



G-PAK 14.2

切削刀具 新产品
CUTTING TOOLS NEW PRODUCTS



厦门金鹭特种合金有限公司
Xiamen Golden Egret Special Alloy Co.,Ltd.

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SOLID CARBIDE ENDMILLS

整体硬质合金立铣刀

ST200 钛合金加工立铣刀系列

ST200 Endmills Optimized for Titanium Alloys



特点 Features

- 适用于航空钛合金材料的高性能加工
Suitable for high performance machining of aerospace titanium alloys.
- 采用超细晶基体、专用R涂层及先进刃口处理技术，有效延长刀具使用寿命
Ultra-fine cemented carbide substrate, special R coating and advanced edge processing, prolong tool life.
- 不等齿距、不等导程设计，大幅提升抗振性能，卓越的工件表面质量
Variable helix angle and differential flute pitch, reduces and eliminates vibration, and improves surface quality.
- 特别适用于大切深小切宽的侧铣、型腔铣加工
Design for large depth & small width in side milling and cavity milling.

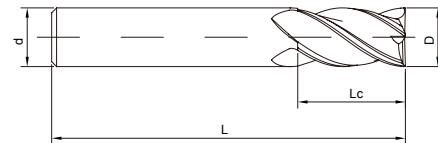
钛合金
For Titanium Alloy



ST200-S4

4刃平头

4Flute, Standard Length



订货号 Ordering code	D	Lc	L	d
ST200-S4-08016	8	16	60	8
ST200-S4-10020	10	20	70	10
ST200-S4-12024	12	24	75	12
ST200-S4-16032	16	32	90	16
ST200-S4-20040	20	40	100	20

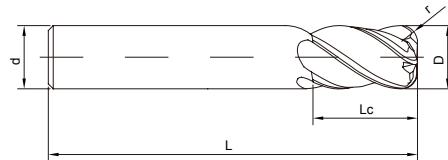
D	公差 Tol
D≤16	-0.03
D > 16	-0.04

单位unit (mm)

工件材料 Workpiece Material						
P			M	S		
4	5	6	1 2 3	4		
合金钢 Alloy Steel (<35HRC)	合金钢 Alloy Steel (35~48 HRC)	PH与铁素体/马氏体不锈钢 PH & Ferrite/ Martensite Stainless Steel (<35HRC)	不锈钢 Stainless Steel	TA (α 相合金) α Phase Alloy	TC (α 相和 β 相合金) α & β Phase Alloy	TB (β 相合金) β Phase Alloy
<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>

○ 最适合 Most Suitable ○ 适合 Suitable

钛合金
For Titanium Alloy



ST200-R4

4刃圆角头

4 Flute, Corner Radius

订货号 Ordering code	D	r	Lc	L	d
ST200-R4-10010	10	1	25	70	10
ST200-R4-12010	12	1	30	75	12
ST200-R4-16010	16	1	36	90	16
ST200-R4-16020	16	2	36	90	16
ST200-R4-20010	20	1	45	100	20
ST200-R4-20020	20	2	45	100	20
ST200-R4-20030	20	3	45	100	20
ST200-R4-25030	25	3	50	110	25

D	公差 Tol
D≤16	0 -0.03
D>16	0 -0.04

单位 unit (mm)

工件材料 Workpiece Material						
P			M	S		
4	5	6	1 2 3	4		
合金钢 Alloy Steel (<35HRC)	合金钢 Alloy Steel (35~48 HRC)	PH与铁素体/马素体不锈钢 PH & Ferrite Martensite Stainless Steel (<35HRC)	不锈钢 Stainless Steel	TA (α 相合金) α Phase Alloy	TC (α 相和 β 相合金) α & β Phase Alloy	TB (β 相合金) β Phase Alloy
○	○	○	○	○	○	○

○ 最适合 Most Suitable ○ 适合 Suitable

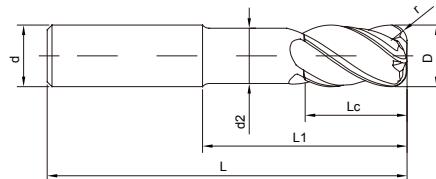
钛合金
For Titanium Alloy



ST200-RN4

4刃长颈圆角头

4 Flute, Corner Radius, with Reduced Neck



订货号 Ordering code	D	r	Lc	L1	d2	L	d
ST200-RN4-10010	10	1	20	35	9	75	10
ST200-RN4-12010	12	1	24	45	11	90	12
ST200-RN4-16010	16	1	32	50	15	100	16
ST200-RN4-16020	16	2	32	50	15	100	16
ST200-RN4-16030	16	3	32	50	15	100	16
ST200-RN4-20010	20	1	40	60	19	110	20
ST200-RN4-20020	20	2	40	60	19	110	20
ST200-RN4-20030	20	3	40	60	19	110	20
ST200-RN4-25030	25	3	50	70	24	130	25

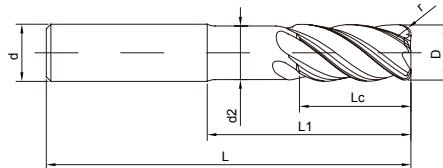
D	公差 Tol
D ≤ 16	0 -0.03
D > 16	0 -0.04

单位 unit (mm)

工件材料 Workpiece Material						
P			M	S		
4	5	6	1 2 3	4		
合金钢 Alloy Steel (<35HRC)	合金钢 Alloy Steel (35–48 HRC)	PH与铁素体/马氏体不锈钢 PH & Ferrite/ Martensite Stainless Steel (<35HRC)	不锈钢 Stainless Steel	TA (α 相合金) α Phase Alloy	TC (α 相和 β 相合金) α & β Phase Alloy	TB (β 相合金) β Phase Alloy
○	○	○	○	○	○	○

○ 最适合 Most Suitable ○ 适合 Suitable

钛合金
For Titanium Alloy



ST200-RN5

5刃长颈圆角头

5 Flute, Corner Radius, with Reduced Neck

订货号 Ordering code	D	r	Lc	L1	d2	L	d
ST200-RN5-16010	16	1	32	50	15	100	16
ST200-RN5-16020	16	2	32	50	15	100	16
ST200-RN5-20010	20	1	40	60	19	110	20
ST200-RN5-20020	20	2	40	60	19	110	20
ST200-RN5-20030	20	3	40	60	19	110	20
ST200-RN5-25030	25	3	50	70	24	130	25

D	公差 Tol
D≤16	0 -0.03
D > 16	0 -0.04

单位 unit (mm)

工件材料 Workpiece Material							
P			M		S		
4	5	6	1 2 3	4			
合金钢 Alloy Steel (<35HRC)	合金钢 Alloy Steel (35~48 HRC)	PH与铁素体/马氏体不锈钢 PH & Ferrite Martensite Stainless Steel (<35HRC)	不锈钢 Stainless Steel	TA (α 相合金) α Phase Alloy	TC (α 相和 β 相合金) α & β Phase Alloy	TB (β 相合金) β Phase Alloy	
○	○	○	○	○	○	○	○

○ 最适合 Most Suitable ○ 适合 Suitable

推荐切削参数

Recommended Cutting Data

工件材料 Workpiece Material				切削速度 Cutting Speed (m/min)			刃径 Tool Diameter (mm)					
		a_p	a_e	最小 Min	较好 Optimum	最大 Max	mm	10	12	16	20	25
P	P4	$\leq 1.5xD$	$\leq 0.2xD$	70	95	120	fz	0.07	0.08	0.08	0.1	0.12
	P5	$\leq 1.5xD$	$\leq 0.2xD$	70	95	120	fz	0.07	0.08	0.08	0.1	0.12
	P6	$\leq 1.5xD$	$\leq 0.2xD$	70	90	120	fz	0.07	0.08	0.08	0.1	0.1
M	M1	$\leq 1.5xD$	$\leq 0.1xD$	65	80	110	fz	0.07	0.08	0.08	0.1	0.1
	M2	$\leq 1.5xD$	$\leq 0.1xD$	65	80	110	fz	0.07	0.08	0.08	0.1	0.1
	M3	$\leq 1.5xD$	$\leq 0.1xD$	60	75	100	fz	0.07	0.08	0.08	0.1	0.1
S	TA	$\leq 1.5xD$	$\leq 0.1xD$	60	75	100	fz	0.06	0.07	0.08	0.1	0.1
	TC	$\leq 1.5xD$	$\leq 0.1xD$	60	70	100	fz	0.06	0.07	0.08	0.1	0.1
	TB	$\leq 1.5xD$	$\leq 0.1xD$	40	45	60	fz	0.06	0.07	0.08	0.1	0.1

工件材料 Workpiece Material				切削速度 Cutting Speed (m/min)			刃径 Tool Diameter (mm)					
		a_p	a_e	最小 Min	较好 Optimum	最大 Max	mm	10	12	16	20	25
P	P4	$\leq 0.8xD$	70	90	120	fz	0.07	0.08	0.08	0.1	0.1	
	P5	$\leq 0.8xD$	70	90	120	fz	0.06	0.08	0.08	0.1	0.1	
	P6	$\leq 0.8xD$	70	85	120	fz	0.06	0.08	0.08	0.09	0.09	
M	M1	$\leq 0.5xD$	60	80	110	fz	0.06	0.08	0.08	0.09	0.09	
	M2	$\leq 0.5xD$	60	80	110	fz	0.06	0.08	0.08	0.09	0.09	
	M3	$\leq 0.5xD$	50	75	100	fz	0.06	0.08	0.08	0.09	0.09	
S	TA	$\leq 0.3xD$	50	75	100	fz	0.06	0.07	0.08	0.09	0.09	
	TC	$\leq 0.3xD$	50	70	100	fz	0.06	0.07	0.08	0.09	0.09	
	TB	$\leq 0.25xD$	30	45	60	fz	0.06	0.07	0.07	0.09	0.09	

1.请使用大功率高刚性的机床，建议采用强力铣削刀柄。

Make sure workpiece and machine are suitable, use high quality collet chucks.

2.请根据切削速度、设备刚性等情况可适当调整转速和进给速度。

Please adjust the speed, feed and cutting depth according to actual cutting conditions.

3.上表按照刀具悬长为直径3倍以下是所制订的，如果刀具悬长过长，加工时易产生振动，此时，请适当调整转速、进给速度和切深量。

The milling conditions are for an endmill where the tool overhang length is less than 3D. When the tool overhang length is longer, please adjust the speed, feed and cutting depth.

ST260 钛合金内冷加工立铣刀系列

ST260 Endmills Optimized for Titanium Alloys



特点 Features

- 适用于航空钛合金材料的高性能内冷加工
Suitable for high performance machining of aerospace titanium alloys.
- 不等齿距、不等导程设计，大幅提升抗振性能，切削更加稳定
Variable helix angle and differential flute pitch, reduces and eliminates vibration, cutting more stably.
- 采用独特的Y型内冷孔设计，发挥优异冷却效果，排屑更顺畅
Special Y type internal cooling holes design, excellent cooling effect, smooth chip evacuation.
- 与ST200系列相比，允许更大的切削速度和切削深度，刀具寿命更长
Comparing with ST200, allows higher cutting speed & cutting depth and longer tool life.

