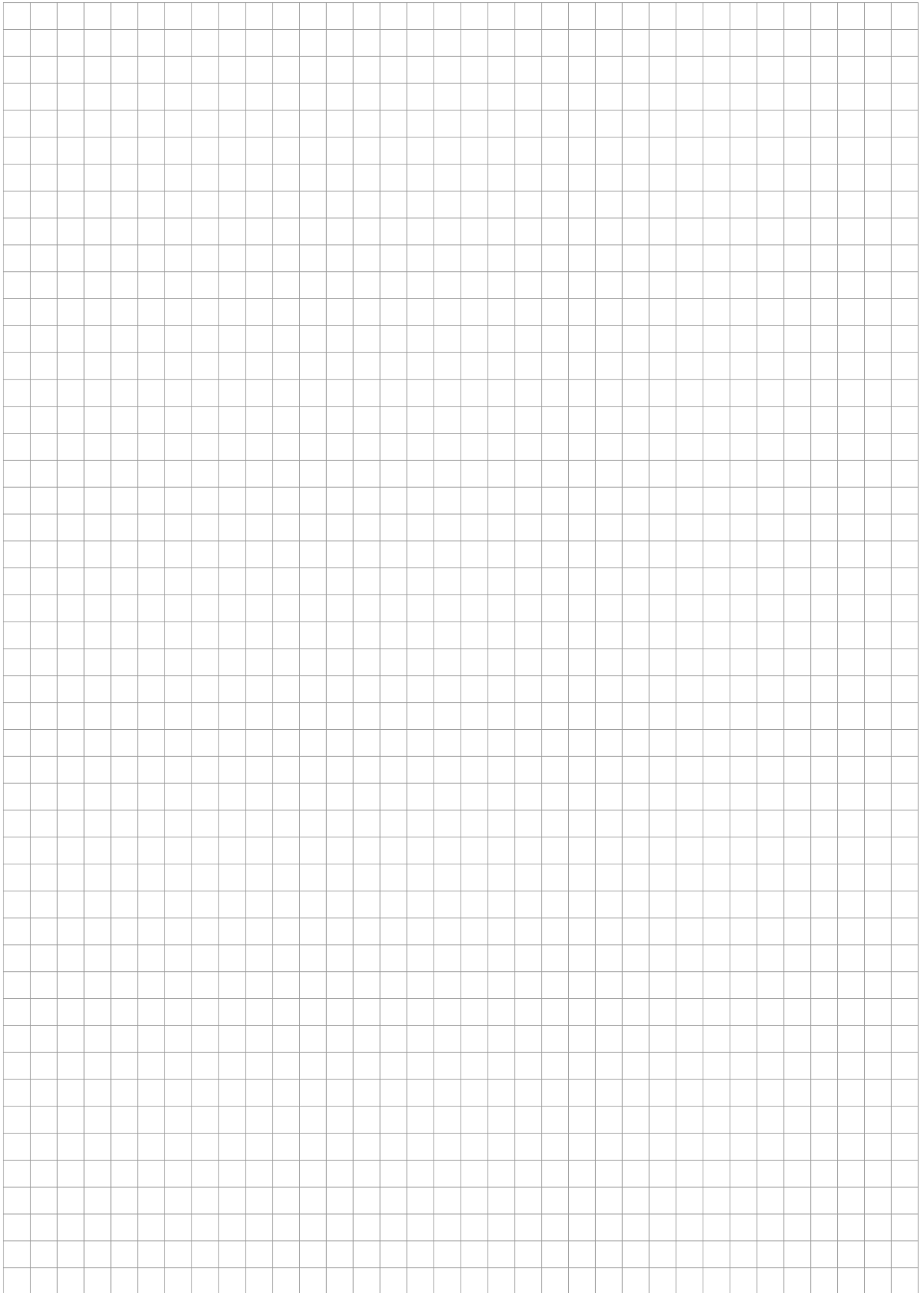
d ₁							
		f _z	a _e	a _p	f _z	a _e	a _p
6	20°	0.030	6.00	9.00	0.062	2.40	15.00
6	10°	0.021	6.00	9.00	0.043	2.40	15.00
8	20°	0.041	8.00	12.00	0.083	3.20	20.00
8	10°	0.029	8.00	12.00	0.058	3.20	20.00
10	20°	0.053	10.00	15.00	0.104	4.00	25.00
10	10°	0.037	10.00	15.00	0.073	4.00	25.00
12	20°	0.064	12.00	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

尺寸单位 : mm

Dimensions in mm

B

B





铣削系列 DG

用于

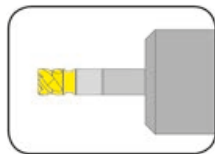
- 刃口过中心切削和槽铣削
- 倒角和中心铣削
- 仿形铣削
- 高进给铣削
- 齿轮铣削

Milling system DG

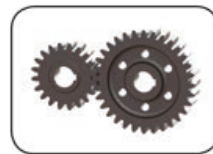
for

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

铣刀杆
Milling shank
MDG



页/Page
C3-C6

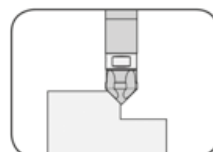


页/Page
C22

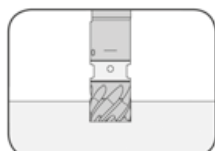
刀片
Cutter Head
DGR/DGF/DGRR/
DGH/DGM/DGK/
DGVZ/DGFF/DGVD-
GVZ/DGFF/DGV



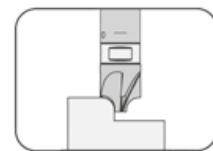
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C8



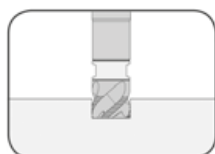
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C24



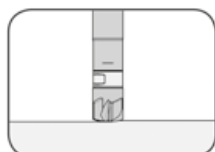
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C10. C12



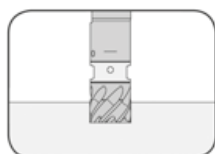
页/Page
C26



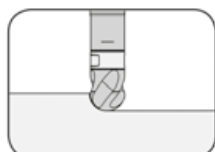
页/Page
C14



页/Page
C16



页/Page
C18



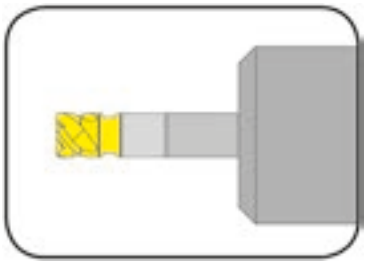
页/Page
C20

铣刀杆
Milling shank

MDG
直接冷却液供应
with through coolant supply

90°刀杆，热缩夹持
Shank 90° - shrink fit

刀杆材质：硬质合金
Material of shank: Carbide



刀片
Cutter Head

- 型号
Type
- DGK
 - DGM
 - DGF
 - DGR
 - DGRR
 - DGFF
 - DGH
 - DGV
 - DGVZ

产品型号 Part number	d	l ₁	l ₂	d ₁	系列 System
MDG.10.0010.90.00.A	10	72.8	30.0	9.8	DG10
MDG.10.0010.90.01.A	10	101.8	56.8	9.8	DG10
MDG.12.0012.90.00.A	12	83.3	36.0	11.7	DG12
MDG.12.0012.90.01.A	12	114.3	59.3	11.7	DG12
MDG.16.0016.90.00.A	16	98.8	48.0	15.6	DG16
MDG.16.0016.90.01.A	16	129.8	64.8	15.6	DG16
MDG.20.0020.90.00.A	20	112.3	60.0	19.5	DG20
MDG.20.0020.90.01.A	20	150.3	70.3	19.5	DG20

按需提供更多尺寸
Further sizes upon request

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！ 更多细节和扭矩规格详见技术参考页C7。

Spare Parts

Wrenches and additional equipment are not combined with the milling shank. Separate order required! For more details and torque specifications please see the technical data on page C7.

