数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GM. TD.
后车削 ABS TBP TKFB
内孔切槽 T.N/E GE. .GR
螺纹车削刀片
铣削刀片

CNGA	A01	刀片材质	CBN	车削刀片
CNGA-2T	A01	刀片材质	CBN	车削刀片
CNMG	A01	刀片材质	PCD	车削刀片
CNMG-AL	A01	刀片材质	PCD带断屑槽	车削刀片
CNGW	A01	刀片材质	PCD平面	车削刀片
CNMG-2T	A01	刀片材质	PCD	车削刀片
CNMG-HA	A01	刀片材质	硬质合金刀片	车削刀片
CNMG-TS	A01	刀片材质	金属陶瓷刀片	车削刀片
CNMG-PF	A01	刀片材质	硬质合金刀片	车削刀片
CNMG-MSF	A01	刀片材质	硬质合金刀片	车削刀片
CNMG-MF	A01	刀片材质	硬质合金刀片	车削刀片
CNMG-HQ	A01	刀片材质	金属陶瓷刀片	车削刀片
CNMG-PM	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-MA	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-MM	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-MT	A02	刀片材质	金属陶瓷刀片	车削刀片
CNMG-HS	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-TM	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-GM	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-MK	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-MS	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-R-X	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-L-X	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-43	A02	刀片材质	硬质合金刀片	车削刀片
CNMA	A02	刀片材质	硬质合金刀片	车削刀片
CNMG-PR	A02	刀片材质	硬质合金刀片	车削刀片
CNMM-PR	A02	刀片材质	硬质合金刀片	车削刀片
DNGA	A03	刀片材质	CBN	车削刀片
DNGA-2T	A03	刀片材质	CBN	车削刀片
DNMG	A03	刀片材质	PCD	车削刀片
DNMG-AL	A03	刀片材质	PCD带断屑槽	车削刀片
DNGW	A03	刀片材质	PCD平面	车削刀片
DNMG-2T	A03	刀片材质	PCD	车削刀片
DNMG-HA	A03	刀片材质	硬质合金刀片	车削刀片
DNMG-PF	A03	刀片材质	硬质合金刀片	车削刀片
DNMG-MSF	A03	刀片材质	硬质合金刀片	车削刀片
DNMG-MF	A03	刀片材质	硬质合金刀片	车削刀片
DNMG-FG	A03	刀片材质	硬质合金刀片	车削刀片
DNMG-MK	A03	刀片材质	硬质合金刀片	车削刀片
DNMG-PM	A04	刀片材质	硬质合金刀片	车削刀片
DNMG-MM	A04	刀片材质	硬质合金刀片	车削刀片
DNMG-TM	A04	刀片材质	硬质合金刀片	车削刀片
DNMG-HQ	A04	刀片材质	金属陶瓷刀片	车削刀片
DNMG-R-VF	A04	刀片材质	金属陶瓷刀片	车削刀片
DNMG-L-VF	A04	刀片材质	金属陶瓷刀片	车削刀片
DNMG-R-S	A04	刀片材质	金属陶瓷刀片	车削刀片
DNMG-L-S	A04	刀片材质	金属陶瓷刀片	车削刀片
DNMG-MS	A04	刀片材质	硬质合金刀片	车削刀片
DNMG-43	A04	刀片材质	硬质合金刀片	车削刀片
DNMA	A04	刀片材质	硬质合金刀片	车削刀片
DNMG-PR	A04	刀片材质	硬质合金刀片	车削刀片
KNUX-R	A05	刀片材质	硬质合金刀片	车削刀片
KNUX-L	A05	刀片材质	硬质合金刀片	车削刀片
RNMG-MO	A06	刀片材质	硬质合金刀片	车削刀片
175.32	A06	刀片材质	硬质合金刀片	车削刀片
SNGA	A07	刀片材质	CBN	车削刀片
SNGA-4T	A07	刀片材质	CBN	车削刀片
SNMG	A07	刀片材质	PCD	车削刀片
SNMG-AL	A07	刀片材质	PCD带断屑槽	车削刀片
SNGW	A07	刀片材质	PCD平面	车削刀片
SNMG-4T	A07	刀片材质	PCD	车削刀片
SNMG-HA	A07	刀片材质	硬质合金刀片	车削刀片
SNMG-PF	A07	刀片材质	硬质合金刀片	车削刀片
SNMG-MF	A07	刀片材质	硬质合金刀片	车削刀片
SNMG-PM	A07	刀片材质	硬质合金刀片	车削刀片
SNMG-HS	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-TM	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-GM	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-R-S	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-L-S	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-MA	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-MM	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-MT	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-HQ	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-MK	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-MS	A08	刀片材质	硬质合金刀片	车削刀片
SNMA	A08	刀片材质	硬质合金刀片	车削刀片
SNMG-PR	A08	刀片材质	硬质合金刀片	车削刀片
SNMM-PR	A08	刀片材质	硬质合金刀片	车削刀片
TNGA	A09	刀片材质	CBN	车削刀片
TNGA-3T	A09	刀片材质	CBN	车削刀片
TNMG	A09	刀片材质	PCD	车削刀片
TNMG-AL	A09	刀片材质	PCD带断屑槽	车削刀片
TNGW	A09	刀片材质	PCD平面	车削刀片
TNMG-3T	A09	刀片材质	PCD	车削刀片
TNMG-HA	A09	刀片材质	硬质合金刀片	车削刀片
TNGG-R-S	A09	刀片材质	精密研磨刀片	车削刀片
TNGG-L-S	A09	刀片材质	精密研磨刀片	车削刀片
TNGG-R-P	A09	刀片材质	精密研磨刀片	车削刀片
TNGG-L-P	A09	刀片材质	精密研磨刀片	车削刀片
TNMG-TS	A09	刀片材质	硬质合金刀片	车削刀片
TNMG-PF	A09	刀片材质	硬质合金刀片	车削刀片
TNMG-MSF	A09	刀片材质	硬质合金刀片	车削刀片
TNMG-MF	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-PM	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-MM	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-MA	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-CQ	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-MT	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-HQ	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-MQ	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-HS	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-TM	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-MK	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-GM	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-43	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-R-S	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-L-S	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-R-VF	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-L-VF	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-MS	A10	刀片材质	硬质合金刀片	车削刀片
TNMA	A10	刀片材质	硬质合金刀片	车削刀片
TNMG-PR	A10	刀片材质	硬质合金刀片	车削刀片
TNMM-PR	A10	刀片材质	硬质合金刀片	车削刀片
VNGA	A11	刀片材质	CBN	车削刀片
VNGA-2T	A11	刀片材质	CBN	车削刀片
VNMG	A11	刀片材质	PCD	车削刀片
VNMG-AL	A11	刀片材质	PCD带断屑槽	车削刀片
VNGW	A11	刀片材质	PCD平面	车削刀片
VNMG-2T	A11	刀片材质	PCD	车削刀片
VNMG-HA	A11	刀片材质	硬质合金刀片	车削刀片
VNMG-PF	A11	刀片材质	硬质合金刀片	车削刀片
VNMG-MSF	A11	刀片材质	硬质合金刀片	车削刀片
VNMG-MF	A11	刀片材质	硬质合金刀片	车削刀片
VNMG-PM	A11	刀片材质	硬质合金刀片	车削刀片
VNMG-MA	A12	刀片材质	硬质合金刀片	车削刀片
VNMG-MM	A12	刀片材质	硬质合金刀片	车削刀片
VNMG-MT	A12	刀片材质	硬质合金刀片	车削刀片
VNMG-HQ	A12	刀片材质	硬质合金刀片	车削刀片
VNMG-HS	A12	刀片材质	硬质合金刀片	车削刀片
VNMG-TM	A12	刀片材质	硬质合金刀片	车削刀片
VNMG-GM	A12	刀片材质	硬质合金刀片	车削刀片
VNMG-MS	A12	刀片材质	硬质合金刀片	车削刀片
VNMA	A12	刀片材质	硬质合金刀片	车削刀片
VNMG-PR	A12	刀片材质	硬质合金刀片	车削刀片
WNGA	A13	刀片材质	CBN	车削刀片
WNGA-3T	A13	刀片材质	CBN	车削刀片
WNMG	A13	刀片材质	PCD	车削刀片
WNMG-AL	A13	刀片材质	PCD带断屑槽	车削刀片
WNGW	A13	刀片材质	PCD平面	车削刀片
WNMG-3T	A13	刀片材质	PCD	车削刀片
WNMG-HA	A13	刀片材质	硬质合金刀片	车削刀片
WNMG-TS	A13	刀片材质	硬质合金刀片	车削刀片
WNMG-PF	A13	刀片材质	硬质合金刀片	车削刀片

WNMG-MSF	A13	刀片材质	硬质合金刀片	车削刀片
WNMG-MF	A13	刀片材质	硬质合金刀片	车削刀片
WNMG-HQ	A13	刀片材质	硬质合金刀片	车削刀片
WNMG-PM	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-MQ	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-MA	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-MK	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-MM	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-MT	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-HS	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-TM	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-GM	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-CQ	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-PC	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-CM	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-MS	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-43	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-R-S	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-L-S	A14	刀片材质	硬质合金刀片	车削刀片
WNMA	A14	刀片材质	硬质合金刀片	车削刀片
WNMG-PR	A14	刀片材质	硬质合金刀片	车削刀片
CCGT	A15	刀片材质	CBN	车削刀片
CCGT-2T	A15	刀片材质	CBN	车削刀片
CCGT	A15	刀片材质	PCD	车削刀片
CCGT-AL	A15	刀片材质	PCD带断屑槽	车削刀片
CCGW	A15	刀片材质	PCD平面	车削刀片
CCGT-2T	A15	刀片材质	PCD	车削刀片
CCGT-AL	A15	刀片材质	硬质合金刀片	车削刀片
CCGT-R	A15	刀片材质	硬质合金刀片	车削刀片
CCGT-L	A15	刀片材质	硬质合金刀片	车削刀片
CCGT-ER-U	A15	刀片材质	硬质合金刀片	车削刀片
CCGT-EL-U	A15	刀片材质	硬质合金刀片	车削刀片
CCGT-R-H	A15	刀片材质	硬质合金刀片	车削刀片
CCGT-L-H	A15	刀片材质	硬质合金刀片	车削刀片
CCMT-TF	A16	刀片材质	硬质合金刀片	车削刀片
CCMT-TF	A16	刀片材质	硬质合金刀片	车削刀片
CCMT-TF	A16	刀片材质	硬质合金刀片	车削刀片
CCMT-TF	A16	刀片材质	硬质合金刀片	车削刀片
CCMT-TF	A16	刀片材质	硬质合金刀片	车削刀片
CCMT-TF	A16	刀片材质	硬质合金刀片	车削刀片
CCMT-TF	A16	刀片材质	硬质合金刀片	车削刀片
CCMT-TF	A16	刀片材质	硬质合金刀片	车削刀片
CCMT-TF	A16	刀片材质	硬质合金刀片	车削刀片
DCGT	A17	刀片材质	CBN	车削刀片
DCGT-2T	A17	刀片材质	CBN	车削刀片
DCGT	A17	刀片材质	PCD	车削刀片
DCGT-AL	A17	刀片材质	PCD带断屑槽	车削刀片
DCGW	A17	刀片材质	PCD平面	车削刀片
DCGT-2T	A17	刀片材质	PCD	车削刀片
DCGT-AL	A17	刀片材质	硬质合金刀片	车削刀片
DCGT-R	A17	刀片材质	硬质合金刀片	车削刀片
DCGT-L	A17	刀片材质	硬质合金刀片	车削刀片
DCGT-ER-U	A17	刀片材质	硬质合金刀片	车削刀片
DCGT-EL-U	A17	刀片材质	硬质合金刀片	车削刀片
DCGT-R-H	A17	刀片材质	硬质合金刀片	车削刀片
DCGT-L-H	A17	刀片材质	硬质合金刀片	车削刀片
DCMT-TF	A18	刀片材质	硬质合金刀片	车削刀片
DCMT-FG	A18	刀片材质	硬质合金刀片	车削刀片
DCMT-TM	A18	刀片材质	硬质合金刀片	车削刀片
DCMT-MT	A18	刀片材质	硬质合金刀片	车削刀片
DCMT-GM	A18	刀片材质	硬质合金刀片	车削刀片
DCMT-HQ	A18	刀片材质	硬质合金刀片	车削刀片
DCMT	A18	刀片材质	硬质合金刀片	车削刀片
DCMT-MV	A18	刀片材质	硬质合金刀片	车削刀片
DCMT-TR	A18	刀片材质	硬质合金刀片	车削刀片
WBGT	A19	刀片材质	CBN	车削刀片
WBGT	A19	刀片材质	PCD	车削刀片
WBGT-R	A19	刀片材质	硬质合金刀片	车削刀片
WBGT-L	A19	刀片材质	硬质合金刀片	车削刀片
RCGT-AL	A19	刀片材质	硬质合金刀片	车削刀片
RCMX-MO	A19	刀片材质	硬质合金刀片	车削刀片
SCGT	A20	刀片材质	CBN	车削刀片
SCGT	A20	刀片材质	PCD	车削刀片
SCGW	A20	刀片材质	PCD	车削刀片
SCGT-AL	A20	刀片材质	硬质合金刀片	车削刀片
SCMT-TF	A20	刀片材质	硬质合金刀片	车削刀片
SCMT-MT	A20	刀片材质	硬质合金刀片	车削刀片
SCMT-TM	A20	刀片材质	硬质合金刀片	车削刀片
SCMT-GM	A20	刀片材质	硬质合金刀片	车削刀片
SCMT-HQ	A20	刀片材质	硬质合金刀片	车削刀片
SCMT-TR	A20	刀片材质	硬质合金刀片	车削刀片
TCGT	A21	刀片材质	CBN	车削刀片
TCGT-3T	A21	刀片材质	CBN	车削刀片
TCGW	A21	刀片材质	PCD平面	车削刀片
TCGT-3T	A21	刀片材质	PCD	车削刀片
TCGT-AL	A21	刀片材质	硬质合金刀片	车削刀片
TPGT-L	A21	刀片材质	硬质合金刀片	车削刀片
TPGT-R	A21	刀片材质	硬质合金刀片	车削刀片
TCMT-TF	A22	刀片材质	硬质合金刀片	车削刀片
TCMT-FG	A22	刀片材质	硬质合金刀片	车削刀片
TCMT-TM	A22	刀片材质	硬质合金刀片	车削刀片
TCMT-GM	A22	刀片材质	硬质合金刀片	车削刀片
TCMT	A22	刀片材质	硬质合金刀片	车削刀片
TCMT-MV	A22	刀片材质	硬质合金刀片	车削刀片
TCMT-HQ	A22	刀片材质	硬质合金刀片	车削刀片
TCMT-MT	A22	刀片材质	硬质合金刀片	车削刀片
TCMT-TR	A22	刀片材质	硬质合金刀片	车削刀片
VBGT	A23	刀片材质	CBN	车削刀片
VBGT-2T	A23	刀片材质	CBN	车削刀片
VBGW	A23	刀片材质	PCD	车削刀片
VBGT-AL	A23	刀片材质	PCD带断屑槽	车削刀片
VBGT	A23	刀片材质	PCD平面	车削刀片
VBGT-AL	A23	刀片材质	硬质合金刀片	车削刀片
VBGT-R-F	A24	刀片材质	硬质合金刀片	车削刀片
VBGT-L-F	A24	刀片材质	硬质合金刀片	车削刀片
VBGT-R-Y	A24	刀片材质	硬质合金刀片	车削刀片
VBGT-L-Y	A24	刀片材质	硬质合金刀片	车削刀片
VBGT-R-H	A24	刀片材质	硬质合金刀片	车削刀片
VBGT-L-H	A24	刀片材质	硬质合金刀片	车削刀片
VBMT-TF	A24	刀片材质	硬质合金刀片	车削刀片
VBMT-HQ	A24	刀片材质	硬质合金刀片	车削刀片
VBMT-MT	A24	刀片材质	硬质合金刀片	车削刀片
VBMT-MV	A24	刀片材质	硬质合金刀片	车削刀片
VBMT-TM	A24	刀片材质	硬质合金刀片	车削刀片
VBMT-GM	A24	刀片材质	硬质合金刀片	车削刀片
VBMT-TR	A24	刀片材质	硬质合金刀片	车削刀片

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GM. TD.
后车削 ABS TBP TKFB
内孔切槽 T.N/E GE. .GR
螺纹车削刀片
铣削刀片

切槽/切断加工

Grooving /Cut-off Machining

TGF32R	TGF32R..R..	TGF32L	TGF32L..R..	GBA43R	GBA43R..R..	GBA43L	GBA43L..R..	T..E..	T..N..	T..N..DM..	T..N..DM..R..
A25	A25	A25	A25	A26	A26	A26	A26	A27	A27	A27	A27
刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质
硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片
切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	端面切槽刀片	端面圆弧切槽刀片

CTP	CTPA	CTPW	TKF
A30	A31	A32	A33
刀片材质	刀片材质	刀片材质	刀片材质
硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片
小零件切槽切断刀片	小零件切槽切断刀片	小零件切槽切断刀片	小零件切槽切断刀片

FGD	FGM	FMM	MFMN	MGMN-G	MGMN-M	MGMN-T	MGMN-H	MGMR-PS	MGML-PS	MGMN-R..	MGMN-L..
A35	A35	A35	A35	A35	A35	A35	A35	A35	A35	A35	A35
刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质
硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片
端面切槽刀片	端面切槽刀片	端面切槽刀片	端面切槽刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片

MGMN	MRGN-A	MRGN-M	MRMN	MVGN	MGGN	MGGN-R..	MGGN-L..	SP..	A4G..	A4R..	DGN-C
A36	A36	A36	A36	A36	A36	A36	A36	A36	A37	A37	A37
刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质
PCD/CBN	硬质合金刀片	硬质合金刀片	CBN/PCD	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片
切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片

DGN-J	PENTA24N	GCMN-MG	GCMN-RG	GMM-MT	GMM-R-MT	GMM-R-TK	GMM-L-MT	GMM-L-TK	GMM-MW	GMM-R	GY2M-MM
A37	A37	A38	A38	A38	A38	A38	A38	A38	A38	A38	A39
刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质
硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片
切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片

GY2M-BM	N123-CM	N123-TM	N123-RM	TDC	TDJ	TDC-R	TSC	TDT	TDC-L	WGE	WGR
A39	A39	A39	A39	A40	A40	A40	A40	A40	A40	A40	A40
刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质
硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片
切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片

WGE-R	WGE-L	ZTED	ZRED	ZQMX	ZR..
A40	A40	A41	A41	A41	A41
刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质
硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片
切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片

GER-A	GER-AR	GER-B	GER-BR	GER-C	GER-CR	GER-D	GER-DR	GER-E	GER-ER	GER-DM	GER-DM-R
A47	A47	A47	A47	A47	A47	A48	A47	A48	A48	A48	A48
刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质
硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片
切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	切槽刀片	端面切槽刀片	端面切槽刀片

7GR..	8/9GR..
A49	A49
刀片材质	刀片材质
硬质合金刀片	硬质合金刀片
切槽刀片	切槽刀片

后车削加工

Back Turning Machining

TBP	TKFB	TB32..	ABS15R..	ABW15R..	ABW23R..
A43	A44	A45	A46	A46	A46
刀片材质	刀片材质	刀片材质	刀片材质	刀片材质	刀片材质
硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片	硬质合金刀片
切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片	切槽/切断刀片

螺纹切削加工

Thread Machining

压制 ISO..	研磨级 ISO..	CBN/PCD	U型..	TTX32R..	TKFT..	压制 W..	研磨级 W..	CBN/PCD	TTX32R..	TKFT..	UN 美制
A51	A51	A51	A51	A52	A52	A53	A53	A53	A54	A54	A55
60° 公制螺纹	60° 公制螺纹	60° 公制螺纹	60° 公制螺纹	60° 公制螺纹	60° 公制螺纹	55° 英制螺纹	55° 英制螺纹	55° 英制螺纹	55° 英制螺纹	55° 英制螺纹	60°美制螺纹
一般工业用	一般工业用	一般工业用	一般工业用	一般工业用	一般工业用	工业机械用管螺纹	工业机械用管螺纹	工业机械用管螺纹	工业机械用管螺纹	工业机械用管螺纹	一般工业用
螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片

UNJ 航空工业	PG钢导管螺纹	BSPT英制锥管	RND 圆齿	NPT 美制锥管	NPTF干密封	ACME美制梯形	V型ACME	STUB ACME	TR梯形30°	U型TR梯形	V型TR梯形
A56	A56	A57	A57	A58	A58	A59	A60	A59	A60	A60	A60
60°航空工业	80°钢导管螺纹	55°英制锥管螺纹	DIN405圆齿管螺纹	60°美制锥管螺纹	60°美制干密封锥管	29°美制梯形螺纹	29°美制梯形螺纹	29°美制短牙梯形螺纹	30°梯形螺纹DIN103	30°梯形螺纹DIN103	30°梯形螺纹DIN103
航空工业用螺纹	DIN40430全牙型	气管/汽管/水管螺纹	防火管件及食品工业	气管/汽管/水管螺纹	气管/汽管/水管螺纹	传递动力用梯形螺纹	传递动力用梯形螺纹	ACME改善型控制阀门用	传递动力用梯形螺纹	传递动力用梯形螺纹	传递动力用梯形螺纹
螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片

ABUT美制锯齿	BBUT美制锯齿	SAGE公制锯齿	U型SAGE锯齿	V型SAGE锯齿	API石油管螺纹	API RD圆齿	API RD圆齿	BUT梯形套管	BUT梯形套管	EL直线套管
A61	A61	A62	A62	A62	A63	A63	A63	A64	A64	A64
45°+7°美制锯齿	45°+7°英制锯齿	30°+3°公制锯齿	30°+3°公制锯齿	30°+3°公制锯齿	60°石油管螺纹	60°圆齿石油管螺纹	60°圆齿石油管螺纹	10°+3°梯形套管螺纹	10°+3°梯形套管螺纹	6°+6°直线套管螺纹
单向受力传递动力用	单向受力传递动力用	单向受力传递动力用	单向受力传递动力用	单向受力传递动力用	石油及天然气工业	石油及天然气工业	石油及天然气工业	石油梯形套管用螺纹	石油梯形套管用螺纹	石油直线套管用螺纹
螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片	螺纹刀片

铣削/钻孔加工

Milling / Drilling Machining

WNMU04..	WNMU08..	6NGU	3PKT..R-M	3PKT..R-ML	3PKT..R-AL	JDMT	EDMT	APKT1003	APKT-G2	APKT-AL	APKT-PCD
A65	A65	A65	A65	A65	A65	A65	A65	A65	A66	A66	A66
双面高进给	双面高进给	双面高进给	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削
High Feed Cutting	High Feed Cutting	High Feed Cutting	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling
铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片

APKT-CBN	APMT-M2	APMT-H..	APMT-DU	APMT-KZ	APMT-ZM	R390-PM	RT	XOMX	AOMT	SEET	APET
A66	A66	A66	A66	A66	A66	A66	A67	A67	A67	A67	A67
直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削
Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling
铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片

AXMT	AXCT	TPKN	TPMR	RPGT-AL	RPEW-MO	RPKT-MOF	RPKT-MOT	RPMT-MOE-JS	RPMT-DU	RPMT-MO-GH	RCGT-AL
A67	A67	A67	A67	A68	A68	A68	A68	A68	A68	A68	A68
直角台肩铣削	直角台肩铣削	直角台肩铣削	直角台肩铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削
Right Angle Milling	Right Angle Milling	Right Angle Milling	Right Angle Milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling
铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片

RCKT-MO-PM	RCKT-MO-PR	RCMT-MO	RCMX-MO	RDKW-MO	RDKX-MO	RDKX-MP-1	RDMW-MOT-PM	RDMT-MO	RNGJ	ZC..	SWB
A68	A68	A69	A69	A69	A69	A69	A69	A69	A69	A69	A70
圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	圆鼻铣削	球形铣削	球形铣削
Round nose milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling	Round nose milling	Ball milling	Ball milling
铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片

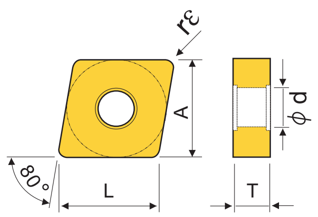
ZPFG	ZCFW	BNM	P3200	ADMT	APMT	CCMT	CPMT	TCMX	SDMB	LPMT	SPMT
A70	A70	A70	A70	A71	A71	A71	A71	A71	A71	A71	A71
球形铣削	球形铣削	球形铣削	球形铣削	钻孔+铣削加工	钻孔+铣削加工	钻孔+铣削加工	钻孔+铣削加工	定位倒角加工	倒角加工	玉米型粗铣加工	玉米型粗铣加工
Ball milling	Ball milling	Ball milling	Ball milling	Drilling + Milling	Drilling + Milling	Drilling + Milling	Drilling + Milling	Positioning Chamfering	Chamfering	Corn type rough milling	Corn type rough milling
铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片

MPHT	XSEQ	JOMW/JDMT	EPNW	SDMT	WDMW	WPGT	HNGX	BLMP06..	BLMP12..	LNMU	SEMT13T3..
A71	A72	A72	A72	A72	A73	A73	A73	A73	A73	A73	A73
三面刃铣削加工	三面刃铣削加工	高进给铣削加工	高进给铣削加工	高进给铣削加工	高进给铣削加工	高进给铣削加工	双面高进给铣削	双面高进给铣削	双面高进给铣削	双面高进给铣削	平面铣削加工
Three side edge milling	Three side edge milling	High Feed Cutting	High Feed Cutting	High Feed Cutting	High Feed Cutting	High Feed Cutting	High Feed Cutting	High Feed Cutting	High Feed Cutting	High Feed Cutting	Face milling
铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片

SEET12T3..	SECA	SEKT1204..	SEHT1204..	SEHT-AK	SEHT-PCD	SEHT-CBN	SEKN	SEKR	WCMX-SU	WCMX-ZK	WCMX
A73	A73	A73	A74	A74	A74	A74	A74	A74	A75	A75	A75
平面铣削加工	平面铣削加工	平面铣削加工	平面铣削加工	平面铣削加工	平面铣削加工	平面铣削加工	平面铣削加工	平面铣削加工	快速钻孔加工	快速钻孔加工	快速钻孔加工
Face milling	Face milling	Face milling	Face milling	Face milling	Face milling	Face milling	Face milling	Face milling	Fast drilling	Fast drilling	Fast drilling
铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	铣削刀片	钻孔刀片	钻孔刀片	钻孔刀片

SPMG-TT	SPMG-PM	SOMT	XOMT-PD	SPMT-PD	WDXT-L	WDXT-G	WDXT-H	GPMT	880-LM	880-GM	880-GR
A75	A75	A75	A75	A75	A76	A76	A76	A76	A76	A76	A76
快速钻孔加工	快速钻孔加工	快速钻孔加工	快速钻孔加工	快速钻孔加工	快速钻孔加工	快速钻孔加工	快速钻孔加工	快速钻孔加工	快速钻孔加工	快速钻孔加工	快速钻孔加工
Fast drilling	Fast drilling	Fast drilling	Fast drilling	Fast drilling	Fast drilling	Fast drilling	Fast drilling	Fast drilling	Fast drilling	Fast drilling	Fast drilling
钻孔刀片	钻孔刀片	钻孔刀片	钻孔刀片	钻孔刀片	钻孔刀片	钻孔刀片	钻孔刀片	钻孔刀片	钻孔刀片	钻孔刀片	钻孔刀片

CN 80°菱形 负角 有孔刀片



外圆车刀 (External Toolholder): B03-B06
内孔车刀 (Internal Toolholder): B35-B36

(mm)

Model	A	T	ϕd
CN..0903..	9.525	3.18	3.81
CN..1204..	12.70	4.76	5.16
CN..1606..	15.875	6.35	6.35
CN..1906..	19.05	6.35	7.94
CN..2509..	25.4	9.52	9.2

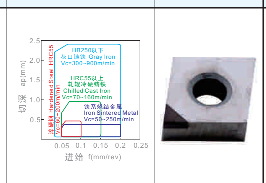
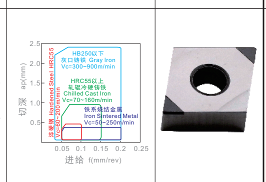
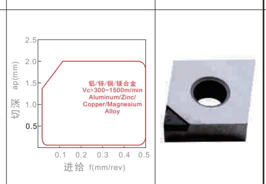
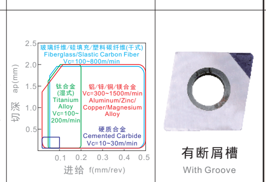
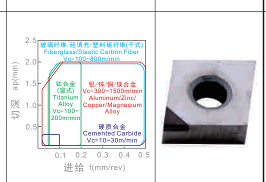
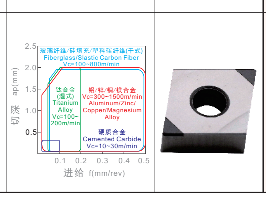
切削线速度 (Cutting Speed): m/min^{-1}

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel			10-30							20-60	20-60	20-80		
M	不锈钢 Stainless Steel				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy	300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30					10-30						20-50		
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200					100-200					20-50	20-60	30-80	

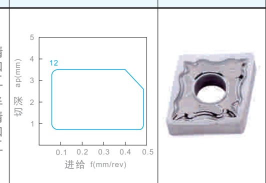
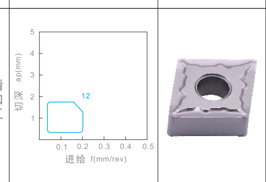
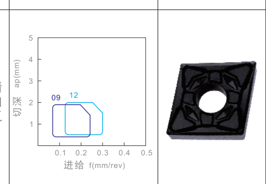
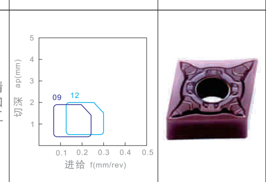
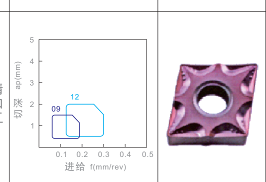
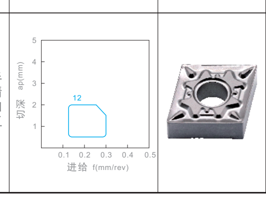
切削形态: Cutting Environment — ● 稳定切削 Stable Cutting; ◕ 一般切削 General Cutting; ✤ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

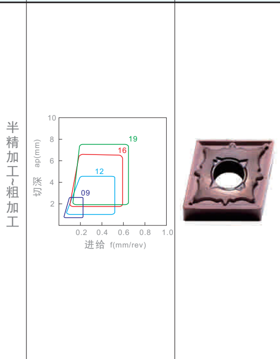
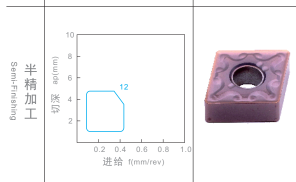
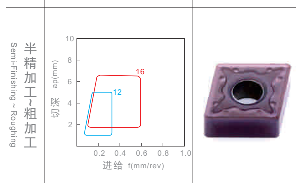
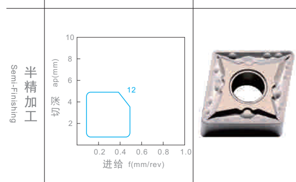
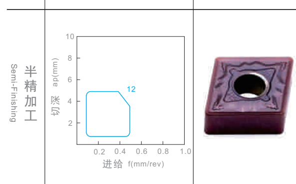
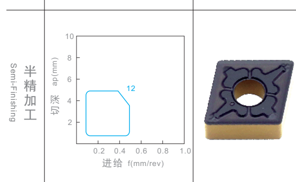
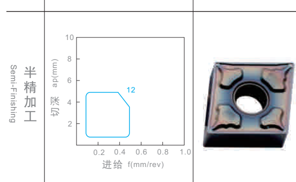
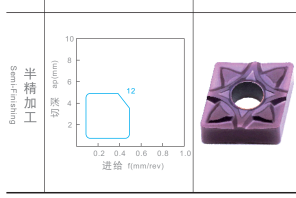
用途 Application / 切削参数 Cutting Parameter / 产品图片 Product Image / 规格型号 Specification / 边长 L / 刀尖 rε / 材质 (PCD, CBN-K, CBN-S, ZN60, ZN90, ZK01, ZC250, ZC251, ZC32S, ZP152, ZP153)





有断屑槽 With Groove



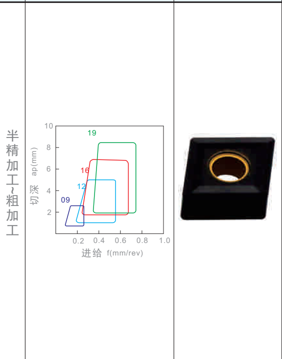
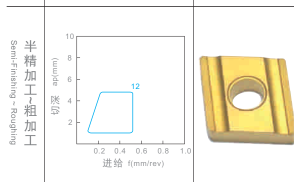
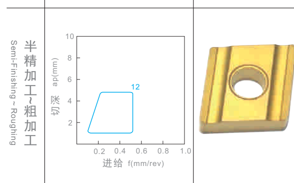
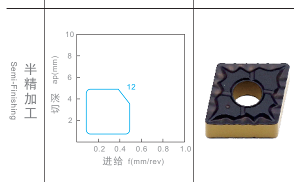
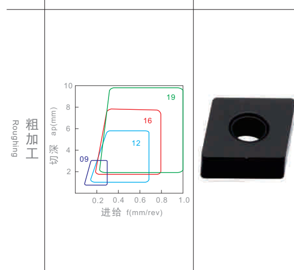
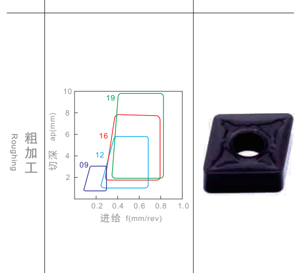
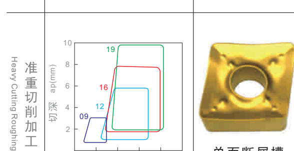
用途 Application	规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
精加工 Finishing	CNGA 120402	12.6	0.2		●	●								
	120404	12.4	0.4		●	●								
	120408	12.0	0.8		●	●								
	120412	11.6	1.2		●	●								
精加工 Finishing	CNGA 120402-2T	12.6	0.2		●	●								
	120404-2T	12.4	0.4		●	●								
	120408-2T	12.0	0.8		●	●								
	120412-2T	11.6	1.2		●	●								
精加工 Finishing	CNMG 120402	12.6	0.2	●										
	120404	12.4	0.4	●										
	120408	12.0	0.8	●										
	120412	11.6	1.2	●										
精加工 Finishing	CNMG 120402-AL	12.6	0.2	●										
	120404-AL	12.4	0.4	●										
	120408-AL	12.0	0.8	●										
	120412-AL	11.6	1.2	●										
精加工 Finishing	CNGW 120402	12.6	0.2	●										
	120404	12.4	0.4	●										
	120408	12.0	0.8	●										
	120412	11.6	1.2	●										
精加工 Finishing	CNMG 120402-2T	12.6	0.2	●										
	120404-2T	12.4	0.4	●										
	120408-2T	12.0	0.8	●										
	120412-2T	11.6	1.2	●										

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工~半精加工 Finishing~Semi-Finishing	CNMG 120404-HA	12.4	0.4			●				●	●			
	120408-HA	12.0	0.8			●				●	●			
	120412-HA	11.6	1.2			●				●	●			
精加工 Finishing	CNMG 120404-TS	12.4	0.4	●										
	120408-TS	12.0	0.8	●										
	120412-TS	11.6	1.2	●										
精加工 Finishing	CNMG 090304-PF	9.2	0.4				●	●		●				
	090308-PF	8.8	0.8				●	●		●				
	120404-PF	12.4	0.4				●	●		●				
	120408-PF	12.0	0.8				●	●		●				
	120412-PF	11.6	1.2				●	●		●				
精加工 Finishing	CNMG 090304-MSF	9.2	0.4							●	●			
	090308-MSF	8.8	0.8							●	●			
	120404-MSF	12.4	0.4							●	●			
	120408-MSF	12.0	0.8							●	●			
半精加工 Semi-Finishing	CNMG 090304-MF	9.2	0.4							●	●			
	090308-MF	8.8	0.8							●	●			
	120404-MF	12.4	0.4							●	●			
	120408-MF	12.0	0.8							●	●			
半精加工 Semi-Finishing	CNMG 120404-HQ	12.4	0.4	●			●	●		●	●			
	120408-HQ	12.0	0.8	●			●	●		●	●			
	120412-HQ	11.6	1.2	●			●	●		●	●			

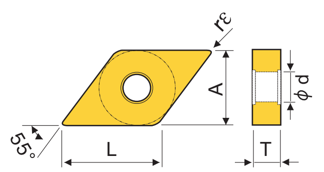









用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工~粗加工 Semi-Finishing~Roughing	CNMG 090304-PM	9.2	0.4				●	●		●				
	090308-PM	8.8	0.8				●	●		●				
	120404-PM	12.4	0.4				●	●		●				
	120408-PM	12.0	0.8				●	●		●				
	120412-PM	11.6	1.2				●	●		●				
	120416-PM	11.2	1.6				●	●		●				
	160608-PM	15.3	0.8				●	●		●				
	160612-PM	14.8	1.2				●	●		●				
	160616-PM	14.4	1.6				●	●		●				
	190608-PM	18.5	0.8				●	●		●				
	190612-PM	18.1	1.2				●	●		●				
	190616-PM	17.7	1.6				●	●		●				
半精加工~粗加工 Semi-Finishing~Roughing	CNMG 120404-MA	12.4	0.4	●			●	●	●	●	●	●		
	120408-MA	12.0	0.8	●			●	●	●	●	●	●		
	120412-MA	11.6	1.2	●			●	●	●	●	●	●		
半精加工~粗加工 Semi-Finishing~Roughing	CNMG 120404-MM	12.4	0.4							●	●			
	120408-MM	12.0	0.8							●	●			
	120412-MM	11.6	1.2							●	●			
	160608-MM	15.3	0.8							●	●			
	160612-MM	14.8	1.2							●	●			
	160616-MM	14.4	1.6							●	●			
半精加工 Semi-Finishing	CNMG 120404-MT	12.4	0.4	●			●			●				
	120408-MT	12.0	0.8	●			●			●				
	120412-MT	11.6	1.2	●			●			●				
半精加工 Semi-Finishing	CNMG 120404-HS	12.4	0.4	●						●				
	120408-HS	12.0	0.8	●						●				
	120412-HS	11.6	1.2	●						●				
半精加工 Semi-Finishing	CNMG 120404-TM	12.4	0.4				●	●	●	●	●	●		
	120408-TM	12.0	0.8				●	●	●	●	●	●		
	120412-TM	11.6	1.2				●	●	●	●	●	●		
半精加工 Semi-Finishing	CNMG 120404-GM	12.4	0.4				●	●	●	●	●	●		
	120408-GM	12.0	0.8				●	●	●	●	●	●		
	120412-GM	11.6	1.2				●	●	●	●	●	●		
半精加工 Semi-Finishing	CNMG 120404-MK	12.4	0.4							●	●			
	120408-MK	12.0	0.8							●	●			
	120412-MK	11.6	1.2							●	●			








单面断屑槽 Single Chip Breaker

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工~粗加工 Semi-Finishing~Roughing	CNMG 090304-MS	9.2	0.4				●	●	●	●	●		●	●
	090308-MS	8.8	0.8				●	●	●	●	●		●	●
	120404-MS	12.4	0.4				●	●	●	●	●		●	●
	120408-MS	12.0	0.8				●	●	●	●	●		●	●
	120412-MS	11.6	1.2				●	●	●	●	●		●	●
	120416-MS	11.2	1.6				●	●	●	●	●		●	●
	160608-MS	15.3	0.8				●	●	●	●	●		●	●
	160612-MS	14.8	1.2				●	●	●	●	●		●	●
	160616-MS	14.4	1.6				●	●	●	●	●		●	●
	160620-MS	14.0	2.0				●	●	●	●	●		●	●
	160630-MS	13.0	3.0				●	●	●	●	●		●	●
	190608-MS	18.5	0.8				●	●	●	●	●		●	●
	190612-MS	18.1	1.2				●	●	●	●	●		●	●
	190616-MS	17.7	1.6				●	●	●	●	●		●	●
半精加工~粗加工 Semi-Finishing~Roughing	CNMG 120404R-X	12.4	0.4				●	●		●				
	120408R-X	12.0	0.8				●	●		●				
	120412R-X	11.6	1.2				●	●		●				
半精加工~粗加工 Semi-Finishing~Roughing	CNMG 120404L-X	12.4	0.4				●	●		●				
	120408L-X	12.0	0.8				●	●		●				
	120412L-X	11.6	1.2				●	●		●				
半精加工 Semi-Finishing	CNMG 120404-43	12.4	0.4				●	●	●	●	●	●		
	120408-43	12.0	0.8				●	●	●	●	●	●		
	120412-43	11.6	1.2				●	●	●	●	●	●		
粗加工 Roughing	CNMA 090304	9.2	0.4				●						●	●
	090308	8.8	0.8				●						●	●
	120404	12.4	0.4				●						●	●
	120408	12.0	0.8				●						●	●
	120412	11.6	1.2				●						●	●
	120416	11.2	1.6				●						●	●
	160608	15.3	0.8				●						●	●
	160612	14.8	1.2				●						●	●
	160616	14.4	1.6				●						●	●
	160620	14.0	2.0				●						●	●
	160630	13.0	3.0				●						●	●
	190608	18.5	0.8				●						●	●
	190612	18.1	1.2				●						●	●
	190616	17.7	1.6				●						●	●
粗加工 Roughing	CNMG 120408-PR	12.0	0.8				●	●		●			●	
	120412-PR	11.6	1.2				●	●		●			●	
	120416-PR	11.2	1.6				●	●		●			●	
	160608-PR	15.3	0.8				●	●		●			●	
	160612-PR	14.8	1.2				●	●		●			●	
	160616-PR	14.4	1.6				●	●		●			●	
	190608-PR	18.5	0.8				●	●		●			●	
	190612-PR	18.1	1.2				●	●		●			●	
	190616-PR	17.7	1.6				●	●		●			●	
	190624-PR	16.9	2.4				●	●		●			●	
准重切削加工 Heavy Cutting Roughing	CNMM 120412-PR	11.6	1.2				●	●		●				
	160608-PR	15.3	0.8				●	●		●				
	160612-PR	14.8	1.2				●	●		●				
	160616-PR	14.4	1.6				●	●		●				
	190612-PR	18.1	1.2				●	●		●				
	190616-PR	17.7	1.6				●	●		●				
	190624-PR	16.9	2.4				●	●		●				
	250924-PR	25.8	2.4				●	●		●				

DN 55°菱形 负角 有孔刀片



外圆车刀 (External Toolholder): B07-B08
内孔车刀 (Internal Toolholder): B40-B41

(mm)

Model	A	T	ϕd
DN..1104..	9.525	4.76	3.81
DN..1504..	12.70	4.76	5.16
DN..1506..	12.70	6.35	5.16
DN..1906..	15.90	6.35	7.94

切削线速度 (Cutting Speed): m/min^{-1}

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel			10-30							20-60	20-60	20-80		
M	不锈钢 Stainless Steel				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy	300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30					10-30						20-50		
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200					100-200				20-50	20-60	30-80		

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✣ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
精加工 Finishing			DNGA 110402	11.4	0.2		●	●								
			110404	11.2	0.4		●	●								
			110408	10.8	0.8		●	●								
			150402	15.3	0.2		●	●								
			150404	15.1	0.4		●	●								
			150408	14.7	0.8		●	●								
			150412	14.4	1.2		●	●								
精加工 Finishing			DNGA 110402-2T	11.4	0.2		●	●								
			110404-2T	11.2	0.4		●	●								
			110408-2T	10.8	0.8		●	●								
			150402-2T	15.3	0.2		●	●								
			150404-2T	15.1	0.4		●	●								
			150408-2T	14.7	0.8		●	●								
			150412-2T	14.4	1.2		●	●								
精加工 Finishing			DNMG 110402	11.4	0.2	●										
			110404	11.2	0.4	●										
			110408	10.8	0.8	●										
			150402	15.3	0.2	●										
			150404	15.1	0.4	●										
			150408	14.7	0.8	●										
			150412	14.4	1.2	●										
精加工 Finishing		有断屑槽 With Groove	DNMG 110402-AL	11.4	0.2	●										
			110404-AL	11.2	0.4	●										
			110408-AL	10.8	0.8	●										
			150402-AL	15.3	0.2	●										
			150404-AL	15.1	0.4	●										
			150408-AL	14.7	0.8	●										
			150412-AL	14.4	1.2	●										
精加工 Finishing			DNGW 110402	11.4	0.2	●										
			110404	11.2	0.4	●										
			110408	10.8	0.8	●										
			150402	15.3	0.2	●										
			150404	15.1	0.4	●										
			150408	14.7	0.8	●										
			150412	14.4	1.2	●										
精加工 Finishing			DNMG 110402-2T	11.4	0.2	●										
			110404-2T	11.2	0.4	●										
			110408-2T	10.8	0.8	●										
			150402-2T	15.3	0.2	●										
			150404-2T	15.1	0.4	●										
			150408-2T	14.7	0.8	●										
			150412-2T	14.4	1.2	●										

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✣ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工~半精加工 Finishing~Semi-Finishing			DNMG 150404-HA	15.1	0.4			●				●	●			
			150408-HA	14.7	0.8			●				●	●			
			150412-HA	14.4	1.2			●				●	●			
			150604-HA	15.1	0.4			●				●	●			
			150608-HA	14.7	0.8			●				●	●			
			150612-HA	14.4	1.2			●				●	●			
精加工 Finishing			DNMG 110404-PF	11.2	0.4				●	●		●				
			110408-PF	10.8	0.8				●	●		●				
			150404-PF	15.1	0.4				●	●		●				
			150408-PF	14.7	0.8				●	●		●				
			150412-PF	14.4	1.2				●	●		●				
			150604-PF	15.1	0.4				●	●		●				
			150608-PF	14.7	0.8				●	●		●				
			150612-PF	14.4	1.2				●	●		●				
精加工 Finishing			DNMG 110404-MSF	11.2	0.4							●	●			
			110408-MSF	10.8	0.8							●	●			
			150404-MSF	15.1	0.4							●	●			
			150408-MSF	14.7	0.8							●	●			
			150412-MSF	14.4	1.2							●	●			
精加工 Finishing			DNMG 110404-MF	11.2	0.4							●	●			
			110408-MF	10.8	0.8							●	●			
			150404-MF	15.1	0.4							●	●			
			150408-MF	14.7	0.8							●	●			
			150412-MF	14.4	1.2							●	●			
			150604-MF	15.1	0.4							●	●			
			150608-MF	14.7	0.8							●	●			
			150612-MF	14.4	1.2							●	●			
精加工 Finishing			DNMG 110404-FG	11.2	0.4	●						●				
			110408-FG	10.8	0.8	●						●				
			150404-FG	15.1	0.4	●						●				
			150408-FG	14.7	0.8	●						●				
			150604-FG	15.1	0.4	●						●				
			150608-FG	14.7	0.8	●						●				
			150612-FG	14.4	1.2	●						●				
半精加工 Semi-Finishing			DNMG 110404-MK	11.2	0.4							●	●			
			110408-MK	10.8	0.8							●	●			
			110412-MK	10.4	1.2							●	●			
			150404-MK	15.1	0.4							●	●			
			150408-MK	14.7	0.8							●	●			
			150604-MK	15.1	0.4							●	●			
			150608-MK	14.7	0.8							●	●			
			150612-MK	14.4	1.2							●	●			

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✣ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工~粗加工 Semi-Finishing~Roughing			CNMG 110404-PM	11.2	0.4				●	●		●				
			110408-PM	10.8	0.8				●	●		●				
			110412-PM	10.4	1.2				●	●		●				
			150404-PM	15.1	0.4				●	●		●				
			150408-PM	14.7	0.8				●	●		●				
			150412-PM	14.4	1.2				●	●		●				
			150416-PM	14.0	1.6				●	●		●				
			150604-PM	15.1	0.4				●	●		●				
			150608-PM	14.7	0.8				●	●		●				
			150612-PM	14.4	1.2				●	●		●				
			150616-PM	14.0	1.6				●	●		●				
半精加工 Semi-Finishing			DNMG 110404-MM	11.2	0.4							●	●			
			110408-MM	10.8	0.8							●	●			
			110412-MM	10.4	1.2							●	●			
			150404-MM	15.1	0.4							●	●			
			150408-MM	14.7	0.8							●	●			
			150604-MM	15.1	0.4							●	●			
			150608-MM	14.7	0.8							●	●			
			150612-MM	14.4	1.2							●	●			
半精加工~粗加工 Semi-Finishing~Roughing			DNMG 150404-TM	15.1	0.4				●	●	●	●	●	●		
			150408-TM	14.7	0.8				●	●	●	●	●	●		
			150412-TM	14.4	1.2				●	●	●	●	●	●		
			150604-TM	15.1	0.4				●	●	●	●	●	●		
			150608-TM	14.7	0.8				●	●	●	●	●	●		
			150612-TM	14.4	1.2				●	●	●	●	●	●		
半精加工 Semi-Finishing			DNMG 150404-HQ	15.1	0.4	●			●	●		●	●			
			150408-HQ	14.7	0.8	●			●	●		●	●			
			150412-HQ	14.4	1.2	●			●	●		●	●			
			150604-HQ	15.1	0.4	●			●	●		●	●			
			150608-HQ	14.7	0.8	●			●	●		●	●			
			150612-HQ	14.4	1.2	●			●	●		●	●			
半精加工 Semi-Finishing			DNMG 150404R-VF	15.1	0.4	●										
			150408R-VF	14.7	0.8	●										
			150412R-VF	14.4	1.2	●										
			150604R-VF	15.1	0.4	●										
			150608R-VF	14.7	0.8	●										
			150612R-VF	14.4	1.2	●										
半精加工 Semi-Finishing			DNMG 150404L-VF	15.1	0.4	●										
			150408L-VF	14.7	0.8	●										
			150412L-VF	14.4	1.2	●										
			150604L-VF	15.1	0.4	●										
			150608L-VF	14.7	0.8	●										
			150612L-VF	14.4	1.2	●										
半精加工 Semi-Finishing			DNMG 150404R-S	15.1	0.4	●			●	●		●				
			150408R-S	14.7	0.8	●			●	●		●				
			150412R-S	14.4	1.2	●			●	●		●				
			150604R-S	15.1	0.4	●			●	●		●				
			150608R-S	14.7	0.8	●			●	●		●				
			150612R-S	14.4	1.2	●			●	●		●				
半精加工 Semi-Finishing			DNMG 150404L-S	15.1	0.4	●			●	●		●				
			150408L-S	14.7	0.8	●			●	●		●				
			150412L-S	14.4	1.2	●			●	●		●				
			150604L-S	15.1	0.4	●			●	●		●				
			150608L-S	14.7	0.8	●			●	●		●				
			150612L-S	14.4	1.2	●			●	●		●				

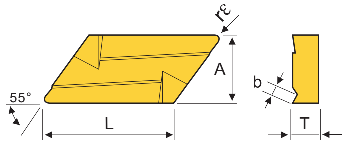
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✣ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工~粗加工 Semi-Finishing~Roughing			DNMG 110404-MS	11.2	0.4				●	●	●	●	●		●	
			110408-MS	10.8	0.8				●	●	●	●	●		●	
			110412-MS	10.4	1.2				●	●	●	●	●		●	
			150404-MS	15.1	0.4				●	●	●	●	●		●	
			150408-MS	14.7	0.8				●	●	●	●	●		●	
			150412-MS	14.4	1.2				●	●	●	●	●		●	
			150604-MS	15.1	0.4				●	●	●	●	●		●	
			150608-MS	14.7	0.8				●	●	●	●	●		●	
			150612-MS	14.4	1.2				●	●	●	●	●		●	
			150616-MS	14.0	1.6				●	●	●	●	●		●	
			190608-MS	18.5	0.8				●	●	●	●	●		●	
			190612-MS	18.1	1.2				●	●	●	●	●		●	
			190616-MS	17.7	1.6				●	●	●	●	●		●	
半精加工~粗加工 Semi-Finishing~Roughing			DNMG 150404-43	15.1	0.4				●	●	●	●	●	●		
			150408-43	14.7	0.8				●	●	●	●	●	●		
			150412-43	14.4	1.2				●	●	●	●	●	●		
			150604-43	15.1	0.4				●	●	●	●	●	●		
			150608-43	14.7	0.8				●	●	●	●	●	●		
			150612-43	14.4	1.2				●	●	●	●	●	●		
粗加工 Roughing			DNMA 110404	11.2	0.4				●						●	●
			110408	10.8	0.8				●						●	●
			110412	10.4	1.2				●						●	●
			150404	15.1	0.4				●						●	●
			150408	14.7	0.8				●						●	●
			150412	14.4	1.2				●						●	●
			150604	15.1	0.4				●						●	●
			150608	14.7	0.8				●						●	●
			150612	14.4	1.2				●						●	●
			150616	14.0	1.6				●						●	●
			190608	18.5	0.8				●						●	●
			190612	18.1	1.2				●						●	●
			190616	17.7	1.6				●						●	●
粗加工 Roughing			DNMG 150404-PR	15.1	0.4				●	●		●			●	
			150408-PR	14.7	0.8				●	●		●			●	
			150412-PR	14.4	1.2				●	●		●			●	
			150604-PR	15.1	0.4				●	●		●			●	
			150608-PR	14.7	0.8				●	●		●			●	
			150612-PR	14.4	1.2				●	●		●			●	

KN

55°四边形
负角
无孔刀片

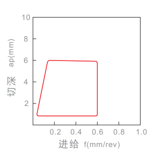
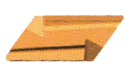
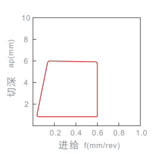


切削线速度(Cutting Speed): m/min

加工材料 刀具材质 / 材质特点	PCD 金刚石	CBN-K 铸铁专用	CBN-S 难切削材用	ZN60 光洁度好	ZN90 高速精加工	ZK01 铜铝加工	ZC250 CVD 钢件	ZC251 CVD 钢件	ZC32S 钢件高速	ZP152 不锈钢通用	ZP153 不锈钢高速	ZP163 高硬高速	ZK50 CVD 铸铁	ZK50S 铸铁高速
P 低碳钢				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P 高碳钢				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P 淬硬钢 HRC46-58			10-30							20-60	20-60	20-80		
M 不锈钢				200-300	200-350					50-150	70-150	50-200		
K 灰口铸铁		300-1500		100-300	100-350								200-300	200-350
K 球墨铸铁/轧辊		400-800		100-200	100-250								150-200	150-250
N 镁/锌/塑料/木材	300-1200					300-1200								
N 铝合金 HB50-70	300-1500					300-1500								
N 淬硬铝合金 HB70-110	300-800					300-800								
N 铜/青铜/黄铜	300-1000					300-1000								
S 硬质合金/粉末冶金	10-30					10-30						20-50		
S 硅填充塑料硬质纤维	400-600					400-600								
H 钛/高温合金/碳纤维	100-200					100-200				20-50	20-60	30-80		

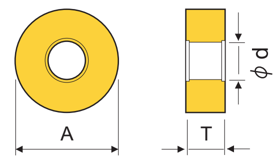
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

			ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✖	◐	✖	✖	◐	●		
M	不锈钢	Stainless Steel	◐	●					✖	◐	●		
K	铸铁	Iron	◐	●					✖			✖	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✖	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✖	◐	●		

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	L	A	T	b	rε	切深 ap(mm)	进给 f(mm/rev)	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工~粗加工 Semi-Finishing ~ Roughing			KNUX 160405R11 160410R11	19.2 18.8	9.525 9.525	4.76 4.76	2.2 2.2	0.5 1.0	1.0-6.0 1.5-6.0	0.2-0.35 0.3-0.6	● ●			● ●	● ●		● ●				
半精加工~粗加工 Semi-Finishing ~ Roughing			KNUX 160405L11 160410L11	19.2 18.8	9.525 9.525	4.76 4.76	2.2 2.2	0.5 1.0	1.0-6.0 1.5-6.0	0.2-0.35 0.3-0.6	● ●			● ●	● ●		● ●				

RN

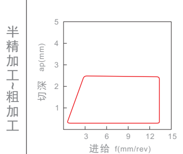
圆形
负角
有孔刀片



加工材料 刀具材质 / 材质特点	PCD 金刚石	CBN-K 铸铁专用	CBN-S 难切削材用	ZN60 光洁度好	ZN90 高速精加工	ZK01 铜铝加工	ZC250 CVD 钢件	ZC251 CVD 钢件	ZC32S 钢件高速	ZP152 不锈钢通用	ZP153 不锈钢高速	ZP163 高硬高速	ZK50 CVD 铸铁	ZK50S 铸铁高速
P 低碳钢				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P 高碳钢				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P 淬硬钢 HRC46-58			10-30							20-60	20-60	20-80		
M 不锈钢				200-300	200-350					50-150	70-150	50-200		
K 灰口铸铁		300-1500		100-300	100-350								200-300	200-350
K 球墨铸铁/轧辊		400-800		100-200	100-250								150-200	150-250
N 镁/锌/塑料/木材	300-1200					300-1200								
N 铝合金 HB50-70	300-1500					300-1500								
N 淬硬铝合金 HB70-110	300-800					300-800								
N 铜/青铜/黄铜	300-1000					300-1000								
S 硬质合金/粉末冶金	10-30					10-30						20-50		
S 硅填充塑料硬质纤维	400-600					400-600								
H 钛/高温合金/碳纤维	100-200					100-200				20-50	20-60	30-80		

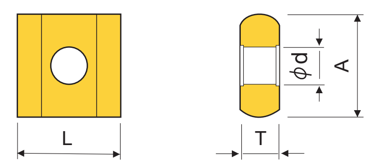
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

			ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✖	◐	✖	✖	◐	●		
M	不锈钢	Stainless Steel	◐	●					✖	◐	●		
K	铸铁	Iron	◐	●					✖			✖	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✖	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✖	◐	●		

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	L	A	T	ϕd	rε	切深 ap(mm)	进给 f(mm/rev)	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工~粗加工 Semi-Finishing ~ Roughing			RNMG 0903MO 1204MO 1506MO 1906MO 2506MO 2509MO 3109MO	- - - - - - -	9.525 12.7 15.875 19.05 25.4 25.4 31.75	3.18 4.76 6.35 6.35 6.35 9.52 9.52	3.81 5.16 6.35 7.93 9.12 9.12 12.7	- - - - - - -	0.09-0.9 0.12-1.2 0.15-1.5 0.19-1.9 0.25-2.5 0.25-2.5 0.3-2.5	0.9-4.5 1.2-4.8 1.15-1.5 1.9-7.6 2.5-10.0 2.5-10.0 3.5-13.0				● ● ● ● ● ● ●			● ● ● ● ● ● ●				

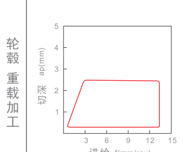
175.32

轮毂
重载加工
有孔刀片



切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

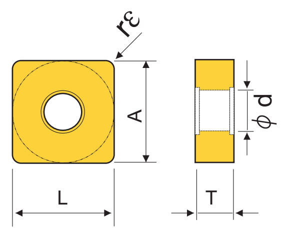
			ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✖	◐	✖	✖	◐	●		
M	不锈钢	Stainless Steel	◐	●					✖	◐	●		
K	铸铁	Iron	◐	●					✖			✖	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✖	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✖	◐	●		

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	L	A	T	ϕd	rε	切深 ap(mm)	进给 f(mm/rev)	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
轮毂重载加工 Heavy Load Machining of Wheel Hub			175.32 191940-22 191940-24 191940-28	19.1 19.1 19.1	19.1 19.1 19.1	10 10 10	6.35 6.35 6.35	4.0 4.0 4.0						● ● ●	● ● ●		● ● ●				

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GM. TD.
后车削 ABS TBP TKFB
内孔切槽 T.N/E GE. . GR
螺纹车削刀片
铣削刀片

SN 正方形 负角 有孔刀片

外圆车刀 (External Toolholder): B09-B10
内孔车刀 (Internal Toolholder): B40



(mm)

Model	A	T	ϕd
SN..0903..	9.525	3.18	3.81
SN..1204..	12.70	4.76	5.16
SN..1506..	15.875	6.35	6.35
SN..1906..	19.05	6.35	7.94
SN..2507..	25.4	7.94	9.12
SN..2509..	25.4	9.525	9.12

切削线速度 (Cutting Speed): m/min

工件材质	材料特点	PCD 金刚石	CBN-K 铸铁专用	CBN-S 难切削材料	ZN60 光洁度好	ZN90 高速精加工	ZK01 铜铝加工	ZC250 CVD 钢件	ZC251 CVD 钢件	ZC32S 钢件高速	ZP152 不锈钢通用	ZP153 不锈钢高速	ZP163 高硬高速	ZK50 CVD 铸铁	ZK50S 铸铁高速
P	低碳钢				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58			10-30							20-60	20-60	20-80		
M	不锈钢				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊		400-800		100-200	100-250								150-200	150-250
N	镁/铝/塑料/木材	300-1200					300-1200								
N	铝合金 HB50-70	300-1500					300-1500								
N	淬硬铝合金 HB70-110	300-800					300-800								
N	铜/青铜/黄铜	300-1000					300-1000								
S	硬质合金/粉末冶金	10-30					10-30						20-50		
S	硅填充塑料硬质纤维	400-600					400-600								
H	钛/高温合金/碳纤维	100-200					100-200				20-50	20-60	30-80		