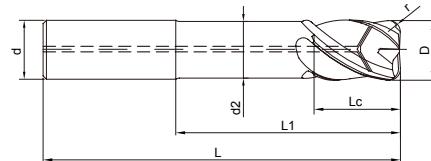
钛合金
For Titanium Alloy



ST260-RN4

4刃长颈圆角头

4 Flute, Corner Radius, with Reduced Neck



订货号 Ordering code	D	r	Lc	L1	d2	L	d
ST260-RN4-16010	16	1	32	50	15	100	16
ST260-RN4-16020	16	2	32	50	15	100	16
ST260-RN4-16030	16	3	32	50	15	100	16
ST260-RN4-20010	20	1	40	60	19	115	20
ST260-RN4-20020	20	2	40	60	19	115	20
ST260-RN4-20030	20	3	40	60	19	115	20
ST260-RN4-25030	25	3	50	65	24	130	25

D	公差 Tol
D≤16	0 -0.03
D > 16	0 -0.04

单位 unit (mm)

工件材料 Workpiece Material							
P			M	S			
4	5	6	1 2 3	4			
合金钢 Alloy Steel (<35HRC)	合金钢 Alloy Steel (35–48 HRC)	PH与铁素体/马氏体不锈钢 PH & Ferrite/ Martensite Stainless Steel (<35HRC)	不锈钢 Stainless Steel	TA (α 相合金) α Phase Alloy	TC (α 相和 β 相合金) α & β Phase Alloy	TB (β 相合金) β Phase Alloy	
<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>

○ 最适合 Most Suitable ○ 适合 Suitable

推荐切削参数

Recommended Cutting Data

工件材料 Workpiece Material				切削速度 Cutting Speed (m/min)			刃径 Tool Diameter (mm)			
		a_p	a_e	最小 Min	较好 Optimum	最大 Max	mm	16	20	25
P	P4	$\leq 1.5xD$	$\leq 0.3xD$	80	100	140	fz	0.08	0.1	0.1
	P5	$\leq 1.5xD$	$\leq 0.3xD$	80	100	140	fz	0.08	0.1	0.1
	P6	$\leq 1.5xD$	$\leq 0.3xD$	80	95	140	fz	0.08	0.095	0.095
M	M1	$\leq 1.5xD$	$\leq 0.2xD$	70	85	120	fz	0.08	0.095	0.095
	M2	$\leq 1.5xD$	$\leq 0.2xD$	70	85	120	fz	0.08	0.095	0.095
	M3	$\leq 1.5xD$	$\leq 0.2xD$	60	85	120	fz	0.08	0.095	0.095
S	TA	$\leq 1.5xD$	$\leq 0.2xD$	60	85	120	fz	0.08	0.095	0.095
	TC	$\leq 1.5xD$	$\leq 0.2xD$	60	80	120	fz	0.08	0.095	0.095
	TB	$\leq 1.5xD$	$\leq 0.2xD$	40	50	60	fz	0.08	0.095	0.095

工件材料 Workpiece Material				切削速度 Cutting Speed (m/min)			刃径 Tool Diameter (mm)			
		a_p		最小 Min	较好 Optimum	最大 Max	mm	16	20	25
P	P4	$\leq 1.0xD$		75	90	130	fz	0.08	0.1	0.1
	P5	$\leq 1.0xD$		75	90	130	fz	0.08	0.1	0.1
	P6	$\leq 1.0xD$		75	85	130	fz	0.08	0.09	0.09
M	M1	$\leq 0.8xD$		65	80	120	fz	0.08	0.09	0.09
	M2	$\leq 0.8xD$		65	80	120	fz	0.08	0.09	0.09
	M3	$\leq 0.6xD$		55	75	110	fz	0.08	0.09	0.09
S	TA	$\leq 0.4xD$		55	75	110	fz	0.08	0.09	0.09
	TC	$\leq 0.4xD$		55	70	110	fz	0.08	0.09	0.09
	TB	$\leq 0.3xD$		40	50	60	fz	0.07	0.09	0.09

1.请使用大功率高刚性的机床，建议采用强力铣削刀柄

Make sure workpiece and machine are suitable, use high quality collet chucks.

2.请根据切削速度、设备刚性等情况可适当调整转速和进给速度

Please adjust the speed, feed and cutting depth according to actual cutting conditions.

3.上表按照刀具悬长为直径3倍以下所制订的，如果刀具悬长过长，加工时易产生振动，此时，请适当调整转速、进给速度和切深量

The milling conditions are for an endmill where the tool overhang length is less than 3D. When the tool overhang length is longer, please adjust the speed, feed and cutting depth.

ST300 钛合金高效内冷加工立铣刀系列

ST300 High Performance Endmills Optimized for Titanium Alloys



特点

Features

- 适用于航空钛合金材料的高效加工
Suitable for high efficiency machining of aerospace titanium alloys.
- 采用超细晶基体、专用R涂层及先进刃口处理技术，使用寿命更长
Ultra-fine cemented carbide substrate, special R coating and advanced edge processing technology, superior wear resistance, longer tool life.
- 不等距排屑空间、圆弧清边设计，优异减震效果，表面精度高
Unequal flute spacing and eccentric relief design, super vibration reduction performance.
- 独特U型槽与内冷孔设计，超凡排屑性能，优异冷却效果，金属去除率更高
Specially internal cooling holes and U type flute design, excellent cooling effect and chip evacuation performance, high material removal rate.
- 可满足大切宽大切深的高效加工要求，并可实现粗精一体化加工
Apply for high efficiency machining at large depth&large width, allows roughing and finishing with one tool.

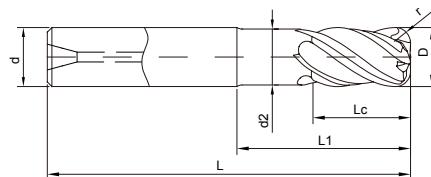
钛合金
For Titanium Alloy



ST300-RN4

4刃长颈圆角头

4 Flute, Corner Radius, with Reduced Neck



订货号 Ordering code	D	r	Lc	L1	d2	L	d
ST300-RN4-12030	12	3	24	45	11	90	16
ST300-RN4-16030	16	3	32	50	15	100	16
ST300-RN4-20010	20	1	40	55	19	115	20
ST300-RN4-20020	20	2	40	55	19	115	20
ST300-RN4-20030	20	3	40	55	19	115	20

D	公差 Tol
D≤16	0 -0.03
D>16	0 -0.04

单位 unit (mm)

工件材料 Workpiece Material							
P			M		S		
4	5	6	1 2 3	4			
合金钢 Alloy Steel (<35HRC)	合金钢 Alloy Steel (35~48 HRC)	PH与铁素体/马素体不锈钢 PH & Ferrite Martensite Stainless Steel (<35HRC)	不锈钢 Stainless Steel	TA (α 相合金) α Phase Alloy	TC (α 相和 β 相合金) α & β Phase Alloy	TB (β 相合金) β Phase Alloy	
<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>

最适合 Most Suitable 适合 Suitable

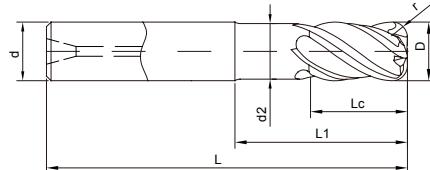
钛合金
For Titanium Alloy



ST300-RN5

5刃长颈圆角头

5 Flute, Corner Radius, with Reduced Neck



订货号 Ordering code	D	r	Lc	L1	d2	L	d
ST300-RN5-16010	16	1	32	50	15	100	16
ST300-RN5-16020	16	2	32	50	15	100	16
ST300-RN5-16030	16	3	32	50	15	100	16
ST300-RN5-20010	20	1	40	55	19	115	20
ST300-RN5-20020	20	2	40	55	19	115	20
ST300-RN5-20030	20	3	40	55	19	115	20
ST300-RN5-25030	25	3	50	65	24	130	25

D	公差 Tol
D≤16	0 -0.03
D > 16	0 -0.04

单位 unit (mm)

工件材料 Workpiece Material						
P			M	S		
4	5	6	1 2 3	4		
合金钢 Alloy Steel (<35HRC)	合金钢 Alloy Steel (35–48 HRC)	PH与铁素体/马素体不锈钢 PH & Ferrite/Martensite Stainless Steel (<35HRC)	不锈钢 Stainless Steel	TA (α 相合金) α Phase Alloy	TC (α 相和 β 相合金) α & β Phase Alloy	TB (β 相合金) β Phase Alloy
○	○	○	○	○	○	○

○ 最适合 Most Suitable ○ 适合 Suitable

推荐切削参数

Recommended Cutting Data

工件材料 Workpiece Material				切削速度 Cutting Speed (m/min)			刃径 Tool Diameter (mm)				
		a_p	a_e	最小 Min	较好 Optimum	最大 Max	mm	12	16	20	25
P	P4	$\leq 1.5xD$	$\leq 0.3xD$	70	85	100	fz	0.075	0.08	0.1	0.1
	P5	$\leq 1.5xD$	$\leq 0.3xD$	70	85	100	fz	0.075	0.08	0.1	0.1
	P6	$\leq 1.5xD$	$\leq 0.3xD$	60	80	100	fz	0.075	0.08	0.095	0.095
M	M1	$\leq 1.5xD$	$\leq 0.2xD$	55	70	90	fz	0.07	0.08	0.095	0.095
	M2	$\leq 1.5xD$	$\leq 0.2xD$	55	70	90	fz	0.07	0.08	0.095	0.095
	M3	$\leq 1.5xD$	$\leq 0.2xD$	50	65	80	fz	0.07	0.08	0.095	0.095
S	TA	$\leq 1.5xD$	$\leq 0.2xD$	50	65	80	fz	0.07	0.08	0.095	0.095
	TC	$\leq 1.5xD$	$\leq 0.2xD$	50	60	80	fz	0.065	0.08	0.09	0.09
	TB	$\leq 1.5xD$	$\leq 0.2xD$	35	45	60	fz	0.065	0.07	0.09	0.09

工件材料 Workpiece Material				切削速度 Cutting Speed (m/min)			刃径 Tool Diameter (mm)				
		a_p		最小 Min	较好 Optimum	最大 Max	mm	12	16	20	25
P	P4	$\leq 1.0xD$		80	100	120	fz	0.075	0.09	0.1	0.1
	P5	$\leq 1.0xD$		80	100	120	fz	0.075	0.09	0.1	0.1
	P6	$\leq 1.0xD$		70	95	120	fz	0.075	0.08	0.095	0.095
M	M1	$\leq 1.0xD$		65	85	110	fz	0.07	0.08	0.095	0.095
	M2	$\leq 1.0xD$		65	85	110	fz	0.07	0.08	0.095	0.095
	M3	$\leq 1.0xD$		65	80	100	fz	0.07	0.08	0.095	0.095
S	TA	$\leq 1.0xD$		60	80	100	fz	0.07	0.08	0.095	0.095
	TC	$\leq 1.0xD$		60	80	100	fz	0.065	0.08	0.09	0.09
	TB	$\leq 0.8xD$		40	55	70	fz	0.065	0.07	0.09	0.09

1.请使用大功率高刚性的机床，建议采用强力铣削刀柄

Make sure workpiece and machine are suitable, use high quality collet chucks.

2.请根据切削速度、设备刚性等情况可适当调整转速和进给速度

Please adjust the speed, feed and cutting depth according to actual cutting conditions.

3.上表按照刀具悬长为直径3倍以下是所制订的，如果刀具悬长过长，加工时易产生振动，此时，请适当调整转速、进给速度和切深量

The milling conditions are for an endmill where the tool overhang length is less than 3D. When the tool overhang length is longer, please adjust the speed, feed and cutting depth.

SP210 普通钢高效加工立铣刀系列补充

Extension to SP210 High Efficiency Endmills for Steels & Cast Iron



特点 Features

- 适用普通钢、铸铁的高速精加工、半精加工
High speed precision of steels, cast iron, suitable for semi-finish machining.
- 独特的刃型设计，能防止振动、保证了高刚性进给
Special edge design, reduces vibration.
- 特殊的底刃处理，实现良好的精加工面
Special geometry of end cutting edge, good surface quality.
- 高精度的球头轮廓
Ball nose profile high accuracy.
- 推荐使用气冷或油雾冷却
Recommended to use air or oil mist cooling.

