



G-PAK 2021

# 切削刀具新品册

NEW CUTTING TOOLS  
CATALOGUE

ПРОМИНСТРУМЕНТ

厦门金鹭 GESAC



# G-PACK22021



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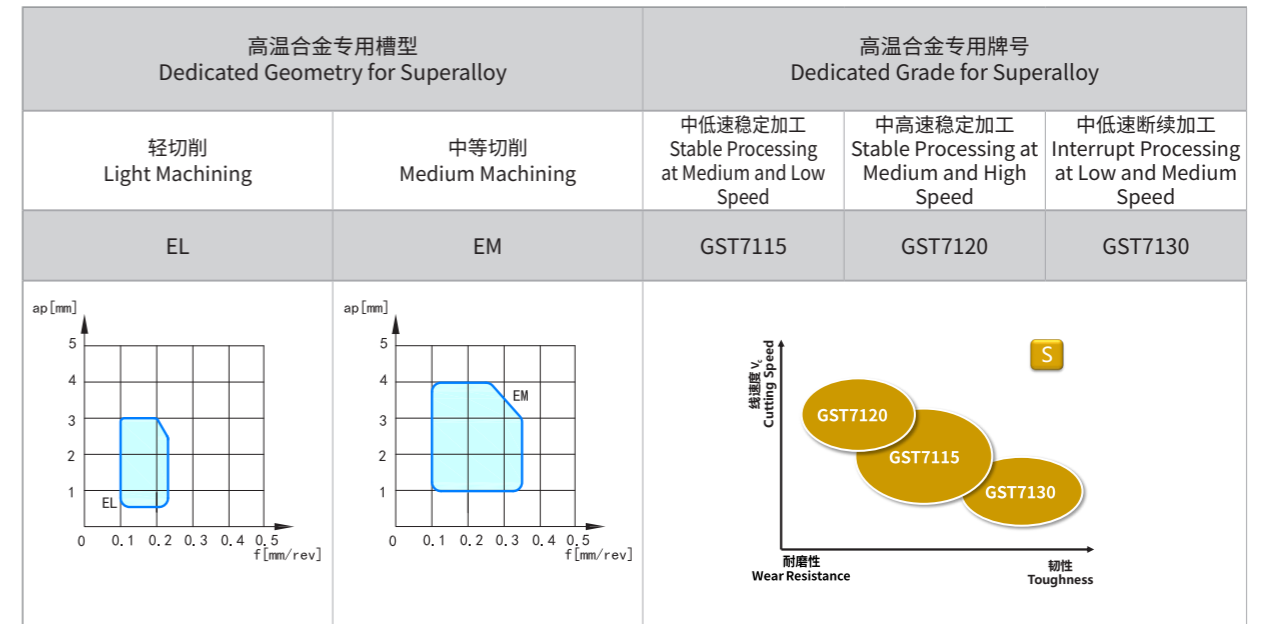
# A

车削  
Turning

## GEFOTECH朱雀系列-全新高温合金材料车削刀片 New Turning Inserts for Superalloy

- 适用于飞机发动机、汽车涡轮增压器等高温合金材料的车削加工。  
Widely used in turning of superalloy such as aircraft engine, automobile turbocharger and so on.
- 全新纳米结构PVD涂层与亚微晶硬质合金基体相结合，特殊的表面后处理技术，具有优异的抗高温磨损性和抗粘结磨损性能。  
New nano-structured PVD coating combine with micro-grain carbide substrate and Dedicated surface treatment, provide excellent resistance to high temperature wear and adhesive wear.
- 搭配高温合金车削EM、EL专用槽型，减小沟槽磨损，实现稳定加工。  
Matched with the Dedicated EM and EL geometry for superalloy to reduce the notch wear and keep stable machining.

### 应用介绍 Application Introduction



## 全新高温合金车削PVD牌号应用一览表

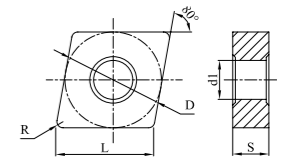
Application Summary of New PVD Grades for Superalloy Turning



材质结构 Grade Microstructure	特点 Grade Feature
	<p><b>高温合金车削PVD牌号GST7115</b> GST7115 PVD Grade for Superalloy Turning</p> <ul style="list-style-type: none"> <li>全新纳米结构的PVD涂层搭配高红硬性和抗塑性变形能力的硬质合金基体，结合特殊的后处理技术，具有优异的抗高温磨损性和抗粘粘磨损性能。</li> <li>New nano-structured PVD coating, combined with specific cemented carbide with high red hardness and superior resistance to plastic deformation, provide excellent resistance to high temperature wear and adhesive wear.</li> <li>适用于高温合金稳定工况下的中低速精到半精加工，加工表面质量高。</li> <li>Suitable for medium and low speed machining of high-temperature Alloy under stable working condition, with high surface quality.</li> </ul>
	<p><b>高温合金车削PVD牌号GST7120</b> GST7120 PVD Grade for Superalloy Turning</p> <ul style="list-style-type: none"> <li>全新升级的优异结合力和耐磨性的PVD涂层，搭配耐磨的亚微细硬质合金基体，具有优异的耐磨性、抗氧化性和加工稳定性。</li> <li>New generation of PVD coating offer superior wear resistance and enhanced adhesion, combined with the hard cemented carbide substrate, provide outstanding wear resistance, oxidation resistance and machining stability.</li> <li>适用于镍基高温合金等难加工材料的中高速耐磨工况。</li> <li>Suitable for medium and high speed machining of high-temperature Alloy under stable cutting condition, with high wear resistance.</li> </ul>
	<p><b>高温合金车削PVD牌号GST7130</b> GST7130 PVD Grade for Superalloy Turning</p> <ul style="list-style-type: none"> <li>采用全新涂层技术升级的PVD涂层，搭配高钴亚微细晶粒强韧硬质合金基体，具有优异的结合力、极高的韧性与刃口强度。</li> <li>New generation coating with new PVD technology, combined with the high-Co submicro-grain and strong toughness carbide, gives this new PVD grade extremely high toughness and reinforced cutting edge.</li> <li>推荐应用于镍基高温合金等难加工材料的中低速粗加工。</li> <li>Suitable for rough machining and interrupted machining of high-temperature Alloy with low to medium cutting speeds.</li> </ul>

车削刀片(负型)  
Turning Insert (Negative)

CN□□

菱形80° 有孔  
Rhombic80°, with Hole

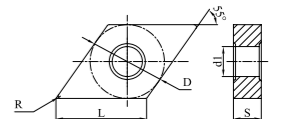



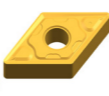
订货号 Ordering Code	尺寸 Dimension(mm)					涂层硬质合金 Coated			
	L	D	S	d1	R	GST7115	GST7120	GST7130	
	CNMG120404-EL	12.9	12.7	4.76	5.16	0.4	●		
	CNMG120408-EL	12.9	12.7	4.76	5.16	0.8	●	●	
	CNMG120412-EL	12.9	12.7	4.76	5.16	1.2	●	●	
	CNMG160608-EL	16.1	15.875	6.35	6.35	0.8	●	●	
	CNMG160612-EL	16.1	15.875	6.35	6.35	1.2	●	●	
	CNMG120404-EM	12.9	12.7	4.76	5.16	0.4	●	●	●
	CNMG120408-EM	12.9	12.7	4.76	5.16	0.8	●	●	●
	CNMG120412-EM	12.9	12.7	4.76	5.16	1.2	●	●	●
	CNMG160608-EM	16.1	15.875	6.35	6.35	0.8	●	●	●
	CNMG160612-EM	16.1	15.875	6.35	6.35	1.2	●	●	●

●标准库存 Stock ○需预定 Available upon Order

DN□□

菱形55° 有孔  
Rhombic55°, with Hole



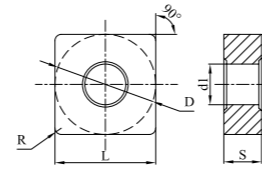
订货号 Ordering Code	尺寸 Dimension(mm)					涂层硬质合金 Coated			
	L	D	S	d1	R	GST7115	GST7120	GST7130	
	DNMG150404-EL	15.5	12.7	4.76	5.16	0.4	●		
	DNMG150408-EL	15.5	12.7	4.76	5.16	0.8	●	○	
	DNMG150412-EL	15.5	12.7	4.76	5.16	1.2	●	●	
	DNMG150604-EL	15.5	12.7	6.35	5.16	0.4	●		
	DNMG150608-EL	15.5	12.7	6.35	5.16	0.8	●	○	
	DNMG150612-EL	15.5	12.7	6.35	5.16	1.2	●	●	
	DNMG150408-EM	15.5	12.7	4.76	5.16	0.8	●	●	○
	DNMG150412-EM	15.5	12.7	4.76	5.16	1.2	●	●	○
	DNMG150608-EM	15.5	12.7	6.35	5.16	0.8	●	●	○
	DNMG150612-EM	15.5	12.7	6.35	5.16	1.2	●	●	○

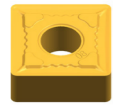
●标准库存 Stock ○需预定 Available upon Order

车削刀片(负型)  
Turning Insert (Negative)

**SN**□□

正方形90°有孔  
Square 90°,with Hole



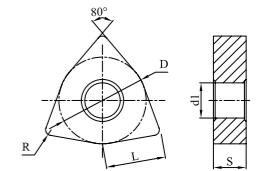
订货号 Ordering Code	尺寸 Dimension(mm)					涂层硬质合金 Coated		
	L	D	S	d1	R	GST7115	GST7120	GST7130
 SNMG120404-EM	12.7	12.7	4.76	5.16	0.4	●	●	
SNMG120408-EM	12.7	12.7	4.76	5.16	0.8	●	●	●
SNMG120412-EM	12.7	12.7	4.76	5.16	1.2	●	●	●



●标准库存 Stock ○需预定 Available upon Order

车削刀片(负型)  
Turning Insert (Negative)

**WN**□□

六边形80°有孔  
Hexagon 80°, with Hole

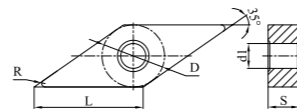




订货号 Ordering Code	尺寸 Dimension(mm)					涂层硬质合金 Coated		
	L	D	S	d1	R	GST7115	GST7120	GST7130
 WNMG080404-EL	8.7	12.7	4.76	5.16	0.4	●		
WNMG080408-EL	8.7	12.7	4.76	5.16	0.8	●	●	
WNMG080412-EL	8.7	12.7	4.76	5.16	1.2	●	●	
 WNMG080408-EM	8.7	12.7	4.76	5.16	0.8	●	●	●
WNMG080412-EM	8.7	12.7	4.76	5.16	1.2	●	●	●

●标准库存 Stock ○需预定 Available upon Order

**VN**□□

菱形35°有孔  
Rhombic 35°,with Hole



订货号 Ordering Code	尺寸 Dimension(mm)					涂层硬质合金 Coated		
	L	D	S	d1	R	GST7115	GST7120	GST7130
 VNMG160404-EL	16.6	9.525	4.76	3.81	0.4	●		
VNMG160408-EL	16.6	9.525	4.76	3.81	0.8	●	○	
VNMG160412-EL	16.6	9.525	4.76	3.81	1.2	●	●	
 VNMG160408-EM	16.6	9.525	4.76	3.81	0.8	●	●	○
VNMG160412-EM	16.6	9.525	4.76	3.81	1.2	●	●	○