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✱ 不稳定切削 Unstable Cutting

	材料	Material
P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S
精加工 Finishing	SNGA 120402	12.7	0.2		●	●
	120404	12.3	0.4		●	●
	120408	11.9	0.8		●	●
	120412	11.5	1.2		●	●
精加工 Finishing	SNGA 120402-4T	12.7	0.2		●	●
	120404-4T	12.3	0.4		●	●
	120408-4T	11.9	0.8		●	●
	120412-4T	11.5	1.2		●	●
精加工 Finishing	SNGA 120402	12.7	0.2	●		
	120404	12.3	0.4	●		
	120408	11.9	0.8	●		
	120412	11.5	1.2	●		
精加工 Finishing (有断屑槽 With Groove)	SNGA 120402-AL	12.7	0.2	●		
	120404-AL	12.3	0.4	●		
	120408-AL	11.9	0.8	●		
	120412-AL	11.5	1.2	●		
精加工 Finishing	SNGW 120402	12.7	0.2	●		
	120404	12.3	0.4	●		
	120408	11.9	0.8	●		
	120412	11.5	1.2	●		
精加工 Finishing	SNGA 120402-4T	12.7	0.2	●		
	120404-4T	12.3	0.4	●		
	120408-4T	11.9	0.8	●		
	120412-4T	11.5	1.2	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工-半精加工 Finishing-Semi-Finishing	SNMG 120404-HA	12.3	0.4			●				●	●			
	120408-HA	11.9	0.8			●				●	●			
	120412-HA	11.5	1.2											
精加工 Finishing	SNMG 090304-PF	9.1	0.4				●	●		●				
	090308-PF	8.7	0.8				●	●		●				
	120404-PF	12.3	0.4				●	●		●				
	120408-PF	11.9	0.8				●	●		●				
	120412-PF	11.5	1.2				●	●		●				
精加工 Finishing	SNMG 090304-MF	9.1	0.4							●	●			
	090308-MF	8.7	0.8							●	●			
	090312-MF	8.3	1.2							●	●			
	120404-MF	12.3	0.4							●	●			
	120408-MF	11.9	0.8							●	●			
	120412-MF	11.5	1.2							●	●			
	150608-MF	15.0	0.8							●	●			
	150612-MF	14.6	1.2							●	●			
半精加工-粗加工 Semi-Finishing-Roughing	SNMG 090304-PM	9.1	0.4				●	●		●				
	090308-PM	8.7	0.8				●	●		●				
	090312-PM	8.3	1.2				●	●		●				
	120404-PM	12.3	0.4				●	●		●				
	120408-PM	11.9	0.8				●	●		●				
	120412-PM	11.5	1.2				●	●		●				
	120416-PM	11.1	1.6				●	●		●				
	150608-PM	15.0	0.8				●	●		●				
	150612-PM	14.6	1.2				●	●		●				
	150616-PM	14.2	1.6				●	●		●				
	190608-PM	18.2	0.8				●	●		●				
	190612-PM	17.8	1.2				●	●		●				
	190616-PM	17.4	1.6				●	●		●				

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工 Semi-Finishing	SNMG 120404-HS	12.3	0.4	●						●				
	120408-HS	11.9	0.8	●						●				
	120412-HS	11.5	1.2	●						●				
半精加工 Semi-Finishing	SNMG 120404-TM	12.3	0.4				●	●	●	●	●	●		
	120408-TM	11.9	0.8				●	●	●	●	●	●		
	120412-TM	11.5	1.2				●	●	●	●	●	●		
半精加工 Semi-Finishing	SNMG 120404-GM	12.3	0.4				●	●	●	●	●	●		
	120408-GM	11.9	0.8				●	●	●	●	●	●		
	120412-GM	11.5	1.2				●	●	●	●	●	●		
粗加工 Roughing	SNMG 120404R-S	12.3	0.4				●	●	●	●				
	120408R-S	11.9	0.8				●	●	●	●				
	120412R-S	11.5	1.2				●	●	●	●				
粗加工 Roughing	SNMG 120404L-S	12.3	0.4				●	●	●	●				
	120408L-S	11.9	0.8				●	●	●	●				
	120412L-S	11.5	1.2				●	●	●	●				
半精加工 Semi-Finishing	SNMG 120404-MA	12.3	0.4	●			●	●	●	●	●	●		
	120408-MA	11.9	0.8	●			●	●	●	●	●	●		
	120412-MA	11.5	1.2	●			●	●	●	●	●	●		
半精加工-粗加工 Semi-Finishing-Roughing	SNMG 120404-MM	12.3	0.4							●	●			
	120408-MM	11.9	0.8							●	●			
	120412-MM	11.5	1.2							●	●			
	150608-MM	15.0	0.8							●	●			
	150612-MM	14.6	1.2							●	●			
	150616-MM	14.2	1.6							●	●			
半精加工 Semi-Finishing	SNMG 120404-MT	12.3	0.4	●			●			●				
	120408-MT	11.9	0.8	●			●			●				
	120412-MT	11.5	1.2	●			●			●				
半精加工 Semi-Finishing	SNMG 120404-HQ	12.3	0.4	●			●	●		●	●			
	120408-HQ	11.9	0.8	●			●	●		●	●			
	120412-HQ	11.5	1.2	●			●	●		●	●			

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工 Semi-Finishing	SNMG 120404-MK	12.3	0.4							●	●	●		
	120408-MK	11.9	0.8							●	●	●		
	120412-MK	11.5	1.2							●	●	●		
半精加工-粗加工 Semi-Finishing-Roughing	SNMG 090304-MS	9.1	0.4				●	●	●	●	●	●	●	●
	090308-MS	8.7	0.8				●	●	●	●	●	●	●	●
	120404-MS	12.3	0.4				●	●	●	●	●	●	●	●
	120408-MS	11.9	0.8				●	●	●	●	●	●	●	●
	120412-MS	11.5	1.2				●	●	●	●	●	●	●	●
	120416-MS	11.1	1.6				●	●	●	●	●	●	●	●
	150608-MS	15.0	0.8				●	●	●	●	●	●	●	●
	150612-MS	14.6	1.2				●	●	●	●	●	●	●	●
	150616-MS	14.2	1.6				●	●	●	●	●	●	●	●
	190608-MS	18.2	0.8				●	●	●	●	●	●	●	●
	190612-MS	17.8	1.2				●	●	●	●	●	●	●	●
	190616-MS	17.4	1.6				●	●	●	●	●	●	●	●
	190624-MS	16.6	2.4				●	●	●	●	●	●	●	●
	250724-MS	23.0	2.4				●	●	●	●	●	●	●	●
	250924-MS	23.0	2.4				●	●	●	●	●	●	●	●
粗加工 Roughing	SNMA 090304	9.1	0.4				●						●	●
	090308	8.7	0.8				●						●	●
	120404	12.3	0.4				●						●	●
	120408	11.9	0.8				●						●	●
	120412	11.5	1.2				●						●	●
	120416	11.1	1.6				●						●	●
	150608	15.0	0.8				●						●	●
	150612	14.6	1.2				●						●	●
	150616	14.2	1.6				●						●	●
	190608	18.2	0.8				●						●	●
	190612	17.8	1.2				●						●	●
	190616	17.4	1.6				●						●	●
	190624	16.6	2.4				●						●	●
	250724	23.0	2.4				●						●	●
	250924	23.0	2.4				●						●	●
粗加工 Roughing	SNMG 120408-PR	11.9	0.8				●	●		●			●	
	120412-PR	11.5	1.2				●	●		●			●	
	120416-PR	11.1	1.6				●	●		●			●	
	150608-PR	15.0	0.8				●	●		●			●	
	150612-PR	14.6	1.2				●	●		●			●	
	150616-PR	14.2	1.6				●	●		●			●	
	150624-PR	13.4	2.4				●	●		●			●	
	190612-PR	17.8	1.2				●	●		●			●	
	190616-PR	17.4	1.6				●	●		●			●	
	190624-PR	16.6	2.4				●	●		●			●	
重切削粗加工 Heavy Cutting Roughing (单面断屑槽 Single Chip Breaker)	SNMM 120408-PR	11.9	0.8				●	●		●				
	120412-PR	11.5	1.2				●	●		●				
	120416-PR	11.1	1.6				●	●		●				
	150608-PR	15.0	0.8				●	●		●				
	150612-PR	14.6	1.2				●	●		●				
	150616-PR	14.2	1.6				●	●		●				
	150624-PR	13.4	2.4				●	●		●				
	190612-PR	17.8	1.2				●	●		●				
	190616-PR	17.4	1.6				●	●		●				
	190624-PR	16.6	2.4				●	●		●				

TN 60°三角形 负角 有孔刀片

外圆车刀 (External Toolholder): B11-B14
小零件专用 (Small Parts Toolholder): AB04/AB12
内孔车刀 (Internal Toolholder): B37-B39

(mm)

Model	A	T	ϕd
TN..1103..	6.35	3.18	2.40
TN..1603..	9.525	3.18	3.81
TN..1604..	9.525	4.76	3.81
TN..2204..	12.7	4.76	5.16
TN..2706..	15.875	6.35	6.35
TN..3307..	19.05	7.94	7.93
TN..3309..	19.05	9.52	7.93

rε A ϕd 60° L T

切削线速度 (Cutting Speed): m/min⁻¹

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel			10-30							20-60	20-60	20-80		
M	不锈钢 Stainless Steel				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy	300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30					10-30						20-50		
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200					100-200				20-50	20-60	30-80		

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✱ 不稳定切削 Unstable Cutting

		PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
P	钢 Steel			●								
M	不锈钢 Stainless Steel											
K	铸铁 Iron		●									
N	铝/铜/镁/锌/塑料/木材 Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●										
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	●										
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	●										

用途 Application	规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
精加工 Finishing	TNGA 160402	16.0	0.2		●	●								
	160404	15.5	0.4		●	●								
	160408	14.5	0.8		●	●								
	160412	13.5	1.2		●	●								
精加工 Finishing	TNGA 160402-3T	16.0	0.2		●	●								
	160404-3T	15.5	0.4		●	●								
	160408-3T	14.5	0.8		●	●								
	160412-3T	13.5	1.2		●	●								
精加工 Finishing	TNMG 160402	16.0	0.2	●										
	160404	15.5	0.4	●										
	160408	14.5	0.8	●										
	160412	13.5	1.2	●										
精加工 Finishing	TNMG 160402-AL (有断屑槽 With Groove)	16.0	0.2	●										
	160404-AL	15.5	0.4	●										
	160408-AL	14.5	0.8	●										
	160412-AL	13.5	1.2	●										
精加工 Finishing	TNGW 160402	16.0	0.2	●										
	160404	15.5	0.4	●										
	160408	14.5	0.8	●										
	160412	13.5	1.2	●										
精加工 Finishing	TNMG 160402-3T	16.0	0.2	●										
	160404-3T	15.5	0.4	●										
	160408-3T	14.5	0.8	●										
	160412-3T	13.5	1.2	●										

切削参数 Cutting Parameter: 切深 ap(mm) / 进给 f(mm/rev)

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✱ 不稳定切削 Unstable Cutting

		ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢 Steel	◐	●		✱	◐	✱	✱	◐	●		
M	不锈钢 Stainless Steel	◐	●					✱	◐	●		
K	铸铁 Iron	◐	●					✱			✱	◐
N	铝/铜/镁/锌/塑料/木材 Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy							✱	◐	●		
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber							✱	◐	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工~半精加工~粗加工 Finishing~Semi-Finishing~Roughing	TNMG 160404-HA	15.5	0.4			●				●	●			
	160408-HA	14.5	0.8			●				●	●			
	160412-HA	13.5	1.2			●				●	●			
精加工 Finishing	TNGG 160402R-S	16.0	0.2		●	●				●	●			
	160404R-S	15.5	0.4		●	●				●	●			
	160408R-S	14.5	0.8		●	●				●	●			
	160402L-S	16.0	0.2		●	●				●	●			
	160404L-S	15.5	0.4		●	●				●	●			
	160408L-S	14.5	0.8		●	●				●	●			
精加工 Finishing	TNGG 160402R-P	16.0	0.2		●	●				●				
	160404R-P	15.5	0.4		●	●				●				
	160408R-P	14.5	0.8		●	●				●				
	160402L-P	16.0	0.2		●	●				●				
	160404L-P	15.5	0.4		●	●				●				
	160408L-P	14.5	0.8		●	●				●				
精加工 Finishing	TNMG 160404-TS	15.5	0.4	●										
	160408-TS	14.5	0.8	●										
	160412-TS	13.5	1.2	●										
精加工 Finishing	TNMG 160404-PF	15.5	0.4				●	●		●				
	160408-PF	14.5	0.8				●	●		●				
精加工 Finishing	TNMG 160404-MSF	15.5	0.4							●	●			
	160408-MSF	14.5	0.8							●	●			

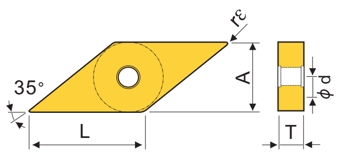
切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✱ 不稳定切削 Unstable Cutting

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工 Finishing	TNMG 160404-MF	15.5	0.4							●	●			
	160408-MF	14.5	0.8							●	●			
半精加工~粗加工 Semi-Finishing~Roughing	TNMG 160404-PM	15.5	0.4				●	●		●			●	
	160408-PM	14.5	0.8				●	●		●			●	
	160412-PM	13.5	1.2				●	●		●			●	
	220404-PM	21.0	0.4				●	●		●			●	
	220408-PM	20.0	0.8				●	●		●			●	
	220412-PM	19.0	1.2				●	●		●			●	
	220416-PM	18.2	1.6				●	●		●			●	
半精加工~粗加工 Semi-Finishing~Roughing	TNMG 160404-MM	15.5	0.4							●	●			
	160408-MM	14.5	0.8							●	●			
	160412-MM	13.5	1.2							●	●			
	220404-MM	21.0	0.4							●	●			
	220408-MM	20.0	0.8							●	●			
	220412-MM	19.0	1.2							●	●			
	220416-MM	18.2	1.6							●	●			
半精加工 Semi-Finishing	TNMG 160404-MA	15.5	0.4	●			●	●	●	●	●	●		
	160408-MA	14.5	0.8	●			●	●	●	●	●	●		
	160412-MA	13.5	1.2	●			●	●	●	●	●	●		
半精加工~粗加工 Semi-Finishing~Roughing	TNMG 160404-CQ	15.5	0.4				●	●		●	●			
	160408-CQ	14.5	0.8				●	●		●	●			
	160412-CQ	13.5	1.2				●	●		●	●			
半精加工 Semi-Finishing	TNMG 160404-MT	15.5	0.4	●			●			●				
	160408-MT	14.5	0.8	●			●			●				
	160412-MT	13.5	1.2	●			●			●				
半精加工 Semi-Finishing	TNMG 160404-HQ	15.5	0.4	●			●	●		●	●			
	160408-HQ	14.5	0.8	●			●	●		●	●			
	160412-HQ	13.5	1.2	●			●	●		●	●			
半精加工 Semi-Finishing	TNMG 160404-MQ	15.5	0.4							●	●			
	160408-MQ	14.5	0.8							●	●			
	160412-MQ	13.5	1.2							●	●			
半精加工 Semi-Finishing	TNMG 160404-HS	15.5	0.4	●			●			●				
	160408-HS	14.5	0.8	●			●			●				
	160412-HS	13.5	1.2	●			●			●				

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✱ 不稳定切削 Unstable Cutting

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工 Semi-Finishing (TM)	TNMG 160404-TM	15.5	0.4				●	●	●	●	●	●		
	160408-TM	14.5	0.8				●	●	●	●	●	●		
	160412-TM	13.5	1.2				●	●	●	●	●	●		
(MK)	TNMG 160404-MK	15.5	0.4							●	●			
	160408-MK	14.5	0.8							●	●			
	160412-MK	13.5	1.2							●	●			
半精加工 Semi-Finishing (GM)	TNMG 160404-GM	15.5	0.4				●	●	●	●	●	●		
	160408-GM	14.5	0.8				●	●	●	●	●	●		
	160412-GM	13.5	1.2				●	●	●	●	●	●		
(43)	TNMG 160404-43	15.5	0.4				●	●	●	●				
	160408-43	14.5	0.8				●	●	●	●				
	160412-43	13.5	1.2				●	●	●	●				
半精加工~粗加工 Semi-Finishing~Roughing (R-S)	TNMG 160404R-S	15.5	0.4	●			●	●		●				
	160408R-S	14.5	0.8	●			●	●		●				
	160412R-S	13.5	1.2	●			●	●		●				
(L-S)	160404L-S	15.5	0.4	●			●	●		●				
	160408L-S	14.5	0.8	●			●	●		●				
	160412L-S	13.5	1.2	●			●	●		●				
半精加工~粗加工 Semi-Finishing~Roughing (R-VF)	TNMG 160404R-VF	15.5	0.4	●			●	●		●				
	160408R-VF	14.5	0.8	●			●	●		●				
	160412R-VF	13.5	1.2	●			●	●		●				
(L-VF)	160404L-VF	15.5	0.4	●			●	●		●				
	160408L-VF	14.5	0.8	●			●	●		●				
	160412L-VF	13.5	1.2	●			●	●		●				
半精加工~粗加工 Semi-Finishing~Roughing	TNMG 110308-MS	9.0	0.8				●						●	●
	160404-MS	15.5	0.4				●						●	●
	160408-MS	14.5	0.8				●						●	●
	160412-MS	13.5	1.2				●						●	●
	160416-MS	12.5	1.6				●						●	●
	220404-MS	21.0	0.4				●						●	●
	220408-MS	20.0	0.8				●						●	●
	220412-MS	19.0	1.2				●						●	●
	220416-MS	18.2	1.6				●						●	●
	270608-MS	25.5	0.8				●						●	●
	270612-MS	24.5	1.2				●						●	●
	270616-MS	23.5	1.6				●						●	●
	330716-MS	29.0	1.6				●						●	●
	330916-MS	29.0	1.6				●						●	●
	330924-MS	27.1	2.4				●						●	●
粗加工 Roughing	TNMA 160404	15.5	0.4				●						●	●
	160408	14.5	0.8				●						●	●
	160412	13.5	1.2				●						●	●
	160416	12.5	1.6				●						●	●
	220408	20.0	0.8				●						●	●
	220412	19.0	1.2				●						●	●
	220416	18.2	1.6				●						●	●
	270612	24.4	1.2				●						●	●
	270616	23.3	1.6				●						●	●
粗加工 Roughing	TNMG 160404-PR	15.5	0.4				●	●		●			●	
	160408-PR	14.5	0.8				●	●		●			●	
	160412-PR	13.5	1.2				●	●		●			●	
	160416-PR	12.5	1.6				●	●		●			●	
	220408-PR	21.0	0.8				●	●		●			●	
	220412-PR	20.0	1.2				●	●		●			●	
	220416-PR	19.0	1.6				●	●		●			●	
	270612-PR	24.5	1.2				●	●		●			●	
准重切削加工 Heavy Cutting Roughing (单面断屑槽 Single Chip Breaker)	TNMM 160408-PR	11.6	1.2				●	●		●				
	160412-PR	15.3	0.8				●	●		●				
	220408-PR	14.8	1.2				●	●		●				
	220412-PR	14.4	1.6				●	●		●				
	220416-PR	18.1	1.2				●	●		●				
	270612-PR	17.7	1.6				●	●		●				
	270616-PR	16.9	2.4				●	●		●				
		25.8	2.4				●	●		●				

VN 35°菱形 负角 有孔刀片



外圆车刀 (External Toolholder): B15-B16
内孔车刀 (Internal Toolholder): B42-B43

(mm)

Model	A	T	ød
VN..1604..	9.525	4.76	3.81
VN..2204..	12.7	4.73	5.16

切削线速度 (Cutting Speed): m/min

加工材料	材质特点	PCD 金刚石	CBN-K 铸铁专用	CBN-S 淬硬材料用	ZN60 光洁度好	ZN90 高速精加工	ZK01 铜铝加工	ZC250 CVD 钢件	ZC251 CVD 钢件	ZC32S 钢件高速	ZP152 不锈钢通用	ZP153 不锈钢高速	ZP163 高硬高速	ZK50 CVD 铸铁	ZK50S 铸铁高速
P	低碳钢				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58			10-30							20-60	20-60	20-80		
M	不锈钢				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊		400-800		100-200	100-250								150-200	150-250
N	镁/铝/塑料/木材	300-1200					300-1200								
N	铝合金 HB50-70	300-1500					300-1500								
N	淬硬铝合金 HB70-110	300-800					300-800								
N	铜/青铜/黄铜	300-1000					300-1000								
S	硬质合金/粉末冶金	10-30					10-30						20-50		
S	硅填充塑料硬质纤维	400-600					400-600								
H	钛/高温合金/碳纤维	100-200					100-200				20-50	20-60	30-80		

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting; ◐ 一般切削 General Cutting; ✱ 不稳定切削 Unstable Cutting

	材料	Material	PCD	CBN-K	CBN-S
P	钢	Steel			●
M	不锈钢	Stainless Steel			
K	铸铁	Iron		◐	
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	◐		
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
精加工 Finishing	VNGA 160402	16.1	0.2		●	●								
	160404	15.6	0.4		●	●								
	160408	14.6	0.8		●	●								
	160412	13.6	1.2		●	●								
精加工 Finishing	VNGA 160402-2T	16.1	0.2		●	●								
	160404-2T	15.6	0.4		●	●								
	160408-2T	14.6	0.8		●	●								
	160412-2T	13.6	1.2		●	●								
精加工 Finishing	VNMG 160402	16.1	0.2	●										
	160404	15.6	0.4	●										
	160408	14.6	0.8	●										
	160412	13.6	1.2	●										
精加工 Finishing (有断屑槽 With Groove)	VNMG 120402-AL	16.1	0.2	●										
	120404-AL	15.6	0.4	●										
	120408-AL	14.6	0.8	●										
	120412-AL	13.6	1.2	●										
精加工 Finishing	VNGW 160402	16.1	0.2	●										
	160404	15.6	0.4	●										
	160408	14.6	0.8	●										
	160412	13.6	1.2	●										
精加工 Finishing	VNMG 160402-2T	16.1	0.2	●										
	160404-2T	15.6	0.4	●										
	160408-2T	14.6	0.8	●										
	160412-2T	13.6	1.2	●										

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting; ◐ 一般切削 General Cutting; ✱ 不稳定切削 Unstable Cutting

	材料	Material	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✱	◐	✱	✱	◐	●		
M	不锈钢	Stainless Steel	◐	●					✱	◐	●		
K	铸铁	Iron	◐	●					✱			✱	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✱	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✱	◐	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工-半精加工 Finishing-Semi-Finishing	VNMG 160404-HA	15.6	0.4			●				●	●			
	160408-HA	14.6	0.8			●				●	●			
	160412-HA	13.6	1.2			●				●	●			
精加工 Finishing	VNMG 160404-PF	15.6	0.4				●	●		●				
	160408-PF	14.6	0.8				●	●		●				
精加工 Finishing	VNMG 160404-MSF	15.6	0.4							●	●			
	160408-MSF	14.6	0.8							●	●			
半精加工 Semi-Finishing	VNMG 160404-MF	15.6	0.4							●	●			
	160408-MF	14.6	0.8							●	●			
半精加工-粗加工 Semi-Finishing-Roughing	VNMG 160404-PM	15.6	0.4				●	●		●				
	160408-PM	14.6	0.8				●	●		●				
	160412-PM	13.6	1.2				●	●		●				

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting; ◐ 一般切削 General Cutting; ✱ 不稳定切削 Unstable Cutting

	材料	Material	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✱	◐	✱	✱	◐	●		
M	不锈钢	Stainless Steel	◐	●					✱	◐	●		
K	铸铁	Iron	◐	●					✱			✱	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✱	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✱	◐	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工 Semi-Finishing	VNMG 160404-MA	15.6	0.4	●			●	●	●	●	●	●		
	160408-MA	14.6	0.8	●			●	●	●	●	●	●		
	160412-MA	13.6	1.2	●			●	●	●	●	●	●		
半精加工-粗加工 Semi-Finishing-Roughing	VNMG 160404-MM	15.6	0.4							●	●			
	160408-MM	14.6	0.8							●	●			
半精加工 Semi-Finishing	VNMG 160404-MT	15.6	0.4	●			●			●				
	160408-MT	14.6	0.8	●			●			●				
	160412-MT	13.6	1.2	●			●			●				
半精加工 Semi-Finishing	VNMG 160404-HQ	15.6	0.4	●			●	●		●	●			
	160408-HQ	14.6	0.8	●			●	●		●	●			
	160412-HQ	13.6	1.2	●			●	●		●	●			
半精加工 Semi-Finishing	VNMG 160404-HS	15.6	0.4	●						●				
	160408-HS	14.6	0.8	●						●				
	160412-HS	13.6	1.2	●						●				
半精加工 Semi-Finishing	VNMG 160404-TM	15.6	0.4				●	●	●	●	●	●		
	160408-TM	14.6	0.8				●	●	●	●	●	●		
	160412-TM	13.6	1.2				●	●	●	●	●	●		
半精加工 Semi-Finishing	VNMG 160404-GM	15.6	0.4				●	●	●	●	●	●		
	160408-GM	14.6	0.8				●	●	●	●	●	●		
	160412-GM	13.6	1.2				●	●	●	●	●	●		
半精加工-粗加工 Semi-Finishing-Roughing	VNMG 160404-MS	15.6	0.4				●	●	●	●	●		●	●
	160408-MS	14.6	0.8				●	●	●	●	●		●	●
	160412-MS	13.6	1.2				●	●	●	●	●		●	●

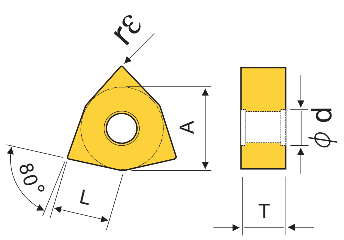
切削形态 Cutting Environment: ● 稳定切削 Stable Cutting; ◐ 一般切削 General Cutting; ✱ 不稳定切削 Unstable Cutting

	材料	Material	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✱	◐	✱	✱	◐	●		
M	不锈钢	Stainless Steel	◐	●					✱	◐	●		
K	铸铁	Iron	◐	●					✱			✱	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✱	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✱	◐	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
粗加工 Roughing	VNMA 160404	15.6	0.4				●						●	●
	160408	14.6	0.8				●						●	●
	160412	13.6	1.2				●						●	●
粗加工 Roughing	VNMG 160408-PR	14.6	0.8				●	●		●			●	
	160412-PR	13.6	1.2				●	●		●			●	

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GM. TD.
后车削 ABS TBP TKFB
内孔切槽 T.N/E GE. .GR
螺纹车削刀片
铣削刀片

WN 80°桃形 负角 有孔刀片



外圆车刀 (External Toolholder): B17-B18
内孔车刀 (Internal Toolholder): B44

(mm)

Model	A	T	ϕd
WN..0603..	9.525	3.18	3.81
WN..0604..	9.525	4.76	3.81
WN..0804..	12.7	4.76	5.16

切削线速度 (Cutting Speed): m/min⁻¹

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel			10-30							20-60	20-60	20-80		
M	不锈钢 Stainless Steel				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy	300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30					10-30					20-50			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200					100-200				20-50	20-60	30-80		

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✤ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S
P	钢	Steel			●
M	不锈钢	Stainless Steel			
K	铸铁	Iron		●	
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●		
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●		

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
精加工 Finishing	HB250以下 灰口铸铁 Gray Iron Vc=300~900m/min; HRC55以上 轧辊冷硬铸铁 Chilled Cast Iron Vc=70~160m/min; 淬硬钢 Hardened Steel HRC55 Vc=60~200m/min; 铁系烧结金属 Iron Sintered Metal Vc=50~250m/min		WNGA 080402 080404 080408 080412	8.7 8.4 8.3 8.2	0.2 0.4 0.8 1.2		●	●								
精加工 Finishing	HB250以下 灰口铸铁 Gray Iron Vc=300~900m/min; HRC55以上 轧辊冷硬铸铁 Chilled Cast Iron Vc=70~160m/min; 淬硬钢 Hardened Steel HRC55 Vc=60~200m/min; 铁系烧结金属 Iron Sintered Metal Vc=50~250m/min		WNGA 080402-3T 080404-3T 080408-3T 080412-3T	8.7 8.4 8.3 8.2	0.2 0.4 0.8 1.2		●	●								
精加工 Finishing	铝/锌/铜/镁合金 Vc=300~1500m/min Aluminum/Zinc/Copper/Magnesium Alloy		WNMG 080402 080404 080408 080412	8.7 8.4 8.3 8.2	0.2 0.4 0.8 1.2	●										
精加工 Finishing	玻璃纤维/硅填充/塑料碳纤维(干式) Fiberglass/Slastic Carbon Fiber Vc=100~800m/min; 钛合金(湿式) Titanium Alloy Vc=100~200m/min; 铝/锌/铜/镁合金 Vc=300~1500m/min Aluminum/Zinc/Copper/Magnesium Alloy; 硬质合金 Cemented Carbide Vc=10~30m/min	有断屑槽 With Groove	WNMG 080402-AL 080404-AL 080408-AL 080412-AL	8.7 8.4 8.3 8.2	0.2 0.4 0.8 1.2	●										
精加工 Finishing	玻璃纤维/硅填充/塑料碳纤维(干式) Fiberglass/Slastic Carbon Fiber Vc=100~800m/min; 钛合金(湿式) Titanium Alloy Vc=100~200m/min; 铝/锌/铜/镁合金 Vc=300~1500m/min Aluminum/Zinc/Copper/Magnesium Alloy; 硬质合金 Cemented Carbide Vc=10~30m/min		WNGW 080402 080404 080408 080412	8.7 8.4 8.3 8.2	0.2 0.4 0.8 1.2	●										
精加工 Finishing	玻璃纤维/硅填充/塑料碳纤维(干式) Fiberglass/Slastic Carbon Fiber Vc=100~800m/min; 钛合金(湿式) Titanium Alloy Vc=100~200m/min; 铝/锌/铜/镁合金 Vc=300~1500m/min Aluminum/Zinc/Copper/Magnesium Alloy; 硬质合金 Cemented Carbide Vc=10~30m/min		WNMG 080402-3T 080404-3T 080408-3T 080412-3T	8.7 8.4 8.3 8.2	0.2 0.4 0.8 1.2	●										

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✤ 不稳定切削 Unstable Cutting

			ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✤	◐	✤	✤	◐	●		
M	不锈钢	Stainless Steel	◐	●					✤	◐	●		
K	铸铁	Iron	◐	●					✤			✤	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✤	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✤	◐	●		

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工~半精加工 Finishing~Semi-Finishing	08		WNMG 080404-HA 080408-HA 080412-HA	8.4 8.3 8.2	0.4 0.8 1.2			●				●	●			
精加工 Finishing	08		WNMG 080404-TS 080408-TS 080412-TS	8.4 8.3 8.2	0.4 0.8 1.2	●										
精加工 Finishing	06 08		WNMG 060404-PF 060408-PF 080404-PF 080408-PF	6.2 6.1 8.4 8.3	0.4 0.8 0.4 0.8				●	●		●				
精加工 Finishing	06 08		WNMG 060304-MSF 060404-MSF 080404-MSF 080408-MSF	6.2 6.2 8.4 8.3	0.4 0.4 0.4 0.8							●	●			
精加工 Finishing	06 08		WNMG 060404-MF 060408-MF 080404-MF 080408-MF	6.2 6.1 8.4 8.3	0.4 0.8 0.4 0.8							●	●			
半精加工 Semi-Finishing	08		WNMG 080404-HQ 080408-HQ 080412-HQ	8.4 8.3 8.2	0.4 0.8 1.2	●			●	●		●	●			

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✤ 不稳定切削 Unstable Cutting

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工~粗加工 Semi-Finishing~Roughing	06 08		WNMG 060404-PM 060408-PM 080404-PM 080408-PM 080412-PM	6.2 6.1 8.4 8.3 8.2	0.4 0.8 0.4 0.8 1.2				●	●		●				
半精加工 Semi-Finishing	16		WNMG 080404-MQ 080408-MQ 080412-MQ	8.4 8.3 8.2	0.4 0.8 1.2	●			●	●	●	●	●	●		
半精加工 Semi-Finishing	08		WNMG 080404-MA 080408-MA 080412-MA	8.4 8.3 8.2	0.4 0.8 1.2	●			●	●	●	●	●	●		
半精加工 Semi-Finishing	08		WNMG 080404-MK 080408-MK 080412-MK	8.4 8.3 8.2	0.4 0.8 1.2							●	●	●		
半精加工~粗加工 Semi-Finishing~Roughing	08		WNMG 060404-MM 060408-MM 060412-MM 080404-MM 080408-MM 080412-MM	6.2 6.1 6.0 8.4 8.3 8.2	0.4 0.8 1.2 0.4 0.8 1.2							●	●			
半精加工 Semi-Finishing	08		WNMG 080404-MT 080408-MT 080412-MT	8.4 8.3 8.2	0.4 0.8 1.2	●			●			●				
半精加工 Semi-Finishing	08		WNMG 080404-HS 080408-HS 080412-HS	8.4 8.3 8.2	0.4 0.8 1.2	●						●				
半精加工 Semi-Finishing	08		WNMG 080404-TM 080408-TM 080412-TM	8.4 8.3 8.2	0.4 0.8 1.2				●	●	●	●	●	●		
半精加工 Semi-Finishing	08		WNMG 080404-GM 080408-GM 080412-GM	12.4 12.0 11.6	0.4 0.8 1.2				●	●	●	●	●	●		

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✤ 不稳定切削 Unstable Cutting

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工 Semi-Finishing	16		WNMG 080404-CQ 080408-CQ 080412-CQ	8.4 8.3 8.2	0.4 0.8 1.2				●	●		●				
半精加工~粗加工 Semi-Finishing~Roughing	08		WNMG 080404-PC 080408-PC 080412-PC	8.4 8.3 8.2	0.4 0.8 1.2				●	●		●	●			
半精加工~粗加工 Semi-Finishing~Roughing	08		WNMG 080404-CM 080408-CM 080412-CM	8.4 8.3 8.2	0.4 0.8 1.2				●	●		●				
半精加工~粗加工 Semi-Finishing~Roughing	08		WNMG 080404-MS 080408-MS 080412-MS	8.4 8.3 8.2	0.4 0.8 1.2				●	●	●	●	●		●	●
半精加工 Semi-Finishing	08		WNMG 080404-43 080408-43 080412-43	8.4 8.3 8.2	0.4 0.8 1.2				●	●	●	●				
半精加工~粗加工 Semi-Finishing~Roughing	08		WNMG 080404R-S 080408R-S 080412R-S	8.4 8.3 8.2	0.4 0.8 1.2	●			●	●	●	●				
半精加工~粗加工 Semi-Finishing~Roughing	08		WNMG 080404L-S 080408L-S 080412L-S	8.4 8.3 8.2	0.4 0.8 1.2	●			●	●	●	●				
粗加工 Roughing	06 08		WNMA 060404 060408 060412 080404 080408 080412 080416	6.2 6.1 6.0 8.4 8.3 8.2 8.1	0.4 0.8 1.2 0.4 0.8 1.2 1.6				●						●	●
粗加工 Roughing	08		WNMG 080408-PR 080412-PR 080416-PR	8.3 8.2 8.1	0.8 1.2 1.6				●	●		●			●	

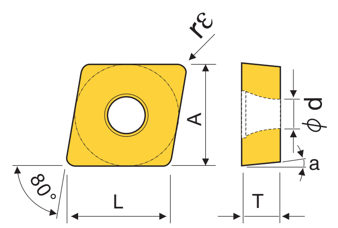
数控刀片 CN DN RN KN 175 SN TN VN WN CC DC RC SC WB TB TC TP VB VC 三角浅槽 TGF GBA T.N/E 小零件 CTP TKF 切槽切断 MG. MR. SP. GM. TD. 后车削 ABS TBP TKFB 内孔切槽 T.N/E GE. .GR 螺纹车削刀片 铣削刀片

CC 80°菱形 正角 有孔刀片

外圆车刀 (External Toolholder): B19-B20
小零件专用 (Small Parts Toolholder): AB03/AB11
内孔车刀 (Internal Toolholder): B45-B48

(mm)

Model	A	T	Φd	a
CC..0301..	3.5	1.39	1.9	7°
CC..0401..	4.3	1.79	2.3	7°
CC..0602..	6.35	2.38	2.8	7°
CC..09T3..	9.525	3.97	4.4	7°
CC..1204..	12.7	4.76	5.5	7°



切削线速度 (Cutting Speed): m/min

刀具材质 / 材质特点		PCD 金刚石	CBN-K 铸铁专用	CBN-S 难切削材用	ZN60 光洁度好	ZN90 高速精加工	ZK01 铜铝加工	ZC250 CVD 钢件	ZC251 CVD 钢件	ZC32S 钢件高速	ZP152 不锈钢通用	ZP153 不锈钢高速	ZP163 高硬高速	ZK50 CVD 铸铁	ZK50S 铸铁高速
P	低碳钢				150-600	150-800		70-500	150-600	150-600	70-250	100-250	80-300		
P	高碳钢				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58			10-30							20-60	20-60	20-80		
M	不锈钢				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊		400-800		100-200	100-250								150-200	150-250
N	镁/铝/塑料/木材	300-1200					300-1200								
N	铝合金 HB50-70	300-1500					300-1500								
N	淬硬铝合金 HB70-110	300-800					300-800								
N	铜/青铜/黄铜	300-1000					300-1000								
S	硬质合金/粉末冶金	10-30											20-50		
S	硅填充塑料硬质纤维	400-600					400-600								
H	钛/高温合金/碳纤维	100-200					100-200				20-60	20-60	30-80		

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S
P	钢	Steel			●
M	不锈钢	Stainless Steel			
K	铸铁	Iron		●	
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●		
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
精加工 Finishing	CCGT 060202	6.2	0.2		●	●								
	060204	6.0	0.4		●	●								
	060208	5.6	0.8		●	●								
	09T302	9.4	0.2		●	●								
	09T304	9.2	0.4		●	●								
	09T308	8.8	0.8		●	●								
	120402	12.6	0.2		●	●								
	120404	12.4	0.4		●	●								
	120408	12.0	0.8		●	●								
精加工 Finishing	CCGT 060202-2T	6.2	0.2		●	●								
	060204-2T	6.0	0.4		●	●								
	060208-2T	5.6	0.8		●	●								
	09T302-2T	9.4	0.2		●	●								
	09T304-2T	9.2	0.4		●	●								
	09T308-2T	8.8	0.8		●	●								
	120402-2T	12.6	0.2		●	●								
	120404-2T	12.4	0.4		●	●								
	120408-2T	12.0	0.8		●	●								
精加工 Finishing	CCGT 060202	6.2	0.2	●										
	060204	6.0	0.4	●										
	060208	5.6	0.8	●										
	09T302	9.4	0.2	●										
	09T304	9.2	0.4	●										
	09T308	8.8	0.8	●										
	120402	12.6	0.2	●										
	120404	12.4	0.4	●										
	120408	12.0	0.8	●										
精加工 Finishing (有断屑槽 With Groove)	CCGT 060202-AL	6.2	0.2	●										
	060204-AL	6.0	0.4	●										
	060208-AL	5.6	0.8	●										
	09T302-AL	9.4	0.2	●										
	09T304-AL	9.2	0.4	●										
	09T308-AL	8.8	0.8	●										
	120402-AL	12.6	0.2	●										
	120404-AL	12.4	0.4	●										
	120408-AL	12.0	0.8	●										
精加工 Finishing	CCGW060202	6.2	0.2	●										
	060204	6.0	0.4	●										
	060208	5.6	0.8	●										
	09T302	9.4	0.2	●										
	09T304	9.2	0.4	●										
	09T308	8.8	0.8	●										
	120402	12.6	0.2	●										
	120404	12.4	0.4	●										
	120408	12.0	0.8	●										
精加工 Finishing	CCGT 060202-2T	6.2	0.2	●										
	060204-2T	6.0	0.4	●										
	060208-2T	5.6	0.8	●										
	09T302-2T	9.4	0.2	●										
	09T304-2T	9.2	0.4	●										
	09T308-2T	8.8	0.8	●										
	120402-2T	12.6	0.2	●										
	120404-2T	12.4	0.4	●										
	120408-2T	12.0	0.8	●										

Cutting parameter chart labels: 切深 ap(mm); 进给 f(mm/rev); HB250以下 灰铸铁 Gray Iron Vc=300~800m/min; HRC50以上 淬硬钢 Chilled Cast Iron Vc=10~150m/min; 烧结铁/粉末冶金 Iron Sintered Metal Vc=100~250m/min; 铝/锌/铜/镁合金 Vc=300~1500m/min Aluminum/Zinc/Copper/Magnesium Alloy; 玻璃纤维/硅填充/塑料碳纤维(干式) Fiberglass/Slastic Carbon Fiber Vc=100~800m/min; 钛合金(湿式) Titanium Alloy Vc=100~200m/min; 硬质合金 Cemented Carbide Vc=10~30m/min

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

			ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✖	◐	✖	✖	◐	●		
M	不锈钢	Stainless Steel	◐	●					✖	◐	●		
K	铸铁	Iron	◐	●					✖			✖	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✖	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✖	◐	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工 Finishing~Semi-Finishing	CCGT 060202-AL	6.2	0.2			●								
	060204-AL	6.0	0.4			●								
	060208-AL	5.6	0.8			●								
	09T302-AL	9.4	0.2			●								
	09T304-AL	9.2	0.4			●								
	09T308-AL	8.8	0.8			●								
	120402-AL	12.6	0.2			●								
	120404-AL	12.4	0.4			●								
	120408-AL	12.0	0.8			●								
精加工 Finishing	CCGT 0301005R	3.6	0.05		●	●				●	●			
	030101R	3.5	0.1		●	●				●	●			
	030102R	3.3	0.2		●	●				●	●			
	030104R	3.1	0.4		●	●				●	●			
	0401005R	4.3	0.05		●	●				●	●			
	040101R	4.2	0.1		●	●				●	●			
	040102R	4.1	0.2		●	●				●	●			
	040104R	3.9	0.4		●	●				●	●			
精加工 Finishing	CCGT 0301005L	3.6	0.05		●	●				●	●			
	030101L	3.5	0.1		●	●				●	●			
	030102L	3.3	0.2		●	●				●	●			
	030104L	3.1	0.4		●	●				●	●			
	0401005L	4.3	0.05		●	●				●	●			
	040101L	4.2	0.1		●	●				●	●			
	040102L	4.1	0.2		●	●				●	●			
	040104L	3.9	0.4		●	●				●	●			
精加工 Finishing	CCGT 060201ER-U	6.5	0.1		●	●				●	●			
	060202ER-U	6.2	0.2		●	●				●	●			
	060204ER-U	6.0	0.4		●	●				●	●			
	09T301ER-U	9.7	0.1		●	●				●	●			
	09T302ER-U	9.4	0.2		●	●				●	●			
	09T304ER-U	9.2	0.4		●	●				●	●			
精加工 Finishing	CCGT 060201EL-U	6.5	0.1		●	●				●	●			
	060202EL-U	6.2	0.2		●	●				●	●			
	060204EL-U	6.0	0.4		●	●				●	●			
	09T301EL-U	9.7	0.1		●	●				●	●			
	09T302EL-U	9.4	0.2		●	●				●	●			
	09T304EL-U	9.2	0.4		●	●				●	●			
精加工 Finishing (R-H / L-H)	CCGT 060201R/L-H	6.5	0.1		●	●				●	●			
	060202R/L-H	6.2	0.2		●	●				●	●			
	060204R/L-H	6.0	0.4		●	●				●	●			
	09T301R/L-H	9.7	0.1		●	●				●	●			
	09T302R/L-H	9.4	0.2		●	●				●	●			
	09T304R/L-H	9.2	0.4		●	●				●	●			

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

			ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✖	◐	✖	✖	◐	●		
M	不锈钢	Stainless Steel	◐	●					✖	◐	●		
K	铸铁	Iron	◐	●					✖			✖	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✖	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✖	◐	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工 Finishing	CCMT 060202-TF	6.2	0.2				●	●		●	●			
	060204-TF	6.0	0.4				●	●		●	●			
	060208-TF	5.6	0.8				●	●		●	●			
	09T304-TF	9.2	0.4				●	●		●	●			
	09T308-TF	8.8	0.8				●	●		●	●			
	120404-TF	12.4	0.4				●	●		●	●			
	120408-TF	12.0	0.8				●	●		●	●			
精加工 Finishing	CCMT 060202-MSF	6.2	0.2							●	●			
	060204-MSF	6.0	0.4							●	●			
	060208-MSF	5.6	0.8							●	●			
	09T304-MSF	9.2	0.4							●	●			
	09T308-MSF	8.8	0.8							●	●			
	120404-MSF	12.4	0.4							●	●			
	120408-MSF	12.0	0.8							●	●			
精加工 Finishing	CCMT 060202-FG	6.2	0.2	●						●	●			
	060204-FG	6.0	0.4	●						●	●			
	09T304-FG	9.2	0.4	●						●	●			
	09T308-FG	8.8	0.8	●						●	●			
半精加工~粗加工 Semi-Finishing~Roughing	CCMT 060204-TM	6.0	0.4				●	●		●	●	●	●	
	060208-TM	5.6	0.8				●	●		●	●	●	●	
	09T304-TM	9.2	0.4				●	●		●	●	●	●	
	09T308-TM	8.8	0.8				●	●		●	●	●	●	
	120404-TM	12.4	0.4				●	●		●	●	●	●	
	120408-TM	12.0	0.8				●	●		●	●	●	●	
半精加工 Semi-Finishing	CCMT 060204-MT	6.0	0.4	●			●			●				
	060208-MT	5.6	0.8	●			●			●				
	09T304-MT	9.2	0.4	●			●			●				
	09T308-MT	8.8	0.8	●			●			●				
半精加工~粗加工 Semi-Finishing~Roughing	CCMT 060204-GM	6.0	0.4				●	●		●	●	●		
	060208-GM	5.6	0.8				●	●		●	●	●		
	09T304-GM	9.2	0.4				●	●		●	●	●		
	09T308-GM	8.8	0.8				●	●		●	●	●		
	120404-GM	12.4	0.4				●	●		●	●	●		
	120408-GM	12.0	0.8				●	●		●	●	●		
半精加工 Semi-Finishing	CCMT 060204-HQ	6.0	0.4	●			●	●		●	●			
	060208-HQ	5.6	0.8	●			●	●		●	●			
	09T304-HQ	9.2	0.4	●			●	●		●	●			
	09T308-HQ	8.8	0.8	●			●	●		●	●			
半精加工~粗加工 Semi-Finishing~Roughing	CCMT 060204	6.0	0.4				●	●		●	●	●	●	
	060208	5.6	0.8				●	●		●	●	●	●	
	09T304	9.2	0.4				●	●		●	●	●	●	
	09T308	8.8	0.8				●	●		●	●	●	●	
	120404	12.4	0.4				●	●		●	●	●	●	
	120408	12.0	0.8				●	●		●	●	●	●	

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
粗加工 Roughing	CCMT 060204-TR	6.0	0.4				●	●		●			●	●
	060208-TR	5.6	0.8				●	●		●			●	●
	09T304-TR	9.2	0.4				●	●		●			●	●
	09T308-TR	8.8	0.8				●	●		●			●	●
	120408-TR	12.0	0.8				●	●		●			●	●
	120412-TR	11.6	1.2				●	●		●			●	●

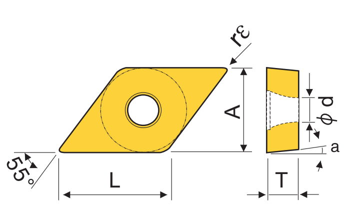
Cutting parameter chart labels: 切深 ap(mm); 进给 f(mm/rev); 06; 09; 12

DC..正角刀片

DC.. Single Side Cutting Edge Inserts

DC 55°菱形 正角 有孔刀片

外圆车刀 (External Toolholder): B21-B22
小零件专用 (Small Parts Toolholder): AB03-AB11
内孔车刀 (Internal Toolholder): B49-B53



(mm)

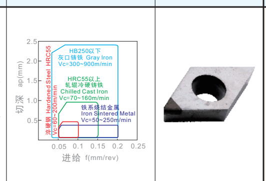
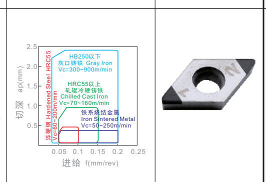
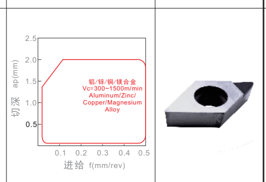
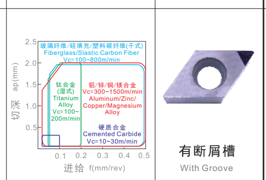
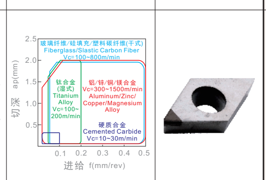
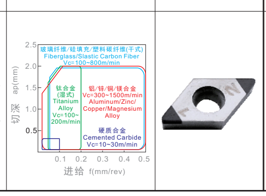
Model	A	T	Φd	a
DC..0702..	6.35	2.38	2.8	7°
DC..11T3..	9.525	3.97	4.4	7°
DC..1504..	12.7	4.76	5.56	7°

切削线速度 (Cutting Speed): m/min

加工材料	刀具材质 / 材料特点	PCD 金刚石	CBN-K 铸铁专用	CBN-S 难切削材用	ZN60 光洁度好	ZN90 高速精加工	ZK01 铜铝加工	ZC250 CVD 钢件	ZC251 CVD 钢件	ZC32S 钢件高速	ZP152 不锈钢通用	ZP153 不锈钢高速	ZP163 高硬高速	ZK50 CVD 铸铁	ZK50S 铸铁高速
P	低碳钢				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58			10-30							20-60	20-60	20-80		
M	不锈钢				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材	300-1200					300-1200								
N	铝合金 HB50-70	300-1500					300-1500								
N	淬硬铝合金 HB70-110	300-800					300-800								
N	铜/青铜/黄铜	300-1000					300-1000								
S	硬质合金/粉末冶金	10-30											20-50		
S	硅填充塑料硬质纤维	400-600					400-600								
H	钛/高温合金/碳纤维	100-200					100-200				20-50	20-60	30-80		

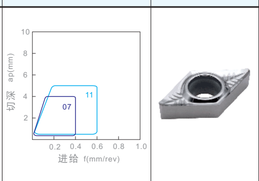
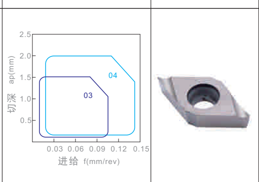
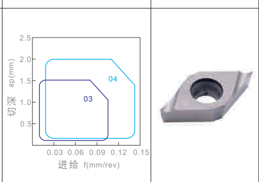
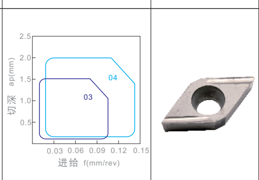
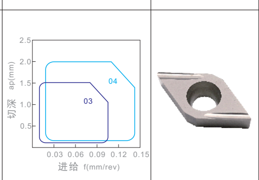
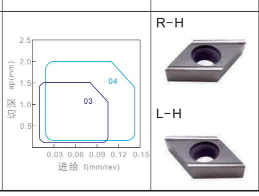
切削形态 Cutting Environment: ● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✣ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S
P	钢	Steel			●
M	不锈钢	Stainless Steel			
K	铸铁	Iron		●	
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	◐		
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●		

用途 Application	切削参数 Cutting Parameter / 产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
精加工 Finishing		DCGT 070202	7.5	0.2		●	●								
		070204	7.3	0.4		●	●								
		070208	6.8	0.8		●	●								
		11T302	11.4	0.2		●	●								
		11T304	11.2	0.4		●	●								
		11T308	10.8	0.8		●	●								
精加工 Finishing		DCGT 070202-2T	7.5	0.2		●	●								
		070204-2T	7.3	0.4		●	●								
		070208-2T	6.8	0.8		●	●								
		11T302-2T	11.4	0.2		●	●								
		11T304-2T	11.2	0.4		●	●								
		11T308-2T	10.8	0.8		●	●								
精加工 Finishing		DCGT 070201	7.7	0.1	●										
		070202	7.5	0.2	●										
		070204	7.3	0.4	●										
		070208	6.8	0.8	●										
		11T302	11.4	0.2	●										
		11T304	11.2	0.4	●										
		11T308	10.8	0.8	●										
精加工 Finishing	 有断屑槽 With Groove	DCGT 070202-AL	7.5	0.2	●										
		070204-AL	7.3	0.4	●										
		070208-AL	6.8	0.8	●										
		11T302-AL	11.4	0.2	●										
		11T304-AL	11.2	0.4	●										
		11T308-AL	10.8	0.8	●										
精加工 Finishing		DCGT 070202	7.5	0.2	●										
		070204	7.3	0.4	●										
		070208	6.8	0.8	●										
		11T302	11.4	0.2	●										
		11T304	11.2	0.4	●										
		11T308	10.8	0.8	●										
精加工 Finishing		DCGT 070202-2T	7.5	0.2	●										
		070204-2T	7.3	0.4	●										
		070208-2T	6.8	0.8	●										
		11T302-2T	11.4	0.2	●										
		11T304-2T	11.2	0.4	●										
		11T308-2T	10.8	0.8	●										

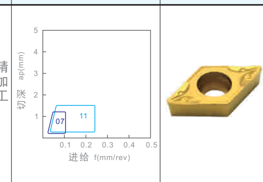
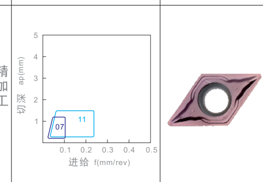
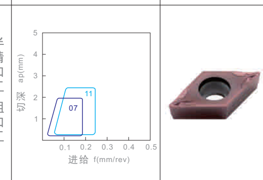
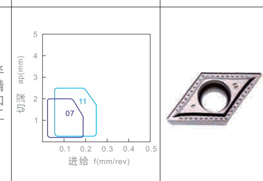
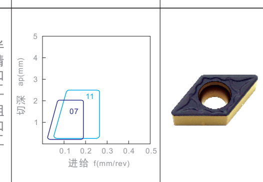
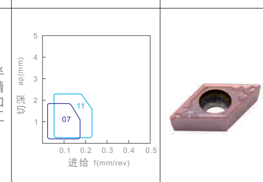
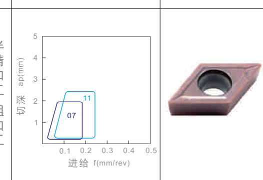
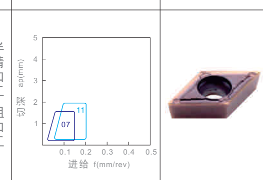
切削形态 Cutting Environment: ● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✣ 不稳定切削 Unstable Cutting

			ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✣	◐	✣	✣	◐	●		
M	不锈钢	Stainless Steel	◐	●					✣	◐	●		
K	铸铁	Iron	◐	●					✣			✣	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✣	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✣	◐	●		

用途 Application	切削参数 Cutting Parameter / 产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工~半精加工 Finishing~Semi-Finishing		DCGT 070202-AL	7.5	0.2			●								
		070204-AL	7.3	0.4			●								
		070208-AL	6.8	0.8			●								
		11T302-AL	11.4	0.2			●								
		11T304-AL	11.2	0.4			●								
		11T308-AL	10.8	0.8			●								
		11T312-AL	10.4	1.2			●								
精加工 Finishing		DCGT 0702005R	7.8	0.05		●	●				●	●			
		070201R	7.8	0.1		●	●				●	●			
		070202R	7.5	0.2		●	●				●	●			
		070204R	7.3	0.4		●	●				●	●			
		11T3005R	11.6	0.05		●	●				●	●			
		11T301R	11.5	0.1		●	●				●	●			
		11T302R	11.4	0.2		●	●				●	●			
		11T304R	11.2	0.4		●	●				●	●			
精加工 Finishing		DCGT 0702005L	7.8	0.05		●	●				●	●			
		070201L	7.8	0.1		●	●				●	●			
		070202L	7.5	0.2		●	●				●	●			
		070204L	7.3	0.4		●	●				●	●			
		11T3005L	11.6	0.05		●	●				●	●			
		11T301L	11.5	0.1		●	●				●	●			
		11T302L	11.4	0.2		●	●				●	●			
		11T304L	11.2	0.4		●	●				●	●			
精加工 Finishing		DCGT 070201ER-U	7.8	0.1		●	●				●	●			
		070202ER-U	7.5	0.2		●	●				●	●			
		070204ER-U	7.3	0.4		●	●				●	●			
		11T301ER-U	11.5	0.1		●	●				●	●			
		11T302ER-U	11.4	0.2		●	●				●	●			
		11T304ER-U	11.2	0.4		●	●				●	●			
精加工 Finishing		DCGT 070201EL-U	7.8	0.1		●	●				●	●			
		070202EL-U	7.5	0.2		●	●				●	●			
		070204EL-U	7.3	0.4		●	●				●	●			
		11T301EL-U	11.5	0.1		●	●				●	●			
		11T302EL-U	11.4	0.2		●	●				●	●			
		11T304EL-U	11.2	0.4		●	●				●	●			
精加工 Finishing	 R-H L-H	DCGT 070201R/L-H	7.8	0.1		●	●				●	●			
		070202R/L-H	7.5	0.2		●	●				●	●			
		070204R/L-H	7.3	0.4		●	●				●	●			
		11T301R/L-H	11.5	0.1		●	●				●	●			
		11T302R/L-H	11.4	0.2		●	●				●	●			
		11T304R/L-H	11.2	0.4		●	●				●	●			

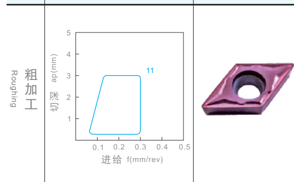
切削形态 Cutting Environment: ● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✣ 不稳定切削 Unstable Cutting

			ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✣	◐	✣	✣	◐	●		
M	不锈钢	Stainless Steel	◐	●					✣	◐	●		
K	铸铁	Iron	◐	●					✣			✣	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✣	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✣	◐	●		

用途 Application	切削参数 Cutting Parameter / 产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工 Finishing		DCMT 070202-TF	7.5	0.2				●	●		●	●			
		070204-TF	7.3	0.4				●	●		●	●			
		070208-TF	6.8	0.8				●	●		●	●			
		11T302-TF	11.4	0.2				●	●		●	●			
		11T304-TF	11.2	0.4				●	●		●	●			
		11T308-TF	10.8	0.8				●	●		●	●			
精加工 Finishing		DCMT 070202-FG	7.5	0.2	●						●	●			
		070204-FG	7.3	0.4	●						●	●			
		11T302-FG	11.4	0.2	●						●	●			
		11T304-FG	11.2	0.4	●						●	●			
		11T308-FG	10.8	0.8	●						●	●			
半精加工~粗加工 Semi-Finishing ~ Roughing		DCMT 070204-TM	7.3	0.4				●	●		●	●	●	●	
		070208-TM	6.8	0.8				●	●		●	●	●	●	
		11T304-TM	11.2	0.4				●	●		●	●	●	●	
		11T308-TM	10.8	0.8				●	●		●	●	●	●	
半精加工 Semi-Finishing		DCMT 070204-MT	7.3	0.4	●			●			●				
		070208-MT	6.8	0.8	●			●			●				
		11T304-MT	11.2	0.4	●			●			●				
		11T308-MT	10.8	0.8	●			●			●				
半精加工~粗加工 Semi-Finishing ~ Roughing		DCMT 070202-GM	7.5	0.2				●	●		●	●	●		
		070204-GM	7.3	0.4				●	●		●	●	●		
		070208-GM	6.8	0.8				●	●		●	●	●		
		11T302-GM	11.4	0.2				●	●		●	●	●		
		11T304-GM	11.2	0.4				●	●		●	●	●		
		11T308-GM	10.8	0.8				●	●		●	●	●		
半精加工 Semi-Finishing		DCMT 070204-HQ	7.3	0.4	●			●	●		●	●			
		070208-HQ	6.8	0.8	●			●	●		●	●			
		11T304-HQ	11.2	0.4	●			●	●		●	●			
		11T308-HQ	10.8	0.8	●			●	●		●	●			
半精加工~粗加工 Semi-Finishing ~ Roughing		DCMT 070204	7.3	0.4	●			●	●		●	●	●	●	
		070208	6.8	0.8	●			●	●		●	●	●	●	
		11T304	11.2	0.4	●			●	●		●	●	●	●	
		11T308	10.8	0.8	●			●	●		●	●	●	●	
半精加工~粗加工 Semi-Finishing ~ Roughing		DCMT 070204-MV	7.3	0.4				●	●		●	●	●	●	
		070208-MV	6.8	0.8				●	●		●	●	●	●	
		11T304-MV	11.2	0.4				●	●		●	●	●	●	
		11T308-MV	10.8	0.8				●	●		●	●	●	●	

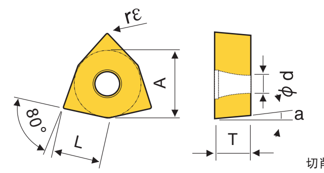
切削形态 Cutting Environment: ● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✣ 不稳定切削 Unstable Cutting

			ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✣	◐	✣	✣	◐	●		
M	不锈钢	Stainless Steel	◐	●					✣	◐	●		
K	铸铁	Iron	◐	●					✣			✣	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✣	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✣	◐	●		

用途 Application	切削参数 Cutting Parameter / 产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
粗加工 Roughing		DCMT 11T304-TR	11.2	0.4				●	●		●			●	●
		11T308-TR	10.8	0.8				●	●		●			●	●
		11T312-TR	10.4	1.2				●	●		●			●	●

WB 80°桃形 正角 有孔刀片

内孔车刀 (Internal Toolholder): B45-B48

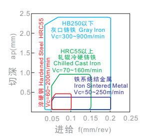
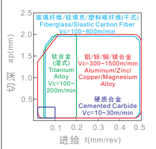
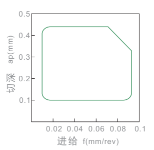
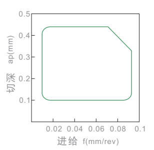


(mm)