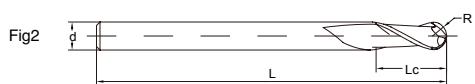
钢件、铸铁
For Steels & Cast Iron



SP210-B2

2刃球头

2 Flute, Ballnose



订货号 Ordering code	D	R	Lc	L	d	图号 Figure No.
SP210-B2-01002	1	0.5	2	50	4	1
SP210-B2-02004	2	1	4	50	4	1
SP210-B2-03006	3	1.5	6	50	4	1
SP210-B2-04008	4	2	8	50	4	2
SP210-B2-06012	6	3	12	50	6	2
SP210-B2-08014	8	4	14	50	8	2
SP210-B2-10018	10	5	18	75	10	2
SP210-B2-12022	12	6	22	75	12	2

R	公差 Tol
R < 3	± 0.005
R ≥ 3	± 0.010

单位 unit (mm)

工件材料 Workpiece Material					
P			M	K	
1 2 3 4	5	6	1 2 3	1 2	3
碳钢、合金钢 Carbon Steels Alloy Steels (<35HRC)	合金钢 Alloy Steels (35–48 HRC)	PH与铁素体/马氏体不锈钢 PH and Ferrite/Martensitic Stainless Steel <td>不锈钢 Stainless Steel</td> <td>灰铸铁、球墨铸铁 Cast Iron、Ductile Cast Iron<br (<32hrc)<="" td=""/><td>高合金铸铁 High Alloy Cast Iron<br (<35–45hrc)<="" td=""/></td></td>	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Cast Iron、Ductile Cast Iron <td>高合金铸铁 High Alloy Cast Iron<br (<35–45hrc)<="" td=""/></td>	高合金铸铁 High Alloy Cast Iron
<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>

最适合 Most Suitable 适合 Suitable

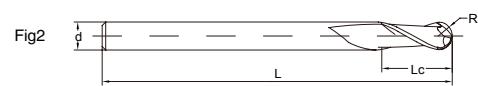
钢件、铸铁
For Steels & Cast Iron



SP210-BH2

2刃长柄球头

2 Flute Ballnose, with Long Shank Length



订货号 Ordering code	D	R	Lc	L	d	图号 Figure No.
SP210-BH2-64008	4	2	8	75	6	1
SP210-BH2-04008	4	2	8	75	4	2
SP210-BH2-06012	6	3	12	75	6	2
SP210-BH2-08014	8	4	14	75	8	2
SP210-BH2-10018	10	5	18	100	10	2
SP210-BH2-12022	12	6	22	100	12	2

R	公差Tol
R < 3	± 0.005
R ≥ 3	± 0.010

单位unit (mm)

工件材料 Workpiece Material					
P			M	K	
1 2 3 4	5	6	1 2 3	1 2	3
碳钢、合金钢 Carbon Steels Alloy Steels (<35HRC)	合金钢 Alloy Steels (35–48 HRC)	PH与铁素体/马氏体不锈钢 PH and Ferrite/Martensitic Stainless Steel <td>不锈钢 Stainless Steel</td> <td>灰铸铁、球墨铸铁 Cast Iron、Ductile Cast Iron<br (<32hrc)<="" td=""/><td>高合金铸铁 High Alloy Cast Iron<br (<35–45hrc)<="" td=""/></td></td>	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Cast Iron、Ductile Cast Iron <td>高合金铸铁 High Alloy Cast Iron<br (<35–45hrc)<="" td=""/></td>	高合金铸铁 High Alloy Cast Iron
○	○	○	○	○	○

○ 最适合 Most Suitable ○ 适合 Suitable

推荐切削参数

Recommended Cutting Data

工件材料 Workpiece Material		切削速度 Cutting Speed (m/min)			刃径 Tool Diameter (mm)										
		a_p	a_e	最小 Min	较好 Optimum	最大 Max	mm	1	2	3	4	6	8	10	12
P	P1	0.04xD	0.04xD	200	220	250	Fz	0.02	0.04	0.06	0.08	0.12	0.16	0.2	0.24
	P2	0.04xD	0.04xD	200	220	250	Fz	0.02	0.04	0.06	0.08	0.12	0.16	0.2	0.24
	P3	0.03xD	0.03xD	170	200	230	Fz	0.018	0.035	0.055	0.075	0.11	0.145	0.18	0.217
	P4	0.03xD	0.03xD	170	200	230	Fz	0.018	0.035	0.055	0.075	0.11	0.145	0.18	0.217
	P5	0.02xD	0.02xD	150	180	210	Fz	0.017	0.035	0.052	0.07	0.105	0.14	0.174	0.209
	P6	0.02xD	0.02xD	150	180	210	Fz	0.017	0.033	0.05	0.065	0.01	0.133	0.166	0.2
M	M1	0.04xD	0.04xD	200	220	250	Fz	0.018	0.035	0.055	0.075	0.11	0.145	0.18	0.217
	M2	0.04xD	0.04xD	200	220	250	Fz	0.018	0.035	0.055	0.075	0.11	0.145	0.18	0.217
	M3	0.03xD	0.03xD	170	200	230	Fz	0.017	0.035	0.052	0.07	0.105	0.14	0.174	0.209
K	K1	0.04xD	0.04xD	200	220	250	Fz	0.02	0.04	0.06	0.08	0.12	0.16	0.2	0.24
	K2	0.04xD	0.04xD	200	220	250	Fz	0.018	0.035	0.055	0.075	0.11	0.145	0.18	0.217
	K3	0.04xD	0.04xD	200	220	250	Fz	0.017	0.035	0.052	0.07	0.105	0.14	0.174	0.209

1.请使用刚性较高的机床，建议采用液压刀柄、热缩刀柄等强力铣削刀柄
Make sure workpiece and machine are suitable, use high quality collet chucks.

2.请根据被加工材料、设备刚性等情况可适当调整转速和进给速度
Please adjust the workpiece materials and cutting depth according to actual cutting conditions.

3.上表按照刀具悬长为直径3倍以下是所制订的，如果刀具悬长过长，加工时易产生振动，此时，请适当调整转速、进给速度和切深量
The milling condition are for an endmill where the tool overhang length is less than 3D. When the tool overhang length is longer, please adjust the speed, feed and cutting depth.



HOLEMAKING TOOLS

孔加工刀具

D938 普通钢加工麻花钻系列

D938 Drills for Steel Applications



特点 Features

- 适用于P类钢（≤48HRC）、K类铸铁的钻削加工
Suitable for drilling of Steel (≤48HRC), Cast Iron.
- 独特刃口处理技术，强化刃口强度，提高性能稳定性
Unique cutting edge preparation to add strength to the cutting edge, and improve the drilling stability.
- 新型AlTiN-nano涂层，刀具耐磨性优异
New AlTiN-nano coating, superior wear resistance, longer tool life.
- 直线型切削刃，提高切削刃强度
Straight cutting edge, improves tool strength.

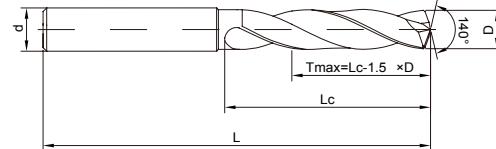
普通钢
For Steel



D938-A3N

3D外冷涂层麻花钻

3D External Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3N-0200	2.00	20	55	4	
D938-A3N-0210	2.10	20	55	4	
D938-A3N-0220	2.20	20	55	4	
D938-A3N-0230	2.30	20	55	4	
D938-A3N-0240	2.40	20	55	4	
D938-A3N-0250	2.50	20	55	4	
D938-A3N-0260	2.60	20	55	4	
D938-A3N-0270	2.70	20	55	4	
D938-A3N-0280	2.80	20	55	4	
D938-A3N-0290	2.90	20	55	4	
D938-A3N-0300	3.00	20	62	6	
D938-A3N-0310	3.10	20	62	6	
D938-A3N-0320	3.20	20	62	6	
D938-A3N-0330	3.30	20	62	6	M4
D938-A3N-0340	3.40	20	62	6	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

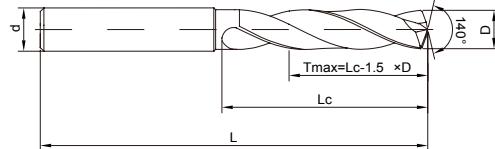
普通钢
For Steel



D938-A3N

3D外冷涂层麻花钻

3D External Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3N-0350	3.50	20	62	6	
D938-A3N-0360	3.60	20	62	6	
D938-A3N-0370	3.70	20	62	6	
D938-A3N-0380	3.80	24	66	6	
D938-A3N-0390	3.90	24	66	6	
D938-A3N-0400	4.00	24	66	6	
D938-A3N-0410	4.10	24	66	6	
D938-A3N-0420	4.20	24	66	6	M5
D938-A3N-0430	4.30	24	66	6	
D938-A3N-0440	4.40	24	66	6	
D938-A3N-0450	4.50	24	66	6	
D938-A3N-0460	4.60	24	66	6	
D938-A3N-0470	4.70	24	66	6	
D938-A3N-0480	4.80	28	66	6	
D938-A3N-0490	4.90	28	66	6	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1	2	3	1	2	3	1	2	3
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
◎	◎	○		○	○			

◎ 最适合 Most Suitable ○ 适合 Suitable

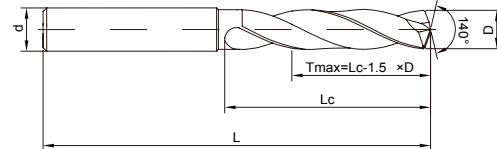
普通钢
For Steel



D938-A3N

3D外冷涂层麻花钻

3D External Coolant Twist Drills



订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3N-0500	5.00	28	66	6	M6
D938-A3N-0510	5.10	28	66	6	
D938-A3N-0520	5.20	28	66	6	
D938-A3N-0530	5.30	28	66	6	
D938-A3N-0540	5.40	28	66	6	
D938-A3N-0550	5.50	28	66	6	
D938-A3N-0560	5.60	28	66	6	
D938-A3N-0570	5.70	28	66	6	
D938-A3N-0580	5.80	28	66	6	
D938-A3N-0590	5.90	28	66	6	
D938-A3N-0600	6.00	28	66	6	
D938-A3N-0610	6.10	34	79	8	
D938-A3N-0620	6.20	34	79	8	
D938-A3N-0630	6.30	34	79	8	
D938-A3N-0640	6.40	34	79	8	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

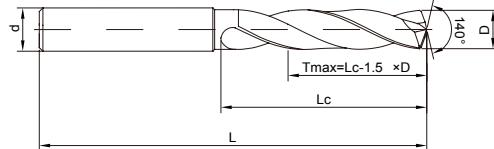
普通钢
For Steel



D938-A3N

3D外冷涂层麻花钻

3D External Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3N-0650	6.50	34	79	8	
D938-A3N-0660	6.60	34	79	8	
D938-A3N-0670	6.70	34	79	8	
D938-A3N-0680	6.80	34	79	8	M8
D938-A3N-0690	6.90	34	79	8	
D938-A3N-0700	7.00	34	79	8	M8 × 1
D938-A3N-0710	7.10	41	79	8	
D938-A3N-0720	7.20	41	79	8	
D938-A3N-0730	7.30	41	79	8	
D938-A3N-0740	7.40	41	79	8	
D938-A3N-0750	7.50	41	79	8	
D938-A3N-0760	7.60	41	79	8	
D938-A3N-0770	7.70	41	79	8	
D938-A3N-0780	7.80	41	79	8	
D938-A3N-0790	7.90	41	79	8	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1	2	3	1	2	3	1	2	3
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

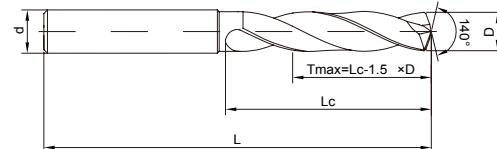
普通钢
For Steel



D938-A3N

3D外冷涂层麻花钻

3D External Coolant Twist Drills



订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3N-0800	8.00	41	79	8	
D938-A3N-0810	8.10	47	89	10	
D938-A3N-0820	8.20	47	89	10	
D938-A3N-0830	8.30	47	89	10	
D938-A3N-0840	8.40	47	89	10	
D938-A3N-0850	8.50	47	89	10	M10
D938-A3N-0860	8.60	47	89	10	
D938-A3N-0870	8.70	47	89	10	
D938-A3N-0880	8.80	47	89	10	
D938-A3N-0890	8.90	47	89	10	
D938-A3N-0900	9.00	47	89	10	M10 × 1
D938-A3N-0910	9.10	47	89	10	
D938-A3N-0920	9.20	47	89	10	
D938-A3N-0925	9.25	47	89	10	
D938-A3N-0930	9.30	47	89	10	
D938-A3N-0940	9.40	47	89	10	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

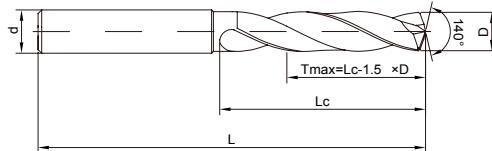
普通钢
For Steel



D938-A3N

3D外冷涂层麻花钻

3D External Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3N-0950	9.50	47	89	10	
D938-A3N-0960	9.60	47	89	10	
D938-A3N-0970	9.70	47	89	10	
D938-A3N-0980	9.80	47	89	10	
D938-A3N-0990	9.90	47	89	10	
D938-A3N-1000	10.00	47	89	10	
D938-A3N-1010	10.10	55	102	12	
D938-A3N-1020	10.20	55	102	12	
D938-A3N-1030	10.30	55	102	12	M12
D938-A3N-1040	10.40	55	102	12	
D938-A3N-1050	10.50	55	102	12	M12 × 1.5
D938-A3N-1060	10.60	55	102	12	
D938-A3N-1070	10.70	55	102	12	
D938-A3N-1080	10.80	55	102	12	
D938-A3N-1090	10.90	55	102	12	
D938-A3N-1100	11.00	55	102	12	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1	2	3	4	5	6	7	1	2
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH, Ferritic, Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys, Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
◎	◎	○		○	○			

