

PH HORN PH



NEW

## DS 钛合金系列

更高性能的钛合金加工,全新的硬质合金材质IG3I

## DS TITAN RANGE

New carbide grade IG3I for more performance in titanium machining



# 不同之处： 更多可能

## THE DIFFERENCE: MORE POSSIBILITIES

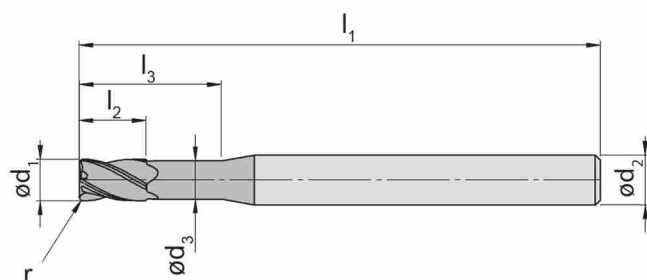
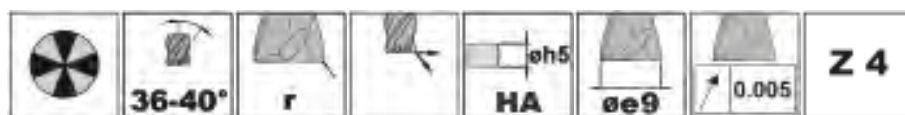
- **高稳定性的切削刃口**  
High cutting edge stability
- **轻快的切削槽型**  
Soft cutting geometry
- **震动倾向性低**  
Low vibration tendency

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	γ	形式 Form	IG3I
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	8	10	4.75	6	50	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

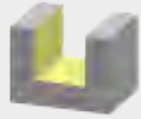
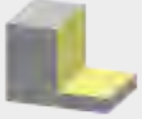

P	○
M	●
K	-
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S	●
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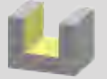
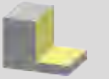

硬质合金牌号  
Carbide grades

# 切削参数 DSRV Ø 2 - 5 mm

Cutting Data DSRV Ø 2 - 5 mm



	 vc = m/min	 vc = m/min	 vc = m/min
M1.1	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 <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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

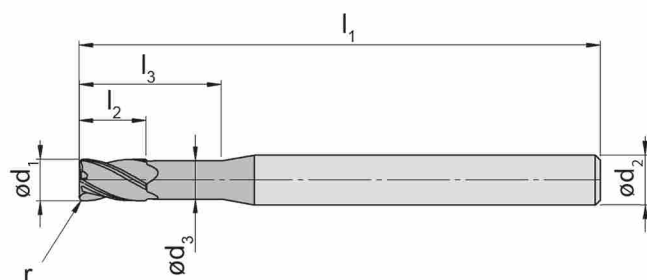
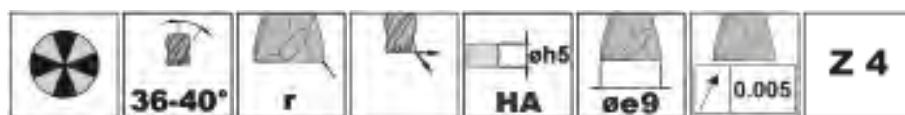
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	形式 Form	IG3I
DSRV.4.060.010.20	6	0.1	9	12	5.7	6	50	4	HA	▲
DSRV.4.060.010.30	6	0.1	13	18	5.7	6	57	4	HA	▲
DSRV.4.060.020.20	6	0.2	9	12	5.7	6	50	4	HA	▲
DSRV.4.060.020.30	6	0.2	13	18	5.7	6	57	4	HA	▲
DSRV.4.060.050.20	6	0.5	9	12	5.7	6	50	4	HA	▲
DSRV.4.060.050.30	6	0.5	13	18	5.7	6	57	4	HA	▲
DSRV.4.060.100.20	6	1.0	9	12	5.7	6	50	4	HA	▲
DSRV.4.060.100.30	6	1.0	13	18	5.7	6	57	4	HA	▲
DSRV.4.080.010.20	8	0.1	12	16	7.6	8	58	4	HA	▲
DSRV.4.080.010.30	8	0.1	17	24	7.6	8	63	4	HA	▲
DSRV.4.080.020.20	8	0.2	12	16	7.6	8	58	4	HA	▲
DSRV.4.080.020.30	8	0.2	17	24	7.6	8	63	4	HA	▲
DSRV.4.080.050.20	8	0.5	12	16	7.6	8	58	4	HA	▲
DSRV.4.080.050.30	8	0.5	17	24	7.6	8	63	4	HA	▲
DSRV.4.080.100.20	8	1.0	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