Model	A	T	ϕd	a
WB..0601..	3.97	1.59	2.3	5°
WB..0802..	4.76	2.38	2.3	5°

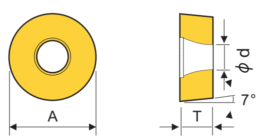
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	L	A	T	ϕd	rε	切深 ap(mm)	进给 f(mm/rev)	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
精加工 Finishing			WBGT 060102 060104	2.6 2.3	3.97 3.97	1.59 1.59	2.3 2.3	0.2 0.4				● ●	● ●								
精加工 Finishing			WBGT 060102 060104	2.6 2.3	3.97 3.97	1.59 1.59	2.3 2.3	0.2 0.4			● ●										
精加工 Finishing			WBGT 060101R 060102R 060104R	2.7 2.6 2.3	3.97 3.97 3.97	1.59 1.59 1.59	2.3 2.3 2.3	0.1 0.2 0.4	0.1-0.3 0.1-0.4 0.1-0.5	0.01-0.05 0.01-0.06 0.01-0.08					● ● ●	● ● ●				● ● ●	● ● ●
精加工 Finishing			WBGT 060101L 060102L 060104L	2.7 2.6 2.3	3.97 3.97 3.97	1.59 1.59 1.59	2.3 2.3 2.3	0.1 0.2 0.4	0.1-0.3 0.1-0.4 0.1-0.5	0.01-0.05 0.01-0.06 0.01-0.08					● ● ●	● ● ●				● ● ●	● ● ●

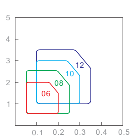
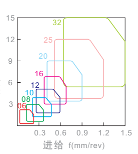
RC 圆形 正角 有孔刀片

外圆车刀 (External Toolholder): B23



切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

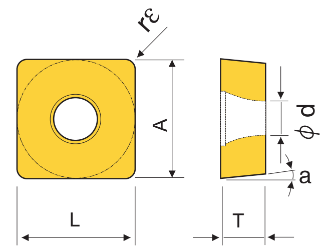
用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	L	A	T	ϕd	rε	切深 ap(mm)	进给 f(mm/rev)	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工~半精加工 Finishing ~ Semi-Finishing			RCGT 0602MO-AL 0803MO-AL 1003MO-AL 10T3MO-AL 1204MO-AL	- - - - -	6.0 8.0 10.0 10.0 12.0	2.38 3.18 3.18 3.97 4.76	2.8 3.35 4.0 4.4 4.4	- - - - -	0.5-2.0 0.5-2.5 1.0-3.0 1.0-3.0 1.0-3.5	0.05-0.2 0.05-0.25 0.1-0.3 0.1-0.3 0.1-0.35			● ● ● ● ●								
半精加工~粗加工 Semi-Finishing ~ Roughing			RCMX 0602MO 0803MO 1003MO 10T3MO 1204MO 1606MO 2006MO 2507MO 3209MO	- - - - - - - - -	6.0 8.0 10.0 10.0 12.0 16.0 20.0 25.0 32.0	2.38 3.18 3.18 3.97 4.76 6.35 6.35 7.94 9.52	2.8 3.35 3.6 3.6 4.2 5.2 6.5 7.25 9.55	- - - - - - - - -	0.5-1.5 0.5-2.0 1.5-4.0 1.5-4.0 2.5-5.0 3.0-7.0 3.5-9.0 4.0-12.0 5.0-15.0	0.1-0.3 0.2-0.4 0.25-0.5 0.25-0.5 0.3-0.6 0.4-0.7 0.48-0.9 0.55-1.2 0.65-1.5				● ● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ● ●		● ● ● ● ● ● ● ● ●	● ● ● ● ● ● ● ● ●		● ● ● ● ● ● ● ● ●	

SC 正方形 正角 有孔刀片

外圆车刀 (External Toolholder): B22
内孔车刀 (Internal Toolholder): B54

(mm)

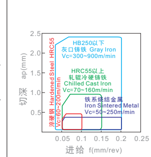
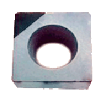
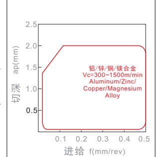
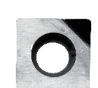
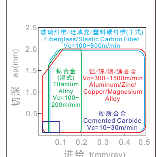
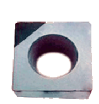
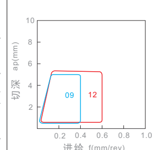
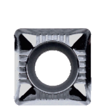
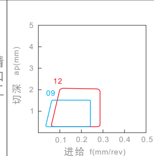
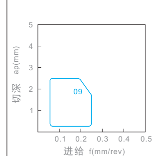
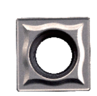
Model	A	T	ϕd	a
SC..09T3..	9.525	3.97	4.4	7°
SC..1204..	12.7	4.76	5.5	7°

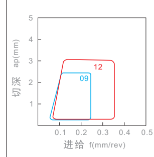
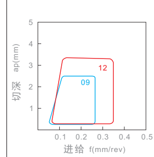
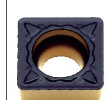
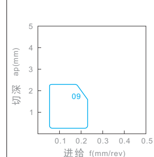
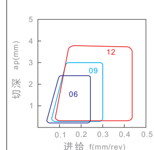
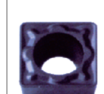


加工材料 Material		刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel					150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel					150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel				10-30							20-60	20-60	20-80		
M	不锈钢 Stainless Steel					200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron			300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron			400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood		300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy		300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy		300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass		300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy		10-30					10-30						20-50		
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber		400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber		100-200					100-200				20-50	20-60	30-80		

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
精加工 Finishing			SCGT 09T302 09T304 09T308 120402 120404 120408	9.5 9.1 8.7 12.7 12.3 11.9	0.2 0.4 0.8 0.2 0.4 0.8		● ● ● ● ● ●	● ● ● ● ● ●								
精加工 Finishing			SCGT 09T302 09T304 09T308 120402 120404 120408	9.5 9.1 8.7 12.7 12.3 11.9	0.2 0.4 0.8 0.2 0.4 0.8	● ● ● ● ● ●										
精加工 Finishing			SCGW 09T302 09T304 09T308 120402 120404 120408	9.5 9.1 8.7 12.7 12.3 11.9	0.2 0.4 0.8 0.2 0.4 0.8	● ● ● ● ● ●										
精加工~半精加工 Finishing ~ Semi-Finishing			SCGT 09T302-AL 09T304-AL 09T308-AL 120404-AL 120408-AL	9.3 9.1 8.7 12.3 11.9	0.2 0.4 0.8 0.4 0.8			● ● ● ● ●								
精加工 Finishing			SCMT 09T304-TF 09T308-TF 120404-TF 120408-TF	9.1 8.7 12.3 11.9	0.4 0.8 0.4 0.8				● ● ● ●	● ● ● ●		● ● ● ●	● ● ● ●			
半精加工 Semi-Finishing			SCMT 09T304-MT 09T308-MT	9.1 8.7	0.4 0.8	● ●			● ●			● ●				

用途 Application	切削参数 Cutting Parameter	产品图片 Product Image	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
半精加工~粗加工 Semi-Finishing ~ Roughing			SCMT 09T304-TM 09T308-TM 120404-TM 120408-TM 120412-TM	9.1 8.7 12.3 11.9 11.5	0.4 0.8 0.4 0.8 1.2				● ● ● ● ●	● ● ● ● ●		● ● ● ● ●	● ● ● ● ●	● ● ● ● ●	● ● ● ● ●	
半精加工~粗加工 Semi-Finishing ~ Roughing			SCMT 09T304-GM 09T308-GM 120404-GM 120408-GM	9.1 8.7 12.3 11.9	0.4 0.8 0.4 0.8				● ● ● ●	● ● ● ●	● ● ● ●	● ● ● ●	● ● ● ●	● ● ● ●		
半精加工 Semi-Finishing			SCMT 09T304-HQ 09T308-HQ	9.1 8.7	0.4 0.8	● ●			● ●	● ●		● ●	● ●			
粗加工 Roughing			SCMT 09T304-TR 09T308-TR 120404-TR 120408-TR 120412-TR	9.1 8.7 12.3 11.9 11.5	0.4 0.8 0.4 0.8 1.2				● ● ● ● ●	● ● ● ● ●		● ● ● ● ●	● ● ● ● ●	● ● ● ● ●	● ● ● ● ●	

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GM. TD.
后车削 ABS TBP TKFB
内孔切槽 T.N/E GE. . GR
螺纹车削刀片
铣削刀片

T.. 60°正三角 正角 有孔刀片

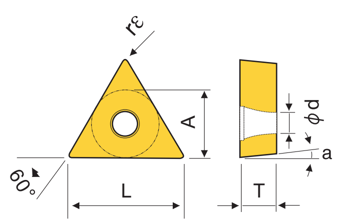
外圆车刀 (External Toolholder): B24
小零件专用 (Small Parts Toolholder): AB07/AB11
内孔车刀 (Internal Toolholder): B55-B60

(mm)

Model	A	T	ϕd	a
TB..0601..	3.97	1.59	2.16	5°

Model	A	T	ϕd	a
TC..0902..	5.56	2.38	2.5	7°
TC..1102..	6.35	2.38	2.8	7°
TC..16T3..	9.525	3.97	4.4	7°

Model	A	T	ϕd	a
TP..0802..	4.76	2.38	2.3	11°
TP..0902..	5.56	2.38	3.0	11°
TP..1102..	6.35	2.38	3.4	11°
TP..1103..	6.35	3.18	3.4	11°
TP..1604..	9.525	4.76	4.4	11°



切削线速度 (Cutting Speed): m/min

加工材料	刀具材质 / 材质特点	PCD 金刚石	CBN-K 铸铁专用	CBN-S 难切削材用	ZN60 光洁度好	ZN90 高速精加工	ZK01 铜铝加工	ZC250 CVD 钢件	ZC251 CVD 钢件	ZC32S 钢件高速	ZP152 不锈钢通用	ZP153 不锈钢高速	ZP163 高硬高速	ZK50 CVD 铸铁	ZK50S 铸铁高速
P	低碳钢				150-600	150-800		70-500	150-500	150-600	70-250	100-250	150-300		
P	高碳钢				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58			10-30							20-60	20-60	20-80		
M	不锈钢				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材	300-1200					300-1200								
N	铝合金 HB50-70	300-1500					300-1500								
N	淬硬铝合金 HB70-110	300-800					300-800								
N	铜/青铜/黄铜	300-1000					300-1000								
S	硬质合金/粉末冶金	10-30					10-30						20-50		
S	硅填充塑料硬质纤维	400-600					400-600								
H	钛/高温合金/碳纤维	100-200					100-200				20-50	20-60	30-80		

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✱ 不稳定切削 Unstable Cutting

	材料	Material	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
P	钢	Steel			●								
M	不锈钢	Stainless Steel											
K	铸铁	Iron		●									
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●										
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●										
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●										

用途 Application	规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
精加工 Finishing	TBGT 060102	6.4	0.2		●	●								
	060104	5.8	0.4		●	●								
	TCGT 090202	9.1	0.2		●	●								
	090204	8.6	0.4		●	●								
	090208	7.6	0.8		●	●								
	110202	10.5	0.2		●	●								
	110204	10.0	0.4		●	●								
	110208	9.0	0.8		●	●								
	16T302	16.0	0.2		●	●								
	16T304	15.5	0.4		●	●								
	16T308	14.5	0.8		●	●								
	TPGT 080202	7.7	0.2		●	●								
	080204	7.2	0.4		●	●								
	090202	9.1	0.2		●	●								
	090204	8.6	0.4		●	●								
	090208	7.6	0.8		●	●								
	110302	10.5	0.2		●	●								
	110304	10.0	0.4		●	●								
	110308	9.0	0.8		●	●								
精加工 Finishing	TCGT 16T302-3T	16.0	0.2		●	●								
	16T304-3T	15.5	0.4		●	●								
	16T308-3T	14.5	0.8		●	●								
	TPGT 110302-3T	10.5	0.2		●	●								
	110304-3T	10.0	0.4		●	●								
	110308-3T	9.0	0.8		●	●								
精加工 Finishing	TBGW 060102	6.4	0.2	●										
	060104	5.8	0.4	●										
	TCGW 090202	9.1	0.2	●										
	090204	8.6	0.4	●										
	090208	7.6	0.8	●										
	110202	10.5	0.2	●										
	110204	10.0	0.4	●										
	110208	9.0	0.8	●										
	16T302	16.0	0.2	●										
	16T304	15.5	0.4	●										
	16T308	14.5	0.8	●										
	TPGW 080202	7.7	0.2	●										
	080204	7.2	0.4	●										
	090202	9.1	0.2	●										
	090204	8.6	0.4	●										
	090208	7.6	0.8	●										
	110302	10.5	0.2	●										
	110304	10.0	0.4	●										
	110308	9.0	0.8	●										
精加工 Finishing	TCGT 16T302-3T	16.0	0.2	●										
	16T304-3T	15.5	0.4	●										
	16T308-3T	14.5	0.8	●										
	TPGT 110302-3T	10.5	0.2	●										
	110304-3T	10.0	0.4	●										
	110308-3T	9.0	0.8	●										

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✱ 不稳定切削 Unstable Cutting

	材料	Material	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	●	●		✱	●	✱	✱	●	●		
M	不锈钢	Stainless Steel	◐	●					✱	◐	●		
K	铸铁	Iron	◐	●					✱			✱	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✱	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✱	◐	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工-半精加工 Finishing-Semi-Finishing	TCGT 090202	9.1	0.2			●								
	090204	8.6	0.4			●								
	090208	7.6	0.8			●								
	110202	10.5	0.2			●								
	110204	10.0	0.4			●								
	110208	9.0	0.8			●								
	16T302	16.0	0.2			●								
	16T304	15.5	0.4			●								
	16T308	14.5	0.8			●								
	16T312	13.5	1.2			●								
	16T316	12.5	1.6			●								
	16T325	10.0	2.5			●								
	TPGT 090202	9.1	0.2			●								
	090204	8.6	0.4			●								
	090208	7.6	0.8			●								
	110302	10.5	0.2			●								
	110304	10.0	0.4			●								
	110308	9.0	0.8			●								
精加工 Finishing	TBGT 060102L	6.4	0.2	●	●					●	●			
	060104L	5.8	0.4	●	●					●	●			
	TCGT 090202L	9.1	0.2	●	●					●	●			
	090204L	8.6	0.4	●	●					●	●			
	090208L	7.6	0.8	●	●					●	●			
	110202L	10.5	0.2	●	●					●	●			
	110204L	10.0	0.4	●	●					●	●			
	110208L	9.0	0.8	●	●					●	●			
	TPGT 080202L	7.7	0.2	●	●					●	●			
	080204L	7.2	0.4	●	●					●	●			
	090202L	9.1	0.2	●	●					●	●			
	090204L	8.6	0.4	●	●					●	●			
	090208L	7.6	0.8	●	●					●	●			
	110302L	10.5	0.2	●	●					●	●			
	110304L	10.0	0.4	●	●					●	●			
	110308L	9.0	0.8	●	●					●	●			
精加工 Finishing	TBGT 060102R	6.4	0.2	●	●					●	●			
	060104R	5.8	0.4	●	●					●	●			
	TCGT 090202R	9.1	0.2	●	●					●	●			
	090204R	8.6	0.4	●	●					●	●			
	090208R	7.6	0.8	●	●					●	●			
	110202R	10.5	0.2	●	●					●	●			
	110204R	10.0	0.4	●	●					●	●			
	110208R	9.0	0.8	●	●					●	●			
	TPGT 080202R	7.7	0.2	●	●					●	●			
	080204R	7.2	0.4	●	●					●	●			
	090202R	9.1	0.2	●	●					●	●			
	090204R	8.6	0.4	●	●					●	●			
	090208R	7.6	0.8	●	●					●	●			
	110302R	10.5	0.2	●	●					●	●			
	110304R	10.0	0.4	●	●					●	●			
	110308R	9.0	0.8	●	●					●	●			

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✱ 不稳定切削 Unstable Cutting

	材料	Material	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	●	●		✱	●	✱	✱	●	●		
M	不锈钢	Stainless Steel	◐	●					✱	◐	●		
K	铸铁	Iron	◐	●					✱			✱	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✱	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✱	◐	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
精加工 Finishing	TCMT 110202-TF	10.5	0.2				●	●		●	●			
	110204-TF	10.0	0.4				●	●		●	●			
	16T304-TF	15.5	0.4				●	●		●	●			
	16T308-TF	14.5	0.8				●	●		●	●			
精加工 Finishing	TPMT 090204-FG	8.6	0.4	●							●			
	110304-FG	10.0	0.4	●							●			
半精加工-粗加工 Semi-Finishing - Roughing	TCMT 090204-TM	8.6	0.4				●	●		●	●	●	●	
	090208-TM	7.6	0.8				●	●		●	●	●	●	
	110204-TM	10.0	0.4				●	●		●	●	●	●	
	110208-TM	9.0	0.8				●	●		●	●	●	●	
	16T304-TM	15.5	0.4				●	●		●	●	●	●	
	16T308-TM	14.5	0.8				●	●		●	●	●	●	
	16T312-TM	13.5	1.2				●	●		●	●	●	●	
半精加工-粗加工 Semi-Finishing - Roughing	TCMT 090204-GM	8.6	0.4				●	●	●	●	●	●		
	090208-GM	7.6	0.8				●	●	●	●	●	●		
	110204-GM	10.0	0.4				●	●	●	●	●	●		
	110208-GM	9.0	0.8				●	●	●	●	●	●		
	16T304-GM	15.5	0.4				●	●	●	●	●	●		
	16T308-GM	14.5	0.8				●	●	●	●	●	●		
	16T312-GM	13.5	1.2				●	●	●	●	●	●		
半精加工-粗加工 Semi-Finishing - Roughing	TCMT 090204	8.6	0.4				●	●		●	●	●	●	
	090208	7.6	0.8				●	●		●	●	●	●	
	110204	10.0	0.4				●	●		●	●	●	●	
	110208	9.0	0.8				●	●		●	●	●	●	
	16T304	15.5	0.4				●	●		●	●	●	●	
	16T308	14.5	0.8				●	●		●	●	●	●	
	16T312	13.5	1.2				●	●		●	●	●	●	
半精加工 Semi-Finishing	TCMT 090204-MV	7.6	0.8	●			●	●		●	●			
	110204-MV	10.0	0.4	●			●	●		●	●			
	110208-MV	9.0	0.8	●			●	●		●	●			
	16T304-MV	15.5	0.4	●			●	●		●	●			
	16T308-MV	14.5	0.8	●			●	●		●	●			
半精加工 Semi-Finishing	TCMT 090202-HQ	9.1	0.2	●			●	●		●	●			
	090204-HQ	8.6	0.4	●			●	●		●	●			
	110202-HQ	10.5	0.2	●			●	●		●	●			
	110204-HQ	10.0	0.4	●			●	●		●	●			
	110208-HQ	9.0	0.8	●			●	●		●	●			
	16T304-HQ	15.5	0.4	●			●	●		●	●			
	16T308-HQ	14.5	0.8	●			●	●		●	●			
半精加工 Semi-Finishing	TCMT 090202-MT	9.1	0.2	●			●	●		●	●			
	090204-MT	8.6	0.4	●			●	●		●	●			
	110202-MT	10.5	0.2	●			●	●		●	●			
	110204-MT	10.0	0.4	●			●	●		●	●			
	110208-MT	9.0	0.8	●			●	●		●	●			
	16T304-MT	15.5	0.4	●			●	●		●	●			
	16T308-MT	14.5	0.8	●			●	●		●	●			

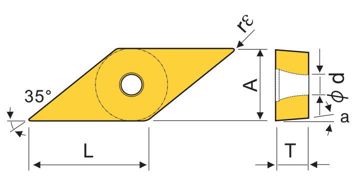
切削形态 Cutting Environment: ● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✱ 不稳定切削 Unstable Cutting

	材料	Material	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	●	●		✱	●	✱	✱	●	●		
M	不锈钢	Stainless Steel	◐	●					✱	◐	●		
K	铸铁	Iron	◐	●					✱			✱	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✱	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✱	◐	●		

用途 Application	规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
粗加工 Roughing	TCMT 16T304-TR	15.5	0.4				●	●		●			●	●
	16T308-TR	14.5	0.8				●	●		●			●	●
	16T312-TR	13.5	1.2				●	●		●			●	●

数控刀片 | CN DN RN KN 175 SN TN VN WN | CC DC RC SC WB TB TC TP VB VC | 三角浅槽 TGF GBA T.N/E | 小零件 CTP TKF | 切槽切断 MG. MR. SP. GM. TD. | 后车削 ABS TBP TKFB | 内孔切槽 T.N/E GE. GR | 螺纹车削刀片 | 铣削刀片

VB 35°菱形 正角 有孔刀片



外圆车刀 (External Toolholder): B25-B26
小零件专用 (Small Parts Toolholder): AB04/AB07/AB12
内孔车刀 (Internal Toolholder): B61-B65

(mm)

Model	A	T	ϕd	a
VB..1103..	6.35	3.18	2.8	5°
VB..1604..	9.525	4.76	4.4	5°
VC..1103	6.35	3.18	2.8	7°
VC..1604..	9.525	4.76	4.4	7°
VC..2205..	12.7	5.56	5.6	7°

切削线速度 (Cutting Speed): m/min⁻¹

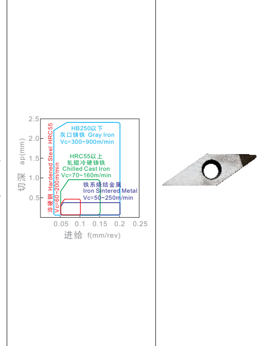
加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel			10-30							20-60	20-60	20-80		
M	不锈钢 Stainless Steel				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy	300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30					10-30						20-50		
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200					100-200				20-50	20-60	30-80		

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✤ 不稳定切削 Unstable Cutting

	材料	Material	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
P	钢	Steel			●								
M	不锈钢	Stainless Steel											
K	铸铁	Iron		●									
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●										
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●										
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●										

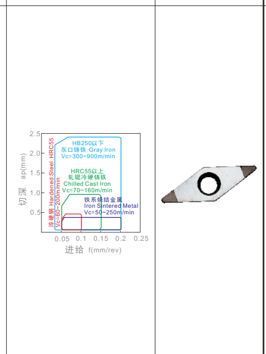
用途 Application | 切削参数 Cutting Parameter | 产品图片 Product Image

精加工 Finishing



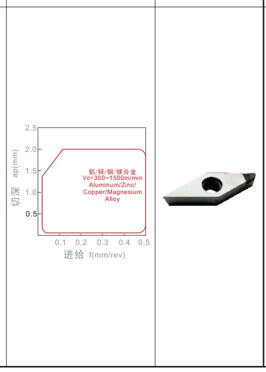
规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
VBGT 110302	11.0	0.2		●	●								
110304	10.0	0.4		●	●								
110308	9.0	0.8		●	●								
160402	16.1	0.2		●	●								
160404	15.6	0.4		●	●								
160408	14.6	0.8		●	●								
VCGT 110302	11.0	0.2		●	●								
110304	10.0	0.4		●	●								
110308	9.0	0.8		●	●								
160402	16.1	0.2		●	●								
160404	15.6	0.4		●	●								
160408	14.6	0.8		●	●								

精加工 Finishing



规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
VBGT 110302-2T	11.0	0.2		●	●								
110304-2T	10.0	0.4		●	●								
110308-2T	9.0	0.8		●	●								
160402-2T	16.1	0.2		●	●								
160404-2T	15.6	0.4		●	●								
160408-2T	14.6	0.8		●	●								
VCGT 110302-2T	11.0	0.2		●	●								
110304-2T	10.0	0.4		●	●								
110308-2T	9.0	0.8		●	●								
160402-2T	16.1	0.2		●	●								
160404-2T	15.6	0.4		●	●								
160408-2T	14.6	0.8		●	●								

精加工 Finishing



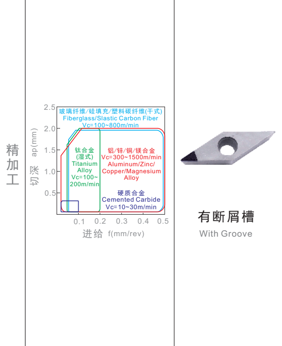
规格型号 Specification	边长 L	刀尖 rε	PCD	CBN-K	CBN-S	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153
VBGW 110301	11.0	0.1		●	●								
110302	11.0	0.2		●	●								
110304	10.0	0.4		●	●								
110308	9.0	0.8		●	●								
160402	16.1	0.2		●	●								
160404	15.6	0.4		●	●								
160408	14.6	0.8		●	●								
160412	13.5	1.2		●	●								
VCGW 110301	11.0	0.1		●	●								
110302	11.0	0.2		●	●								
110304	10.0	0.4		●	●								
110308	9.0	0.8		●	●								
160402	16.1	0.2		●	●								
160404	15.6	0.4		●	●								
160408	14.6	0.8		●	●								
160412	13.5	1.2		●	●								

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✤ 不稳定切削 Unstable Cutting

	材料	Material	PCD	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel			●								
M	不锈钢	Stainless Steel											
K	铸铁	Iron		●									
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●										
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●										
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●										

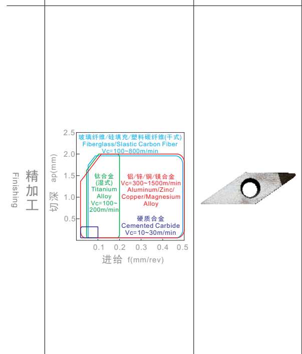
用途 Application | 切削参数 Cutting Parameter | 产品图片 Product Image

精加工 Finishing



规格型号 Specification	边长 L	刀尖 rε	PCD	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBGT 110302-AL	11.0	0.2	●										
110304-AL	10.0	0.4	●										
110308-AL	9.0	0.8	●										
160402-AL	16.1	0.2	●										
160404-AL	15.6	0.4	●										
160408-AL	14.6	0.8	●										
VCGT 110302-AL	11.0	0.2	●										
110304-AL	10.0	0.4	●										
110308-AL	9.0	0.8	●										
160402-AL	16.1	0.2	●										
160404-AL	15.6	0.4	●										
160408-AL	14.6	0.8	●										

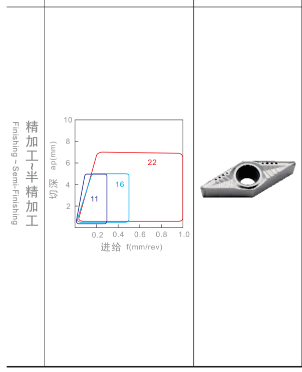
精加工 Finishing



有断屑槽 With Groove

规格型号 Specification	边长 L	刀尖 rε	PCD	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBGT 110302	11.0	0.2	●										
110304	10.0	0.4	●										
110308	9.0	0.8	●										
160402	16.1	0.2	●										
160404	15.6	0.4	●										
160408	14.6	0.8	●										
VCGT 110302	11.0	0.2	●										
110304	10.0	0.4	●										
110308	9.0	0.8	●										
160402	16.1	0.2	●										
160404	15.6	0.4	●										
160408	14.6	0.8	●										

精加工+半精加工 Finishing+Semi-Finishing



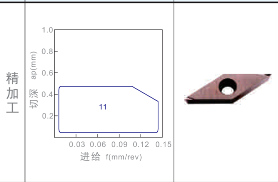
规格型号 Specification	边长 L	刀尖 rε	PCD	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBGT 110302-AL	11.0	0.2			●								
110304-AL	10.0	0.4			●								
110308-AL	9.0	0.8			●								
160402-AL	16.1	0.2			●								
160404-AL	15.6	0.4			●								
160408-AL	14.6	0.8			●								
VCGT 110302-AL	11.0	0.2			●								
110304-AL	10.0	0.4			●								
110308-AL	9.0	0.8			●								
160402-AL	16.1	0.2			●								
160404-AL	15.6	0.4			●								
160408-AL	14.6	0.8			●								
160412-AL	13.6	1.2			●								
220516-AL	18.0	1.6			●								
220525-AL	15.6	2.5			●								
220530-AL	14.3	3.0			●								

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✤ 不稳定切削 Unstable Cutting

	材料	Material	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✤	◐	✤	✤	◐	●		
M	不锈钢	Stainless Steel	◐	●					✤	◐	●		
K	铸铁	Iron	◐	●					✤			✤	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✤	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✤	◐	●		

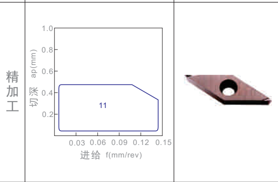
用途 Application | 切削参数 Cutting Parameter | 产品图片 Product Image

精加工 Finishing



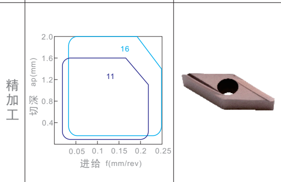
规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBGT 1103005R-F	11.0	0.05		●	●				●	●			
110301R-F	11.0	0.1		●	●				●	●			
110302R-F	11.0	0.2		●	●				●	●			
110304R-F	10.0	0.4		●	●				●	●			
VCGT 1103005R-F	11.0	0.05		●	●				●	●			
110301R-F	11.0	0.1		●	●				●	●			
110302R-F	11.0	0.2		●	●				●	●			
110304R-F	10.0	0.4		●	●				●	●			

精加工 Finishing



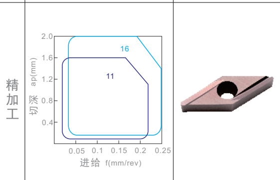
规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBGT 1103005L-F	11.0	0.05		●	●				●	●			
110301L-F	11.0	0.1		●	●				●	●			
110302L-F	11.0	0.2		●	●				●	●			
110304L-F	10.0	0.4		●	●				●	●			
VCGT 1103005L-F	11.0	0.05		●	●				●	●			
110301L-F	11.0	0.1		●	●				●	●			
110302L-F	11.0	0.2		●	●				●	●			
110304L-F	10.0	0.4		●	●				●	●			

精加工 Finishing



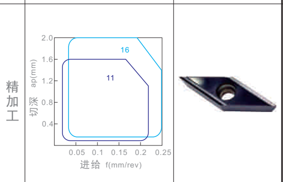
规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBGT 1103005R-Y	11.0	0.05		●	●				●	●			
110301R-Y	11.0	0.1		●	●				●	●			
110302R-Y	11.0	0.2		●	●				●	●			
110304R-Y	10.0	0.4		●	●				●	●			
160404R-Y	15.6	0.4		●	●				●	●			
160408R-Y	14.6	0.8		●	●				●	●			
VCGT 1103005R-Y	11.0	0.05		●	●				●	●			
110301R-Y	11.0	0.1		●	●				●	●			
110302R-Y	11.0	0.2		●	●				●	●			
110304R-Y	10.0	0.4		●	●				●	●			

精加工 Finishing



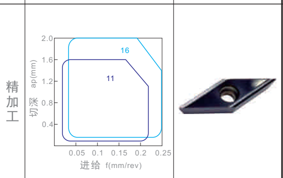
规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBGT 1103005L-Y	11.0	0.05		●	●				●	●			
110301L-Y	11.0	0.1		●	●				●	●			
110302L-Y	11.0	0.2		●	●				●	●			
110304L-Y	10.0	0.4		●	●				●	●			
160404L-Y	15.6	0.4		●	●				●	●			
160408L-Y	14.6	0.8		●	●				●	●			
VCGT 1103005L-Y	11.0	0.05		●	●				●	●			
110301L-Y	11.0	0.1		●	●				●	●			
110302L-Y	11.0	0.2		●	●				●	●			
110304L-Y	10.0	0.4		●	●				●	●			

精加工 Finishing



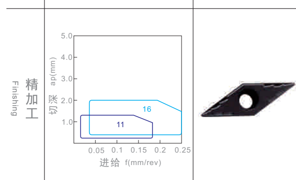
规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBGT 1103005R-H	11.0	0.05		●	●				●	●			
110301R-H	11.0	0.1		●	●				●	●			
110302R-H	11.0	0.2		●	●				●	●			
110304R-H	10.0	0.4		●	●				●	●			
160404R-H	15.6	0.4		●	●				●	●			
160408R-H	14.6	0.8		●	●				●	●			
VCGT 1103005R-H	11.0	0.05		●	●				●	●			
110301R-H	11.0	0.1		●	●				●	●			
110302R-H	11.0	0.2		●	●				●	●			
110304R-H	10.0	0.4		●	●				●	●			

精加工 Finishing



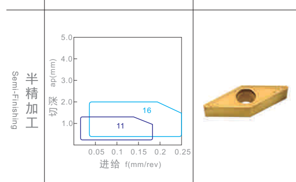
规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBGT 1103005L-H	11.0	0.05		●	●				●	●			
110301L-H	11.0	0.1		●	●				●	●			
110302L-H	11.0	0.2		●	●				●	●			
110304L-H	10.0	0.4		●	●				●	●			
160404L-H	15.6	0.4		●	●				●	●			
160408L-H	14.6	0.8		●	●				●	●			
VCGT 1103005L-H	11.0	0.05		●	●				●	●			
110301L-H	11.0	0.1		●	●				●	●			
110302L-H	11.0	0.2		●	●				●	●			
110304L-H	10.0	0.4		●	●				●	●			

精加工 Finishing



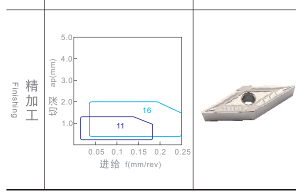
规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBMT 110302-TF	11.0	0.2				●	●		●	●			
110304-TF	10.0	0.4				●	●		●	●			
160404-TF	15.6	0.4				●	●		●	●			
160408-TF	14.6	0.8				●	●		●	●			
VCMT 110302-TF	11.0	0.2				●	●		●	●			
110304-TF	10.0	0.4				●	●		●	●			
160404-TF	15.6	0.4				●	●		●	●			
160408-TF	14.6	0.8				●	●		●	●			

半精加工 Semi-Finishing



规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBMT 110302-HQ	11.0	0.2	●			●	●		●	●			
110304-HQ	10.0	0.4	●			●	●		●	●			
110308-HQ	9.0	0.8	●			●	●		●	●			
160404-HQ	15.6	0.4	●			●	●		●	●			
160408-HQ	14.6	0.8	●			●	●		●	●			
VCMT 110302-HQ	11.0	0.2	●			●	●		●	●			
110304-HQ	10.0	0.4	●			●	●		●	●			
110308-HQ	9.0	0.8	●			●	●		●	●			
160404-HQ	15.6	0.4	●			●	●		●	●			
160408-HQ	14.6	0.8	●			●	●		●	●			

精加工 Finishing



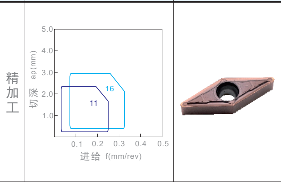
规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBMT 110302-MT	11.0	0.2	●			●	●		●	●			
110304-MT	10.0	0.4	●			●	●		●	●			
110308-MT	9.0	0.8	●			●	●		●	●			
160404-MT	15.6	0.4	●			●	●		●	●			
160408-MT	14.6	0.8	●			●	●		●	●			
VCMT 110302-MT	11.0	0.2	●			●	●		●	●			
110304-MT	10.0	0.4	●			●	●		●	●			
110308-MT	9.0	0.8	●			●	●		●	●			
160404-MT	15.6	0.4	●			●	●		●	●			
160408-MT	14.6	0.8	●			●	●		●	●			

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✤ 不稳定切削 Unstable Cutting

	材料	Material	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
P	钢	Steel	◐	●		✤	◐	✤	✤	◐	●		
M	不锈钢	Stainless Steel	◐	●					✤	◐	●		
K	铸铁	Iron	◐	●					✤			✤	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood			◐								
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy							✤	◐	●		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber							✤	◐	●		

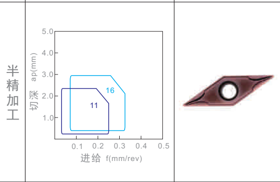
用途 Application | 切削参数 Cutting Parameter | 产品图片 Product Image

精加工 Finishing



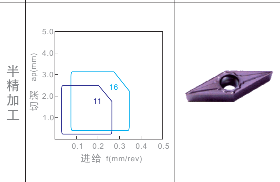
规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBMT 110302-MV	11.0	0.2	●			●	●		●	●			
110304-MV	10.0	0.4	●			●	●		●	●			
110308-MV	9.0	0.8	●			●	●		●	●			
160404-MV	15.6	0.4	●			●	●		●	●			
160408-MV	14.6	0.8	●			●	●		●	●			
VCMT 110302-MV	11.0	0.2	●			●	●		●	●			
110304-MV	10.0	0.4	●			●	●		●	●			
110308-MV	9.0	0.8	●			●	●		●	●			
160404-MV	15.6	0.4	●			●	●		●	●			
160408-MV	14.6	0.8	●			●	●		●	●			

半精加工 Semi-Finishing



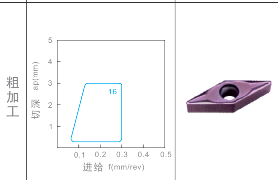
规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBMT 110304-TM	10.0	0.4				●	●		●	●		●	
110308-TM	9.0	0.8				●	●		●	●		●	
160404-TM	15.6	0.4				●	●		●	●		●	
160408-TM	14.6	0.8				●	●		●	●		●	
VCMT 110304-TM	10.0	0.4				●	●		●	●		●	
110308-TM	9.0	0.8				●	●		●	●		●	
160404-TM	15.6	0.4				●	●		●	●		●	
160408-TM	14.6	0.8				●	●		●	●		●	

半精加工 Semi-Finishing



规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBMT 110304-GM	10.0	0.4				●	●	●	●	●	●		
110308-GM	9.0	0.8				●	●	●	●	●	●		
160404-GM	15.6	0.4				●	●	●	●	●	●		
160408-GM	14.6	0.8				●	●	●	●	●	●		
VCMT 110304-GM	10.0	0.4				●	●	●	●	●	●		
110308-GM	9.0	0.8				●	●	●	●	●	●		
160404-GM	15.6	0.4				●	●	●	●	●	●		
160408-GM	14.6	0.8				●	●	●	●	●	●		

粗加工 Roughing



规格型号 Specification	边长 L	刀尖 rε	ZN60	ZN90	ZK01	ZC250	ZC251	ZC32S	ZP152	ZP153	ZP163	ZK50	ZK50S
VBMT 160404-TR	15.6	0.4				●	●		●			●	●
160408-TR	14.6	0.8				●	●		●			●	●
160412-TR	13.5	1.2				●	●		●			●	●
VCMT 160404-TR	15.6	0.4				●	●		●			●	●
160408-TR	14.6	0.8				●	●		●			●	●
160412-TR	13.5	1.2				●	●		●			●	●

TGF 三角形 多功能 切槽刀片

外圆车刀:B108-B109 (External Toolholder)
内孔车刀:B108 (Internal Toolholder)

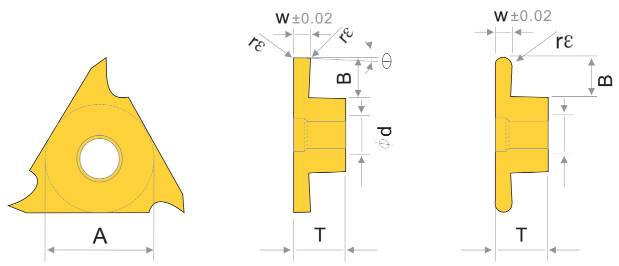


Fig.1　Fig.2 圆弧槽刀

TGF32R..　TGF32L..　TGF32R..R..　TGF32L..R..

切削线速度(Cutting Speed):m/min⁻¹　(mm)

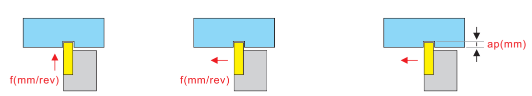
加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZK01 铜铝加工 Copper/Aluminum	ZM826 黄色通用 Yellow	ZP15 紫色通用 Purple	ZM856 不锈钢通用 Stainless Steel
P	低碳钢 Low-Carbon steel				150-600		60-250	70-250	100-250
P	高碳钢 High-Carbon steel				150-350		60-150	70-150	80-150
P	淬硬钢 HRC46-58 Hardened Steel			10-30			20-60	20-60	20-60
M	不锈钢 Stainless Steel				200-300		50-150	50-150	70-150
K	灰口铸铁 Gray Cast Iron		300-1500		100-300		130-210	150-200	150-300
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200				300-1200			
N	铝合金 HB50-70 Aluminum Alloy	300-1500				300-1500			
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800				300-800			
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000				300-1000			
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30				10-30			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600				400-600			
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200				100-200	20-50	20-50	20-60

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　○ 一般切削(第二推荐) General Cutting(Second recommend)　✖ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✖	◐	◐	◐
M	不锈钢	Stainless Steel				◐		◐	◐	✖	◐	◐	◐
K	铸铁	Iron		●		◐		◐		✖	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◐

用途 Application	规格型号 Specification	W±0.02	B	rε	A	T	ϕd	Fig	刀具安装角度 θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切槽加工 Grooving	TGF32R/L 030-005	0.30	0.05	0.05	9.525	3.18	4.5	Fig.1	2°					●	●	●			●	
	033-005	0.33												●	●	●			●	
	040-005	0.40	1.25											●	●	●			●	
	045-005	0.45												●	●	●			●	
	050-005	0.50												●	●	●			●	
	050L220	0.50	2.2											●	●	●			●	
	055-005	0.55	1.25	0.05	9.525	3.18	4.5	Fig.1	2°					●	●	●			●	
	060-005	0.60												●	●	●			●	
	065-010	0.65	2.05	0.1										●	●	●			●	
	070-010	0.70												●	●	●			●	
	075-010	0.75												●	●	●			●	
	080-010	0.80												●	●	●			●	
	085-010	0.85												●	●	●			●	
	090-010	0.90												●	●	●			●	
	095-010	0.95												●	●	●			●	
	100L330	1.00	3.3											●	●	●			●	
	100-010	1.00								●	●	●	●	●	●	●			●	
	105-010	1.05	2.2	0.1	9.525	3.18	4.5	Fig.1	2°					●	●	●			●	
	110-010	1.10												●	●	●			●	
	115-010	1.15												●	●	●			●	
	120-010	1.20												●	●	●			●	
	125-010	1.25												●	●	●			●	
	130-010	1.30												●	●	●			●	
	135-010	1.35												●	●	●			●	
	140-010	1.40												●	●	●			●	
	145-010	1.45												●	●	●			●	
	150-010	1.50								●	●	●	●	●	●	●			●	
	150L380	1.50	3.8											●	●	●			●	
	155-010	1.55	2.4	0.15	9.525	3.18	4.5	Fig.1	2°					●	●	●			●	
	160-015	1.60	2.4											●	●	●			●	
	165-015	1.65												●	●	●			●	
	170-015	1.70												●	●	●			●	
	175-010	1.75	2.4	0.1										●	●	●			●	
	175-015	1.75	2.4	0.15										●	●	●			●	
	180-015	1.80												●	●	●			●	
	185-015	1.85												●	●	●			●	
	190-015	1.90	2.7											●	●	●			●	
	195-015	1.95												●	●	●			●	
	200-010	2.00	2.7	0.1						●	●	●	●	●	●	●			●	
	200-015	2.00	2.7	0.15										●	●	●			●	
	200L400	2.00	4.0	0.1										●	●	●			●	
	210-015	2.10	2.7	0.15	9.525	3.18	4.5	Fig.1	2°					●	●	●			●	
	215-015	2.15												●	●	●			●	
	220-015	2.20												●	●	●			●	
	225-015	2.25												●	●	●			●	
	230-015	2.30												●	●	●			●	
	240-015	2.40												●	●	●			●	
	250-010	2.50	3.0	0.1						●	●	●	●	●	●	●			●	
	250-015	2.50	3.0	0.15										●	●	●			●	
	250L400	2.50	4.0	0.1										●	●	●			●	
	260-015	2.60	3.0	0.15	9.525	3.18	4.5	Fig.1	2°					●	●	●			●	
	265-015	2.65												●	●	●			●	
	270-015	2.70												●	●	●			●	
	280-015	2.80												●	●	●			●	
	290-015	2.90												●	●	●			●	
	300-020	3.00	3.4	0.2						●	●	●	●	●	●	●			●	
	320-020	3.20												●	●	●			●	

用途 Application	规格型号 Specification	W±0.02	B	rε	A	T	ϕd	Fig	刀具安装角度 θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切槽加工 Grooving	TGF32R/L 100-R050	1.00	2.2	0.50	9.525	3.18	4.5	Fig.2	2°	●	●	●		●	●	●			●	
	150-R075	1.50	2.2	0.75						●	●	●		●	●	●			●	
	200-R100	2.00	2.7	1.00						●	●	●		●	●	●			●	
	250-R125	2.50	3.0	1.25						●	●	●		●	●	●			●	
	300-R150	3.00	3.2	1.50						●	●	●		●	●	●			●	



代号说明: Code Description　T.1 切槽加工时的进给 Feed of Grooving　T.2 横向切槽加工时的进给 Feed of Transverse Grooving　T.3 横向切槽加工时的切深 Depth of Transverse Grooving

用途 Application	被加工材料 Processed Material	切削参数 Cutting Parameter TGF32R/L 033~055 T.1	T.2	T.3	TGF32R/L 055~095 T.1	T.2	T.3	TGF32R/L 100~145 T.1	T.2	T.3	TGF32R/L 150~250 T.1	T.2	T.3	TGF32R/L 255~320 T.1	T.2	T.3
P	钢 Steel	0.01~0.05	~	~	0.02~0.07	~	~	0.03~0.08	0.03~0.06	0.02~0.2	0.03~0.1	0.03~0.09	0.02~0.3	0.03~0.12	0.03~0.1	0.02~0.3
M	不锈钢 Stainless Steel	0.01~0.04	~	~	0.02~0.06	~	~	0.03~0.07	0.02~0.05	0.02~0.2	0.03~0.1	0.02~0.08	0.02~0.3	0.03~0.1	0.02~0.09	0.02~0.3
K	铸铁 Iron	0.01~0.04	~	~	0.02~0.06	~	~	0.03~0.08	0.02~0.05	0.02~0.2	0.03~0.1	0.02~0.08	0.02~0.3	0.03~0.12	0.02~0.09	0.02~0.3
N	铝/铜/镁/锌/塑料/木材 Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	0.01~0.05	~	~	0.02~0.07	~	~	0.03~0.08	0.03~0.06	0.02~0.2	0.03~0.12	0.03~0.12	0.02~0.3	0.03~0.15	0.03~0.15	0.02~0.3
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	0.01~0.02	~	~	0.01~0.02	~	~	0.01~0.03	~	~	0.01~0.05	0.01~0.03	0.02~0.1	0.01~0.05	0.01~0.03	0.02~0.1
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	0.01~0.02	~	~	0.01~0.02	~	~	0.01~0.03	~	~	0.01~0.05	0.01~0.03	0.02~0.1	0.01~0.05	0.01~0.03	0.02~0.1

GBA 三角形 多功能 切槽刀片

外圆车刀:B104-B105 (External Toolholder)
内孔车刀:B105 (Internal Toolholder)

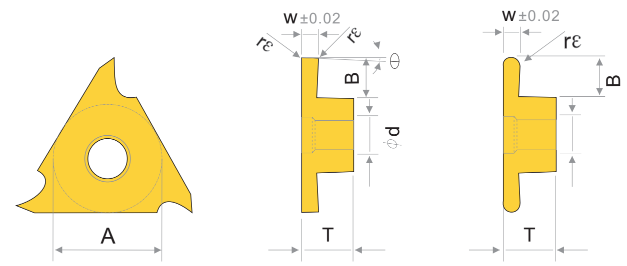


Fig.1　Fig.2 圆弧槽刀

GBA43R..　GBA43L..　GBA43R..R..　GBA43L..R..

切削线速度(Cutting Speed):m/min⁻¹　(mm)

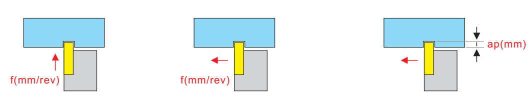
加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZK01 铜铝加工 Copper/Aluminum	ZM826 黄色通用 Yellow	ZP15 紫色通用 Purple	ZM856 不锈钢通用 Stainless Steel
P	低碳钢 Low-Carbon steel				150-600		60-250	70-250	100-250
P	高碳钢 High-Carbon steel				150-350		60-150	70-150	80-150
P	淬硬钢 HRC46-58 Hardened Steel			10-30			20-60	20-60	20-60
M	不锈钢 Stainless Steel				200-300		50-150	50-150	70-150
K	灰口铸铁 Gray Cast Iron		300-1500		100-300		130-210	150-200	150-300
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200				300-1200			
N	铝合金 HB50-70 Aluminum Alloy	300-1500				300-1500			
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800				300-800			
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000				300-1000			
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30				10-30			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600				400-600			
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200				100-200	20-50	20-50	20-60

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　○ 一般切削(第二推荐) General Cutting(Second recommend)　✖ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✖	◐	◐	◐
M	不锈钢	Stainless Steel				◐		◐	◐	✖	◐	◐	◐
K	铸铁	Iron		●		◐		◐		✖	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◐

用途 Application	规格型号 Specification	W±0.02	B	rε	A	T	ϕd	Fig	刀具安装角度 θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切槽加工 Grooving	GBA43R/L 100-010	1.00	2.0	0.1	12.7	4.76	5.5	Fig.1	2°	●	●	●	●	●	●	●			●	
	120-010	1.20												●	●	●			●	
	125-010	1.25												●	●	●			●	
	125-020	1.25	2.0	0.2										●	●	●			●	
	140-020	1.40												●	●	●			●	
	145-020	1.45												●	●	●			●	
	150-010	1.50	3.5	0.1										●	●	●			●	
	150-020	1.50	3.5	0.2						●	●	●	●	●	●	●			●	
	170-020	1.70	3.5	0.2	12.7	4.76	5.5	Fig.1	2°					●	●	●			●	
	175-020	1.75												●	●	●			●	
	180-020	1.80												●	●	●			●	
	185-020	1.85												●	●	●			●	
	190-020	1.90												●	●	●			●	
	195-020	1.95												●	●	●			●	
	200-010	2.00	3.5	0.1										●	●	●			●	
	200-020	2.00	3.5	0.2						●	●	●	●	●	●	●			●	
	220-020	2.20	3.5	0.2	12.7	4.76	5.5	Fig.1	2°					●	●	●			●	
	225-020	2.25												●	●	●			●	
	230-020	2.30												●	●	●			●	
	250-010	2.50	5.0	0.1										●	●	●			●	
	250-030	2.50	5.0	0.3										●	●	●			●	
	260-030	2.60	5.0							●	●	●	●	●	●	●			●	
	265-030	2.65	5.0	0.3	12.7	4.76	5.5	Fig.1	2°					●	●	●			●	
	270-030	2.70												●	●	●			●	
	280-030	2.80												●	●	●			●	
	290-030	2.90												●	●	●			●	
	300-010	3.00	5.0	0.1										●	●	●			●	
	300-030	3.00	5.0	0.3						●	●	●	●	●	●	●			●	
	310-030	3.10	5.0	0.3	12.7	4.76	5.5	Fig.1	2°					●	●	●			●	
	320-030	3.20												●	●	●			●	
	325-030	3.25												●	●	●			●	
	330-030	3.30												●	●	●			●	
	340-030	3.40												●	●	●			●	
	350-010	3.50	5.0	0.1										●	●	●			●	
	350-030	3.50	5.0	0.3						●	●	●	●	●	●	●			●	
	360-030	3.60	5.0	0.3	12.7	4.76	5.5	Fig.1	2°					●	●	●			●	
	370-030	3.70												●	●	●			●	
	380-030	3.80												●	●	●			●	
	390-030	3.90												●	●	●			●	
	400-010	4.00	5.0	0.1										●	●	●			●	
	400-040	4.00	5.0	0.4						●	●	●	●	●	●	●			●	
	410-040	4.10	5.0	0.4	12.7	4.76	5.5	Fig.1	2°					●	●	●			●	
	420-040	4.20												●	●	●			●	
	430-040	4.30												●	●	●			●	
	440-040	4.40												●	●	●			●	
	450-010	4.50	5.0	0.1										●	●	●			●	
	450-040	4.50	5.0	0.4						●	●	●	●	●	●	●			●	
	460-040	4.60	5.0	0.4	12.7	4.76	5.5	Fig.1	2°					●	●	●			●	
	470-040	4.70												●	●	●			●	
	480-040	4.80			12.7	5.00	5.5	Fig.1	2°					●	●	●			●	
	490-040	4.90												●	●	●			●	
	500-010	5.00	5.0	0.1										●	●	●			●	
	500-040	5.00	5.0	0.4						●	●	●	●	●	●	●			●	
	510-040	5.10	5.0	0.4	12.7	5.10	5.5	Fig.1	2°					●	●	●			●	

用途 Application	规格型号 Specification	W±0.02	B	rε	A	T	ϕd	Fig	刀具安装角度 θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切槽加工 Grooving	GBA43R/L 100-R050	1.00	2.0	0.50	12.7	4.76	5.5	Fig.2	2°	●	●	●		●	●	●			●	
	150-R075	1.50	3.5	0.75						●	●	●		●	●	●			●	
	200-R100	2.00	3.5	1.00						●	●	●		●	●	●			●	
	250-R125	2.50	4.0	1.25						●	●	●		●	●	●			●	
	300-R150	3.00	4.0	1.50						●	●	●		●	●	●			●	
	400-R200	4.00	5.0	2.00						●	●	●		●	●	●			●	



代号说明: Code Description　T.1 切槽加工时的进给 Feed of Grooving　T.2 横向切槽加工时的进给 Feed of Transverse Grooving　T.3 横向切槽加工时的切深 Depth of Transverse Grooving

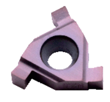
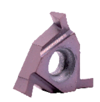
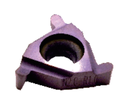
用途 Application	被加工材料 Processed Material	切削参数 Cutting Parameter GBA43R/L 100~150 T.1	T.2	T.3	GBA43R/L 150~200 T.1	T.2	T.3	GBA43R/L 210~300 T.1	T.2	T.3	GBA43R/L 310~400 T.1	T.2	T.3	GBA43R/L 410~510 T.1	T.2	T.3
P	钢 Steel	0.03~0.08	~	~	0.04~0.09	0.04~0.09	0.02~0.3	0.05~0.1	0.05~0.1	0.02~0.5	0.05~0.12	0.05~0.1	0.02~0.5	0.05~0.12	0.05~0.1	0.02~0.8
M	不锈钢 Stainless Steel	0.03~0.07	~	~	0.04~0.08	0.04~0.08	0.02~0.3	0.05~0.09	0.05~0.09	0.02~0.5	0.05~0.1	0.05~0.1	0.02~0.5	0.05~0.1	0.05~0.1	0.02~0.8
K	铸铁 Iron	0.03~0.08	~	~	0.04~0.08	0.04~0.08	0.02~0.3	0.05~0.1	0.05~0.1	0.02~0.5	0.05~0.1	0.05~0.1	0.02~0.5	0.05~0.1	0.05~0.1	0.02~0.8
N	铝/铜/镁/锌/塑料/木材 Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	0.05~0.12	~	~	0.05~0.15	0.05~0.15	0.02~0.5	0.05~0.15	0.05~0.15	0.02~0.8	0.08~0.15	0.08~0.15	0.02~0.8	0.08~0.15	0.08~0.15	0.02~0.8
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	0.01~0.03	~	~	0.02~0.05	~	~	0.03~0.07	0.01~0.04	0.01~0.1	0.03~0.08	0.03~0.08	0.01~0.1	0.03~0.08	0.03~0.08	0.01~0.1
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	0.01~0.03	~	~	0.02~0.05	~	~	0.03~0.07	0.01~0.04	0.01~0.1	0.03~0.08	0.03~0.08	0.01~0.1	0.03~0.08	0.03~0.08	0.01~0.1

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

T..

三角形 多功能 切槽刀片

外圆车刀:B69
(External Toolholder)
内孔车刀:B75-B77
(Internal Toolholder)

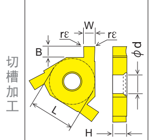
T..E..	T..N..	T..N..DM..	T..N..DM..R..
切槽加工 Grooving	切槽加工 Grooving	端面切槽 End Face Grooving	端面圆头切槽 End Face Round Grooving

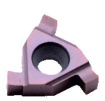
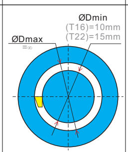
切削线速度(Cutting Speed):m/min^{-1} (mm)

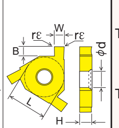
加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZK01 铜铝加工 Copper/Aluminum	ZM826 黄色通用 Yellow	ZP15 紫色通用 Purple	ZM856 不锈钢通用 Stainless Steel
P	低碳钢 Low-Carbon steel				150-600		60-250	70-250	100-250
P	高碳钢 High-Carbon steel				150-350		60-150	70-150	80-150
P	淬硬钢 HRC46-58 Hardened Steel			10-30			20-60	20-60	20-60
M	不锈钢 Stainless Steel				200-300		50-150	50-150	70-150
K	灰口铸铁 Gray Cast Iron		300-1500		100-300		130-210	150-200	150-300
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200				300-1200			
N	铝合金 HB50-70 Aluminum Alloy	300-1500				300-1500			
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800				300-800			
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000				300-1000			
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30				10-30			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600				400-600			
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200				100-200	20-50	20-50	20-60

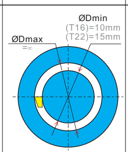
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✠ 不稳定切削 Unstable Cutting

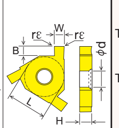
			PCD	CBN-K	CBN-S	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856
P	钢	Steel			●		◐	●	✠	◐	◐
M	不锈钢	Stainless Steel					◐	◐	✠	◐	◐
K	铸铁	Iron		●			◐		✠	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●			◐	◐	◐	◐	◐	◐
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●						✠		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●						✠		





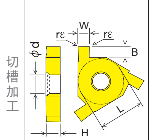


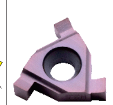
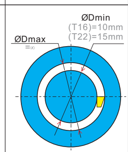


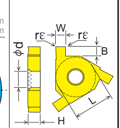
用途 Application	规格型号 Specification	W	B	rε	L	H	ϕd	PCD	CBN-K	CBN-S	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856
切槽加工 Grooving	T11N 050	0.50	1.0	0.06							•		•			•
	060	0.60	1.0	0.06							•		•			•
	080	0.80	1.2	0.06							•		•			•
	100	1.00	1.5	0.06							•		•			•
	110	1.10	1.5	0.10							•		•			•
	120	1.20	1.5	0.10							•		•			•
	125	1.25	1.5	0.10	6.35	3.18	3.0				•		•			•
	140	1.40	1.5	0.10							•		•			•
	150	1.50	1.5	0.10							•		•			•
	160	1.60	1.5	0.10							•		•			•
	170	1.70	1.5	0.10							•		•			•
	175	1.75	1.5	0.10							•		•			•
	180	1.80	1.5	0.10							•		•			•
	200	2.00	1.3	0.10							•		•			•
	T16N 033	0.33	1.6	0.06							•		•			•
	050	0.50	1.6	0.06							•		•			•
	060	0.60	1.6	0.06							•		•			•
	070	0.70	1.6	0.06							•		•			•
	075	0.75	1.6	0.06							•		•			•
	080	0.80	1.6	0.06							•		•			•
	090	0.90	1.6	0.06							•		•			•
	095	0.95	1.6	0.06							•		•			•
	100	1.00	1.8	0.10							•		•			•
	110	1.10	1.8	0.10							•		•			•
	115	1.15	1.8	0.10							•		•			•
	120	1.20	1.8	0.10	9.525	3.65	4.0				•		•			•
	125	1.25	1.8	0.10							•		•			•
	130	1.30	1.8	0.10							•		•			•
	140	1.40	1.8	0.10							•		•			•
	145	1.45	1.8	0.10							•		•			•
	150	1.50	1.8	0.10							•		•			•
	160	1.60	1.8	0.10							•		•			•
	170	1.70	1.8	0.10							•		•			•
	175	1.75	1.8	0.10							•		•			•
	180	1.80	1.8	0.10							•		•			•
	190	1.90	1.8	0.10							•		•			•
	200	2.00	1.8	0.10							•		•			•
	210	2.10	2.0	0.20							•		•			•
	215	2.15	2.0	0.20							•		•			•
	220	2.20	2.0	0.20							•		•			•
	225	2.25	2.0	0.20							•		•			•
	230	2.30	2.0	0.20							•		•			•
	240	2.40	2.0	0.20							•		•			•
	250	2.50	2.0	0.20							•		•			•
	260	2.60	2.0	0.20							•		•			•
	265	2.65	2.2	0.20							•		•			•
	270	2.70	2.0	0.20							•		•			•
	280	2.80	2.0	0.20							•		•			•
	290	2.90	2.0	0.20							•		•			•
	300	3.00	2.0	0.20							•		•			•
端面切槽加工 End Face Grooving	T16N 150DM10	1.50	1.8	0.1							•		•			•
	200DM10	2.00	2.2	0.1	9.525	3.65	4.0				•		•			•
	250DM10	2.50	2.2	0.1							•		•			•
	T22N 200DM15	2.00	3.0	0.1							•		•			•
	250DM15	2.50	3.0	0.1	12.7	4.76	5.0				•		•			•
	300DM15	3.00	3.0	0.1							•		•			•
端面切槽加工 End Face Grooving	T16N 150DM10R075	1.50	2.0	0.75	9.525	3.65	4.0				•		•			•
	200DM10R100	2.00	2.2	1.00							•		•			•
	T22N 200DM15R100	2.00	3.0	1.00							•		•			•
	250DM15R125	2.50	3.0	1.25	12.7	4.76	5.0				•		•			•
	300DM15R150	3.00	3.0	1.50							•		•			•

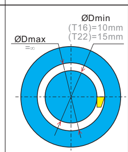
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✠ 不稳定切削 Unstable Cutting

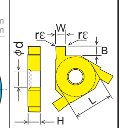
			PCD	CBN-K	CBN-S	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856
P	钢	Steel			●		◐	●	✠	◐	◐
M	不锈钢	Stainless Steel					◐	◐	✠	◐	◐
K	铸铁	Iron		●			◐		✠	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●			◐	◐	◐	◐	◐	◐
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●						✠		
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●						✠		









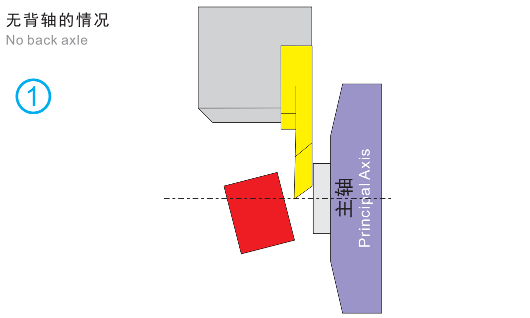
用途 Application	规格型号 Specification	W	B	rε	L	H	ϕd	PCD	CBN-K	CBN-S	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856
切槽加工 Grooving	T11E 050	0.50	1.0	0.06							•		•			•
	060	0.60	1.0	0.06							•		•			•
	080	0.80	1.2	0.06							•		•			•
	100	1.00	1.5	0.06							•		•			•
	110	1.10	1.5	0.10							•		•			•
	120	1.20	1.5	0.10							•		•			•
	125	1.25	1.5	0.10	6.35	3.18	3.0				•		•			•
	140	1.40	1.5	0.10							•		•			•
	150	1.50	1.5	0.10							•		•			•
	160	1.60	1.5	0.10							•		•			•
	170	1.70	1.5	0.10							•		•			•
	175	1.75	1.5	0.10							•		•			•
	180	1.80	1.5	0.10							•		•			•
	200	2.00	1.3	0.10							•		•			•
	T16E 033	0.33	1.6	0.06							•		•			•
	050	0.50	1.6	0.06							•		•			•
	060	0.60	1.6	0.06							•		•			•
	070	0.70	1.6	0.06							•		•			•
	075	0.75	1.6	0.06							•		•			•
	080	0.80	1.6	0.06							•		•			•
	090	0.90	1.6	0.06							•		•			•
	095	0.95	1.6	0.06							•		•			•
	100	1.00	1.8	0.10							•		•			•
	110	1.10	1.8	0.10							•		•			•
	115	1.15	1.8	0.10							•		•			•
	120	1.20	1.8	0.10	9.525	3.65	4.0				•		•			•
	125	1.25	1.8	0.10							•		•			•
	130	1.30	1.8	0.10							•		•			•
	140	1.40	1.8	0.10							•		•			•
	145	1.45	1.8	0.10							•		•			•
	150	1.50	1.8	0.10							•		•			•
	160	1.60	1.8	0.10							•		•			•
	170	1.70	1.8	0.10							•		•			•
	175	1.75	1.8	0.10							•		•			•
	180	1.80	1.8	0.10							•		•			•
	190	1.90	1.8	0.10							•		•			•
	200	2.00	1.8	0.10							•		•			•
	210	2.10	2.0	0.20							•		•			•
	215	2.15	2.0	0.20							•		•			•
	220	2.20	2.0	0.20							•		•			•
	225	2.25	2.0	0.20							•		•			•
	230	2.30	2.0	0.20							•		•			•
	240	2.40	2.0	0.20							•		•			•
	250	2.50	2.0	0.20							•		•			•
	260	2.60	2.0	0.20							•		•			•
	265	2.65	2.2	0.20							•		•			•
	270	2.70	2.0	0.20							•		•			•
	280	2.80	2.0	0.20							•		•			•
	290	2.90	2.0	0.20							•		•			•
	300	3.00	2.0	0.20							•		•			•
端面切槽加工 End Face Grooving	T16E 150DM10	1.50	1.8	0.1							•		•			•
	200DM10	2.00	2.2	0.1	9.525	3.65	4.0				•		•			•
	250DM10	2.50	2.2	0.1							•		•			•
	T22E 200DM15	2.00	3.0	0.1							•		•			•
	250DM15	2.50	3.0	0.1	12.7	4.76	5.0				•		•			•
	300DM15	3.00	3.0	0.1							•		•			•
端面切槽加工 End Face Grooving	T16E 150DM10R075	1.50	2.0	0.75	9.525	3.65	4.0				•		•			•
	200DM10R100	2.00	2.2	1.00							•		•			•
	T22E 200DM15R100	2.00	3.0	1.00							•		•			•
	250DM15R125	2.50	3.0	1.25	12.7	4.76	5.0				•		•			•
	300DM15R150	3.00	3.0	1.50							•		•			•

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

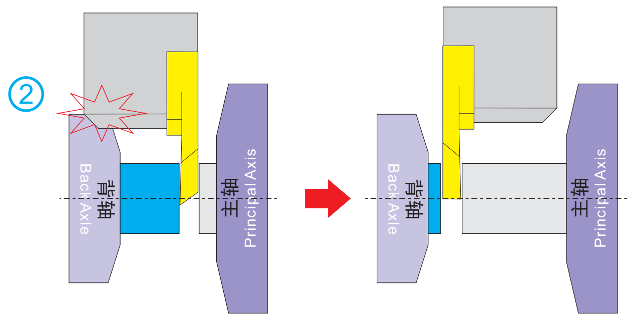
1 如何选用左/右手刀杆
How to select the R and L toolholder

无背轴的情况
No back axle



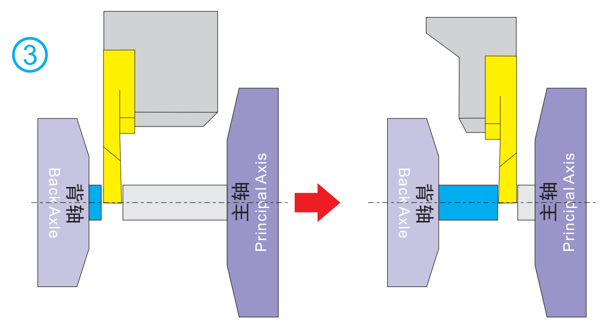
没有背轴的情况下推荐使用右手刀杆。
为减小残留的尾钉推荐使用刀尖带角度的切断刀。

Recommended to use the R Toolholder when there is no back axle.
In order to reduce the residual tail pin, it is recommended to use a cutting knife with an angle at the tip.