◎ 最适合 Most Suitable ○ 适合 Suitable

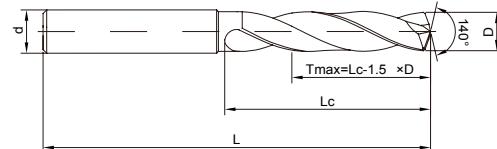
普通钢
For Steel



D938-A3N

3D外冷涂层麻花钻

3D External Coolant Twist Drills



订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3N-1110	11.10	55	102	12	
D938-A3N-1120	11.20	55	102	12	
D938-A3N-1130	11.30	55	102	12	
D938-A3N-1140	11.40	55	102	12	
D938-A3N-1150	11.50	55	102	12	
D938-A3N-1160	11.60	55	102	12	
D938-A3N-1170	11.70	55	102	12	
D938-A3N-1180	11.80	55	102	12	
D938-A3N-1190	11.90	55	102	12	
D938-A3N-1200	12.00	55	102	12	M14
D938-A3N-1250	12.50	60	107	14	M14 × 1.5
D938-A3N-1280	12.80	60	107	14	
D938-A3N-1300	13.00	60	107	14	
D938-A3N-1350	13.50	60	107	14	
D938-A3N-1380	13.80	60	107	14	
D938-A3N-1400	14.00	60	107	14	M16

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1	2	3	1	2	3	1	2	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

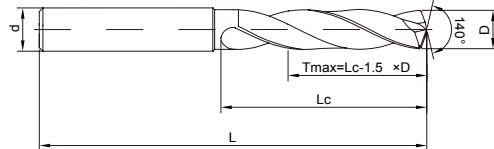
普通钢
For Steel



D938-A3N

3D外冷涂层麻花钻

3D External Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3N-1450	14.50	65	115	16	M16 × 1.5
D938-A3N-1480	14.80	65	115	16	
D938-A3N-1500	15.00	65	115	16	
D938-A3N-1550	15.50	65	115	16	
D938-A3N-1580	15.80	65	115	16	
D938-A3N-1600	16.00	65	115	16	
D938-A3N-1650	16.50	73	123	18	
D938-A3N-1680	16.80	73	123	18	
D938-A3N-1700	17.00	73	123	18	
D938-A3N-1750	17.50	73	123	18	
D938-A3N-1780	17.80	73	123	18	
D938-A3N-1800	18.00	73	123	18	
D938-A3N-1850	18.50	79	131	20	
D938-A3N-1880	18.80	79	131	20	
D938-A3N-1900	19.00	79	131	20	
D938-A3N-1950	19.50	79	131	20	
D938-A3N-1980	19.80	79	131	20	
D938-A3N-2000	20.00	79	131	20	

尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH, Ferritic, Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys, Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

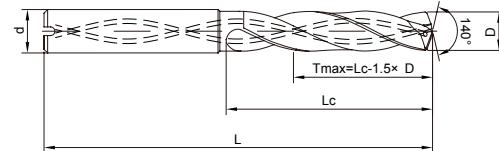
普通钢
For Steel



D938-A3C

3D内冷涂层麻花钻

3D Internal Coolant Twist Drills



订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3C-0300	3.00	20	62	6	
D938-A3C-0310	3.10	20	62	6	
D938-A3C-0320	3.20	20	62	6	
D938-A3C-0330	3.30	20	62	6	M4
D938-A3C-0340	3.40	20	62	6	
D938-A3C-0350	3.50	20	62	6	
D938-A3C-0360	3.60	20	62	6	
D938-A3C-0370	3.70	20	62	6	
D938-A3C-0380	3.80	24	66	6	
D938-A3C-0390	3.90	24	66	6	
D938-A3C-0400	4.00	24	66	6	
D938-A3C-0410	4.10	24	66	6	
D938-A3C-0420	4.20	24	66	6	M5
D938-A3C-0430	4.30	24	66	6	
D938-A3C-0440	4.40	24	66	6	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

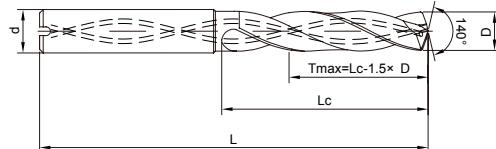
普通钢
For Steel



D938-A3C

3D内冷涂层麻花钻

3D Internal Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3C-0450	4.50	24	66	6	
D938-A3C-0460	4.60	24	66	6	
D938-A3C-0470	4.70	24	66	6	
D938-A3C-0480	4.80	28	66	6	
D938-A3C-0490	4.90	28	66	6	
D938-A3C-0500	5.00	28	66	6	M6
D938-A3C-0510	5.10	28	66	6	
D938-A3C-0520	5.20	28	66	6	
D938-A3C-0530	5.30	28	66	6	
D938-A3C-0540	5.40	28	66	6	
D938-A3C-0550	5.50	28	66	6	
D938-A3C-0560	5.60	28	66	6	
D938-A3C-0570	5.70	28	66	6	
D938-A3C-0580	5.80	28	66	6	
D938-A3C-0590	5.90	28	66	6	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

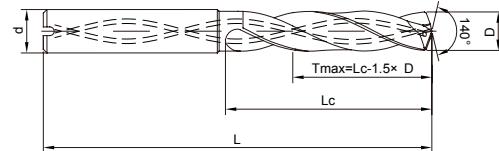
普通钢
For Steel



D938-A3C

3D内冷涂层麻花钻

3D Internal Coolant Twist Drills



Tmax –推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3C-0600	6.00	28	66	6	
D938-A3C-0610	6.10	34	79	8	
D938-A3C-0620	6.20	34	79	8	
D938-A3C-0630	6.30	34	79	8	
D938-A3C-0640	6.40	34	79	8	
D938-A3C-0650	6.50	34	79	8	
D938-A3C-0660	6.60	34	79	8	
D938-A3C-0670	6.70	34	79	8	
D938-A3C-0680	6.80	34	79	8	M8
D938-A3C-0690	6.90	34	79	8	
D938-A3C-0700	7.00	34	79	8	M8 × 1
D938-A3C-0710	7.10	41	79	8	
D938-A3C-0720	7.20	41	79	8	
D938-A3C-0730	7.30	41	79	8	
D938-A3C-0740	7.40	41	79	8	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

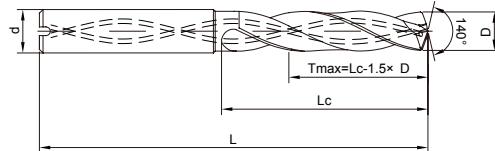
普通钢
For Steel



D938-A3C

3D内冷涂层麻花钻

3D Internal Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3C-0750	7.50	41	79	8	
D938-A3C-0760	7.60	41	79	8	
D938-A3C-0770	7.70	41	79	8	
D938-A3C-0780	7.80	41	79	8	
D938-A3C-0790	7.90	41	79	8	
D938-A3C-0800	8.00	41	79	8	
D938-A3C-0810	8.10	47	89	10	
D938-A3C-0820	8.20	47	89	10	
D938-A3C-0830	8.30	47	89	10	
D938-A3C-0840	8.40	47	89	10	
D938-A3C-0850	8.50	47	89	10	M10
D938-A3C-0860	8.60	47	89	10	
D938-A3C-0870	8.70	47	89	10	
D938-A3C-0880	8.80	47	89	10	
D938-A3C-0890	8.90	47	89	10	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH, Ferritic, Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys, Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

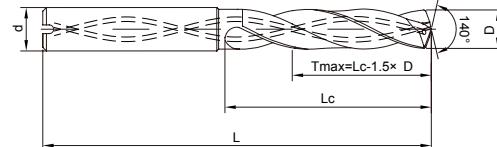
普通钢
For Steel



D938-A3C

3D内冷涂层麻花钻

3D Internal Coolant Twist Drills



订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3C-0900	9.00	47	89	10	M10 × 1
D938-A3C-0910	9.10	47	89	10	
D938-A3C-0920	9.20	47	89	10	
D938-A3C-0930	9.30	47	89	10	
D938-A3C-0940	9.40	47	89	10	
D938-A3C-0950	9.50	47	89	10	
D938-A3C-0960	9.60	47	89	10	
D938-A3C-0970	9.70	47	89	10	
D938-A3C-0980	9.80	47	89	10	
D938-A3C-0990	9.90	47	89	10	
D938-A3C-1000	10.00	47	89	10	
D938-A3C-1010	10.10	55	102	12	
D938-A3C-1020	10.20	55	102	12	
D938-A3C-1030	10.30	55	102	12	M12
D938-A3C-1040	10.40	55	102	12	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

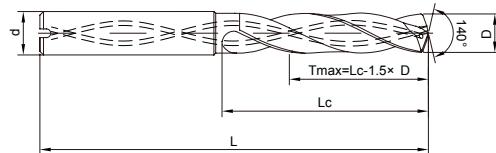
普通钢
For Steel



D938-A3C

3D内冷涂层麻花钻

3D Internal Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3C-1050	10.50	55	102	12	M12×1.5
D938-A3C-1060	10.60	55	102	12	
D938-A3C-1070	10.70	55	102	12	
D938-A3C-1080	10.80	55	102	12	
D938-A3C-1090	10.90	55	102	12	
D938-A3C-1100	11.00	55	102	12	
D938-A3C-1110	11.10	55	102	12	
D938-A3C-1120	11.20	55	102	12	
D938-A3C-1130	11.30	55	102	12	
D938-A3C-1140	11.40	55	102	12	
D938-A3C-1150	11.50	55	102	12	
D938-A3C-1160	11.60	55	102	12	
D938-A3C-1170	11.70	55	102	12	
D938-A3C-1180	11.80	55	102	12	
D938-A3C-1190	11.90	55	102	12	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

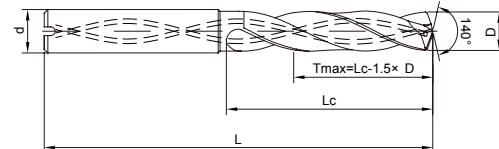
普通钢
For Steel



D938-A3C

3D内冷涂层麻花钻

3D Internal Coolant Twist Drills



订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3C-1200	12.00	55	102	12	M14
D938-A3C-1250	12.50	60	107	14	M14 × 1.5
D938-A3C-1280	12.80	60	107	14	
D938-A3C-1300	13.00	60	107	14	
D938-A3C-1350	13.50	60	107	14	
D938-A3C-1380	13.80	60	107	14	
D938-A3C-1400	14.00	60	107	14	M16
D938-A3C-1450	14.50	65	115	16	M16 × 1.5
D938-A3C-1480	14.80	65	115	16	
D938-A3C-1500	15.00	65	115	16	
D938-A3C-1550	15.50	65	115	16	
D938-A3C-1580	15.80	65	115	16	
D938-A3C-1600	16.00	65	115	16	
D938-A3C-1650	16.50	73	123	18	
D938-A3C-1680	16.80	73	123	18	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

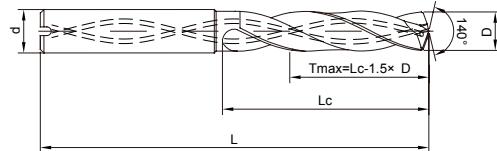
普通钢
For Steel



D938-A3C

3D内冷涂层麻花钻

3D Internal Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A3C-1700	17.00	73	123	18	
D938-A3C-1750	17.50	73	123	18	
D938-A3C-1780	17.80	73	123	18	
D938-A3C-1800	18.00	73	123	18	
D938-A3C-1850	18.50	79	131	20	
D938-A3C-1880	18.80	79	131	20	
D938-A3C-1900	19.00	79	131	20	
D938-A3C-1950	19.50	79	131	20	
D938-A3C-1980	19.80	79	131	20	
D938-A3C-2000	20.00	79	131	20	

尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位unit (mm)

