





孔加工

1 高速钢钻头

2 整体硬质合金钻头

3 可转位刀片式钻头

4 铰刀和铰钻

5 镗刀

螺纹加工

6 丝锥及挤压丝锥

7 槽铣刀和螺纹铣刀

8 螺纹车刀

车削

9 可转位刀片式车刀

10 多用途刀具 -
EcoCut 及 FreeTurn

11 切槽及切断

12 微径车刀

12

铣削

13 高速钢铣刀

14 整体硬质合金铣刀

15 可转位刀片式铣刀

样本 -
夹持技术

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WNT \ Performance

高性能品质产品线

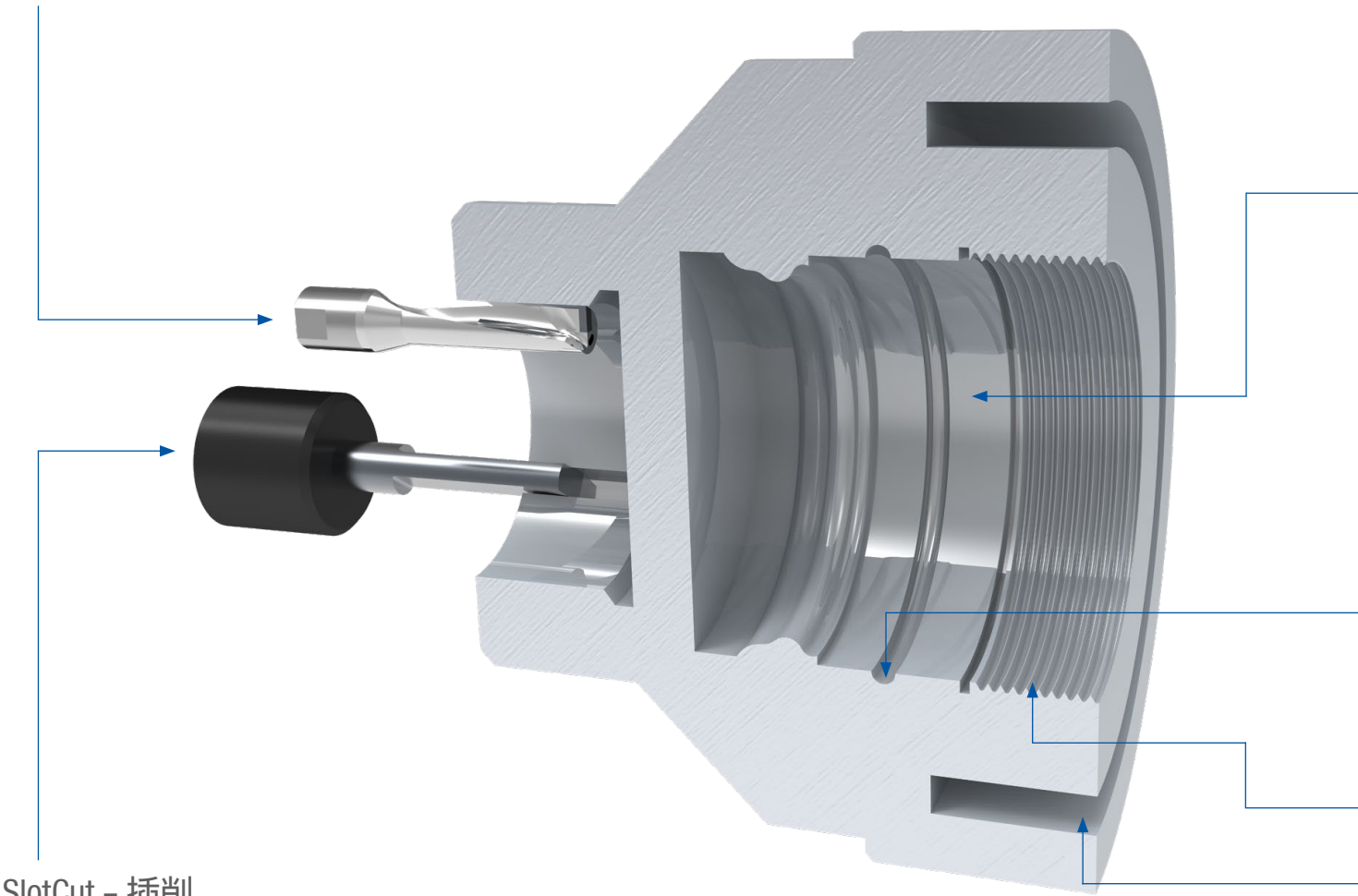
WNT Performance 优质产品线专为特定应用而设计, 以其出色的切削性能和卓越的加工能力表现而著称。如果您正在寻找最佳的刀具解决方案, 以满足您对生产率的高要求, 我们推荐您使用 Performance 高性能品质产品线。