HORN可以返修损坏的铣刀杆基座。

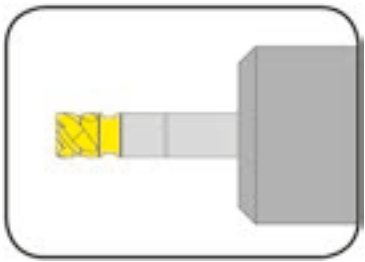
Milling cutter shanks with damaged seating can be repaired by HORN.

尺寸单位：mm
Dimensions in mm

铣刀杆
Milling shank

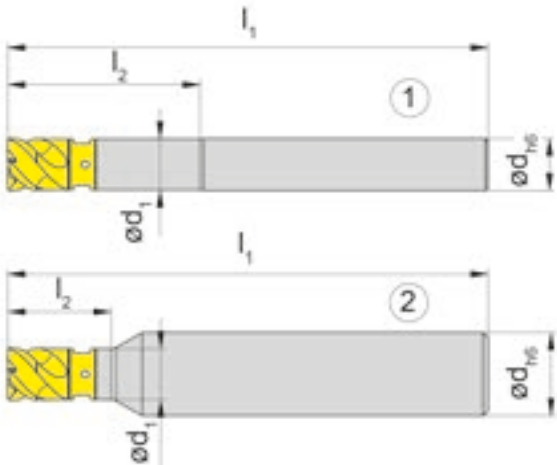
MDG

无内冷
no coolant supply



90°刀杆，不推荐热缩夹持
Shank 90° - not recommended for shrinking

刀杆材料：钢
Material of shank: Steel



刀片
Cutter Head

型号
Type

DGK
DGM
DGF
DGR
DGRR
DGFF
DGH
DGV
DGVZ

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

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

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！ 更多细节和扭矩规格详见技术参考页C7。

Spare Parts
Wrenches and additional equipment are not combined with the milling shank. Separate order required! For more details and torque specifications please see the technical data on page C7.
HORN可以返修损坏的铣刀杆基座。
Milling cutter shanks with damaged seating can be repaired by HORN.

槽铣削
Groove milling

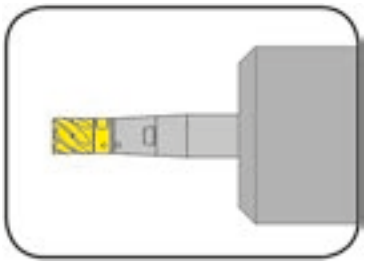


铣刀杆
Milling shank

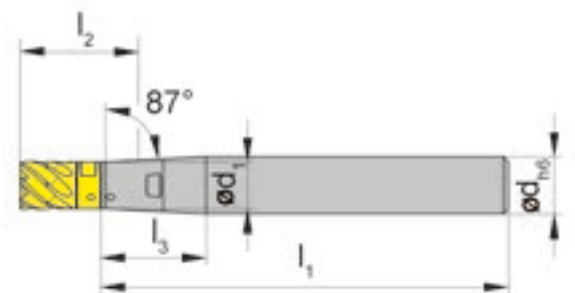
MDG
直接冷却液供应
with through coolant supply

87°刀杆，热缩夹持
Shank 87° - shrink fit

刀杆材质：硬质合金
Material of shank: Carbide



C



刀片
Cutter Head

- 型号
Type
- DGK
 - DGM
 - DGF
 - DGR
 - DGRR
 - DGFF
 - DGH
 - DGV
 - DGVZ

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

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

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！ 更多细节和扭矩规格详见技术参考页C7。

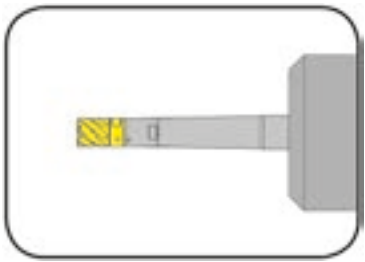
Spare Parts
Wrenches and additional equipment are not combined with the milling shank. Separate order required! For more details and torque specifications please see the technical data on page C7.
HORN可以返修损坏的铣刀杆基座。
Milling cutter shanks with damaged seating can be repaired by HORN.

铣刀杆
Milling shank

MDG
直接冷却液供应
with through coolant supply

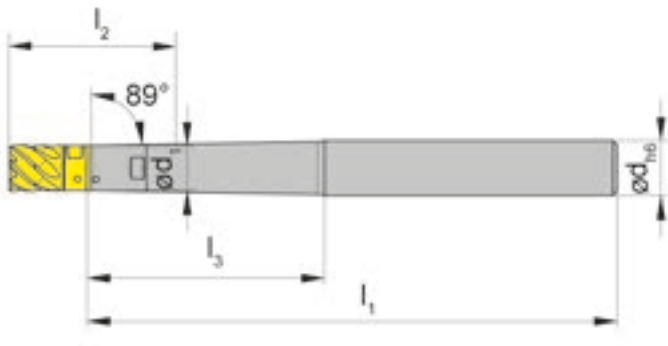
89°刀柄, 热缩夹持
Shank 89° - shrink fit

刀杆材质：硬质合金
Material of shank: Carbide



刀片
Cutter Head

- 型号
Type
- DGK
 - DGM
 - DGF
 - DGR
 - DGRR
 - DGFF
 - DGH
 - DGV
 - DGVZ



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

按需提供更多尺寸
Further sizes upon request

尺寸单位：mm
Dimensions in mm

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！更多细节和扭矩规格详见技术参考页C7。

Spare Parts

Wrenches and additional equipment are not combined with the milling shank. Separate order required! For more details and torque specifications please see the technical data on page C7.

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 (Nm) 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 5 - 25 Nm	D1050VK 10 - 50 Nm
DG12	14	10		D.DG1201		
DG16	25	13	S.DG1620	D.DG1601	D20100VK 20 - 100 Nm	
DG20	35	17		D.DG2001		

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.

角铣削和槽铣削

Corner and Groove Milling

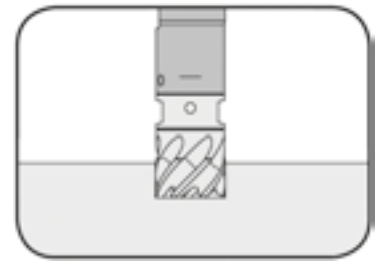


刀片

Cutter Head

DGR

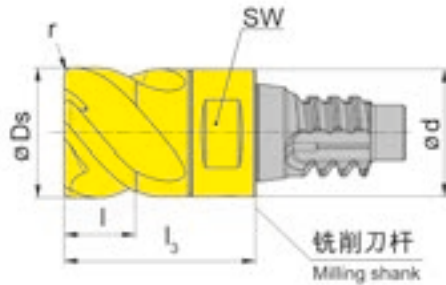
直接冷却液供应
with through coolant supply



带刀尖圆角的刀片
Cutter head with corner radius

用于铣削刀柄
for Milling shank

型号 MDG
Type



图示=右手型
Picture = right hand cutting version

端面加工切削刃不过中心
face cutting edge not cutting
across centre

产品型号 Part number	系列 System	SW	Z	d ₁	d	r	l ₃	l	AN2P
DGR.3.10.1000.05.IK	DG10	8	3	10	9.8	0.5	16.8	5.5	▲
DGR.3.10.1000.10.IK	DG10	8	3	10	9.8	1.0	16.8	5.5	▲
DGR.4.10.1000.05.IK	DG10	8	4	10	9.8	0.5	16.8	5.5	▲
DGR.4.10.1000.10.IK	DG10	8	4	10	9.8	1.0	16.8	5.5	▲
DGR.3.12.1200.05.IK	DG12	10	3	12	11.7	0.5	19.3	6.5	▲
DGR.4.12.1200.05.IK	DG12	10	4	12	11.7	0.5	19.3	6.5	▲
DGR.4.12.1200.10.IK	DG12	10	4	12	11.7	1.0	19.3	6.5	▲
DGR.5.16.1600.05.IK	DG16	13	5	16	15.6	0.5	24.8	8.5	▲
DGR.5.16.1600.10.IK	DG16	13	5	16	15.6	1.0	24.8	8.5	▲
DGR.5.16.1600.15.IK	DG16	13	5	16	15.6	1.5	24.8	8.5	▲
DGR.5.16.1600.20.IK	DG16	13	5	16	15.6	2.0	24.8	8.5	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