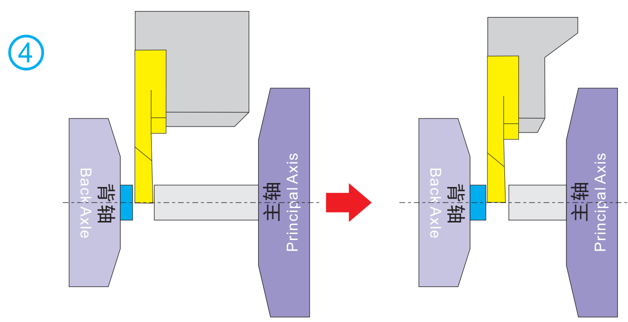
切断时若背轴和刀杆发生干涉，可使用左手刀杆。
不产生残留尾钉，推荐使用刀尖没有角度的刀片。

If the back axis interferes with the cutter rod during cutting, the L toolholder can be used.
There is no residual tail pin. It is recommended to use a blade with no angle at the tip.



工件直径小需要考虑刚性时，推荐使用R右手SUB型背轴刀杆。

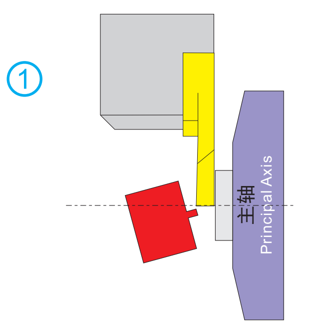
R-SUB type toolholder is recommended when rigidity is considered
for small workpiece diameter.



工件直径小且工件短需要考虑刚性时，推荐使用L右手SUB型背轴刀杆。

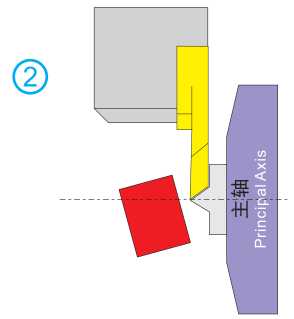
When the diameter of workpiece is small and the rigidity of workpiece is short,
L-SUB type toolholder is recommended.

2 如何选用平头/带角度刀尖
How to choose flat head / angle head



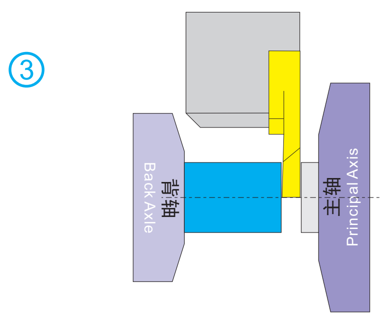
在没有背轴的情况下使用不带角度的平头切断刀，
工件会留下尾钉。

In the case of no back axis, using a flat head cutter
without angle, the workpiece will leave a tail pin.



在没有背轴的情况下使用带角度的切断刀片时，
工件不会留下尾钉。

In the case of no back axis, using angle head cutter,
the workpiece without tail pin.



在有背轴的情况下使用不带角度的平头切断刀，工件不会留下尾钉。
但是加工小工件考虑切削阻力变形时，请选用带角度刀尖。

In the case of a back shaft, use a flat head cutter without angle, and the workpiece will not leave a tail pin.However, when considering the deformation of cutting resistance in small workpiece processing, please select the tool tip with angle.

3 如何选用合适的宽度
How to choose the right width

切断刀宽度 Cutter Width = 工件直径 Workpiece Diameter ÷ 7

4 防止刀具异常损伤对策
Countermeasures for abnormal tool damage

① 推荐设定线速度不变的加工程序，转速一定的情况下，刀尖越靠近工件中心，线速度大幅度下降，容易造成粘刀，崩刀等异常损伤。
It is recommended to set the processing program with constant linear speed. When the rotation speed is fixed, the closer the tool tip is to the center of the workpiece, the linear speed will be greatly reduced, which is easy to cause abnormal damage such as knife sticking and knife collapsing.

② 考虑到切断时的冲击、工件中心部位线速度不足等情况，推荐降低切断前(1-2mm)的进给(降低到原来的50%)。
Considering the impact during cutting and insufficient linear speed at the center of workpiece, it is recommended to reduce the feed before cutting (1-2mm) (to 50% of the original).

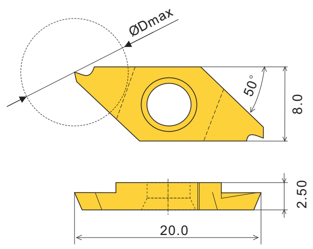
③ 尽量避免断续加工。
Try to avoid intermittent processing.

5 小零件切槽/切断加工切削参数推荐
Recommended cutting parameters for grooving / cutting of small parts

用途 Application	被加工材料 Processed Material	f(mm/rev) 切削参数 Cutting Parameter											
		CTP 刃宽W(mm)						CTPA 刃宽W(mm)					
		0.5	0.7	1.0	1.25	1.5	2.0	0.7	1.0	1.5	2.0	2.5	3.0
P	钢 Steel	0.01~0.02	0.01~0.03	0.01~0.04	0.01~0.04	0.01~0.04	0.01~0.04	0.01~0.04	0.01~0.04	0.02~0.07	0.02~0.07	0.02~0.1	0.02~0.15
M	不锈钢 Stainless Steel	0.005~0.015	0.01~0.02	0.01~0.02	0.01~0.02	0.01~0.02	0.01~0.02	0.01~0.02	0.01~0.02	0.01~0.04	0.01~0.04	0.01~0.1	0.01~0.1
K	铸铁 Iron	0.01~0.03	0.01~0.04	0.01~0.05	0.01~0.05	0.01~0.05	0.01~0.05	0.01~0.05	0.01~0.05	0.02~0.08	0.02~0.08	0.02~0.1	0.02~0.15
N	铝/铜/镁/锌/塑料/木材 Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	0.01~0.03	0.01~0.04	0.01~0.05	0.01~0.05	0.01~0.05	0.01~0.05	0.01~0.05	0.01~0.05	0.02~0.08	0.02~0.08	0.02~0.12	0.02~0.15
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	0.003~0.007	0.003~0.008	0.003~0.01	0.003~0.015	0.003~0.015	0.003~0.015	0.003~0.01	0.003~0.015	0.003~0.015	0.005~0.02	0.005~0.025	0.005~0.03
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	0.003~0.007	0.003~0.008	0.003~0.01	0.003~0.015	0.003~0.015	0.003~0.015	0.003~0.01	0.003~0.015	0.003~0.015	0.005~0.02	0.005~0.025	0.005~0.03

CTP 小零件加工 切断 切槽刀片

小零件专用车刀:AB20
(Small Parts Toolholder)



CTP
ØDmax=Ø5~13mm

切削线速度(Cutting Speed): m/min (mm)

被加工材料 材质特点		PCD 金刚石	CBN-K 铸铁专用	CBN-S 难切削材用	ZN60 光洁度好	ZK01 铜铝加工	ZM826 黄色通用	ZP15 紫色通用	ZM856 不锈钢通用
P	低碳钢				150-600		60-250	70-250	100-250
	高碳钢				150-350		60-150	70-150	80-150
	淬硬钢 HRC46-58			10-30			20-60	20-60	20-60
M	不锈钢				200-300		50-150	50-150	70-150
K	灰口铸铁		300-1500		100-300		130-210	150-200	150-300
	球墨铸铁/轧辊		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材	300-1200				300-1200			
	铝合金 HB50-70	300-1500				300-1500			
	淬硬铝合金 HB70-110	300-800				300-800			
	铜/青铜/黄铜	300-1000				300-1000			
S	硬质合金/粉末冶金	10-30				10-30			
	硅填充塑料硬质纤维	400-600				400-600			
H	钛/高温合金/碳纤维	100-200				100-200	20-50	20-50	20-60

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ○ 一般切削(第二推荐) General Cutting(Second recommend) ✲ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✲	◐	◐	◐
M	不锈钢	Stainless Steel				◐		◐	◐	◐	◐	◐	◐
K	铸铁	Iron		●		◐		◐		✲	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✲			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✲			◐

用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W±0.05	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切断加工 Cut-off	有排屑槽 With Groove	CTP 05FR 07FR 10FR 15FR 20FR	0.5 0.7 1.0 1.5 2.0	2.8 4.5 6.7 6.7 6.7	0.03 0.05 0.05 0.05 0.05	15° 16° 16° 16° 16°					●	●	●			●	
切断/切槽加工 Cut-off/Grooving	有排屑槽 With Groove	CTP 05FRN 10FRN 15FRN 20FRN	0.5 1.0 1.5 2.0	2.8 6.7 6.7 6.7	0.03 0.05 0.05 0.05	0°					●	●	●			●	
切断加工 Cut-off	有排屑槽 With Groove 用于安装了副夹头的机型 Applicable to models with auxiliary chuck installed	CTP 10FRK 15FRK 20FRK	1.0 1.5 2.0	6.7	0.05	16°					●	●	●			●	
切断加工 Cut-off	有排屑槽 With Groove	CTP 07FL 10FL 15FL 20FL	0.7 1.0 1.5 2.0	4.5 6.7 6.7 6.7	0.05	16°					●	●	●			●	
切断/切槽加工 Cut-off/Grooving	有排屑槽 With Groove	CTP 05FLN 10FLN 15FLN 20FLN	0.5 1.0 1.5 2.0	2.8 6.7 6.7 6.7	0.03 0.05 0.05 0.05	0°					●	●	●			●	
切断加工 Cut-off	有排屑槽 With Groove 用于安装了副夹头的机型 Applicable to models with auxiliary chuck installed	CTP 05FLK 10FLK 15FLK 20FLK 15FLKB	0.5 1.0 1.5 2.0 1.5	2.8 6.7 6.7 6.7 6.7	0.03 0.05 0.05 0.05 0.05	17° 16° 16° 16° 16°					●	●	●			●	

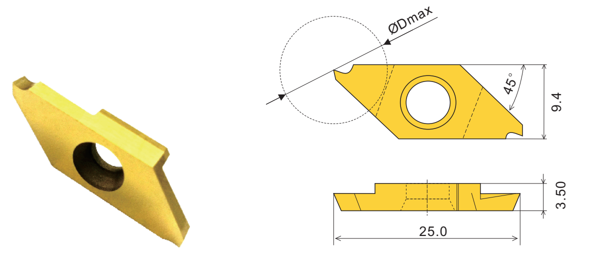
用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W±0.05	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切断加工 Cut-off	无排屑槽 Without Groove	CTP 10FRV 15FRV 20FRV	1.0 1.5 2.0	6.7	0.0	20°	●				●	●	●			●	
切断/切槽加工 Cut-off/Grooving	无排屑槽 Without Groove	CTP 15FRNV 20FRNV	1.5 2.0	6.7	0.0	0°	●				●	●	●			●	
切断加工 Cut-off	无排屑槽 Without Groove	CTP 10FLV 15FLV 20FLV	1.0 1.5 2.0	6.7	0.0	20°	●				●	●	●			●	
切断/切槽加工 Cut-off/Grooving	无排屑槽 Without Groove	CTP 15FLNV 20FLNV	1.5 2.0	6.7	0.0	0°	●				●	●	●			●	
切断加工 Cut-off	无排屑槽 Without Groove 用于安装了副夹头的机型 Applicable to models with auxiliary chuck installed	CTP 15FLKV	1.5	6.7	0.0	20°	●				●	●	●			●	

☆θ为刀柄安装时取值
☆θ Installation Angle For The Toolholder

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

CTPA 小零件加工 切断 切槽刀片

小零件专用车刀:AB20
(Small Parts Toolholder)



ØDmax=Ø9~18mm

切削线速度(Cutting Speed):m/min⁻¹ (mm)

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZK01 铜铝加工 Copper/Aluminum	ZM826 黄色通用 Yellow	ZP15 紫色通用 Purple	ZM856 不锈钢通用 Stainless Steel
P	低碳钢 Low-Carbon steel				150-600		60-250	70-250	100-250
P	高碳钢 High-Carbon steel				150-350		60-150	70-150	80-150
P	淬硬钢 HRC46-58 Hardened Steel			10-30			20-60	20-60	20-60
M	不锈钢 Stainless Steel				200-300		50-150	50-150	70-150
K	灰口铸铁 Gray Cast Iron		300-1500		100-300		130-210	150-200	150-300
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200				300-1200			
N	铝合金 HB50-70 Aluminum Alloy	300-1500				300-1500			
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800				300-800			
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000				300-1000			
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30				10-30			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600				400-600			
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200				100-200	20-50	20-50	20-60

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ○ 一般切削(第二推荐) General Cutting(Second recommend) ✖ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✖	◐	◐	◐
M	不锈钢	Stainless Steel				○		○	○	✖	○	○	○
K	铸铁	Iron		●		◐		◐		✖	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◐

用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W±0.05	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切断加工 Cut-off	有排屑槽 With Groove	CTPA 07FR	0.7	4.5	0.05	16°					●	●	●			●	
		10FR	1.0	6.7							●	●	●			●	
		15FR	1.5	9.2							●	●	●			●	
		20FR	2.0	9.2							●	●	●			●	
		25FR	2.5	9.2							●	●	●			●	
		30FR	3.0	9.2							●	●	●			●	
切断/切槽加工 Cut-off/Grooving	有排屑槽 With Groove	CTPA 07FRN	0.7	4.5	0.05	0°					●	●	●			●	
		10FRN	1.0	6.7							●	●	●			●	
		15FRN	1.5	9.2							●	●	●			●	
		20FRN	2.0	9.2							●	●	●			●	
		25FRN	2.5	9.2							●	●	●			●	
		30FRN	3.0	9.2							●	●	●			●	
切断加工 Cut-off	有排屑槽 With Groove; 用于安装了副夹头的机型 Applicable to models with auxiliary chuck installed	CTPA 07FRK	0.7	4.5	0.05	16°					●	●	●			●	
		10FRK	1.0	6.7							●	●	●			●	
		15FRK	1.5	9.2							●	●	●			●	
		20FRK	2.0	9.2							●	●	●			●	
切断加工 Cut-off	有排屑槽 With Groove	CTPA 07FL	0.7	4.5	0.05	16°					●	●	●			●	
		10FL	1.0	6.7							●	●	●			●	
		15FL	1.5	9.2							●	●	●			●	
		20FL	2.0	9.2							●	●	●			●	
		25FL	2.5	9.2							●	●	●			●	
		30FL	3.0	9.2							●	●	●			●	
切断/切槽加工 Cut-off/Grooving	有排屑槽 With Groove	CTPA 07FLN	0.7	4.5	0.05	0°					●	●	●			●	
		10FLN	1.0	6.7							●	●	●			●	
		15FLN	1.5	9.2							●	●	●			●	
		20FLN	2.0	9.2							●	●	●			●	
		25FLN	2.5	9.2							●	●	●			●	
		30FLN	3.0	9.2							●	●	●			●	
切断加工 Cut-off	有排屑槽 With Groove; 用于安装了副夹头的机型 Applicable to models with auxiliary chuck installed	CTPA 07FLK	0.7	4.5	0.05	16°					●	●	●			●	
		10FLK	1.0	6.7							●	●	●			●	
		15FLK	1.5	9.2							●	●	●			●	
		20FLK	2.0	9.2							●	●	●			●	

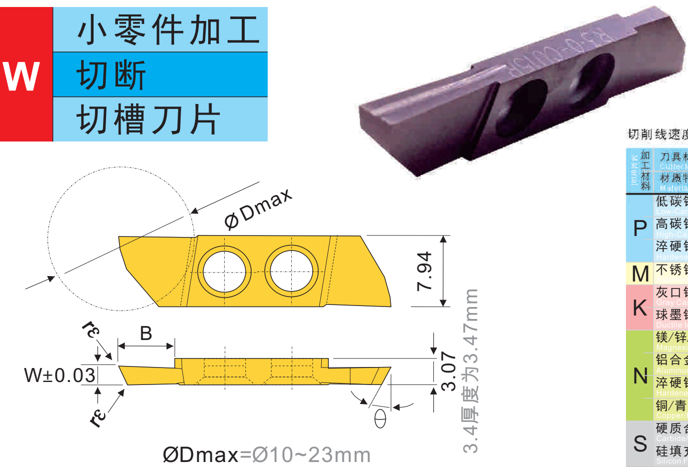
用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W±0.05	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切断加工 Cut-off	无排屑槽 Without Groove	CTPA 10FRV	1.0	6.7	0.0	20°	●				●	●	●			●	
		15FRV	1.5	9.5			●				●	●	●			●	
		20FRV	2.0	9.5			●				●	●	●			●	
切断/切槽加工 Cut-off/Grooving	无排屑槽 Without Groove	CTPA 15FRNV	1.5	9.5	0.0	0°	●				●	●	●			●	
		20FRNV	2.0				●				●	●	●			●	
切断加工 Cut-off	无排屑槽 Without Groove	CTPA 10FLV	1.0	6.7	0.0	20°	●				●	●	●			●	
		15FLV	1.5	9.5			●				●	●	●			●	
		20FLV	2.0	9.5			●				●	●	●			●	
切断/切槽加工 Cut-off/Grooving	无排屑槽 Without Groove	CTPA 15FLNV	1.5	9.5	0.0	0°	●				●	●	●			●	
		20FLNV	2.0				●				●	●	●			●	
切断加工 Cut-off	无排屑槽 Without Groove; 用于安装了副夹头的机型 Applicable to models with auxiliary chuck installed	CTPA 15FLKV	1.5	9.5	0.0	20°	●				●	●	●			●	

外圆刀柄：AB10

☆θ为刀柄安装时取值
☆θ Installation Angle For The Toolholder

CTPW 小零件加工 切断 切槽刀片

小零件专用车刀:AB21
(Small Parts Toolholder)



ØDmax=Ø10~23mm

切削线速度(Cutting Speed):m/min⁻¹ (mm)

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZK01 铜铝加工 Copper/Aluminum	ZM826 黄色通用 Yellow	ZP15 紫色通用 Purple	ZM856 不锈钢通用 Stainless Steel
P	低碳钢 Low-Carbon steel				150-600		60-250	70-250	100-250
P	高碳钢 High-Carbon steel				150-350		60-150	70-150	80-150
P	淬硬钢 HRC46-58 Hardened Steel			10-30			20-60	20-60	20-60
M	不锈钢 Stainless Steel				200-300		50-150	50-150	70-150
K	灰口铸铁 Gray Cast Iron		300-1500		100-300		130-210	150-200	150-300
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200				300-1200			
N	铝合金 HB50-70 Aluminum Alloy	300-1500				300-1500			
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800				300-800			
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000				300-1000			
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30				10-30			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600				400-600			
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200				100-200	20-50	20-50	20-60

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ○ 一般切削(第二推荐) General Cutting(Second recommend) ✖ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✖	◐	◐	◐
M	不锈钢	Stainless Steel				○		○	○	✖	○	○	○
K	铸铁	Iron		●		◐		◐		✖	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◐

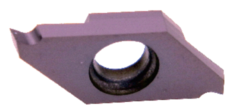
用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W±0.05	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切断加工 Cut-off	有排屑槽 With Groove	CTPW10FR	1.0	5.0	0.06	15°					●	●	●			●	
		15FR	1.5	8.5	0.06						●	●	●			●	
		20FR	2.0	11.5	0.1						●	●	●			●	
		25FR	2.5	11.5	0.1						●	●	●			●	
		30FR	3.0	11.5	0.2						●	●	●			●	
		34FR	3.4	11.5	0.2						●	●	●			●	
切断/切槽加工 Cut-off/Grooving	有排屑槽 With Groove	CTPW10FRN	1.0	5.0	0.06	0°					●	●	●			●	
		15FRN	1.5	8.5	0.06						●	●	●			●	
		20FRN	2.0	11.5	0.1						●	●	●			●	
		25FRN	2.5	11.5	0.1						●	●	●			●	
		30FRN	3.0	11.5	0.2						●	●	●			●	
		34FRN	3.4	11.5	0.2						●	●	●			●	
切断加工 Cut-off	有排屑槽 With Groove	CTPW10FL	1.0	5.0	0.06	15°					●	●	●			●	
		15FL	1.5	8.5	0.06						●	●	●			●	
		20FL	2.0	11.5	0.1						●	●	●			●	
		25FL	2.5	11.5	0.1						●	●	●			●	
		30FL	3.0	11.5	0.2						●	●	●			●	
		34FL	3.4	11.5	0.2						●	●	●			●	
切断/切槽加工 Cut-off/Grooving	有排屑槽 With Groove	CTPW10FLN	1.0	5.0	0.06	0°					●	●	●			●	
		15FLN	1.5	8.5	0.06						●	●	●			●	
		20FLN	2.0	11.5	0.1						●	●	●			●	
		25FLN	2.5	11.5	0.1						●	●	●			●	
		30FLN	3.0	11.5	0.2						●	●	●			●	
		34FLN	3.4	11.5	0.2						●	●	●			●	

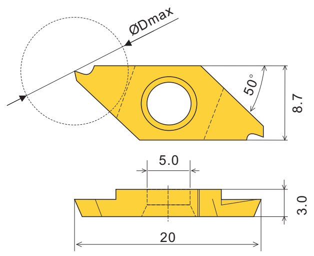
用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W±0.05	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切断加工 Cut-off	有排屑槽 With Groove	CTPW10FRU	1.0	5.0	0.06	15°					●	●	●			●	
		15FRU	1.5	8.5	0.06						●	●	●			●	
		20FRU	2.0	11.5	0.1						●	●	●			●	
		25FRU	2.5	11.5	0.1						●	●	●			●	
		30FRU	3.0	11.5	0.2						●	●	●			●	
		34FRU	3.4	11.5	0.2						●	●	●			●	
切断/切槽加工 Cut-off/Grooving	无排屑槽 Without Groove	CTPW10FRNV	1.0	5.0	0.06	0°					●	●	●			●	
		15FRNV	1.5	8.5	0.06						●	●	●			●	
		20FRNV	2.0	11.5	0.1						●	●	●			●	
		25FRNV	2.5	11.5	0.1						●	●	●			●	
		30FRNV	3.0	11.5	0.2						●	●	●			●	
		34FRNV	3.4	11.5	0.2						●	●	●			●	
切断加工 Cut-off	有排屑槽 With Groove	CTPW10FLU	1.0	5.0	0.06	15°					●	●	●			●	
		15FLU	1.5	8.5	0.06						●	●	●			●	
		20FLU	2.0	11.5	0.1						●	●	●			●	
		25FLU	2.5	11.5	0.1						●	●	●			●	
		30FLU	3.0	11.5	0.2						●	●	●			●	
		34FLU	3.4	11.5	0.2						●	●	●			●	
切断/切槽加工 Cut-off/Grooving	无排屑槽 Without Groove	CTPW10FLNV	1.0	5.0	0.06	0°					●	●	●			●	
		15FLNV	1.5	8.5	0.06						●	●	●			●	
		20FLNV	2.0	11.5	0.1						●	●	●			●	
		25FLNV	2.5	11.5	0.1						●	●	●			●	
		30FLNV	3.0	11.5	0.2						●	●	●			●	
		34FLNV	3.4	11.5	0.2						●	●	●			●	
端面切槽加工 End Face Grooving	ØDmax =∞; ØDmin =10mm; 有排屑槽 With Groove	CTPW20FLN-D	2.0	9.0	0.06	0°					●	●	●			●	
		25FLN-D	2.5	11.5	0.10						●	●	●			●	
		30FLN-D	3.0	11.5	0.15						●	●	●			●	
		34FLN-D	3.4	11.5	0.15						●	●	●			●	

☆θ为刀柄安装时取值
☆θ Installation Angle For The Toolholder

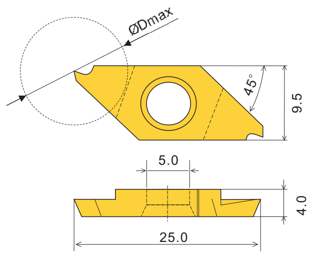
数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

TKF 小零件加工 切断 切槽刀片





TKF12..
ØDmax=Ø5~12mm



TKF16..
ØDmax=Ø5~16mm

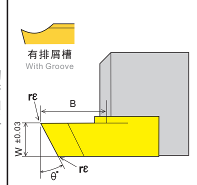
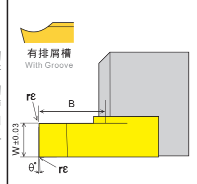
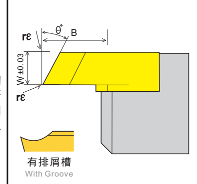
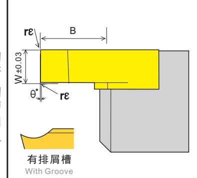
小零件专用车刀:AB05/AB25
(Small Parts Toolholder)

切削线速度(Cutting Speed): m/min⁻¹ (mm)

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZK01 铜铝加工 Copper/Aluminum	ZM826 黄色通用 Yellow	ZP15 紫色通用 Purple	ZM856 不锈钢通用 Stainless Steel
P	低碳钢 Low-Carbon steel				150-600		60-250	70-250	100-250
P	高碳钢 High-Carbon steel				150-350		60-150	70-150	80-150
P	淬硬钢 HRC46-58 Hardened Steel			10-30			20-60	20-60	20-60
M	不锈钢 Stainless Steel				200-300		50-150	50-150	70-150
K	灰口铸铁 Gray Cast Iron		300-1500		100-300		130-210	150-200	150-300
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200				300-1200			
N	铝合金 HB50-70 Aluminum Alloy	300-1500				300-1500			
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800				300-800			
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000				300-1000			
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30				10-30			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600				400-600			
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200				100-200	20-50	20-50	20-60

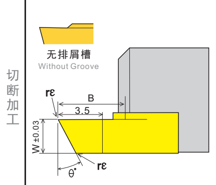
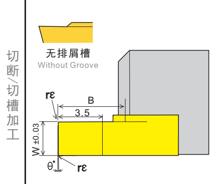
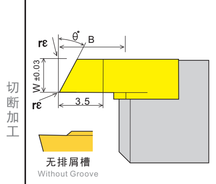
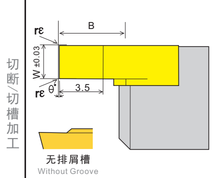
切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　○ 一般切削(第二推荐) General Cutting(Second recommend)　✜ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✜	◐	◐	◐
M	不锈钢	Stainless Steel				◐		◐	◐	✜	◐	◐	◐
K	铸铁	Iron		●		◐		◐		✜	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✜			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✜			◐

用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W±0.05	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切断加工 Cut-off	 有排屑槽 With Groove	TKF12R 050-S16R	0.5	2.8	0.03	16°					●	●	●			●	
		070-S16R	0.7	4.5							●	●	●			●	
		100-S16R	1.0	6.5							●	●	●			●	
		125-S16R	1.25	6.5							●	●	●			●	
		150-S16R	1.5	6.5							●	●	●			●	
		200-S16R	2.0	6.5							●	●	●			●	
		TKF16R 100-S16R	1.0	8.5	0.05	16°					●	●	●			●	
		125-S16R	1.25								●	●	●			●	
		150-S16R	1.5								●	●	●			●	
		200-S16R	2.0								●	●	●			●	
		250-S16R	2.5								●	●	●			●	
		300-S16R	3.0								●	●	●			●	
切断/切槽加工 Cut-off/Grooving	 有排屑槽 With Groove	TKF12R 050-S	0.5	2.8	0.03	0°					●	●	●			●	
		070-S	0.7	4.5							●	●	●			●	
		100-S	1.0	6.5							●	●	●			●	
		125-S	1.25	6.5							●	●	●			●	
		150-S	1.5	6.5							●	●	●			●	
		200-S	2.0	6.5							●	●	●			●	
		TKF16R 100-S	1.0	8.5	0.05	0°					●	●	●			●	
		125-S	1.25								●	●	●			●	
		150-S	1.5								●	●	●			●	
		200-S	2.0								●	●	●			●	
		250-S	2.5								●	●	●			●	
		300-S	3.0								●	●	●			●	
切断加工 Cut-off	 有排屑槽 With Groove	TKF12L 050-S16R	0.5	2.8	0.03	16°					●	●	●			●	
		070-S16R	0.7	4.5							●	●	●			●	
		100-S16R	1.0	6.5							●	●	●			●	
		125-S16R	1.25	6.5							●	●	●			●	
		150-S16R	1.5	6.5							●	●	●			●	
		200-S16R	2.0	6.5							●	●	●			●	
		TKF16L 100-S16R	1.0	8.5	0.05	16°					●	●	●			●	
		125-S16R	1.25								●	●	●			●	
		150-S16R	1.5								●	●	●			●	
		200-S16R	2.0								●	●	●			●	
		250-S16R	2.5								●	●	●			●	
		300-S16R	3.0								●	●	●			●	
切断/切槽加工 Cut-off/Grooving	 有排屑槽 With Groove	TKF12L 050-S	0.5	2.8	0.03	0°					●	●	●			●	
		070-S	0.7	4.5							●	●	●			●	
		100-S	1.0	6.5							●	●	●			●	
		125-S	1.25	6.5							●	●	●			●	
		150-S	1.5	6.5							●	●	●			●	
		200-S	2.0	6.5							●	●	●			●	
		TKF16L 100-S	1.0	8.5	0.05	0°					●	●	●			●	
		125-S	1.25								●	●	●			●	
		150-S	1.5								●	●	●			●	
		200-S	2.0								●	●	●			●	
		250-S	2.5								●	●	●			●	
		300-S	3.0								●	●	●			●	

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　○ 一般切削(第二推荐) General Cutting(Second recommend)　✜ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✜	◐	◐	◐
M	不锈钢	Stainless Steel				◐		◐	◐	✜	◐	◐	◐
K	铸铁	Iron		●		◐		◐		✜	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✜			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✜			◐

用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W±0.05	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
切断加工 Cut-off	 无排屑槽 Without Groove	TKF12R 050N-S16R	0.5	2.8	0.03	20°					●	●	●			●	
		070N-S16R	0.7	4.5							●	●	●			●	
		100N-S16R	1.0	6.5							●	●	●			●	
		125N-S16R	1.25	6.5							●	●	●			●	
		150N-S16R	1.5	6.5							●	●	●			●	
		200N-S16R	2.0	6.5							●	●	●			●	
		TKF16R 100N-S16R	1.0	8.5	0.05	20°					●	●	●			●	
		125N-S16R	1.25								●	●	●			●	
		150N-S16R	1.5								●	●	●			●	
		200N-S16R	2.0								●	●	●			●	
		250N-S16R	2.5								●	●	●			●	
		300N-S16R	3.0								●	●	●			●	
切断/切槽加工 Cut-off/Grooving	 无排屑槽 Without Groove	TKF12R 050N-S	0.5	2.8	0.03	0°					●	●	●			●	
		070N-S	0.7	4.5							●	●	●			●	
		100N-S	1.0	6.5							●	●	●			●	
		125N-S	1.25	6.5							●	●	●			●	
		150N-S	1.5	6.5							●	●	●			●	
		200N-S	2.0	6.5							●	●	●			●	
		TKF16R 100N-S	1.0	8.5	0.05	0°					●	●	●			●	
		125N-S	1.25								●	●	●			●	
		150N-S	1.5								●	●	●			●	
		200N-S	2.0								●	●	●			●	
		250N-S	2.5								●	●	●			●	
		300N-S	3.0								●	●	●			●	
切断加工 Cut-off	 无排屑槽 Without Groove	TKF12L 050N-S16R	0.5	2.8	0.03	20°					●	●	●			●	
		070N-S16R	0.7	4.5							●	●	●			●	
		100N-S16R	1.0	6.5							●	●	●			●	
		125N-S16R	1.25	6.5							●	●	●			●	
		150N-S16R	1.5	6.5							●	●	●			●	
		200N-S16R	2.0	6.5							●	●	●			●	
		TKF16L 100N-S16R	1.0	8.5	0.05	20°					●	●	●			●	
		125N-S16R	1.25								●	●	●			●	
		150N-S16R	1.5								●	●	●			●	
		200N-S16R	2.0								●	●	●			●	
		250N-S16R	2.5								●	●	●			●	
		300N-S16R	3.0								●	●	●			●	
切断/切槽加工 Cut-off/Grooving	 无排屑槽 Without Groove	TKF12L 050N-S	0.5	2.8	0.03	0°					●	●	●			●	
		070N-S	0.7	4.5							●	●	●			●	
		100N-S	1.0	6.5							●	●	●			●	
		125N-S	1.25	6.5							●	●	●			●	
		150N-S	1.5	6.5							●	●	●			●	
		200N-S	2.0	6.5							●	●	●			●	
		TKF16L 100N-S	1.0	8.5	0.05	0°					●	●	●			●	
		125N-S	1.25								●	●	●			●	
		150N-S	1.5								●	●	●			●	
		200N-S	2.0								●	●	●			●	
		250N-S	2.5								●	●	●			●	
		300N-S	3.0								●	●	●			●	

☆θ为刀柄安装时取值
☆θ Installation Angle For The Toolholder

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

MG 切断加工 内孔切槽 端面切槽

外圆车刀 (External Toolholder): B88-B90
内孔车刀 (Internal Toolholder): B89
端面槽车刀 (End Face Toolholder): B118/B125-B130

切削线速度 (Cutting Speed): m/min-1 (mm)

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel			10-30							20-60	20-60	20-80		
M	不锈钢 Stainless Steel				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy	300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30					10-30						20-50		
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200					100-200				20-50	20-60	30-80		

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
P	钢	Steel			●	●		✖	◐	✖	◐
M	不锈钢	Stainless Steel				●				✖	◐
K	铸铁	Iron		●		●				✖	
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐				
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖	◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖	◐

用途 Application	尺寸标示 Dimensioning	产品图片 Product Image	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
端面切槽加工 End Face Grooving		刀柄 (Toolholder) B119-B120	FGD 300R-03	3.0	0.3	15.0	2.0	4.0	-						●			
			400R-04	4.0	0.4	15.0	3.0	4.5	-						●			
			500R-04	5.0	0.4	15.0	4.0	5.0	-						●			
端面切槽加工 End Face Grooving		刀柄 (Toolholder) B119-B120	FGM 300R-03	3.0	0.3	15.0	2.0	4.0	-					●				
			400R-04	4.0	0.4	15.0	3.0	4.5	-									
			500R-04	5.0	0.4	15.0	4.0	5.0	-									
端面切槽加工 End Face Grooving		刀柄 (Toolholder) B119-B120	FMM 300R-03	3.0	0.3	15.0	2.0	3.91	-						●			
			400R-04	4.0	0.4	15.0	3.0	3.96	-						●			
			500R-04	5.0	0.4	15.0	4.0	4.42	-						●			
端面切槽加工 End Face Grooving	12°	刀柄 (Toolholder) B121-B122	MFMN 300	3.0	0.2	18.0	2.0	3.0	-							●		
切断/切槽加工 Cut-off / Grooving	7°		MGMN 150-G	1.5	0.15	16.0	1.2	3.5	-				●	●	●	●	●	●
			200-G	2.0	0.2	16.0	1.6	3.5	-				●	●	●	●	●	●
			250-G	2.5	0.2	18.5	2.0	3.85	-				●	●	●	●	●	●
			300-G	3.0	0.4	21.0	2.35	4.8	-									
			400-G	4.0	0.4	21.0	3.3	4.8	-									
			500-G	5.0	0.8	26.0	4.1	5.8	-									
			600-G	6.0	0.8	26.0	5.0	5.8	-									
切断/切槽加工 Cut-off / Grooving	7°		MGMN 200-M	2.0	0.2	16.0	1.2	3.5	-									
			250-M	2.5	0.2	18.5	2.0	3.85	-				●	●	●	●	●	●
			300-02-M	3.0	0.2	21.0	2.35	4.8	-				●	●	●	●	●	●
			300-M	3.0	0.4	21.0	2.35	4.8	-				●	●	●	●	●	●
			350-03-M	3.5	0.3	21.0	2.9	4.8	-									
			400-02-M	4.0	0.2	21.0	3.3	4.8	-				●	●	●	●	●	●
			400-M	4.0	0.4	21.0	3.3	4.8	-				●	●	●	●	●	●
			500-04-M	5.0	0.4	26.0	4.1	5.8	-				●	●	●	●	●	●
			500-M	5.0	0.8	26.0	4.1	5.8	-				●	●	●	●	●	●
			600-M	6.0	0.8	26.0	5.0	5.8	-				●	●	●	●	●	●
			800-M	8.0	0.8	31.0	6.0	6.5	-					●	●	●		

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

用途 Application	尺寸标示 Dimensioning	产品图片 Product Image	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切断/切槽加工 Cut-off / Grooving	7°	ZP151 ZC32S	MGMN 200-T	2.0	0.2	16.0	1.6	3.5	-						●	●	●	●
			250-T	2.5	0.2	18.5	2.0	3.85	-						●	●	●	●
			300-T	3.0	0.4	21.0	2.35	4.8	-						●	●	●	●
			400-T	4.0	0.4	21.0	3.3	4.8	-						●	●	●	●
			500-T	5.0	0.8	26.0	4.1	5.8	-						●	●	●	●
			600-T	6.0	0.8	26.0	5.0	5.8	-						●	●	●	●
切断/切槽加工 Cut-off / Grooving	7°		MGMN 200-H	2.0	0.2	16	1.6	3.5	-						●	●	●	●
			300-H	3.0	0.2	21	2.35	4.8	-						●	●	●	●
			400-H	4.0	0.2	21	3.3	4.8	-						●	●	●	●
			500-H	5.0	0.4	26	4.1	5.8	-						●	●	●	●
切断加工 Cut-off Processing	7°		MGMR 300-6D-PS	3.0	0.2	21.0	2.35	4.8	6.0									
			300-8D-PS	3.0	0.2	21.0	2.35	4.8	8.0									
			300-15D-PS	3.0	0.2	21.0	2.35	4.8	15.0									
			400-4D-PS	4.0	0.3	21.0	3.3	4.8	4.0									
			500-4D-PS	5.0	0.3	26.0	4.1	5.8	4.0									
切断加工 Cut-off Processing	7°		MGML 300-6D-PS	3.0	0.2	21.0	2.35	4.8	6.0									
			300-8D-PS	3.0	0.2	21.0	2.35	4.8	8.0									
			300-15D-PS	3.0	0.2	21.0	2.35	4.8	15.0									
			400-4D-PS	4.0	0.3	21.0	3.3	4.8	4.0									
			500-4D-PS	5.0	0.3	26.0	4.1	5.8	4.0									
切断加工 Cut-off Processing	7°		MGMN 200R-6	2.0	0.2	16.0	1.6	3.6	6.0				●	●	●	●	●	●
			300R-6	3.0	0.2	21.0	2.35	4.8	6.0									
			300R-8	3.0	0.2	21.0	2.35	4.8	8.0				●	●	●	●	●	●
			300R-15	3.0	0.2	21.0	2.35	4.8	15.0									
			400R-4	4.0	0.3	21.0	3.3	4.8	4.0				●	●	●	●	●	●
			500R-4	5.0	0.3	26.0	4.1	5.8	4.0				●	●	●	●	●	●
切断加工 Cut-off Processing	7°		MGMN 200L-6	2.0	0.2	16.0	1.6	3.6	6.0				●	●	●	●	●	●
			300L-6	3.0	0.2	21.0	2.35	4.8	6.0									
			300L-8	3.0	0.2	21.0	2.35	4.8	8.0				●	●	●	●	●	●
			300L-15	3.0	0.2	21.0	2.35	4.8	15.0									
			400L-4	4.0	0.3	21.0	3.3	4.8	4.0				●	●	●	●	●	●
			500L-4	5.0	0.3	26.0	4.1	5.8	4.0				●	●	●	●	●	●

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

用途 Application	尺寸标示 Dimensioning	产品图片 Product Image	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切断/切槽加工 Cut-off / Grooving	7°		MGMN 150	1.5	0.15	16.0	1.6	3.5	-	●	●	●						
			200	2.0	0.2	16.0	1.6	3.5	-	●	●	●						
			250	2.5	0.2	18.5	2.0	3.85	-	●	●	●						
			300-02	3.0	0.2	21.0	2.35	4.8	-	●	●	●						
			300	3.0	0.4	21.0	2.35	4.8	-	●	●	●						
			350-03	3.5	0.3	21.0	2.35	4.8	-	●	●	●						
			400-02	4.0	0.2	21.0	3.3	4.8	-	●	●	●						
			400	4.0	0.4	21.0	3.3	4.8	-	●	●	●						
			500-04	5.0	0.4	26.0	4.1	5.8	-	●	●	●						
			500	5.0	0.8	26.0	4.1	5.8	-	●	●	●						
			600	6.0	0.8	26.0	5.0	5.8	-	●	●	●						
			700	7.0	0.8	26.0	5.0	5.8	-	●	●	●						
			800	8.0	0.8	31.0	6.0	6.5	-	●	●	●						
铝合金轮毂加工 Aluminum Alloy Wheel Processing	7°		MRGN 400-A	4.0	2.0	21.0	3.3	4.8	-					●				
			500-A	5.0	2.5	26.0	4.1	5.8	-					●				
			600-A	6.0	3.0	26.0	5.0	5.8	-					●				
			800-A	8.0	4.0	31.0	6.0	6.5	-					●				
切槽加工 Grooving	7°		MRMN 200-M	2.0	1.0	16.0	1.5	3.5	-						●	●	●	●
			300-M	3.0	1.5	21.0	2.35	4.8	-						●	●	●	●
			400-M	4.0	2.0	21.0	3.3	4.8	-						●	●	●	●
			500-M	5.0	2.5	26.0	4.1	5.8	-						●	●	●	●
			600-M	6.0	3.0	26.0	5.0	5.8	-						●	●	●	●
			800-M	8.0	4.0	31.0	6.0	6.5	-						●	●	●	●
切槽加工 Grooving	7°		MRMN 150	1.5	0.75	16.0	1.2	3.5	-	●	●	●						
			200	2.0	1.0	16.0	1.6	3.5	-	●	●	●						
			250	2.5	1.25	18.5	2.0	3.85	-	●	●	●						
			300	3.0	1.5	21.0	2.35	4.8	-	●	●	●						
			350	3.5	1.75	21.0	2.35	4.8	-	●	●	●						
			400	4.0	2.0	21.0	3.3	4.8	-	●	●	●						
			500	5.0	2.5	26.0	4.1	5.8	-	●	●	●						
			600	6.0	3.0	26.0	5.0	5.8	-	●	●	●						
			700	7.0	3.5	26.0	5.0	5.8	-	●	●	●						
			800	8.0	4.0	31.0	6.0	6.5	-	●	●	●						
铝合金轮毂加工 Aluminum Alloy Wheel Processing	35° 7°		MVGN 8N-A-R1.2	-	1.2	30.0	6.0	6.9	-					●				
			8N-A-R1.6	-	1.6	30.0	6.0	6.9	-					●				
切断/切槽加工 Cut-off / Grooving	7°		MGGN 150	1.5	0.15	16.0	1.2	3.5	-				●	●			●	●
			200	2.0	0.2	16.0	1.6	3.5	-				●	●			●	●
			250	2.5	0.2	18.5	2.0	3.85	-				●	●			●	●
			300	3.0	0.4	21.0	2.35	4.8	-				●	●			●	●
			400	4.0	0.4	21.0	3.3	4.8	-				●	●			●	●
			500	5.0	0.8	26.0	4.1	5.8	-				●	●			●	●
			600	6.0	0.8	26.0	5.0	5.8	-				●	●			●	●
切断加工 Cut-off Processing	θ 7°		MGGN 150R-8	1.5	0.15	16.0	1.2	3.5	8°				●	●			●	●
			200R-8	2.0	0.2	16.0	1.6	3.5	8°				●	●			●	●
			250R-8	2.5	0.2	18.5	2.0	3.85	8°				●	●			●	●
			300R-8	3.0	0.4	21.0	2.35	4.8	8°				●	●			●	●
			400R-8	4.0	0.4	21.0	3.3	4.8	8°				●	●			●	●
			500R-8	5.0	0.8	26.0	4.1	5.8	8°				●	●			●	●
			600R-8	6.0	0.8	26.0	5.0	5.8	8°				●	●			●	●
切断加工 Cut-off Processing	θ 7°		MGGN 150L-8	1.5	0.15	16.0	1.2	3.5	8°				●	●			●	●
			200L-8	2.0	0.2	16.0	1.6	3.5	8°				●	●			●	●
			250L-8	2.5	0.2	18.5	2.0	3.85	8°				●	●			●	●
			300L-8	3.0	0.4	21.0	2.35	4.8	8°				●	●			●	●
			400L-8	4.0	0.4	21.0	3.3	4.8	8°				●	●			●	●
			500L-8	5.0	0.8	26.0	4.1	5.8	8°				●	●			●	●
			600L-8	6.0	0.8	26.0	5.0	5.8	8°				●	●			●	●

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

用途 Application	尺寸标示 Dimensioning	产品图片 Product Image	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切断加工 Cut-off Processing	7°	刀柄 (Toolholder) B83/B86	SP 200	2.2	0.2	9.3	-	-	-						●	●	●	●
			300	3.1	0.2	11.3	-	-	-						●	●	●	●
			400	4.1	0.25	11.3	-	-	-						●	●	●	●
			500	5.1	0.3	11.4	-	-	-						●	●	●	●
			600	6.4	0.35	11.4	-	-	-						●	●	●	●
切断加工 Cut-off Processing	7° 8°	刀柄 (Toolholder) B83/B86	SP 200R	2.2	0.2	9.3	-	-	-						●	●	●	●
			300R	3.1	0.2	11.3	-	-	-						●	●	●	●
			400R	4.1	0.25	11.3	-	-	-						●	●	●	●
			500R	5.1	0.3	11.4	-	-	-						●	●	●	●
			600R	6.4	0.35	11.4	-	-	-						●	●	●	●
切断加工 Cut-off Processing	7° 8°	刀柄 (Toolholder) B83/B86	SP 200L	2.2	0.2	9.3	-	-	-						●	●	●	●
			300L	3.1	0.2	11.3	-	-	-						●	●	●	●
			400L	4.1	0.25	11.3	-	-	-						●	●	●	●
			500L	5.1	0.3	11.4	-	-	-						●	●	●	●
			600L	6.4	0.35	11.4	-	-	-						●	●	●	●

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

切削线速度(Cutting Speed):m/min⁻¹ (mm)

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel			10-30							20-60	20-60	20-80		
M	不锈钢 Stainless Steel				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy	300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30					10-30						20-50		
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200					100-200				20-50	20-60	30-80		

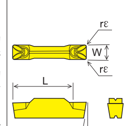
A4. 切断加工 外圆内孔 端面切槽

外圆车刀:B100 (External Toolholder)

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✱ 不稳定切削 Unstable Cutting

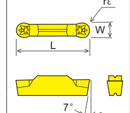
	材料	Material
P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application: 切断/切槽加工 Cut-off / Grooving



规格型号 Specification		W	rε	L	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
A4G	0205M02U02GMN	2.05	0.2	20						●		●	●
	0255M2BU02GMN	2.62	0.2	20						●		●	●
	0305M03U02GMN	3.05	0.2	20						●		●	●
	0305M03U04GMN	3.05	0.4	20						●		●	●
	0405M04U04GMN	4.05	0.4	20						●		●	●
	0405M04U08GMN	4.05	0.8	20						●		●	●
	0505M05U04GMN	5.05	0.4	25						●		●	●
	0505M05U08GMN	5.05	0.8	25						●		●	●
	0605M06U04GMN	6.05	0.4	30						●		●	●
	0605M06U08GMN	6.05	0.8	30						●		●	●
	0605M06U12GMN	6.05	1.2	30						●		●	●
	0805M08U08GMN	8.05	0.8	30						●		●	●
	0805M08U12GMN	8.05	1.2	30						●		●	●
	1005M10U08GMN	10.0	0.5	30						●		●	●
	1005M10U12GMN	10.0	1.2	30						●		●	●

用途 Application: 切槽加工 Grooving



规格型号 Specification		W	rε	L	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
A4R	0205M02U00GMN	2.05	1.1	20						●		●	●
	0305M03U00GMN	3.05	1.5	20						●		●	●
	0405M04U00GMN	4.05	2.0	20						●		●	●
	0505M05U00GMN	5.05	2.5	25						●		●	●
	0605M06U00GMN	6.05	3.0	30						●		●	●
	0805M08U00GMN	8.05	4.0	30						●		●	●
	1005M10U00GMN	10.0	5.0	30						●		●	●

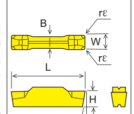
DG 切断加工 外圆内孔 端面切槽

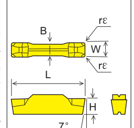
外圆车刀:B101 (External Toolholder)

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✱ 不稳定切削 Unstable Cutting

	材料	Material
P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application: 切断/切槽加工 Cut-off / Grooving

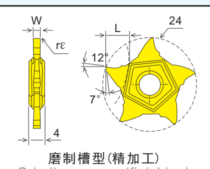




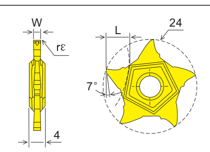
规格型号 Specification		W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
DGN	2002C	2.0	0.2	19.9	-	-	-						●		●	●
	2502C	2.5	0.2	20.7	-	-	-						●		●	●
	3102C	3.1	0.2	20.1	-	-	-						●		●	●
	4003C	4.0	0.3	18.8	-	-	-						●		●	●
	5003C	5.0	0.3	19.1	-	-	-						●		●	●
DGN	2002J	2.0	0.2	19.9	-	-	-						●		●	●
	3102J	3.1	0.2	20.1	-	-	-						●		●	●
	4003J	4.0	0.3	18.8	-	-	-						●		●	●
	5003J	5.0	0.3	19.1	-	-	-						●		●	●

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✱ 不稳定切削 Unstable Cutting

用途 Application: 切断/切槽加工 Cut-off / Grooving



磨制槽型(精加工) Grinding groove (finishing)



有断屑槽(粗加工) With chip breaker (roughing)

规格型号 Specification		W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
PENTA24N	050P005	0.50	0.05	2.0	-	-	-								●	
	075P005	0.75	0.05	3.0	-	-	-								●	
	100P005	1.00	0.05	4.0	-	-	-								●	
	120P005	1.20	0.05	4.0	-	-	-								●	
	150P005	1.50	0.05	4.0	-	-	-								●	
	185P005	1.85	0.05	4.0	-	-	-								●	
	200P005	2.00	0.05	4.0	-	-	-								●	
	230P005	2.30	0.05	4.5	-	-	-								●	
	250P005	2.50	0.05	4.5	-	-	-								●	
	270P005	2.70	0.05	4.5	-	-	-								●	
	300P005	3.00	0.05	4.5	-	-	-								●	
PENTA24N	050J	0.5	0.05	2.0	-	-	-								●	
	100J	1.0	0.10	2.5	-	-	-								●	
	150J	1.5	0.10	6.0	-	-	-								●	
	200J	2.0	0.10	6.0	-	-	-								●	
	250J	2.5	0.20	6.0	-	-	-								●	
	300J	3.0	0.20	6.0	-	-	-								●	

(External Toolholder):B110

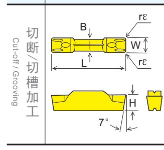
GC 切断加工 外圆内孔 端面切槽

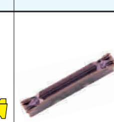
外圆车刀:B102 (External Toolholder)

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✱ 不稳定切削 Unstable Cutting

	材料	Material
P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

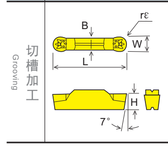
用途 Application: 切断/切槽加工 Cut-off / Grooving





规格型号 Specification		W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
GCMN	3004-MG	3.0	0.4	21.1	-	3.8	-						●		●	
	4008-MG	4.0	0.8	26.4	-	4.0	-						●		●	
	5008-MG	5.0	0.8	26.4	-	4.1	-						●		●	
	6008-MG	6.0	0.8	26.4	-	4.5	-						●		●	
	7008-MG	7.0	0.8	28.7	-	5.5	-						●		●	
	8008-MG	8.0	0.8	28.7	-	6.0	-						●		●	

用途 Application: 切槽加工 Grooving



规格型号 Specification		W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
GCMN	3015-RG	3.0	1.5	21.1	-	3.8	-						●		●	
	4020-RG	4.0	2.0	26.4	-	4.0	-						●		●	
	5025-RG	5.0	2.5	27.2	-	4.1	-						●		●	
	6030-RG	6.0	3.0	27.5	-	4.5	-						●		●	
	7035-RG	7.0	3.5	29.0	-	5.5	-						●		●	
	8040-RG	8.0	4.0	29.0	-	6.0	-						●		●	

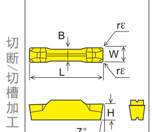
GM 切断加工 外圆切槽 内孔切槽

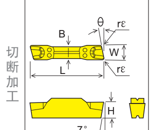
外圆车刀:B93-B94 (External Toolholder)
内孔车刀:B93 (Internal Toolholder)

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✱ 不稳定切削 Unstable Cutting

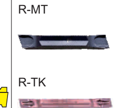
	材料	Material
P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

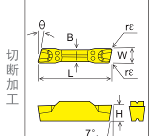
用途 Application: 切断/切槽加工 Cut-off / Grooving; 切槽加工 Grooving



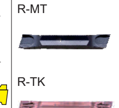


R-MT
R-TK



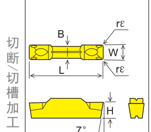


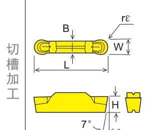
R-MT
R-TK



规格型号 Specification		W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
GMM	1520-MT	1.5	0.0	20	1.2	4.3	-					●			●	
	2020-MT	2.0	0.0	20	1.5	4.3	-					●			●	
	2520-MT	2.5	0.0	20	1.9	4.3	-					●			●	
	3020-MT	3.0	0.0	20	2.3	4.3	-					●			●	
GMM	1520R-MT-15D	1.5	0.0	20	1.2	4.3	15°					●			●	
	2020R-MT-15D	2.0	0.0	20	1.5	4.3	15°					●			●	
	2520R-MT-15D	2.5	0.0	20	1.9	4.3	15°					●			●	
	3020R-MT-15D	3.0	0.0	20	2.3	4.3	15°					●			●	
	2020R-TK-8D	2.0	0.2	20	1.5	4.3	8°					●			●	
	2520R-TK-8D	2.5	0.2	20	1.9	4.3	8°					●			●	
	3020R-TK-8D	3.0	0.25	20	2.3	4.3	8°					●			●	
GMM	1520L-MT-15D	1.5	0.0	20	1.2	4.3	15°					●			●	
	2020L-MT-15D	2.0	0.0	20	1.5	4.3	15°					●			●	
	2520L-MT-15D	2.5	0.0	20	1.9	4.3	15°					●			●	
	3020L-MT-15D	3.0	0.0	20	2.3	4.3	15°					●			●	
	2020L-TK-8D	2.0	0.2	20	1.5	4.3	8°									
	2520L-TK-8D	2.5	0.2	20	1.9	4.3	8°									
	3020L-TK-8D	3.0	0.25	20	2.3	4.3	8°									

用途 Application: 切断/切槽加工 Cut-off / Grooving; 切槽加工 Grooving





规格型号 Specification		W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
GMM	3020-020MW	3.0	0.2	20	2.3	4.3	-				●	●	●		●	
	3020-040MW	3.0	0.4	20	2.3	4.3	-				●	●	●		●	
	4020-020MW	4.0	0.2	20	3.3	4.3	-				●	●	●		●	
	4020-040MW	4.0	0.4	20	3.3	4.3	-				●	●	●		●	
	4020-080MW	4.0	0.8	20	3.3	4.3	-				●	●	●		●	
	5020-040MW	5.0	0.4	20	4.2	4.3	-				●	●	●		●	
	5020-080MW	5.0	0.8	20	4.2	4.3	-				●	●	●		●	
	6020-040MW	6.0	0.4	20	5.2	4.3					●	●	●		●	
	6020-080MW	6.0	0.8	20	5.2	4.3					●	●	●		●	
	8030-080MW	8.0	0.8	30	6.0	5.5					●	●	●		●	
GMM	3020-150R	3.0	1.5	20	2.3	4.3	-				●	●	●		●	
	4020-200R	4.0	2.0	20	3.3	4.3	-				●	●	●		●	
	5020-250R	5.0	2.5	20	4.2	4.3	-				●	●	●		●	
	6020-300R	6.0	3.0	20	5.2	4.3	-				●	●	●		●	