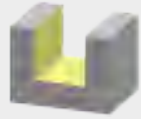
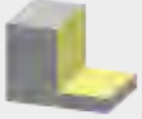

P	○
M	●
K	-
N	-
S	●
H	-

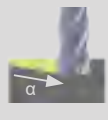



硬质合金牌号  
Carbide grades

# 切削参数 DSRV Ø 6 - 8 mm

Cutting Data DSRV Ø 6 - 8 mm



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

d <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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

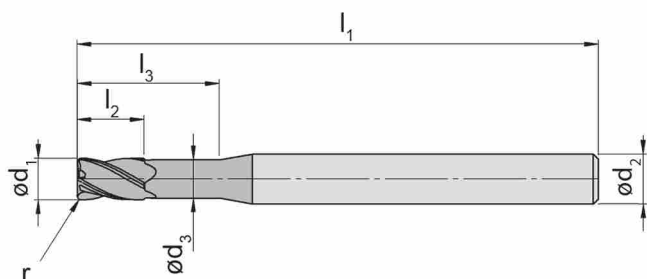
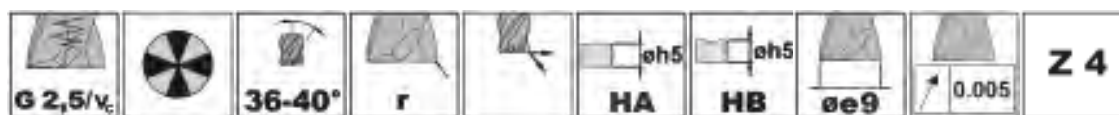
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	形式 Form	IG3I
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

○ 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	-

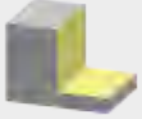
硬质合金牌号  
Carbide grades



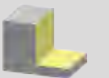



# 切削参数 DSRV Ø 10 mm

## 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 <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.040	10.00	10.00	0.060	2.00	15.00	0.215	0.50	15.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00
10	5°	0.032	10.00	10.00	0.054	2.00	20.00	0.194	0.50	20.00

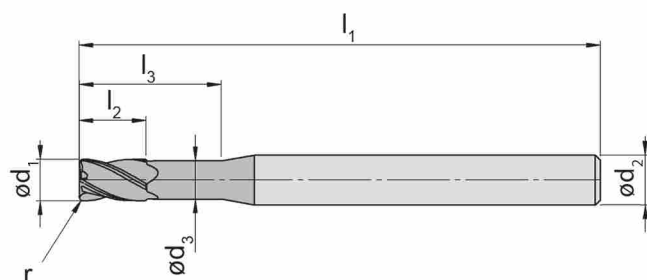
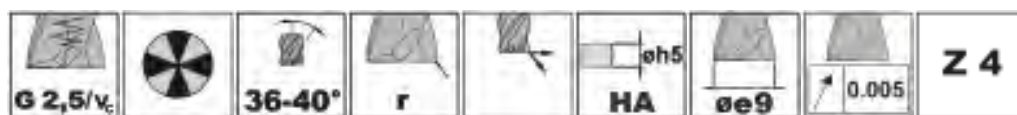
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	形式 Form	[G3]
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.4.120.300.20	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	▲
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	▲