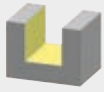
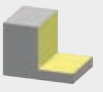
钎焊/金属陶瓷 / brazed/Cermet

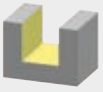
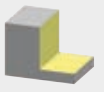
尺寸单位 : mm

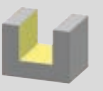
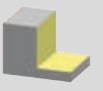
Dimensions in mm

P	•
M	•
K	•
N	-
S	•
H	○

硬质合金牌号
Carbide grades

		
	vc = m/min	vc = m/min
P1.1	150	180
P1.2	150	180
P1.3	140	170
P2.1	130	160
P2.2	130	160
P2.3	130	160
P3.1	110	130
P3.2	100	120
M1.1	90	110
M2.1	70	80
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	130	160
K1.2	110	130
K2.1	110	130
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1.1	65	80
S2.1	45	50
S3.1	35	40
-	-	-
-	-	-

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

尺寸单位 : mm
Dimensions in mm

角铣削和槽铣削

Corner and Groove Milling

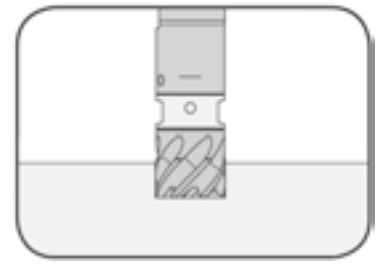


刀片

Cutter Head

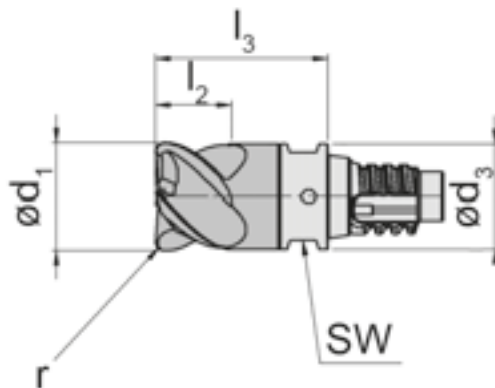
DGR

带刀尖圆角的刀片
Cutter head with corner radius



用于铣削刀柄
for Milling shank

型号 MDG
Type



图示=右手型
Picture = right hand cutting version

端面加工切削刃过中心
face cutting edge cutting across centre

产品型号 Part number	系列 系列	SW	Z	d ₁	d ₃	r	l ₃	l ₂	AN2P
DGR.3.10.1000.05.00	DG10	8	3	10	9.8	0.5	16.8	5.5	▲
DGR.3.10.1000.10.00	DG10	8	3	10	9.8	1.0	16.8	5.5	▲
DGR.4.10.1000.05.00	DG10	8	4	10	9.8	0.5	16.8	5.5	▲
DGR.4.10.1000.10.00	DG10	8	4	10	9.8	1.0	16.8	5.5	▲
DGR.3.12.1200.05.00	DG12	10	3	12	11.7	0.5	19.3	6.5	▲
DGR.4.12.1200.05.00	DG12	10	4	12	11.7	0.5	19.3	6.5	▲
DGR.4.12.1200.10.00	DG12	10	4	12	11.7	1.0	19.3	6.5	▲
DGR.5.16.1600.05.00	DG16	13	5	16	15.6	0.5	24.8	8.5	▲
DGR.5.16.1600.10.00	DG16	13	5	16	15.6	1.0	24.8	8.5	▲
DGR.5.16.1600.15.00	DG16	13	5	16	15.6	1.5	24.8	8.5	▲
DGR.5.16.1600.20.00	DG16	13	5	16	15.6	2.0	24.8	8.5	▲
DGR.5.20.2000.05.00	DG20	17	5	20	19.5	0.5	30.3	12.0	▲
DGR.5.20.2000.10.00	DG20	17	5	20	19.5	1.0	30.3	12.0	▲
DGR.5.20.2000.15.00	DG20	17	5	20	19.5	1.5	30.3	12.0	▲
DGR.5.20.2000.20.00	DG20	17	5	20	19.5	2.0	30.3	12.0	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

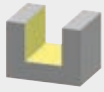
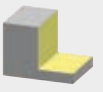
■ 钎焊/金属陶瓷 / brazed/Cermet

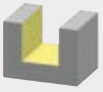
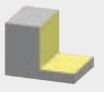
尺寸单位 : mm

Dimensions in mm

P	●
M	●
K	●
N	-
S	●
H	○

硬质合金牌号
Carbide grades

		
	vc = m/min	vc = m/min
P1.1	150	180
P1.2	150	180
P1.3	140	170
P2.1	130	160
P2.2	130	160
P2.3	130	160
P3.1	110	130
P3.2	100	120
M1.1	90	110
M2.1	70	80
M3.1	60	70

		
	vc = m/min	vc = m/min
K1.1	130	160
K1.2	110	130
K2.1	110	130
K2.2	100	120
K3.1	80	100
K3.2	70	80
S1.1	65	80
S2.1	45	50
S3.1	35	40
-	-	-
-	-	-

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

尺寸单位 : mm
Dimensions in mm

C

角铣削和槽铣削

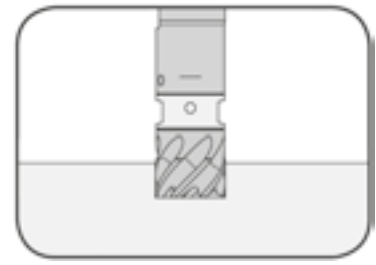
Corner and Groove Milling



刀片

Cutter Head

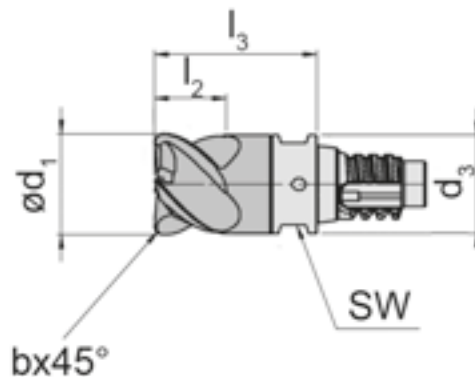
DGF



带刀尖倒角的刀片
Cutter head with corner chamfer

用于铣削刀柄
for Milling shank

型号 MDG
Type



端面加工切削刃过中心
face cutting edge cutting
across centre

图示=右手型
Picture = right hand cutting version

产品型号 Part number	系列 系列	SW	Z	d ₁	d ₃	l ₃	l ₂	b	AN2P
DGF.3.10.1000.02.00	DG10	8	3	10	9.8	16.8	5.5	0.20	▲
DGF.3.12.1200.02.00	DG12	10	3	12	11.7	19.3	6.5	0.20	▲
DGF.4.16.1600.02.00	DG16	13	4	16	15.6	24.8	8.5	0.20	▲
DGF.4.20.2000.03.00	DG20	17	4	20	19.5	30.3	12.0	0.25	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