Toolfinder

EcoCut Mini

最小直径 Ø 2 mm

刀片和刀杆参见 → 第 10 章 – 多用途刀具 EcoCut 及 FreeTurn



SlotCut – 插削

刀片 + 刀杆 DIN138 54-57

系统概览

UltraMini



- ▲ 最小直径 $\varnothing 0.5$ mm
- ▲ 灵活的系统
- ▲ 磨削刀片
- ▲ 重复精度高
- ▲ 冷却液供应至切削刃

MiniCut



- ▲ 最小直径 $\varnothing 7.8$ mm
- ▲ 稳定的三定位
- ▲ 操作简便
- ▲ 冷却液供应至切削刃
- ▲ 精确的切削刃位置

SlotCut

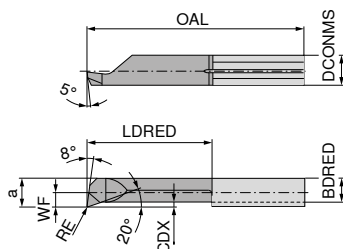
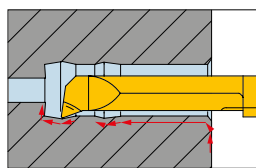


- ▲ 直接在机床上插削
- ▲ 可用最小直径 $\varnothing 6$ mm
- ▲ 机床负荷低
- ▲ 多种公差等级

		UltraMini											MiniCut					
孔直径 (mm) Ø d1			≥ 0,5	≥ 2	≥ 2,4	≥ 2,8	≥ 3	≥ 4	≥ 5	≥ 6	≥ 8	≥ 16		≥ 8	≥ 9	≥ 11	≥ 14	≥ 16
镗孔、仿形车削			4-7	4-7	4-7	4-7		4-7	4-7	4-7				35	35	35	35	35
镗孔、仿形车削 - 硬质材料加工				8		8		8	8	8				36		36	36	36
高进给车削				10			10	10	10	10								
车削和仿形车削 - 超级合金				9		9		9	9	9								
镗孔						11		11	11					37	37	37	37	37
背镗							12	12	12	12				38	38	38	38	
镗孔、倒角									13	13				38	38	38	38	
预切槽、倒角								13	13	13				39	39	39	39	39
切槽				14-16			14-16	14-16	14-16	14-16				40+41	40+41	40+41	40+41	40+41
内径退刀槽加工				17		17		17	17	17				42	42	42	42	42
切槽、仿形车削								18	18	18				43	43	43	43	43
内螺纹车削					19-21			19-21	19-21	19-21				44-47	44-47	44-47	44-47	44-47
轴向切槽									22-27	22-27	22-27	22-27		48+49	48+49	48+49	48+49	48+49
复合切削刃			30-34											50-53				
套件			28+29											49				

UltraMini – 整体硬质合金刀具 – 镗孔/仿形车削

▲ CDX = 车削时最大切深



图示为右手刀具

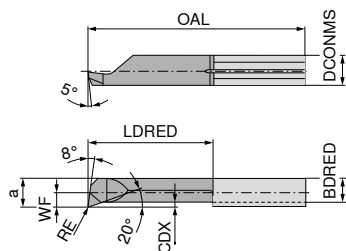
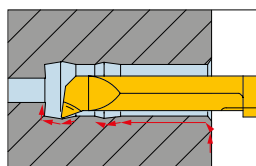