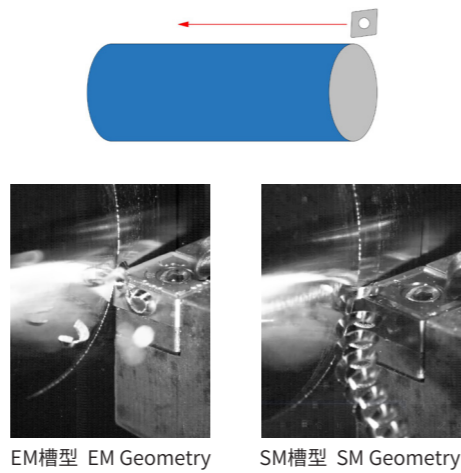
●标准库存 Stock ○需预定 Available upon Order

## 应用案例

Application

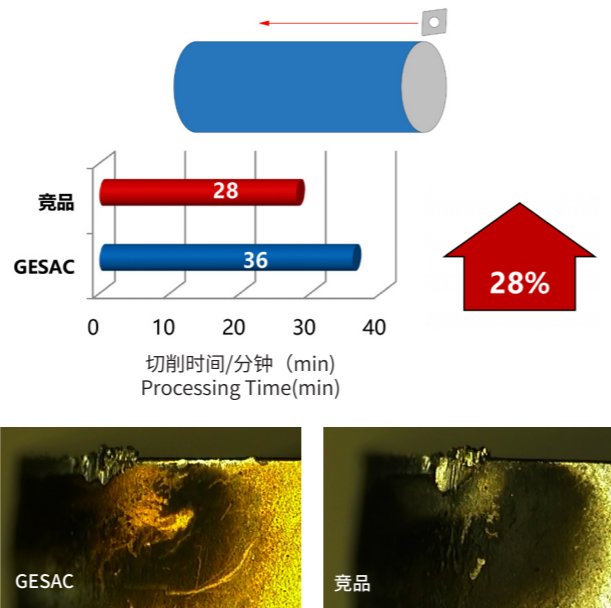
## 案例1: 断屑性能测试

Case 1: Chip Breaking Performance Test

工件 Workpiece	实心圆棒-GH4169 Solid Round Bar GH4169	 <p>EM槽型 EM Geometry    SM槽型 SM Geometry</p>
加工方式 Processing Methods	外圆连续中等加工 Circumferential Continuous Medium Machining	
切削参数 Parameters	Vc= 30m/min f=0.2mm/r ap=1.0mm	
测试刀具 Test Tool	CNMG120408-EM-GST7115	

## 案例2: 耐磨性能测试

Case 2: Wear Resistance Test

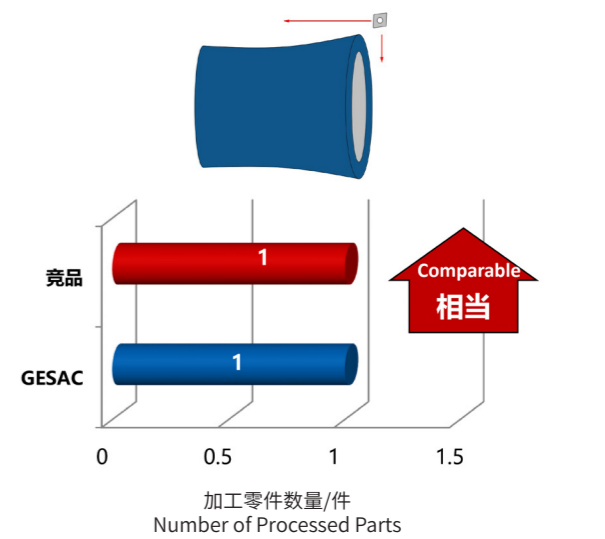
工件 Workpiece	实心圆棒-GH4169 Solid Round Bar GH4169	 <p>切削时间/分钟 (min) Processing Time(min)</p> <p>竞品 28 GESAC 36 28%</p> <p>GESAC    竞品</p>
加工方式 Processing Methods	外圆连续车削-中等加工-湿切 Circumferential Continuous Turning- Medium Machining-Wet Cutting	
切削参数 Parameters	Vc= 30m/min f=0.15mm/r ap=1.0mm	
测试刀具 Test Tool	CNMG120408-EM-GST7115	

## 应用案例

Application

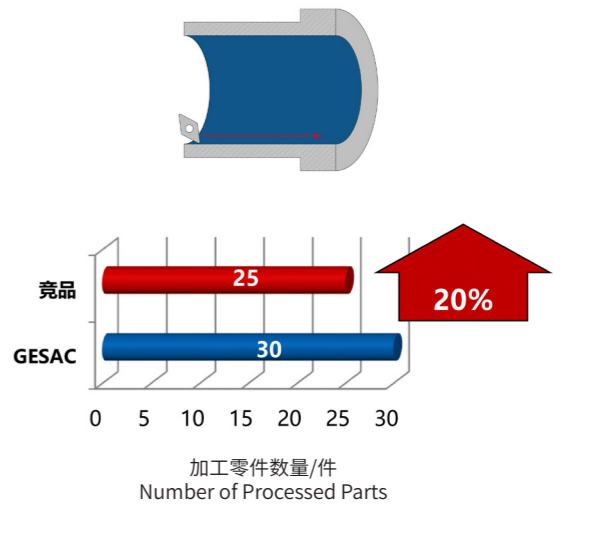
## 案例3: 进气机匣外壁加工

Case 3: Machining the Outer Surface of The Intake Housing

工件 Workpiece	进气机匣-GH4169 Air Intake Casing-GH4169	 <p>加工零件数量/件 Number of Processed Parts</p> <p>竞品 1 GESAC 1 相当</p>
加工方式 Processing Methods	外圆/端面连续车削-半精加工-湿切 Cylindrical / End Face Continuous Turning - Semi Finishing - Wet Cutting	
切削参数 Parameters	Vc= 17.6m/min f=0.15mm/r ap=0.3-0.5mm	
测试刀具 Test Tool	CNMG120408-EL-GST7120	

## 案例4: 筒壁件加工

Case 4: Machining the Internal Cylindrical Surface

工件 Workpiece	筒壁件-GH141 Cylinder Wall Part of GH141	 <p>加工零件数量/件 Number of Processed Parts</p> <p>竞品 25 GESAC 30 20%</p>
加工方式 Processing Methods	内圆连续车削-粗加工-湿切 Cylindrical / End Face Continuous Turning - Inner Circle Continuous Turning- Rough Machining- Wet Cutting	
切削参数 Parameters	Vc= 19 m/min f=0.2mm/r ap=3.5mm	
测试刀具 Test Tool	DNMG150408-EM-GST7115	

## 选型指南 Selection Guide

	MFC115	MFC145	MFC160
图示 Image			
规格尺寸 Specification	ø25-ø160	ø25-ø315	ø40-ø250
接口形式 Connection Type	心轴式 Arbor 圆柱直柄式 Cylindrical Shank 可换刀头式 Screwed Type	心轴式 Arbor 圆柱直柄式 Cylindrical Shank 可换刀头式 Screwed Type	心轴式 Arbor
最大切深 Maximum Depth of Cut	HN06: APMX =1.6mm HN09: APMX =2.2mm	HN06: APMX =3.2mm HN09: APMX =4.5mm HN13: APMX =8.0mm	HN06: APMX =4.3mm HN09: APMX =7.4mm

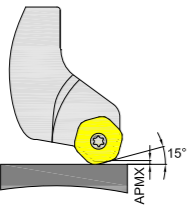

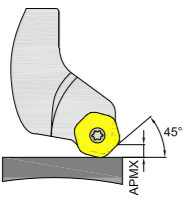

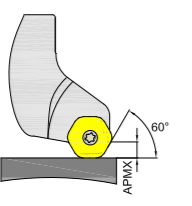

# B

## 铣削 Milling

### 骇客系列-多功能经济型面铣刀具HNGU+MFC115&145&160 Multifunctional and Economical Face-milling Tools HNGU+MFC115&145&160

- 双面12刃，高经济性。  
Double-side with 12 cutting edges achieving cost effective.
- 刀片分段切削刃设计搭配3种主偏角刀盘满足常规平面铣、高效进给铣削等多样加工需求。  
The sectional cutting edge design of insert is matched with 3 different entering angle holders, which meets the diverse processing needs of face milling and high feed milling.
- 广泛应用于汽车行业、通用机械、能源重工行业。  
Mainly used in the automobile industry, general machinery industry and energy heavy industry.

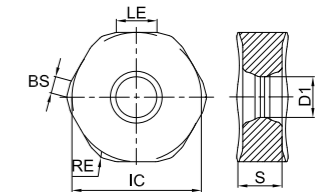
### 可转位铣削产品一览表 Indexable Milling Products List








类型 Type	应用 Application	刀片系列 Inserts Series	刀体系列 Cutter Series	图示 Picture	简介 Product Application
平面铣削 Face Milling	 HN06: APMX =1.6mm HN09: APMX =2.2mm	HNGU	MFC115 (Φ25-Φ160)		钢、铸铁、不锈钢等材料的平面铣削加工。 Face milling for steel, Cast Iron and Stainless Steel.
	 HN06: APMX =3.2mm HN09: APMX =4.5mm HN13: APMX =8.0mm	HNGU	MFC145 (Φ25-Φ315)		钢、铸铁、不锈钢等材料的平面铣削加工。 Face milling for steel, Cast Iron and Stainless Steel.
	 HN06: APMX =4.3mm HN09: APMX =7.4mm	HNGU	MFC160 (Φ40-Φ250)		钢、铸铁、不锈钢等材料的平面铣削加工。 Face milling for steel, Cast Iron and Stainless Steel.

### 平面铣削 Face Milling

## HNGU

负型十二刃平面铣刀片  
Negative Face Milling Insert with Twelve Cutting Edges











订货号 Ordering Code	尺寸 Dimension(mm)						涂层硬质合金 Coating Grade										硬质合金 Uncoated	金属陶瓷 Cermet	
	LE	IC	S	BS	D1	RE	GPMT120	GA4325	GA4330	GP2115	GM4135	GM2140	GK4125	GK2115	GS4130	GH4115			GN9125
	HNGU0604ANEN-GL	3.4	12	4.44	1.1	4.9	1.0	●		●	●	○	●	●	●	○			
	HNGU0905ANEN-GL	4.6	15.88	5.52	1.35	5	2.2	●		●	●	●	●	●	●	●			
	HNGU060432-GL	3.4	12	4.44	--	4.9	3.2	●		○	○	○	○	○	○	○			
	HNGU0604ANEN-GM	3.4	12	4.48	1.1	4.9	1.0	●	●	●	●	●	●	●	●	●			
	HNGU0905ANEN-GM	4.6	15.88	5.56	1.35	5	2.2	●	●	●	●	●	●	●	●	●			
	HNGU1307ANEN-GM	7.3	22.25	7.48	1.65	7.95	1.3	●	○	●	○	○	●	●	●	○			
	HNGU130720-GM	10.5	22.25	7.48	--	7.95	2.0	●	○	○	○	○	○	○	○	○			
	HNGU0604ANEN-GH	3.4	12	4.48	1.1	4.9	1.0	●		●			●	●	●				
	HNGU0905ANEN-GH	4.6	15.88	5.56	1.35	5	2.2	●		●			●	●	●				
	HNGU1307ANEN-GH	7.3	22.25	7.48	1.65	7.95	1.3	●		●			●	●	●				
	HNGU060432-GH	3.4	12	4.48	--	4.9	3.2	●		○				○	○				
	HNGU090543-GH	4.2	15.88	5.56	--	5	4.3	●		○				○	○				
	HNGU130720-GH	10.5	22.25	7.48	--	7.95	2.0	●		○				○	○				
	HNGU130735-GH	8.8	22.25	7.48	--	7.95	3.5	●		○				○	○				
	★ HNGU0604ANFN-GW	5.6	12	4.53	4.8	4.9	1.2	●						○					
	★ HNGU0905ANFN-GW	7.8	15.88	5.54	6.1	5	1.6	●						○					

注: ★ HNGU\*\*\*\*ANFN-GW刀片搭配MFC145系列刀体  
Note: ★ HNGU\*\*\*\*ANFN-GW Inserts Match with MFC145 Cutters

●标准库存 Stock ○需预定 Available upon Order



## HNGU 系列槽型 HNGU Series Geometry

通用材料轻切削 Light Cutting for General Material	通用材料中切削 Medium Cutting for General Material	通用材料重切削 Heavy Cutting for General Material	修光刃 Wiper
			
GL	GM	GH	GW
			
大前角设计，最适于低切削力、低进给率的轻载加工。 Large rake angle, suitable for light cutting of low cutting speed and feed rate.	大前角设计，切削轻快，大多数工况下可实现高稳定性加工。 Under general cutting conditions, high stability can be achieved by milling with large rake angle.	高强度刃口，断续切削、粗加工时性能优异。 High-strength cutting edge with excellent performance in intermittent cutting and rough machining.	大圆弧修光刃，提高表面质量。 The wiper edge is smooth with large arc, which improves the surface quality.