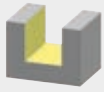
■ 钎焊/金属陶瓷 / brazed/Cermet

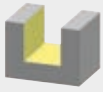
尺寸单位 : mm

Dimensions in mm

P	•
M	•
K	•
N	-
S	•
H	o

硬质合金牌号
Carbide grades

		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	50	60

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	90	110
K3.1	70	80
K3.2	60	70
S1.1	55	70
S2.1	40	50
S3.1	30	40
-	-	-
-	-	-

d ₁		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

尺寸单位：mm
Dimensions in mm

粗加工立铣刀

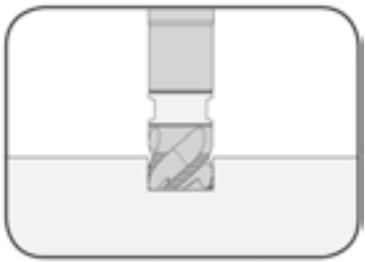
Roughing End Mill



刀片

Cutter Head

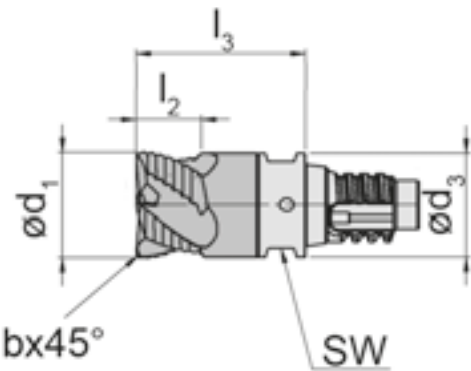
DGRR



带刀尖倒角的刀片
Cutter head with corner chamfer

用于铣削刀柄
for Milling shank

型号 MDG
Type



图示=右手型
Picture = right hand cutting version

端面加工切削刃过中心
face cutting edge cutting
across centre

产品型号 Part number	系列 System	SW	Z	d ₁	d ₃	l ₃	l ₂	b	AN2P	
DGRR.3.10.1000.00	DG10	8	3	10	9.8	16.8	5.5	0.3	▲	•
DGRR.4.10.1000.00	DG10	8	4	10	9.8	16.8	5.5	0.3	▲	•
DGRR.3.12.1200.00	DG12	10	3	12	11.7	19.3	6.5	0.5	▲	•
DGRR.4.12.1200.00	DG12	10	4	12	11.7	19.3	6.5	0.5	▲	•
DGRR.5.16.1600.00	DG16	13	5	16	15.6	24.8	8.5	0.5	▲	•
DGRR.5.20.2000.00	DG20	17	5	20	19.5	30.3	12.0	0.5	▲	•
										P •
										M •
										K •
										N -
										S •
										H ○

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

• 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

非涂层 / uncoated grades

涂层 / coated grades

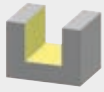
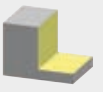
钎焊/金属陶瓷 / brazed/Cermet

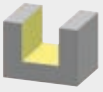
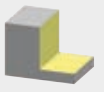
尺寸单位 : mm

Dimensions in mm

硬质合金牌号

Carbide grades

		
	vc = m/min	vc = m/min
P1.1	120	140
P1.2	120	140
P1.3	110	130
P2.1	110	130
P2.2	110	130
P2.3	110	130
P3.1	100	120
P3.2	100	120
M1.1	70	80
M2.1	60	70
M3.1	50	60

		
	vc = m/min	vc = m/min
K1.1	110	130
K1.2	100	120
K2.1	100	120
K2.2	80	100
K3.1	60	70
K3.2	60	70
S1.1	50	60
S2.1	40	50
S3.1	30	40
-	-	-
-	-	-

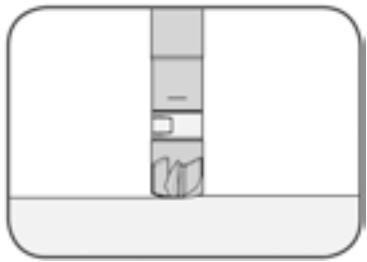
d ₁		f _z	a _e	a _p	f _z	a _e	a _p
10	5°	0.06	10	5	0.07	8	5
10	4°	0.05	10	5	0.06	8	5
12	3°	0.06	12	6	0.07	9	6
12	3°	0.06	12	6	0.07	9	6
16	3°	0.09	16	8	0.10	12	8
20	3°	0.11	20	10	0.13	15	10

尺寸单位 : mm
Dimensions in mm

C

刀片
Cutter Head

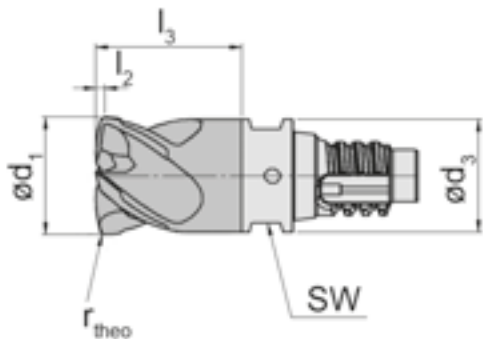
DGH



带刀尖圆角的刀片
Cutter head with corner radius

用于铣削刀柄
for Milling shank

型号 MDG
Type



图示=右手型
Picture = right hand cutting version

端面加工切削刃不过中心
face cutting edge not cutting
across centre

产品型号 Part number	系列 System	SW	Z	d ₁	d ₃	l ₃	l ₂	r _{theo}	AN2P
DGH.4.10.1000.00	DG10	8	4	10	9.8	16.8	0.7	1.07	▲
DGH.4.12.1200.00	DG12	10	4	12	11.7	19.3	0.8	1.18	▲
DGH.4.16.1600.00	DG16	13	4	16	15.6	24.8	1.0	1.38	▲
DGH.4.20.2000.00	DG20	17	4	20	19.5	30.3	1.2	1.96	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

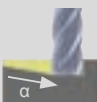
尺寸单位 : mm
Dimensions in mm

P	•
M	•
K	•
N	-
S	•
H	○

硬质合金牌号
Carbide grades

		
	vc = m/min	vc = m/min
P1.1	160	190
P1.2	160	190
P1.3	160	190
P2.1	150	180
P2.2	140	170
P2.3	140	170
P3.1	130	160
P3.2	130	160
M1.1	110	130
M2.1	100	120
M3.1	90	110

		
	vc = m/min	vc = m/min
K1.1	130	160
K1.2	130	160
K2.1	120	140
K2.2	120	140
K3.1	110	130
K3.2	110	130
S1	90	110
S2	70	80
S3	60	70
-	-	-
-	-	-

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

尺寸单位 : mm
Dimensions in mm

C

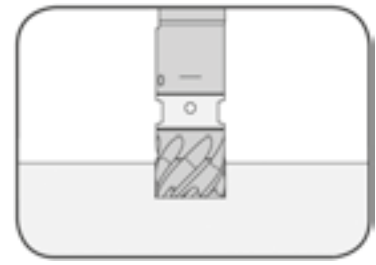
角铣削和槽铣削

Corner and Groove Milling



刀片 Cutter Head

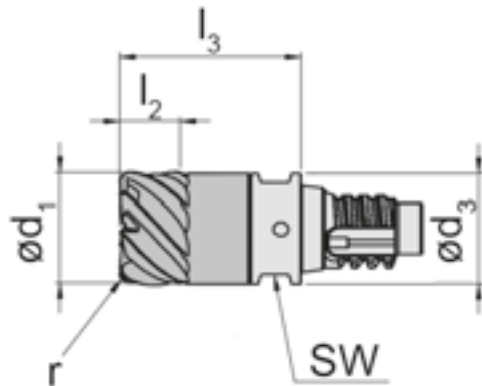
DGM



多刃
multiple fluted

用于铣削刀柄
for Milling shank

型号 MDG
Type



图示=右手型
Picture = right hand cutting version

端面加工切削刃不过中心
face cutting edge not cutting
across centre

产品型号 Part number	系列 System	SW	Z	d ₁	d ₃	r	l ₃	l ₂	AN2P
DGM.7.10.1000.02.0	DG10	8	7	10	9.8	0.2	16.8	5.5	▲
DGM.7.10.1000.10.0	DG10	8	7	10	9.8	1.0	16.8	5.5	▲
DGM.7.12.1200.02.0	DG12	10	7	12	11.7	0.2	19.3	6.5	▲
DGM.7.12.1200.10.0	DG12	10	7	12	11.7	1.0	19.3	6.5	▲
DGM.9.16.1600.02.0	DG16	13	9	16	15.6	0.2	24.8	9.0	▲
DGM.9.16.1600.10.0	DG16	13	9	16	15.6	1.0	24.8	9.0	▲
DGM.9.20.2000.02.0	DG20	17	9	20	19.5	0.2	30.3	11.0	▲
DGM.9.20.2000.10.0	DG20	17	9	20	19.5	1.0	30.3	11.0	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