规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BRED mm	RE mm	标准刀杆	左手刀具 73 005 ...		右手刀具 73 004 ...	
R/L 050.05-2	4		0.5	0.4	20	2	0.03	0.32	0.02	645.00...D	500		500	
R/L 050.06-2	4		0.6	0.5	20	2	0.05	0.40	0.04	645.00...D	510		510	
R/L 050.06-3	4		0.6	0.5	20	3	0.05	0.40	0.04	645.00...D	511		511	
R/L 050.08-4	4		0.8	0.7	20	4	0.05	0.60	0.04	645.00...D			812	812
R/L 050.1-8	4		1.0	0.9	22	8	0.10	0.75	0.05	645.00...D			813	813
R/L 050.15-5	4		1.5	1.3	19	5	0.10	1.15	0.05	645.00...D	515		515	
R/L 050.15-10	4		1.5	1.3	24	10	0.10	1.15	0.05	645.00...D	516		516	
R/L 050.15-12	4		1.5	1.3	26	12	0.10	1.15	0.05	645.00...D			818	818
R/L 050.2-5	4		2.0	1.7	19	5	0.10	1.50	0.05	645.00...D	520		520	
R/L 050.2-10	4		2.0	1.7	24	10	0.10	1.50	0.05	645.00...D	521		521	
R/L 050.2-15	4		2.0	1.7	29	15	0.10	1.50	0.05	645.00...D	522		522	
R/L 050.3-10	4	0.6	2.8	2.6	24	10	0.20	2.30	0.10	645.00...D	531		531	
R/L 050.3-16	4	0.6	2.8	2.6	30	16	0.20	2.30	0.10	645.00...D	530		530	
R/L 050.3-20	4	0.6	2.8	2.6	34	20	0.20	2.30	0.10	645.00...D	532		532	
R/L 050.35-10	4	1.1	3.5	3.1	24	10	0.25	2.80	0.10	645.00...D			835	835
R/L 050.35-16	4	1.1	3.5	3.1	30	16	0.25	2.80	0.10	645.00...D			836	836
R/L 050.35-20	4	1.1	3.5	3.1	34	20	0.25	2.80	0.10	645.00...D			837	837
R/L 050.35-24	4	1.1	3.5	3.1	38	24	0.25	2.80	0.10	645.00...D			838	838
R/L 050.4-10	4	1.5	4.0	3.5	24	10	0.30	3.00	0.10	645.00...D	541		541	
R/L 050.4-16	4	1.5	4.0	3.5	30	16	0.30	3.00	0.10	645.00...D	540		540	
R/L 050.4-20	4	1.5	4.0	3.5	34	20	0.30	3.00	0.10	645.00...D	542		542	
R/L 050.4-24	4	1.5	4.0	3.5	38	24	0.30	3.00	0.10	645.00...D	545		545	
R/L 050.4-28	4	1.5	4.0	3.5	42	28	0.30	3.00	0.10	645.00...D	546		546	
R/L 050.5-10	5	1.9	5.0	4.4	25	10	0.50	3.80	0.15	645.00...D	551		551	
R/L 050.5-15	5	1.9	5.0	4.4	30	15	0.50	3.80	0.15	645.00...D	552		552	
R/L 050.5-20	5	1.9	5.0	4.4	35	20	0.50	3.80	0.15	645.00...D	550		550	
R/L 050.5-25	5	1.9	5.0	4.4	40	25	0.50	3.80	0.15	645.00...D	553		553	
R/L 050.5-30	5	1.9	5.0	4.4	45	30	0.50	3.80	0.15	645.00...D	554		554	
R/L 050.5-35	5	1.9	5.0	4.4	50	35	0.50	3.80	0.15	645.00...D	556		556	
R/L 050.5-40	5	1.9	5.0	4.4	55	40	0.50	3.80	0.15	645.00...D			857	857
R/L 050.6-15	6	2.3	6.0	5.3	30	15	0.50	4.50	0.15	676.00...D	561		561	
R/L 050.6-22	6	2.3	6.0	5.3	37	22	0.50	4.50	0.15	676.00...D	560		560	
R/L 050.6-25	6	2.3	6.0	5.3	40	25	0.50	4.50	0.15	676.00...D	562		562	
R/L 050.6-30	6	2.3	6.0	5.3	45	30	0.50	4.50	0.15	676.00...D	563		563	
R/L 050.6-35	6	2.3	6.0	5.3	50	35	0.50	4.50	0.15	676.00...D	564		564	
R/L 050.6-42	6	2.3	6.0	5.3	57	42	0.50	4.50	0.15	676.00...D	565		565	
R/L 050.7-20	7	2.8	6.8	6.3	35	20	0.60	5.50	0.15	676.00...D	572		572	
R/L 050.7-25	7	2.8	6.8	6.3	40	25	0.60	5.50	0.15	676.00...D	573		573	
R/L 050.7-30	7	2.8	6.8	6.3	45	30	0.60	5.50	0.15	676.00...D	574		574	
R/L 050.7-35	7	2.8	7.0	6.3	50	35	0.60	5.50	0.15	676.00...D	575		575	
R/L 050.7-40	7	2.8	7.0	6.3	55	40	0.60	5.50	0.15	676.00...D	576		576	
R/L 050.7-45	7	2.8	7.0	6.3	60	45	0.60	5.50	0.15	676.00...D	577		577	
R/L 050.7-50	7	2.8	7.0	6.3	65	50	0.60	5.50	0.15	676.00...D	578		578	
P											●		●	●
M											●		●	●
K											●		●	●
N											●		●	●
S											○		○	●
H											○		○	●
O											●		●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 镗孔/仿形车削