## 平面铣削 Face Milling

### MFC115

心轴式  
Arbor

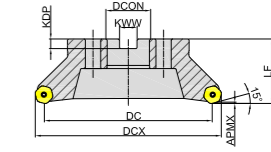
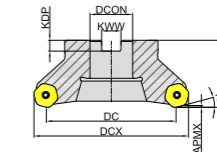
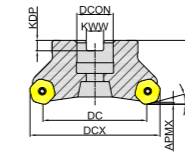
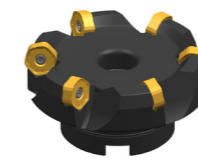


Fig1

Fig2

Fig3

订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 Dimension(mm)						最大切深 APMX	匹配刀片 Suitable for	内冷 Coolant	图示 Shape	库存 Stock
			DC	DCX	DCON	LF	KWW	KDP					
MFC115040R05A16HN06	40	5	40	53	16	40	8.4	5.6	1.6	HNGU0604	√	Fig1	●
MFC115050R04A22HN09	50	4	50	67.7	22	40	10.4	6.3	2.2	HNGU0905	√	Fig1	●
MFC115050R05A22HN06	50	5	50	63	22	40	10.4	6.3	1.6	HNGU0604	√	Fig1	●
MFC115063R05A22HN09	63	5	63	80.7	22	40	10.4	6.3	2.2	HNGU0905	√	Fig1	●
MFC115063R06A22HN06	63	6	63	76	22	40	10.4	6.3	1.6	HNGU0604	√	Fig1	●
MFC115080R06A27HN09	80	6	80	97.7	27	50	12.4	7	2.2	HNGU0905	√	Fig1	●
MFC115080R08A27HN06	80	8	80	93	27	50	12.4	7	1.6	HNGU0604	√	Fig1	●
MFC115100R08B32HN09	100	8	100	117.7	32	50	14.5	8	2.2	HNGU0905	×	Fig2	●
MFC115125R09B40HN09	125	9	125	142.7	40	63	16.4	9	2.2	HNGU0905	×	Fig2	●
MFC115160R12C40HN09	160	12	160	177.7	40	63	16.4	9	2.2	HNGU0905	×	Fig3	●

●标准库存 Stock ○需预定 Available upon Order

### MFC115

可换式刀头  
Screwed Cutter

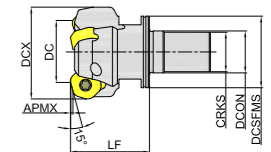


Fig4

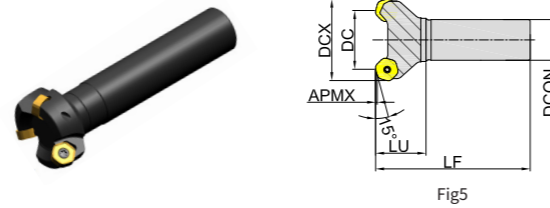
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			DC	DCX	DCON	DCSFMS	LF	CRKS					
MFC115025R03M16HN06	25	3	25	38.2	17	29	32	M16	1.6	HNGU0604	√	Fig4	●
MFC115032R03M16HN06	32	3	32	45	17	29	40	M16	1.6	HNGU0604	√	Fig4	●

●标准库存 Stock ○需预定 Available upon Order

平面铣削  
Face Milling

# MFC115

圆柱直柄式  
Cylindrical Straight Type



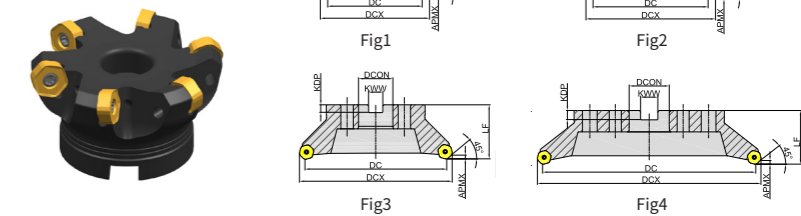
订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 Dimension(mm)					最大 切深 APMX	匹配刀片 Suitable for	内冷 Coolant	图示 Shape	库存 Stock
			DC	DCX	DCON	LF	LU					
MFC115025R03P20HN06	25	3	25	38.2	20	120	32	1.6	HNGU0604	√	Fig5	●
MFC115032R03P25HN06	32	3	32	45	25	130	40	1.6	HNGU0604	√	Fig5	●

●标准库存 Stock ○需预定 Available upon Order

平面铣削  
Face Milling

# MFC145

心轴式  
Arbor  
疏齿型  
Sparse Pitch



订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 Dimension(mm)							最大 切深 APMX	匹配刀片 Suitable for	内冷 Coolant	图示 Shape	库存 Stock
			DC	DCX	DCON	LF	KWW	KDP						
MFC145040R04A16HN06	40	4	40	48	16	40	8.4	5.6	3.2	HNGU0604	√	Fig1	●	
MFC145050R04A22HN06	50	4	50	58	22	40	10.4	6.3	3.2	HNGU0604	√	Fig1	●	
MFC145050R04A22HN09	50	4	50	60.6	22	40	10.4	6.3	4.5	HNGU0905	√	Fig1	●	
MFC145063R04A22HN06	63	4	63	71	22	40	10.4	6.3	3.2	HNGU0604	√	Fig1	●	
MFC145063R05A22HN09	63	5	63	73.6	22	40	10.4	6.3	4.5	HNGU0905	√	Fig1	●	
MFC145080R04A27HN13	80	4	80	95.4	27	50	12.4	7	8.0	HNGU1307	√	Fig1	●	
MFC145080R05A27HN06	80	5	80	88	27	50	12.4	7	3.2	HNGU0604	√	Fig1	●	
MFC145080R05A27HN09	80	5	80	90.6	27	50	12.4	7	4.5	HNGU0905	√	Fig1	●	
MFC145100R05B32HN13	100	5	100	115.4	32	50	14.5	8	8.0	HNGU1307	×	Fig2	●	
MFC145100R06B32HN06	100	6	100	108	32	50	14.5	8	3.2	HNGU0604	×	Fig2	●	
MFC145100R06B32HN09	100	6	100	110.6	32	50	14.5	8	4.5	HNGU0905	×	Fig2	●	
MFC145125R06B40HN13	125	6	125	140.4	40	63	16.4	9	8.0	HNGU1307	×	Fig2	●	
MFC145125R08B40HN06	125	8	125	133	40	63	16.4	9	3.2	HNGU0604	×	Fig2	●	
MFC145125R08B40HN09	125	8	125	135.6	40	63	16.4	9	4.5	HNGU0905	×	Fig2	●	
MFC145160R09C40HN13	160	9	160	175.4	40	63	16.4	9	8.0	HNGU1307	×	Fig3	●	
MFC145160R10C40HN09	160	10	160	170.6	40	63	16.4	9	4.5	HNGU0905	×	Fig3	●	
MFC145200R12C60HN13	200	12	200	215.4	60	63	25.7	14	8.0	HNGU1307	×	Fig3	●	
MFC145200R16C60HN09	200	16	200	210.6	60	63	25.7	14	4.5	HNGU0905	×	Fig3	●	
MFC145250R12C60HN13	250	12	250	265.4	60	63	25.7	14	8.0	HNGU1307	×	Fig3	●	
MFC145250R20C60HN09	250	20	250	260.6	60	63	25.7	14	4.5	HNGU0905	×	Fig3	●	
MFC145315R14D60HN13	315	14	315	330.4	60	80	25.7	14	8.0	HNGU1307	×	Fig4	●	
MFC145315R24D60HN09	315	24	315	325.6	60	80	25.7	14	4.5	HNGU0905	×	Fig4	●	

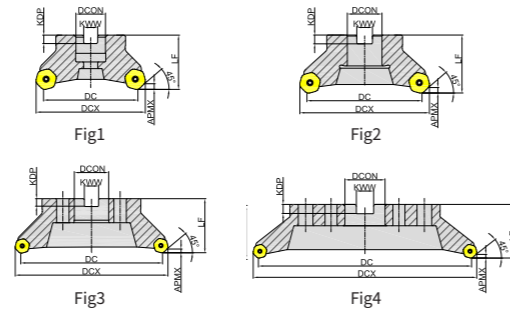
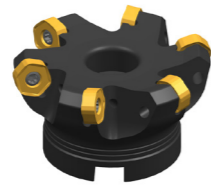
●标准库存 Stock ○需预定 Available upon Order

平面铣削  
Face Milling

# MFC145

心轴式  
Arbor

密齿型  
Dense Pitch



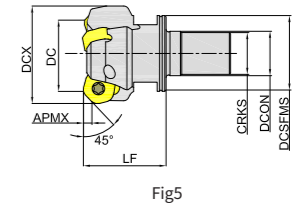
订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 Dimension(mm)						最大 切深 APMX	匹配刀片 Suitable for	内冷 Coolant	图示 Shape	库存 Stock
			DC	DCX	DCON	LF	KWW	KDP					
MFC145040R05A16HN06	40	5	40	48	16	40	8.4	5.6	3.2	HNGU0604	√	Fig1	●
MFC145050R05A22HN06	50	5	50	58	22	40	10.4	6.3	3.2	HNGU0604	√	Fig1	●
MFC145050R05A22HN09	50	5	50	60.6	22	40	10.4	6.3	4.5	HNGU0905	√	Fig1	●
MFC145050R06A22HN06	50	6	50	58	22	40	10.4	6.3	3.2	HNGU0604	√	Fig1	●
MFC145063R06A22HN06	63	6	63	71	22	40	10.4	6.3	3.2	HNGU0604	√	Fig1	●
MFC145063R06A22HN09	63	6	63	73.6	22	40	10.4	6.3	4.5	HNGU0905	√	Fig1	●
MFC145063R07A22HN09	63	7	63	73.6	22	40	10.4	6.3	4.5	HNGU0905	√	Fig1	●
MFC145063R08A22HN06	63	8	63	71	22	40	10.4	6.3	3.2	HNGU0604	√	Fig1	●
MFC145080R06A27HN09	80	6	80	90.6	27	50	12.4	7	4.5	HNGU0905	√	Fig1	●
MFC145080R08A27HN06	80	8	80	88	27	50	12.4	7	3.2	HNGU0604	√	Fig1	●
MFC145080R09A27HN09	80	9	80	90.6	27	50	12.4	7	4.5	HNGU0905	√	Fig1	●
MFC145080R10A27HN06	80	10	80	88	27	50	12.4	7	3.2	HNGU0604	√	Fig1	●
MFC145100R08B32HN09	100	08	100	110.6	32	50	14.5	8	4.5	HNGU0905	×	Fig2	●
MFC145100R09A32HN06	100	09	100	108	32	50	14.5	8	3.2	HNGU0604	√	Fig1	●
MFC145100R09B32HN06	100	09	100	108	32	50	14.5	8	3.2	HNGU0604	×	Fig2	●
MFC145100R11B32HN09	100	11	100	110.6	32	50	14.5	8	4.5	HNGU0905	×	Fig2	●
MFC145100R12A32HN06	100	12	100	108	32	50	14.5	8	3.2	HNGU0604	√	Fig1	●
MFC145100R12B32HN06	100	12	100	108	32	50	14.5	8	3.2	HNGU0604	×	Fig2	●
MFC145125R10B40HN09	125	10	125	135.6	40	63	16.4	9	4.5	HNGU0905	×	Fig2	●
MFC145125R12B40HN06	125	12	125	133	40	63	16.4	9	3.2	HNGU0604	×	Fig2	●
MFC145125R14B40HN09	125	14	125	135.6	40	63	16.4	9	4.5	HNGU0905	×	Fig2	●
MFC145125R16B40HN06	125	16	125	133	40	63	16.4	9	3.2	HNGU0604	×	Fig2	●
MFC145160R12C40HN09	160	12	160	170.6	40	63	16.4	9	4.5	HNGU0905	×	Fig3	●
MFC145160R16C40HN09	160	16	160	170.6	40	63	16.4	9	4.5	HNGU0905	×	Fig3	●
MFC145200R10C60HN13	200	10	200	215.4	60	63	25.7	14	8.0	HNGU1307	×	Fig3	●
MFC145250R14C60HN13	250	14	250	265.4	60	63	25.7	14	8.0	HNGU1307	×	Fig3	●
MFC145315R18D60HN13	315	18	315	330.4	60	80	25.7	14	8.0	HNGU1307	×	Fig4	●