▲ 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	-


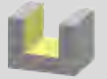
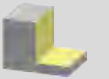

硬质合金牌号  
Carbide grades

# 切削参数 DSRV Ø 12 mm

## Cutting Data DSRV Ø 12 mm



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

d <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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

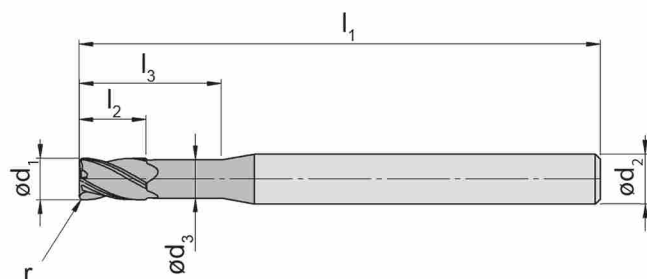
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	形式 Form	IG3I
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.4.160.150.20B	16	1.5	24	32	15.2	16	82	4	HB	▲
DSRV.4.160.150.30	16	1.5	34	48	15.2	16	100	4	HA	▲
DSRV.4.160.150.30B	16	1.5	34	48	15.2	16	100	4	HB	▲
DSRV.4.160.200.20	16	2.0	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

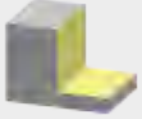
P	○
M	●
K	-
N	-
S	●
H	-



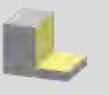
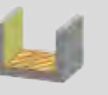
硬质合金牌号  
Carbide grades

# 切削参数 DSRV Ø 16 mm

Cutting Data DSRV Ø 16 mm



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

d <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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

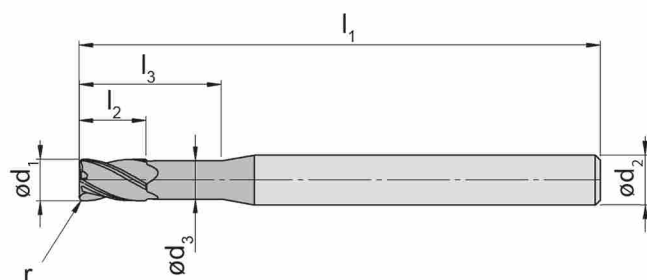
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	形式 Form	IG3I
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	42	60	19	20	120	4	HA	▲
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	HB	▲
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

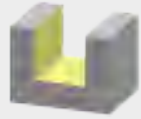
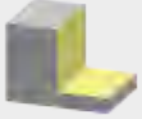

P	○
M	●
K	-
N	-
S	●
H	-

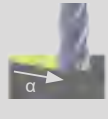



硬质合金牌号  
Carbide grades

# 切削参数 DSRV Ø 16 mm

## Cutting Data DSRV Ø 16 mm



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

d <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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	0.385	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

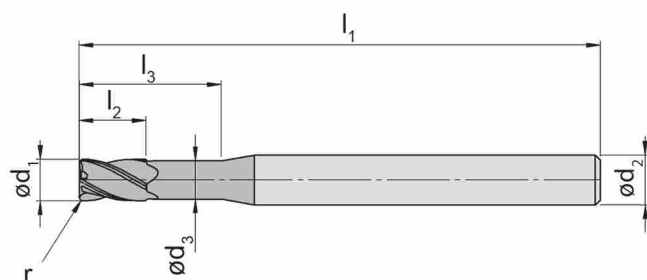
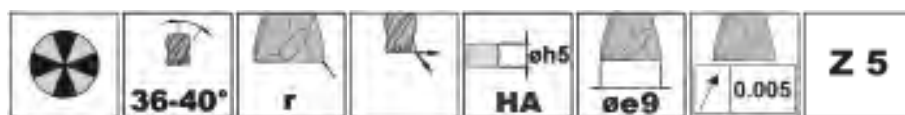
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	γ	形式 Form	IG3I
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	-