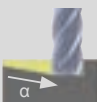
Dimensions in mm

P	•
M	•
K	•
N	-
S	•
H	○

硬质合金牌号
Carbide grades

		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	50	60

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	90	110
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	30	40
-	-	-
-	-	-

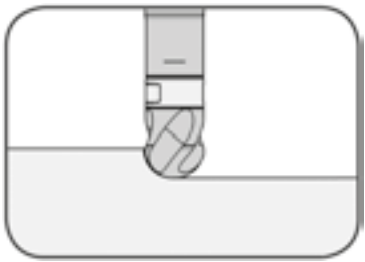
d ₁		f _z	a _e	a _p	f _z	a _e	a _p
10	2°	0.04	1.0	5,0	0.06	0.20	5,00
10	2°	0.04	1.0	5,0	0.06	0.20	5,00
12	2°	0.05	1.2	6,0	0.08	0.24	6,00
12	2°	0.05	1.2	6,0	0.08	0.24	6,00
16	2°	0.07	1.6	8,0	0.11	0.32	8,00
16	2°	0.07	1.6	8,0	0.11	0.32	8,00
20	2°	0.10	2,0	10,0	0.17	0.40	10,00
20	2°	0.10	2,0	10,0	0.17	0.40	10,00

尺寸单位 : mm
Dimensions in mm

C

刀片
Cutter Head

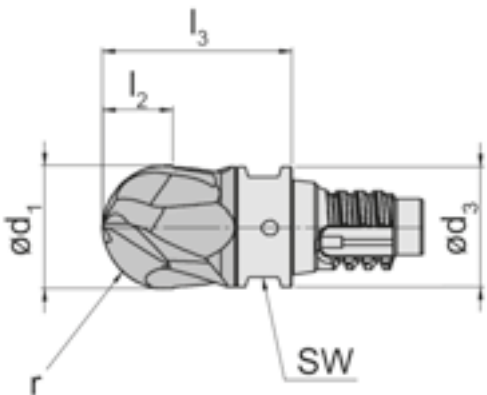
DGK



180°球头铣刀头
Ballnose milling head 180°

用于铣削刀柄
for Milling shank

型号 MDG
Type



图示=右手型
Picture = right hand cutting version

端面加工切削刃过中心
face cutting edge cutting
across centre

产品型号 Part number	系列 System	SW	Z	d ₁	d ₃	r	l ₃	l ₂	AN2P
DGK.2.10.1000.00	DG10	8	2	10	9.8	5	16.8	5.5	▲
DGK.4.10.1000.00	DG10	8	4	10	9.8	5	16.8	5.5	▲
DGK.2.12.1200.00	DG12	10	2	12	11.7	6	19.3	6.5	▲
DGK.4.12.1200.00	DG12	10	4	12	11.7	6	19.3	6.5	▲
DGK.2.16.1600.00	DG16	13	2	16	15.6	8	24.8	8.5	▲
DGK.4.16.1600.00	DG16	13	4	16	15.6	8	24.8	8.5	▲
DGK.2.20.2000.00	DG20	17	2	20	19.5	10	30.3	12.0	▲
DGK.4.20.2000.00	DG20	17	4	20	19.5	10	30.3	12.0	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

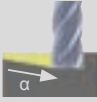
Dimensions in mm

P	●
M	●
K	○
N	○
S	○
H	○

硬质合金牌号
Carbide grades

		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	50	60

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	90	110
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	30	40
-	-	-
-	-	-

d ₁		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

尺寸单位：mm
Dimensions in mm

C

刀片

Cutter Head

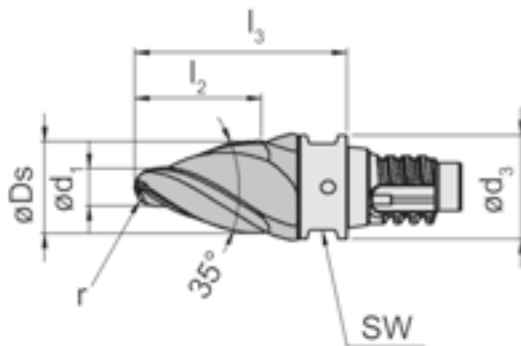
DGVZ



Schneidkopf Vollradius, konisch
Cutter head conical ball nose

用于铣削刀柄
for Milling shank

型号 MDG
Type



端面加工切削刃过中心
face cutting edge cutting
across centre

图示=右手型
Picture = right hand cutting version

产品型号 Part number	系列 System	SW	Z	Ds	d	r	l_3	d_1	a_p	AN2P
DGVZ.4.10.35.15.00	DG10	8	4	10	9.8	1.5	21	2.86	12.30	▲
DGVZ.4.12.35.20.00	DG12	10	4	12	11.7	2.0	24	3.82	14.30	▲
DGVZ.6.16.35.30.00	DG16	13	6	16	15.6	3.0	32	5.72	18.40	▲
DGVZ.6.20.35.50.00	DG20	17	6	20	19.5	5.0	37	9.54	20.09	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

o 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm

Dimensions in mm

P	●
M	●
K	○
N	○
S	○
H	○

硬质合金牌号
Carbide grades

		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	50	60

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	90	110
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	30	40
-	-	-
-	-	-

d_1		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

尺寸单位 : mm
Dimensions in mm

倒角

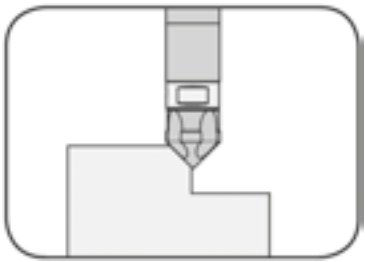
Chamfering



刀片

Cutter Head

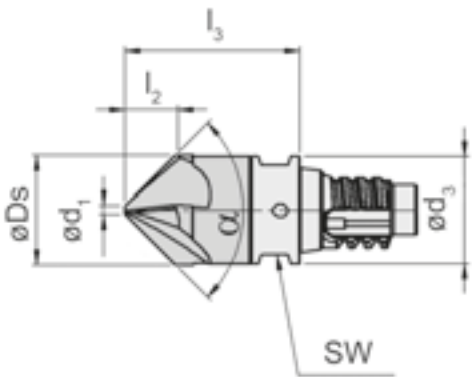
DGFF



倒角角度 Angle of chamfer 45 °

用于铣削刀柄
for Milling shank

型号 MDG
Type



不能用于面铣
not face cutting

图示=右手型
Picture = right hand cutting version

产品型号 Part number	系列 System	SW	Z	Ds	d ₃	l ₃	l ₂	d ₁	AN2P
DGFF.3.10.45.00	DG10	8	3	10	9.8	16.8	4.0	2	▲
DGFF.4.10.45.00	DG10	8	4	10	9.8	16.8	4.5	1	▲
DGFF.3.12.45.00	DG12	10	3	12	11.7	19.3	5.0	2	▲
DGFF.4.12.45.00	DG12	10	4	12	11.7	19.3	5.5	1	▲
DGFF.3.16.45.00	DG16	13	3	16	15.6	24.8	7.0	2	▲
DGFF.6.16.45.00	DG16	13	6	16	15.6	24.8	7.5	1	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