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

GY 切断加工 外圆内孔 端面切槽

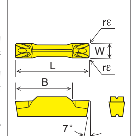
外圆车刀:B97
(External Toolholder)

切削线速度(Cutting Speed): m/min⁻¹ (mm)

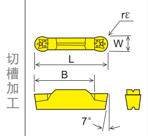
加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel			10-30							20-60	20-60	20-80		
M	不锈钢 Stainless Steel				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy	300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30					10-30						20-50		
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200					100-200				20-50	20-60	30-80		

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✱ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
P	钢	Steel			●	●		✱	◐	✱	◐
M	不锈钢	Stainless Steel				●				✱	◐
K	铸铁	Iron		●		●				✱	
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐				
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✱	◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✱	◐



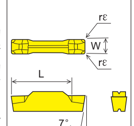

用途 Application	规格型号 Specification	W	rε	L	B	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切断/切槽加工 Cut-off/Grooving	GY2M 0200D020N-MM	2.0	0.2	20.7	19.1						●		●	●
	0250E020N-MM	2.5	0.2	20.7	19.1						●		●	●
	0300F020N-MM	3.0	0.2	20.7	19.1						●		●	●
	0300F040N-MM	3.0	0.4	20.7	18.9						●		●	●
	0300F080N-MM	3.0	0.8	20.7	18.5						●		●	●
	0400G020N-MM	4.0	0.2	25.6	24.1						●		●	●
	0400G040N-MM	4.0	0.4	25.6	23.9						●		●	●
	0400G080N-MM	4.0	0.8	25.6	23.5						●		●	●
	0500H040N-MM	5.0	0.4	25.6	23.9						●		●	●
	0500H080N-MM	5.0	0.8	25.6	23.5						●		●	●
	0600J040N-MM	6.0	0.4	25.6	23.9						●		●	●
	0600J080N-MM	6.0	0.8	25.6	23.5						●		●	●
	0800K080N-MM	8.0	0.8	30.5	28.5						●		●	●
	0800K120N-MM	8.0	1.2	30.5	28.1						●		●	●

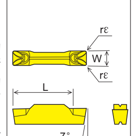



用途 Application	规格型号 Specification	W	rε	L	B	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切槽加工 Grooving	GY2M 0200D100N-BM	2.0	1.0	20.9	19.5						●		●	●
	0250E125N-BM	2.5	1.25	20.9	19.3						●		●	●
	0300F150N-BM	3.0	1.5	20.9	19.0						●		●	●
	0318F159N-BM	3.18	1.59	20.9	18.9						●		●	●
	0400G200N-BM	4.0	2.0	25.8	23.4						●		●	●
	0475H238N-BM	4.75	2.38	25.8	22.9						●		●	●
	0500H250N-BM	5.0	2.5	25.8	22.8						●		●	●
	0600J300N-BM	6.0	3.0	25.9	22.5						●		●	●
	0635J318N-BM	6.35	3.18	25.9	22.3						●		●	●
	0800K400N-BM	8.0	4.0	30.8	26.5						●		●	●

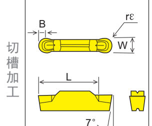
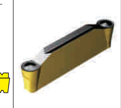
N123 切断加工 外圆切槽 内孔切槽

外圆车刀:B99
(External Toolholder)





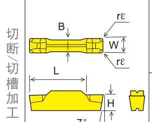
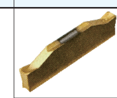
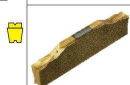
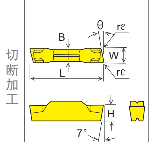

用途 Application	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切断/切槽加工 Cut-off/Grooving	N123 D2-0150-0002-CM	1.5	0.2	12.9	-	-	-					●			●	
	E2-0200-0002-CM	2.0	0.2	19.0	-	-	-					●			●	
	F2-0250-0002-CM	2.5	0.2	18.9	-	-	-					●			●	
	G2-0300-0002-CM	3.0	0.2	18.9	-	-	-					●			●	
	H2-0400-0002-CM	4.0	0.2	24.1	-	-	-					●			●	
	J2-0500-0002-CM	5.0	0.2	24.1	-	-	-					●			●	
切断/切槽加工 Cut-off/Grooving	N123 G2-0300-0004-TM	3.0	0.4	18.4	-	-	-					●			●	
	H2-0400-0004-TM	4.0	0.4	23.4	-	-	-					●			●	
	H2-0400-0008-TM	4.0	0.8	23.4	-	-	-					●			●	
	J2-0500-0004-TM	5.0	0.4	23.4	-	-	-					●			●	
	J2-0500-0008-TM	5.0	0.8	23.0	-	-	-					●			●	
	K2-0600-0004-TM	6.0	0.4	23.4	-	-	-					●			●	
	K2-0600-0008-TM	6.0	0.8	23.0	-	-	-					●			●	
	L2-0800-0008-TM	8.0	0.8	28.0	-	-	-					●			●	
	L2-0800-0012-TM	8.0	1.2	27.6	-	-	-					●			●	

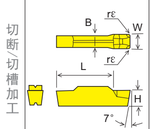



用途 Application	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切槽加工 Grooving	N123 F2-0300-RM	3.00	1.50	18.6	1.3	-	-						●		●	
	F2-0318-RM	3.18	1.59	18.6	1.4	-	-						●		●	
	G2-0400-RM	4.00	2.00	18.1	1.8	-	-						●		●	
	H2-0400-RM	4.00	2.00	23.1	1.8	-	-						●		●	
	H2-0475-RM	4.75	2.38	22.9	2.2	-	-						●		●	
	H2-0500-RM	5.00	2.50	22.7	2.3	-	-						●		●	
	J2-0600-RM	6.00	3.00	22.2	2.8	-	-						●		●	
	J2-0635-RM	6.35	3.18	22.0	3.0	-	-						●		●	
	L2-0800-RM	8.00	4.00	27.0	3.8	-	-						●		●	

TD 切断加工 外圆内孔 端面切槽

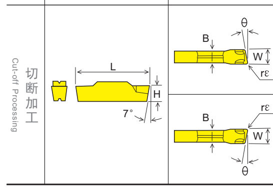
外圆车刀:B91
(External Toolholder)
内孔车刀:B92
(Internal Toolholder)



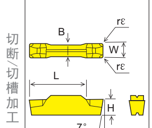

用途 Application	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切断/切槽加工 Cut-off/Grooving	TDC 2	2.0	0.2	20.0	1.7	4.7	-				●	●	●		●	●
	3	3.0	0.2	20.0	2.4	4.7	-				●	●	●		●	●
	4	4.0	0.3	20.0	3.0	4.7	-				●	●	●		●	●
	5	5.0	0.3	25.0	4.0	5.2	-				●	●	●		●	●
	6	6.0	0.3	25.0	5.0	5.2	-									
	8	8.0	0.4	30.0	6.0	6.4	-									
	TDJ 1.4	1.4	0.16	16.0	1.0	4.0	-					●			●	●
	2	2.0	0.2	20.0	1.7	4.7	-					●			●	●
	3	3.0	0.2	20.0	2.4	4.7	-					●			●	●
	4	4.0	0.3	20.0	3.0	4.7	-					●			●	●
	5	5.0	0.3	25.0	4.0	5.2	-									
	6	6.0	0.3	25.0	5.0	5.2	-									
切断加工 Cut-off Processing	TDC 2-6R	2	0.2	20.0	1.7	4.7	6°								●	
	2-8R	2	0.2	20.0	1.7	4.7	8°								●	
	2-15R	2	0.2	20.0	1.7	4.7	15°								●	
	3-6R	3	0.2	20.0	2.4	4.7	6°								●	
	3-15R	3	0.2	20.0	2.4	4.7	15°								●	
	4-4R	4	0.3	20.0	3.0	4.7	4°								●	
	4-15R	4	0.3	20.0	3.0	4.7	15°								●	
	5-4R	5	0.3	25.0	4.0	5.2	4°								●	
切断/切槽加工 Cut-off/Grooving	TSC 2	2.0	0.2	20.0	1.7	4.7	-								●	
	3	3.0	0.2	20.0	2.4	4.7	-								●	
	4	4.0	0.2	20.0	3.0	4.7	-								●	
	5	5.0	0.3	25.0	4.0	4.7	-								●	
	6	6.0	0.3	25.0	5.0	4.7	-								●	
	8	8.0	0.4	30.0	6.0	5.2	-								●	

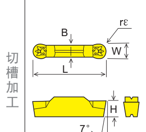
用途 Application	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切槽加工 Grooving	TDT 30	3.0	1.5	20	-	5.5	-				●		●		●	
	40	4.0	2.0	25	-	5.7	-				●		●		●	
	50	5.0	2.5	25	-	5.9	-				●		●		●	
切断加工 Cut-off Processing	TDC 2-6L	2	0.2	20.0	1.7	4.7	6°								●	
	2-8L	2	0.2	20.0	1.7	4.7	8°								●	
	2-15L	2	0.2	20.0	1.7	4.7	15°								●	
	3-6L	3	0.2	20.0	2.4	4.7	6°								●	
	3-15L	3	0.2	20.0	2.4	4.7	15°								●	
	4-4L	4	0.3	20.0	3.0	4.7	4°								●	
	4-15L	4	0.3	20.0	3.0	4.7	15°								●	
	5-4L	5	0.3	25.0	4.0	5.2	4°								●	
切断加工 Cut-off Processing	TDC 2	2.0	0.2	20.0	1.7	4.7	-								●	
	3	3.0	0.2	20.0	2.4	4.7	-								●	
	4	4.0	0.3	20.0	3.0	4.7	-								●	
	5	5.0	0.3	25.0	4.0	5.2	-								●	
	6	6.0	0.3	25.0	5.0	5.2	-									
	8	8.0	0.4	30.0	6.0	6.4	-									
	TDJ 1.4	1.4	0.16	16.0	1.0	4.0	-								●	
	2	2.0	0.2	20.0	1.7	4.7	-								●	
	3	3.0	0.2	20.0	2.4	4.7	-								●	
	4	4.0	0.3	20.0	3.0	4.7	-								●	
	5	5.0	0.3	25.0	4.0	5.2	-									
	6	6.0	0.3	25.0	5.0	5.2	-									



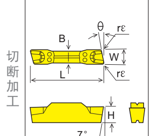
WGE 切断加工 外圆内孔 端面切槽

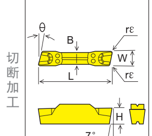
外圆车刀:B98
(External Toolholder)






用途 Application	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切断/切槽加工 Cut-off/Grooving	WGE 20	2.0	0.2	20	-	4.7	-				●		●		●	
	30	3.0	0.2	20	-	5.5	-				●		●		●	
	40	4.0	0.2	25	-	5.7	-				●		●		●	
	50	5.0	0.2	25	-	5.9	-				●		●		●	
切槽加工 Grooving	WGR 30	3.0	1.5	20	-	5.5	-				●		●		●	
	40	4.0	2.0	25	-	5.7	-				●		●		●	
	50	5.0	2.5	25	-	5.9	-				●		●		●	






用途 Application	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切断加工 Cut-off Processing	WGE 20R	2.0	0.2	20	-	4.7	-				●		●		●	
	30R	3.0	0.2	20	-	5.5	-				●		●		●	
	40R	4.0	0.2	25	-	5.7	-				●		●		●	
	50R	5.0	0.2	25	-	5.9	-				●		●		●	
切断加工 Cut-off Processing	WGE 20L	2.0	0.2	20	-	4.7	-				●		●		●	
	30L	3.0	0.2	20	-	5.5	-				●		●		●	
	40L	4.0	0.2	25	-	5.7	-				●		●		●	
	50L	5.0	0.2	25	-	5.9	-				●		●		●	

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

Z..

切断加工 外圆内孔 端面切槽

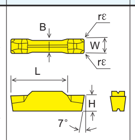
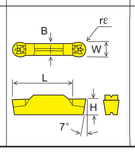
外圆车刀: B96
(External Toolholder)
内孔车刀 : B95-B96
(Internal Toolholder)
端面槽车刀: B123
(End Face Toolholder)

切削线速度(Cutting Speed): m/min⁻¹ (mm)

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel			10-30							20-60	20-60	20-80		
M	不锈钢 Stainless Steel				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy	300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30					10-30						20-50		
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200					100-200				20-50	20-60	30-80		

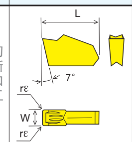
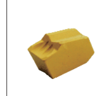
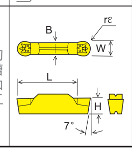
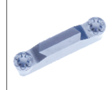
切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✤ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
P	钢	Steel			●	●		✤	◐	✤	◐
M	不锈钢	Stainless Steel				●				✤	◐
K	铸铁	Iron		●		●				✤	
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐				
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✤	◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✤	◐

用途 Application	尺寸标示 Dimensioning	产品图片 Product Image	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切断/切槽加工 Cut-off / Grooving			ZTED 02503-MG	2.5	0.3	17	-	-	-						•		•	
			0303-MG	3.0	0.3	17	-	-	-						•		•	
			0404-MG	4.0	0.4	22	-	-	-						•		•	
			0504-MG	5.0	0.4	22	-	-	-						•		•	
			0608-MG	6.0	0.8	22	-	-	-						•		•	
切槽加工 Grooving			ZRED 025-MG	2.5	1.25	17.5	-	-	-						•		•	
			03-MG	3.0	1.5	17	-	-	-						•		•	
			04-MG	4.0	2.0	21	-	-	-						•		•	
			05-MG	5.0	2.5	20	-	-	-						•		•	
			06-MG	6.0	3.0	19	-	-	-						•		•	

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✤ 不稳定切削 Unstable Cutting

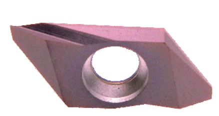
			PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
P	钢	Steel			●	●		✤	◐	✤	◐
M	不锈钢	Stainless Steel				●				✤	◐
K	铸铁	Iron		●		●				✤	
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐				
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✤	◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✤	◐

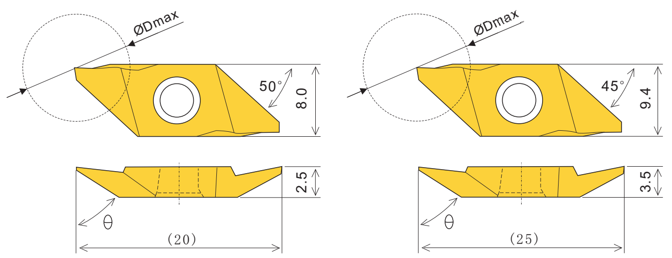
用途 Application	尺寸标示 Dimensioning	产品图片 Product Image	规格型号 Specification	W	rε	L	B	H	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切断加工 Cut-off Processing			ZQMX 3N11-1E	3.1	0.3	11	-	-	-						•	•	•	
			4N11-1E	4.1	0.3	11	-	-	-						•	•	•	
			5N11-1E	5.1	0.3	11	-	-	-						•	•	•	
			6N11-1E	6.4	0.3	11	-	-	-						•	•	•	
			7N11-1E	7.0	0.3	14	-	-	-						•	•	•	
切槽加工 Grooving			ZRKD 06-LH	6.0	3.0	19	-	-	-					•				
			ZRLD 08-LH	8.0	4.0	22	-	-	-					•				

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

TBP 外圆加工 背车削 后车削刀片





TBP
ØDmax=Ø5~10mm

TBPA
ØDmax=Ø5~12mm

小零件专用:AB05/AB15/A43
(Small Parts Toolholder)

切削线速度(Cutting Speed):m/min⁻¹ (mm)

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZK01 铜铝加工 Copper/Aluminum	ZM826 黄色通用 Yellow	ZP15 紫色通用 Purple	ZM856 不锈钢通用 Stainless Steel
P	低碳钢 Low-Carbon steel				150-600		60-250	70-250	100-250
P	高碳钢 High-Carbon steel				150-350		60-150	70-150	80-150
P	淬硬钢 HRC46-58 Hardened Steel			10-30			20-60	20-60	20-60
M	不锈钢 Stainless Steel				200-300		50-150	50-150	70-150
K	灰口铸铁 Gray Cast Iron		300-1500		100-300		130-210	150-200	150-300
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200				300-1200			
N	铝合金 HB50-70 Aluminum Alloy	300-1500				300-1500			
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800				300-800			
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000				300-1000			
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30				10-30			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600				400-600			
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200				100-200	20-50	20-50	20-60

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ○ 一般切削(第二推荐) General Cutting(Second recommend) ✖ 不稳定切削 Unstable Cutting

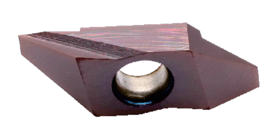
			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✖	◕	◕	◕
M	不锈钢	Stainless Steel				◕		◕	◕	✖	◕	◕	◕
K	铸铁	Iron		●		◕		◕		✖	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◕

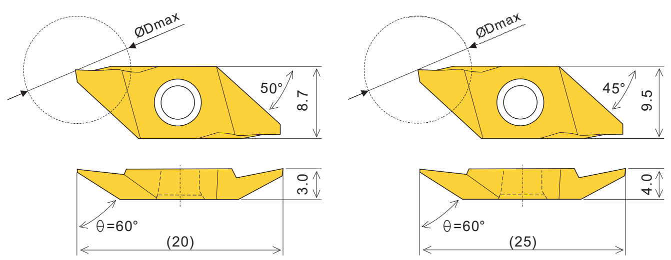
用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	A	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外圆加工 External Processing	有排屑槽 With Groove	TBP 55FR00	3.0	5.3	0.00	55°					●	●	●			●	
		55FR10	3.0		0.10	55°					●	●	●			●	
		60FR00	3.7		0.00	60°					●	●	●			●	
		60FR10	3.7		0.10	60°					●	●	●			●	
		60FR20	3.7		0.20	60°					●	●	●			●	
外圆加工 External Processing	有排屑槽 With Groove	TBPA 60FR00	4.5	5.3	0.00	60°					●	●	●			●	
		60FR10	4.5		0.10						●	●	●			●	
		60FR20	4.5		0.20						●	●	●			●	

用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W±0.05	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外圆加工 External Processing	无排屑槽 Without Groove	TBP 60FRV00	4.8	5.3	0.00	60°					●	●	●			●	
		60FRV05			0.05						●	●	●			●	
		60FRV10			0.10						●	●	●			●	
外圆加工 External Processing	无排屑槽 Without Groove	TBPA 60FRV00	6.3	6.8	0.00	60°					●	●	●			●	
		60FRV05									●	●	●			●	
		60FRV10									●	●	●			●	

☆θ为刀柄安装时取值
☆θ Installation Angle For The Toolholder

TKFB 外圆加工 背车削 后车削刀片





TKFB
ØDmax=Ø5~9mm

TKFB
ØDmax=Ø5~12mm

小零件专用:AB05/AB25
(Small Parts Toolholder)

切削线速度(Cutting Speed):m/min⁻¹ (mm)

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZK01 铜铝加工 Copper/Aluminum	ZM826 黄色通用 Yellow	ZP15 紫色通用 Purple	ZM856 不锈钢通用 Stainless Steel
P	低碳钢 Low-Carbon steel				150-600		60-250	70-250	100-250
P	高碳钢 High-Carbon steel				150-350		60-150	70-150	80-150
P	淬硬钢 HRC46-58 Hardened Steel			10-30			20-60	20-60	20-60
M	不锈钢 Stainless Steel				200-300		50-150	50-150	70-150
K	灰口铸铁 Gray Cast Iron		300-1500		100-300		130-210	150-200	150-300
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200				300-1200			
N	铝合金 HB50-70 Aluminum Alloy	300-1500				300-1500			
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800				300-800			
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000				300-1000			
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30				10-30			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600				400-600			
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200				100-200	20-50	20-50	20-60

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ○ 一般切削(第二推荐) General Cutting(Second recommend) ✖ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✖	◕	◕	◕
M	不锈钢	Stainless Steel				◕		◕	◕	✖	◕	◕	◕
K	铸铁	Iron		●		◕		◕		✖	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◕

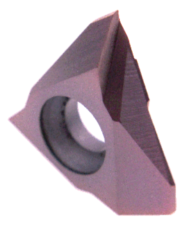
用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W	B	rε	a	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外圆加工 External Processing	有排屑槽 With Groove	TKFB12R 15005M	1.5	2.6	0.05	0.25					●	●	●			●	
		28005M	2.8	4.6	0.05	0.3					●	●	●			●	
		28010M	2.8	4.6	0.1	0.3					●	●	●			●	
外圆加工 External Processing	有排屑槽 With Groove	TKFB16R 38005M	3.8	0.3	0.05	0.3					●	●	●			●	
		38010M			0.1						●	●	●			●	

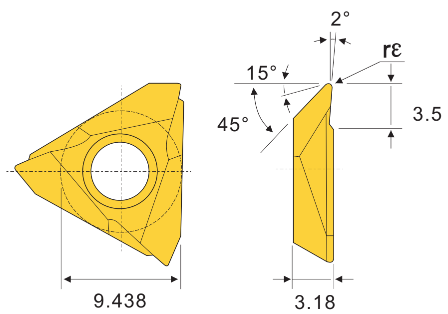
用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	W	B	rε	a	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外圆加工 External Processing	有排屑槽 With Groove	TKFB12L 15005M	1.5	2.6	0.05	0.25					●	●	●			●	
		28005M	2.8	4.6	0.05	0.3					●	●	●			●	
		28010M	2.8	4.6	0.1	0.3					●	●	●			●	
外圆加工 External Processing	有排屑槽 With Groove	TKFB16L 38005M	3.8	0.3	0.05	0.3					●	●	●			●	
		38010M			0.1						●	●	●			●	

☆θ为刀柄安装时取值
☆θ Installation Angle For The Toolholder

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

TB.. 外圆加工 背车削 后车削刀片





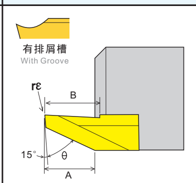
☞ 小零件专用:AB14
(Small Parts Toolholder)

切削线速度(Cutting Speed):m/min⁻¹ (mm)

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZK01 铜铝加工 Copper/Aluminum	ZM826 黄色通用 Yellow	ZP15 紫色通用 Purple	ZM856 不锈钢通用 Stainless Steel
P	低碳钢 Low-Carbon steel				150-600		60-250	70-250	100-250
P	高碳钢 High-Carbon steel				150-350		60-150	70-150	80-150
P	淬硬钢 HRC46-58 Hardened Steel			10-30			20-60	20-60	20-60
M	不锈钢 Stainless Steel				200-300		50-150	50-150	70-150
K	灰口铸铁 Gray Cast Iron		300-1500		100-300		130-210	150-200	150-300
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200				300-1200			
N	铝合金 HB50-70 Aluminum Alloy	300-1500				300-1500			
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800				300-800			
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000				300-1000			
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30				10-30			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600				400-600			
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200				100-200	20-50	20-50	20-60

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ○ 一般切削(第二推荐) General Cutting(Second recommend) ✖ 不稳定切削 Unstable Cutting

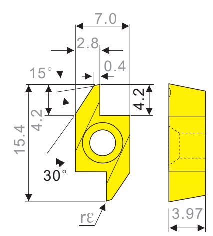
			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✖	◕	◕	◕
M	不锈钢	Stainless Steel				○		○	○	✖	○	○	○
K	铸铁	Iron		●		◕		◕		✖	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◕

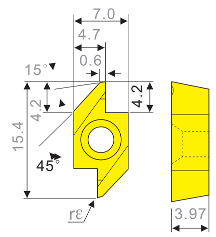
用途 Application	尺寸形状 Dimension and Shape	规格型号 Specification	A	B	rε	θ	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外圆加工 External Processing		TB 3200R	3.2	3.5	0.00	45°					●	●	●			●	
		TB 3205R	3.2	3.5	0.05	45°					●	●	●			●	
		TB 3210R	3.2	3.5	0.10	45°					●	●	●			●	
		TB 3215R	3.2	3.5	0.15	45°					●	●	●			●	
		TB 3220R	3.2	3.5	0.20	45°					●	●	●			●	

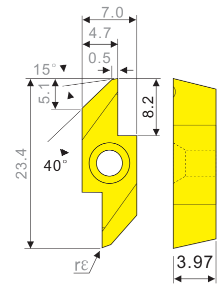
(Dimension 尺寸 spans A, B, rε, θ.)

☆θ为刀柄安装时取值
☆θ Installation Angle For The Toolholder

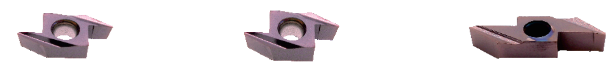
AB.. 外圆加工 背车削 后车削刀片







ABS15 切深 ap=4.2mm | ABW15 切深 ap=4.2mm | ABW23 切深 ap=8.2mm



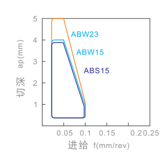
☞ 小零件专用:AB13
(Small Parts Toolholder)

切削线速度(Cutting Speed):m/min⁻¹ (mm)

加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZK01 铜铝加工 Copper/Aluminum	ZM826 黄色通用 Yellow	ZP15 紫色通用 Purple	ZM856 不锈钢通用 Stainless Steel
P	低碳钢 Low-Carbon steel				150-600		60-250	70-250	100-250
P	高碳钢 High-Carbon steel				150-350		60-150	70-150	80-150
P	淬硬钢 HRC46-58 Hardened Steel			10-30			20-60	20-60	20-60
M	不锈钢 Stainless Steel				200-300		50-150	50-150	70-150
K	灰口铸铁 Gray Cast Iron		300-1500		100-300		130-210	150-200	150-300
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200		100-160	100-150	150-230
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200				300-1200			
N	铝合金 HB50-70 Aluminum Alloy	300-1500				300-1500			
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800				300-800			
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000				300-1000			
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30				10-30			
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600				400-600			
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200				100-200	20-50	20-50	20-60

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ○ 一般切削(第二推荐) General Cutting(Second recommend) ✖ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✖	◕	◕	◕
M	不锈钢	Stainless Steel				○		○	○	✖	○	○	○
K	铸铁	Iron		●		◕		◕		✖	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◕

用途 Application	切削参数 Cutting Parameter	规格型号 Specification	尺寸 Dimension rε	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外圆加工 External Processing		ABS15R 4005	0.05					●	●	●			●	
		ABS15R 4015	0.15					●	●	●			●	
		ABW15R 4005	0.05					●	●	●			●	
		ABW15R 4015	0.15					●	●	●			●	
		ABW23R 5005	0.05					●	●	●			●	
		ABW23R 5015	0.15					●	●	●			●	

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 T.N/E GER GR
螺纹车削刀片
铣削刀片

GER 小零件 小孔 内孔切槽

内孔车刀:B112 (Internal Toolholder)
端面切槽:B116 (End Face Toolholder)

切削线速度 (Cutting Speed): m/min (mm)

加工材料	刀具材质 / 材质特点	PCD 金刚石	CBN-K 铸铁专用	CBN-S 淬切削材用	ZN60 光洁度好	ZN90 高速精加工	ZK01 铜铝加工	ZC250 CVD 钢件	ZC251 CVD 钢件	ZC32S 钢件高速	ZP152 不锈钢通用	ZP153 不锈钢高速	ZP163 高硬高速	ZK50 CVD 铸铁	ZK50S 铸铁高速
P	低碳钢				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58			10-30							20-60	20-60	20-80		
M	不锈钢				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材	300-1200					300-1200								
N	铝合金 HB50-70	300-1500					300-1500								
N	淬硬铝合金 HB70-110	300-800					300-800								
N	铜/青铜/黄铜	300-1000					300-1000								
S	硬质合金/粉末冶金	10-30					10-30						20-50		
S	硅填充塑料硬质纤维	400-600					400-600								
H	钛/高温合金/碳纤维	100-200					100-200				20-50	20-60	30-80		

切削形态 (Cutting Environment): ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

	材料	Material
P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

GER 切槽加工 Grooving

规格型号 Specification	W	rε	B	A	L	Ød	ZK01	ZP152	ZP153
GER 050-A	0.5	0.05	1.2	6.69	6.5	2.5	●	●	●
060-A	0.6						●	●	●
070-A	0.7						●	●	●
080-A	0.8						●	●	●
100-A	1.0						●	●	●
120-A	1.2		1.5				●	●	●
125-A	1.25	0.1					●	●	●
140-A	1.4						●	●	●
150-A	1.5						●	●	●
180-A	1.8						●	●	●
200-A	2.0						●	●	●
GER 100-050AR	1.0	0.5	1.5	6.69	6.5	2.5	●	●	●
150-075AR	1.5	0.75					●	●	●
200-100AR	2.0	1.0					●	●	●
GER 080-B	0.8	0.05	1.8	8.46	8.2	2.7	●	●	●
100-B	1.0						●	●	●
120-B	1.2						●	●	●
125-B	1.25	0.1	2.2				●	●	●
130-B	1.3						●	●	●
145-B	1.45						●	●	●
150-B	1.5						●	●	●
180-B	1.8						●	●	●
200-B	2.0						●	●	●
225-B	2.25						●	●	●
250-B	2.5	0.2					●	●	●
280-B	2.8						●	●	●
300-B	3.0						●	●	●
GER 100-050BR	1.0	0.5	2.2	8.46	8.2	2.7	●	●	●
150-075BR	1.5	0.75					●	●	●
200-100BR	2.0	1.0					●	●	●
250-125BR	2.5	1.25					●	●	●
300-150BR	3.0	1.5					●	●	●
GER 100-C	1.0	0.05	2.5	5.8	11.5	2.8	●	●	●
120-C	1.2						●	●	●
125-C	1.25						●	●	●
140-C	1.4	0.1					●	●	●
145-C	1.45						●	●	●
150-C	1.5						●	●	●
160-C	1.6						●	●	●
170-C	1.7						●	●	●
185-C	1.85						●	●	●
195-C	1.95						●	●	●
200-C	2.0						●	●	●
225-C	2.25						●	●	●
250-C	2.5	0.2					●	●	●
275-C	2.75						●	●	●
280-C	2.8						●	●	●
300-C	3.0						●	●	●
320-C	3.2						●	●	●
350-C	3.5						●	●	●
GER 100-050CR	1.0	0.5	2.5	5.8	11.5	2.8	●	●	●
150-075CR	1.5	0.75					●	●	●
200-100CR	2.0	1.0					●	●	●
250-125CR	2.5	1.25					●	●	●
300-150CR	3.0	1.5					●	●	●
GER 150-075DR	1.5	0.75	3.2	6.8	16.4	3.4	●	●	●
200-100DR	2.0	1.0					●	●	●
250-125DR	2.5	1.25	4.5				●	●	●
300-150DR	3.0	1.5					●	●	●

GEL 切槽加工 Grooving

规格型号 Specification	W	rε	B	A	L	Ød	ZK01	ZP152	ZP153
GEL 050-A	0.5	0.05	1.2	6.69	6.5	2.5	●	●	●
060-A	0.6						●	●	●
070-A	0.7						●	●	●
080-A	0.8						●	●	●
100-A	1.0						●	●	●
120-A	1.2		1.5				●	●	●
125-A	1.25	0.1					●	●	●
140-A	1.4						●	●	●
150-A	1.5						●	●	●
180-A	1.8						●	●	●
200-A	2.0						●	●	●
GEL 100-050AR	1.0	0.5	1.5	6.69	6.5	2.5	●	●	●
150-075AR	1.5	0.75					●	●	●
200-100AR	2.0	1.0					●	●	●
GEL 080-B	0.8	0.05	1.8	8.46	8.2	2.7	●	●	●
100-B	1.0						●	●	●
120-B	1.2						●	●	●
125-B	1.25	0.1	2.2				●	●	●
130-B	1.3						●	●	●
145-B	1.45						●	●	●
150-B	1.5						●	●	●
180-B	1.8						●	●	●
200-B	2.0						●	●	●
225-B	2.25						●	●	●
250-B	2.5	0.2					●	●	●
280-B	2.8						●	●	●
300-B	3.0						●	●	●
GEL 100-050BR	1.0	0.5	2.2	8.46	8.2	2.7	●	●	●
150-075BR	1.5	0.75					●	●	●
200-100BR	2.0	1.0					●	●	●
250-125BR	2.5	1.25					●	●	●
300-150BR	3.0	1.5					●	●	●
GEL 100-C	1.0	0.05	2.5	5.8	11.5	2.8	●	●	●
120-C	1.2						●	●	●
125-C	1.25						●	●	●
140-C	1.4	0.1					●	●	●
145-C	1.45						●	●	●
150-C	1.5						●	●	●
160-C	1.6						●	●	●
170-C	1.7						●	●	●
185-C	1.85						●	●	●
195-C	1.95						●	●	●
200-C	2.0						●	●	●
225-C	2.25						●	●	●
250-C	2.5	0.2					●	●	●
275-C	2.75						●	●	●
280-C	2.8						●	●	●
300-C	3.0						●	●	●
320-C	3.2						●	●	●
350-C	3.5						●	●	●
GEL 100-050CR	1.0	0.5	2.5	5.8	11.5	2.8	●	●	●
150-075CR	1.5	0.75					●	●	●
200-100CR	2.0	1.0					●	●	●
250-125CR	2.5	1.25					●	●	●
300-150CR	3.0	1.5					●	●	●
GEL 150-075DR	1.5	0.75	3.2	6.8	16.4	3.4	●	●	●
200-100DR	2.0	1.0					●	●	●
250-125DR	2.5	1.25	4.5				●	●	●
300-150DR	3.0	1.5					●	●	●

GER 切槽加工 Grooving / 端面切槽加工 End Face Grooving

刀柄 (Toolholder) B116

规格型号 Specification	W	rε	B	A	L	Ød	ZK01	ZP152	ZP153
GER 100-D	1.0	0.05	2.25	6.8	16.4	3.4	●	●	●
120-D	1.2						●	●	●
125-D	1.25						●	●	●
140-D	1.4						●	●	●
145-D	1.45	0.1					●	●	●
150-D	1.5		3.0				●	●	●
170-D	1.7						●	●	●
185-D	1.85						●	●	●
195-D	1.95						●	●	●
200-D	2.0		3.6				●	●	●
225-D	2.25						●	●	●
230-D	2.3	0.2					●	●	●
250-D	2.5						●	●	●
275-D	2.75						●	●	●
280-D	2.8		4.5				●	●	●
300-D	3.0						●	●	●
320-D	3.2						●	●	●
330-D	3.3						●	●	●
350-D	3.5						●	●	●
400-D	4.0						●	●	●
GER 100-E	1.0	0.05	2.5	9.54	21.7	4.4	●	●	●
150-E	1.5	0.1	3.0				●	●	●
170-E	1.7						●	●	●
185-E	1.85						●	●	●
195-E	1.95						●	●	●
200-E	2.0		3.2				●	●	●
225-E	2.25						●	●	●
230-E	2.3	0.2					●	●	●
250-E	2.5		4.5				●	●	●
275-E	2.75						●	●	●
280-E	2.8						●	●	●
300-E	3.0						●	●	●
330-E	3.3						●	●	●
350-E	3.5		5.5				●	●	●
400-E	4.0						●	●	●
430-E	4.3		6.5				●	●	●
450-E	4.5						●	●	●
460-E	4.6						●	●	●
500-E	5.0						●	●	●
GER 250-125ER	2.5	1.25	5.5	9.54	21.7	4.4	●	●	●
300-150ER	3.0	1.5					●	●	●
350-175ER	3.5	1.75					●	●	●
400-200ER	4.0	2.0	6.5				●	●	●
450-225ER	4.5	2.25					●	●	●
500-250ER	5.0	2.5					●	●	●
GER 100DM06-D	1.0	0.05	2.5	6.8	16.4	3.4	●	●	●
150DM10-D	1.5	0.1	2.8				●	●	●
200DM10-D	2.0	0.1	3.5				●	●	●
250DM15-D	2.5	0.2	4.5				●	●	●
300DM15-D	3.0	0.2	4.5				●	●	●
400DM15-D	4.0	0.2	4.5				●	●	●
GER150DM10R075-D	1.5	0.75	2.5	6.8	16.4	3.4	●	●	●
200DM10R100-D	2.0	1.0	3.5				●	●	●
250DM15R125-D	2.5	1.25	4.5				●	●	●
300DM15R150-D	3.0	1.5	4.5				●	●	●
400DM15R200-D	4.0	2.0	4.5						
GER 150DM10-E	1.5	0.1	3.6	9.54	21.7	4.4	●	●	●
200DM10-E	2.0	0.1	4.8				●	●	●
250DM15-E	2.5	0.2	6.0				●	●	●
300DM15-E	3.0	0.2	6.5				●	●	●
400DM15-E	4.0	0.2	6.5				●	●	●
450DM15-E	4.5	0.2	6.5				●	●	●
500DM15-E	5.0	0.2	6.5				●	●	●
GER150DM10R075-E	1.5	0.75	3.6	9.54	21.7	4.4	●	●	●
200DM10R100-E	2.0	1.0	4.8				●	●	●
250DM15R125-E	2.5	1.25	6.0				●	●	●
300DM15R150-E	3.0	1.5	6.5				●	●	●
400DM15R200-E	4.0	2.0	6.5				●	●	●
500DM15R250-E	5.0	2.5	6.5				●	●	●

GEL 切槽加工 Grooving / 端面切槽加工 End Face Grooving

刀柄 (Toolholder) B116

规格型号 Specification	W	rε	B	A	L	Ød	ZK01	ZP152	ZP153
GEL 100-D	1.0	0.05	2.25	6.8	16.4	3.4	●	●	●
120-D	1.2						●	●	●
125-D	1.25						●	●	●
140-D	1.4						●	●	●
145-D	1.45	0.1					●	●	●
150-D	1.5		3.0				●	●	●
170-D	1.7						●	●	●
185-D	1.85						●	●	●
195-D	1.95						●	●	●
200-D	2.0		3.6				●	●	●
225-D	2.25						●	●	●
230-D	2.3	0.2					●	●	●
250-D	2.5						●	●	●
275-D	2.75						●	●	●
280-D	2.8		4.5				●	●	●
300-D	3.0						●	●	●
320-D	3.2						●	●	●
330-D	3.3						●	●	●
350-D	3.5						●	●	●
400-D	4.0						●	●	●
GEL 100-E	1.0	0.05	2.5	9.54	21.7	4.4	●	●	●
150-E	1.5	0.1	3.0				●	●	●
170-E	1.7						●	●	●
185-E	1.85						●	●	●
195-E	1.95						●	●	●
200-E	2.0		3.2				●	●	●
225-E	2.25						●	●	●
230-E	2.3	0.2					●	●	●
250-E	2.5		4.5				●	●	●
275-E	2.75						●	●	●
280-E	2.8						●	●	●
300-E	3.0						●	●	●
330-E	3.3						●	●	●
350-E	3.5		5.5				●	●	●
400-E	4.0						●	●	●
430-E	4.3		6.5				●	●	●
450-E	4.5						●	●	●
460-E	4.6						●	●	●
500-E	5.0						●	●	●
GEL 250-125ER	2.5	1.25	5.5	9.54	21.7	4.4	●	●	●
300-150ER	3.0	1.5					●	●	●
350-175ER	3.5	1.75					●	●	●
400-200ER	4.0	2.0	6.5				●	●	●
450-225ER	4.5	2.25					●	●	●
500-250ER	5.0	2.5					●	●	●
GEL 150DM10-E	1.5	0.1	3.6	9.54	21.7	4.4	●	●	●
200DM10-E	2.0	0.1	4.8				●	●	●
250DM15-E	2.5	0.2	6.0				●	●	●
300DM15-E	3.0	0.2	6.5				●	●	●
400DM15-E	4.0	0.2	6.5				●	●	●
450DM15-E	4.5	0.2	6.5				●	●	●
500DM15-E	5.0	0.2	6.5				●	●	●
GEL 150DM10R075-E	1.5	0.75	3.6	9.54	21.7	4.4	●	●	●
200DM10R100-E	2.0	1.0	4.8				●	●	●
250DM15R125-E	2.5	1.25	6.0				●	●	●
300DM15R150-E	3.0	1.5	6.5				●	●	●
400DM15R200-E	4.0	2.0	6.5				●	●	●
500DM15R250-E	5.0	2.5	6.5				●	●	●

GR 小零件 小孔 内孔切槽

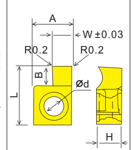
内孔车刀:B113
(Internal Toolholder)

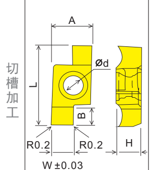
切削线速度(Cutting Speed): m/min⁻¹ (mm)

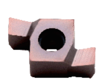
加工材料 Material	刀具材质 Cutter Material / 材质特点 Material Characteristics	PCD 金刚石 Diamond	CBN-K 铸铁专用 Cast Iron	CBN-S 难切削材用 Hardened Material	ZN60 光洁度好 Good Surface	ZN90 高速精加工 Finishing	ZK01 铜铝加工 Copper/Aluminum	ZC250 CVD 钢件 CVD Steel	ZC251 CVD 钢件 CVD Steel	ZC32S 钢件高速 Steel High Speed	ZP152 不锈钢通用 Stainless Steel	ZP153 不锈钢高速 Stainless Steel	ZP163 高硬高速 HRC60 High Speed	ZK50 CVD 铸铁 CVD Cast Iron	ZK50S 铸铁高速 CVD High Speed
P	低碳钢 Low-Carbon steel				150-600	150-800		70-500	150-500	150-600	70-250	100-250	80-300		
P	高碳钢 High-Carbon steel				150-350	150-500		70-250	80-350	100-400	70-150	80-150	60-200		
P	淬硬钢 HRC46-58 Hardened Steel			10-30							20-60	20-60	20-80		
M	不锈钢				200-300	200-350					50-150	70-150	50-200		
K	灰口铸铁 Gray Cast Iron		300-1500		100-300	100-350								200-300	200-350
K	球墨铸铁/轧辊 Ductile Iron		400-800		100-200	100-250								150-200	150-250
N	镁/锌/塑料/木材 Magnesium/Zinc/Plastic/Wood	300-1200					300-1200								
N	铝合金 HB50-70 Aluminum Alloy	300-1500					300-1500								
N	淬硬铝合金 HB70-110 Hardened Aluminum Alloy	300-800					300-800								
N	铜/青铜/黄铜 Copper/Bronze/Brass	300-1000					300-1000								
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy	10-30					10-30						20-50		
S	硅填充塑料硬质纤维 Silicon Filled Plastic Hard Fiber	400-600					400-600								
H	钛/高温合金/碳纤维 Titanium/Superalloy/Carbon Fiber	100-200					100-200					20-50	20-60	30-80		

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✣ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
P	钢	Steel			●	●		✣	◐	✣	◐
M	不锈钢	Stainless Steel				●				✣	◐
K	铸铁	Iron		●		●				✣	
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐				
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✣	◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✣	◐





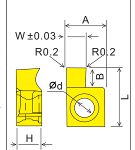


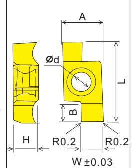
用途 Application	规格型号 Specification	W	B	A	L	H	Ød	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切槽加工 Grooving	6GR 100	1.0	1.5	5.56	6.44	2.34	2.3				●	●			●	
	6GR 150	1.5	1.5								●	●			●	
	6GR 200	2.0	1.5								●	●			●	
	7GR 100	1.0	1.5	5.56	7.36	3.08	2.58				●	●			●	
	7GR 150	1.5	1.5								●	●			●	
	7GR 200	2.0	1.5								●	●			●	
切槽加工 Grooving	8GR 100	1.0	1.5	5.56	10.2	3.87	2.58				●	●			●	
	8GR 150	1.5	2.0								●	●			●	
	8GR 200	2.0	2.0								●	●			●	
	8GR 250	2.5	2.0								●	●			●	
	8GR 300	3.0	2.0								●	●			●	
	8GR 350	3.5	2.0								●	●			●	
	9GR 100	1.0	1.5	6.35	13.0	4.66	2.86				●	●			●	
	9GR 150	1.5	2.0								●	●			●	
	9GR 200	2.0	3.0								●	●			●	
	9GR 250	2.5	3.0								●	●			●	
	9GR 300	3.0	3.0								●	●			●	
	9GR 350	3.5	3.0								●	●			●	
	15GR 100	1.0	1.5	9.2	20.8	5.1	4.8									
	15GR 150	1.5	2.0													
	15GR 200	2.0	3.0													
	15GR 250	2.5	3.0													
	15GR 300	3.0	3.0													
	15GR 350	3.5	3.0													
	15GR 400	4.0	4.0													
	15GR 450	4.5	4.0													
	15GR 500	5.0	5.0													

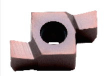
Dimensioning 尺寸标示 / Product Image 产品图片

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✣ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
P	钢	Steel			●	●		✣	◐	✣	◐
M	不锈钢	Stainless Steel				●				✣	◐
K	铸铁	Iron		●		●				✣	
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐				
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✣	◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✣	◐







用途 Application	规格型号 Specification	W	B	A	L	H	Ød	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC250	ZC251	ZP152	ZP153
切槽加工 Grooving	6GL 100	1.0	1.5	5.56	6.44	2.34	2.3				●	●			●	
	6GL 150	1.5	1.5								●	●			●	
	6GL 200	2.0	1.5								●	●			●	
	7GL 100	1.0	1.5	5.56	7.36	3.08	2.58				●	●			●	
	7GL 150	1.5	1.5								●	●			●	
	7GL 200	2.0	1.5								●	●			●	
切槽加工 Grooving	8GL 100	1.0	1.5	5.56	10.2	3.87	2.58				●	●			●	
	8GL 150	1.5	2.0								●	●			●	
	8GL 200	2.0	2.0								●	●			●	
	8GL 250	2.5	2.0								●	●			●	
	8GL 300	3.0	2.0								●	●			●	
	8GL 350	3.5	2.0								●	●			●	
	9GL 100	1.0	1.5	6.35	13.0	4.66	2.86				●	●			●	
	9GL 150	1.5	2.0								●	●			●	
	9GL 200	2.0	3.0								●	●			●	
	9GL 250	2.5	3.0								●	●			●	
	9GL 300	3.0	3.0								●	●			●	
	9GL 350	3.5	3.0								●	●			●	
	15GL 100	1.0	1.5	9.2	20.8	5.1	4.8									
	15GL 150	1.5	2.0													
	15GL 200	2.0	3.0													
	15GL 250	2.5	3.0													
	15GL 300	3.0	3.0													
	15GL 350	3.5	3.0													
	15GL 400	4.0	4.0													
	15GL 450	4.5	4.0													
	15GL 500	5.0	5.0													

Dimensioning 尺寸标示 / Product Image 产品图片

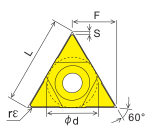
数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 T.N/E GER GR
螺纹车削刀片
铣削刀片

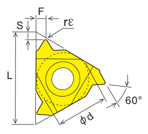
ISO 60°牙型 公制 螺纹刀片

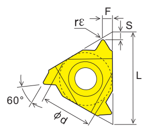
螺纹应用领域：一般工业
Thread Application: General Industry

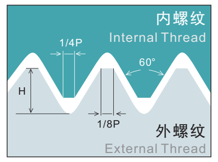
材质 Material		切削形态: Cutting Environment	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✤	◐	◐	◐
M	不锈钢	Stainless Steel				○		○	○	✤	○	○	○
K	铸铁	Iron		●		◐		◐		✤	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✤			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✤			◐

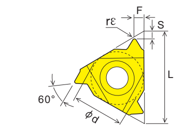
● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　○ 一般切削(第二推荐) General Cutting(Second recommend)　✤ 不稳定切削 Unstable Cutting

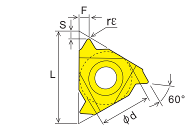

U 型

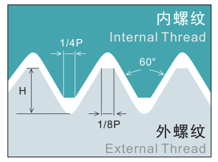

ER 型


EL 型




IR 型


IL 型



外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	螺距 Pitch of Screw (mm)	(tpi)	尺寸 Dimension (mm) ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER A60	11EL A60	0.5-1.5	48-16	6.35	11	0.05	0.8	0.9	●	●	●		●	●	●	●	●	●	●
	(ERM) AG60	AG60	0.5-2.5	48-10			0.05	0.9	1.2	●	●	●		●	●	●	●	●	●	●
	16ER A60	16EL A60	0.5-1.5	48-16	9.525	16	0.05	0.8	0.9	●	●	●		●	●	●	●	●	●	●
	(ERM) G60	G60	1.75-3.0	14-8			0.27	1.2	1.7	●	●	●		●	●	●	●	●	●	●
	AG60	AG60	0.5-3.0	48-8			0.08	1.2	1.7	●	●	●		●	●	●	●	●	●	●
	22ER N60 (ERM)	22EL N60	3.5-5.0	7-5	12.7	22	0.53	1.7	2.5	●	●	●		●	●	●	●	●	●	●
	27ER Q60	27EL Q60	5.5-6.0	4.5-4	15.875	27	0.64	2.1	3.1	●	●	●		●	●	●	●	●	●	●

用途 Application	规格型号 Specification [ER]	[EL]	螺距 Pitch (tpi)	切深 Depth Hmin	尺寸 Dimension (mm) ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER 035 ISO	11EL 035 ISO	0.35	0.21	6.35	11	0.04	0.8	0.4					●				●	●	●
	(ERM) 040 ISO	040 ISO	0.40	0.25			0.04	0.7	0.4					●				●	●	●
	045 ISO	045 ISO	0.45	0.28			0.05	0.7	0.4					●				●	●	●
	050 ISO	050 ISO	0.50	0.31			0.04	0.6	0.4					●				●	●	●
	060 ISO	060 ISO	0.60	0.37			0.07	0.6	0.6					●				●	●	●
	070 ISO	070 ISO	0.70	0.43			0.07	0.6	0.6					●				●	●	●
	075 ISO	075 ISO	0.75	0.46			0.08	0.6	0.6					●				●	●	●
	080 ISO	080 ISO	0.80	0.49			0.09	0.6	0.6					●				●	●	●
	100 ISO	100 ISO	1.00	0.61			0.12	0.7	0.7	●	●	●		●	●	●	●	●	●	●
	125 ISO	125 ISO	1.25	0.77			0.15	0.8	0.9					●				●	●	●
	150 ISO	150 ISO	1.50	0.92			0.18	0.8	1.0	●	●	●		●	●	●	●	●	●	●
	175 ISO	175 ISO	1.75	1.07			0.21	0.8	1.1					●				●	●	●
	16ER 035 ISO	16EL 035 ISO	0.35	0.21	9.525	16	0.04	0.8	0.4					●				●	●	●
	(ERM) 040 ISO	040 ISO	0.40	0.25			0.04	0.7	0.4					●				●	●	●
	045 ISO	045 ISO	0.45	0.28			0.05	0.7	0.4					●				●	●	●
	050 ISO	050 ISO	0.50	0.31			0.04	0.6	0.4	●	●	●		●	●	●	●	●	●	●
	060 ISO	060 ISO	0.60	0.37			0.07	0.6	0.6					●				●	●	●
	070 ISO	070 ISO	0.70	0.43			0.07	0.6	0.6					●				●	●	●
	075 ISO	075 ISO	0.75	0.46			0.08	0.6	0.6					●				●	●	●
	080 ISO	080 ISO	0.80	0.49			0.09	0.6	0.6					●				●	●	●
	100 ISO	100 ISO	1.00	0.61			0.12	0.7	0.7	●	●	●		●	●	●	●	●	●	●
	125 ISO	125 ISO	1.25	0.77			0.15	0.8	0.9					●				●	●	●
	150 ISO	150 ISO	1.50	0.92			0.18	0.8	1.0	●	●	●		●	●	●	●	●	●	●
	175 ISO	175 ISO	1.75	1.07			0.21	0.9	1.2					●				●	●	●
	200 ISO	200 ISO	2.00	1.23			0.25	1.0	1.3	●	●	●		●	●	●	●	●	●	●
	250 ISO	250 ISO	2.50	1.53			0.31	1.1	1.5	●	●	●		●	●	●	●	●	●	●
	300 ISO	300 ISO	3.00	1.84			0.38	1.2	1.6	●	●	●		●	●	●	●	●	●	●
	350 ISO	350 ISO	3.50	2.15			0.44	1.6	2.3	●	●	●		●	●	●	●	●	●	●
	22ER 350 ISO	22EL 350 ISO	3.50	2.15	12.7	22	0.44	1.6	2.3	●	●	●		●	●	●	●	●	●	●
	(ERM) 400 ISO	400 ISO	4.00	2.45			0.52	1.6	2.3	●	●	●		●	●	●	●	●	●	●
	450 ISO	450 ISO	4.50	2.78			0.58	1.7	2.4	●	●	●		●	●	●	●	●	●	●
	500 ISO	500 ISO	5.00	3.07			0.64	1.7	2.5	●	●	●		●	●	●	●	●	●	●
	27ER 550 ISO	27EL 550 ISO	5.50	3.37	15.875	27	0.70	1.9	2.7					●				●	●	●
	(ERM) 600 ISO	600 ISO	6.00	3.68			0.78	2.0	2.9					●				●	●	●

用途 Application	规格型号 Specification [U]	螺距 Pitch of Screw (mm)	(tpi)	尺寸 Dimension (mm) ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	22UER U60	5.5-8.0	4.5-3.25	12.7	22	0.28	0.6	11.0					●				●	●	
	27UER U60	6.5-9.0	4-2.75	15.88	27	0.28	1.0	13.7					●				●	●	
	22UER 550 ISO	5.5		12.7	22	0.70	2.3	11.0					●				●	●	
	600 ISO	6.0		12.7	22	0.78	2.6	11.0					●				●	●	
	27UER 800 ISO	8.0		15.88	27	1.08	2.4	13.7					●				●	●	
	22UIR 550 ISO	5.5		12.7	22	0.35	2.4	11.0					●				●	●	
	600 ISO	6.0		12.7	22	0.39	2.1	11.0					●				●	●	
	27UIR 800 ISO	8.0		15.88	27	0.53	2.4	13.7					●				●	●	

内孔车刀 (Internal Toolholder): B75-B77

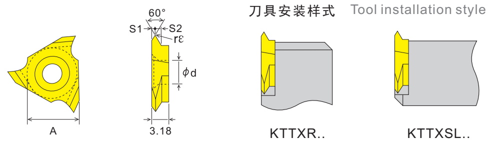
用途 Application	规格型号 Specification [IR]	[IL]	螺距 Pitch of Screw (mm)	(tpi)	尺寸 Dimension (mm) ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	06IR A60	06IL A60	0.5-1.25	48-20	3.97	6	0.05	0.5	0.6	●	●	●		●	●	●	●	●	●	●
	08IR A60	08IL A60	0.5-1.5	48-16	4.76	8	0.05	0.6	0.7	●	●	●		●	●	●	●	●	●	●
	11IR A60	11EL A60	0.5-1.5	48-16	6.35	11	0.05	0.8	0.9	●	●	●		●	●	●	●	●	●	●
	(IRM) AG60	AG60	0.5-2.5	48-10			0.05	0.9	1.2	●	●	●		●	●	●	●	●	●	●
	16IR A60	16EL A60	0.5-1.5	48-16	9.525	16	0.05	0.8	0.9	●	●	●		●	●	●	●	●	●	●
	(IRM) G60	G60	1.75-3.0	14-8			0.16	1.2	1.7	●	●	●		●	●	●	●	●	●	●
	AG60	AG60	0.5-3.0	48-8			0.05	1.2	1.7	●	●	●		●	●	●	●	●	●	●
	22IR N60 (IRM)	22EL N60	3.5-5.0	7-5	12.7	22	0.30	1.7	2.5	●	●	●		●	●	●	●	●	●	●
	27IR Q60	27EL Q60	5.5-6.0	4.5-4	15.875	27	0.30	1.8	2.7	●	●	●		●	●	●	●	●	●	●

用途 Application	规格型号 Specification [IR]	[IL]	螺距 Pitch (tpi)	切深 Depth Hmin	尺寸 Dimension (mm) ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	06IR 050ISO	06IL 050ISO	0.50	0.29	3.97	6	0.03	0.5	0.5					●				●	●	●
	075ISO	075ISO	0.75	0.43			0.04	0.5	0.5					●				●	●	●
	100ISO	100ISO	1.00	0.58			0.05	0.5	0.6					●				●	●	●
	125ISO	125ISO	1.25	0.72			0.07	0.6	0.6					●				●	●	●
	08IR 050ISO	08IL 050ISO	0.50	0.29	4.76	8	0.04	0.6	0.5					●				●	●	●
	075ISO	075ISO	0.75	0.43			0.05	0.6	0.5					●				●	●	●
	100ISO	100ISO	1.00	0.58			0.05	0.6	0.6					●				●	●	●
	125ISO	125ISO	1.25	0.72			0.07	0.6	0.6					●				●	●	●
	150ISO	150ISO	1.50	0.87			0.08	0.6	0.7					●				●	●	●
	175ISO	175ISO	1.75	1.01			0.10	0.6	0.8					●				●	●	●
	11IR 035 ISO	11IL 035 ISO	0.35	0.20	6.35	11	0.02	0.8	0.3					●				●	●	●
	(IRM) 040 ISO	040 ISO	0.40	0.23			0.02	0.8	0.4					●				●	●	●
	045 ISO	045 ISO	0.45	0.26			0.02	0.8	0.4					●				●	●	●
	050 ISO	050 ISO	0.50	0.29			0.03	0.6	0.4	●	●	●		●	●	●	●	●	●	●
	060 ISO	060 ISO	0.60	0.35			0.03	0.6	0.6					●				●	●	●
	070 ISO	070 ISO	0.70	0.40			0.04	0.6	0.6					●				●	●	●
	075 ISO	075 ISO	0.75	0.43			0.04	0.6	0.6					●				●	●	●
	080 ISO	080 ISO	0.80	0.46			0.04	0.6	0.6					●				●	●	●
	100 ISO	100 ISO	1.00	0.58			0.05	0.6	0.7	●	●	●		●	●	●	●	●	●	●
	125 ISO	125 ISO	1.25	0.72			0.07	0.8	0.9					●				●	●	●
	150 ISO	150 ISO	1.50	0.87			0.08	0.8	1.0	●	●	●		●	●	●	●	●	●	●
	175 ISO	175 ISO	1.75	1.01			0.10	0.9	1.1					●				●	●	●
	200 ISO	200 ISO	2.00	1.15			0.12	0.9	1.1	●	●	●		●	●	●	●	●	●	●
	250 ISO	250 ISO	2.50	1.44			0.15	0.9	1.1	●	●	●		●	●	●	●	●	●	●
	16IR 035 ISO	16IL 035 ISO	0.35	0.20	9.525	16	0.02	0.8	0.3					●				●	●	●
	(IRM) 040 ISO	040 ISO	0.40	0.23			0.02	0.8	0.4					●				●	●	●
	045 ISO	045 ISO	0.45	0.26			0.02	0.8	0.4					●				●	●	●
	050 ISO	050 ISO	0.50	0.29			0.03	0.6	0.4	●	●	●		●	●	●	●	●	●	●
	060 ISO	060 ISO	0.60	0.35			0.03	0.6	0.6					●				●	●	●
	070 ISO	070 ISO	0.70	0.40			0.04	0.6	0.6					●				●	●	●
	075 ISO	075 ISO	0.75	0.43			0.04	0.6	0.6					●				●	●	●
	080 ISO	080 ISO	0.80	0.46			0.04	0.6	0.6					●				●	●	●
	100 ISO	100 ISO	1.00	0.58			0.05	0.6	0.7	●	●	●		●	●	●	●	●	●	●
	125 ISO	125 ISO	1.25	0.72			0.07	0.8	0.9					●				●	●	●
	150 ISO	150 ISO	1.50	0.87			0.08	0.8	1.0	●	●	●		●	●	●	●	●	●	●
	175 ISO	175 ISO	1.75	1.01			0.10	0.9	1.1					●				●	●	●
	200 ISO	200 ISO	2.00	1.15			0.12	1.0	1.3	●	●	●		●	●	●	●	●	●	●
	250 ISO	250 ISO	2.50	1.44			0.15	1.1	1.5	●	●	●		●	●	●	●	●	●	●
	300 ISO	300 ISO	3.00	1.73			0.18	1.1	1.5	●	●	●		●	●	●	●	●	●	●
	350 ISO	350 ISO	3.50	2.02			0.22	1.6	2.3	●	●	●		●	●	●	●	●	●	●
	22IR 350 ISO	22IL 350 ISO	3.50	2.02	12.7	22	0.22	1.6	2.3					●				●	●	●
	(IRM) 400 ISO	400 ISO	4.00	2.31			0.25	1.6	2.3					●				●	●	●
	450 ISO	450 ISO	4.50	2.60			0.29	1.6	2.4					●				●	●	●
	500 ISO	500 ISO	5.00	2.89			0.32	1.6	2.3					●				●	●	●
	27IR 550 ISO	27IL 550 ISO	5.50	3.17	15.875	27	0.35	1.6	2.3					●				●	●	●
	(IRM) 600 ISO	600 ISO	6.00	3.46			0.39	1.8	2.5					●				●	●	●

TTX32R

外圆车刀：AB26/B71 (External Toolholder)
内孔车刀：B74 (Internal Toolholder)

刀具安装样式 Tool installation style

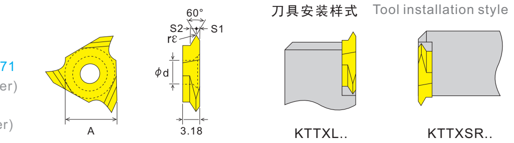


用途 Application	规格型号 Specification		螺距 Pitch of Screw (mm)	(tpi)	尺寸 Dimension (mm) rε	S1	S2	A	ϕd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TTX32R	6000	0.5-1.0	56-32	0.00	0.6	1.12	9.525	4.4					●	●	●		●	●	
		6000S	0.5-1.0	56-32	0.00	0.3	1.12							●	●	●		●	●	
		60005	0.5-1.0	48-32	0.05	0.6	1.12							●	●	●		●	●	
		60005S	0.5-1.0	48-32	0.05	0.3	1.12							●	●	●		●	●	
		6001	1.0-2.0	28-14	0.1	1.1	1.62							●	●	●		●	●	
		6002	1.5-2.5	16-10	0.2	1.1	1.62							●	●	●		●	●	
		6003	2.5	11-10	0.3	1.1	1.62							●	●	●		●	●	

TTX32L

外圆车刀：AB26/B71 (External Toolholder)
内孔车刀：B74 (Internal Toolholder)

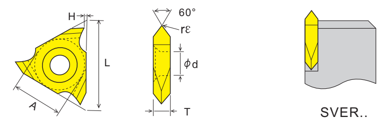
刀具安装样式 Tool installation style



用途 Application	规格型号 Specification		螺距 Pitch of Screw (mm)	(tpi)	尺寸 Dimension (mm) rε	S1	S2	A	ϕd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TTX32L	6000	0.5-1.0	56-32	0.00	0.6	1.12	9.525	4.4					●	●	●		●	●	
		6000S	0.5-1.0	56-32	0.00	0.3	1.12							●	●	●		●	●	
		60005	0.5-1.0	48-32	0.05	0.6	1.12							●	●	●		●	●	
		60005S	0.5-1.0	48-32	0.05	0.3	1.12							●	●	●		●	●	
		6001	1.0-2.0	28-14	0.1	1.1	1.62							●	●	●		●	●	
		6002	1.5-2.5	16-10	0.2	1.1	1.62							●	●	●		●	●	
		6003	2.5	11-10	0.3	1.1	1.62							●	●	●		●	●	

VER..