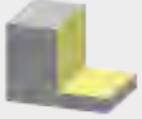

硬质合金牌号  
Carbide grades


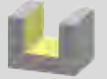
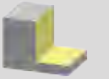



# 切削参数 DSRV Ø 2 - 5 mm

Cutting Data DSRV Ø 2 - 5 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 <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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
5	3°	0.019	5.00	5.00	0.028	1.00	7.50	0.099	0.25	7.50
5	3°	0.015	5.00	5.00	0.021	1.00	10.00	0.089	0.25	10.00
5	3°	0.019	5.00	5.00	0.028	1.00	7.50	0.099	0.25	7.50
5	3°	0.015	5.00	5.00	0.021	1.00	10.00	0.089	0.25	10.00
5	3°	0.019	5.00	5.00	0.028	1.00	7.50	0.099	0.25	7.50
5	3°	0.015	5.00	5.00	0.021	1.00	10.00	0.089	0.25	10.00
5	3°	0.019	5.00	5.00	0.028	1.00	7.50	0.099	0.25	7.50
5	3°	0.015	5.00	5.00	0.021	1.00	10.00	0.089	0.25	10.00

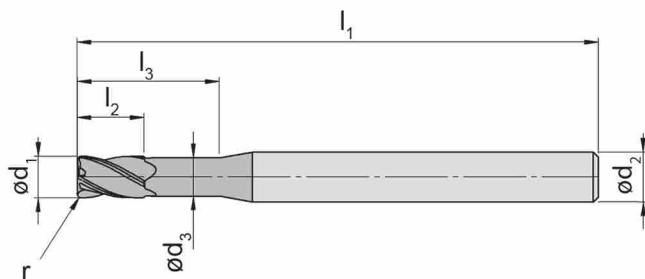
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	形式 Form	IG3I
DSRV.5.060.010.20	6	0.1	9	12	5.7	6	50	5	HA	▲
DSRV.5.060.010.30	6	0.1	13	18	5.7	6	57	5	HA	▲
DSRV.5.060.020.20	6	0.2	9	12	5.7	6	50	5	HA	▲
DSRV.5.060.020.30	6	0.2	13	18	5.7	6	57	5	HA	▲
DSRV.5.060.050.20	6	0.5	9	12	5.7	6	50	5	HA	▲
DSRV.5.060.050.30	6	0.5	13	18	5.7	6	57	5	HA	▲
DSRV.5.060.100.20	6	1.0	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

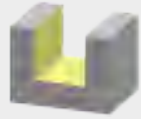
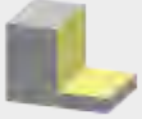

P	○
M	●
K	-
N	-
S	●
H	-


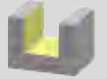
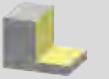

硬质合金牌号  
Carbide grades

# 切削参数 DSRV Ø 6 - 8 mm

Cutting Data DSRV Ø 6 - 8 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 <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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

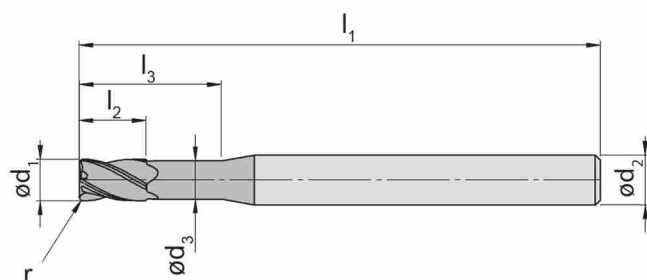
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	形式 Form	IG3I
DSRV.5.100.010.20	10	0.1	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.010.20B	10	0.1	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.010.30	10	0.1	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.010.30B	10	0.1	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.020.20	10	0.2	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.020.20B	10	0.2	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.020.30	10	0.2	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.020.30B	10	0.2	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.050.20	10	0.5	15	20	9.5	10	66	5	HA	▲
DSRV.5.100.050.20B	10	0.5	15	20	9.5	10	66	5	HB	▲
DSRV.5.100.050.30	10	0.5	21	30	9.5	10	72	5	HA	▲
DSRV.5.100.050.30B	10	0.5	21	30	9.5	10	72	5	HB	▲
DSRV.5.100.100.20	10	1.0	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