尺寸单位 : mm
Dimensions in mm

P	•
M	•
K	○
N	○
S	○
H	○

硬质合金牌号
Carbide grades

切削参数 DGFF

Cutting Data DGFF



		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	50	60

		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	90	110
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	30	40
-	-	-
-	-	-

						
d ₁	f _z	a _e	a _p	f _z	a _e	a _p
10	0.05	2,5	2,5	0.14	0.25	0.25
10	0.04	2,5	2,5	0.10	0.25	0.25
12	0.05	3,0	3,0	0.15	0.30	0.30
12	0.04	3,0	3,0	0.11	0.30	0.30
16	0.06	4,0	4,0	0.18	0.40	0.40
16	0.04	4,0	4,0	0.10	0.40	0.40

尺寸单位 : mm
Dimensions in mm

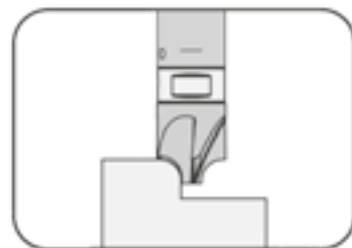
C

圆角 Corner Rounding



刀片 Cutter Head

DGV



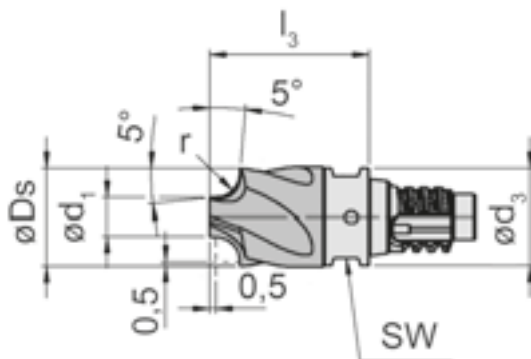
内凹圆角

Radius concave

0.2-3 mm

用于铣削刀柄
for Milling shank

型号 MDG
Type



不能用于面铣
not face cutting

图示=右手型
Picture = right hand cutting version

产品型号 Part number	系列 System	SW	Z	Ds	d ₃	r	l ₃	d ₁	AN2P
DGV.4.10.R020.00	DG10	8	4	10	9.8	0.20	16.8	8.6	▲
DGV.4.10.R050.00	DG10	8	4	10	9.8	0.50	16.8	8.0	▲
DGV.4.10.R100.00	DG10	8	4	10	9.8	1.00	16.8	7.0	▲
DGV.4.10.R125.00	DG10	8	4	10	9.8	1.25	16.8	6.5	▲
DGV.4.10.R150.00	DG10	8	4	10	9.8	1.50	16.8	6.0	▲
DGV.4.10.R200.00	DG10	8	4	10	9.8	2.00	16.8	5.0	▲
DGV.4.10.R250.00	DG10	8	4	10	9.8	2.50	16.8	4.0	▲
DGV.4.10.R300.00	DG10	8	4	10	9.8	3.00	16.8	3.0	▲

▲ 库存 / on stock Δ 4周 / 4 weeks x 根据要求 / upon request

● 推荐 / recommended

○ 次推荐 / alternative recommendation

- 不合适 / not suitable

■ 非涂层 / uncoated grades

■ 涂层 / coated grades

■ 钎焊/金属陶瓷 / brazed/Cermet

P	●
M	●
K	○
N	○
S	○
H	○

硬质合金牌号
Carbide grades

		
	vc = m/min	vc = m/min
P1.1	140	170
P1.2	140	170
P1.3	130	160
P2.1	120	140
P2.2	120	140
P2.3	120	140
P3.1	100	120
P3.2	90	110
M1.1	80	100
M2.1	60	70
M3.1	50	60

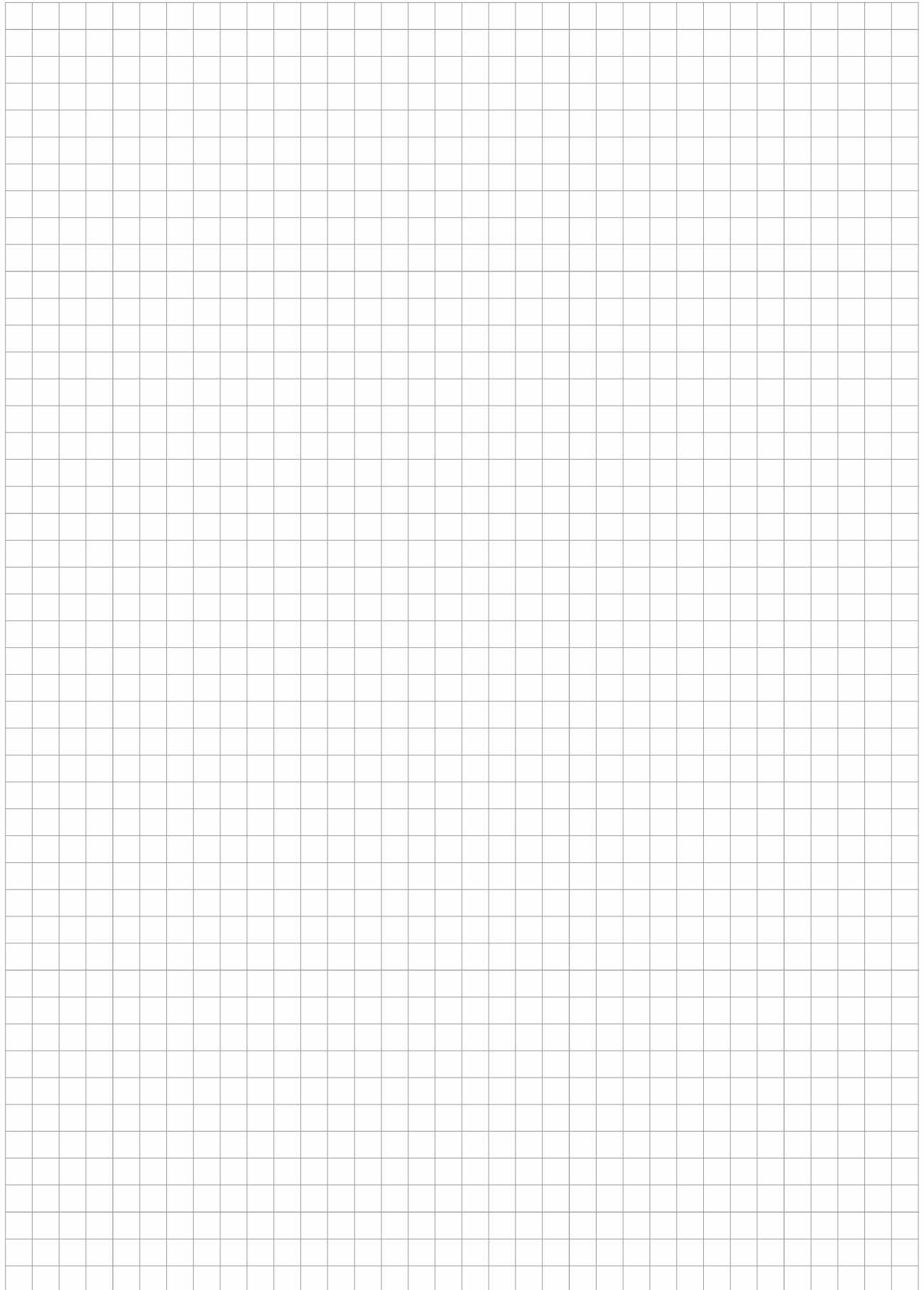
		
	vc = m/min	vc = m/min
K1.1	120	140
K1.2	100	120
K2.1	100	120
K2.2	90	110
K3.1	70	80
K3.2	60	70
S1	55	70
S2	40	50
S3	30	40
-	-	-
-	-	-