工件材料 Workpiece Material

P		M	K		N			
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

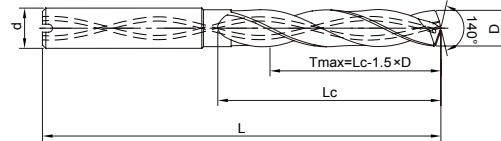
普通钢
For Steel



D938-A5C

5D内冷涂层麻花钻

5D Internal Coolant Twist Drills



订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A5C-0300	3.00	28	66	6	
D938-A5C-0310	3.10	28	66	6	
D938-A5C-0320	3.20	28	66	6	
D938-A5C-0330	3.30	28	66	6	M4
D938-A5C-0340	3.40	28	66	6	
D938-A5C-0350	3.50	28	66	6	
D938-A5C-0360	3.60	28	66	6	
D938-A5C-0370	3.70	28	66	6	
D938-A5C-0380	3.80	36	74	6	
D938-A5C-0390	3.90	36	74	6	
D938-A5C-0400	4.00	36	74	6	
D938-A5C-0410	4.10	36	74	6	
D938-A5C-0420	4.20	36	74	6	M5
D938-A5C-0430	4.30	36	74	6	
D938-A5C-0440	4.40	36	74	6	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1	2	3	1	2	3	1	2	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

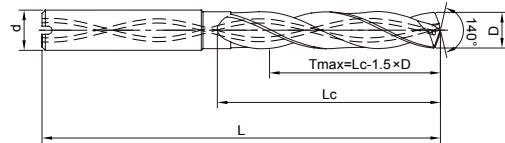
普通钢
For Steel



D938-A5C

5D内冷涂层麻花钻

5D Internal Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A5C-0450	4.50	36	74	6	
D938-A5C-0460	4.60	36	74	6	
D938-A5C-0465	4.65	36	74	6	
D938-A5C-0470	4.70	36	74	6	
D938-A5C-0480	4.80	44	82	6	
D938-A5C-0490	4.90	44	82	6	
D938-A5C-0500	5.00	44	82	6	M6
D938-A5C-0510	5.10	44	82	6	
D938-A5C-0520	5.20	44	82	6	
D938-A5C-0530	5.30	44	82	6	
D938-A5C-0540	5.40	44	82	6	
D938-A5C-0550	5.50	44	82	6	
D938-A5C-0555	5.55	44	82	6	
D938-A5C-0560	5.60	44	82	6	
D938-A5C-0570	5.70	44	82	6	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1	2	3	1	2	3	1	2	3
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
◎	◎	○		○	○			

◎ 最适合 Most Suitable ○ 适合 Suitable

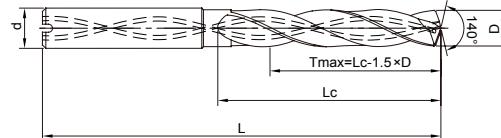
普通钢
For Steel



D938-A5C

5D内冷涂层麻花钻

5D Internal Coolant Twist Drills



订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A5C-0580	5.80	44	82	6	
D938-A5C-0590	5.90	44	82	6	
D938-A5C-0600	6.00	44	82	6	
D938-A5C-0610	6.10	53	91	8	
D938-A5C-0620	6.20	53	91	8	
D938-A5C-0630	6.30	53	91	8	
D938-A5C-0640	6.40	53	91	8	
D938-A5C-0650	6.50	53	91	8	
D938-A5C-0660	6.60	53	91	8	
D938-A5C-0670	6.70	53	91	8	
D938-A5C-0680	6.80	53	91	8	M8
D938-A5C-0690	6.90	53	91	8	
D938-A5C-0700	7.00	53	91	8	M8 × 1
D938-A5C-0710	7.10	53	91	8	
D938-A5C-0720	7.20	53	91	8	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1	2	3	1	2	3	1	2	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

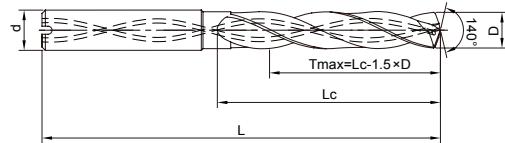
普通钢
For Steel



D938-A5C

5D内冷涂层麻花钻

5D Internal Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A5C-0730	7.30	53	91	8	
D938-A5C-0740	7.40	53	91	8	
D938-A5C-0745	7.45	53	91	8	
D938-A5C-0750	7.50	53	91	8	
D938-A5C-0760	7.60	53	91	8	
D938-A5C-0770	7.70	53	91	8	
D938-A5C-0780	7.80	53	91	8	
D938-A5C-0790	7.90	53	91	8	
D938-A5C-0800	8.00	53	91	8	
D938-A5C-0810	8.10	61	103	10	
D938-A5C-0820	8.20	61	103	10	
D938-A5C-0830	8.30	61	103	10	
D938-A5C-0840	8.40	61	103	10	
D938-A5C-0850	8.50	61	103	10	M10
D938-A5C-0860	8.60	61	103	10	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1	2	3	4	5	6	7	1	2
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
◎	◎	○		○	○			

◎ 最适合 Most Suitable ○ 适合 Suitable

普通钢
For Steel

SHANK
DIN
6535HA

AITiN
nano

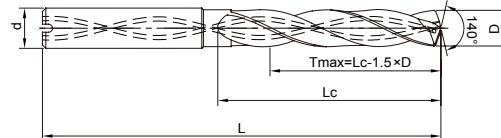
5D



D938-A5C

5D内冷涂层麻花钻

5D Internal Coolant Twist Drills



订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A5C-0870	8.70	61	103	10	
D938-A5C-0880	8.80	61	103	10	
D938-A5C-0890	8.90	61	103	10	
D938-A5C-0900	9.00	61	103	10	M10×1
D938-A5C-0910	9.10	61	103	10	
D938-A5C-0920	9.20	61	103	10	
D938-A5C-0930	9.30	61	103	10	
D938-A5C-0935	9.35	61	103	10	
D938-A5C-0940	9.40	61	103	10	
D938-A5C-0950	9.50	61	103	10	
D938-A5C-0960	9.60	61	103	10	
D938-A5C-0970	9.70	61	103	10	
D938-A5C-0980	9.80	61	103	10	
D938-A5C-0990	9.90	61	103	10	
D938-A5C-1000	10.00	61	103	10	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1	2	3	1	2	3	1	2	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

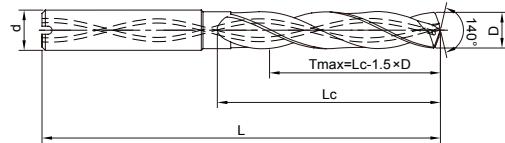
普通钢
For Steel



D938-A5C

5D内冷涂层麻花钻

5D Internal Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A5C-1010	10.10	71	118	12	
D938-A5C-1020	10.20	71	118	12	
D938-A5C-1030	10.30	71	118	12	M12
D938-A5C-1040	10.40	71	118	12	
D938-A5C-1050	10.50	71	118	12	M12 × 1.5
D938-A5C-1060	10.60	71	118	12	
D938-A5C-1070	10.70	71	118	12	
D938-A5C-1080	10.80	71	118	12	
D938-A5C-1090	10.90	71	118	12	
D938-A5C-1100	11.00	71	118	12	
D938-A5C-1110	11.10	71	118	12	
D938-A5C-1120	11.20	71	118	12	
D938-A5C-1130	11.30	71	118	12	
D938-A5C-1140	11.40	71	118	12	
D938-A5C-1150	11.50	71	118	12	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

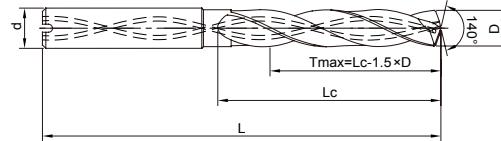
普通钢
For Steel



D938-A5C

5D内冷涂层麻花钻

5D Internal Coolant Twist Drills



订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A5C-1160	11.60	71	118	12	
D938-A5C-1170	11.70	71	118	12	
D938-A5C-1180	11.80	71	118	12	
D938-A5C-1190	11.90	71	118	12	
D938-A5C-1200	12.00	71	118	12	M14
D938-A5C-1250	12.50	77	124	14	M14 × 1.5
D938-A5C-1280	12.80	77	124	14	
D938-A5C-1300	13.00	77	124	14	
D938-A5C-1350	13.50	77	124	14	
D938-A5C-1380	13.80	77	124	14	
D938-A5C-1400	14.00	77	124	14	M16
D938-A5C-1450	14.50	83	133	16	M16 × 1.5
D938-A5C-1480	14.80	83	133	16	
D938-A5C-1500	15.00	83	133	16	
D938-A5C-1510	15.10	83	133	16	

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尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K	N			
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH,Ferritic,Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys,Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

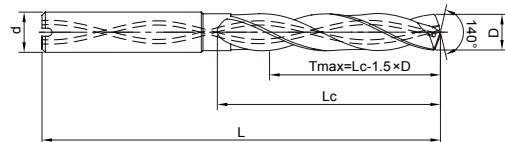
普通钢
For Steel



D938-A5C

5D内冷涂层麻花钻

5D Internal Coolant Twist Drills



Tmax - 推荐最大钻深 Recommended Maximum Depth

订货号 Ordering code	D(m7)	Lc	L	d(h6)	螺纹尺寸 Screw Thread Dim
D938-A5C-1550	15.50	83	133	16	
D938-A5C-1580	15.80	83	133	16	
D938-A5C-1600	16.00	83	133	16	
D938-A5C-1650	16.50	93	143	18	
D938-A5C-1680	16.80	93	143	18	
D938-A5C-1700	17.00	93	143	18	
D938-A5C-1750	17.50	93	143	18	
D938-A5C-1780	17.80	93	143	18	
D938-A5C-1800	18.00	93	143	18	
D938-A5C-1850	18.50	101	153	20	
D938-A5C-1880	18.80	101	153	20	
D938-A5C-1900	19.00	101	153	20	
D938-A5C-1950	19.50	101	153	20	
D938-A5C-1980	19.80	101	153	20	
D938-A5C-2000	20.00	101	153	20	

尺寸范围 nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/-0.006
>3—6	+0.004/+0.016	0.000/-0.008
>6—10	+0.006/+0.021	0.000/-0.009
>10—18	+0.007/+0.025	0.000/-0.011
>18—20	+0.008/+0.029	0.000/-0.013

单位 unit (mm)

工件材料 Workpiece Material								
P			M	K		N		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4
碳钢、合金钢 (<35HRC) Carbon Steel, Alloy Steel(<35HRC)	合金钢 (35—48HRC) Alloy Steel, Tool Steel(35—48HRC)	PH与铁素体/马氏体 不锈钢 (<48HRC) PH, Ferritic, Martensitic Stainless Steel (<48HRC)	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 (<32HRC) Grey Cast Iron, Nodular Cast Iron(<32HRC)	高合金铸铁 (35—45HRC) High-alloy Cast Iron(35—45HRC)	锻造铝合金、铸造铝合金 (Si≤12%) Wrought Aluminium Alloys, Cast Aluminium Alloys (Si≤12%)	铸造铝合金 (Si>12%) Cast Aluminium Alloys (Si>12%)	铜合金 (<200HB) Copper Alloys (<200HB)
○	○	○		○	○			

○ 最适合 Most Suitable ○ 适合 Suitable

推荐切削参数

Recommended Cutting Data

工件材料 Workpiece Material		切削速度Vc Cutting Speed (m/min)		进给量fn Feed Per Revolution (mm/rev)				
				φ 3	φ 4	φ 6	φ 8	φ 10
P	P1	120–80–50	140–100–60	0.10–0.15–0.20	0.10–0.15–0.20	0.14–0.19–0.25	0.16–0.22–0.32	0.16–0.22–0.35
	P2	120–75–50	140–100–60	0.10–0.15–0.20	0.10–0.15–0.20	0.14–0.19–0.25	0.16–0.22–0.32	0.16–0.22–0.35
	P3	120–70–45	120–80–60	0.10–0.15–0.20	0.10–0.15–0.20	0.14–0.19–0.25	0.16–0.22–0.30	0.16–0.22–0.32
	P4	100–70–45	110–80–60	0.09–0.13–0.16	0.09–0.13–0.16	0.12–0.17–0.23	0.14–0.20–0.28	0.14–0.20–0.30
	P5	80–60–35	90–60–35	0.08–0.11–0.14	0.08–0.11–0.14	0.08–0.14–0.20	0.09–0.16–0.25	0.09–0.16–0.28
	P6	70–50–30	90–60–30	0.05–0.08–0.11	0.05–0.08–0.11	0.07–0.12–0.17	0.08–0.14–0.20	0.08–0.14–0.23
	P7	70–45–25	80–50–30	0.04–0.06–0.08	0.04–0.06–0.08	0.06–0.10–0.14	0.08–0.13–0.18	0.08–0.13–0.20
K	K1	140–100–60	160–120–60	0.13–0.17–0.20	0.15–0.20–0.23	0.17–0.25–0.30	0.20–0.27–0.35	0.23–0.30–0.40
	K2	120–80–60	140–100–60	0.11–0.15–0.18	0.13–0.17–0.20	0.15–0.20–0.25	0.17–0.25–0.32	0.20–0.28–0.36
	K3	100–70–50	100–80–50	0.06–0.09–0.11	0.08–0.10–0.13	0.10–0.13–0.16	0.12–0.16–0.20	0.14–0.20–0.26