●标准库存 Stock ○需预定 Available upon Order

平面铣削  
Face Milling

# MFC145

可换式刀头  
Screwed Cutter



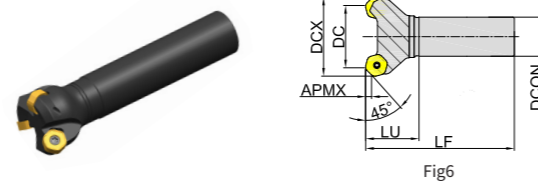
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			DC	DCX	DCON	DCSFMS	LF	CRKS					
MFC145025R03M16HN06	25	3	25	33	17	29	32	M16	3.2	HNGU0604	√	Fig5	●
MFC145032R03M16HN06	32	3	32	40	17	29	40	M16	3.2	HNGU0604	√	Fig5	●
MFC145032R04M16HN06	32	4	32	40	17	29	40	M16	3.2	HNGU0604	√	Fig5	●

●标准库存 Stock ○需预定 Available upon Order

平面铣削  
Face Milling

# MFC145

圆柱直柄式  
Cylindrical Straight Type

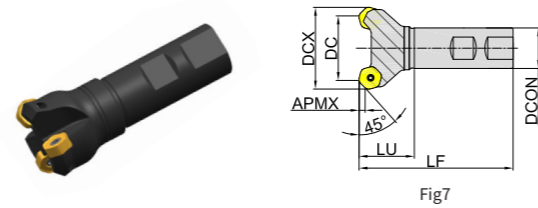


订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 Dimension(mm)					最大 切深 APMX	匹配刀片 Suitable for	内冷 Coolant	图示 Shape	库存 Stock
			DC	DCX	DCON	LF	LU					
MFC145025R02P20HN06	25	2	25	33	20	120	32	3.2	HNGU0604	√	Fig6	●
MFC145025R03P25HN06L	25	3	25	33	20	200	32	3.2	HNGU0604	√	Fig6	●
MFC145032R03P25HN06	32	3	32	40	25	130	40	3.2	HNGU0604	√	Fig6	●
MFC145040R03P25HN09	40	3	40	50.7	25	107	50	4.5	HNGU0905	√	Fig6	●
MFC145025R03P20HN06	25	3	25	33	20	120	32	3.2	HNGU0604	√	Fig6	●
MFC145032R04P25HN06	32	4	32	40	25	130	40	3.2	HNGU0604	√	Fig6	●
MFC145040R04P25HN09	40	4	40	50.7	25	107	50	4.5	HNGU0905	√	Fig6	●

●标准库存 Stock ○需预定 Available upon Order

# MFC145

侧固式  
Side Clamp Type



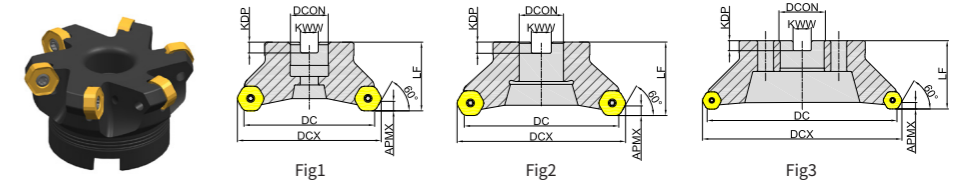
订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 Dimension(mm)					最大 切深 APMX	匹配刀片 Suitable for	内冷 Coolant	图示 Shape	库存 Stock
			DC	DCX	DCON	LF	LU					
MFC145025R03W20HN06	25	3	25	33	20	82	32	3.2	HNGU0604	√	Fig7	●
MFC145032R03W25HN06	32	3	32	40	25	97	40	3.2	HNGU0604	√	Fig7	●
MFC145040R03W25HN09	40	3	40	50.6	25	107	50	4.5	HNGU0905	√	Fig7	●
MFC145032R04W25HN06	32	4	32	40	25	97	40	3.2	HNGU0604	√	Fig7	●
MFC145040R04W25HN09	40	4	40	50.6	25	107	50	4.5	HNGU0905	√	Fig7	●

●标准库存 Stock ○需预定 Available upon Order

平面铣削  
Face Milling

# MFC160

心轴式  
Arbor  
疏齿型  
Sparse Pitch



订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 Dimension(mm)						最大 切深 APMX	匹配刀片 Suitable for	内冷 Coolant	图示 Shape	库存 Stock
			DC	DCX	DCON	LF	KWW	KDP					
MFC160040R04A16HN06	40	4	40	46.1	16	40	8.4	5.6	4.3	HNGU0604	√	Fig1	●
MFC160050R04A22HN06	50	4	50	56.1	22	40	10.4	6.3	4.3	HNGU0604	√	Fig1	●
MFC160050R05A22HN09	50	5	50	58	22	40	10.4	6.3	7.4	HNGU0905	√	Fig1	●
MFC160063R04A22HN06	63	4	63	69.1	22	40	10.4	6.3	4.3	HNGU0604	√	Fig1	●
MFC160063R06A22HN09	63	6	63	71	22	40	10.4	6.3	7.4	HNGU0905	√	Fig1	●
MFC160080R05A27HN06	80	5	80	86.1	27	50	12.4	7	4.3	HNGU0604	√	Fig1	●
MFC160080R08A27HN09	80	8	80	88	27	50	12.4	7	7.4	HNGU0905	√	Fig1	●
MFC160100R06B32HN06	100	6	100	106.1	32	50	14.5	8	4.3	HNGU0604	×	Fig2	●
MFC160100R10B32HN09	100	10	100	108	32	50	14.5	8	7.4	HNGU0905	×	Fig2	●
MFC160125R08B40HN06	125	8	125	131.1	40	63	16.4	9	4.3	HNGU0604	×	Fig2	●
MFC160125R12B40HN09	125	12	125	133	40	63	16.4	9	7.4	HNGU0905	×	Fig2	●
MFC160160R14C40HN09	160	14	160	168	40	63	16.4	9	7.4	HNGU0905	×	Fig3	●
MFC160200R16C60HN09	200	16	200	208	60	63	25.7	14	7.4	HNGU0905	×	Fig3	●
MFC160250R16C60HN09	250	16	250	258	60	63	25.7	14	7.4	HNGU0905	×	Fig3	●

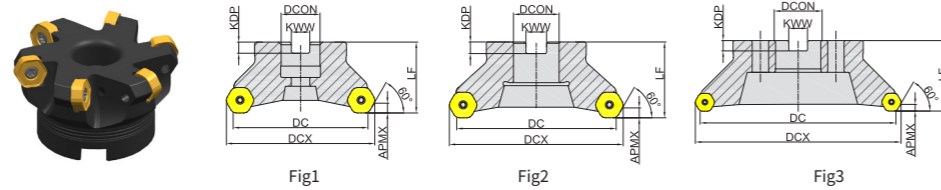
●标准库存 Stock ○需预定 Available upon Order

平面铣削  
Face Milling

# MFC160

心轴式  
Arbor

密齿型  
Dense Pitch



订货号 Ordering Code	直径 Diameter	刃数 Teeth	尺寸 Dimension(mm)						最大 切深 APMX	匹配刀片 Suitable for	内冷 Coolant	图示 Shape	库存 Stock
			DC	DCX	DCON	LF	KWW	KDP					
MFC160040R05A16HN06	40	5	40	46.1	16	40	8.4	5.6	4.3	HNGU0604	√	Fig1	●
MFC160050R05A22HN06	50	5	50	56.1	22	40	10.4	6.3	4.3	HNGU0604	√	Fig1	●
MFC160063R06A22HN06	63	6	63	69.1	22	40	10.4	6.3	4.3	HNGU0604	√	Fig1	●
MFC160080R08A27HN06	80	8	80	86.1	27	50	12.4	7	4.3	HNGU0604	√	Fig1	●
MFC160100R09B32HN06	100	9	100	106.1	32	50	14.5	8	4.3	HNGU0604	×	Fig2	●
MFC160125R12B40HN06	125	12	125	131.1	40	63	16.4	9	4.3	HNGU0604	×	Fig2	●

●标准库存 Stock ○需预定 Available upon Order

## 应用案例 Application

### 案例 1 Case 1

工件 Workpiece	涡轮壳法兰面-1.4837 The Flange Surface of Turbine Shell	<p>加工零件数量/件 Number of Processed Parts</p>
加工方式 Processing Methods	平面铣削-粗加工-干切 Face Milling-Roughing-Dry Cutting	
切削参数 Parameters	Vc= 130 m/min fz=0.15mm/z ap=2.5mm ae=56mm	
测试刀具 Test Tool	刀片Insert: HNGU0604ANEN-GM-GM2140 刀体Cutter Holder: MFC145-080R05A27-HN06	

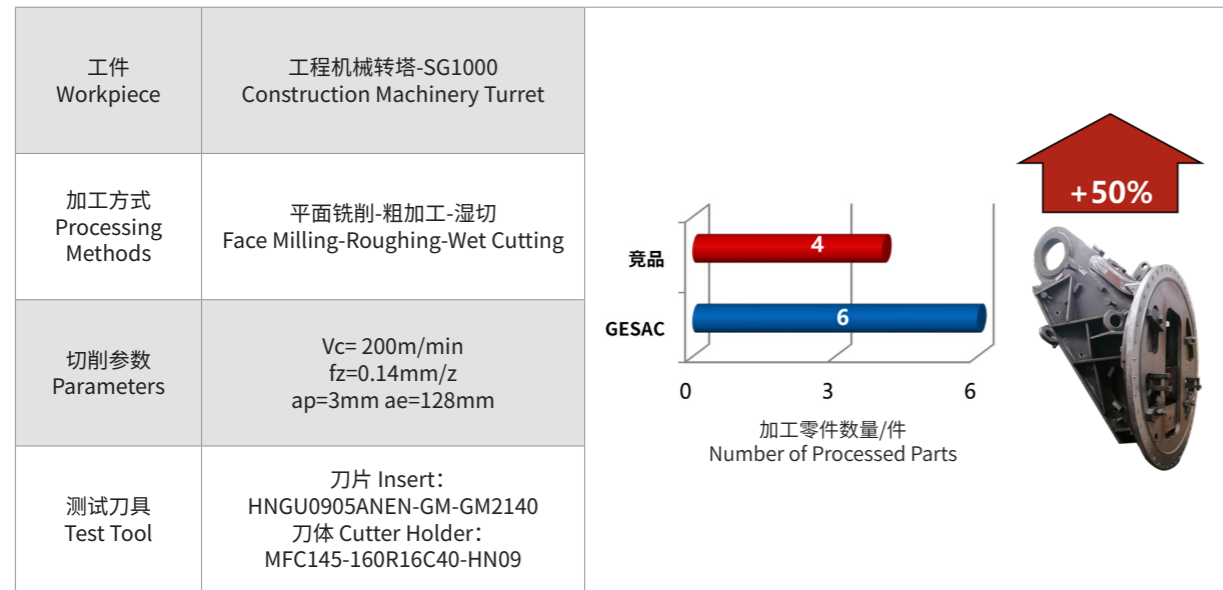
## 刀体配件列表 Spare Parts

零件名称 Part Name		刀片螺钉 Inserts Screw	刀片螺钉扳手 Insert Screw Wrench	
适用刀片 Inserts	形状 Shape			
	规格 Specification	SR30M040100	TT15P	TT15T
HNGU0604	订货号 Ordering Code	SR30M040100K	TT15PQ	TT15TQ
HNGU0905	规格 Specification	SR30M040100	TT15P	TT15T
	订货号 Ordering Code	SR30M040100K	TT15PQ	TT15TQ
HNGU1307	规格 Specification	SR45M060160I		TI25T
	订货号 Ordering Code	SR45M060160IK		TI25TQ