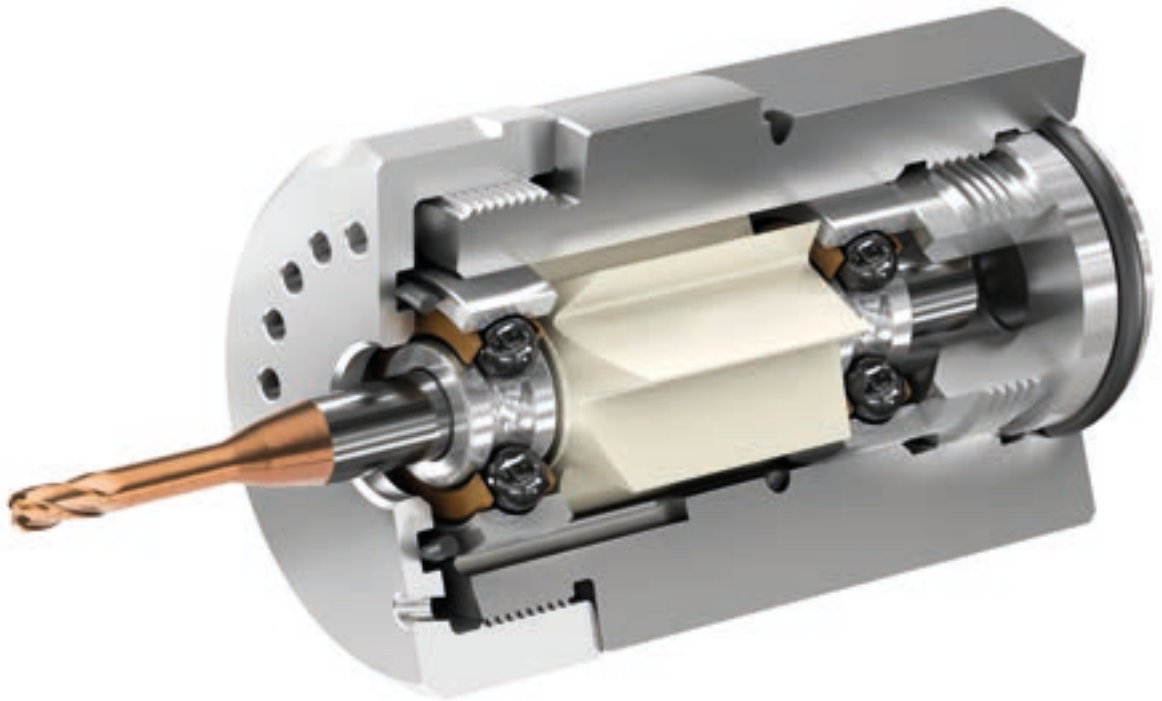
						
d ₁	f _z	a _e	a _p	f _z	a _e	a _p
10	0.08	0.20	0.20	0.10	0.20	0.20
10	0.07	0.50	0.50	0.10	0.25	0.25
10	0.06	1.00	1.00	0.10	0.25	0.25
10	0.05	1.25	1.25	0.10	0.25	0.25
10	0.05	1.50	1.50	0.10	0.25	0.25
10	0.04	2,00	2,00	0.10	0.25	0.25
10	0.04	2,50	2,50	0.10	0.25	0.25
10	0.04	3,00	3,00	0.10	0.25	0.25

尺寸单位 : mm
Dimensions in mm

C

C





高精度铣削
直径范围0.1-3.0mm
用于 DS系列立铣刀

High-precision milling from
diameters of 0.1 - 3.0 mm,
for DS end mills

高速轴
High Speed Spindles
TB131 / TB131-90 /
TG131

页/Page
D4

辅件
Additional Equipment

页/Page
D5

转速与压力
Rotation Speed and
Coolant Pressure

页/Page
D6

安装说明
Assembly Instruction

页/Page
D7

预安装驱动叶轮的微铣刀标准品有超过600多种，交期一周左右。
订货物料编号改动，将“**DS...**”改为“**TS...**”
例如订货编号：DSTH.4.120.020.015 改为 TSTH.4.120.020.015

More than 600 Micro pre-mounted end mills are available as standard within one week.
This changes the part number from “**DS....**” into “**TS....**”
Ordering example: DSTH.4.120.020.015 becomes TSTH.4.120.020.015



高速轴 用于DS微型铣刀

有超过600款标准品微铣刀，铣削直径范围从0.1到3mm，能预安装驱动叶轮，与高速轴配合使用，交期为一周。微铣刀能满足特殊需求，不仅仅是因为它的直径小。微铣刀有多种款式，槽型，涂层和基材，从而适用于各种材料加工，其中包括非铁金属，钢件，脆硬钢，钛合金和其他难加工材料。高速轴安装夹持方便，与常规刀杆类似，可以液压夹持，筒夹夹持和采用侧固接纳器，同时也可以使用在镗杆上。

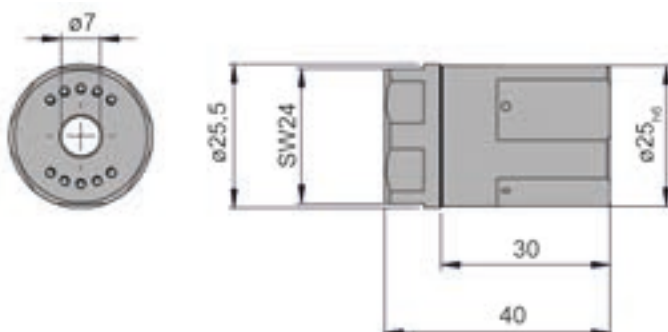
Toodle high-speed spindles for DS milling cutters

More than 600 DS milling cutters with cutting edge diameters of between 0.1 and 3 mm can be supplied with a pre-mounted Toodle spindle within one week. The milling cutters can be adapted to meet specific requirements more than simply in terms of their diameter. Thanks to the numerous versions with various geometries, coatings and carbide substrates, the tool best suited to the job can be selected for machining non-ferrous metals, steels, hardened steels, titanium alloys as well as other hard-to-cut materials. The high-speed spindles can be clamped with ease in standard tool holders, such as hydraulic expansion chucks, collet chucks and Weldon shank adapters, as well as in boring bar holders.