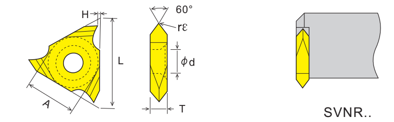
外圆车刀：B73 (External Toolholder)



用途 Application	规格型号 Specification [VER]		螺距 Pitch (mm)	尺寸 Dimension (mm) H	rε	L	T	A	ϕd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	16VER	AG60	0.5-3.0	-	0.07	16	3.65	9.525	4.0					●				●	●	
		100ISO	1.0	0.7	0.07									●				●	●	
		150ISO	1.5	1.0	0.11									●				●	●	
		200ISO	2.0	1.3	0.14									●				●	●	
		250ISO	2.5	1.5	0.18									●				●	●	
		300ISO	3.0	1.6	0.22									●				●	●	
	22VER	400ISO	4.0	2.0	0.29	22	4.9	12.7	5.1					●				●	●	
		500ISO	5.0	2.4	0.36									●				●	●	
		600ISO	6.0	2.7	0.43									●				●	●	
	27VER	V60	6.0-9.0	-	0.87	27	8.7	15.87	6.35					●				●	●	
		800ISO	8.0	-										●				●	●	
		10.0ISO	10.0	-										●				●	●	

VNR..

内孔车刀：B74 (Internal Toolholder)

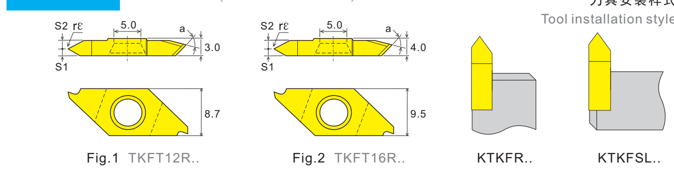


用途 Application	规格型号 Specification [VNR]		螺距 Pitch (mm)	尺寸 Dimension (mm) H	rε	L	T	A	ϕd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	16VNR	AG60	0.5-3.0	-	0.07	16	3.65	9.525	4.0					●				●	●	
		100ISO	1.0	0.7	0.07									●				●	●	
		150ISO	1.5	1.0	0.08									●				●	●	
		200ISO	2.0	1.3	0.12									●				●	●	
		250ISO	2.5	1.5	0.15									●				●	●	
		300ISO	3.0	1.6	0.18									●				●	●	
	22VNR	400ISO	4.0	2.0	0.25	22	4.9	12.7	5.1					●				●	●	
		500ISO	5.0	2.4	0.32									●				●	●	
		600ISO	6.0	2.7	0.39									●				●	●	
	27VNR	V60	6.0-9.0	-	0.43	27	8.7	15.87	6.35					●				●	●	
		800ISO	8.0	-										●				●	●	
		10.0ISO	10.0	-										●				●	●	

TKFT..R..

(External Toolholder): AB25/B72

刀具安装样式 Tool installation style

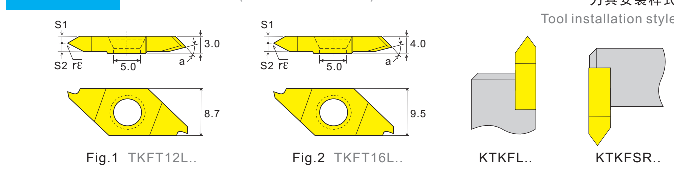


用途 Application	规格型号 Specification		螺距 Pitch of Screw (mm)	(tpi)	尺寸 Dimension (mm) rε	S1	S2	a	Fig	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TKFT12R	A6000	0.2-0.6	64-48	<0.05	0.4	2.1	60°	1					●	●	●			●	
		B6000	0.2-0.6	64-48	<0.05	2.1	0.4							●	●	●			●	
		A60005	0.5-1.25	48-24	0.05	0.8	1.7							●	●	●			●	
		B60005	0.5-1.25	48-24	0.05	1.7	0.8							●	●	●			●	
		N6001	1.0-1.50	24-18	0.1	1.25	1.25							●	●	●			●	
	TKFT16R	A6000	0.2-0.6	64-48	<0.05	0.4	2.1	60°	2					●	●	●			●	
		B6000	0.2-0.6	64-48	<0.05	2.1	0.4							●	●	●			●	
		A60005	0.5-1.25	48-24	0.05	0.8	1.7							●	●	●			●	
		B60005	0.5-1.25	48-24	0.05	1.7	0.8							●	●	●			●	
		N6001	1.0-1.50	24-18	0.1	1.25	1.25							●	●	●			●	

TKFT..L..

外圆车刀 (External Toolholder): AB25/B72

刀具安装样式 Tool installation style

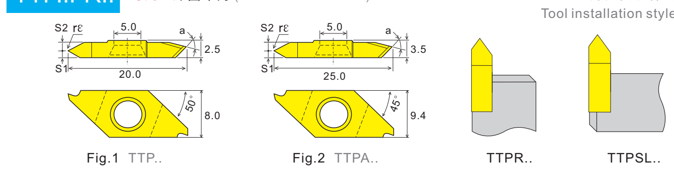


用途 Application	规格型号 Specification		螺距 Pitch of Screw (mm)	(tpi)	尺寸 Dimension (mm) rε	S1	S2	a	Fig	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TKFT12L	A6000	0.2-0.6	64-48	<0.05	2.1	0.4	60°	1					●	●	●			●	
		B6000	0.2-0.6	64-48	<0.05	0.4	2.1							●	●	●			●	
		A60005	0.5-1.25	48-24	0.05	1.7	0.8							●	●	●			●	
		B60005	0.5-1.25	48-24	0.05	0.8	1.7							●	●	●			●	
		N6001	1.0-1.50	24-18	0.1	1.25	1.25							●	●	●			●	
	TKFT16L	A6000	0.2-0.6	64-48	<0.05	2.1	0.4	60°	2					●	●	●			●	
		B6000	0.2-0.6	64-48	<0.05	0.4	2.1							●	●	●			●	
		A60005	0.5-1.25	48-24	0.05	1.7	0.8							●	●	●			●	
		B60005	0.5-1.25	48-24	0.05	0.8	1.7							●	●	●			●	
		N6001	1.0-1.50	24-18	0.1	1.25	1.25							●	●	●			●	

TTP..FR..

外圆车刀 (External Toolholder): AB22

刀具安装样式 Tool installation style

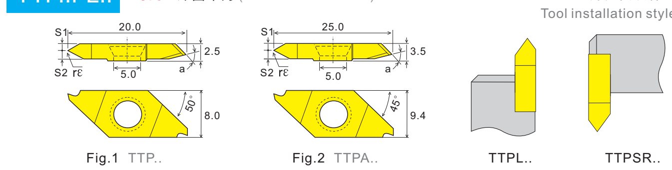


用途 Application	规格型号 Specification		螺距 Pitch of Screw (mm)	(tpi)	尺寸 Dimension (mm) rε	S1	S2	a	Fig	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TTP60	FR4A	0.2-0.6	64-48	<0.05	0.4	2.1	60°	1					●	●	●			●	
		FR4B	0.2-0.6	64-48	<0.05	2.1	0.4							●	●	●			●	
		FR8A	0.5-1.25	48-24	0.05	0.8	1.7							●	●	●			●	
		FR8B	0.5-1.25	48-24	0.05	1.7	0.8							●	●	●			●	
		FRN	1.0-1.50	24-18	0.1	1.25	1.25							●	●	●			●	
		FRN02	1.0-1.50	24-18	0.2	1.25	1.25							●	●	●			●	
	TTPA60	FR4A	0.2-0.6	64-48	<0.05	0.4	2.1	60°	2					●	●	●			●	
		FR4B	0.2-0.6	64-48	<0.05	2.1	0.4							●	●	●			●	
		FR8A	0.5-1.25	48-24	0.05	0.8	1.7							●	●	●			●	
		FR8B	0.5-1.25	48-24	0.05	1.7	0.8							●	●	●			●	
		FRN	1.0-1.50	24-18	0.1	1.25	1.25							●	●	●			●	
		FRN02	1.0-1.50	24-18	0.2	1.25	1.25							●	●	●			●	

TTP..FL..

外圆车刀 (External Toolholder): Ab22

刀具安装样式 Tool installation style



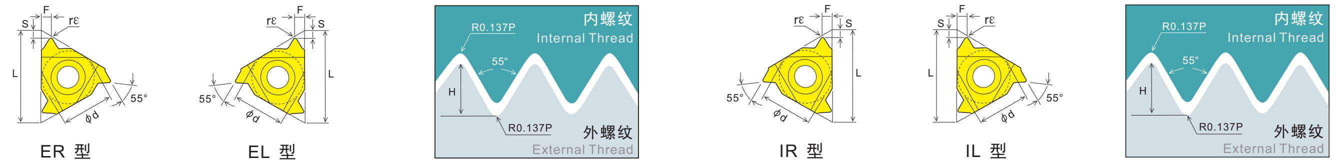
用途 Application	规格型号 Specification		螺距 Pitch of Screw (mm)	(tpi)	尺寸 Dimension (mm) rε	S1	S2	a	Fig	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TTP60	FL4A	0.2-0.6	64-48	<0.05	0.4	2.1	60°	1					●	●	●			●	
		FL4B	0.2-0.6	64-48	<0.05	0.4	2.1							●	●	●			●	
		FL8A	0.5-1.25	48-24	0.05	1.7	0.8							●	●	●			●	
		FL8B	0.5-1.25	48-24	0.05	0.8	1.7							●	●	●			●	
		FLN	1.0-1.50	24-18	0.1	1.25	1.25							●	●	●			●	
		FLN02	1.0-1.50	24-18	0.2	1.25	1.25							●	●	●			●	
	TTPA60	FL4A	0.2-0.6	64-48	<0.05	0.4	2.1	60°	2					●	●	●			●	
		FL4B	0.2-0.6	64-48	<0.05	2.1	0.4							●	●	●			●	
		FL8A	0.5-1.25	48-24	0.05	1.7	0.8							●	●	●			●	
		FL8B	0.5-1.25	48-24	0.05	0.8	1.7							●	●	●			●	
		FLN	1.0-1.50	24-18	0.1	1.25	1.25							●	●	●			●	
		FLN02	1.0-1.50	24-18	0.2	1.25	1.25							●	●	●			●	

数控刀片 CN DN RN KN 175 SN TN VN WN | CC DC RC SC WB TB TC TP VB VC | 三角浅槽 TGF GBA T.N/E | 小零件 CTP TKF | 切槽切断 MG. MR. SP. GMM TDC | 后车削 ABS TBP TKFB | 内孔切槽 GER GR | 螺纹车削刀片 | 铣削刀片

W 55°全牙型 英制/惠氏 BSW,BSF,BSP,BSB

螺纹应用领域：工业机械用管螺纹
Thread Application: Pipe thread for industrial machinery

材质 Material	切削形态 Cutting Environment: 稳定切削 Stable Cutting / 一般切削 General Cutting / 一般切削(第二推荐) General Cutting(Second recommend) / 不稳定切削 Unstable Cutting
P	钢 Steel
M	不锈钢 Stainless Steel
K	铸铁 Iron
N	铝/铜/镁/锌/塑料/木材 Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金 Carbide/Powder Metallurgy
H	钛/高温合金/硬纤维 Titanium/Superalloy/Carbon Fiber



外圆车刀 (External Toolholder): B69

用途 Application	规格型号 [ER]	[EL]	螺距 (mm)	(tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER A55 (ERM) AG55	11EL A55 AG55	0.5-1.5 / 0.5-2.5	48-16 / 48-10	6.35	11	0.05 / 0.05	0.8 / 0.9	0.9 / 1.2	●	●	●	●	●	●	●	●	●	●	●
	16ER A55 (ERM) G55 AG55	16EL A55 G55 AG55	0.5-1.5 / 1.75-3.0 / 0.5-3.0	48-16 / 14-8 / 48-8	9.525	16	0.05 / 0.21 / 0.07	0.8 / 1.2 / 1.2	0.9 / 1.7 / 1.7	●	●	●	●	●	●	●	●	●	●	●
	22ER N55 (ERM)	22EL N55	3.5-5.0	7-5	12.7	22	0.43	1.7	2.5	●	●	●	●	●	●	●	●	●	●	●
	27ER Q55	27EL Q55	5.5-6.0	4.5-4	15.875	27	0.60	2.0	2.9	●	●	●	●	●	●	●	●	●	●	●

用途 Application	规格型号 [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER 72 W	11EL 72 W	0.23	72	6.35	11	0.02	0.7	0.4					●				●	●	●
	(ERM) 60 W	60 W	0.27	60			0.02	0.7	0.4					●				●	●	●
	56 W	56 W	0.29	56			0.02	0.7	0.4					●				●	●	●
	48 W	48 W	0.34	48			0.04	0.6	0.6					●				●	●	●
	40 W	40 W	0.41	40			0.06	0.6	0.6					●				●	●	●
	36 W	36 W	0.45	36			0.07	0.6	0.6					●				●	●	●
	32 W	32 W	0.51	32			0.09	0.6	0.6					●				●	●	●
	28 W	28 W	0.58	28			0.09	0.6	0.7					●				●	●	●
	26 W	26 W	0.63	26			0.10	0.7	0.8					●				●	●	●
	24 W	24 W	0.68	24			0.11	0.7	0.8					●				●	●	●
	22 W	22 W	0.74	22			0.13	0.8	0.9					●				●	●	●
	20 W	20 W	0.81	20			0.14	0.8	0.9	●	●	●		●	●	●	●	●	●	●
	19 W	19 W	0.86	19			0.15	0.8	1.0					●				●	●	●
	18 W	18 W	0.90	18			0.16	0.8	1.0	●	●	●		●	●	●	●	●	●	●
	16 W	16 W	1.02	16			0.18	0.9	1.1					●				●	●	●
	14 W	14 W	1.16	14			0.21	1.0	1.2					●				●	●	●
	16ER 72 W	16EL 72 W	0.23	72	9.525	16	0.02	0.7	0.4					●				●	●	●
	(ERM) 60 W	60 W	0.27	60			0.02	0.7	0.4					●				●	●	●
	56 W	56 W	0.29	56			0.02	0.7	0.4	●	●	●		●	●	●	●	●	●	●
	48 W	48 W	0.34	48			0.04	0.6	0.6					●				●	●	●
	40 W	40 W	0.41	40			0.06	0.6	0.6					●				●	●	●
	36 W	36 W	0.45	36			0.06	0.6	0.6					●				●	●	●
	32 W	32 W	0.51	32			0.09	0.6	0.6					●				●	●	●
	30 W	30 W	0.55	30			0.09	0.6	0.7					●				●	●	●
	28 W	28 W	0.58	28			0.09	0.6	0.7	●	●	●		●	●	●	●	●	●	●
	26 W	26 W	0.63	26			0.10	0.7	0.8					●				●	●	●
	24 W	24 W	0.68	24			0.11	0.7	0.8					●				●	●	●
	22 W	22 W	0.74	22			0.13	0.8	0.9					●				●	●	●
	20 W	20 W	0.81	20			0.14	0.8	0.9	●	●	●		●	●	●	●	●	●	●
	19 W	19 W	0.86	19			0.15	0.8	1.0					●				●	●	●
	18 W	18 W	0.90	18			0.16	0.8	1.0					●				●	●	●
	16 W	16 W	1.02	16			0.18	0.9	1.1	●	●	●		●	●	●	●	●	●	●
	14 W	14 W	1.16	14			0.21	1.0	1.2	●	●	●		●	●	●	●	●	●	●
	12 W	12 W	1.36	12			0.25	1.1	1.4	●	●	●		●	●	●	●	●	●	●
	11 W	11 W	1.48	11			0.27	1.1	1.5	●	●	●		●	●	●	●	●	●	●
	10 W	10 W	1.63	10			0.31	1.1	1.5	●	●	●		●	●	●	●	●	●	●
	09 W	09 W	1.81	9			0.34	1.2	1.5	●	●	●		●	●	●	●	●	●	●
	08 W	08 W	2.03	8			0.39	1.2	1.7	●	●	●		●	●	●	●	●	●	●
	22ER 07 W	22EL 07 W	2.32	7	12.7	22	0.45	1.6	2.3	●	●	●		●	●	●	●	●	●	●
	(ERM) 06 W	06 W	2.71	6			0.52	1.6	2.3	●	●	●		●	●	●	●	●	●	●
	05 W	05 W	3.25	5			0.65	1.7	2.4	●	●	●		●	●	●	●	●	●	●
	27ER 4.5 W	27EL 4.5 W	3.25	4.5	15.875	27	0.73	1.8	2.6					●				●	●	●
	(ERM) 4 W	4 W	3.61	4			0.82	2.0	2.9					●				●	●	●

内孔车刀 (Internal Toolholder): B75-B77

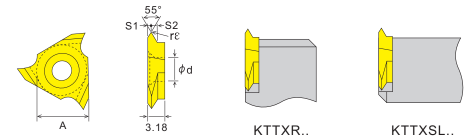
用途 Application	规格型号 [IR]	[IL]	螺距 (mm)	(tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	06IR A55	06IL A55	0.5-1.25	48-20	3.97	6	0.05	0.6	0.6	●	●	●	●	●	●	●	●	●	●	●
	08IR A55	08IL A55	0.5-1.5	48-16	4.76	8	0.05	0.6	0.7	●	●	●	●	●	●	●	●	●	●	●
	11IR A55 (IRM) AG55	11EL A55 AG55	0.5-1.5 / 0.5-2.5	48-16 / 48-10	6.35	11	0.05 / 0.05	0.8 / 0.9	0.9 / 1.2	●	●	●	●	●	●	●	●	●	●	●
	16IR A55 (IRM) G55 AG55	16EL A55 G55 AG55	0.5-1.5 / 1.75-3.0 / 0.5-3.0	48-16 / 14-8 / 48-8	9.525	16	0.05 / 0.21 / 0.07	0.8 / 1.2 / 1.2	0.9 / 1.7 / 1.7	●	●	●	●	●	●	●	●	●	●	●
	22IR N55 (IRM)	22EL N55	3.5-5.0	7-5	12.7	22	0.43	1.7	2.5	●	●	●	●	●	●	●	●	●	●	●
	27IR Q55	27EL Q55	5.5-6.0	4.5-4	15.875	27	0.60	2.0	2.9	●	●	●	●	●	●	●	●	●	●	●

用途 Application	规格型号 [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	06IR 26 W	06IL 26 W	0.63	26	3.97	6	0.10	0.7	0.6					●				●	●	●
	22 W	22 W	0.74	22			013	0.6	0.6					●				●	●	●
	20 W	20 W	0.81	20			0.14	0.6	0.7					●				●	●	●
	18 W	18 W	0.90	18			0.16	0.6	0.7					●				●	●	●
	08IR 28 W	08IL 28 W	0.58	28	4.76	8	0.09	0.6	0.6					●				●	●	●
	24 W	24 W	0.68	24			0.11	0.6	0.6					●				●	●	●
	20 W	20 W	0.81	20			0.14	0.6	0.7					●				●	●	●
	19 W	19 W	0.86	19			0.15	0.6	0.7					●				●	●	●
	18 W	18 W	0.90	18			0.16	0.6	0.7					●				●	●	●
	16 W	16 W	1.02	16			0.18	0.6	0.7					●				●	●	●
	11IR 72 W	11IL 72 W	0.23	72	6.35	11	0.02	0.7	0.4					●				●	●	●
	(IRM) 60 W	60 W	0.27	60			0.02	0.7	0.4					●				●	●	●
	56 W	56 W	0.29	56			0.02	0.7	0.4					●				●	●	●
	48 W	48 W	0.34	48			0.04	0.6	0.6					●				●	●	●
	40 W	40 W	0.41	40			0.07	0.6	0.6					●				●	●	●
	36 W	36 W	0.45	36			0.09	0.6	0.6					●				●	●	●
	32 W	32 W	0.51	32			0.09	0.6	0.6					●				●	●	●
	28 W	28 W	0.58	28			0.09	0.6	0.7					●				●	●	●
	26 W	26 W	0.63	26			0.10	0.7	0.8					●				●	●	●
	24 W	24 W	0.68	24			0.11	0.7	0.8					●				●	●	●
	22 W	22 W	0.74	22			0.13	0.8	0.9					●				●	●	●
	20 W	20 W	0.81	20			0.14	0.8	0.9	●	●	●		●	●	●	●	●	●	●
	19 W	19 W	0.86	19			0.15	0.8	1.0					●				●	●	●
	18 W	18 W	0.90	18			0.16	0.8	1.0	●	●	●		●	●	●	●	●	●	●
	16 W	16 W	1.02	16			0.18	0.9	1.1					●				●	●	●
	14 W	14 W	1.16	14			0.21	0.9	1.1					●				●	●	●
	12 W	12 W	1.32	12			0.25	0.9	1.2					●				●	●	●
	16IR 72 W	16IL 72 W	0.23	72	9.525	16	0.02	0.7	0.4					●				●	●	●
	(IRM) 60 W	60 W	0.27	60			0.02	0.7	0.4					●				●	●	●
	56 W	56 W	0.29	56			0.02	0.7	0.4	●	●	●		●	●	●	●	●	●	●
	48 W	48 W	0.34	48			0.04	0.6	0.6					●				●	●	●
	40 W	40 W	0.41	40			0.06	0.6	0.6					●				●	●	●
	36 W	36 W	0.45	36			0.09	0.6	0.6					●				●	●	●
	32 W	32 W	0.51	32			0.09	0.6	0.6					●				●	●	●
	30 W	30 W	0.55	30			0.09	0.6	0.7					●				●	●	●
	28 W	28 W	0.58	28			0.09	0.6	0.7	●	●	●		●	●	●	●	●	●	●
	26 W	26 W	0.63	26			0.10	0.7	0.8					●				●	●	●
	24 W	24 W	0.68	24			0.11	0.7	0.8					●				●	●	●
	22 W	22 W	0.74	22			0.13	0.8	0.9					●				●	●	●
	20 W	20 W	0.81	20			0.14	0.8	0.9	●	●	●		●	●	●	●	●	●	●
	19 W	19 W	0.86	19			0.15	0.8	1.0					●				●	●	●
	18 W	18 W	0.90	18			0.16	0.8	1.0					●				●	●	●
	16 W	16 W	1.02	16			0.18	0.9	1.1	●	●	●		●	●	●	●	●	●	●
	14 W	14 W	1.16	14			0.21	1.0	1.2	●	●	●		●	●	●	●	●	●	●
	12 W	12 W	1.36	12			0.25	1.1	1.4	●	●	●		●	●	●	●	●	●	●
	11 W	11 W	1.48	11			0.27	1.1	1.5	●	●	●		●	●	●	●	●	●	●
	10 W	10 W	1.63	10			0.31	1.1	1.5	●	●	●		●	●	●	●	●	●	●
	09 W	09 W	1.81	9			0.34	1.2	1.5	●	●	●		●	●	●	●	●	●	●
	08 W	08 W	2.03	8			0.39	1.2	1.7	●	●	●		●	●	●	●	●	●	●
	22IR 07 W	22IL 07 W	2.32	7	12.7	22	0.45	1.6	2.3	●	●	●		●	●	●	●	●	●	●
	(IRM) 06 W	06 W	2.71	6			0.52	1.6	2.3	●	●	●		●	●	●	●	●	●	●
	05 W	05 W	3.25	5			0.65	1.7	2.4	●	●	●		●	●	●	●	●	●	●
	27IR 4.5 W	27IL 4.5 W	3.61	4.5	15.875	27	0.73	1.8	2.6					●				●	●	●
	(IRM) 4 W	4 W	4.07	4			0.82	2.0	2.9					●				●	●	●

TTX32R

外圆车刀：AB26/B71 (External Toolholder)
内孔车刀：B74 (Internal Toolholder)

刀具安装样式 Tool installation style

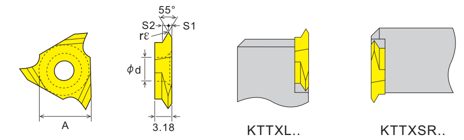


用途 Application	规格型号 Specification		螺距 (mm)	(tpi)	rε	S1	S2	A	ϕd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TTX32R	5501	-	28-10	0.1	1.1	0.5	9.525	4.4					●	●	●		●	●	
		5502	-	14-10	0.2	1.1	0.5							●	●	●		●	●	

TTX32L

外圆车刀：AB26/B71 (External Toolholder)
内孔车刀：B74 (Internal Toolholder)

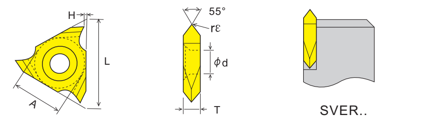
刀具安装样式 Tool installation style



用途 Application	规格型号 Specification		螺距 (mm)	(tpi)	rε	S1	S2	A	ϕd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TTX32L	5501	-	28-10	0.1	1.1	0.5	9.525	4.4					●	●	●		●	●	
		5502	-	14-10	0.2	1.1	0.5							●	●	●		●	●	

VER..

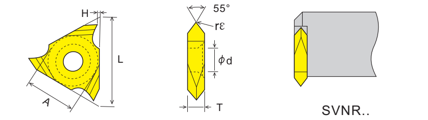
外圆车刀：B73 (External Toolholder)



用途 Application	规格型号 [VER]		螺距 Pitch (tpi)	H	rε	L	T	A	ϕd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	16VER	AG55	48-8	-	0.07	16	3.65	9.525	4.0					●				●	●	
	27VER	V55	4-2.5	-	0.88	27	8.7	15.87	6.35					●				●	●	
		4W	4											●				●	●	
		3W	3											●				●	●	
		2.5W	2.5											●				●	●	

VNR..

内孔车刀：B74 (Internal Toolholder)

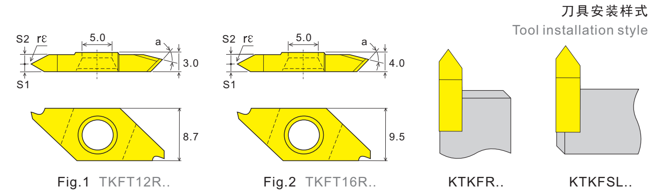


用途 Application	规格型号 [VNR]		螺距 Pitch (tpi)	H	rε	L	T	A	ϕd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	16VNR	AG55	48-8	-	0.06	16	3.65	9.525	4.0					●				●	●	
	27VNR	V55	4-2.5	-	0.89	27	8.7	15.87	6.35					●				●	●	
		4W	4											●				●	●	
		3W	3											●				●	●	
		2.5W	2.5											●				●	●	

TKFT..R..

(External Toolholder): AB25/B72

刀具安装样式 Tool installation style

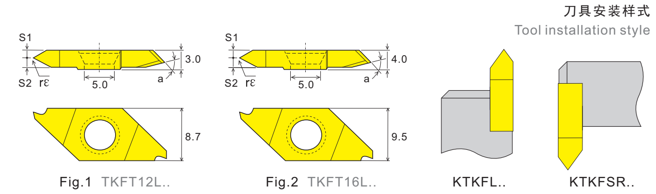


用途 Application	规格型号 Specification		螺距 (mm)	(tpi)	rε	S1	S2	a	Fig	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TKFT12R	A55005	-	40-16	0.05	0.8	1.7	55°	1					●	●	●			●	
		B55005	-	40-16	0.05	1.7	0.8							●	●	●			●	
	TKFT16R	A55005	-	40-16	0.05	0.8	1.7	55°	2					●	●	●			●	
		B55005	-	40-16	0.05	1.7	0.8							●	●	●			●	

TKFT..L..

外圆车刀 (External Toolholder): AB25/B72

刀具安装样式 Tool installation style

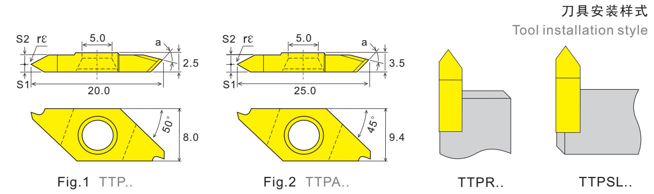


用途 Application	规格型号 Specification		螺距 (mm)	(tpi)	rε	S1	S2	a	Fig	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TKFT12L	A55005	-	40-16	0.05	1.7	0.8	55°	1					●	●	●			●	
		B55005	-	40-16	0.05	0.8	1.7							●	●	●			●	
	TKFT16L	A55005	-	40-16	0.05	1.7	0.8	55°	2					●	●	●			●	
		B55005	-	40-16	0.05	0.8	1.7							●	●	●			●	

TTP..FR..

外圆车刀 (External Toolholder): AB22

刀具安装样式 Tool installation style

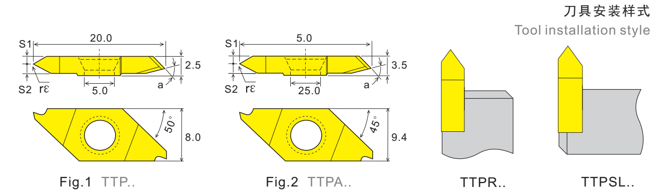


用途 Application	规格型号 Specification		螺距 (mm)	(tpi)	rε	S1	S2	a	Fig	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TTP55	FR8A	-	48-16	0.05	0.8	1.7	55°	1					●	●	●			●	
		FR8B	-	48-16	0.05	1.7	0.8							●	●	●			●	
	TTPA55	FR8A	-	48-16	0.05	0.8	1.7	55°	2					●	●	●			●	
		FR8B	-	48-16	0.05	1.7	0.8							●	●	●			●	

TTP..FL..

外圆车刀 (External Toolholder): Ab22

刀具安装样式 Tool installation style



用途 Application	规格型号 Specification		螺距 (mm)	(tpi)	rε	S1	S2	a	Fig	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
螺纹加工 Thread processing	TTP55	FL8A	-	48-16	0.05	1.7	0.8	55°	1					●	●	●			●	
		FL8B	-	48-16	0.05	0.8	1.7							●	●	●			●	
	TTPA55	FL8A	-	48-16	0.05	1.7	0.8	55°	2					●	●	●			●	
		FL8B	-	48-16	0.05	0.8	1.7							●	●	●			●	

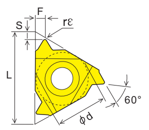
UN 60°全牙型 美制

UNC,UNF,UNEF,UNS

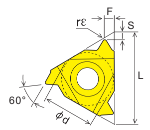
螺纹应用领域：一般工业

Thread Application: General Industry

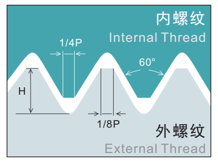
材质 Material	切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ○ 一般切削(第二推荐) General Cutting(Second recommend) ✖ 不稳定切削 Unstable Cutting		PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✖	◕	◕	◕
M	不锈钢	Stainless Steel				◕		◕	◕	✖	◕	◕	◕
K	铸铁	Iron		●		◕		◕		✖	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◕



ER 型



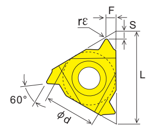
EL 型



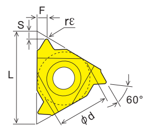
外圆车刀 (External Toolholder): B69

用途 Application: 外螺纹加工 External thread processing

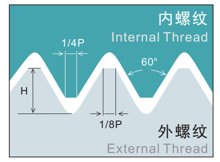
规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	尺寸 Dimension (mm) ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
11ER 72 UN (ERM)	11EL 72 UN	0.22	72	6.35	11	0.02	0.8	0.4					●				●	●	●
64 UN	64 UN	0.24	64			0.02	0.8	0.4					●				●	●	●
56 UN	56 UN	0.28	56			0.04	0.7	0.4					●				●	●	●
48 UN	48 UN	0.32	48			0.05	0.6	0.6					●				●	●	●
44 UN	44 UN	0.35	44			0.05	0.6	0.6					●				●	●	●
40 UN	40 UN	0.39	40			0.06	0.6	0.6					●				●	●	●
36 UN	36 UN	0.43	36			0.07	0.6	0.6					●				●	●	●
32 UN	32 UN	0.49	32			0.09	0.6	0.6					●				●	●	●
28 UN	28 UN	0.56	28			0.10	0.6	0.7					●				●	●	●
27 UN	27 UN	0.58	27			0.10	0.7	0.8					●				●	●	●
24 UN	24 UN	0.65	24			0.12	0.7	0.8					●				●	●	●
20 UN	20 UN	0.78	20			0.15	0.8	0.9					●				●	●	●
18 UN	18 UN	0.87	18			0.17	0.8	1.0	●	●	●		●	●	●	●	●	●	●
16 UN	16 UN	0.97	16			0.18	0.9	1.1					●				●	●	●
14 UN	14 UN	1.11	14			0.22	0.9	1.1	●	●	●		●	●	●	●	●	●	●
16ER 72 UN (ERM)	16EL 72 UN	0.22	72	9.525	16	0.02	0.8	0.4					●				●	●	●
64 UN	64 UN	0.24	64			0.02	0.8	0.4					●				●	●	●
56 UN	56 UN	0.28	56			0.04	0.7	0.4					●				●	●	●
48 UN	48 UN	0.32	48			0.05	0.6	0.6					●				●	●	●
44 UN	44 UN	0.35	44			0.05	0.6	0.6					●				●	●	●
40 UN	40 UN	0.39	40			0.06	0.6	0.6					●				●	●	●
36 UN	36 UN	0.43	36			0.07	0.6	0.6					●				●	●	●
32 UN	32 UN	0.49	32			0.09	0.6	0.6					●				●	●	●
28 UN	28 UN	0.56	28			0.10	0.6	0.7	●	●	●		●	●	●	●	●	●	●
27 UN	27 UN	0.58	27			0.10	0.7	0.8					●				●	●	●
24 UN	24 UN	0.65	24			0.12	0.7	0.8	●	●	●		●	●	●	●	●	●	●
20 UN	20 UN	0.78	20			0.15	0.8	0.9	●	●	●		●	●	●	●	●	●	●
18 UN	18 UN	0.87	18			0.18	0.8	1.0	●	●	●		●	●	●	●	●	●	●
16 UN	16 UN	0.97	16			0.18	0.9	1.1	●	●	●		●	●	●	●	●	●	●
14 UN	14 UN	1.11	14			0.22	1.0	1.2	●	●	●		●	●	●	●	●	●	●
13 UN	13 UN	1.20	13			0.24	1.0	1.3					●				●	●	●
12 UN	12 UN	1.30	12			0.26	1.1	1.4	●	●	●		●	●	●	●	●	●	●
11.5 UN	11.5 UN	1.35	11.5			0.27	1.1	1.5					●				●	●	●
11 UN	11 UN	1.42	11			0.28	1.1	1.5	●	●	●		●	●	●	●	●	●	●
10 UN	10 UN	1.56	10			0.32	1.1	1.5	●	●	●		●	●	●	●	●	●	●
09 UN	09 UN	1.73	9			0.36	1.2	1.6	●	●	●		●	●	●	●	●	●	●
08 UN	08 UN	1.95	8			0.41	1.2	1.7	●	●	●		●	●	●	●	●	●	●
22ER 07 UN (ERM)	22EL 07 UN	2.22	7	12.7	22	0.47	1.6	2.3	●	●	●		●	●	●	●	●	●	●
06 UN	06 UN	2.60	6			0.56	1.6	2.3	●	●	●		●	●	●	●	●	●	●
05 UN	05 UN	3.12	5			0.67	1.7	2.5	●	●	●		●	●	●	●	●	●	●
27ER 4.5 UN (ERM)	27EL 4.5 UN	3.46	4.5	15.875	27	0.75	1.9	2.7					●				●	●	●
4 UN	4 UN	3.89	4			0.85	2.1	3.0					●				●	●	●



IR 型



IL 型



内孔车刀 (Internal Toolholder): B75-B77

用途 Application: 内螺纹加工 Internal thread processing

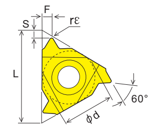
规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	尺寸 Dimension (mm) ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
06IR 32 UN	06IL 32 UN	0.46	32	3.97	6	0.04	0.5	0.5					●				●	●	●
28 UN	28 UN	0.52	28			0.04	0.5	0.5					●				●	●	●
24 UN	24 UN	0.61	24			0.05	0.5	0.6					●				●	●	●
20 UN	20 UN	0.73	20			0.06	0.6	0.6					●				●	●	●
18 UN	18 UN	0.81	18			0.07	0.6	1.6					●				●	●	●
08IR 32 UN	08IL 32 UN	0.46	32	4.76	8	0.04	0.6	0.5					●				●	●	●
28 UN	28 UN	0.52	28			0.04	0.6	0.6					●				●	●	●
24 UN	24 UN	0.61	24			0.05	0.6	0.6					●				●	●	●
20 UN	20 UN	0.73	20			0.06	0.6	0.7					●				●	●	●
18 UN	18 UN	0.81	18			0.07	0.6	0.7					●				●	●	●
16 UN	16 UN	0.92	16			0.09	0.6	0.7					●				●	●	●
14 UN	14 UN	1.05	14			0.10	0.6	0.8					●				●	●	●
11IR 72 UN (IRM)	11IL 72 UN	0.20	72	6.35	11	0.02	0.8	0.3					●				●	●	●
64 UN	64 UN	0.23	64			0.02	0.8	0.4					●				●	●	●
56 UN	56 UN	0.26	56			0.02	0.7	0.4					●				●	●	●
48 UN	48 UN	0.31	48			0.03	0.6	0.6					●				●	●	●
44 UN	44 UN	0.33	44			0.03	0.6	0.6					●				●	●	●
40 UN	40 UN	0.37	40			0.03	0.6	0.6					●				●	●	●
36 UN	36 UN	0.41	36			0.04	0.6	0.6					●				●	●	●
32 UN	32 UN	0.46	32			0.04	0.6	0.6					●				●	●	●
28 UN	28 UN	0.52	28			0.04	0.6	0.7					●				●	●	●
27 UN	27 UN	0.54	27			0.04	0.7	0.8					●				●	●	●
24 UN	24 UN	0.61	24			0.05	0.7	0.8					●				●	●	●
20 UN	20 UN	0.73	20			0.06	0.8	0.9					●				●	●	●
18 UN	18 UN	0.81	18			0.07	0.8	1.0	●	●	●		●	●	●	●	●	●	●
16 UN	16 UN	0.92	16			0.09	0.9	1.1					●				●	●	●
14 UN	14 UN	1.05	14			0.10	0.9	1.1	●	●	●		●	●	●	●	●	●	●
12 UN	12 UN	1.22	12			0.12	0.8	1.1					●				●	●	●
11 UN	11 UN	1.33	11			0.14	0.8	1.1					●				●	●	●
16IR 72 UN (IRM)	16IL 72 UN	0.20	72	9.525	16	0.02	0.8	0.3					●				●	●	●
64 UN	64 UN	0.23	64			0.02	0.8	0.4					●				●	●	●
56 UN	56 UN	0.26	56			0.02	0.7	0.4					●				●	●	●
48 UN	48 UN	0.31	48			0.03	0.6	0.6					●				●	●	●
44 UN	44 UN	0.33	44			0.03	0.6	0.6					●				●	●	●
40 UN	40 UN	0.37	40			0.03	0.6	0.6					●				●	●	●
36 UN	36 UN	0.41	36			0.04	0.6	0.6					●				●	●	●
32 UN	32 UN	0.51	32			0.04	0.6	0.6					●				●	●	●
28 UN	28 UN	0.52	28			0.04	0.6	0.7	●	●	●		●	●	●	●	●	●	●
27 UN	27 UN	0.54	27			0.04	0.7	0.8					●				●	●	●
24 UN	24 UN	0.61	24			0.05	0.7	0.8	●	●	●		●	●	●	●	●	●	●
20 UN	20 UN	0.73	20			0.06	0.8	0.9	●	●	●		●	●	●	●	●	●	●
18 UN	18 UN	0.81	18			0.07	0.8	1.0	●	●	●		●	●	●	●	●	●	●
16 UN	16 UN	0.92	16			0.09	0.9	1.1	●	●	●		●	●	●	●	●	●	●
14 UN	14 UN	1.05	14			0.10	0.9	1.2	●	●	●		●	●	●	●	●	●	●
13 UN	13 UN	1.13	13			0.11	1.0	1.3					●				●	●	●
12 UN	12 UN	1.22	12			0.12	1.1	1.4	●	●	●		●	●	●	●	●	●	●
11.5 UN	11.5 UN	1.28	11.5			0.13	1.1	1.5					●				●	●	●
11 UN	11 UN	1.33	11			0.14	1.1	1.5	●	●	●		●	●	●	●	●	●	●
10 UN	10 UN	1.47	10			0.15	1.1	1.5	●	●	●		●	●	●	●	●	●	●
09 UN	09 UN	1.63	9			0.17	1.2	1.6	●	●	●		●	●	●	●	●	●	●
08 UN	08 UN	1.83	8			0.19	1.2	1.7	●	●	●		●	●	●	●	●	●	●
22IR 07 UN (IRM)	22IL 07 UN	2.09	7	12.7	22	0.22	1.6	2.3	●	●	●		●	●	●	●	●	●	●
06 UN	06 UN	2.44	6			0.26	1.6	2.3	●	●	●		●	●	●	●	●	●	●
05 UN	05 UN	2.93	5			0.32	1.7	2.3	●	●	●		●	●	●	●	●	●	●
27IR 4.5 UN (IRM)	27IL 4.5 UN	3.26	4.5	15.875	27	0.36	1.9	2.4					●				●	●	●
4 UN	4 UN	3.67	4			0.41	2.1	2.7					●				●	●	●

UNJ 60°牙型 航空 工业螺纹

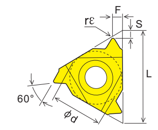
螺纹应用领域：航空工业用螺纹

Thread Application: Threads for aviation industry

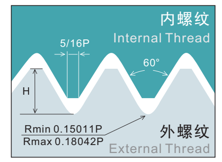
材质 Material	切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ○ 一般切削(第二推荐) General Cutting(Second recommend) ✖ 不稳定切削 Unstable Cutting		PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✖	◕	◕	◕
M	不锈钢	Stainless Steel				◕		◕	◕	✖	◕	◕	◕
K	铸铁	Iron		●		◕		◕		✖	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◕



ER 型



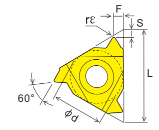
EL 型



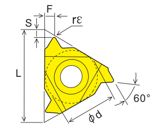
外圆车刀 (External Toolholder): B69

用途 Application: 外螺纹加工 External thread processing

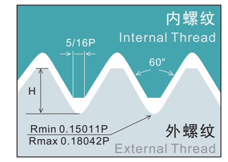
规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	尺寸 Dimension (mm) ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
11ER 48 UNJ	11EL 48 UNJ	0.31	48	6.35	11	0.08	0.6	0.5					●				●	●	●
44 UNJ	44 UNJ	0.33	44			0.09	0.6	0.6					●				●	●	●
40 UNJ	40 UNJ	0.37	40			0.10	0.6	0.6					●				●	●	●
36 UNJ	36 UNJ	0.41	36			0.11	0.6	0.6					●				●	●	●
32 UNJ	32 UNJ	0.46	32			0.12	0.6	0.7					●				●	●	●
28 UNJ	28 UNJ	0.52	28			0.14	0.7	0.7					●				●	●	●
24 UNJ	24 UNJ	0.61	24			0.17	0.7	0.8					●				●	●	●
20 UNJ	20 UNJ	0.73	20			0.20	0.8	0.9					●				●	●	●
18 UNJ	18 UNJ	0.81	18			0.22	0.8	1.0					●				●	●	●
16 UNJ	16 UNJ	0.92	16			0.26	0.9	1.1					●				●	●	●
14 UNJ	14 UNJ	1.05	14			0.29	1.0	1.2					●				●	●	●
16ER 48 UNJ	16EL 48 UNJ	0.31	48	9.525	16	0.08	0.6	0.5					●				●	●	●
44 UNJ	44 UNJ	0.33	44			0.09	0.6	0.6					●				●	●	●
40 UNJ	40 UNJ	0.37	40			0.10	0.6	0.6					●				●	●	●
36 UNJ	36 UNJ	0.41	36			0.11	0.6	0.6					●				●	●	●
32 UNJ	32 UNJ	0.46	32			0.12	0.6	0.7					●				●	●	●
28 UNJ	28 UNJ	0.52	28			0.14	0.7	0.7					●				●	●	●
24 UNJ	24 UNJ	0.61	24			0.17	0.7	0.8					●				●	●	●
20 UNJ	20 UNJ	0.73	20			0.20	0.8	0.9					●				●	●	●
18 UNJ	18 UNJ	0.81	18			0.22	0.8	1.0					●				●	●	●
16 UNJ	16 UNJ	0.92	16			0.26	0.9	1.1					●				●	●	●
14 UNJ	14 UNJ	1.05	14			0.29	1.0	1.2					●				●	●	●
13 UNJ	13 UNJ	1.13	13			0.31	1.0	1.3					●				●	●	●
12 UNJ	12 UNJ	1.22	12			0.34	1.1	1.3					●				●	●	●
11 UNJ	11 UNJ	1.33	11			0.36	1.2	1.5					●				●	●	●
10 UNJ	10 UNJ	1.47	10			0.41	1.2	1.5					●				●	●	●
09 UNJ	09 UNJ	1.63	9			0.44	1.2	1.6					●				●	●	●
08 UNJ	08 UNJ	1.83	8			0.51	1.3	1.7					●				●	●	●
22ER 07 UNJ	22EL 07 UNJ	2.09	7	12.7	22	0.57	1.7	2.3					●				●	●	●
06 UNJ	06 UNJ	2.44	6			0.66	1.7	2.3					●				●	●	●
05 UNJ	05 UNJ	2.93	5			0.77	1.8	2.5					●				●	●	●
27ER 4.5 UNJ	27EL 4.5 UNJ	3.26	4.5	15.87	27	0.85	2.0	2.7					●				●	●	●
4 UNJ	4 UNJ	3.67	4			0.95	2.2	3.0					●				●	●	●



IR 型



IL 型



内孔车刀 (Internal Toolholder): B75-B77

用途 Application: 内螺纹加工 Internal thread processing

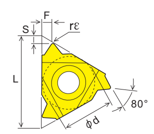
规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	尺寸 Dimension (mm) ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
11IR 48 UNJ	11IL 48 UNJ	0.28	48	6.35	11	0.03	0.6	0.5					●				●	●	●
44 UNJ	44 UNJ	0.30	44			0.03	0.6	0.6					●				●	●	●
40 UNJ	40 UNJ	0.33	40			0.03	0.6	0.6					●				●	●	●
36 UNJ	36 UNJ	0.37	36			0.04	0.6	0.6					●				●	●	●
32 UNJ	32 UNJ	0.42	32			0.04	0.6	0.7					●				●	●	●
28 UNJ	28 UNJ	0.47	28			0.04	0.7	0.7					●				●	●	●
24 UNJ	24 UNJ	0.55	24			0.05	0.7	0.8					●				●	●	●
20 UNJ	20 UNJ	0.66	20			0.06	0.8	0.9					●				●	●	●
18 UNJ	18 UNJ	0.74	18			0.07	0.8	1.0					●				●	●	●
16 UNJ	16 UNJ	0.83	16			0.09	0.9	1.1					●				●	●	●
14 UNJ	14 UNJ	0.95	14			0.10	1.0	1.2					●				●	●	●
16IR 48 UNJ	16IL 48 UNJ	0.28	48	9.525	16	0.03	0.6	0.5					●				●	●	●
44 UNJ	44 UNJ	0.30	44			0.03	0.6	0.6					●				●	●	●
40 UNJ	40 UNJ	0.33	40			0.03	0.6	0.6					●				●	●	●
36 UNJ	36 UNJ	0.37	36			0.04	0.6	0.6					●				●	●	●
32 UNJ	32 UNJ	0.42	32			0.04	0.6	0.7					●				●	●	●
28 UNJ	28 UNJ	0.47	28			0.04	0.7	0.7					●				●	●	●
24 UNJ	24 UNJ	0.55	24			0.05	0.7	0.8					●				●	●	●
20 UNJ	20 UNJ	0.66	20			0.06	0.8	0.9					●				●	●	●
18 UNJ	18 UNJ	0.74	18			0.07	0.8	1.0					●				●	●	●
16 UNJ	16 UNJ	0.83	16			0.09	0.9	1.1					●				●	●	●
14 UNJ	14 UNJ	0.95	14			0.10	1.0	1.2					●				●	●	●
13 UNJ	13 UNJ	1.02	13			0.11	1.0	1.3					●				●	●	●
12 UNJ	12 UNJ	1.11	12			0.12	1.1	1.3					●				●	●	●
11 UNJ	11 UNJ	1.21	11			0.12	1.2	1.5					●				●	●	●
10 UNJ	10 UNJ	1.33	10			0.15	1.2	1.5					●				●	●	●
09 UNJ	09 UNJ	1.48	9			0.17	1.2	1.6					●				●	●	●
08 UNJ	08 UNJ	1.66	8			0.19	1.3	1.7					●				●	●	●
22IR 07 UNJ	22IL 07 UNJ	1.90	7	12.7	22	0.22	1.7	2.3					●				●	●	●
06 UNJ	06 UNJ	2.21	6			0.26	1.7	2.3					●				●	●	●
05 UNJ	05 UNJ	2.65	5			0.32	1.8	2.5					●				●	●	●
27IR 4.5 UNJ	27IL 4.5 UNJ	2.95	4.5	15.87	27	0.36	2.0	2.7					●				●	●	●
4 UNJ	4 UNJ	3.32	4			0.41	2.2	3.0					●				●	●	●

PG 80°全牙型 DIN40430 钢导管螺纹

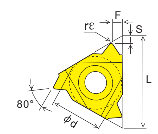
螺纹应用领域：钢导管螺纹

Thread Application: Conduit thread

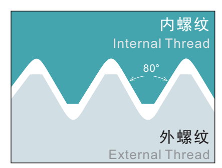
材质 Material	切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ○ 一般切削(第二推荐) General Cutting(Second recommend) ✖ 不稳定切削 Unstable Cutting		PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✖	◕	◕	◕
M	不锈钢	Stainless Steel				◕		◕	◕	✖	◕	◕	◕
K	铸铁	Iron		●		◕		◕		✖	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◕



ER 型



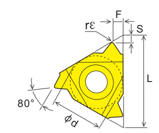
EL 型



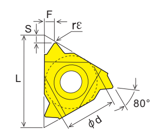
外圆车刀 (External Toolholder): B69

用途 Application: 外螺纹加工 External thread processing

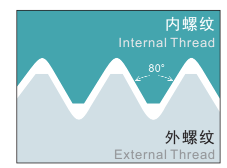
规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	尺寸 Dimension (mm) ϕd	L	rε	T	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
11ER 20 PG	11EL 20 PG		20	6.35	11		3.18	0.9					●				●	●	
18 PG	18 PG		18					1.0					●				●	●	
16 PG	16 PG		16					1.1					●				●	●	
16ER 20 PG	16EL 20 PG		20	9.525	16		3.65	0.9					●				●	●	
18 PG	18 PG		18					1.0					●				●	●	
16PG	16PG		16					1.1					●				●	●	



IR 型



IL 型



内孔车刀 (Internal Toolholder): B75-B77

用途 Application: 内螺纹加工 Internal thread processing

规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	尺寸 Dimension (mm) ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
11IR 20 PG	11IL 20 PG		20	6.35	11		3.18	0.9					●				●	●	
18 PG	18 PG		18					1.0					●				●	●	
16 PG	16 PG		16					1.1					●				●	●	
16IR 20 PG	16IL 20 PG		20	9.525	16		3.65	0.9					●				●	●	
18 PG	18 PG		18					1.0					●				●	●	
16PG	16PG		16					1.1					●				●	●	

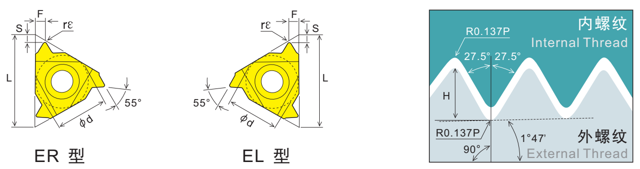
数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GMM TDC
后车削 ABS TBP TKFB
内孔切槽 GER GR
螺纹车削刀片
铣削刀片

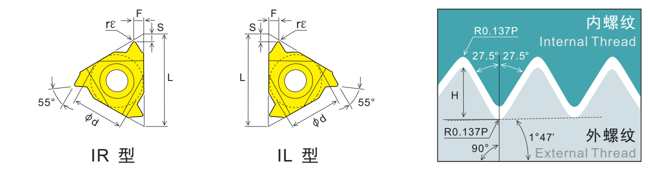
BSPT 55°牙型 英制 锥管螺纹

螺纹应用领域：气管/汽管/水管螺纹
Thread Application: Air pipe / steam pipe / water pipe thread

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting; ◑ 一般切削 General Cutting; ○ 一般切削(第二推荐) General Cutting(Second recommend); ✕ 不稳定切削 Unstable Cutting

材质 Material			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◑		◑	●	✕	◑	◑	◑
M	不锈钢	Stainless Steel				○		○	○	✕	○	○	○
K	铸铁	Iron		●		◑		◑		✕	◑	◑	◑
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◑	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✕			◑
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✕			◑





外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER 28BSPT	11EL 28BSPT	0.58	28	6.35	11	0.11	0.6	0.6					●				●	●	●
	(ERM) 19BSPT	19BSPT	0.86	19			0.16	0.8	0.9					●				●	●	●
	14BSPT	14BSPT	1.16	14			0.21	0.9	1.0					●				●	●	●
	16ER 28BSPT	16EL 28BSPT	0.58	28	9.525	16	0.11	0.6	0.6	●	●	●		●	●	●	●	●	●	●
	(ERM) 19BSPT	19BSPT	0.86	19			0.16	0.8	0.9	●	●	●		●	●	●	●	●	●	●
	14BSPT	14BSPT	1.16	14			0.21	1.0	1.2	●	●	●		●	●	●	●	●	●	●
	11BSPT	11BSPT	1.48	11			0.28	1.1	1.5	●	●	●		●	●	●	●	●	●	●

内孔车刀 (Internal Toolholder): B75-B77

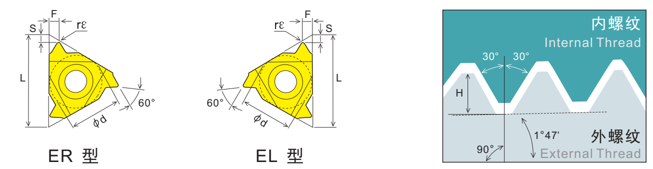
用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	06IR 28BSPT	06IL 28BSPT	0.58	28	3.97	6	0.11	0.7	0.6					●				●	●	●
	08IR 28BSPT	08IL 28BSPT	0.58	28	4.76	8	0.11	0.6	0.6					●				●	●	●
	19BSPT	19BSPT	0.86	19			0.16	0.6	0.6					●				●	●	●
	11IR 28BSPT	11IL 28BSPT	0.58	28	6.35	11	0.11	0.6	0.6					●				●	●	●
	(IRM) 19BSPT	19BSPT	0.86	19			0.16	0.8	0.9					●				●	●	●
	14BSPT	14BSPT	1.16	14			0.21	0.9	1.0					●				●	●	●
	16IR 28BSPT	16IL 28BSPT	0.58	28	9.525	16	0.11	0.6	0.6	●	●	●		●	●	●	●	●	●	●
	(IRM) 19BSPT	19BSPT	0.86	19			0.16	0.8	0.9	●	●	●		●	●	●	●	●	●	●
	14BSPT	14BSPT	1.16	14			0.21	1.0	1.2	●	●	●		●	●	●	●	●	●	●
	11BSPT	11BSPT	1.48	11			0.28	1.1	1.5	●	●	●		●	●	●	●	●	●	●

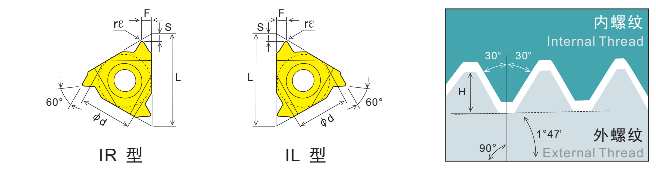
NPT 60°牙型 美制 锥管螺纹

螺纹应用领域：气管/汽管/水管螺纹
Thread Application: Air pipe / steam pipe / water pipe thread

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting; ◑ 一般切削 General Cutting; ○ 一般切削(第二推荐) General Cutting(Second recommend); ✕ 不稳定切削 Unstable Cutting

材质 Material			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◑		◑	●	✕	◑	◑	◑
M	不锈钢	Stainless Steel				○		○	○	✕	○	○	○
K	铸铁	Iron		●		◑		◑		✕	◑	◑	◑
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◑	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✕			◑
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✕			◑





外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER 27 NPT	11EL 27 NPT	0.66	27	6.35	11	0.04	0.7	0.8					●				●	●	●
	(ERM) 18 NPT	18 NPT	1.01	18			0.06	0.8	1.0					●				●	●	●
	14 NPT	14 NPT	1.33	14			0.07	0.8	1.0					●				●	●	●
	16ER 27 NPT	16EL 27 NPT	0.66	27	9.525	16	0.04	0.7	0.8					●		●	●	●	●	●
	(ERM) 18 NPT	18 NPT	1.01	18			0.06	0.8	1.0					●		●	●	●	●	●
	14 NPT	14 NPT	1.33	14			0.07	0.9	1.2					●		●	●	●	●	●
	11.5 NPT	11.5 NPT	1.64	11.5			0.09	1.1	1.5					●		●	●	●	●	●
	08 NPT	08 NPT	2.42	8			0.12	1.3	1.8					●		●	●	●	●	●

内孔车刀 (Internal Toolholder): B75-B77

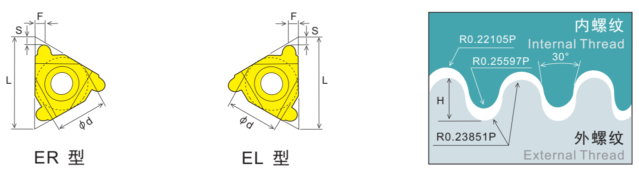
用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	06IR 27 NPT	06IL 27 NPT	0.66	27	3.97	6	0.04	0.6	0.6					●				●	●	●
	08IR 27 NPT	08IL 27 NPT	0.66	27	4.76	8	0.04	0.6	0.6					●				●	●	●
	18 NPT	18 NPT	1.01	18			0.06	0.6	0.6					●				●	●	●
	11IR 27 NPT	11IL 27 NPT	0.66	27	6.35	11	0.04	0.7	0.8					●				●	●	●
	(IRM) 18 NPT	18 NPT	1.01	18			0.06	0.8	1.0					●				●	●	●
	14 NPT	14 NPT	1.33	14			0.07	0.8	1.0					●				●	●	●
	16IR 27 NPT	16IL 27 NPT	0.66	27	9.525	16	0.04	0.7	0.8					●		●	●	●	●	●
	(IRM) 18 NPT	18 NPT	1.01	18			0.06	0.8	1.0					●		●	●	●	●	●
	14 NPT	14 NPT	1.33	14			0.07	0.9	1.2					●		●	●	●	●	●
	11.5 NPT	11.5 NPT	1.64	11.5			0.09	1.1	1.5					●		●	●	●	●	●
	08 NPT	08 NPT	2.42	8			0.12	1.2	1.8					●				●	●	●

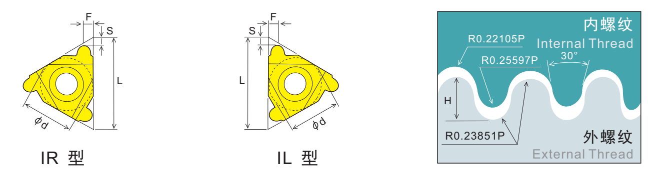
RND DIN405 圆齿 管螺纹

螺纹应用领域：防火管件和食品工业用管螺纹
Thread Application: For Fireproof pipe fittings and food industry

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting; ◑ 一般切削 General Cutting; ○ 一般切削(第二推荐) General Cutting(Second recommend); ✕ 不稳定切削 Unstable Cutting

材质 Material			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◑		◑	●	✕	◑	◑	◑
M	不锈钢	Stainless Steel				○		○	○	✕	○	○	○
K	铸铁	Iron		●		◑		◑		✕	◑	◑	◑
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◑	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✕			◑
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✕			◑





外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	16ER 10 RND	16EL 10 RND	1.27	10	9.525	16		1.1	1.2					●		●		●	●	●
	8 RND	8 RND	1.59	8				1.4	1.3					●		●		●	●	●
	6 RND	6 RND	2.12	6				1.5	1.7					●		●		●	●	●
	22ER 6 RND	22EL 6 RND	2.12	6	12.7	22		1.5	1.7					●		●		●	●	●
	4 RND	4 RND	3.18	4				2.2	2.3					●		●		●	●	●
	27ER 4 RND	27EL 4 RND	3.18	4	15.87	27		2.2	2.3					●		●		●	●	●

内孔车刀 (Internal Toolholder): B75-B77

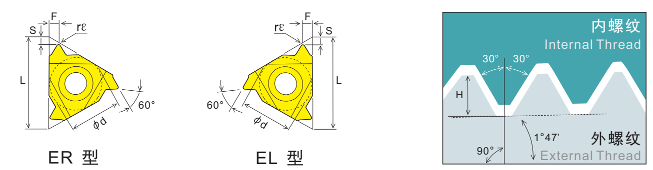
用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	16IR 10 RND	16IL 10 RND	1.27	10	9.525	16		1.1	1.2					●		●		●	●	●
	8 RND	8 RND	1.59	8				1.4	1.3					●		●		●	●	●
	6 RND	6 RND	2.12	6				1.5	1.7					●		●		●	●	●
	22IR 6 RND	22IL 6 RND	2.12	6	12.7	22		1.5	1.7					●		●		●	●	●
	4 RND	4 RND	3.18	4				2.2	2.3					●		●		●	●	●
	27IR 4 RND	27IL 4 RND	3.18	4	15.87	27		2.2	2.3					●		●		●	●	●

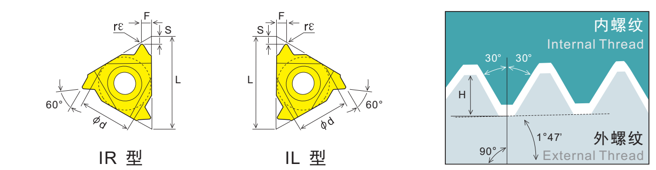
NPTF 60°牙型 美制干密封 锥管螺纹

螺纹应用领域：气管/汽管/水管螺纹
Thread Application: Air pipe / steam pipe / water pipe thread

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting; ◑ 一般切削 General Cutting; ○ 一般切削(第二推荐) General Cutting(Second recommend); ✕ 不稳定切削 Unstable Cutting

材质 Material			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◑		◑	●	✕	◑	◑	◑
M	不锈钢	Stainless Steel				○		○	○	✕	○	○	○
K	铸铁	Iron		●		◑		◑		✕	◑	◑	◑
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◑	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✕			◑
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✕			◑





外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER 27 NPTF	11EL 27 NPTF	0.64	27	6.35	11	0.04	0.7	0.8					●				●	●	●
	(ERM)18 NPTF	18 NPTF	1.00	18			0.04	0.8	1.0					●				●	●	●
	14 NPTF	14 NPTF	1.35	14			0.04	0.8	1.0					●				●	●	●
	16ER 27 NPTF	16EL 27 NPTF	0.64	27	9.525	16	0.04	0.7	0.8					●		●	●	●	●	●
	(ERM)18 NPTF	18 NPTF	1.00	18			0.04	0.8	1.0					●		●	●	●	●	●
	14 NPTF	14 NPTF	1.35	14			0.04	0.9	1.2					●		●	●	●	●	●
	11.5 NPTF	11.5 NPTF	1.63	11.5			0.04	1.1	1.5					●		●	●	●	●	●
	08 NPTF	08 NPTF	2.38	8			0.04	1.3	1.8					●		●	●	●	●	●

内孔车刀 (Internal Toolholder): B75-B77

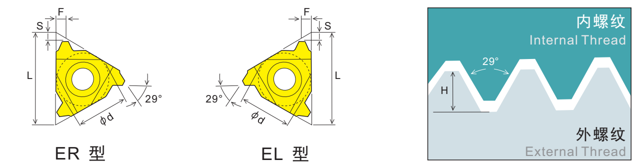
用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	06IR 27 NPTF	06IL 27 NPTF	0.64	27	3.97	6	0.04	0.7	0.6					●				●	●	●
	08IR 27 NPTF	08IL 27 NPTF	0.64	27	4.76	8	0.04	0.6	0.6					●				●	●	●
	18 NPTF	18 NPTF	1.00	18			0.04	0.6	0.6					●				●	●	●
	11IR 27 NPTF	11IL 27 NPTF	0.64	27	6.35	11	0.04	0.7	0.7					●				●	●	●
	(IRM)18 NPTF	18 NPTF	1.00	18			0.04	0.8	1.0					●				●	●	●
	14 NPTF	14 NPTF	1.35	14			0.04	0.8	1.0					●				●	●	●
	16IR 27 NPTF	16IL 27 NPTF	0.64	27	9.525	16	0.04	0.7	0.7					●		●	●	●	●	●
	(IRM)18 NPTF	18 NPTF	1.00	18			0.04	0.8	1.0					●		●	●	●	●	●
	14 NPTF	14 NPTF	1.35	14			0.04	0.9	1.2					●		●	●	●	●	●
	11.5 NPTF	11.5 NPTF	1.63	11.5			0.04	1.1	1.5					●		●	●	●	●	●
	08 NPTF	08 NPTF	2.38	8			0.04	1.3	1.8					●				●	●	●

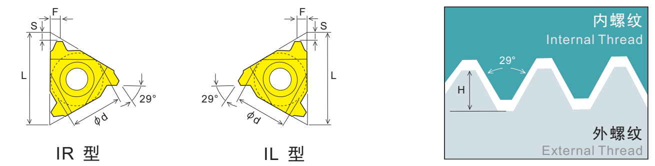
ACME 29°牙型 美制 梯形螺纹

螺纹应用领域：传递动力用梯形螺纹
Thread Application: Trapezoidal thread for power transmission

材质 Material	钢 / 材料		PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◑		◑	●	✱	◑	◑	◑
M	不锈钢	Stainless Steel				◑		◑	◑	✱	◑	◑	◑
K	铸铁	Iron		●		◑		◑		✱	◑	◑	◑
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◑	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✱			◑
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✱			◑

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting　◑ 一般切削 General Cutting　○ 一般切削(第二推荐) General Cutting(Second recommend)　✱ 不稳定切削 Unstable Cutting





外圆车刀 (External Toolholder): B69

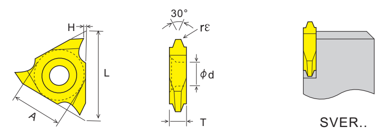
用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	φd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER 16 ACME	11EL 16 ACME	0.92	16	6.35	11		1.0	1.1					●				●	●	
	16ER 16 ACME	16EL 16 ACME	0.92	16	9.525	16		1.0	1.1					●				●	●	
	(ERM) 14 ACME	14 ACME	1.03	14				1.0	1.2					●				●	●	
	12 ACME	12 ACME	1.19	12				1.1	1.2					●				●	●	
	10 ACME	10 ACME	1.52	10				1.3	1.4					●				●	●	
	8 ACME	8 ACME	1.84	8				1.4	1.5					●				●	●	
	6 ACME	6 ACME	2.37	6				1.7	1.9					●				●	●	
	22ER 6 ACME	22EL 6 ACME	2.37	6	12.7	22		1.8	2.1					●				●	●	
	(ERM) 5 ACME	5 ACME	2.79	5				2.0	2.3					●				●	●	
	27ER 4 ACME	27EL 4 ACME	3.43	4	15.87	27		2.4	2.7					●				●	●	
	3 ACME	3 ACME	4.45	3				2.9	3.3					●				●	●	

内孔车刀 (Internal Toolholder): B75-B77

用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	φd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	11IR 16 ACME	11IL 16 ACME	0.92	16	6.35	11		0.9	0.9					●				●	●	
	16IR 16 ACME	16IL 16 ACME	0.92	16	9.525	16		1.0	1.1					●				●	●	
	(IRM) 14 ACME	14 ACME	1.03	14				1.1	1.2					●				●	●	
	12 ACME	12 ACME	1.19	12				1.2	1.3					●				●	●	
	10 ACME	10 ACME	1.52	10				1.2	1.3					●				●	●	
	8 ACME	8 ACME	1.84	8				1.4	1.5					●				●	●	
	6 ACME	6 ACME	2.37	6				1.7	1.9					●				●	●	
	22IR 6 ACME	22IL 6 ACME	2.37	6	12.7	22		1.8	2.1					●				●	●	
	(IRM) 5 ACME	5 ACME	2.79	5				2.0	2.3					●				●	●	
	27IR 4 ACME	27IL 4 ACME	3.43	4	15.87	27		2.3	2.6					●				●	●	
	3 ACME	3 ACME	4.45	3				2.9	3.3					●				●	●	

VER..