▲ CDX = 车削时最大切深



图示为右手刀具



左手刀具

右手刀具

73 005 ...

73 004 ...

规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	标准刀杆
R/L 050.2-5	4		2.0	1.7	19	5	0.1	1.5	0.05	645.00...D
R/L 050.2-10	4		2.0	1.7	24	10	0.1	1.5	0.05	645.00...D
R/L 050.2-15	4		2.0	1.7	29	15	0.1	1.5	0.05	645.00...D
R/L 050.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.10	645.00...D
R/L 050.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.10	645.00...D
R/L 050.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.10	645.00...D
R/L 050.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.10	645.00...D
R/L 050.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.10	645.00...D
R/L 050.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.10	645.00...D
R/L 050.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.15	645.00...D
R/L 050.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.15	645.00...D
R/L 050.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.15	645.00...D
R/L 050.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	0.15	645.00...D
R 050.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.05	645.00...D
L 050.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.15	645.00...D
R/L 050.6-15	6	2.3	6.0	5.3	30	15	0.5	4.5	0.15	676.00...D
R/L 050.6-22	6	2.3	6.0	5.3	37	22	0.5	4.5	0.15	676.00...D
R/L 050.6-25	6	2.3	6.0	5.3	40	25	0.5	4.5	0.15	676.00...D
R/L 050.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	0.15	676.00...D
R/L 050.7-20	7	2.8	6.8	6.3	35	20	0.6	5.5	0.15	676.00...D
R/L 050.7-25	7	2.8	6.8	6.3	40	25	0.6	5.5	0.15	676.00...D
R/L 050.7-30	7	2.8	6.8	6.3	45	30	0.6	5.5	0.15	676.00...D

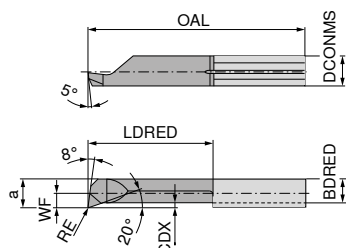
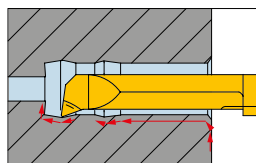
P		
M		
K		
N	○	○
S		
H		
O	●	●

→ v_c 请参见页码 59

UltraMini – 内孔车削和仿形车削刀片

▲ 刀尖半径 ≤ 0.05 mm

▲ CDX = 车削时最大切深



图示为右手刀具

TiAlN

TiAlN

TiAlN

TiAlN



左手刀具

右手刀具

左手刀具

右手刀具

73 021 ...

73 020 ...

73 023 ...

73 022 ...