○ 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

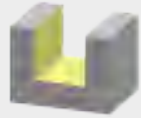
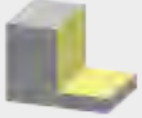

P	○
M	●
K	-
N	-
S	●
H	-





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
<b>M1.1</b>	100	130	190
<b>M2.1</b>	80	100	150
<b>M3.1</b>	70	90	130
<b>S1.1</b>	60	80	120
<b>S2.1</b>	40	50	70
<b>S3.1</b>	33	40	60

d <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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

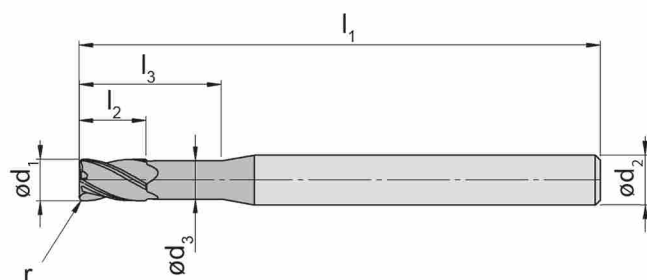
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	形式 Form	IG3I
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

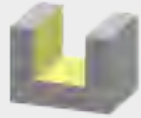
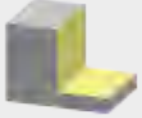
P	○
M	●
K	-
N	-
S	●
H	-





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
<b>M1.1</b>	100	130	190
<b>M2.1</b>	80	100	150
<b>M3.1</b>	70	90	130
<b>S1.1</b>	60	80	120
<b>S2.1</b>	40	50	70
<b>S3.1</b>	33	40	60

d <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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

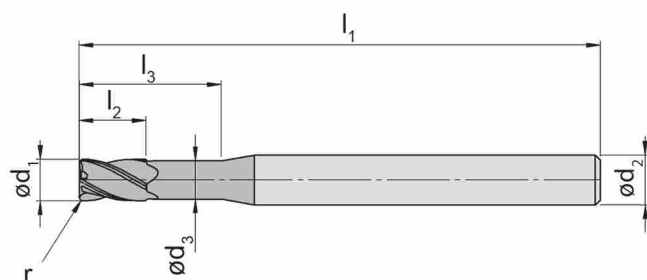
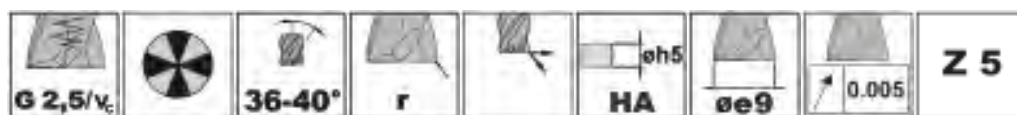
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	形式 Form	IG3I
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.5.160.200.30	16	2.0	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.200.30B	16	2.0	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.250.20	16	2.5	24	32	15.2	16	82	5	HA	▲
DSRV.5.160.250.20B	16	2.5	24	32	15.2	16	82	5	HB	▲
DSRV.5.160.250.30	16	2.5	34	48	15.2	16	100	5	HA	▲
DSRV.5.160.250.30B	16	2.5	34	48	15.2	16	100	5	HB	▲
DSRV.5.160.300.20	16	3.0	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	HB	▲
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	-