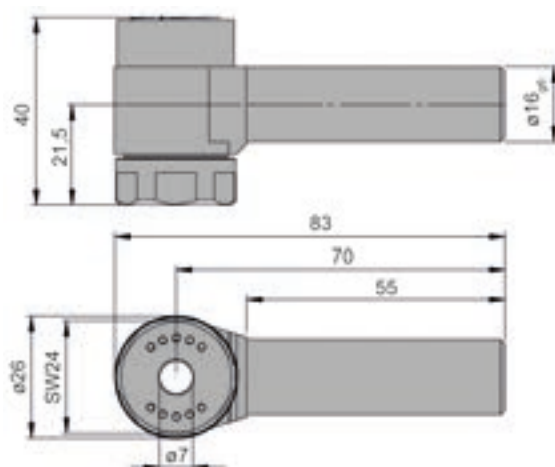
TB131

乳化液，油
Emulsion, Oil



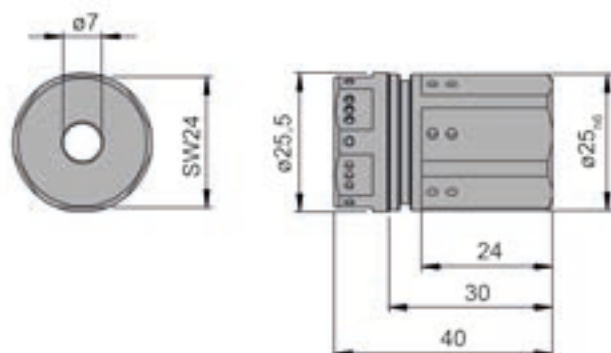
TB131-90

乳化液，油
Emulsion, Oil



TG131

压缩空气
Air mist



装配组件
Assembly kit

刀柄直径
Shank diameter

RK13M3

Ø 3 mm

RK13M4

Ø 4 mm

RK13M6

Ø 6 mm



D

装配组件
Assembly kit

刀柄直径
Shank diameter

AK13M3

Ø 3 mm

AK13M4

Ø 4 mm

AK13M6

Ø 6 mm



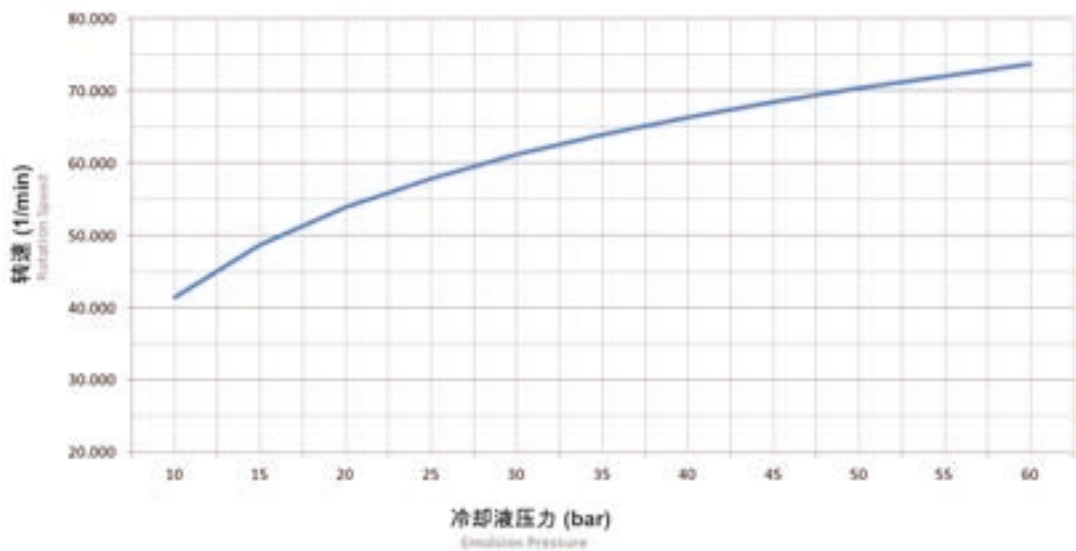
压力表
Pressure Manometer

PK25



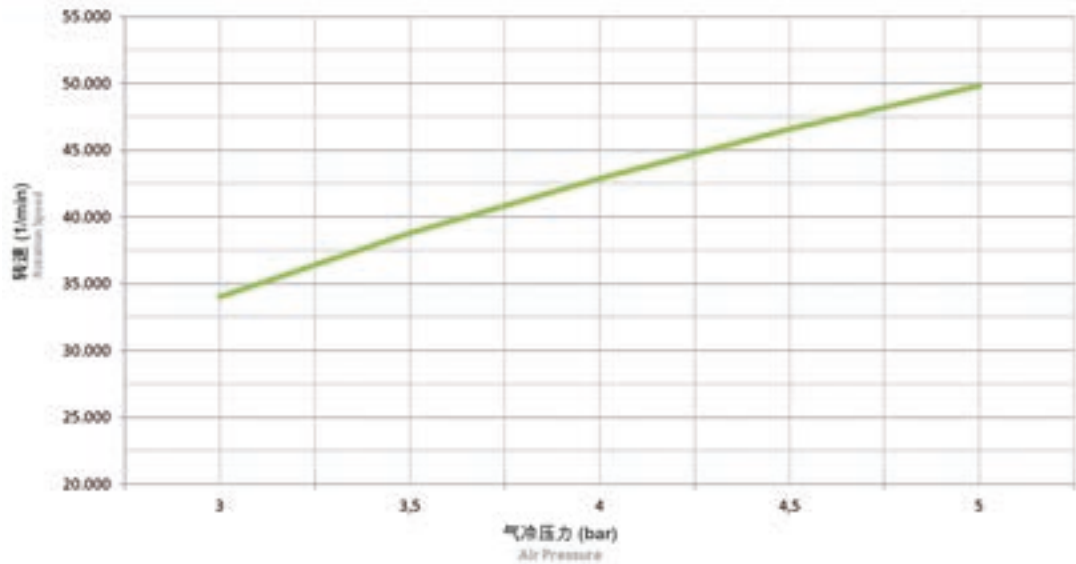
转速 / 冷却液压力 Toodle Blue TB131 & TB131-90

Rotation Speed / Emulsion Pressure



转速 / 气冷压力 Toodle Green TG131

Rotation Speed / Air pressure

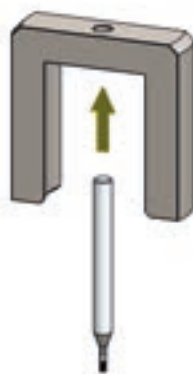




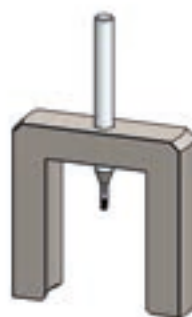
1.



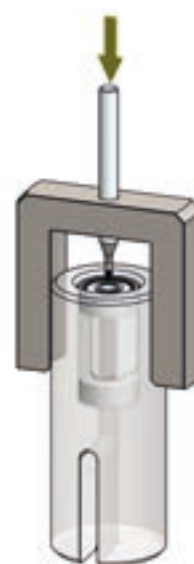
2.



3.



4.



5.



6.



7.

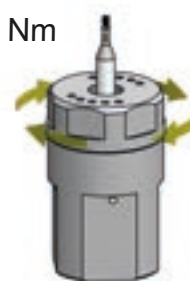


8.



9.

5-10 Nm



10.

刀柄的选择，参见样本
钻削和铰削

For suitable toolholders please see our catalogue
„Drilling and Reaming“

D



加工材料组 nach DIN ISO 513

Cutting Material Groups per DIN ISO 513

组别 Main group	标志	子组别 Subgroups
硬质合金 Carbide	HW	非涂层硬质合金, WC基体 uncoated carbides based upon WC
	HT	非涂层硬质合金, TiC/TiN-基体 (金属陶瓷) uncoated carbides based upon TiC/TiN (Cermets)
	HF	细微颗粒硬质合金 micro grane carbides
	HC	涂层硬质合金/金属陶瓷 coated carbides / cermets
陶瓷 Ceramic cutting material	CA	氧化物陶瓷, Al ₂ O ₃ -基体 Oxide ceramics based upon Al ₂ O ₃
	CM	混合陶瓷, Al ₂ O ₃ + 金属碳化物-基体 Mixed ceramics based upon Al ₂ O ₃ + metal carbide
	CN	氮化物陶瓷, Si ₃ N ₄ -基体 Nitride ceramics based upon Si ₃ N ₄
	CC	涂层陶瓷 Coated ceramics
金刚石 Diamond	DM	单晶金刚石 (MCD) Monocrystalline diamond (MCD)
	DP	立方金刚石 (PCD) Polycrystalline diamond (PCD)
氮化硼 Boron nitride	BN	立方氮化硼 (CBN) Polycrystalline, cubic boron nitride (PCBN)

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