规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	标准刀杆				
R/L 053.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.03	645.00...D		310		310
R/L 053.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.03	645.00...D		316		316
R/L 053.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.03	645.00...D		320		320
R/L 053.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.03	645.00...D		410		410
R/L 053.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.03	645.00...D		416		416
R/L 053.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.03	645.00...D		420		420
R/L 053.4-24	4	1.5	4.0	3.5	38	24	0.3	3.0	0.03	645.00...D		424		424
R/L 053.4-28	4	1.5	4.0	3.5	42	28	0.3	3.0	0.03	645.00...D		428		428
R/L 055.2-10	4		2.0	1.7	24	10	0.1	1.5	0.05	645.00...D			210	210
R/L 055.2-15	4		2.0	1.7	29	15	0.1	1.5	0.05	645.00...D			215	215
R/L 055.2-5	4		2.0	1.7	19	5	0.1	1.5	0.05	645.00...D			205	205
R/L 055.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.05	645.00...D			310	310
R/L 055.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.05	645.00...D			316	316
R/L 055.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.05	645.00...D			320	320
R/L 055.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.05	645.00...D			410	410
R/L 055.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.05	645.00...D			416	416
R/L 055.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.05	645.00...D			420	420
R/L 055.4-24	4	1.5	4.0	3.5	38	24	0.3	3.0	0.05	645.00...D			424	424
R/L 055.4-28	4	1.5	4.0	3.5	42	28	0.3	3.0	0.05	645.00...D			428	428
R/L 055.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.05	645.00...D			510	510
R/L 055.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.05	645.00...D			515	515
R/L 055.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.05	645.00...D			520	520
R/L 055.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	0.05	645.00...D			525	525
R/L 055.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.05	645.00...D			530	530
R/L 055.5-35	5	1.9	5.0	4.4	50	35	0.5	3.8	0.05	645.00...D			535	535
R/L 055.6-15	6	2.3	6.0	5.3	30	15	0.5	4.5	0.05	676.00...D			615	615
R/L 055.6-22	6	2.3	6.0	5.3	37	22	0.5	4.5	0.05	676.00...D			622	622
R/L 055.6-25	6	2.3	6.0	5.3	40	25	0.5	4.5	0.05	676.00...D			625	625
R/L 055.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	0.05	676.00...D			630	630
R/L 055.6-35	6	2.3	6.0	5.3	50	35	0.5	4.5	0.05	676.00...D			635	635
R/L 055.6-42	6	2.3	6.0	5.3	57	42	0.5	4.5	0.05	676.00...D			642	642

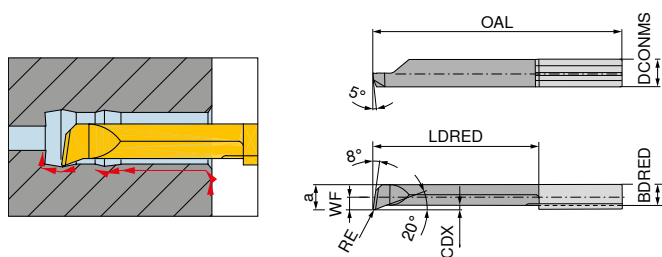
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M	●	●	●	●
K	●	●	●	●
N	●	●	●	●
S	●	●	●	●
H	●	●	●	●
O	●	●	●	●

→ v_c 请参见页码 59

UltraMini - 整体硬质合金刀具 - 镗孔/仿形车削

▲ 带断屑槽

▲ CDX = 车削时最大切深



图示为右手刀具



左手刀具

右手刀具

73 017 ...

73 016 ...