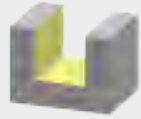
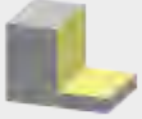

硬质合金牌号  
Carbide grades



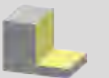



# 切削参数 DSRV Ø 16 mm

Cutting Data DSRV Ø 16 mm



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

d <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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

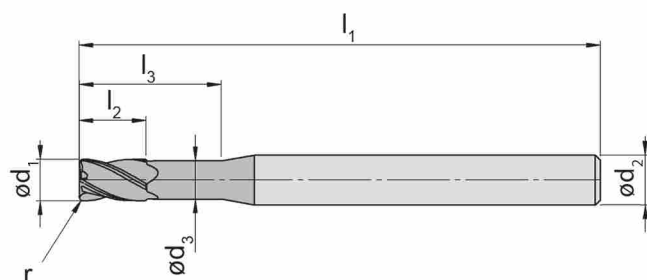
尺寸单位 : mm  
Dimensions in mm

# 立铣刀, 带圆角

## End Mill, corner radius



### DSRV



产品型号 Part number	d <sub>1</sub>	r	l <sub>2</sub>	l <sub>3</sub>	d <sub>3</sub>	d <sub>2</sub>	l <sub>1</sub>	Z	形式 Form	IG3I
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.5.200.250.20	20	2.5	30	40	19	20	92	5	HA	▲
DSRV.5.200.250.20B	20	2.5	30	40	19	20	92	5	HB	▲
DSRV.5.200.250.30	20	2.5	42	60	19	20	120	5	HA	▲
DSRV.5.200.250.30B	20	2.5	42	60	19	20	120	5	HB	▲
DSRV.5.200.300.20	20	3.0	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

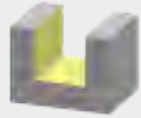
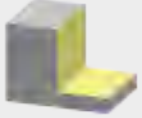

P	○
M	●
K	-
N	-
S	●
H	-





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
<b>M1.1</b>	100	130	190
<b>M2.1</b>	80	100	150
<b>M3.1</b>	70	90	130
<b>S1.1</b>	60	80	120
<b>S2.1</b>	40	50	70
<b>S3.1</b>	33	40	60

d <sub>1</sub>										
		f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>	f <sub>z</sub>	a <sub>e</sub>	a <sub>p</sub>
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

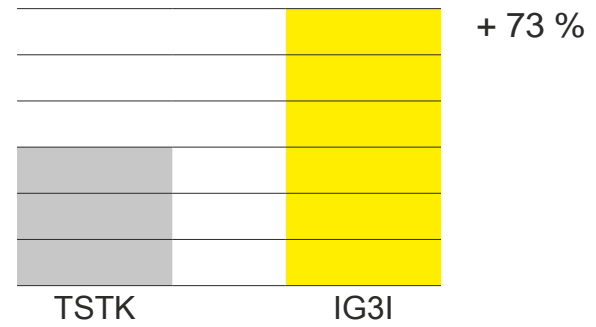
## 刀具寿命测试

Tool life test

立铣刀: DSRV  
Milling Cutter: Ø 12 mm  
Z4

材料: Ti6Al4V  
Material:

切削参数:  $v_c$  80 m/min  
Cutting data:  $f_z$  0,085 mm  
 $a_e$  3 mm  
 $a_p$  24 mm



### 技术参数

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

### Technical data

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

	中心切削 Centre cutting		水平切削 Diving horizontal
	Z 1 齿数 Number of teeth		水平切削, 破走, 螺旋插补 Diving, ramping, helical
	G 2,5/v <sub>c</sub> 动平衡 Balance quality		水平切削, 破走, 螺旋插补, 插铣 Diving, ramping, helical, vertical
	0° 螺旋角 Helix angle		轮廓误差 Form tolerance
	r 圆角 Corner radius		公差 Tolerance
	r <sub>th</sub> 理论圆角 Radius theoretic		柄部标准 DIN 6535 HA Shank DIN 6535 HA
	bx45° 倒角 Corner chamfer		柄部标准 DIN 6535 HB Shank DIN 6535 HB
	球刀 Full radius		跳动 Concentricity
	锋利 Sharp		内冷 Internal cooling
	槽铣 Slot milling		摆线铣 Trochoidal milling
	侧铣 Corner milling		破走铣 Diving
	仿形铣 Copy milling		有效长度 Effective neck length