工件材料 Workpiece Material		切削速度Vc Cutting Speed (m/min)		进给量fn Feed Per Revolution (mm/rev)				
				φ 12	φ 14	φ 16	φ 18	φ 20
P	P1	120–80–50	140–100–60	0.18–0.28–0.40	0.22–0.32–0.45	0.22–0.32–0.45	0.25–0.38–0.50	0.25–0.38–0.50
	P2	120–75–50	140–100–60	0.18–0.28–0.40	0.22–0.32–0.45	0.22–0.32–0.45	0.25–0.38–0.50	0.25–0.38–0.50
	P3	120–70–45	120–80–60	0.18–0.28–0.38	0.22–0.32–0.45	0.22–0.32–0.45	0.25–0.38–0.50	0.25–0.38–0.50
	P4	100–70–45	110–80–60	0.15–0.23–0.34	0.18–0.25–0.38	0.18–0.25–0.38	0.20–0.30–0.40	0.20–0.30–0.40
	P5	80–60–35	90–60–35	0.11–0.19–0.30	0.12–0.22–0.32	0.12–0.22–0.32	0.14–0.24–0.34	0.14–0.24–0.34
	P6	70–50–30	90–60–30	0.10–0.18–0.28	0.12–0.20–0.30	0.12–0.20–0.30	0.14–0.24–0.32	0.14–0.24–0.32
	P7	70–45–25	80–50–30	0.10–0.18–0.28	0.12–0.20–0.30	0.12–0.20–0.30	0.14–0.24–0.32	0.14–0.24–0.32
K	K1	140–100–60	160–120–60	0.25–0.33–0.45	0.28–0.36–0.48	0.30–0.40–0.50	0.32–0.42–0.52	0.35–0.45–0.55
	K2	120–80–60	140–100–60	0.22–0.30–0.42	0.24–0.33–0.45	0.25–0.35–0.48	0.28–0.38–0.48	0.30–0.40–0.50
	K3	100–70–50	100–80–50	0.16–0.22–0.28	0.18–0.24–0.30	0.20–0.26–0.32	0.22–0.28–0.34	0.23–0.28–0.35

1. 请使用刚性较高的机床，建议采用液压刀柄、热涨刀柄、带弹簧夹头的强力铣削刀柄

Make sure workpiece and machine are stable, use hydraulic chucks, high quality collet chucks, or shrink fit chucks.

2. 刀具安装时需确保钻头尖径向跳动小于0.02mm

Make sure total indicated run-out(TIR) is less than 0.02mm.

3. 推荐使用可溶机油（乳化液）并带有EP（极压）添加剂的冷却液，并且机油和水的混合比应该在6–8%之间，以得到最佳的刀具寿命，同时冷却液要使用上下梯次配置

For excellent results, it is best to apply non water soluble fluid with EP additive as coolant fluid, and keep mixing ratio of oil and water between 6–8%, meanwhile, place the coolant nozzles properly.

4. 请根据实际加工工况适当调整切削参数

Please adjust the cutting data, according to actual cutting conditions.



MILLING

铣削

MKA110刀体+UD/UP刀片系列 – 三刃快进给铣削刀具

MKA110+ UD/UP – High Feed Milling Tool (3 Edges)



特点 Features

- 耐用性:

优质合金钢材料，表面特殊处理提高耐腐蚀性、耐摩擦性

Durability:

High quality alloy steel with special surface treatment to improve corrosive resistance and protect against chip wash.

- 广泛性:

不同齿数刀体供选择，适用于不同加工形态

Range of cutter options:

Different pitch cutter bodies are available for various working applications.

- 稳定性:

大容屑槽设计配合螺钉夹紧方式实现高稳定性铣削，有效改善刀体和刀片散热

Stability:

Large chip pocket design with screw clamping to achieve stable milling and improve heat dissipation.

铣削 Milling

MKA110刀体+UD/UP刀片系列 – 三刃快进给铣削刀具

MKA110+ UD/UP – High Feed Milling Tool (3 Edges)

MKA110

圆柱直柄式

Shank Type

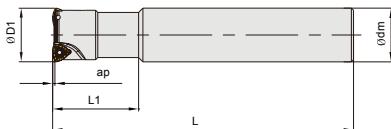


Fig.1

订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 (mm) Dimensions					最大 切深 a_p	匹配刀片 Gauge Insert	配件 Spare Parts		图示 Shape	库存 Stock
			Φ D1	Φ dm	L	L1	-			螺钉 Screw	扳手 Wrench		
MKA110-020R02P20-UD08S	20	2	20	20	120	40	-	1.0	UD**0803	S60M2.5	T08P	Fig1	●
MKA110-025R02P25-UD08	25	2	25	25	160	50	-	1.0	UD**0803	S60M2.5	T08P	Fig1	●
MKA110-035R05P32-UD08	35	5	35	32	200	50	-	1.0	UD**0803	S60M2.5	T08P	Fig1	○
MKA110-025R02P25-UD12	25	2	25	25	160	50	-	1.5	UD**12T3	S60M4	T15P	Fig1	●
MKA110-030R03P32-UD12	30	3	30	32	200	50	-	1.5	UD**12T3	S60M4	T15P	Fig1	○
MKA110-032R03P32-UD12	32	3	32	32	200	50	-	1.5	UD**12T3	S60M4	T15P	Fig1	●
MKA110-035R03P32-UD12	35	3	35	32	200	50	-	1.5	UD**12T3	S60M4	T15P	Fig1	●

● 标准库存 Stock ○ 需预定 Available upon Order

铣削

Milling

MKA110刀体+UD/UP刀片系列 – 三刃快进给铣削刀具

MKA110+ UD/UP – High Feed Milling Tool (3 Edges)

MKA110

心轴式

Arbor Mount

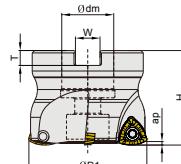


Fig.2

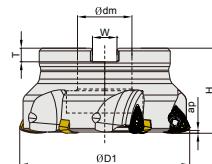


Fig.3

订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 (mm) Dimensions					最大 切深 a_p	匹配刀片 Gauge Insert	配件 Spare Parts		图示 Shape	库存 Stock
			$\phi D1$	ϕdm	H	W	T			螺钉 Screw	扳手 Wrench		
MKA110-050R04A22-UD12	50	4	50	22	50	10.4	6.3	1.5	UD**12T3	S60M4	T15P	Fig2	●
MKA110-063R05A22-UD12	63	5	63	22	50	10.4	6.3	1.5	UD**12T3	S60M4	T15P	Fig2	○
MKA110-063R04A22-UP17	63	4	63	22	50	10.4	6.3	2.0	UP**1705	S60M5	T20P	Fig2	●
MKA110-080R05A27-UP17	80	5	80	27	50	12.4	7	2.0	UP**1705	S60M5	T20P	Fig2	●
MKA110-080R06A27-UP17	80	6	80	32	50	12.4	7	2.0	UP**1705	S60M5	T20P	Fig2	○
MKA110-100R06B32-UP17	100	6	100	40	63	14.4	8	2.0	UP**1705	S60M5	T20P	Fig3	○

●标准库存 Stock ○需预定 Available upon Order

UD/UP刀片

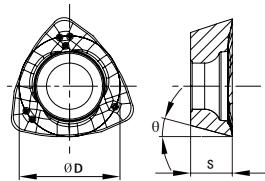
UD/UP Insert

特点

Features

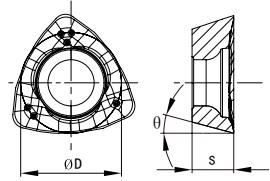
- 独特的三刃设计，最适合快进给铣削
Optimized three cutting edges design, especially for high feed milling.
- 可适合中载与重载加工工况，配合不同牌号满足加工要求
Suitable for medium and heavy cutting, different grades can meet various working application.
- 不同规格搭配不同后角，保证刀片强度
Range of insert geometries for achieving optimum cutting conditions.

UD/UP



订货号 Ordering Code	尺寸 Dimensions(mm)			库存 Stock		
	ØD	S	θ	GA4225	GA4230	GK4125
	UDET080308-MM	6.8	3.18	15	●	●
	UDET12T312-MM	9.6	3.97	15	●	●
	UPET170520-PM	13	5.56	11	●	●
	UDMT080308T-MH	6.8	3.18	15	○	○

UD/UP



订货号 Ordering Code	尺寸 Dimensions(mm)			库存 Stock			
	ΦD	S	θ	GA4225	GA4230	GK4125	GN9125
UDMT12T312T-MH	9.6	3.97	15	●	●		
UDMW12T312T	9.6	3.97	15	●	●		

MM/PM-中载/Medium , MH-重载/Heavy

● 标准库存 Stock ○ 需预定 Available upon Order

A

B

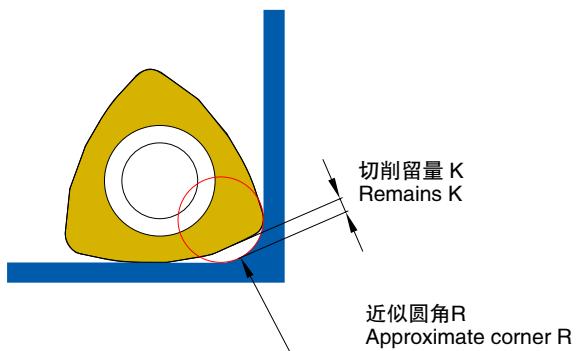
C

D

适用范围 Application Range

ISO	P					M					K					S					H					
	钢 Steel					不锈钢 Stainless Steel					铸铁 Cast Iron					耐热、钛合金 Heat-resistant Alloy TitaniumAlloy					淬火钢 Hardened Steel					
	P01	P10	P20	P30	P40	M01	M10	M20	M30	M40	K01	K10	K20	K30	K40	S01	S10	S20	S30	S40	H01	H10	H20	H30	H40	
适用领域 Range				GA4225				GA4225						GA4230			GA4230						GA4230			

加工程序参数 Parameters for Programming Calculations



刀片规格 Insert	近似编程圆角R(mm) Approximate Corner R	切削残留量K(mm) Remains K
UD**0803	1.8	0.58
UD**12T3	2.8	0.86
UP**1705	3.5	1.02

推荐切削参数

Recommended Cutting Data

被加工材料 Workpiece Materials		材料硬度 Material Hardness	牌号 Grade	切削速度 Cutting Speed	进给/刃 (mm/tooth)	
				Vc (m/min)	中载切削 (M) Medium Cutting	重载切削 (H) Heavy Cutting
P	普通结构钢 Mild Steel	≤HB200	GA4225 GA4230	150–180–200	0.8–1.2–1.5	1.0–1.5–2.0
	碳素钢、合金钢 Carbon Steel Alloy Steel	≤HRC35	GA4225 GA4230	120–150–180	0.8–1.2–1.5	1.0–1.5–2.0
	碳素钢、合金钢 Carbon Steel Alloy Steel	HRC35–45	GA4230	90–120–140	0.6–1.0–1.2	0.8–1.2–1.5
M	不锈钢 (铁素体、马氏体) Stainless Steel (Ferrite、Martensite)	≤HRC35	GA4225 GA4230	90–120–140	0.6–0.8–1.0	0.8–1.0–1.2
K	铸铁、球墨铸铁 Cast Iron Nodular Cast Iron	≤HB350	GA4230	150–180–200	0.8–1.2–1.5	1.0–1.5–2.0
S	耐热合金、钛合金 Heat-resistant Alloy and Titanium Alloy	≤HRC35	GA4230	30–40–60	0.15–0.3–0.4	0.2–0.4–0.6
H	淬火钢 Hardened Steel	HRC45–55	GA4230	60–80–100	0.1–0.2–0.3	0.15–0.3–0.4

UD/UP刀片推荐进给量与切深关系

The Relationship of recommended Feed and Depth of UD/UP inserts

刀片规格 Insert size	切深ap (mm)					
	0.5	1	1.5	2	2.5	3
08	0.6–0.8–1.2	0.4–0.5–0.8	–	–	–	–
12	1.0–1.5–2.0	0.8–1.2–1.5	0.6–0.8–1.2	–	–	–
17	1.8–2.0–2.5	1.0–1.5–2.0	0.8–1.2–1.5	0.6–0.8–1.2	–	–

MKB113刀体 +SDMT刀片系列 – 四刃快进给铣削刀具

MKB113+ SDMT – High Feed Milling Tool (4 Edges)



特点 Features

- 耐用性：
优质合金钢材料，表面特殊处理提高耐腐蚀性、耐磨损性
Durability:
High quality alloy steel with special treatment in surface to improve corrosive resistance and protect against chip wash.
- 广泛性：
不同齿数刀体供选择，适用于不同加工形态
Range of cutter options:
Different pitches of cutter bodies are available for various working applications.
- 经济性：
四条有效切削刃，经济实用
Economy:
Four cutting edges insert design with high economy.
- 易用性：
刀体上特殊的高精度定位槽，确保定位安全可靠。采用螺钉夹紧，易于拆装刀片
Convenience:
Special high precision insert pocket ensure safety and stability. Screw clamping makes inserts loading more convenient.