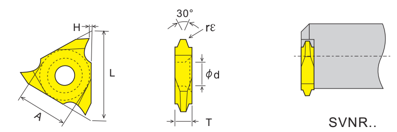
外圆车刀：B73 (External Toolholder)



用途 Application	规格型号 Specification [VER]	螺距 Pitch (tpi)	H	rε	L	T	A	φd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	22VER 6ACME	6		0.2	22	4.9	12.7	5.1					●				●	●	
	5ACME	5		0.25									●				●	●	
	4ACME	4		0.3									●				●	●	
	27VER 3.5ACME	3.5		0.3	27	8.7	15.87	6.35					●				●	●	
	3ACME	3		0.3									●				●	●	

VNR..

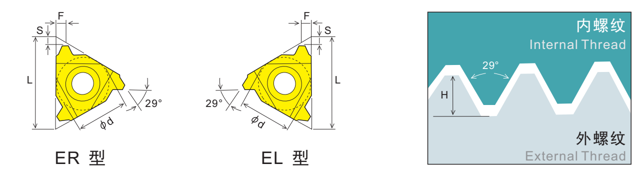
内孔车刀：B74 (Internal Toolholder)

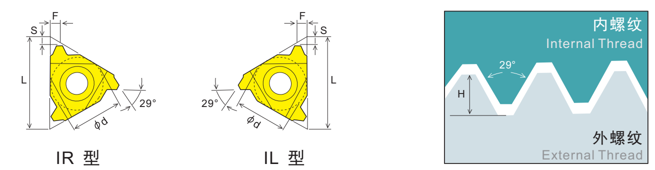


用途 Application	规格型号 Specification [VNR]	螺距 Pitch (tpi)	H	rε	L	T	A	φd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	22VNR 6ACME	6		0.2	22	4.9	12.7	5.1					●				●	●	
	5ACME	5		0.25									●				●	●	
	4ACME	4		0.3									●				●	●	
	27VNR 3.5ACME	3.5		0.3	27	8.7	15.87	6.35					●				●	●	
	3ACME	3		0.3									●				●	●	

STUB ACME 29°牙型 美制 短牙 梯形螺纹

螺纹应用领域：ACME改善型控制阀门用成型螺纹
Thread Application: Acme improved control valve forming thread





外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	φd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER 16 STACME	11EL 16 STACME	0.60	16	6.35	11		1.0	1.0					●				●	●	
	16ER 16 STACME	16EL 16 STACME	0.60	16	9.525	16		1.0	1.0					●				●	●	
	(ERM) 14 STACME	14 STACME	0.67	14				1.1	1.1					●				●	●	
	12 STACME	12 STACME	0.76	12				1.2	1.2					●				●	●	
	10 STACME	10 STACME	1.02	10				1.2	1.3					●				●	●	
	8 STACME	8 STACME	1.21	8				1.4	1.5					●				●	●	
	6 STACME	6 STACME	1.52	6				1.7	1.8					●				●	●	
	22ER6 STACME	22EL6 STACME	1.52	6	12.7	22		1.7	1.8					●				●	●	
	(ERM) 5 STACME	5 STACME	1.78	5				2.1	2.3					●				●	●	
	27ER4 STACME	27EL4 STACME	2.16	4	15.87	27		2.3	2.4					●				●	●	
	3 STACME	3 STACME	2.79	3				2.9	2.9					●				●	●	

内孔车刀 (Internal Toolholder): B75-B77

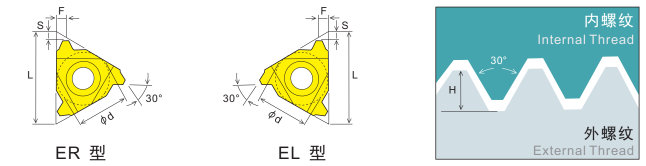
用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	φd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	11IR 16 STACME	11IL 16 STACME	0.60	16	6.35	11		1.0	1.0					●				●	●	
	16IR 16 STACME	16IL 16 STACME	0.60	16	9.525	16		1.0	1.0					●				●	●	
	(IRM) 14 STACME	14 STACME	0.67	14				1.1	1.1					●				●	●	
	12 STACME	12 STACME	0.76	12				1.1	1.2					●				●	●	
	10 STACME	10 STACME	1.02	10				1.2	1.3					●				●	●	
	8 STACME	8 STACME	1.21	8				1.4	1.5					●				●	●	
	6 STACME	6 STACME	1.52	6				1.7	1.8					●				●	●	
	22IR 6 STACME	22IL 6 STACME	1.52	6	12.7	22		1.7	1.8					●				●	●	
	(IRM) 5 STACME	5 STACME	1.78	5				2.1	2.3					●				●	●	
	27IR 4 STACME	27IL 4 STACME	2.16	4	15.87	27		2.3	2.4					●				●	●	
	3 STACME	3 STACME	2.79	3				2.9	2.9					●				●	●	

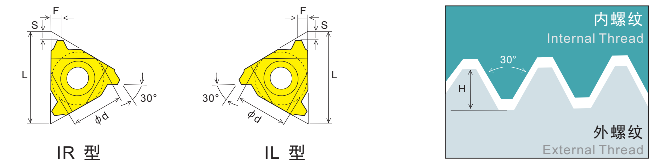
TR 30°牙型 DIN103 梯形螺纹

螺纹应用领域：传递动力用梯形螺纹
Thread Application: Trapezoidal thread for power transmission

材质 Material	钢 / 材料		PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◑		◑	●	✱	◑	◑	◑
M	不锈钢	Stainless Steel				◑		◑	◑	✱	◑	◑	◑
K	铸铁	Iron		●		◑		◑		✱	◑	◑	◑
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◑	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✱			◑
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✱			◑

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting　◑ 一般切削 General Cutting　○ 一般切削(第二推荐) General Cutting(Second recommend)　✱ 不稳定切削 Unstable Cutting





外圆车刀 (External Toolholder): B69

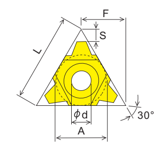
用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (mm)	φd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER 1.5 TR	11EL 1.5 TR	0.90	1.5	6.35	11		0.8	0.9					●				●	●	●
	16ER 1.5 TR	16EL 1.5 TR	0.90	1.5	9.525	16		1.0	1.1					●				●	●	●
	(ERM) 2.0 TR	2.0 TR	1.25	2.0				1.1	1.3					●				●	●	●
	3.0 TR	3.0 TR	1.75	3.0				1.3	1.5					●				●	●	●
	22ER 4.0 TR	22EL 4.0 TR	2.25	4.0	12.7	22		1.7	1.9					●				●	●	●
	(ERM) 5.0 TR	5.0 TR	2.75	5.0				2.1	2.5					●				●	●	●
	6.0 TR	6.0 TR	3.50	6.0				2.3	2.7					●				●	●	●
	27ER 6.0 TR	27EL 6.0 TR	3.50	6.0	15.87	27		2.3	2.7					●				●	●	●
	7.0 TR	7.0 TR	4.00	7.0				2.2	2.6					●				●	●	●

内孔车刀 (Internal Toolholder): B75-B77

用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (mm)	φd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	11IR 1.5 TR	11IL 1.5 TR	0.90	1.5	6.35	11		0.8	0.9					●				●	●	●
	16IR 1.5 TR	16IL 1.5 TR	0.90	1.5	9.525	16		1.0	1.1					●				●	●	●
	(IRM) 2.0 TR	2.0 TR	1.25	2.0				1.1	1.3					●				●	●	●
	3.0 TR	3.0 TR	1.75	3.0				1.3	1.5					●				●	●	●
	22IR 4.0 TR	22IL 4.0 TR	2.25	4.0	12.7	22		1.7	1.9					●				●	●	●
	(IRM) 5.0 TR	5.0 TR	2.75	5.0				2.1	2.5					●				●	●	●
	6.0 TR	6.0 TR	3.50	6.0				2.3	2.7					●				●	●	●
	27IR 6.0 TR	27IL 6.0 TR	3.50	6.0	15.87	27		2.3	2.7					●				●	●	●
	7.0 TR	7.0 TR	4.00	7.0				2.2	2.6					●				●	●	●

UER..

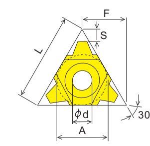
外圆车刀：B70 (External Toolholder)



用途 Application	规格型号 Specification [U]	切深 Depth Hmin	螺距 Pitch (mm)	φd	L	A	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	22UER 6.0 TR	3.50	6.0	5.1	22	12.7	2.0	11.0					●				●	●	
	7.0 TR	4.00	7.0	5.1	22	12.7	2.3	11.0					●				●	●	
	27UER 8.0 TR	4.57	8.0	6.35	27	15.87	2.6	13.7					●				●	●	
	9.0 TR		9.0	6.35	27	15.87	3.0	13.7					●				●	●	
	10.0 TR		10.0	6.35	27	15.87		13.7					●				●	●	

UIR..

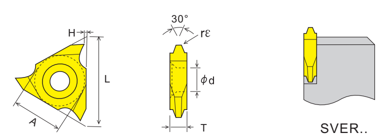
内孔车刀：B70 (Internal Toolholder)



用途 Application	规格型号 Specification [U]	切深 Depth Hmin	螺距 Pitch (mm)	φd	L	A	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	22UIR 6.0 TR	3.50	6.0	5.1	22	12.7	2.0	11.0					●				●	●	
	7.0 TR	4.00	7.0	5.1	22	12.7	2.3	11.0					●				●	●	
	27UIR 8.0 TR	4.57	8.0	6.35	27	15.87	2.6	13.7					●				●	●	
	9.0 TR		9.0	6.35	27	15.87	3.0	13.7					●				●	●	
	10.0 TR		10.0	6.35	27	15.87		13.7					●				●	●	

VER..

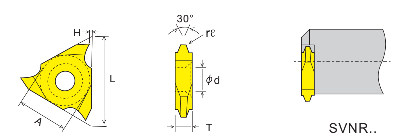
外圆车刀：B73 (External Toolholder)



用途 Application	规格型号 Specification [VER]	螺距 Pitch (mm)	H	rε	L	T	A	φd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	22VER 4.0TR	4.0		0.1	22	4.9	12.7	5.1					●				●	●	
	5.0TR	5.0		0.1									●				●	●	
	6.0TR	6.0		0.25									●				●	●	
	27VER 6.0TR	6.0		0.25	27	8.7	15.87	6.35					●				●	●	
	7.0TR	7.0		0.25									●				●	●	
	8.0TR	8.0		0.25									●				●	●	
	9.0TR	9.0		0.25									●				●	●	
	10.0TR	10.0		0.3									●				●	●	
	12.0TR	12.0		0.5									●				●	●	

VNR..

内孔车刀：B74 (Internal Toolholder)



用途 Application	规格型号 Specification [VNR]	螺距 Pitch (mm)	H	rε	L	T	A	φd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	22VNR 4.0TR	4.0		0.1	22	4.9	12.7	5.1					●				●	●	
	5.0TR	5.0		0.1									●				●	●	
	6.0TR	6.0		0.25									●				●	●	
	27VNR 6.0TR	6.0		0.25	27	8.7	15.87	6.35					●				●	●	
	7.0TR	7.0		0.25									●				●	●	
	8.0TR	8.0		0.25									●				●	●	
	9.0TR	9.0		0.25									●				●	●	
	10.0TR	10.0		0.3									●				●	●	
	12.0TR	12.0		0.5									●				●	●	

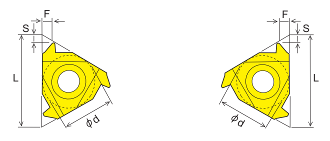
数控刀片
CN
DN
RN
KN
175
SN
TN
VN
WN
CC
DC
RC
SC
WB
TB
TC
TP
VB
VC
三角浅槽
TGF
GBA
T.N/E
小零件
CTP
TKF
切槽切断
MG.
MR.
SP.
GMM
TDC
后车削
ABS
TBP
TKFB
内孔切槽
GER
GR
螺纹车削刀片
铣削刀片

ABUT

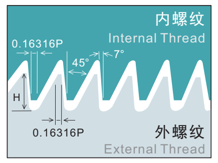
45°+7°牙型
美制
锯齿螺纹

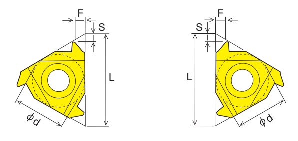
螺纹应用领域：单向受力较大，传递动力用螺纹
Thread Application: One way force is large, and the thread for power transmission

材质 Material		切削形态: Cutting Environment — ● 稳定切削 Stable Cutting; ◐ 一般切削 General Cutting; ○ 一般切削(第二推荐) General Cutting(Second recommend); ✖ 不稳定切削 Unstable Cutting	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✖	◐	◐	◐
M	不锈钢	Stainless Steel				○		○	○	✖	○	○	○
K	铸铁	Iron		●		◐		◐		✖	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◐

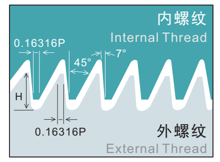


ER 型　　EL 型





IR 型　　IL 型



外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	11ER 20 ABUT	11EL 20 ABUT	0.84	20	6.35	11		1.0	1.4					●				●	●	
	16 ABUT	16 ABUT	1.05	16				1.3	1.9					●				●	●	
	16ER 20 ABUT	16EL 20 ABUT	0.84	20	9.525	16		1.0	1.4					●				●	●	
	16 ABUT	16 ABUT	1.05	16				1.3	1.9					●				●	●	
	12 ABUT	12 ABUT	1.40	12				1.4	2.0					●				●	●	
	10 ABUT	10 ABUT	1.68	10				1.5	2.3					●				●	●	
	22ER 8 ABUT	22EL 8 ABUT	2.10	8	12.7	22		2.0	3.2					●				●	●	
	6 ABUT	6 ABUT	2.80	6				2.2	3.5					●				●	●	

内孔车刀 (Internal Toolholder): B75-B77

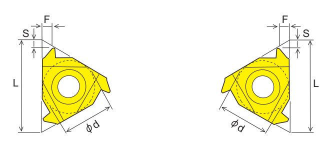
用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	11IR 20 ABUT	11IL 20 ABUT	0.84	20	6.35	11		1.0	1.4					●				●	●	
	16 ABUT	16 ABUT	1.05	16				1.3	1.9					●				●	●	
	16IR 20 ABUT	16IL 20 ABUT	0.84	20	9.525	16		1.0	1.4					●				●	●	
	16 ABUT	16 ABUT	1.05	16				1.3	1.9					●				●	●	
	12 ABUT	12 ABUT	1.40	12				1.4	2.0					●				●	●	
	10 ABUT	10 ABUT	1.68	10				1.5	2.3					●				●	●	
	22IR 8 ABUT	22IL 8 ABUT	2.10	8	12.7	22		2.0	3.2					●				●	●	
	6 ABUT	6 ABUT	2.80	6				2.2	3.5					●				●	●	

BBUT

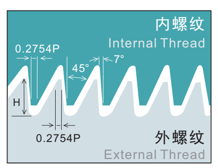
45°+7°牙型
英制
锯齿螺纹

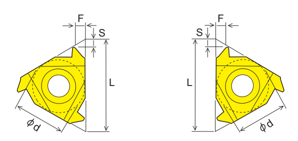
螺纹应用领域：单向受力较大，传递动力用螺纹
Thread Application: One way force is large, and the thread for power transmission

材质 Material		切削形态: Cutting Environment — ● 稳定切削 Stable Cutting; ◐ 一般切削 General Cutting; ○ 一般切削(第二推荐) General Cutting(Second recommend); ✖ 不稳定切削 Unstable Cutting	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✖	◐	◐	◐
M	不锈钢	Stainless Steel				○		○	○	✖	○	○	○
K	铸铁	Iron		●		◐		◐		✖	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◐

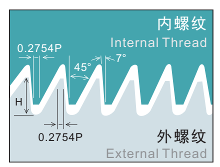


ER 型　　EL 型





IR 型　　IL 型



外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	16ER 16 BBUT	16EL 16 BBUT	0.80	16	9.525	16		1.1	1.6					●				●	●	
	12 BBUT	12 BBUT	1.07	12				1.4	2.1					●				●	●	
	10 BBUT	10 BBUT	1.28	10				1.4	2.2					●				●	●	
	8 BBUT	8 BBUT	1.61	8				1.6	2.5					●				●	●	
	22ER 8 BBUT	22EL 8 BBUT	1.61	8	12.7	22		1.6	2.5					●				●	●	

内孔车刀 (Internal Toolholder): B75-B77

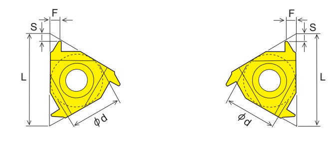
用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	16IR 16 BBUT	16IL 16 BBUT	0.80	16	9.525	16		1.1	1.6					●				●	●	
	12 BBUT	12 BBUT	1.07	12				1.4	2.1					●				●	●	
	10 BBUT	10 BBUT	1.28	10				1.4	2.2					●				●	●	
	8 BBUT	8 BBUT	1.61	8				1.6	2.5					●				●	●	
	22IR 8 BBUT	22IL 8 BBUT	1.61	8	12.7	22		1.6	2.5					●				●	●	

SAGE

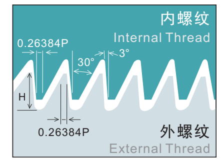
30°+3°牙型
公制
锯齿螺纹

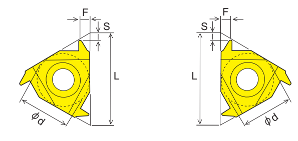
螺纹应用领域：单向受力较大，传递动力用螺纹
Thread Application: One way force is large, and the thread for power transmission

材质 Material		切削形态: Cutting Environment — ● 稳定切削 Stable Cutting; ◐ 一般切削 General Cutting; ○ 一般切削(第二推荐) General Cutting(Second recommend); ✖ 不稳定切削 Unstable Cutting	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✖	◐	◐	◐
M	不锈钢	Stainless Steel				○		○	○	✖	○	○	○
K	铸铁	Iron		●		◐		◐		✖	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◐

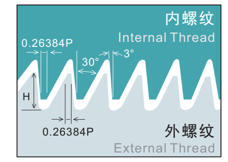


ER 型　　EL 型





IR 型　　IL 型



外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (mm)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	16ER 2.0 SAGE	16EL 2.0 SAGE	1.74	2.0	9.525	16		1.47	2.08					●				●	●	
	22ER 2.0 SAGE	22EL 2.0 SAGE	1.74	2.0	12.7	22		1.47	2.08					●				●	●	
	3.0 SAGE	3.0 SAGE	2.60	3.0				1.79	2.60					●				●	●	
	4.0 SAGE	4.0 SAGE	3.55	4.0				1.93	3.20					●				●	●	

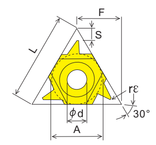
内孔车刀 (Internal Toolholder): B75-B77

用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (mm)	ϕd	L	rε	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	16IR 2.0 SAGE	16IL 2.0 SAGE	1.50	2.0	9.525	16		1.52	2.2					●				●	●	
	22IR 3.0 SAGE	22IL 3.0 SAGE	2.25	3.0	12.7	22		1.66	2.9					●				●	●	
	4.0 SAGE	4.0 SAGE	3.09	4.0				2.12	3.2					●				●	●	

材质 Material		切削形态: Cutting Environment — ● 稳定切削 Stable Cutting; ◐ 一般切削 General Cutting; ○ 一般切削(第二推荐) General Cutting(Second recommend); ✖ 不稳定切削 Unstable Cutting	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◐		◐	●	✖	◐	◐	◐
M	不锈钢	Stainless Steel				○		○	○	✖	○	○	○
K	铸铁	Iron		●		◐		◐		✖	◐	◐	◐
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐	○	○	○	○	○	○
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✖			◐
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✖			◐

UER..

外螺纹加工
External thread processing

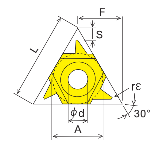


外圆车刀：B70
(External Toolholder)

用途 Application	规格型号 Specification [U]	切深 Depth Hmin	螺距 Pitch (mm)	ϕd	L	rε	A	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
	22UER 5.0 SAGE		5.0	5.1	22	0.62	12.7	11.0					●				●	●	
	6.0 SAGE		6.0			0.75							●				●	●	

UIR..

内螺纹加工
Internal thread processing

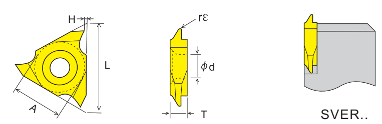


内孔车刀：B70
(Internal Toolholder)

用途 Application	规格型号 Specification [U]	切深 Depth Hmin	螺距 Pitch (mm)	ϕd	L	rε	A	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
	22UIR 5.0 SAGE		5.0	5.1	22	0.62	12.7	11.0					●				●	●	
	6.0 SAGE		6.0			0.75							●				●	●	

VER..

外螺纹加工
External thread processing

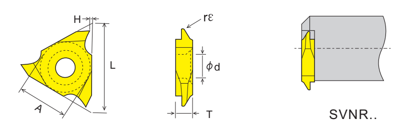


外圆车刀：B73
(External Toolholder)

用途 Application	规格型号 Specification [VER]	螺距 Pitch (mm)	H	rε	L	T	A	ϕd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
	27VER 8.0 SAGE	8.0		0.8	27	8.7	15.87	6.35					●				●	●	

VNR..

内螺纹加工
Internal thread processing



内孔车刀：B74
(Internal Toolholder)

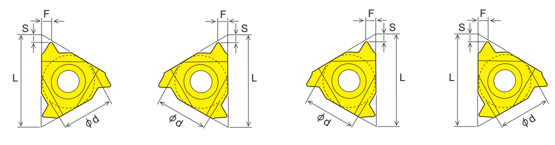
用途 Application	规格型号 Specification [VNR]	螺距 Pitch (mm)	H	rε	L	T	A	ϕd	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
	27VNR 8.0 SAGE	8.0		0.2	27	8.7	15.87	6.35					●				●	●	

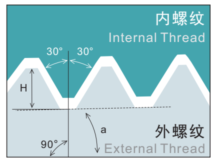
API 石油管螺纹 天然气工业 螺纹刀片

螺纹应用领域：石油及天然气工业轴肩连接用螺纹
Thread Application: Petroleum and natural gas industries - screw threads for shoulder connections

材质 Material			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✲	◕	◕	◕
M	不锈钢	Stainless Steel				◷		◷	◷	✲	◷	◷	◷
K	铸铁	Iron		●		◕		◕		✲	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	◷	◷	◷	◷	◷	◷
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✲			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✲			◕

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ◷ 一般切削(第二推荐) General Cutting(Second recommend) ✲ 不稳定切削 Unstable Cutting


ER 型 EL 型 IR 型 IL 型



刀片规格 Inserts	适用螺纹管规格 Applicable specification of threaded pipe
4API382	N23~NC50
4API383	NC56~NC77
4API502	6-5/8"REG,5-1/2"FH,6-5/8"FH
4API503	5-1/2",7-5/8",8-5/8"REG
5API403	2-3/8"~4-1/2"REG,3-1/2"FH,4-1/2"FH
6API551	NC10~NC16

外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	a	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	22ER 4API382	22EL 4API382	3.09	4	12.7	22	2°	2.1	2.8					●				●	●	
	4API383	4API383	3.08	4			3°	2.1	2.8					●				●	●	
	4API502	4API502	3.75	4			2°	2.0	2.9					●				●	●	
	4API503	4API503	3.74	4			3°	2.0	2.9					●				●	●	
	5API403	5API403	2.99	5			3°	1.8	2.6					●				●	●	
	6API551	6API551	1.41	6			1°	2.6	2.0					●				●	●	
	27ER 4API382	27EL 4API382	3.09	4	15.87	27	2°	2.1	2.8					●				●	●	
	4API383	4API383	3.08	4			3°	2.1	2.8					●				●	●	
	4API502	4API502	3.75	4			2°	2.1	3.1					●				●	●	
	4API503	4API503	3.74	4			3°	2.1	3.1					●				●	●	
	5API403	5API403	2.99	5			3°	1.9	2.7					●				●	●	

内孔车刀 (Internal Toolholder): B75-B77

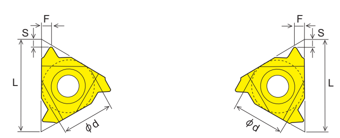
用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	a	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	22IR 4API382	22IL 4API382	3.09	4	12.7	22	2°	2.1	2.8					●				●	●	
	4API383	4API383	3.08	4			3°	2.1	2.8					●				●	●	
	4API502	4API502	3.75	4			2°	2.1	3.1					●				●	●	
	4API503	4API503	3.74	4			3°	2.0	2.9					●				●	●	
	5API403	5API403	2.99	5			3°	1.8	2.6					●				●	●	
	6API551	6API551	1.41	6			1°	2.6	2.0					●				●	●	
	27IR 4API382	27IL 4API382	3.09	4	15.87	27	2°	2.1	2.8					●				●	●	
	4API383	4API383	3.08	4			3°	2.1	2.8					●				●	●	
	4API502	4API502	3.75	4			2°	2.1	3.1					●				●	●	
	4API503	4API503	3.74	4			3°	2.1	3.1					●				●	●	
	5API403	5API403	2.99	5			3°	1.9	2.7					●				●	●	

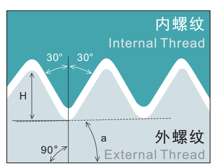
API RD 圆齿 天然气工业 石油管螺纹

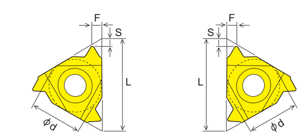
螺纹应用领域：石油及天然气工业用螺纹
Thread Application: Threads for petroleum and natural gas industries

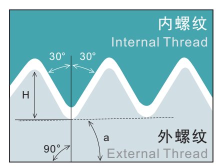
材质 Material			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✲	◕	◕	◕
M	不锈钢	Stainless Steel				◷		◷	◷	✲	◷	◷	◷
K	铸铁	Iron		●		◕		◕		✲	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	◷	◷	◷	◷	◷	◷
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✲			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✲			◕

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ◷ 一般切削(第二推荐) General Cutting(Second recommend) ✲ 不稳定切削 Unstable Cutting


ER 型 EL 型




IR 型 IL 型



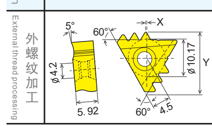
外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	a	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	16ER 10APIRD	16EL 10APIRD	1.41	10	9.525	16	1.47°	1.2	1.4					●				●	●	
	8APIRD	8APIRD	1.81	8				1.3	1.5					●				●	●	

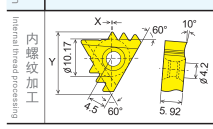
内孔车刀 (Internal Toolholder): B75-B77

用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (tpi)	ϕd	L	a	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	16IR 10APIRD	16IL 10APIRD	1.41	10	9.525	16	1.47°	1.2	1.4					●				●	●	
	8APIRD	8APIRD	1.81	8				1.3	1.5					●				●	●	

外圆车刀 (External Toolholder): B78

用途 Application	尺寸标示 Dimensioning	规格型号 Specification	螺距 Pitch (tpi)	齿数	a	X	Y	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing		22ER 10APIRD-4	10	4	1.47°	0.18	17.1					●				●	●	
		8APIRD-3	8	3		0.32	17.1					●				●	●	

内孔车刀 (Internal Toolholder): B79-B80

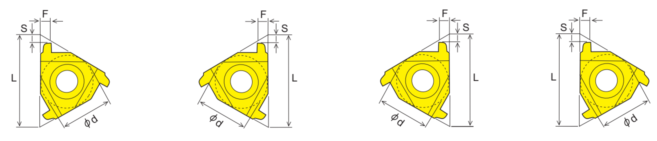
用途 Application	尺寸标示 Dimensioning	规格型号 Specification	螺距 Pitch (tpi)	齿数	a	X	Y	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing		22IR 10APIRD-4	10	4	1.47°	0.18	17.1					●				●	●	
		8APIRD-3	8	3		0.32	17.1					●				●	●	

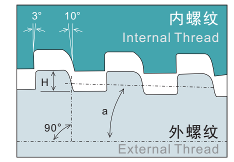
BUT 梯形 套管 石油管螺纹

螺纹应用领域：石油梯形套管用螺纹
Thread Application: Thread for petroleum trapezoidal casing

材质 Material			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✲	◕	◕	◕
M	不锈钢	Stainless Steel				◷		◷	◷	✲	◷	◷	◷
K	铸铁	Iron		●		◕		◕		✲	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	◷	◷	◷	◷	◷	◷
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✲			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✲			◕

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ◷ 一般切削(第二推荐) General Cutting(Second recommend) ✲ 不稳定切削 Unstable Cutting


ER 型 EL 型 IR 型 IL 型



刀片规格 Inserts	适用螺纹管规格 Applicable specification of threaded pipe
5BUT75	4-1/2"~13-3/8"
5BUT1	16"~20"

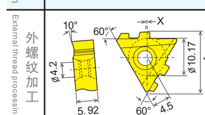
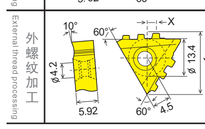
外圆车刀 (External Toolholder): B69

用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (mm)	ϕd	L	a	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	22ER 5BUT75	22EL 5BUT75	1.55	5.0	12.7	22	0.75°	3.1	1.9					●				●	●	
	5BUT1	5BUT1	1.55	5.0			1°	3.1	1.9					●				●	●	

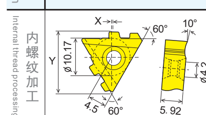
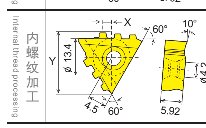
内孔车刀 (Internal Toolholder): B75-B77

用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (mm)	ϕd	L	a	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	22IR 5BUT75	22IL 5BUT75	1.55	5.0	12.7	22	0.75°	2.8	1.9					●				●	●	
	5BUT1	5BUT1	1.55	5.0			1°	2.8	1.9					●				●	●	

外圆车刀 (External Toolholder): B78

用途 Application	尺寸标示 Dimensioning	规格型号 Specification	螺距 Pitch (tpi)	齿数	a	X	Y	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing		22ER 5BUT75-2	5	2	0.75°	2.05	16.8					●				●	●	
外螺纹加工 External thread processing		27ER 5BUT75-3	5	3	0.75°	2.46	21.9					●				●	●	

内孔车刀 (Internal Toolholder): B79-B80

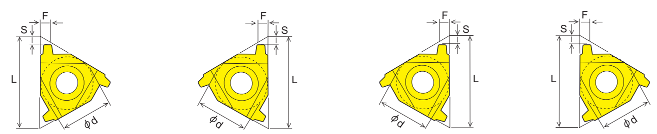
用途 Application	尺寸标示 Dimensioning	规格型号 Specification	螺距 Pitch (tpi)	齿数	a	X	Y	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing		22IR 5BUT75-2	5	2	0.75°	1.14	16.65					●				●	●	
内螺纹加工 Internal thread processing		27IR 5BUT75-3	5	3	0.75°	2.46	21.9					●				●	●	

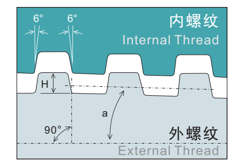
EL 直线型 套管 石油管螺纹

螺纹应用领域：石油直线型套管用螺纹
Thread Application: Thread for linear casing

材质 Material			PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
P	钢	Steel			●	◕		◕	●	✲	◕	◕	◕
M	不锈钢	Stainless Steel				◷		◷	◷	✲	◷	◷	◷
K	铸铁	Iron		●		◕		◕		✲	◕	◕	◕
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◕	◷	◷	◷	◷	◷	◷
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✲			◕
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✲			◕

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◕ 一般切削 General Cutting ◷ 一般切削(第二推荐) General Cutting(Second recommend) ✲ 不稳定切削 Unstable Cutting


ER 型 EL 型 IR 型 IL 型



刀片规格 Inserts	适用螺纹管规格 Applicable specification of threaded pipe
6EL15	5"~7-5/8"
5EL125	8-5/8"~10-3/4"

外圆车刀 (External Toolholder): B69

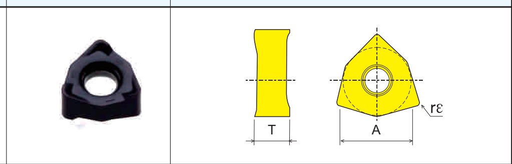
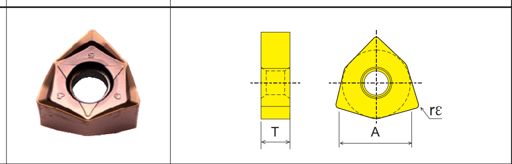
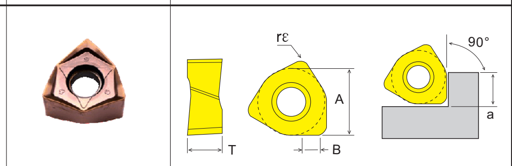
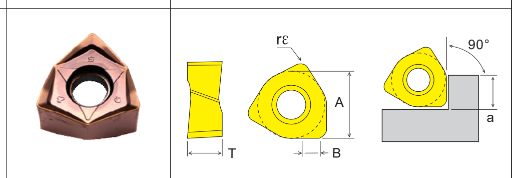
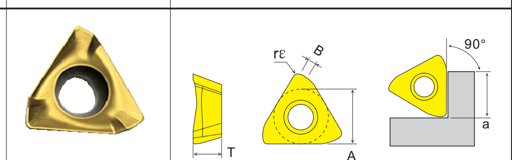
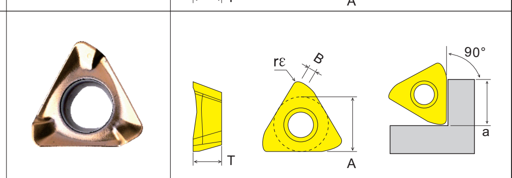
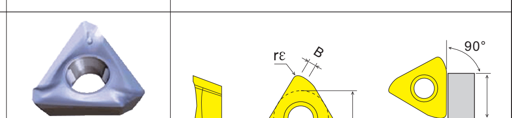
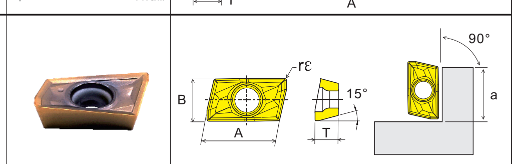
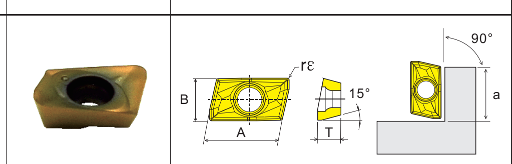
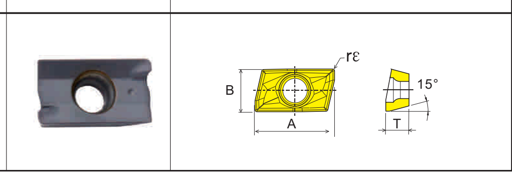
用途 Application	规格型号 Specification [ER]	[EL]	切深 Depth Hmin	螺距 Pitch (mm)	ϕd	L	a	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
外螺纹加工 External thread processing	22ER 6EL15	22EL 6EL15	1.21	6.0	12.7	22	1.5°	1.9	1.9					●				●	●	
	5EL125	5EL125	1.71	5.0			1.25°	2.3	2.4					●				●	●	

内孔车刀 (Internal Toolholder): B75-B77

用途 Application	规格型号 Specification [IR]	[IL]	切深 Depth Hmin	螺距 Pitch (mm)	ϕd	L	a	S	F	PCD	CBN-K	CBN-S	ZN60	ZK01	ZM826	ZP15	ZP150	ZP680	ZM856	ZM860
内螺纹加工 Internal thread processing	22IR 6EL15	22IL 6EL15	1.39	6.0	12.7	22	1.5°	1.8	1.9					●				●	●	
	5EL125	5EL125	1.91	5.0			1.25°	2.2	2.4					●				●	●	

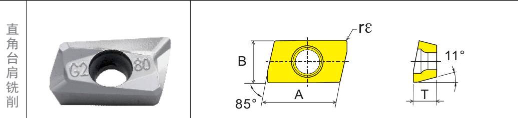
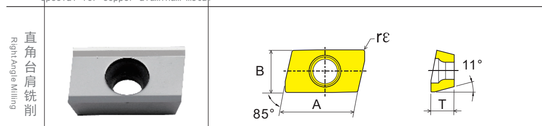
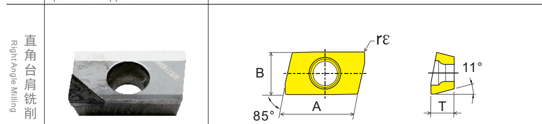
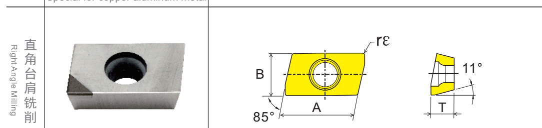
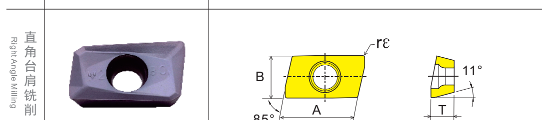
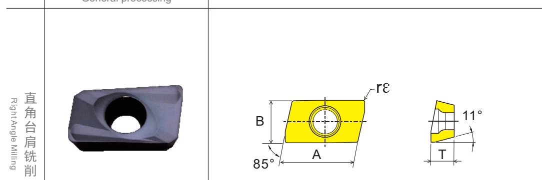
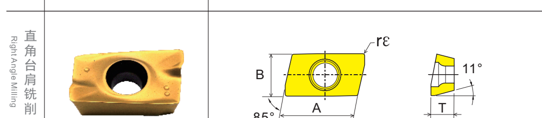
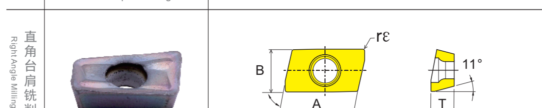
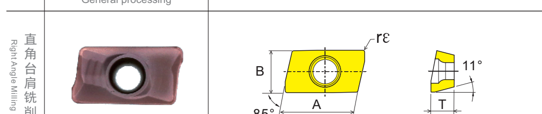
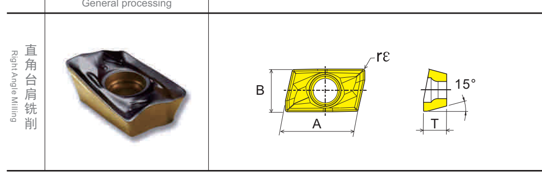
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✤ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
P	钢	Steel			●	◐		◐	✤	✤	✤	◐	●
M	不锈钢	Stainless Steel				◐		◐	✤	✤	✤	◐	●
K	铸铁	Iron		●		◐		◐	✤	✤	✤		
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐						
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✤	✤	◐	●
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✤	✤	◐	●

用途 Application	产品图片 Product Image	几何尺寸 Dimensioning	规格型号 Specification	rε	A	B	T	L	a	配套刀柄 Matching Toolholder	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
高进给铣削加工			WNMU 0404	0.8	6.35	-	4.76			刀柄：(Toolholder) D03							●	●	●	●	●
高进给铣削加工			WNMU 080604EN-GM	0.4	14.02	-	6.65			刀柄：(Toolholder) D04											
			080608EN-GM	0.8	14.02	-	6.65										●	●	●	●	●
			低阻力 080608EN-SM	0.8	14.02	-	6.65														
			重切削用 080608EN-GH	0.8	14.02	-	6.65														
直角台肩铣削			6NGU 060404R-M	0.4	9.26	2.36	4.76	-	6.2	刀柄：(Toolholder) D05-D06							●		●	●	
			060405R-M	0.5	9.26	2.36	4.76	-	6.2								●		●	●	
			060408R-M	0.8	9.26	1.96	4.76	-	6.2								●		●	●	
			060410R-M	1.0	9.26	1.76	4.76	-	6.2								●		●	●	
			060416R-M	1.6	9.26	1.16	4.76	-	6.2								●		●	●	
直角台肩铣削			6NGU 090504R-M	0.4	13.05	2.2	6.74	-	9.2	刀柄：(Toolholder) D05-D06							●		●		
			090508R-M	0.8	13.05	2.0	6.74	-	9.2								●		●		
			090516R-M	1.6	13.05	1.2	6.74	-	9.2								●		●		
直角台肩铣削			3PKT 100404R-M	0.4	6.9	1.3	4	-	7	刀柄：(Toolholder) D07-D08							●		●	●	
			100408R-M	0.5	6.9	0.9	4	-	7								●		●	●	
			150508R-M	0.8	10.7	1.6	5	-	11								●		●	●	
			190608R-M	1.0	13.5	2.0	6	-	15								●		●	●	
			190616R-M	1.6	13.5	1.2	6	-	15								●		●	●	
直角台肩铣削			3PKT 100404R-ML	6.9	6.9	0.9	4	-	7	刀柄：(Toolholder) D07-D08							●		●	●	
			150508R-ML	10.7	10.7	1.6	5	-	11								●		●	●	
			190608R-ML	13.5	13.5	2.0	6	-	15								●		●	●	
直角台肩铣削	 铝专用 Special for Aluminum		3PHT 100404R-AL	6.9	6.9	1.3	4	-	7	刀柄：(Toolholder) D07-D08					●						
			100408R-AL	6.9	6.9	0.9	4	-	7						●						
			150508R-AL	10.7	10.7	1.6	5	-	11						●						
			190608R-AL	13.5	13.5	2.0	6	-	15						●						
直角台肩铣削			JDMT 100304R	0.4	11.0	6.1	3.5	-	10	刀柄：(Toolholder) D09-D10	●	●	●					●	●	●	
			100308R	0.8	11.0	6.1	3.5	-	10		●	●	●					●	●	●	
			100320R	2.0	11.0	6.1	3.5	-	10		●	●	●								
			100332R	3.2	11.0	6.1	3.5	-	10		●	●	●								
			150504R	0.4	16.0	9.12	5.0	-	15		●	●	●					●	●	●	
			150508R	0.8	16.0	9.12	5.0	-	15		●	●	●					●	●	●	
			150520R	2.0	16.0	9.12	5.0	-	15		●	●	●								
			150530R	3.0	16.0	9.12	5.0	-	15		●	●	●								
直角台肩铣削			JDMT 070202R	0.2	6.4	4.3	2.45		6	刀柄：(Toolholder) D11	●	●	●					●	●	●	
			070204R	0.4	6.4	4.3	2.45		6		●	●	●					●	●	●	
			070208R	0.8	6.4	4.3	2.45		6		●	●	●					●	●	●	
			EDMT 070220R-T	2.0	6.4	4.3	2.5		6		●	●	●								
			070220R	2.0	6.4	4.3	2.5		6		●	●	●								
直角台肩铣削			APKT 1003PDR-HM	0.5	10.95	6.7	3.55			刀柄：(Toolholder) D12	●	●	●		●						
			1003PDTR-76	0.5	11.00	6.7	3.47				●	●	●		●						
			1003PDTR-RM	0.5	11.00	6.7	3.47				●	●	●			●	●		●		
			100308PDTR-RM	0.8	11.00	6.7	3.47				●	●	●			●	●		●		
			100310PDR-RM	1.0	10.75	6.7	3.47				●	●	●								
			100312TR-RM	1.2	10.50	6.7	3.47				●	●	●								
			100316PDTR-RM	1.6	10.90	6.7	3.47				●	●	●								
			100320PDTR-RM	2.0	10.90	6.7	3.47				●	●	●								

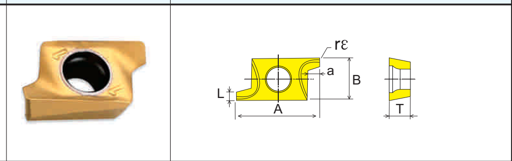
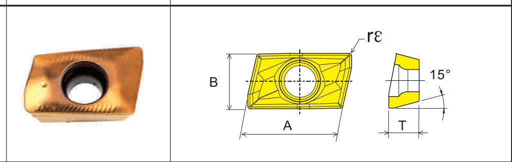
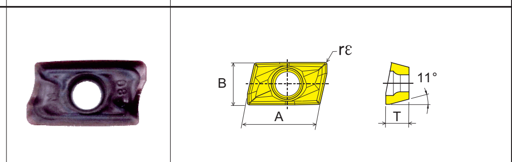
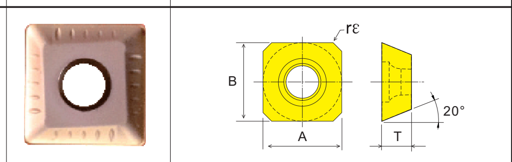
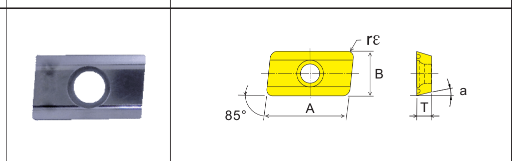
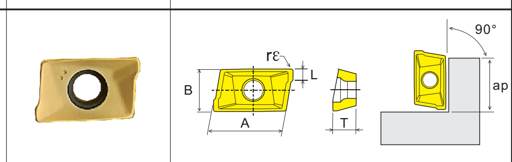
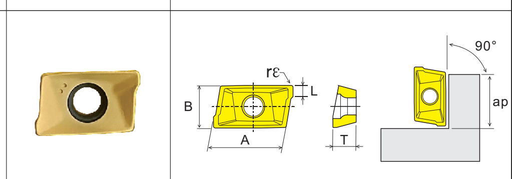
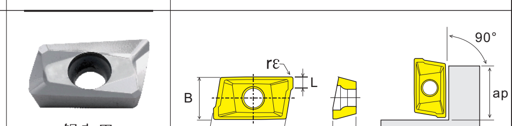
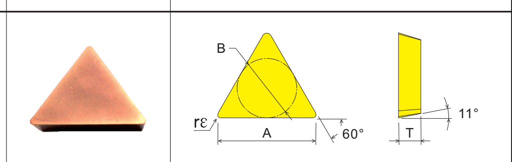
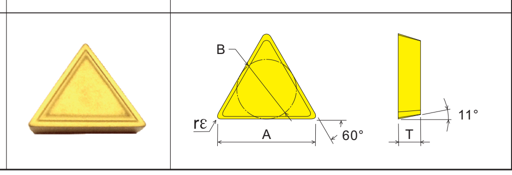
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✤ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
P	钢	Steel			●	◐		◐	✤	✤	✤	◐	●
M	不锈钢	Stainless Steel				◐		◐	✤	✤	✤	◐	●
K	铸铁	Iron		●		◐		◐	✤	✤	✤		
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐						
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✤	✤	◐	●
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✤	✤	◐	●

用途 Application	产品图片 Product Image	几何尺寸 Dimensioning	规格型号 Specification	rε	A	B	T	L	a	配套刀柄 Matching Toolholder	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
直角台肩铣削	 铜铝非铁金属专用 Special for copper aluminum metal		APKT 1135PDER-G2	0.8	11	6.35	3.5			刀柄：(Toolholder) D14-D16, D48,D52					●						
			1604PDER-G2	0.8	16.5	9.525	4.76								●						
直角台肩铣削	 铜铝非铁金属专用 Special for copper aluminum metal		APKT 160402-AL	0.2	16.5	9.525	4.76			刀柄：(Toolholder) D14-D16, D48,D52					●						
			160404-AL	0.4	16.5	9.525	4.76								●						
			160408-AL	0.8	16.5	9.525	4.76								●						
直角台肩铣削	 铜铝非铁金属专用 Special for copper aluminum metal		APKT 113502	0.2	11	6.35	3.5			刀柄：(Toolholder) D14-D16, D48,D52	●										
			113504	0.4	11	6.35	3.5				●										
			113508	0.8	11	6.35	3.5				●										
			160402	0.2	16.5	9.525	4.76				●										
			160404	0.4	16.5	9.525	4.76				●										
			160408	0.8	16.5	9.525	4.76				●										
直角台肩铣削	 铸铁及淬火超硬材料加工 Cast iron and hard to cut materials		APKT 113502	0.2	11	6.35	3.5			刀柄：(Toolholder) D14-D16, D48,D52		●	●								
			113504	0.4	11	6.35	3.5					●	●								
			113508	0.8	11	6.35	3.5					●	●								
			160402	0.2	16.5	9.525	4.76					●	●								
			160404	0.4	16.5	9.525	4.76					●	●								
			160408	0.8	16.5	9.525	4.76					●	●								
直角台肩铣削	 通用加工 General processing		APMT 1135PDER-M2	0.8	11	6.35	3.5			刀柄：(Toolholder) D14-D16, D48,D52				●				●	●	●	●
			1604PDER-M2	0.8	16.5	9.525	4.76							●				●	●	●	●
直角台肩铣削	 通用加工 General processing		APMT 1135PDER-H1	0.4	11	6.35	3.5			刀柄：(Toolholder) D14-D16, D48,D52									●		
			1135PDER-H2	0.8	11	6.35	3.5							●				●	●	●	●
			1135PDER-H3	1.2	11	6.35	3.5												●		
			1135PDER-H4	1.6	11	6.35	3.5												●		
			1135PDER-H6	2.4	11	6.35	3.5												●		
			1604PDER-H1	0.4	16.5	9.525	4.76												●		
			1604PDER-H2	0.8	16.5	9.525	4.76							●				●	●	●	●
			1604PDER-H3	1.2	16.5	9.525	4.76												●		
			1604PDER-H4	1.6	16.5	9.525	4.76												●		
			1604PDER-H6	2.4	16.5	9.525	4.76												●		
			1604PDER-H8	3.2	16.5	9.525	4.76												●		
直角台肩铣削	 通用加工 General processing		APMT 1135PDER-DU	0.8	11	6.35	3.5			刀柄：(Toolholder) D14-D16, D48,D52				●		●	●	●	●	●	●
			1604PDER-DU	0.8	16.5	9.525	4.76							●		●	●	●	●	●	●
直角台肩铣削	 通用加工 General processing		APMT 1135PDER-KZ	0.8	11	6.35	3.5			刀柄：(Toolholder) D14-D16, D48,D52								●	●	●	●
			1604PDER-KZ	0.8	16.5	9.525	4.76											●	●	●	●
直角台肩铣削	 通用加工 General processing		APMT 1135PDER-ZM	0.8	11	6.35	3.5			刀柄：(Toolholder) D14-D16, D48,D52								●	●	●	
			1604PDER-ZM	0.8	16.5	9.525	4.76											●	●	●	
直角台肩铣削			R390- 11T304M-PM	0.4	10	6.8	3.59			刀柄：(Toolholder) D17-D18	●	●	●	●		●	●		●	●	●
			11T308M-PM	0.8	10	6.8	3.59				●	●	●	●		●	●		●	●	●
			11T316M-PM	1.6	10	6.8	3.59				●	●	●								
			11T331M-PM	3.1	10	6.8	3.59				●	●	●								
			170404M-PM	0.4	15.7	9.6	4.76				●	●	●	●		●	●		●	●	●
			170408M-PM	0.8	15.7	9.6	4.76				●	●	●	●		●	●		●	●	●
			170416M-PM	1.6	15.7	9.6	4.76				●	●	●								
			170431M-PM	3.1	15.7	9.6	4.76				●	●	●								

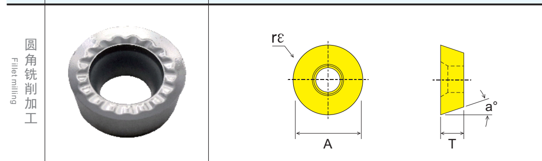
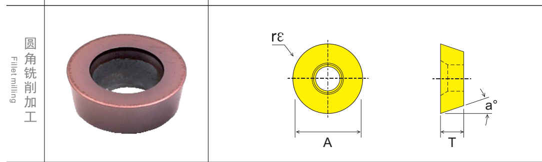
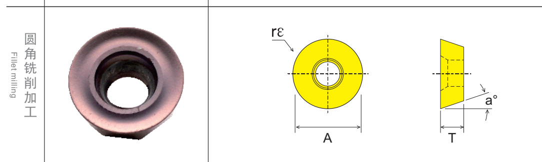
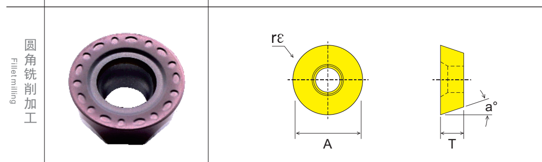
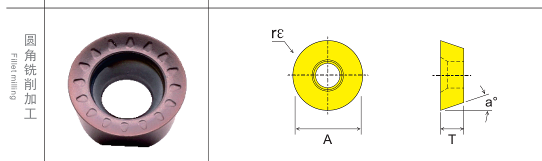
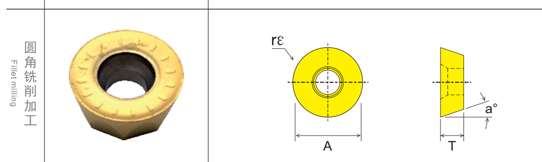
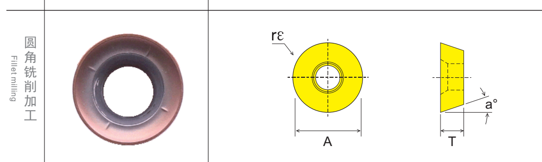
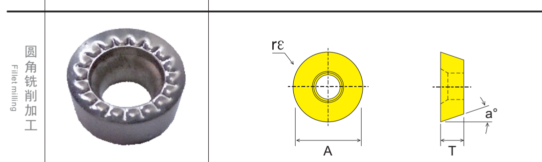
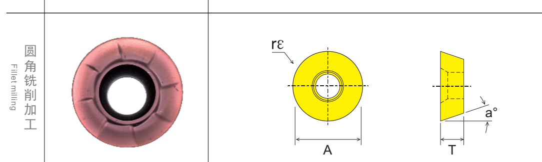
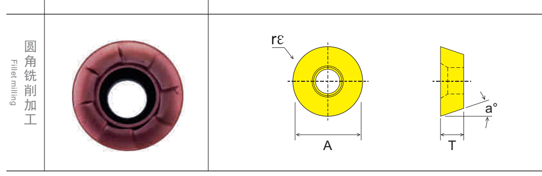
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ● 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