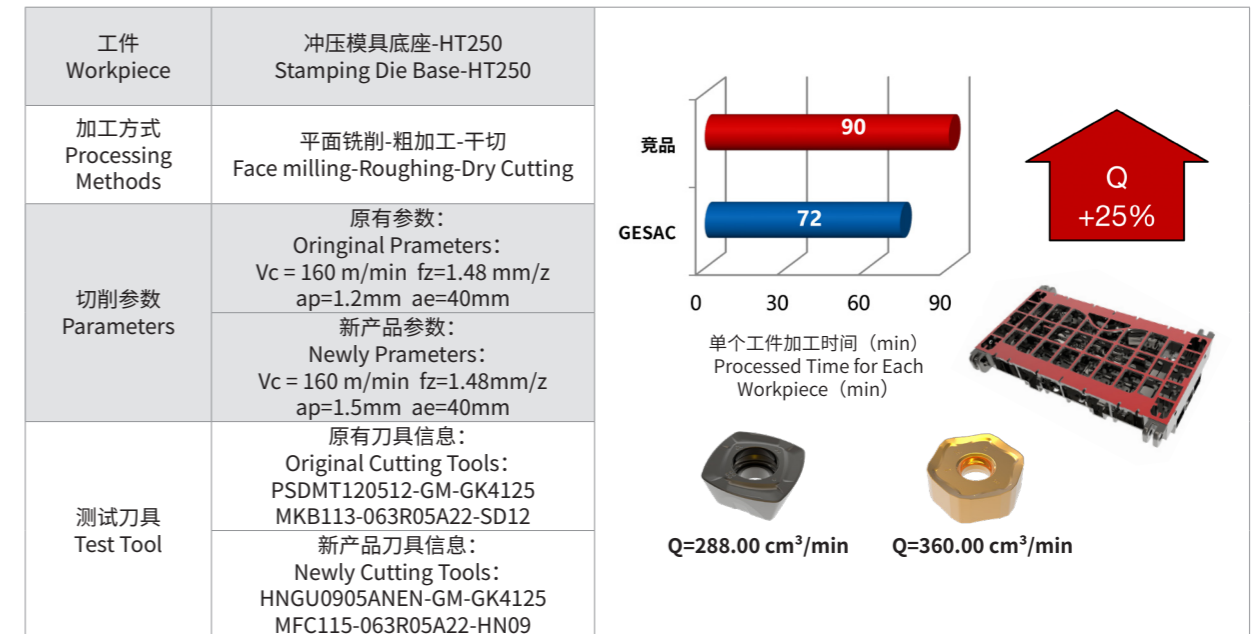
### 案例 2 Case 2

工件 Workpiece	涡轮壳法兰面-1.4837 The Flange Surface of Turbine Shell	<p>加工零件数量/件 Number of Processed Parts</p>
加工方式 Processing Methods	平面铣削-精加工-湿切 Face milling-Finish-Wet cutting	
切削参数 Parameters	Vc= 172m/min fz=0.12mm/z ap=0.3mm ae=80mm	
测试刀具 Test Tool	刀片 Insert: HNGU0604ANEN-GL-GM2140 刀体 Cutter Holder: MFC145-100R09A32-HN06	

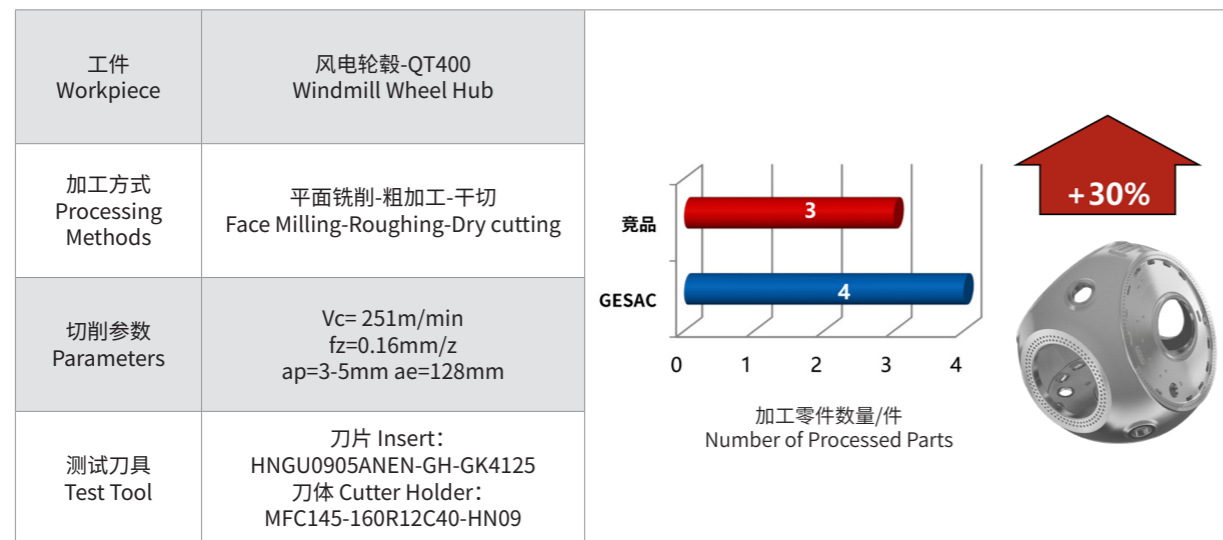
案例 3  
Case 3



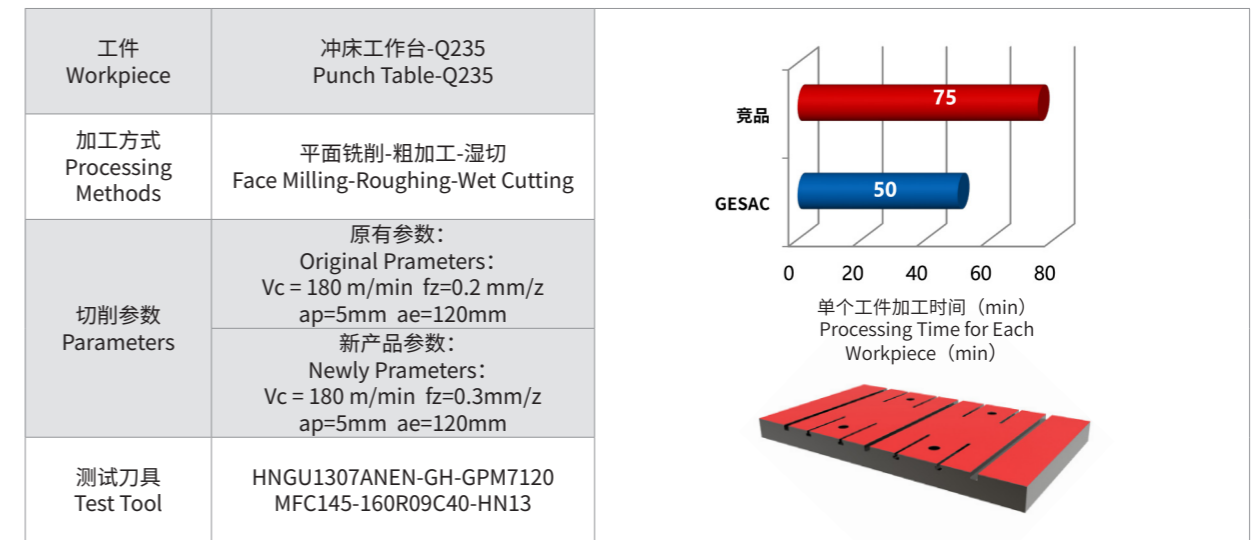
案例 5  
Case 5



案例 4  
Case 4



案例 6  
Case 6



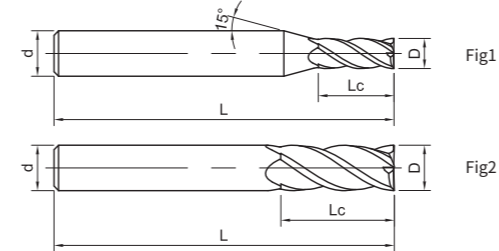
# B

铣削  
Milling



## SS600-S4

4刃平头  
4 Flutes, Square



订货号 Ordering Code	D	Lc	L	d	图号 Figure No.	库存 Stock
SS600-S4-02006	2	6	50	4	1	●
SS600-S4-03009	3	9	50	4	1	●
SS600-S4-04011	4	11	50	4	2	●
SS600-S4-64011	4	11	50	6	1	●
SS600-S4-05013	5	13	50	6	1	●
SS600-S4-06016	6	16	50	6	2	●
SS600-S4-08020	8	20	60	8	2	●
SS600-S4-10025	10	25	75	10	2	●
SS600-S4-12026	12	26	83	12	2	●
SS600-S4-16032	16	32	92	16	2	●
SS600-S4-20038	20	38	100	20	2	●

●标准库存 Stock ○需预定 Available upon Order

D	公差 Tolerance
D < 6	0 -0.02
6 ≤ D ≤ 12	0 -0.03
D > 12	0 -0.04

单位unit (mm)

### SS600高效不锈钢加工立铣刀 SS600 Endmills for High-efficiency Machining of Stainless Steel

- 适用于加工高强度钢、沉淀硬化不锈钢、钛合金等。  
Suitable for processing high strength steel, precipitated hardened stainless steel, titanium alloy, etc.
- SS600-R5特殊圆角保护，可用于摆线铣，高效加工或者精加工。  
Special fillet protection, can be used for trochoidal milling, high-efficiency machining or finished machining.
- 槽铣性能优异，刃口强度高，抗崩刃。  
Excellent slotting performance can be achieved by high edge strength and strong anti-collapse ability.
- 不等螺旋不等分度设计，切削过程稳定。  
Unequal helical non-isometric design, stable cutting process.
- 抛物线型容屑槽设计，拥有优异的排屑能力。  
Parabolic chip geometry with excellent chip removal capability.

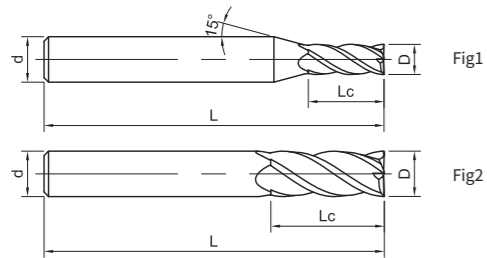
#### 工件材料 Workpiece Material

P		M	K	S	
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
◎	◎	◎	○	○	◎

◎ 最适合 Most Suitable ○ 适合 Suitable

# SS600-SS4

4刃短刃平头  
4 Short Flutes, Square



订货号 Ordering Code	D	Lc	L	d	图号 Figure No.	库存 Stock
SS600-SS4-02004	2	4	50	4	1	●
SS600-SS4-03006	3	6	50	4	1	●
SS600-SS4-04006	4	6	50	4	2	●
SS600-SS4-06006	6	6	50	6	2	●
SS600-SS4-06010	6	10	50	6	2	●
SS600-SS4-08015	8	15	60	8	2	●
SS600-SS4-10015	10	15	60	10	2	●
SS600-SS4-12016	12	16	75	12	2	●
SS600-SS4-16022	16	22	92	16	2	●
SS600-SS4-20026	20	26	100	20	2	●

●标准库存 Stock ○需预定 Available upon Order

D	公差 Tolerance
D<6	0 -0.02
6≤D≤12	0 -0.03
D>12	0 -0.04

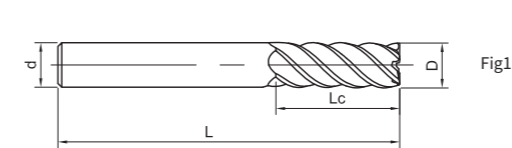
单位unit (mm)

工件材料 Workpiece Material					
P		M	K	S	
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
◎	◎	◎	○	○	◎