铣削
Milling**MKB113刀体 +SDMT刀片系列 – 四刃快进给铣削刀具**

MKB113+ SDMT- High Feed Milling Tool (4 Edges)

MKB113**圆柱直柄式**

Shank Type

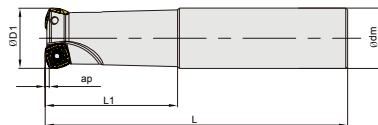


Fig.1

订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 (mm) Dimensions					最大 切深 a_p	匹配刀片 Gauge Insert	配件 Spare Parts		图示 Shape	库存 Stock
			ΦD_1	Φd_m	L	L1	-			螺钉 Screw	扳手 Wrench		
MKB113-032R02P32-SD12S	32	2	32	32	160	70	-	2.0	SD**1205	S60M4	T15P	Fig1	●
MKB113-032R02P32-SD12	32	2	32	32	200	70	-	2.0	SD**1205	S60M4	T15P	Fig1	●
MKB113-035R03P32-SD12	35	3	35	32	200	70	-	2.0	SD**1205	S60M4	T15P	Fig1	○
MKB113-040R03P32-SD12	40	3	40	32	200	70	-	2.0	SD**1205	S60M4	T15P	Fig1	○

● 标准库存 Stock ○ 需预定 Available upon Order

铣削

Milling

MKB113刀体 +SDMT刀片系列 – 四刃快进给铣削刀具

MKB113+ SDMT- High Feed Milling Tool (4 Edges)

MKB113

心轴式

Arbor Mount

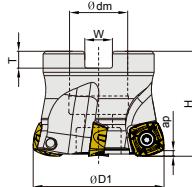


Fig.2

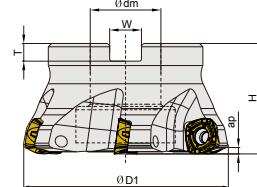


Fig.3

订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 (mm) Dimensions					最大 切深 a_p	匹配刀片 Gauge Insert	配件 Spare Parts		图示 Shape	库存 Stock
			$\Phi D1$	Φdm	H	W	T			螺钉 Screw	扳手 Wrench		
MKB113-050R04A22-SD12	50	4	50	22	40	10.4	6.3	2.0	SD**1205	S60M4	T15P	Fig2	●
MKB113-063R04A22-SD12	63	4	63	22	40	10.4	6.3	2.0	SD**1205	S60M4	T15P	Fig2	●
MKB113-063R05A22-SD12	63	5	63	22	40	10.4	6.3	2.0	SD**1205	S60M4	T15P	Fig2	●
MKB113-080R06A27-SD12	80	6	80	27	50	12.4	7	2.0	SD**1205	S60M4	T15P	Fig2	○
MKB113-063R04A22-SD15	63	4	63	22	40	10.4	6.3	3.0	SD**1505	S60M5	T20P	Fig2	●
MKB113-080R05A27-SD15	80	5	80	27	50	12.4	7	3.0	SD**1505	S60M5	T20P	Fig2	●
MKB113-100R06B32-SD15	100	6	100	32	50	14.4	8	3.0	SD**1505	S60M5	T20P	Fig3	○
MKB113-125R07B40-SD15	125	7	125	40	63	16.4	9	3.0	SD**1505	S60M5	T20P	Fig3	○

● 标准库存 Stock ○ 需预定 Available upon Order

A

B

C

D

SDMT刀片

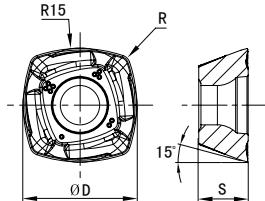
SDMT Insert

特点

Features

- 变前角+变刃带刃形设计，使得切削刃随着切深增大，刀尖强度增加。特别适合大平面铣削
Unique rake angle and cutting edge design increase the strength of inserts, especially for the face milling.
- 适合中载与重载加工，配合不同牌号能够满足钢和铸铁等材料不同工况的加工
Suitable for medium and heavy cutting, different grades can cover a wide variety of materials, especially for steel and cast iron.
- 后刀面上独特的定位面设计，确保定位安全可靠
Special positioning surface on the flank ensure the safety and stability.

SDMT



订货号 Ordering Code	尺寸 Dimensions(mm)			库存 Stock			
	ØD	S	R	GA4225	GA4230	GK4125	GN9125
SDMT120512-GM	12.7	5.56	1.2	●	●	●	
SDMT150512-GM	15.875	5.56	1.2	●	●		
SDMT120512-GH	12.7	5.56	1.2	●	●		
SDMT150512-GH	15.875	5.56	1.2	●	●		

GM-中载/Medium, GH-重载/Heavy

●标准库存 Stock ○需预定 Available upon Order

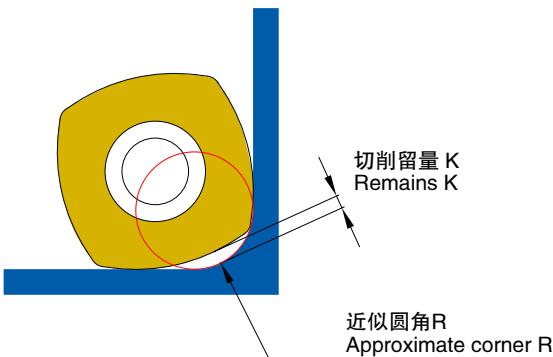
适用范围

Application Range

ISO	P					M					K					S					H				
	钢 Steel					不锈钢 Stainless Steel					铸铁 Cast Iron					耐热、钛合金 Heat-resistant Alloy TitaniumAlloy					淬火钢 Hardened Steel				
	P01	P10	P20	P30	P40	M01	M10	M20	M30	M40	K01	K10	K20	K30	K40	S01	S10	S20	S30	S40	H01	H10	H20	H30	H40
适用领域 Range				GA4225				GA4225							GA4230									GA4230	

加工程序参数

Parameters for Programming Calculations



刀片规格 Insert	近似编程圆角R(mm) Approximate Corner R	切削残留量K(mm) Remains K
SD**12	4.0	0.85
SD**15	5.0	1.05

推荐切削参数

Recommended Cutting Data

被加工材料 Workpiece Materials		材料硬度 Material Hardness	牌号 Grade	切削速度 Cutting Speed	进给/刃 (mm/tooth)	
				Vc (m/min)	中载切削 (M) Medium Cutting	重载切削 (H) Heavy Cutting
P	普通结构钢 Mild Steel	≤HB200	GA4225 GA4230	150–180–200	0.8–1.2–2.0	1.0–1.5–3.0
	碳素钢、合金钢 Carbon Steel Alloy Steel	≤HRC35	GA4225 GA4230	120–150–180	0.8–1.2–2.0	1.0–1.5–3.0
	碳素钢、合金钢 Carbon Steel Alloy Steel	HRC35–45	GA4230	90–120–140	0.6–1.0–1.8	0.8–1.2–2.0
M	不锈钢 (铁素体、马氏体) Stainless Steel (Ferrite, Martensite)	≤HRC35	GA4225 GA4230	90–120–140	0.6–0.8–1.5	0.8–1.0–1.8
K	铸铁、球墨铸铁 Cast Iron Nodular Cast Iron	≤HB350	GK4125 GA4230	150–180–200	0.8–1.2–2.0	1.0–1.5–3.0
S	耐热合金、钛合金 Heat-resistant Alloy and Titanium Alloy	≤HRC35	GA4230	30–40–60	0.15–0.3–0.4	0.2–0.4–0.6
H	淬火钢 Hardened Steel	HRC45–55	GA4230	60–80–100	0.1–0.2–0.4	0.15–0.3–0.4

SDMT刀片推荐进给量与切深关系

The Relationship of recommended Feed and Depth of SDMT inserts

刀片规格 Insert size	切深ap (mm)					
	0.5	1	1.5	2	2.5	3
12	1.5–1.8–2.0	1.0–1.5–1.8	0.6–1.0–1.5	0.4–0.8–1.0	–	–
15	1.8–2.0–3.0	1.5–1.8–2.0	1.0–1.5–1.8	0.6–1.0–1.5	0.4–0.8–1.0	0.4–0.6–0.8

MEA190刀体 + APM(G)T刀片系列补充 – 通用方肩铣削刀具

Extension to MEA190 + APM(G)T – General Shoulder Milling Tool



特点 Features

- 耐用性:

优质合金钢材料，表面镀镍处理提高耐腐蚀性、耐磨损性

Durability:

High quality alloy steel and nickel plating to improve corrosion resistance and resist chip wash.

- 易用性:

高精度定位槽，确保定位安全可靠。采用螺钉夹紧，易于拆装刀片

Convenience:

High precision insert pocket ensures safety and stability. Screw clamping makes inserts loading more convenient.

- 高刚性:

高刚性设计，切削平稳，可靠的加工伙伴

Rigidity:

High rigidity design to maximize cutting stability.

铣削

Milling

MEA190刀体 + APM(G)T刀片系列补充 – 通用方肩铣削刀具

Extension to MEA190 + APM(G)T – General Shoulder Milling Tool

MEA190

圆柱直柄式

Shank Type

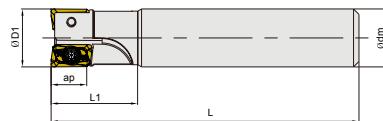


Fig.1

订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 (mm) Dimensions					最大 切深 a_p	匹配刀片 Gauge Insert	配件 Spare Parts		图示 Shape	库存 Stock
			ΦD_1	Φd_m	L	L1	-			螺钉 Screw	扳手 Wrench		
MEA190-016R02P16-AP11	16	2	16	16	120	40	-	9	AP*T1135	S60M2.5	T08P	Fig1	●
MEA190-020R03P20-AP11	20	3	20	20	160	50	-	9	AP*T1135	S60M2.5	T08P	Fig1	●
MEA190-025R03P25-AP11	25	3	25	25	160	50	-	9	AP*T1135	S60M2.5	T08P	Fig1	●
MEA190-025R02P25-AP16	25	2	25	25	160	50	-	14	AP*T1604	S60M4	T15P	Fig1	●
MEA190-032R03P32-AP16	32	3	32	32	160	80	-	14	AP*T1604	S60M4	T15P	Fig1	●

● 标准库存 Stock ○ 需预定 Available upon Order

A

B

C

D

铣削
Milling

MEA190刀体 + APM(G)T刀片系列补充 – 通用方肩铣削刀具

Extension to MEA190 + APM(G)T – General Shoulder Milling Tool

MEA190

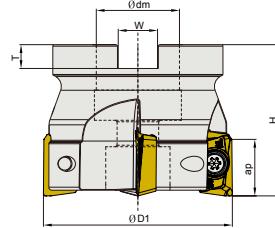
心轴式
Arbor Mount

Fig.2

订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 (mm) Dimensions				最大 切深 ap	匹配刀片 Gauge Insert	配件 Spare Parts		图示 Shape	库存 Stock
			ØD1	Ødm	H	W	T		螺钉 Screw	扳手 Wrench		
MEA190-050R04A22-AP16	50	4	50	22	50	10.4	6.3	14	AP*T1604	S60M4	T15P	Fig2
MEA190-063R05A22-AP16	63	5	63	22	50	10.4	6.3	14	AP*T1604	S60M4	T15P	Fig2

● 标准库存 Stock ○ 需预定 Available upon Order

APGT-AL刀片 — 铝合金方肩铣削

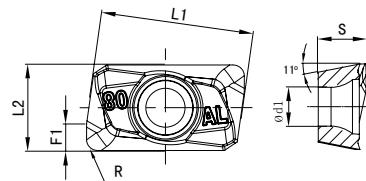
APGT-AL Insert — Shoulder Milling for Aluminum Alloy

特点

Features

- 锋利刃配合表面抛光，铝合金加工首选
Sharp edge with surface polishing is the first choice for aluminum machining.
- 独特的槽型配合优质牌号，确保刀片长寿命
Unique geometry combined with ideal grade to ensure long life.
- 高精度的刀片制造工艺，获得理想的表面质量
High accuracy inserts results in excellent surface finish.