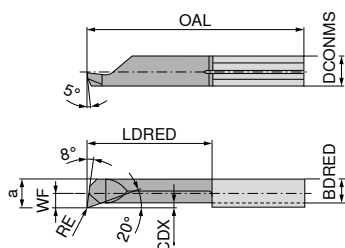
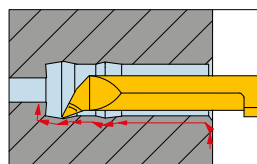
规格型号	DCONMS _{hg} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	标准刀杆		
R/L 050.4-10C	4	1.5	4	3.5	24	10	0.3	3.0	0.2	645.00...-D	410	410
R/L 050.4-16C	4	1.5	4	3.5	30	16	0.3	3.0	0.2	645.00...-D	416	416
R/L 050.4-20C	4	1.5	4	3.5	34	20	0.3	3.0	0.2	645.00...-D	420	420
R/L 050.4-24C	4	1.5	4	3.5	38	24	0.3	3.0	0.2	645.00...-D	424	424
R/L 050.4-28C	4	1.5	4	3.5	42	28	0.3	3.0	0.2	645.00...-D	428	428
R/L 050.5-10C	5	1.9	5	4.4	25	10	0.5	3.8	0.2	645.00...-D	510	510
R/L 050.5-15C	5	1.9	5	4.4	30	15	0.5	3.8	0.2	645.00...-D	515	515
R/L 050.5-20C	5	1.9	5	4.4	35	20	0.5	3.8	0.2	645.00...-D	520	520
R/L 050.5-25C	5	1.9	5	4.4	40	25	0.5	3.8	0.2	645.00...-D	525	525
R/L 050.5-30C	5	1.9	5	4.4	45	30	0.5	3.8	0.2	645.00...-D	530	530
R/L 050.5-35C	5	1.9	5	4.4	50	35	0.5	3.8	0.2	645.00...-D	535	535
R/L 050.6-15C	6	2.3	6	5.3	30	15	0.5	4.5	0.2	676.00...-D	615	615
R/L 050.6-22C	6	2.3	6	5.3	37	22	0.5	4.5	0.2	676.00...-D	622	622
R/L 050.6-25C	6	2.3	6	5.3	40	25	0.5	4.5	0.2	676.00...-D	625	625
R/L 050.6-30C	6	2.3	6	5.3	45	30	0.5	4.5	0.2	676.00...-D	630	630
R/L 050.6-35C	6	2.3	6	5.3	50	35	0.5	4.5	0.2	676.00...-D	635	635
R/L 050.6-42C	6	2.3	6	5.3	57	42	0.5	4.5	0.2	676.00...-D	642	642
R/L 050.7-20C	7	2.8	7	6.3	35	20	0.6	5.5	0.2	676.00...-D	720	720
R/L 050.7-25C	7	2.8	7	6.3	40	25	0.6	5.5	0.2	676.00...-D	725	725
R/L 050.7-30C	7	2.8	7	6.3	45	30	0.6	5.5	0.2	676.00...-D	730	730
R/L 050.7-35C	7	2.8	7	6.3	50	35	0.6	5.5	0.2	676.00...-D	735	735
R/L 050.7-40C	7	2.8	7	6.3	55	40	0.6	5.5	0.2	676.00...-D	740	740
R/L 050.7-45C	7	2.8	7	6.3	60	45	0.6	5.5	0.2	676.00...-D	745	745
R/L 050.7-50C	7	2.8	7	6.3	65	50	0.6	5.5	0.2	676.00...-D	750	750
P											●	●
M											●	●
K											●	●
N											●	●
S											●	●
H											●	●
O											●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 镗孔/仿形车削（硬质材料加工）

▲ 46 至 65 HRC

▲ CDX = 车削时最大切深



图示为右手刀具



左手刀具

右手刀具

73 025 ...

73 024 ...

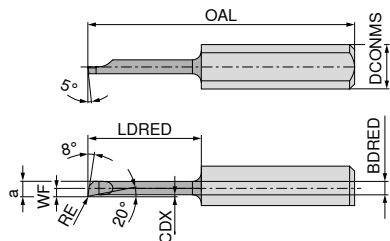
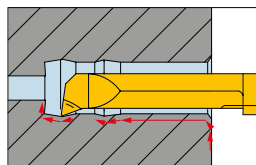
规格型号	DCONMS _{HS} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	标准刀杆		
R/L 050.2-5	4		2.0	1.7	19	5	0.1	1.5	0.05	645.00...D	920	920
R/L 050.2-10	4		2.0	1.7	24	10	0.1	1.5	0.05	645.00...D	921	921
R/L 050.2-15	4		2.0	1.7	29	15	0.1	1.5	0.05	645.00...D	922	922
R/L 050.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.10	645.00...D	931	931
R/L 050.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.10	645.00...D	930	930
R/L 050.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.10	645.00...D	932	932
R/L 050.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.10	645.00...D	941	941
R/L 050.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.10	645.00...D	940	940
R/L 050.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.10	645.00...D	942	942
R/L 050.4-24	4	1.5	4.0	3.5	38	24	0.3	3.0	0.10	645.00...D	945	945
R/L 050.4-28	4	1.5	4.0	3.5	42	28	0.3	3.0	0.10	645.00...D	946	946
R/L 050.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.15	645.00...D	951	951
R/L 050.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.15	645.00...D	952	952
R/L 050.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.15	645.00...D	950	950
R/L 050.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	0.15	645.00...D	953	953
R/L 050.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.15	645.00...D	954	954
R/L 050.5-35	5	1.9	5.0	4.4	50	35	0.5	3.8	0.15	645.00...D	956	956
R/L 050.6-15	6	2.3	6.0	5.3	30	15	0.5	4.5	0.15	676.00...D	961	961
R/L 050.6-22	6	2.3	6.0	5.3	37	22	0.5	4.5	0.15	676.00...D	960	960
R/L 050.6-25	6	2.3	6.0	5.3	40	25	0.5	4.5	0.15	676.00...D	962	962
R/L 050.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	0.15	676.00...D	963	963
R/L 050.6-35	6	2.3	6.0	5.3	50	35	0.5	4.5	0.15	676.00...D	964	964
R/L 050.6-42	6	2.3	6.0	5.3	57	42	0.5	4.5	0.15	676.00...D	965	965
R/L 050.7-20	7	2.8	6.8	6.3	35	20	0.6	5.5	0.15	676.00...D	972	972
R/L 050.7-25	7	2.8	6.8	6.3	40	25	0.6	5.5	0.15	676.00...D	973	973
R/L 050.7-30	7	2.8	6.8	6.3	45	30	0.6	5.5	0.15	676.00...D	974	974
R/L 050.7-35	7	2.8	6.8	6.3	50	35	0.6	5.5	0.15	676.00...D	975	975
R/L 050.7-40	7	2.8	6.8	6.3	55	40	0.6	5.5	0.15	676.00...D	976	976
R/L 050.7-45	7	2.8	6.8	6.3	60	45	0.6	5.5	0.15	676.00...D	977	977
R/L 050.7-50	7	2.8	6.8	6.3	65	50	0.6	5.5	0.15	676.00...D	978	978
P											○	○
M											○	○
K											○	○
N											○	○
S											○	○
H											●	●
O											○	○