# 材料概述

## Material Overview



	材料	Material			硬度 / Hardness
<b>P1.1</b>	碳钢	Carbon steel	0,2% C		140 HB
<b>P1.2</b>	碳钢	Carbon steel	0,4% C		180 HB
<b>P1.3</b>	碳钢	Carbon steel	0,6% C		200 HB
<b>P2.1</b>	合金钢	Alloyed steel	退火	annealed	180 HB
<b>P2.2</b>	合金钢	Alloyed steel	调质	quenched	280 HB
<b>P2.3</b>	合金钢	Alloyed steel	调质	quenched	350 HB
<b>P3.1</b>	高合金钢	High alloyed steel	退火	annealed	200 HB
<b>P3.2</b>	高合金钢	High alloyed steel	调质	quenched	325 HB
<b>M1.1</b>	不锈钢	Stainless steel	马氏体, 铁素体	martensitic, ferritic	200 HB
<b>M2.1</b>	不锈钢	Stainless steel	奥氏体	austenitic	180 HB
<b>M3.1</b>	不锈钢	Stainless steel	奥氏体, 铁素体	austenitic, ferritic	260 HB
<b>K1.1</b>	灰铁	Grey cast iron	抗拉强度低	low tensile strength	180 HB
<b>K1.2</b>	灰铁	Grey cast iron	抗拉强度高	high tensile strength	250 HB
<b>K2.1</b>	球铁	Spheroidal graphite cast iron	铁素体	ferritic	160 HB
<b>K2.2</b>	球铁	Spheroidal graphite cast iron	珠光体	perlitic	250 HB
<b>K3.1</b>	可锻铸铁	Malleable cast iron	铁素体	ferritic	125 HB
<b>K3.2</b>	可锻铸铁	Malleable cast iron	珠光体	perlitic	225 HB
<b>N1.1</b>	铝合金	Aluminum alloys	不可热处理	not heat treatable	80 HB
<b>N1.2</b>	铝合金	Aluminum alloys	可热处理	heat treatable	120 HB
<b>N2.1</b>	铸铝	Cast Aluminum	< 6% Si	< 6% Si	
<b>N2.2</b>	铸铝	Cast Aluminum	6 - 10% Si	6 - 10% Si	
<b>N2.3</b>	铸铝	Cast Aluminum	10 - 15% Si	10 - 15% Si	
<b>N3.1</b>	铜合金	Copper alloys	不可热处理	not heat treatable	90 HB
<b>N3.2</b>	铜合金	Copper alloys	可热处理	heat treatable	100 HB
<b>N4.1</b>	合成材料	Synthetics			
<b>S1.1</b>	钛合金	Titanium alloys			280 HB
<b>S2.1</b>	镍合金	Nickel-base alloys			450 HB
<b>S3.1</b>	钴合金	Cobalt-base alloys			450 HB
<b>H1.1</b>	淬硬钢	Hardened steels			50-55 HRC
<b>H1.2</b>	淬硬钢	Hardened steels			56-59 HRC
<b>H1.3</b>	淬硬钢	Hardened steels			60-63 HRC
<b>H1.4</b>	淬硬钢	Hardened steels			> 63 HRC

更多信息详见“立铣刀”样本

Further products can be found in our catalogue  
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**整体硬质合金立铣刀**  
**Solid Carbide Mills**

**2020**

ph HORN ph

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