◎最适合 Most Suitable ○适合 Suitable

# SS600-S5

5刃平头  
5 Flutes, Square



订货号 Ordering Code	D	Lc	L	d	图号 Figure No.	库存 Stock
SS600-S5-06016	6	16	50	6	1	●
SS600-S5-08020	8	20	60	8	1	●
SS600-S5-10025	10	25	75	10	1	●
SS600-S5-12026	12	26	83	12	1	●
SS600-S5-16032	16	32	92	16	1	●
SS600-S5-20038	20	38	100	20	1	●
SS600-S5-25050	25	50	125	25	1	●

●标准库存 Stock ○需预定 Available upon Order

D	公差 Tolerance
D<6	0 -0.02
6≤D≤12	0 -0.03
D>12	0 -0.04

单位unit (mm)

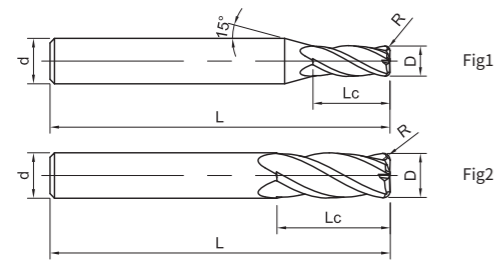
工件材料 Workpiece Material					
P		M	K	S	
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
◎	◎	◎	○	○	◎

◎最适合 Most Suitable ○适合 Suitable



# SS600-R4

4刃圆角头  
4 Flutes, Corner Radius



订货号 Ordering Code	D	R	Lc	L	d	图号 Figure No.	库存 Stock
SS600-R4-02002	2	0.2	6	50	4	1	●
SS600-R4-03005	3	0.5	8	50	4	1	●
SS600-R4-04005	4	0.5	11	50	4	2	●
SS600-R4-64005	4	0.5	11	50	6	1	●
SS600-R4-05005	5	0.5	13	50	6	1	●
SS600-R4-06005	6	0.5	16	50	6	2	●
SS600-R4-06010	6	1	16	50	6	2	●
SS600-R4-08005	8	0.5	20	60	8	2	●
SS600-R4-08010	8	1	20	60	8	2	●
SS600-R4-10005	10	0.5	25	75	10	2	●
SS600-R4-10010	10	1	25	75	10	2	●
SS600-R4-10020	10	2	25	75	10	2	●

●标准库存 Stock ○需预定 Available upon Order

D	公差 Tolerance
D<6	0 -0.02
6≤D≤12	0 -0.03
D>12	0 -0.04

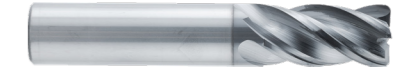
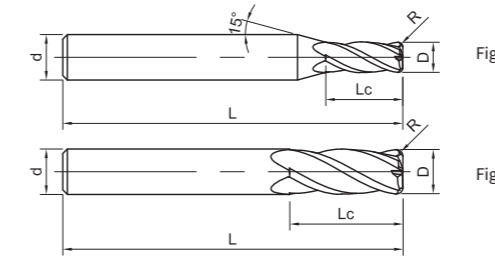
单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
◎	◎	◎	○	○	◎

◎最适合 Most Suitable ○适合 Suitable

# SS600-R4

4刃圆角头  
4 Flutes, Corner Radius



订货号 Ordering Code	D	R	Lc	L	d	图号 Figure No.	库存 Stock
SS600-R4-12005	12	0.5	26	83	12	2	●
SS600-R4-12010	12	1	26	83	12	2	●
SS600-R4-12020	12	2	26	83	12	2	●
SS600-R4-12030	12	3	26	83	12	2	●
SS600-R4-16005	16	0.5	32	92	16	2	●
SS600-R4-16010	16	1	32	92	16	2	●
SS600-R4-16015	16	1.5	32	92	16	2	●
SS600-R4-16020	16	2	32	92	16	2	●
SS600-R4-16030	16	3	32	92	16	2	●
SS600-R4-20005	20	0.5	38	100	20	2	●
SS600-R4-20010	20	1	38	100	20	2	●
SS600-R4-20020	20	2	38	100	20	2	●
SS600-R4-20030	20	3	38	100	20	2	●

●标准库存 Stock ○需预定 Available upon Order

D	公差 Tolerance
D<6	0 -0.02
6≤D≤12	0 -0.03
D>12	0 -0.04

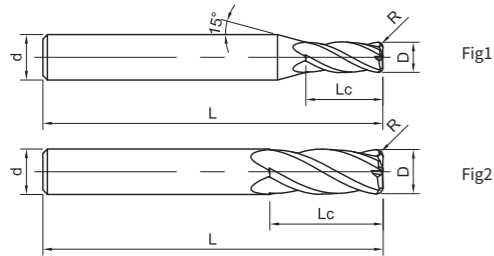
单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
◎	◎	◎	○	○	◎

◎最适合 Most Suitable ○适合 Suitable

# SS600-RS4

4刃短刃圆角头  
4 Flutes, Corner Radius



订货号 Ordering Code	D	R	Lc	L	d	图号 Figure No.	库存 Stock
SS600-RS4-02001	2	0.1	4	50	4	1	●
SS600-RS4-04002	4	0.2	6	50	4	2	●
SS600-RS4-06005	6	0.5	10	50	6	2	●
SS600-RS4-08005	8	0.5	12	60	8	2	●
SS600-RS4-10005	10	0.5	14	60	10	2	●
SS600-RS4-12010	12	1	16	75	12	2	●
SS600-RS4-16010	16	1	22	92	16	2	●
SS600-RS4-20010	20	1	26	100	20	2	●

●标准库存 Stock ○需预定 Available upon Order

D	公差 Tolerance
D<6	0 -0.02
6≤D≤12	0 -0.03
D>12	0 -0.04

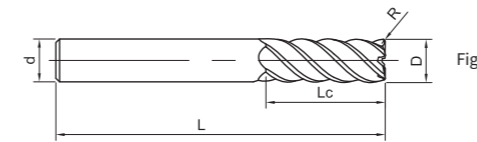
单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
◎	◎	◎	○	○	◎

◎最适合 Most Suitable ○适合 Suitable

# SS600-R5

5刃圆角头  
5 Flutes, Corner Radius



订货号 Ordering Code	D	R	Lc	L	d	图号 Figure No.	库存 Stock
SS600-R5-06005	6	0.5	16	50	6	1	●
SS600-R5-06005A	6	0.5	16	60	6	1	●
SS600-R5-06005B	6	0.5	16	75	6	1	●
SS600-R5-06010	6	1	16	50	6	1	●
SS600-R5-08005	8	0.5	20	60	8	1	●
SS600-R5-08010	8	1	20	60	8	1	●
SS600-R5-08010A	8	1	20	75	8	1	●
SS600-R5-10005	10	0.5	25	75	10	1	●
SS600-R5-10010	10	1	25	75	10	1	●
SS600-R5-10010A	10	1	25	100	10	1	●

●标准库存 Stock ○需预定 Available upon Order

D	公差 Tolerance
D<6	0 -0.02
6≤D≤12	0 -0.03
D>12	0 -0.04

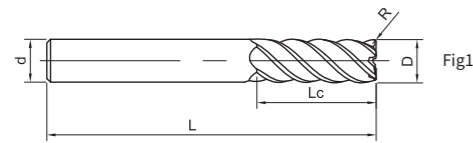
单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
◎	◎	◎	○	○	◎

◎最适合 Most Suitable ○适合 Suitable

# SS600-R5

5刃圆角头  
5 Flutes, Corner Radius



订货号 Ordering Code	D	R	Lc	L	d	图号 Figure No.	库存 Stock
SS600-R5-12005	12	0.5	26	83	12	1	●
SS600-R5-12010	12	1	26	83	12	1	●
SS600-R5-12020	12	2	26	83	12	1	●
SS600-R5-12030	12	3	26	83	12	1	●
SS600-R5-16010	16	1	32	92	16	1	●
SS600-R5-16020	16	2	32	92	16	1	●
SS600-R5-16030	16	3	32	92	16	1	●
SS600-R5-20010	20	1	38	100	20	1	●
SS600-R5-20020	20	2	38	100	20	1	●
SS600-R5-20030	20	3	38	100	20	1	●
SS600-R5-25030	25	3	50	125	25	1	●

●标准库存 Stock ○需预定 Available upon Order

D	公差 Tolerance
D < 6	0 -0.02
6 ≤ D ≤ 12	0 -0.03
D > 12	0 -0.04

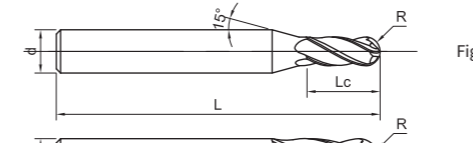
单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
◎	◎	◎	○	○	◎

◎最适合 Most Suitable ○适合 Suitable

# SS600-B4

4刃球头  
4 Flutes, Ball Nose



订货号 Ordering Code	D	R	Lc	L	d	图号 Figure No.	库存 Stock
SS600-B4-02004	2	1	4	50	4	1	●
SS600-B4-04008	4	2	8	50	4	2	●
SS600-B4-06012	6	3	12	50	6	2	●
SS600-B4-08014	8	4	14	60	8	2	●
SS600-B4-10018	10	5	18	75	10	2	●
SS600-B4-12022	12	6	22	75	12	2	●
SS600-B4-16030	16	8	30	100	16	2	●
SS600-B4-20038	20	10	38	100	20	2	●

●标准库存 Stock ○需预定 Available upon Order

R	公差Tol
R ≥ 1	±0.020

单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
◎	◎	◎	○	○	◎

◎最适合 Most Suitable ○适合 Suitable

## 推荐切削参数 Recommended Cutting Data

### SS600-SS4/RS4

不锈钢 Stainless Steel——侧铣 Side Milling



工件材料 Workpiece Material	切削量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	4	6	8	10	12	16	20
M 不锈钢 Stainless Steel	ap≤1.5D	80 (60~110)	转速Speed (min-1)	6730	4245	3185	2545	2020	1590	1275
	ae≤0.25D		进给速度Feed Rate (mm/min)	510	510	510	510	485	445	430
S 钛合金 Titanium Alloy	ap≤1.5D	60 (40~100)	转速Speed (min-1)	4780	3185	2390	1910	1590	1195	955
	ae≤0.25D		进给速度Feed Rate (mm/min)	285	320	335	354	350	310	305

### SS600-SS4/RS4

不锈钢 Stainless Steel——槽铣 Slotting



工件材料 Workpiece Material	切削量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	4	6	8	10	12	16	20
M 不锈钢 Stainless Steel	ap≤1.5D	60 (50~70)	转速Speed (min-1)	4775	3185	2390	1910	1590	1195	955
	ae≤1D		进给速度Feed Rate (mm/min)	285	320	335	345	350	310	305
S 钛合金 Titanium Alloy	ap≤1.5D	40 (30~60)	转速Speed (min-1)	3185	2120	1590	1270	1060	792	635
	ae≤1D		进给速度Feed Rate (mm/min)	190	190	190	200	210	190	190

### SS600-B4

不锈钢 Stainless Steel——仿型铣 Profiling



工件材料 Workpiece Material	切削量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	6	8	10	12	16	20
M 不锈钢 Stainless Steel	ap≤0.2D	100 (80~120)	转速Speed (min-1)	5300	3980	3180	2650	1990	1590
	ae≤0.2D		进给速度Feed Rate (mm/min)	1100	1100	1080	1050	1030	1020
S 钛合金 Titanium Alloy	ap≤0.2D	70 (60~80)	转速Speed (min-1)	3715	2785	2230	1860	1390	1110
	ae≤0.2D		进给速度Feed Rate (mm/min)	670	610	535	480	445	352