产品图片 Product Image / 几何尺寸 Dimensioning	用途 Application	规格型号 Specification	rε	A	B	T	L	a	配套刀柄 Matching Toolholder	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
	直角台肩铣削	RT 070204R-81	0.4	6.4	4.3	2.38	1.3	1.5	刀柄: (Toolholder) D19-D20	●	●	●				●		●		
		100304R-81	0.4	11	6.35	3.4	1.8	2.1		●	●	●				●		●		
		100304R-31	0.4	11	6.35	3.4	1.8	2.1		●	●	●				●		●		
		100308R-81	0.8	11	6.35	3.4	1.8	2.1		●	●	●				●		●		
	直角台肩铣削	XOMX 060208FR-E03	0.8	6.94	4.09	2.45			刀柄: (Toolholder) D20							●		●		
		060208R-M05	0.8	6.94	4.09	2.45										●		●		
		090308FR-E05	0.8	10.8	6.35	3.65										●		●		
		120408TR-M06	0.8	11.41	8.18	4.15										●		●		
	直角台肩铣削	AOMT 123602PEER-M	0.2	12	6.6	3.6			刀柄: (Toolholder) D21											
		123604PEER-M	0.4															●		
		123608PEER-M	0.8															●		
		123612PEER-M	1.2															●		
		123616PEER-M	1.6																	
		123620PEER-M	2.0																	
		123624PEER-M	2.4																	
		123632PEER-M	3.2																	
	直角台肩铣削	SEET 09T308PER-PF	0.8	9.525	9.525	4.01			刀柄: (Toolholder) D22							●		●		
		09T308PER-PM	0.8	9.525	9.525	4.01										●		●		
		09T308PER-PR	0.8	9.525	9.525	4.01										●		●		
		SEET 120308PER-PF	0.8	13.308	13.308	4.04										●		●		
		120308PER-PM	0.8	13.308	13.308	4.04										●		●		
		120308PER-PR	0.8	13.308	13.308	4.04										●		●		
	直角台肩铣削	APET 120202SR	0.2	12.7	7.938	2.5		11°	刀柄: (Toolholder) D23,D47											
		120204SR	0.4	12.7	7.938	2.5		11°												
		120208SR	0.8	12.7	7.938	2.5		11°												
		APNT 120208SR	0.8	12.7	7.938	2.5		11°					●			●		●		
		ADET 160302SR	0.2	15.875	9.525	3.18		15°												
		160304SR	0.4	15.875	9.525	3.18		15°												
		160308SR	0.8	15.875	9.525	3.18		15°												
		ADNT 160308SR	0.8	15.875	9.525	3.18		15°					●			●		●		
	直角台肩铣削	AXMT 0602PER-EM	0.2	6	4.15	2.6	1.0	5.75	刀柄: (Toolholder) D24							●		●	●	
		060204R-EM	0.4	6	4.15	2.6	1.0	5.75								●		●	●	
		060208R-EM	0.8	6	4.15	2.6	1.0	5.75								●		●	●	
		060216R-EM	1.6	6	4.15	2.6	1.0	5.75								●		●	●	
	直角台肩铣削	AXMT 0903PER-ML	0.4	9.5	6.21	3.6	1.4	8.8	刀柄: (Toolholder) D24							●		●	●	
		0903PER-EML	0.4	9.5	6.21	3.6	0.84	8.8								●		●	●	
		090308R-EML	0.8	9.5	6.21	3.6	-	8.8								●		●	●	
		090316R-ML	1.6	9.5	6.21	3.6	-	8.8								●		●	●	
		090320R-EML	2.0	9.5	6.21	3.6	-	8.8								●		●	●	
		090332R-EML	3.2	9.5	6.21	3.6	-	8.8								●		●	●	
 铝专用 Special for Aluminum	直角台肩铣削	AXCT 060202R-AL	0.2	6	4.15	2.6	0.83	5.75	刀柄: (Toolholder) D24					●						
		060204R-AL	0.4	6	4.15	2.6	0.83	5.75						●						
		0903PER-AL	0.4	9.5	6.21	3.6	0.83	8.8						●						
	平面铣削/倒角加工	TPKN 110304	0.4	11	6.35	3.18			刀柄: (Toolholder) D25,D45				●		●	●	●	●	●	
		110308	0.8	11	6.35	3.18							●		●	●	●	●	●	
		160304	0.4	16.5	9.525	3.18							●		●	●	●	●	●	
		160308	0.8	16.5	9.525	3.18							●		●	●	●	●	●	
		220404	0.4	22	12.7	4.76							●		●	●	●	●	●	
		220408	0.8	22	12.7	4.76							●		●	●	●	●	●	
		220412	1.2	22	12.7	4.76							●		●	●	●	●	●	
		2204PDR	-	22	12.7	4.76							●		●	●	●	●	●	
	平面铣削/倒角加工	TPMR 090204	0.4	9.6	5.56	2.38			刀柄: (Toolholder) D25,D45											
		110304	0.4	11	6.35	3.18														
		110308	0.8	11	6.35	3.18														
		160304	0.4	16.5	9.525	3.18							●		●	●	●	●	●	
		160308	0.8	16.5	9.525	3.18							●		●	●	●	●	●	
		160312	1.2	16.5	9.525	3.18														
		220412	1.2	22	12.7	4.76							●		●	●	●	●	●	
		330916	1.6	33	19.05	9.52														

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ● 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

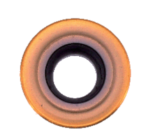
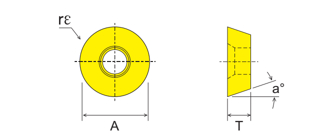
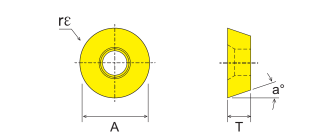
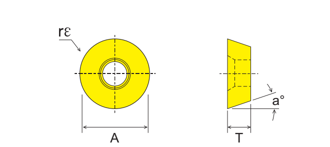
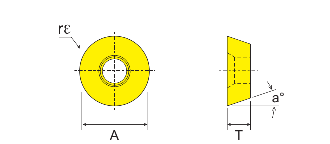
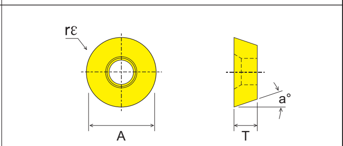
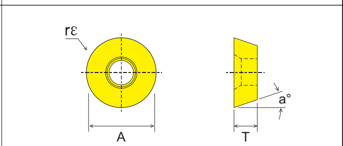
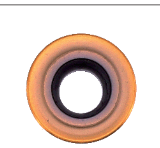
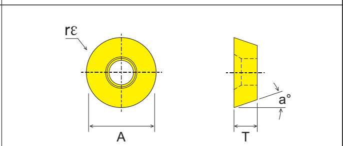
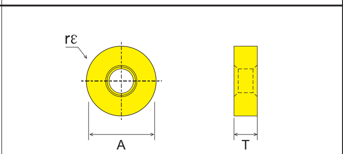
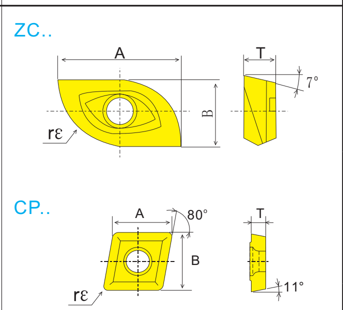
产品图片 Product Image / 几何尺寸 Dimensioning	用途 Application	规格型号 Specification	rε	A	B	T	L	a	配套刀柄 Matching Toolholder	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
	圆角铣削加工	RPGT 08T2-AL	4	8			2.78	11°	刀柄: (Toolholder) D29-D30					●						
		1003-AL	5	10			3.15	11°						●						
		10T3-AL	5	10			3.97	11°						●						
		1204-AL	6	12			4.76	11°						●						
	圆角铣削加工	RPEW 0802MO	4	8			2.38	11°	刀柄: (Toolholder) D29-D30				●		●		●	●	●	●
		1003MO	5	10			3.15	11°					●		●		●	●	●	●
		1003MO-DU	5	10			3.97	11°					●		●	●	●	●	●	●
		1204MOF	6	12			4.76	11°					●		●		●	●	●	●
	圆角铣削加工	RPKT 10T3MOF	5	10			3.97	11°	刀柄: (Toolholder) D29-D30								●	●	●	●
		1204MOF	6	12			4.76	11°									●	●	●	●
	圆角铣削加工	RPKT 10T3MOT	5	10			3.97	11°	刀柄: (Toolholder) D29-D30								●	●	●	●
		1204MOT	6	12			4.76	11°									●	●	●	●
	圆角铣削加工	RPMT 08T2MOE-JS	4	8			2.78	11°	刀柄: (Toolholder) D29-D30						●		●	●	●	●
		1003MOE-JS	5	10			3.18	11°							●		●	●	●	●
		10T3MOE-JS	5	10			3.97	11°							●		●	●	●	●
		1204MOE-JS	6	12			4.76	11°							●		●	●	●	●
	圆角铣削加工	RPMT 10T3MO-DU	5	10			3.97	11°	刀柄: (Toolholder) D29-D30							●	●	●	●	●
		1204MO-DU	6	12			4.76	11°								●	●	●	●	●
	圆角铣削加工	RPMT 08T2MO-GH	4	8			2.78	11°	刀柄: (Toolholder) D29-D30							●	●	●	●	●
		10T3MO-GH	5	10			3.97	11°								●	●	●	●	●
		1204MO-GH	6	12			4.76	11°								●	●	●	●	●
	圆角铣削加工	RCGT 0602-AL	3	6			2.38	7°	刀柄: (Toolholder) D32					●						
		0803-AL	4	8			3.15	7°						●						
		1003-AL	5	10			3.15	7°						●						
		10T3-AL	5	10			3.97	7°						●						
		1204-AL	6	12			4.76	7°						●						
	圆角铣削加工	RCKT 10T3MO-PM	5	10			3.97	7°	刀柄: (Toolholder) D32							●	●	●	●	●
		1204MO-PM	6	12			4.76	7°								●	●	●	●	●
		1606MO-PM	8	16			6.35	7°								●	●	●	●	●
		2006MO-PM	10	20			6.35	7°								●	●	●	●	●
	圆角铣削加工	RCKT 10T3MO-PR	5	10			3.97	7°	刀柄: (Toolholder) D32							●	●	●	●	●
		1204MO-PR	6	12			4.76	7°								●	●	●	●	●
		1606MO-PR	8	16			6.35	7°								●	●	●	●	●
		2006MO-PR	10	20			6.35	7°								●	●	●	●	●

数控刀片 | CN DN RN KN 175 SN TN VN WN | CC DC RC SC WB TB TC TP VB VC | 三角浅槽 TGF GBA T.N/E | 小零件 CTP TKF | 切槽切断 MG. MR. SP. GM. TD. | 后车削 ABS TBP TKFB | 内孔切槽 T.N/E GE. . GR | 螺纹车削刀片 | 铣削刀片

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

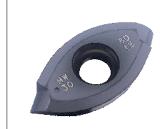
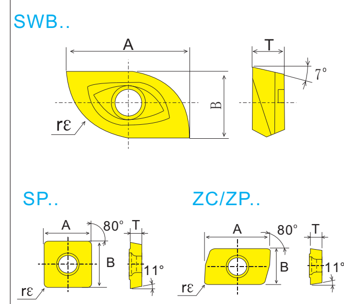
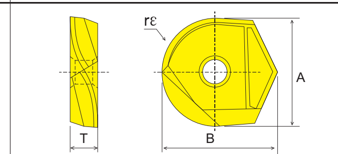
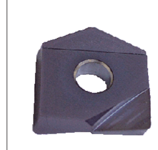
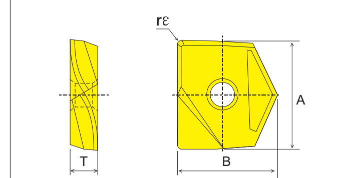
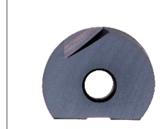
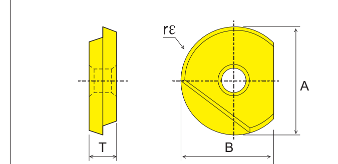
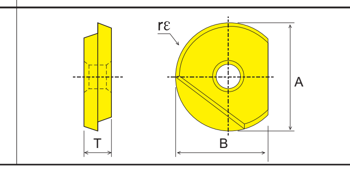
P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

Grades: PCD, CBN-K, CBN-S, ZN60, ZK01, ZC32S, ZP201, ZP150, ZP152, ZP153, ZP163

用途 Application	产品图片 Product Image	几何尺寸 Dimensioning	规格型号 Specification	rε	A	B	T	L	a	配套刀柄 Matching Toolholder	牌号 (●)
圆角铣削加工			RCMT 0803MO	4	8			3.18	7°	刀柄：(Toolholder) D32	ZP201, ZP152, ZP153
			1003MO	5	10			3.18	7°		
			10T3MO	5	10			3.97	7°		
			1204MO	6	12			4.76	7°		
			1606MO	8	16			6.35	7°		
			2006MO	10	20			6.35	7°		
圆角铣削加工			RCMX 0803MO	4	8			3.18	7°	刀柄：(Toolholder) D32	ZP201, ZP152, ZP153
			1003MO	5	10			3.18	7°		
			10T3MO	5	10			3.97	7°		
			1204MO	6	12			4.76	7°		
			1606MO	8	16			6.35	7°		
			2006MO	10	20			6.35	7°		
			2507MO	12.5	25			7.94	7°		
			3209MO	16	32			9.52	7°		
圆角铣削加工			RDKW 0501MO	2.5	5			1.59	15°	刀柄：(Toolholder) D34-D35	ZC32S, ZP150, ZP153
			0702MO	3.5	7			2.38	15°		
			0803MO	4	8			3.15	15°		
			10T3MO	5	10			3.97	15°		
			1204MO	6	12			4.76	15°		
			1604MO	8	16			4.76	15°		
			1605MO	8	16			5.56	15°		
			1606MO	8	16			6.35	15°		
			2006MO	10	20			6.35	15°		
圆角铣削加工			RDKX 10T3MO	5	10			3.97	15°	刀柄：(Toolholder) D34-D35	ZC32S, ZP150, ZP153
			1204MO	6	12			4.76	15°		
			1605MO	8	16			6.35	15°		
				10	20			6.35	15°		
圆角铣削加工			RDKX 10T3MP-1	5	10			3.97	15°	刀柄：(Toolholder) D34-D35	ZP150, ZP153
			1204MP-1	6	12			4.76	15°		
圆角铣削加工			RDMW 10T3MOT-PM	5	10			3.97	15°	刀柄：(Toolholder) D34-D35	ZP201, ZP150, ZP152, ZP153
			1204MOT-PM	6	12			4.76	15°		
			1605MOT-PM	8	16			5.56	15°		
圆角铣削加工			RDMT 10T3MO	5	10			3.97	15°	刀柄：(Toolholder) D34-D35	ZP201, ZP150, ZP152, ZP153
			1204MO	6	12			4.76	15°		
平面铣削加工			RNGJ 1204M0ELD / 1204M0SGD / 1204M0SHD	6	12			4.75		刀柄：(Toolholder) D36	ZP201, ZP150, ZP152, ZP153
球头仿形粗铣加工			ZCET 080CE 主刃	8	15.6	7.9	3.97			刀柄：(Toolholder) D37	ZP201, ZP150, ZP152, ZP153
			ZCET 100CE	10	18.3	10	4.74				
			ZCEW 100CE	10	18.3	10	4.74				
			ZCET 125CE	12.5	23.1	12.3	6.1				
			ZCEW 125CE	12.5	23.1	12.3	6.1				
			ZCET 150CE	15	28.3	14.9	7.59				
			ZCEW 150CE	15	28.3	14.9	7.59				
			ZCET 160CE	16	28.8	15.4	7.45				
			ZCEW 200CE	20	35.4	20.1	8.0				
			ZCET 080SE 副刃	8	16.8	5.9	3.43				
			ZCET 100SE	10	16.7	8.1	4.24				
			ZCEW 100SE	10	16.7	8.1	4.24				
			ZCET 125SE	12.5	20.8	9.3	5.4				
			ZCEW 125SE	12.5	20.8	9.3	5.4				
			ZCET 150SE	15	25.7	11.8	7.09				
			ZCEW 150SE	15	25.7	11.8	7.09				
			ZCET 160SE	16	26.3	12.4	6.96				
			ZCEW 200SE	20	31.9	15.7	7.0				
			CPMT 080204 外周刃	0.4	7.94	7.94	2.38				
			CPMT 090308	0.8	9.525	9.525	3.18				

切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

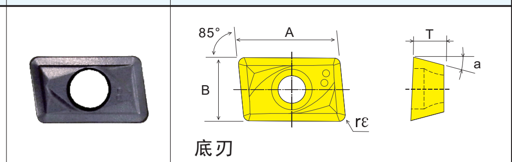
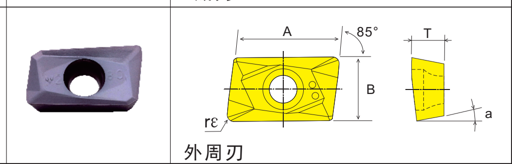
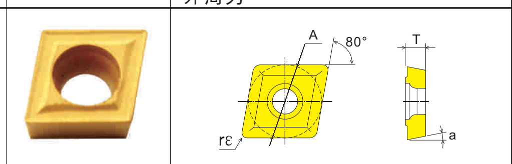
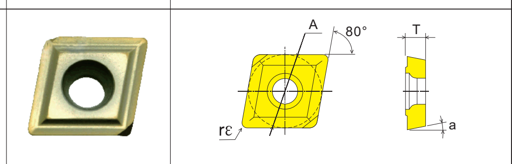
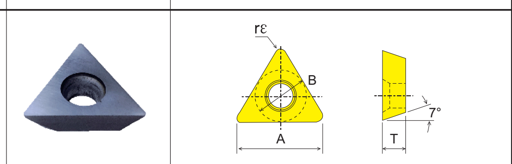
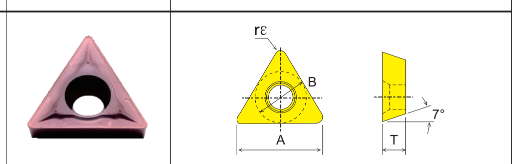
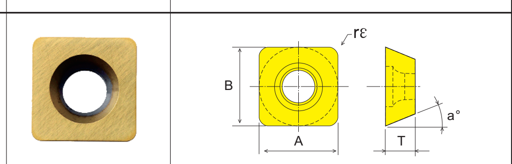
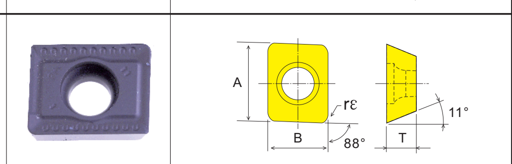
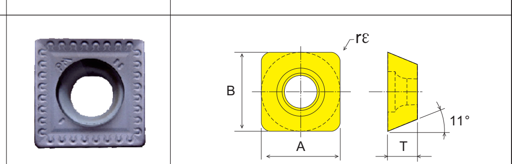
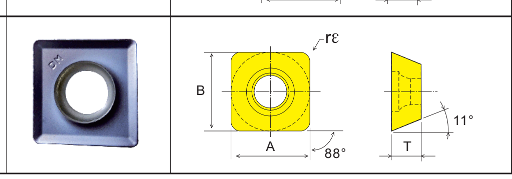
P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	产品图片 Product Image	几何尺寸 Dimensioning	规格型号 Specification	rε	A	B	T	L	a	配套刀柄 Matching Toolholder	牌号 (●)
球头仿形粗铣加工			SWB 216HM 主刃	8	15	7.9	3			刀柄：(Toolholder) D38	ZP152, ZP153
			220HM	10	15.8	9.9	3.65				
			225HM	12.5	18.5	12.4	3.8				
			230HM	15	22.2	14.8	5.35				
			232HM	16	26	16	5.35				
			240HM	20	30.4	20.8	6.85				
			250HM	25	34.4	25.7	7				
			216HS 副刃	8	16.1	6.6	3				
			220HS	10	20	8.2	3.65				
			225HS	12.5	23.8	10.5	3.8				
			230HS	15	27.5	12.3	5.35				
			232HS	16	31.7	13.9	5.35				
			240HS	20	37.5	16.3	6.85				
			250HS	25	42.6	20.8	7				
			SPGA 090304 外周刃	0.4	9.525	9.525	3.18				
			SPMA 090304	0.4	9.525	9.525	3.18				
			IM-SP 32GS	0.8	9.525	9.525	3.18				
			ZCMT 100308R	0.8	10.4	6.35	3.4				
			ZPMT 100308ZER	0.8	10	6	3.2				
球头仿形铣削加工			ZPFG 080	4	8	9.7	2.1			刀柄：(Toolholder) D39	PCD, CBN-K, CBN-S, ZK01, ZP201, ZP150, ZP152, ZP153, ZP163
			100	5	10	12.1	2.7				
			120	6	12	14.6	3.2				
			160	8	16	16.6	4.2				
			200	10	20	20.3	5.2				
			250	12.5	25	24.1	6.2				
			300	15	30	29.2	7.2				
			320	16	32	30.2	7.2				
直角台肩精铣加工			ZCFW 080-R0.3	0.3	8	9.7	2.1			刀柄：(Toolholder) D39	PCD, CBN-K, CBN-S, ZK01, ZP201, ZP150, ZP152, ZP153, ZP163
			100-R0.3	0.3	10	12.1	2.7				
			100-R0.5	0.5	10	12.1	2.7				
			100-R1.0	1.0	10	12.1	2.7				
			120-R0.3	0.3	12	14.6	3.2				
			120-R0.5	0.5	12	14.6	3.2				
			120-R1.0	1.0	12	14.6	3.2				
			160-R0.3	0.3	16	16.6	4.2				
			160-R0.5	0.5	16	16.6	4.2				
			160-R1.0	1.0	16	16.6	4.2				
			160-R1.5	1.5	16	16.6	4.2				
			160-R2.0	2.0	16	16.6	4.2				
			200-R0.3	0.3	20	19.9	5.2				
			200-R0.5	0.5	20	19.9	5.2				
			200-R1.0	1.0	20	19.9	5.2				
			200-R1.5	1.5	20	19.9	5.2				
			200-R2.0	2.0	20	19.9	5.2				
			250-R0.3	0.3	25	22.6	6.2				
			250-R0.5	0.5	25	22.6	6.2				
			250-R1.0	1.0	25	22.6	6.2				
			250-R1.5	1.5	25	22.6	6.2				
			250-R2.0	2.0	25	22.6	6.2				
			300-R0.3	0.3	30	27.2	7.2				
			300-R0.5	0.5	30	27.2	7.2				
			300-R1.0	1.0	30	27.2	7.2				
			320-R0.3	0.3	32	28.2	7.2				
			320-R0.5	0.5	32	28.2	7.2				
			320-R1.0	1.0	32	28.2	7.2				
球头仿形精铣加工			BNM 060	3	6	5	2			刀柄：(Toolholder) D40	PCD, CBN-K, CBN-S, ZK01, ZP201, ZP150, ZP152, ZP153, ZP163
			070	3.5	7	5.5	2				
			080	4	8	7	2.4				
			100	5	10	8.5	2.6				
			110	5.5	11	9	2.6				
			120	6	12	10	3				
			160	8	16	12	4				
			200	10	20	15	5				
			250	12.5	25	18.5	6				
			300	15	30	22.5	7				
			320	16	32	23.5	7				
球头仿形精铣加工			P3200- D08	4	8	7	2.4			刀柄：(Toolholder) D42	PCD, CBN-K, CBN-S, ZK01, ZP201, ZP150, ZP152, ZP153, ZP163
			D10	5	10	8.5	2.6				
			D12	6	12	10	3				
			D16	8	16	12	4				
			D20	10	20	15	5				
			D25	12.5	25	18.5	6				
			D30	15	30	22.5	7				
			D32	16	32	23.5	7				

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GM. TD.
后车削 ABS TBP TKFB
内孔切槽 T.N/E GE. . GR
螺纹车削刀片
铣削刀片

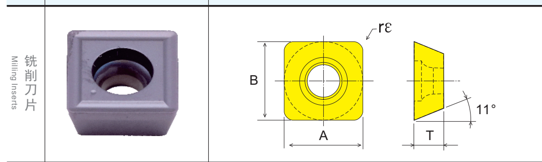
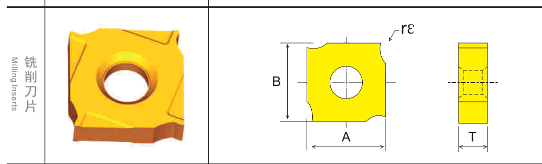
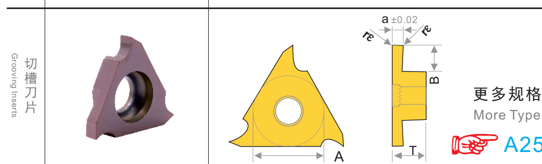
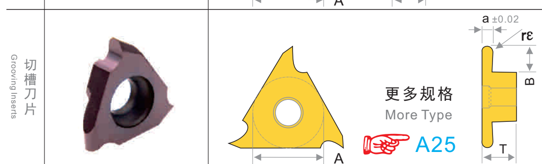
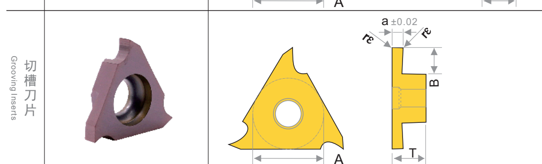
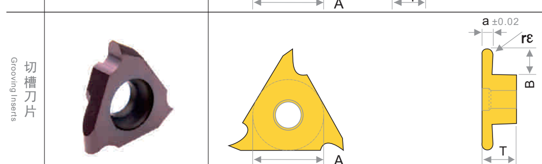
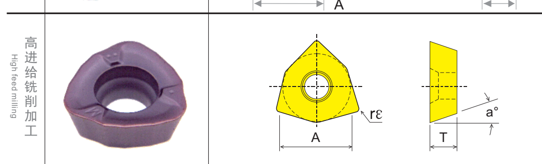
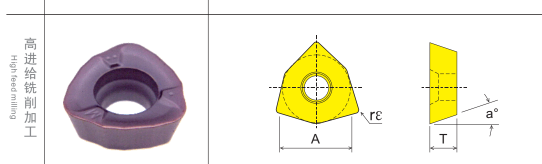
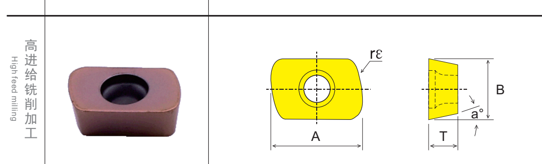
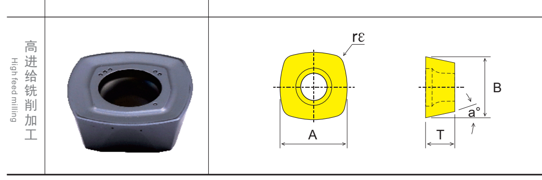
切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✖ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	产品图片 Product Image / 几何尺寸 Dimensioning	规格型号 Specification	rε	A	B	T	L	a	配套刀柄 Matching Toolholder	PCD / CBN-K / CBN-S / ZN60 / ZK01 / ZC32S / ZP201 / ZP150 / ZP152 / ZP153 / ZP163
平面铣削/倒角加工 Plane milling / chamfering		ADMT 080308L 100308L 12T308L APMT 160408L 170408L 190508L 250508L	0.8 0.8 0.8 0.8 0.8 0.8 0.8	7.8 10.4 12.6 16.45 17.6 19.6 25.4	6.2 6.35 7.93 9.53 9.53 10 11	3.0 3.18 3.9 4.76 4.76 5.0 5.5		15 15 15 11 11 11 11	刀柄: (Toolholder) D43	ZP201, ZP152, ZP153 ZP201, ZP152, ZP153 ZP201, ZP152, ZP153 ZP201, ZP152, ZP153
平面铣削/倒角加工 Plane milling / chamfering		APMT 090208R ACMT 100308R APMT 100320R 12T308R 12T320R 12T330R 150408R 150430R	0.8 0.8 2.0 0.8 2.0 3.0 0.8 3.0	9.1 10.1 10.1 13.14 13.14 13.14 15.88 15.88	5.1 6.35 6.35 7.93 7.93 7.93 9.53 9.53	2.6 3.4 3.4 3.9 3.9 3.9 4.76 4.76		11 7 7 11 11 11 11 11	刀柄: (Toolholder) D43	ZP201, ZP152, ZP153 ZP201, ZP152, ZP153 ZP201, ZP152, ZP153 ZP201, ZP152, ZP153
平面铣削/倒角加工 Plane milling / chamfering		CCMT 060204 09T304 09T308 CPMT 090308 120408 120430	0.4 0.4 0.8 0.8 0.8 3.0	6.35 9.525 9.525 9.525 12.7 12.7		2.38 3.9 3.9 3.15 4.76 4.76			刀柄: (Toolholder) D43-44	ZN60, ZK01, ZC32S, ZP201, ZP150, ZP152, ZP153 ZN60, ZK01, ZC32S, ZP201, ZP150, ZP152, ZP153 ZN60, ZK01, ZC32S, ZP201, ZP150, ZP152, ZP153 ZP201, ZP150, ZP152 ZP201, ZP150, ZP152
平面铣削/倒角加工 Plane milling / chamfering		CPMT 080204Z 090204Z 120308Z 160408Z 160430Z 190408Z 190430Z	0.4 0.4 0.8 0.8 3.0 0.8 3.0	7.94 9.525 12.7 15.875 15.875 19.05 19.05		2.38 2.38 3.15 4.76 4.76 4.76 4.76			刀柄: (Toolholder) D43-44	ZP201, ZP150, ZP152 ZP201, ZP150, ZP152 ZP201, ZP150, ZP152 ZP201, ZP150, ZP152
定位点倒角加工 Positioning point chamfering		TCMX 090204 110204 16T304	0.4 0.4 0.4	8.6 10 15.5	5.56 6.35 9.525	2.38 2.38 2.38			刀柄: (Toolholder) D45	ZK01, ZP201, ZP150, ZP152, ZP153 ZK01, ZP201, ZP150, ZP152, ZP153 ZK01, ZP201, ZP150, ZP152, ZP153
倒角加工 Chamfering		TCMT 090204 110204 16T304	0.4 0.4 0.4	8.6 10 15.5	5.56 6.35 9.525	2.38 2.38 2.38			刀柄: (Toolholder) D46	ZK01, ZP201, ZP150, ZP152, ZP153 ZK01, ZP201, ZP150, ZP152, ZP153 ZK01, ZP201, ZP150, ZP152, ZP153
直角台阶铣削 Right Angle Milling		SPMW 090304 SDMB 26152	0.4 0.4	9.525 8.3	9.525 8.3	3.18 2.5		11° 15°	刀柄: (Toolholder) D47	ZN60, ZP201, ZP152, ZP153 ZN60, ZP201, ZP152, ZP153
铣削刀片 Milling Inserts		APKT 150412-PM 150412-KM LPMT 150412-PM 150412-KM	1.2 1.2 1.2 1.2	16.33 16.33 16.33 16.33	12.7 12.7 12.7 12.7	4.76 4.76 4.76 4.76			刀柄: (Toolholder) D53-D54	ZP201, ZP150, ZP152, ZP153 ZP201, ZP150, ZP152, ZP153 ZP201, ZP150, ZP152, ZP153 ZP201, ZP150, ZP152, ZP153
铣削刀片 Milling Inserts		SPMT 120408-PM 120408-KM	0.8 0.8	12.7 12.7	12.7 12.7	4.76 4.76			刀柄: (Toolholder) D53-D54	ZP201, ZP150, ZP152, ZP153 ZP201, ZP150, ZP152, ZP153
铣削刀片 Milling Inserts		MPHT 060304-DM 080305-DM 120408-DM	0.4 0.5 0.8	6.35 8.3 12.7	6.35 8.3 12.7	3.18 3.18 4.76			刀柄: (Toolholder) D57-D58	ZP201, ZP152, ZP153 ZP201, ZP152, ZP153 ZP201, ZP152, ZP153

切削形态: Cutting Environment　● 稳定切削 Stable Cutting　◐ 一般切削 General Cutting　✖ 不稳定切削 Unstable Cutting

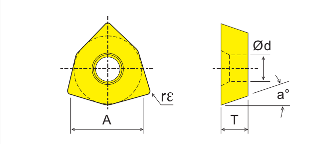
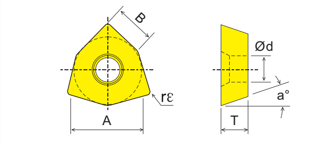
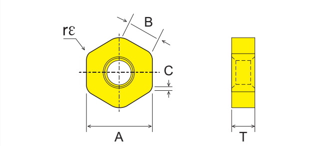
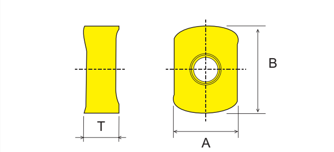
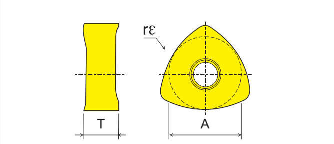
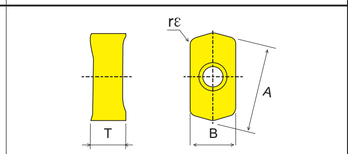
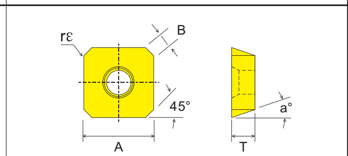
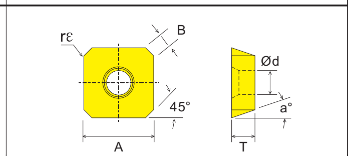
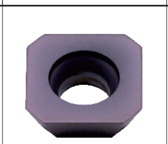
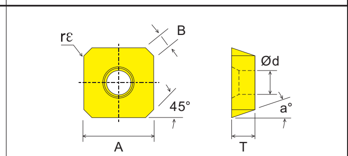
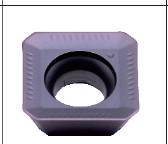
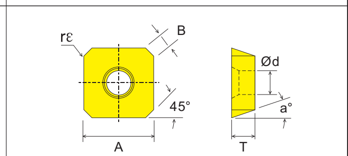
P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	产品图片 Product Image / 几何尺寸 Dimensioning	规格型号 Specification	rε	A	B	T	L	a	配套刀柄 Matching Toolholder	PCD / CBN-K / CBN-S / ZN60 / ZK01 / ZC32S / ZP201 / ZP150 / ZP152 / ZP153 / ZP163
铣削刀片 Milling Inserts		SPMG 050204-TT 060204-TT 07T308-TT 090408-TT 110408-TT 140512-TT	0.4 0.4 0.8 0.8 0.8 1.2	5.0 6.0 7.94 9.8 11.5 14.3	5.0 6.0 7.94 9.8 11.5 14.3	2.38 2.38 3.97 4.30 4.8 5.0			刀柄: (Toolholder) D59-D60	ZK01, ZP201, ZP150, ZP152, ZP153 ZK01, ZP201, ZP150, ZP152, ZP153 ZK01, ZP201, ZP150, ZP152, ZP153 ZK01, ZP201, ZP150, ZP152, ZP153 ZK01, ZP201, ZP150, ZP152, ZP153 ZK01, ZP201, ZP150, ZP152, ZP153
铣削刀片 Milling Inserts		XSEQ 1202 1203 12T3 1204 12T4		12.7 12.7 12.7 12.7 12.7	12.7 12.7 12.7 12.7 12.7	2.3 3.0 3.5 4.0 4.5			刀柄: (Toolholder) D61-D62	ZP201, ZP152, ZP153 ZP201, ZP152, ZP153 ZP201, ZP152, ZP153 ZP201, ZP152, ZP153 ZP201, ZP152, ZP153
切槽刀片 Grooving Inserts		TGF32L 150 200 250 300 350	0.1 0.15 0.15 0.15 0.15	16	2.0 2.8 2.8 2.8 2.8	3.18		1.5 2.0 2.5 3.0 3.5	刀柄: (Toolholder) D55-D56	PCD, CBN-K, CBN-S, ZK01, ZP201, ZP152, ZP153 (each size)
切槽刀片 Grooving Inserts		TGF32L 150-R0.75 200-R1.0 250-R1.25 300-R1.5	0.75 1.0 1.25 1.5	16	2.0 2.8 2.8 2.8	3.18		R0.75 R1.0 R1.25 R1.5	刀柄: (Toolholder) D55-D56	PCD, CBN-K, CBN-S, ZK01, ZP201, ZP152, ZP153 (each size)
切槽刀片 Grooving Inserts		TT43L 200 250 300 350 400 500	0.2 0.2 0.2 0.2 0.2 0.2	22	4.8	5.0		2.0 2.5 3.0 3.5 4.0 5.0	刀柄: (Toolholder) D55-D56	PCD, CBN-K, CBN-S, ZK01, ZP201, ZP152, ZP153 (each size)
切槽刀片 Grooving Inserts		TT43L 200-R1.0 250-R1.25 300-R1.5 350-R1.75 400-R2.0 500-R2.5	1.0 1.25 1.5 1.75 2.0 2.5	22	4.8	5.0		R1.0 R1.25 R1.5 R1.75 R2.0 R2.5	刀柄: (Toolholder) D55-D56	PCD, CBN-K, CBN-S, ZK01, ZP201, ZP152, ZP153 (each size)
高进给铣削加工 High feed milling		JOMW 06T215ZZSR-FT 080320ZZSR-FT JDMW 09T320ZDSR-FT 120420ZDSR-FT 140520ZDSR-FT	1.5 2.0 2.0 2.0 2.0	6.35 8.0 9.525 12.0 14.0	2.78 3.18 3.97 4.76 5.56	13° 13° 15° 15° 15°			刀柄: (Toolholder) D63-D64	ZP152, ZP153 (each size)
高进给铣削加工 High feed milling		JOMT 06T215ZZSR-JM 080320ZZSR-JM JDMT 09T320ZDSR-JM 120420ZDSR-JM 140520ZDSR-JM	1.5 2.0 2.0 2.0 2.0	6.35 8.0 9.525 12.0 14.0	2.78 3.18 3.97 4.76 5.56	13° 13° 15° 15° 15°			刀柄: (Toolholder) D63-D64	ZP152, ZP153 (each size)
高进给铣削加工 High feed milling		EPNW 0603TN-8 EPMT 0603TN-8 EDNW 12T3TN-10 EDMT 12T3TN-10	8 8 10 10	10 12 10 12	6.35 6.35 10 10	3.18 3.18 3.97 3.97	11° 11° 15° 15°		刀柄: (Toolholder) D65-D66	ZP150, ZP152 (each size)
高进给铣削加工 High feed milling		EPNW 0803TN-10 EDNW 10T3TN-10 SDNW 1205ZDTN-R15 SDMT 1205ZDTN-R15 EDNW 13T4TN-10 13T4TN-15 SDNW 1505ZDTN-R15 SDMT 1505ZDTN-R15 带修光刃 1505ZDTN-C15	10 10 15 15 10 15 15 15 15	8.1 10 12.7 12.7 13.5 13.5 15.875 15.875 15.875	8.1 10 12.7 12.7 13.5 13.5 15.875 15.875 15.875	3.18 3.97 5.56 5.56 5.56 5.56 5.56 5.56 5.56	11° 15° 15° 15° 15° 15° 15° 15° 15°		刀柄: (Toolholder) D65-D66	ZP150, ZP152 (each size)

数控刀片
CN DN RN KN 175 SN TN VN WN
CC DC RC SC WB TB TC TP VB VC
三角浅槽 TGF GBA T.N/E
小零件 CTP TKF
切槽切断 MG. MR. SP. GM. TD.
后车削 ABS TBP TKFB
内孔切槽 T.N/E GE. . GR
螺纹车削刀片
铣削刀片

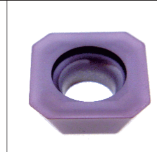
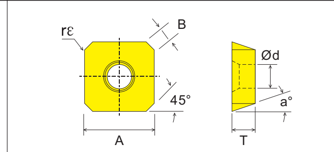
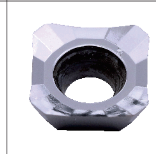
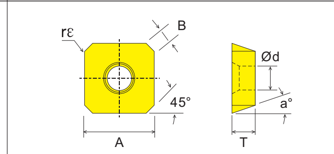
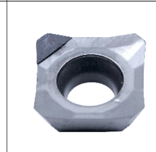
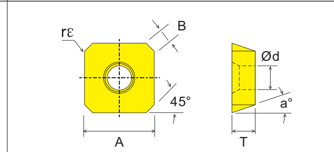
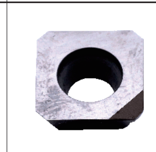
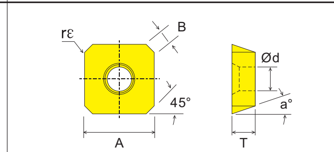
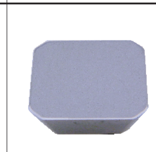
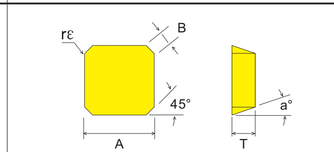
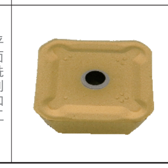
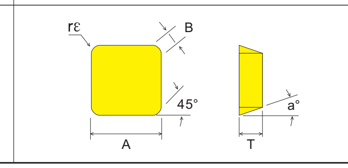
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✣ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
P	钢	Steel			●	◐		◐	✣	✣	✣	◐	●
M	不锈钢	Stainless Steel				◐		◐	✣	✣	✣	◐	●
K	铸铁	Iron		●		◐		◐	✣	✣	✣		
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐						
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✣	✣	◐	●
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✣	✣	◐	●

用途 Application	产品图片 Product Image	几何尺寸 Dimensioning	规格型号 Specification	尺寸 Dimension (mm) rε	A	B	T	L	a	配套刀柄 Matching Toolholder	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
高进给铣削加工			WOMW 04T215ZER	1.5	6.5	2.8	13°			刀柄：(Toolholder) D67-D68							●		●	●	
			WDMW 050316ZER	1.6	8	3.2	13°										●		●	●	
			050316ZTR	1.6	8	3.2	13°										●		●	●	
			06T320ZER	2.0	10	3.97	13°										●		●	●	
			06T320ZTR	2.0	10	3.97	13°										●		●	●	
			080520ZER	2.0	13	5.5	13°										●		●	●	
			080520ZTR	2.0	13	5.5	13°										●		●	●	
			10X620ZER	2.0	16	6	13°										●		●	●	
			10X620ZTR	2.0	16	6	13°										●		●	●	
高进给铣削加工			WPGT 050315ZSR	1.5	7.94	6	3.5	11°		刀柄：(Toolholder) D69											
			060415ZSR	1.5	9.525		4.2	11°									●	●	●	●	
			080615ZSR	1.5	12.85		6.35	11°									●	●	●	●	
			090725ZSR	2.5	15		7.0	11°													
			050315ZSR-PM	1.5	7.94		3.5	11°													
			060415ZSR-PM	1.5	9.525		4.2	11°									●	●	●	●	
			080615ZSR-PM	1.5	12.85		6.35	11°									●	●	●	●	
			090725ZSR-PM	2.5	15		7.0	11°													
高进给铣削加工			HNGX 0906ANSN-M	1.2	15.88	9	1.8	5.56		刀柄：(Toolholder) D70							●	●	●	●	●
			0906ANSN-R														●	●	●	●	●
高进给铣削加工			BLMP 0603R-M	-	6.39	9	3.73			刀柄：(Toolholder) D71							●	●	●	●	●
高进给铣削加工			BLMP 1205R-M	15	12	-	5.5			刀柄：(Toolholder) D71							●	●	●	●	●
高进给铣削加工			LNMU 0303ZER-MJ	1.2	11.59	6.0	4.29			刀柄：(Toolholder) D72							●	●	●	●	●
			0303ZER-ML	1.2	11.59	6.0	4.29														
平面铣削加工			SEET 13T3AGEN-JL	1.5	13.4	1.9	3.97	20°		刀柄：(Toolholder) D73				●			●	●	●	●	
			SEMT 13T3AGSN-JH											●			●	●	●	●	
			13T3AGSN-JM											●			●	●	●	●	
平面铣削加工			SEET 12T3-DF	-	13.4	2.55	3.97	4.1	20°	刀柄：(Toolholder) D74							●	●	●		
			轻切削 12T3-CF														●	●	●		
			12T3-EF														●	●	●		
			中切削 12T3-DM														●	●	●		
			12T3-CM														●	●	●		
			12T3-EM														●	●	●		
			重切削 12T3-DR														●	●	●		
			12T3-CR														●	●	●		
			铜铝用 12T3-LH												-						
平面铣削加工			SECA 1204AFSN	-	12.7	2.66	4.76	5.56	20°	刀柄：(Toolholder) D75							●	●	●	●	
			1204AFTN	-	12.7	2.66	4.76	5.56	20°								●	●	●	●	
平面铣削加工			SEKT 1204AFTN	-	12.7	2.66	4.76	5.56	20°	刀柄：(Toolholder) D75							●	●	●	●	

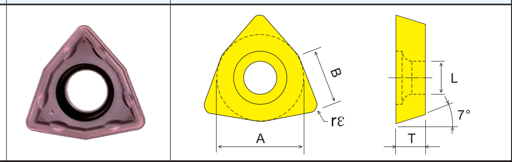
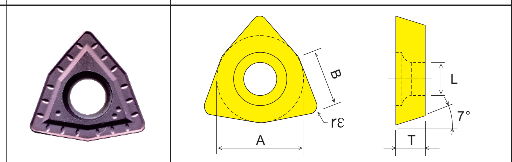
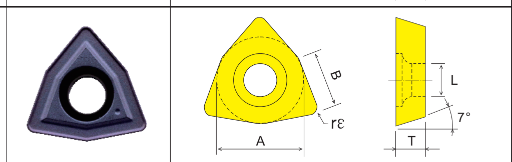
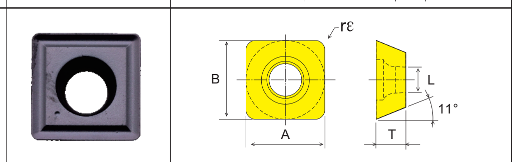
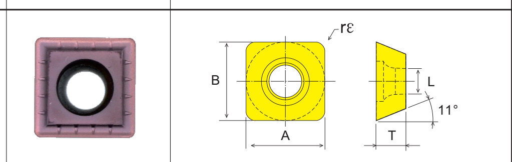
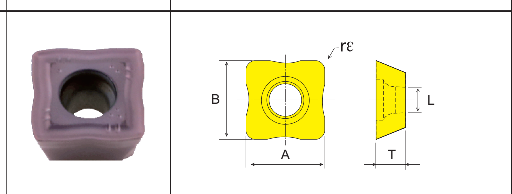
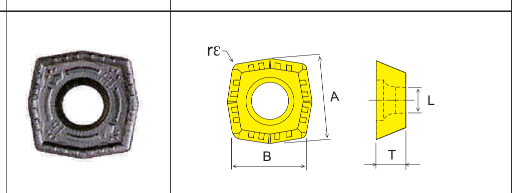
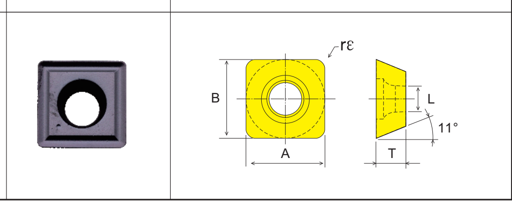
切削形态: Cutting Environment ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✣ 不稳定切削 Unstable Cutting

			PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
P	钢	Steel			●	◐		◐	✣	✣	✣	◐	●
M	不锈钢	Stainless Steel				◐		◐	✣	✣	✣	◐	●
K	铸铁	Iron		●		◐		◐	✣	✣	✣		
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●				◐						
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●							✣	✣	◐	●
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●							✣	✣	◐	●

用途 Application	产品图片 Product Image	几何尺寸 Dimensioning	规格型号 Specification	尺寸 Dimension (mm) rε	A	B	T	L	a	配套刀柄 Matching Toolholder	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
平面铣削加工			SEHT 1204AFSN	-	12.7	2.66	4.76	5.56	20°	刀柄：(Toolholder) D75							●	●	●	●	
平面铣削加工			SEHT 1204-AK	-	12.7	2.66	4.76	5.56	20°	刀柄：(Toolholder) D75					●						
平面铣削加工			SEHT 1204	-	12.7	2.66	4.76	5.56	20°	刀柄：(Toolholder) D75	●										
平面铣削加工			SEHT 1204	-	12.7	2.66	4.76	5.56	20°	刀柄：(Toolholder) D75		●	●								
平面铣削加工			SDKN 1203AETN	-	12.7	1.7	3.18	15°		刀柄：(Toolholder) D77-D78	●	●	●	●			●	●	●		
			1504AETN	-	15.875	1.7	4.76	15°			●	●	●	●			●	●	●		
			SEEN 1203AFTN1	1.0	12.7	1.4	3.18	20°			●	●	●	●			●	●	●		
			1504AFTN1	1.0	15.875	1.4	4.76	20°			●	●	●	●			●	●	●		
			SEKN 1203AFTN1	-	12.7	1.4	3.18	20°			●	●	●	●			●	●	●		
			1504AFTN1	-	15.875	1.4	4.78	20°			●	●	●	●			●	●	●		
			SPKN 1203EDR	-	12.7	1.4	3.18	11°			●	●	●	●			●	●	●		
平面铣削加工			SEKR 1203AFEN-JS	1.0	12.7	1.4	3.18	20°		刀柄：(Toolholder) D77-D78				●	●		●	●	●		
			1504AFEN-JS	1.0	15.875	1.4	4.76	20°						●	●		●	●	●		

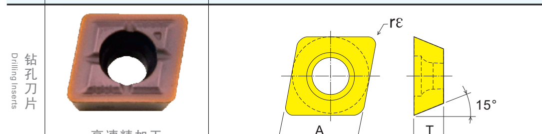
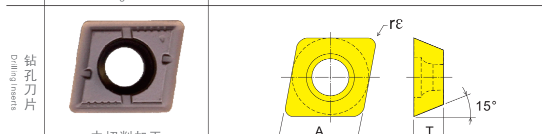
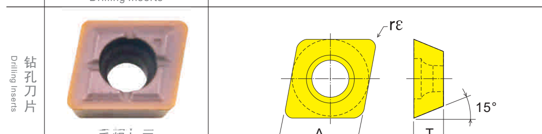
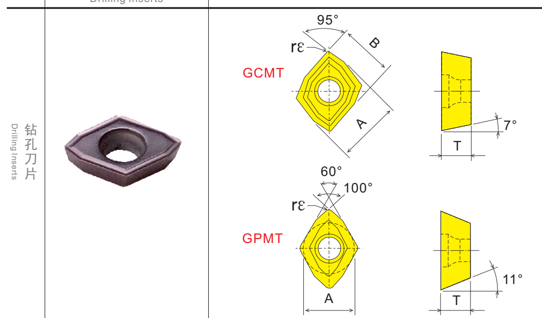
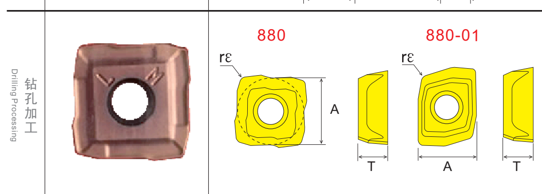
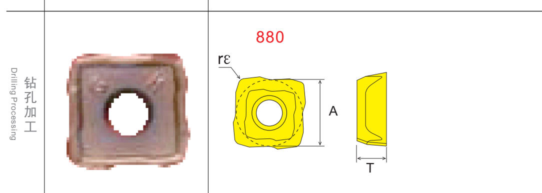
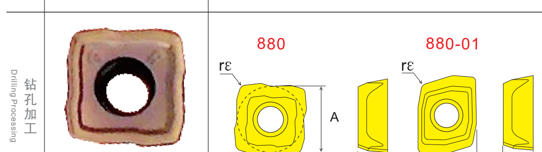
切削形态 Cutting Environment: ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	产品图片 Product Image / 几何尺寸 Dimensioning	规格型号 Specification	尺寸 Dimension (mm) rε	A	B	T	L	配套刀柄 Matching Toolholder	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
钻孔刀片 Drilling Inserts		WCMX 030208-SU 040208-SU 050308-SU 06T308-SU 080412-SU	0.8 0.8 0.8 0.8 1.2	5.56 6.35 7.94 9.525 12.7	3.8 4.3 5.4 6.5 8.7	2.38 2.38 3.18 3.97 4.76	2.8 3.1 3.2 3.7 4.3	刀柄:(Toolholder) K05-K06 K19-K20					●	●	●	●	●	●	
钻孔刀片 Drilling Inserts		WCMX 030208-ZK 040208-ZK 050308-ZK 06T308-ZK 080412-ZK	0.8 0.8 0.8 0.8 1.2	5.56 6.35 7.94 9.525 12.7	3.8 4.3 5.4 6.5 8.7	2.38 2.38 3.18 3.97 4.76	2.8 3.1 3.2 3.7 4.3	刀柄:(Toolholder) K05-K06 K19-K20					●		●	●	●	●	
钻孔刀片 Drilling Inserts		WCMX 030208 040208 050308 06T308 080412	0.8 0.8 0.8 0.8 1.2	5.56 6.35 7.94 9.525 12.7	3.8 4.3 5.4 6.5 8.7	2.38 2.38 3.18 3.97 4.76	2.8 3.1 3.2 3.7 4.3	刀柄:(Toolholder) K05-K06 K19-K20					●		●	●	●	●	
钻孔刀片 Drilling Inserts		SPMG 050204-TT 060204-TT 07T308-TT 090408-TT 110408-TT 140512-TT	0.4 0.4 0.8 0.8 0.8 1.2	5.0 6.0 7.94 9.8 11.5 14.3	5.0 6.0 7.94 9.8 11.5 14.3	2.38 2.38 3.97 4.30 4.8 5.0	2.2 2.6 2.8 4.2 4.4 5.75	刀柄:(Toolholder) K07-K08					●	●	●	●	●	●	
钻孔刀片 Drilling Inserts		SPMG 050204-PM 060204-PM 07T308-PM 090408-PM 110408-PM 140512-PM	0.4 0.4 0.8 0.8 0.8 1.2	5.0 6.0 7.94 9.8 11.5 14.3	5.0 6.0 7.94 9.8 11.5 14.3	2.38 2.38 3.97 4.30 4.8 5.0	2.2 2.6 2.8 4.2 4.4 5.75	刀柄:(Toolholder) K07-K08					●		●	●	●	●	
钻孔刀片 Drilling Inserts		SOMT 040202-DP 050204-DP 060204-DP 070306-DP 08T306-DP 09T308-DP 11T308-DP 130408-DP 150510-DP	0.2 0.4 0.4 0.6 0.6 0.8 0.8 0.8 1.0	4.0 4.9 5.7 6.8 7.9 9.2 11.0 12.8 15.0	4.0 4.9 5.7 6.8 7.9 9.2 11.0 12.8 15.0	1.8 2.38 2.38 2.8 3.97 3.97 3.97 4.4 4.8	2.0 2.25 2.6 2.6 2.85 3.8 3.8 4.4 5.4	刀柄:(Toolholder) K09-K10							●		●	●	
钻孔刀片 Drilling Inserts		XOMT 040204-PD 050204-PD 060204-PD 07T205-PD 090305-PD 11T306-PD 130406-PD 15M508-PD 180508-PD	0.4 0.4 0.4 0.5 0.5 0.6 0.6 0.8 0.8	4.9 5.4 6.6 7.8 9.6 11.4 13.6 15.9 18.9	4.3 4.8 5.8 6.9 8.4 10.0 11.9 13.9 16.5	2.4 2.4 2.5 2.8 3.3 4.0 4.5 5.0 5.5	2.3 2.3 2.5 2.8 3.4 4.0 4.5 5.5 6.0	刀柄:(Toolholder) K11-K12							●		●	●	
钻孔刀片 Drilling Inserts		SPMT 040204-PD 050204-PD 060205-PD 07T208-PD 090308-PD 11T308-PD 130410-PD 15M510-PD 180510-PD	0.4 0.4 0.5 0.8 0.8 0.8 1.0 1.0 1.0	4.7 5.1 6.2 7.5 9.2 11.0 13.0 15.2 18.2	4.7 5.1 6.2 7.5 9.2 11.0 13.0 15.2 18.2	2.4 2.4 2.5 2.8 3.3 4.0 4.5 5.0 5.5	2.3 2.3 2.5 2.8 3.4 4.0 4.5 5.5 6.0	刀柄:(Toolholder) K11-K12							●		●	●	

切削形态 Cutting Environment: ● 稳定切削 Stable Cutting ◐ 一般切削 General Cutting ✖ 不稳定切削 Unstable Cutting

P	钢	Steel
M	不锈钢	Stainless Steel
K	铸铁	Iron
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber

用途 Application	产品图片 Product Image / 几何尺寸 Dimensioning	规格型号 Specification	尺寸 Dimension (mm) rε	A	B	T	L		配套刀柄 Matching Toolholder	PCD	CBN-K	CBN-S	ZN60	ZK01	ZC32S	ZP201	ZP150	ZP152	ZP153	ZP163
钻孔刀片 Drilling Inserts	 高速精加工 Drilling Inserts	WDXT 042004-L 052504-L 063006-L 073506-L 094008-L 125012-L 156012-L 186012-L	0.4 0.4 0.6 0.6 0.8 1.2 1.2 1.2	4.2 5.0 6.0 7.5 9.6 12.4 15.2 18.0		2.0 2.5 3.0 3.5 4.0 5.0 6.0 8.0			刀柄:(Toolholder) K13-K14							●		●		
钻孔刀片 Drilling Inserts	 中切削加工 Drilling Inserts	WDXT 042004-G 052504-G 063006-G 073506-G 094008-G 125012-G 156012-G 186012-G	0.4 0.4 0.6 0.6 0.8 1.2 1.2 1.2	4.2 5.0 6.0 7.5 9.6 12.4 15.2 18.0		2.0 2.5 3.0 3.5 4.0 5.0 6.0 8.0			刀柄:(Toolholder) K13-K14							●		●		
钻孔刀片 Drilling Inserts	 重粗加工 Drilling Inserts	WDXT 042004-H 052504-H 063006-H 073506-H 094008-H 125012-H 156012-H 186012-H	0.4 0.4 0.6 0.6 0.8 1.2 1.2 1.2	4.2 5.0 6.0 7.5 9.6 12.4 15.2 18.0		2.0 2.5 3.0 3.5 4.0 5.0 6.0 8.0			刀柄:(Toolholder) K13-K14							●		●		
钻孔刀片 Drilling Inserts	 GCMT GPMT	GCMT 040204-U2 GPMT 060204-U2 070204-U2 090304-U2 11T308-U2 140408-U2	0.4 0.4 0.4 0.4 0.8 0.8	5.0 5.56 6.35 7.94 9.525 12.7	4.7 - - - - -	2.38 2.38 2.38 3.18 3.97 4.76			刀柄:(Toolholder) K16									●	●	
钻孔加工 Drilling Processing	 880 880-01	880- 010203H-C-LM 020204H-C-LM 030305H-C-LM 040305H-C-LM 050305H-C-LM 060406H-C-LM 070406H-C-LM 080508H-C-LM 090608H-C-LM	0.3 0.4 0.5 0.5 0.5 0.6 0.6 0.8 0.8	4.80 4.90 5.70 6.80 8.40 10.20 12.35 14.85 17.90	- - - - - - - - -	2.2 2.4 2.6 2.8 3.0 3.5 4.0 4.5 5.5	- - - - - - - - -	- - - - - - - - -	刀柄:(Toolholder) K15							●		●		
钻孔加工 Drilling Processing	 880	880- 020204H-C-GM 030305H-C-GM 040305H-C-GM 050305H-C-GM 060406H-C-GM 070406H-C-GM 080508H-C-GM 090608H-C-GM	0.4 0.5 0.5 0.5 0.6 0.6 0.8 0.8	4.90 5.70 6.80 8.40 10.20 12.35 14.85 17.90	- - - - - - - -	2.4 2.6 2.8 3.0 3.5 4.0 4.5 5.5	- - - - - - - -	- - - - - - - -	刀柄:(Toolholder) K15							●		●		
钻孔加工 Drilling Processing	 高进给 Deep-feed 880 880-01	880- 010203H-C-GR 020204H-C-GR 030305H-C-GR 040305H-C-GR 050305H-C-GR 060406H-C-GR 070406H-C-GR 080508H-C-GR 090608H-C-GR	0.3 0.4 0.5 0.5 0.5 0.6 0.6 0.8 0.8	4.80 4.90 5.70 6.80 8.40 10.20 12.35 14.85 17.90	- - - - - - - - -	2.2 2.4 2.6 2.8 3.0 3.5 4.0 4.5 5.5	- - - - - - - - -	- - - - - - - - -	刀柄:(Toolholder) K15							●		●		

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