APGT-AL



订货号 Ordering Code	尺寸 Dimensions(mm)						库存 Stock			
	L1	L2	S	F1	ΦD1	R	GA4225	GA4230	GK4125	GN9125
APGT1135PDR-AL	10.83	6.16	3.5	1.92	2.8	0.8				●
APGT1604PDR-AL	16.26	9.26	4.76	2	4.6	0.8				●

AL—铝合金/Aluminum Alloy

● 标准库存 Stock ○ 需预定 Available upon Order

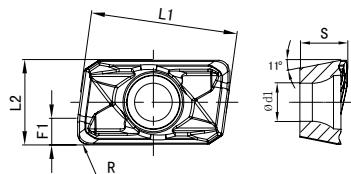
APMT-PL 刀片—通用材料轻载方肩铣削

APMT-PL Insert — Light Shoulder Milling for General Materials

特点 Features

- 槽型与多种牌号优化组合，满足不同材料的铣削加工应用
The combination of variety geometries and grades can meet different materials milling applications.
- 独特的槽型设计，满足轻载加工的需要
Unique geometries design to satisfy light cutting.
- 低切削力与优良的排屑性能结合，获得更好的表面质量
Low cutting force with perfect chip evacuation to achieve excellent surface finish.

APMT-PL



订货号 Ordering Code		尺寸 Dimensions(mm)						库存 Stock			
		L1	L2	S	F1	ΦD1	R	GA4225	GA4230	GK4125	GN9125
	APMT1135PDER-PL	10.83	6.16	3.5	1.92	2.8	0.8	●	●		
	APMT1604PDER-PL	16.26	9.26	4.76	2	4.6	0.8	●	●		

PL-轻载/Light

● 标准库存 Stock ○ 需预定 Available upon Order

适用范围 Application Range

ISO	P				M				K				N				S								
	钢 Steel				不锈钢 Stainless Steel				铸铁 Cast Iron				有色金属 Nonferrous Metal				耐热、钛合金 Heat-resistant Alloy TitaniumAlloy								
	P01	P10	P20	P30	P40	M01	M10	M20	M30	M40	K01	K10	K20	K30	K40	N01	N10	N20	N30	N40	S01	S10	S20	S30	S40
适用领域 Range																									

推荐切削参数

Recommended Cutting Data

工件材料 Workpiece Materials		牌号 Grade	切削速度 Cutting speed	轻载切削 Light Cutting		中载切削 Medium Cutting		重载切削 Heavy Cutting	
			Vc (m/min)	进给/刃 (mm/tooth)	槽型 Geometry	进给/刃 (mm/tooth)	槽型 Geometry	进给/刃 (mm/tooth)	槽型 Geometry
P	软钢 Low Carbon Steel \leqslant HB200	GA4225 GA4230	150–180–200	0.05–0.1–0.15	PL	0.1–0.15–0.2	PM	0.1–0.2–0.25	PR
	碳钢、合金钢 Carbon Steel、Alloy Steel \leqslant HRC35	GA4225 GA4230	120–150–200	0.1–0.1–0.15	PL	0.1–0.15–0.2	PM	0.1–0.2–0.25	PR
	碳钢、合金钢 Carbon Steel、Alloy Steel HRC35–45	GA4225 GA4230	120–150–200	0.1–0.1–0.15	PL	0.1–0.15–0.2	PM	0.1–0.2–0.25	PR
M	不锈钢 Stainless Steel \leqslant HRC35	GA4225 GA4230	100–140–160	0.1–0.15–0.3	PL	0.1–0.15–0.2	PM	0.1–0.2–0.25	PR
K	铸造、球墨铸造 Gray Cast Iron Nodular Cast Iron (eg: FC250、FCD400) \leqslant HB350	GA4230	100–120–140	0.05–0.1–0.15	PL	0.1–0.15–0.2	PM	0.1–0.2–0.25	PR
N	铝合金 Aluminum Alloy HB60–210	GN9125	200–500–900	0.05–0.15–0.25	AL	0.05–0.15–0.25	AL	0.05–0.15–0.25	AL
S	耐热合金、钛合金 Heat-resistant Alloy and Titanium Alloy \leqslant HRC35	GA4230	50–60–100	0.05–0.1–0.15	PL	0.05–0.1–0.15	PM	0.1–0.15–0.15	PR
H	淬火钢 Hardened Steel HRC45–55	GA4230	50–60–100	0.05–0.1–0.15	PL	0.05–0.1–0.15	PM	0.1–0.15–0.15	PR



SUPERHARD CUTTING TOOLS

超硬刀具

YP系列PCD标准刀片

YP Series PCD Tipped Profiling Inserts



特点 Features

- 适用于难加工有色金属材料以及非金属材料的加工
Suitable for hard machining nonferrous metal materials and non-metallic materials processing.
- 可实现高速高效高精度加工
Outstanding for high speed, high efficiency and high precision processing.
- 装卸方便，可快速精确定位，节约换刀时间
Convenient loading and unloading, allows fast and accurate positioning, saving tool change time.
- 具有极高的耐磨性且焊接牢固，刀具使用寿命长
Very high abrasion resistance and superior brazing process provides for long tool life.

牌号系列 Grade Profile

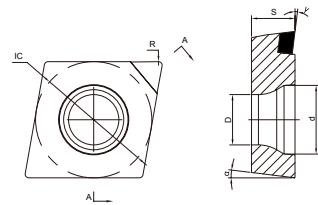
牌号 Grades	特点 Features
GD9950	极高的耐磨性及抗冲击性能，超长的刀具寿命； High abrasion resistance and impact resistance performance for long edge life; 主要用于石墨、高硅铝合金、复合木地板等其他耐磨材料的加工； Mainly used for graphite, high silicon aluminum alloy, processing of composite wood and other wear-resistant materials;
GD9852	兼具良好的韧性及耐磨性,使用范围广泛，可作为粗精加工一体化刀具使用； Combination of good toughness and wear resistance, wide range of use, can be used as both rough and finish machining; 主要用于中低硅铝合金、铜及铜合金等材料的加工； Mainly used for the processing of low silicon aluminum alloy, Cu and copper alloy material.

超硬刀具

Superhard Cutting Tools

YP系列PCD标准刀片

YP Series PCD Tipped Profiling Inserts

C-80°

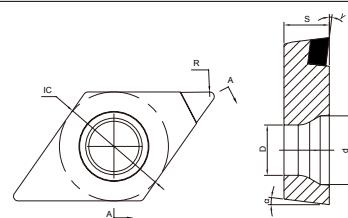
订货号 Ordering Code	尺寸 Dimensions(mm)						库存 Stock	
	IC	S	d	R	α	γ	GD9950	GD9852
CCGW 09T304	9.525	3.97	4.4	0.4	7	0	○	○
CCGW 09T308	9.525	3.97	4.4	0.8	7	0	○	○
CCGW 09T304Q3	9.525	3.97	4.4	0.4	7	3	○	○
CCGW 09T308Q3	9.525	3.97	4.4	0.8	7	3	○	●
CCGW 09T304Q7	9.525	3.97	4.4	0.4	7	7	○	○
CCGW 09T308Q7	9.525	3.97	4.4	0.8	7	7	○	●
CPGW 09T304	9.525	3.97	4.4	0.4	11	0	○	○
CPGW 09T308	9.525	3.97	4.4	0.8	11	0	○	○
CPGW 09T304Q3	9.525	3.97	4.4	0.4	11	3	○	●
CPGW 09T308Q3	9.525	3.97	4.4	0.8	11	3	○	○
CPGW 09T304Q7	9.525	3.97	4.4	0.4	11	7	○	●
CPGW 09T308Q7	9.525	3.97	4.4	0.8	11	7	○	○
CCGW120404	12.7	4.76	5.5	0.4	0	0	○	○
CCGW120408	12.7	4.76	5.5	0.8	0	0	●	○
CCGW120404Q3	12.7	4.76	5.5	0.4	0	3	○	●
CCGW120408Q3	12.7	4.76	5.5	0.8	0	3	○	●
CCGW120404Q7	12.7	4.76	5.5	0.4	0	7	○	○
CCGW120408Q7	12.7	4.76	5.5	0.8	0	7	○	○

● 标准库存 Stock ○ 需预定 Available upon Order

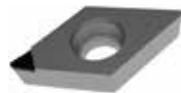
超硬刀具
Superhard Cutting Tools

YP系列PCD标准刀片
YP Series PCD Tipped Profiling Inserts

D-55°



订货号 Ordering Code	尺寸 Dimensions(mm)						库存 Stock	
	IC	S	d	R	α	γ	GD9950	GD9852
DCGW 11T302	9.525	3.97	4.4	0.20	7	0	○	○
DCGW 11T304	9.525	3.97	4.4	0.40	7	0	○	○
DCGW11T308	9.525	3.97	4.4	0.80	7	0	●	○
DCGW 11T302Q3	9.525	3.97	4.4	0.20	7	3	○	○
DCGW 11T304Q3	9.525	3.97	4.4	0.40	7	3	○	●
DCGW11T308Q3	9.525	3.97	4.4	0.80	7	3	○	●
DCGW 11T302Q7	9.525	3.97	4.4	0.20	7	7	○	○
DCGW 11T304Q7	9.525	3.97	4.4	0.40	7	7	○	○
DCGW11T308Q7	9.525	3.97	4.4	0.80	7	7	○	○



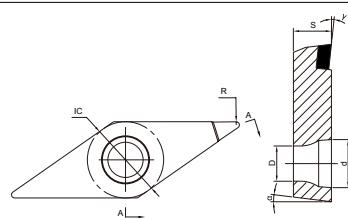
●标准库存 Stock ○需预定 Available upon Order

超硬刀具

Superhard Cutting Tools

YP系列PCD标准刀片

YP Series PCD Tipped Profiling Inserts

V-35°

订货号 Ordering Code	尺寸 Dimensions(mm)						库存 Stock	
	IC	S	d	R	α	γ	GD9950	GD9852
VCGW110302	6.35	3.18	2.8	0.2	7	0	○	○
VCGW110304	6.35	3.18	2.8	0.4	7	0	○	○
VCGW110302Q3	6.35	3.18	2.8	0.2	7	3	○	○
VCGW110304Q3	6.35	3.18	2.8	0.4	7	3	○	●
VCGW110302Q7	6.35	3.18	2.8	0.2	7	7	○	○
VCGW110304Q7	6.35	3.18	2.8	0.4	7	7	○	○
	VCGW160404	9.525	4.76	4.4	0.4	7	0	○
	VCGW160408	9.525	4.76	4.4	0.8	7	0	●
	VCGW160404Q3	9.525	4.76	4.4	0.4	7	3	○
	VCGW160408Q3	9.525	4.76	4.4	0.8	7	3	●
	VCGW160404Q7	9.525	4.76	4.4	0.4	7	7	○
	VCGW160408Q7	9.525	4.76	4.4	0.8	7	7	○

● 标准库存 Stock ○ 需预定 Available upon Order

推荐切削参数

Recommended Cutting Data

工件材料 Workpiece Material	切削速度 V_c (m/min)	进给量 f_n (mm/r)	切削深度 a_p (mm)
石墨 Stone	100–500	0.1–1	0.5–2
高硅铝合金 High Silicon Aluminum Alloy	300–1000	0.02–0.2	0.1–2
中、低硅铝合金 Silicon, Low Aluminum Alloy	200–1500	0.03–0.4	0.1–3
铜, 铜合金 Copper, Copper Alloy	300–600	0.03–0.5	0.1–3

A

B

C

D



免费技术
服务热线

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