### SS600-S5/R5

不锈钢 Stainless Steel——侧铣 Side Milling



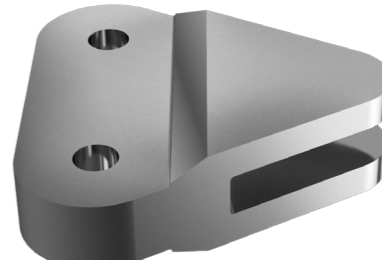
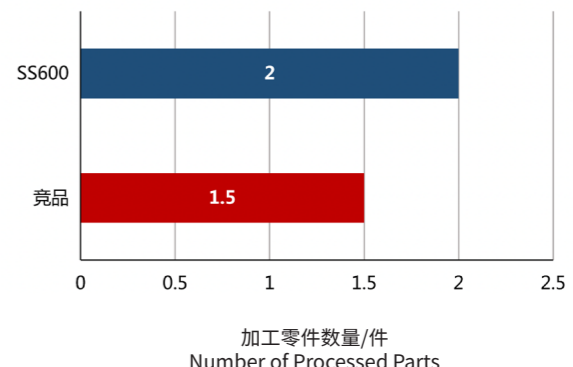
工件材料 Workpiece Material	切削量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	6	8	10	12	16	20	25
M 不锈钢 Stainless Steel	ap≤1.5D	80 (60~110)	转速Speed (min-1)	4245	3185	2545	2020	1590	1275	1019
	ae≤0.25D		进给速度Feed Rate (mm/min)	638	638	638	600	556	535	427
S 钛合金 Titanium Alloy	ap≤1.5D	60 (40~100)	转速Speed (min-1)	3185	2390	1910	1590	1195	955	764
	ae≤0.25D		进给速度Feed Rate (mm/min)	400	418	432	437	387	381	305

## 应用案例

Application

### 机翼铰链板

Wing Hinge Plate

刀具型号 Type	SS600-R4-16015	  <p>加工零件数量/件 Number of Processed Parts</p>
刀具规格 Size	D16*R1.5*32*92*d16	
加工材料 Workpiece Material	15-5PH	
转速 Speed	1300rpm(65m/min)	
进给速度 Feed Rate	130mm/min(0.025mm/z)	
切削方式 Cutting Method	槽铣、侧铣 Slot Milling Side Milling	
切深量 Cutting Depth	ap=7mm, ae=16mm ap=20mm, ae=3mm	
冷却方式 Cooling Method	乳化液、外冷 Emulsion External Cooling	
加工效果 Processing Result	寿命高, 抗崩缺性好 Long service life and strong anti-collapse capability.	

## 应用案例 Application

汽车配件  
Auto Parts

刀具型号 Type	SS600-R4-12005	
加工材料 Workpiece Material	4CrNiMo	
转速 Speed	2600rpm (125m/min)	
进给速度 Feed Rate	1000mm/min(0.096mm/z)	
切削方式 Cutting Method	槽铣 Slot Milling	
切深量 Cutting Depth	ap=4.65mm, ae=12mm	
冷却方式 Cooling Method	乳化液、外冷 Emulsion External Cooling	
加工效果 Processing Result	相比客户现有刀具，寿命相当 Compared with the customer's existing tools, the service life is equivalent.	

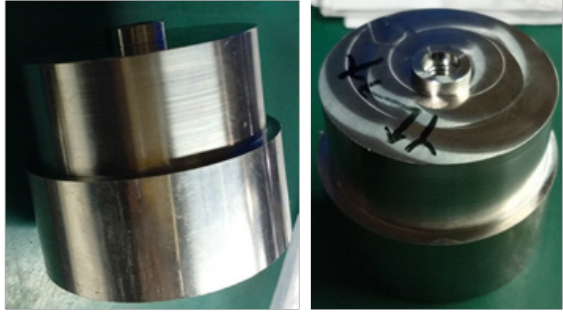
  

SS600	1202
竞品	1200

加工零件数量/件  
Number of Processed Parts

## SS600应用案例 SS600 Case

医疗轴件  
Medical Shaft

刀具型号 Type	SS600-R4-10010	
加工材料 Workpiece Material	17-4PH	
转速 Speed	1800rpm (56m/min)	
进给速度 Feed Rate	160mm/min(0.022mm/z)	
切削方式 Cutting Method	槽铣、侧铣 Slot Milling Side Milling	
切深量 Cutting Depth	ap=22mm, ae=0.1mm ap=8mm, ae=8mm	
冷却方式 Cooling Method	乳化液、外冷 Emulsion External Cooling	
加工效果 Processing Result	精加工表面质量与寿命与美国耐产品相当 The quality and life of the finished surface are equivalent to those of the American resistant products.	

SS600	5.2
竞品	5

加工零件数量/件  
Number of Processed Parts



# B

铣削  
Milling

## US260通用不锈钢加工立铣刀 US260 Endmills for General Machining of Stainless Steel

●适用于不锈钢 (<380HB) 的粗加工、精加工;  
Suitable for roughing and finishing machining of stainless steel (<380HB).

●采用优异的刀具基体和涂层工艺, 提升粗加工抗崩性及精加工耐磨性, 刀具寿命长;  
Using excellent substrate and coating technology, improving anti-collapse of roughing and wear resistance of finishing, and longer tool life.

●适用于高速快速进给加工, 面铣、侧铣、浅槽铣 ( $ap \leq 0.1D$ );  
Suitable for high speed and high feed processing, face milling, side milling and shallow slot milling ( $ap \leq 0.1D$ ).

●推荐油冷、水冷的冷却方式。  
It is recommended to adopt oil cooling and water cooling.

## US260-SS4A

4 刃短刃平头  
4 Short Flutes, Square

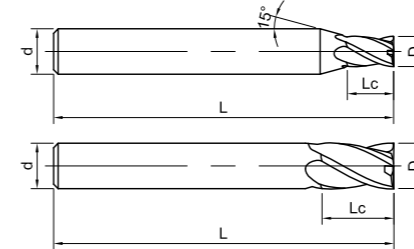


Fig1

Fig2



订货号 Ordering Code	D	Lc	L	d	图号 Figure No.	库存 Stock
US260-SS4A-01002	1	2	50	4	1	●
US260-SS4A-01502	1.5	2.5	50	4	1	●
US260-SS4A-01503	1.5	3	50	4	1	●
US260-SS4A-02004	2	4	50	4	1	●
US260-SS4A-03003	3	3	50	4	1	●
US260-SS4A-03006	3	6	50	4	1	●
US260-SS4A-04006	4	6	50	4	2	●
US260-SS4A-06006	6	6	50	6	2	●
US260-SS4A-06010	6	10	50	6	2	●
US260-SS4A-08015	8	15	60	8	2	●
US260-SS4A-10015	10	15	50	10	2	●
US260-SS4A-12015	12	15	50	12	2	●
US260-SS4A-16024	16	24	100	16	2	●
US260-SS4A-20030	20	30	100	20	2	●

● 标准库存 Stock ○ 需预定 Available upon Order

D	公差 Tolerance
D ≤ 12	0 -0.02
D > 12	0 -0.03

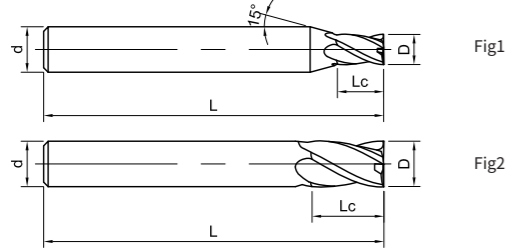
单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
○	○	◎	○	○	○

◎ 最适合 Most Suitable ○ 适合 Suitable

# US260-SS4B

4 刃短刃平头  
4 Short Flutes, Square



订货号 Ordering Code	D	Lc	L	d	图号 Figure No.	库存 Stock
US260-SS4B-01002	1	2	50	4	1	●
US260-SS4B-01503	1.5	3	50	4	1	●
US260-SS4B-02004	2	4	50	4	1	●
US260-SS4B-03003	3	3	50	4	1	●
US260-SS4B-04006	4	6	50	4	2	●
US260-SS4B-05006	5	6	50	6	1	●
US260-SS4B-06006	6	6	50	6	2	●

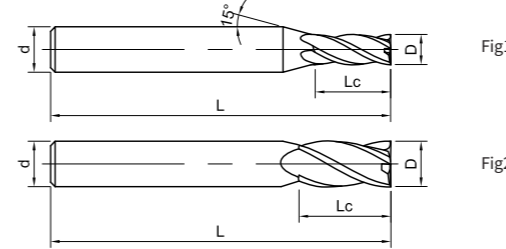
● 标准库存 Stock ○ 需预定 Available upon Order

D	公差 Tolerance
D ≤ 6	0 -0.02

单位unit (mm)

# US260-S4A

4 刃平头  
4 Flutes, Square



订货号 Ordering Code	D	Lc	L	d	图号 Figure No.	库存 Stock
US260-S4A-01003	1	3	50	4	1	●
US260-S4A-01504	1.5	4	50	4	1	●
US260-S4A-01505	1.5	5	50	4	1	●
US260-S4A-01506	1.5	6	50	4	1	●
US260-S4A-02006	2	6	50	4	1	●
US260-S4A-02508	2.5	8	50	4	1	●
US260-S4A-03009	3	9	50	4	1	●
US260-S4A-04011	4	11	50	4	2	●
US260-S4A-05013	5	13	50	6	1	●
US260-S4A-06016	6	16	50	6	2	●
US260-S4A-08020	8	20	60	8	2	●
US260-S4A-10025	10	25	75	10	2	●
US260-S4A-10030	10	30	75	10	2	●
US260-S4A-12030	12	30	75	12	2	●
US260-S4A-16036	16	36	100	16	2	●
US260-S4A-20045	20	45	100	20	2	●

● 标准库存 Stock ○ 需预定 Available upon Order

D	公差 Tolerance
D ≤ 12	0 -0.02
D > 12	0 -0.03

单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
○	○	◎	○	○	○

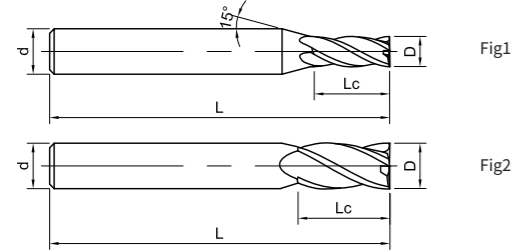
◎ 最适合 Most Suitable ○ 适合 Suitable

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
○	○	◎	○	○	○

◎ 最适合 Most Suitable ○ 适合 Suitable

# US260-S4B

4 刃平头  
4 Flutes, Square



订货号 Ordering Code	D	Lc	L	d	图号 Figure No.	库存 Stock
US260-S4B-01003	1	3	50	4	1	●
US260-S4B-01203	1.2	3	50	4	1	●
US260-S4B-01503	1.5	3.5	50	4	1	●
US260-S4B-01504	1.5	4	50	4	1	●
US260-S4B-02006	2	6	50	4	1	●
US260-S4B-03009	3	9	50	4	1	●
US260-S4B-04011	4	11	50	4	2	●
US260-S4B-06016	6	16	50	6	2	●

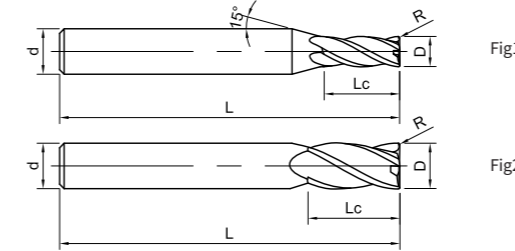
● 标准库存 Stock ○ 需预定 Available upon Order

D	公差 Tolerance
D ≤ 6	0 -0.02

单位unit (mm)

# US260-RS4

4 刃短刃圆角头  
4 Short Flutes, Corner Radius



订货号 Ordering Code	D	Lc	r	L	d	图号 Figure No.	库存 Stock
US260-RS4-01001	1	2	0.1	50	4	1	●
US260-RS4-04001	4	5	0.1	50	4	2	●
US260-RS4-04002	4	5	0.2	50	4	2	●
US260-RS4-05001	5	6	0.1	50	6	1	●
US260-RS4-06001	6	8	0.1	50	6	2	●
US260-RS4-06002	6	8	0.2	50	6	2	●
US260-RS4-06005	6	8	0.5	50	6	2	●
US260-RS4-08002	8	15	0.2	60	8	2	●
US260-RS4-08005	8	15	0.5	60	8	2	●
US260-RS4-10002	10	15	0.2	50	10	2	●
US260-RS4-10005	10	15	0.5	50	10	2	●
US260-RS4-12010	12	15	1	75	12	2	●
US260-RS4-16010	16	24	1	100	16	2	●
US260-RS4-20010	20	30	1	100	20	2	●

● 标准库存 Stock ○ 需预定 Available upon Order

D	公差 Tolerance
D ≤ 12	0 -0.02
D > 12	0 -0.03

单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
○	○	◎	○	○	○

◎ 最适合 Most Suitable ○ 适合 Suitable

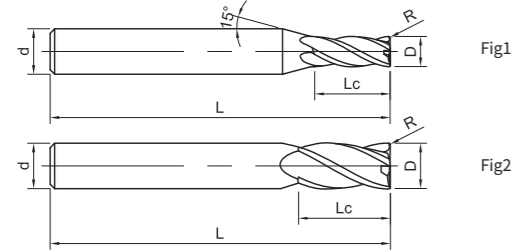
工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
○	○	◎	○	○	○

◎ 最适合 Most Suitable ○ 适合 Suitable



# US260-R4

4 刃圆角头  
4 Flutes, Corner Radius



订货号 Ordering Code	D	Lc	r	L	d	图号 Figure No.	库存 Stock
US260-R4-01501	1.5	5	0.1	50	4	1	●
US260-R4-02001	2	6	0.1	50	4	1	●
US260-R4-02002	2	6	0.2	50	4	1	●
US260-R4-03001	3	9	0.1	50	4	1	●
US260-R4-03002	3	9	0.2	50	4	1	●
US260-R4-03003	3	9	0.3	50	4	1	●
US260-R4-63001	3	9	0.1	50	6	1	●
US260-R4-63002	3	9	0.2	50	6	1	●
US260-R4-63003	3	9	0.3	50	6	1	●
US260-R4-06001	6	16	0.1	50	6	2	●
US260-R4-06002	6	12	0.2	50	6	2	●
US260-R4-06005	6	16	0.5	50	6	2	●

● 标准库存 Stock ○ 需预定 Available upon Order

D	公差 Tolerance
D ≤ 12	0 -0.02
D > 12	0 -0.03

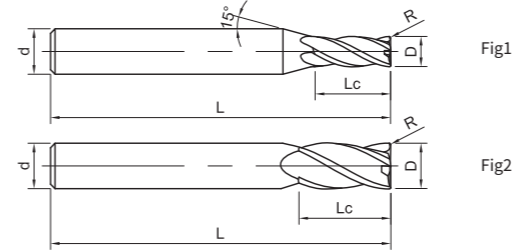
单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
○	○	◎	○	○	○

◎ 最适合 Most Suitable ○ 适合 Suitable

# US260-R4

4 刃圆角头  
4 Flutes, Corner Radius



订货号 Ordering Code	D	Lc	r	L	d	图号 Figure No.	库存 Stock
US260-R4-08005	8	20	0.5	60	8	2	●
US260-R4-08010	8	20	1	60	8	2	●
US260-R4-10005	10	25	0.5	75	10	2	●
US260-R4-10010	10	25	1	75	10	2	●
US260-R4-12005	12	30	0.5	75	12	2	●
US260-R4-12010	12	30	1	75	12	2	●
US260-R4-12030	12	30	3	75	12	2	●
US260-R4-16010	16	36	1	100	16	2	●
US260-R4-16020	16	36	2	100	16	2	●
US260-R4-16030	16	36	3	100	16	2	●
US260-R4-20010	20	45	1	100	20	2	●
US260-R4-20020	20	45	2	100	20	2	●
US260-R4-20030	20	45	3	100	20	2	●

● 标准库存 Stock ○ 需预定 Available upon Order

D	公差 Tolerance
D ≤ 12	0 -0.02
D > 12	0 -0.03

单位unit (mm)

工件材料 Workpiece Material					
P	M	K	S		
1234	5	123	123	123	4
碳钢、合金钢 Carbon Steel, Alloy Steel <35HRC	合金钢 Alloy Steel <48HRC	不锈钢 Stainless Steel	铸铁 Cast Iron	高温合金 HRSA	钛合金 Titanium Alloy
○	○	◎	○	○	○

◎ 最适合 Most Suitable ○ 适合 Suitable

## 推荐切削参数 Recommended Cutting Data

### US260-SS4A/SS4B、S4A/S4B

不锈钢 Stainless Steel——侧铣 Side Milling



工件材料 Workpiece Material		切削量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	1	1.5	2	3	4	6	8	10	12
M	不锈钢 Stainless Steel	$ap \leq 1D$	40 -180	转速Speed (min-1)	13000	11000	10000	9500	9000	8000	6000	5000	4500
		$ae \leq 0.1D$		进给速度Feed Rate (mm/min)	1400	1700	2200	2700	3000	3500	3800	4000	4200

### US260-SS4A/SS4B、S4A/S4B

不锈钢 Stainless Steel——面铣 Face Milling



工件材料 Workpiece Material		切削量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	1	1.5	2	3	4	6	8	10	12
M	不锈钢 Stainless Steel	$ap \leq 0.1D$	40 -180	转速Speed (min-1)	13000	11000	10000	9500	9000	8000	6000	5000	4500
		$ae \leq 1D$		进给速度Feed Rate (mm/min)	1300	1600	2100	2600	2800	3200	3500	3800	4000

### US260-R4/RS4

不锈钢 Stainless Steel——侧铣 Side Milling



工件材料 Workpiece Material		切削量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	1	1.5	2	3	4	6	8	10	12
M	不锈钢 Stainless Steel	$ap \leq 1D$	40 -180	转速Speed (min-1)	13000	11000	10000	9500	9000	8000	6000	5000	4500
		$ae \leq 0.1D$		进给速度Feed Rate (mm/min)	1500	1800	2400	3000	3200	3600	3800	4000	4200

### US260-R4/RS4

不锈钢 Stainless Steel——面铣 Face Milling



工件材料 Workpiece Material		切削量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	1	1.5	2	3	4	6	8	10	12
M	不锈钢 Stainless Steel	$ap \leq 0.1D$	40 -180	转速Speed (min-1)	13000	11000	10000	9500	9000	8000	6000	5000	4500
		$ae \leq 1D$		进给速度Feed Rate (mm/min)	1500	1800	2400	3000	3200	3600	3800	4000	4200

1. 请使用刚性较高的机床和刀柄。

Please attention to use machine and holder with high rigidity.

2. 请根据切削速度、设备刚性等情况可适当调整转速和进给速度。

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

3. 上表是按照刀具悬长为直径4倍以下时所制订的，如果刀具悬长过长，加工时易产生振动，此时，请适当调整转速，进给速度和切深量。


The milling conditions are for an endmill where the tool overhang length is less than 4\*D(mill dia).

When the tool overhang length is longer, please adjust the speed, feed rate and cutting depth.

## US260应用案例 US260 Case

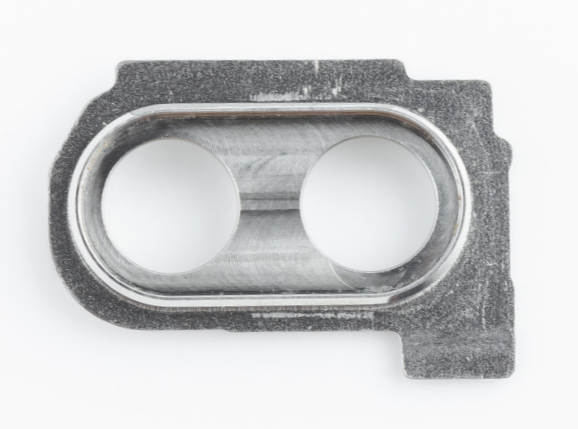
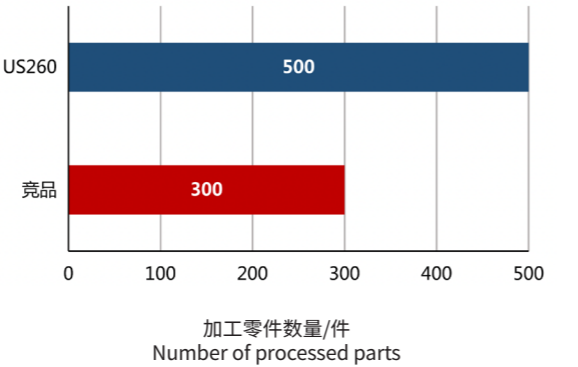
3C小零件

3C Small Parts

刀具型号 Type	US260-RS4-06001	
工件材料 Workpiece Material	316L (260HV)	
加工设备 Processing Equipment	FANUC α-D14MiA (BT30)	
切削方式 Cutting Method	型腔开粗、精修(分层铣) Rough opening and finishing of cavity (layered milling)	
切削速度 Cutting Speed	150.7m/min(8000rpm)	
进给速度 Feed Speed	3500mm/min(0.109mm/z)	
切深量 Cutting Depth	$ap=0.15mm, ae=100\%D$	
冷却方式 Cooling Method	油冷 Oil Cooling	
切削效果 Processing Result	粗精加工使用同一刀号，加工表面无振刀纹，产品边沿无披锋，刀具寿命高于竞品20% The same tool is used for roughing and finishing. The machined surface has no vibrating knife marks, and the product edge has no collapes. The service life of cutting tools is 20% higher than that of competing products.	

## US260应用案例 US260 Case

3C小零件  
3C Small Parts

刀具型号 Type	US260-S4A-06016	 
工件材料 Workpiece Material	SUS316L粉末冶金 (HV220) SUS316L Powder metallurgy (HV220)	
加工设备 Processing Equipment	Brother S500Z1 (BT30-SK10-60)	
切削速度 Cutting Speed	113m/min(6000rpm)	
进给速度 Feed Speed	1000mm/min(0.042mm/z)	
切削方式 Cutting Method	顺铣, 精修Finished milling	
切深量 Cutting Depth	ap=1mm, ae=0.03mm	
冷却方式 Cooling Method	油冷 Oil cooling	
切削效果 Processing Result	加工工件无明显振刀纹、 内侧壁不可踏边 There is no obvious vibration pattern on the processed workpiece, and the inner side wall is neat.	

## US260应用案例 US260 Case

3C小零件  
3C Small Parts

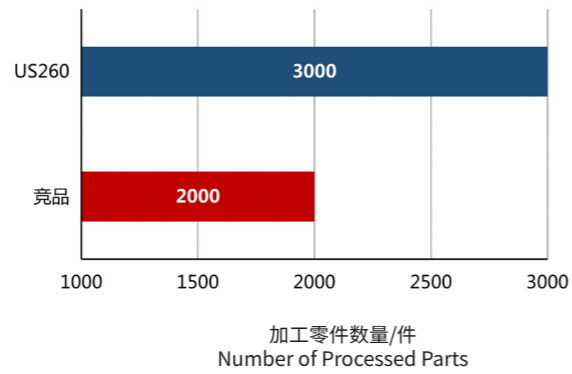
刀具型号 Type	US260-SS4B-03003	 
工件材料 Workpiece Material	SUS316L锻压 (HV320) Forging	
加工设备 Processing Equipment	FANUC	
切削速度 Cutting Speed	131.88m/min(14000rpm)	
进给速度 Feed Speed	3000mm/min(0.054mm/z)	
切削方式 Cutting Method	侧铣四周 Side Milling	
切深量 Cutting Depth	ap=2mm, ae=0.04	
冷却方式 Cooling Method	油冷 Oil Cooling	
切削效果 Processing Result	加工外周、要求无明显横刀线 Processing external surface with no obvious horizontal cutting line.	

## US260应用案例

### US260 Case

3C小零件  
3C Small Parts

刀具型号 Type	US260-R4-06005	
工件材料 Workpiece Material	SUS316L (Hv350)	
加工设备 Processing Equipment	FANUC	
切削速度 Cutting Speed	226m/min(12000rpm)	
进给速度 Feed Speed	2000mm/min(0.042mm/z)	
切深量 Cutting Depth	ap=0.2 mm, ae=4 mm	
冷却方式 Cooling Method	油冷(Oil Cooling)	
切削效果 Processing Result	寿命高, 抗崩缺性好 Long service life and strong anti-collapse capability.	





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Hardware Commercial District Chang'an Town Dongguan  
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Tel: +86-592-7301126

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