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 镗孔/仿形车削

▲ 专为超级合金设计

▲ CDX = 车削时最大切深



图示为右手刀具

规格型号	DCONMS _{HS} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	标准刀杆
R/L M050.05-2	4	0.20	0.5	0.40	20	2	0.02	0.02	0.02	645.00...D
R/L M050.08-4	4	0.35	0.8	0.70	20	4	0.08	0.03	0.02	645.00...D
R/L M050.1-5	4	0.40	1.0	0.90	20	5	0.05	0.05	0.02	645.00...D
R/L M050.1-7	4	0.40	1.0	0.90	22	7	0.05	0.05	0.02	645.00...D
R/L M050.15-5	4	0.60	1.5	1.15	19	5	0.08	0.08	0.02	645.00...D
R/L M050.15-10	4	0.60	1.5	1.15	24	10	0.08	0.08	0.02	645.00...D
R/L M050.2-5	4	0.80	2.0	1.70	19	5	0.08	0.08	0.02	645.00...D
R/L M050.2-10	4	0.80	2.0	1.70	24	10	0.08	0.08	0.02	645.00...D
R/L M050.25-5	4	0.20	2.5	2.20	19	5	0.10	0.10	0.02	645.00...D
R/L M050.25-10	4	0.20	2.5	2.20	24	10	0.10	0.10	0.02	645.00...D
R/L M050.3-10	4	0.60	3.0	2.60	24	10	0.15	0.15	0.02	645.00...D
R/L M050.3-16	4	0.60	3.0	2.60	30	16	0.15	0.15	0.02	645.00...D
R/L M050.35-10	4	1.10	3.5	3.10	24	10	0.17	0.17	0.02	645.00...D
R/L M050.35-16	4	1.10	3.5	3.10	30	16	0.17	0.17	0.02	645.00...D
R/L M050.35-20	4	1.10	3.5	3.10	34	20	0.17	0.17	0.02	645.00...D
R/L M050.4-10	4	1.50	4.0	3.50	24	10	0.20	0.20	0.02	645.00...D
R/L M050.4-16	4	1.50	4.0	3.50	30	16	0.20	0.20	0.02	645.00...D
R/L M050.4-20	4	1.50	4.0	3.50	34	20	0.20	0.20	0.02	645.00...D
R/L M050.4-24	4	1.50	4.0	3.50	38	24	0.20	0.20	0.02	645.00...D

P	●	●
M	●	●
K	○	○
N	○	○
S	○	○
H	○	○
O	○	○



左手刀具

右手刀具

73 027 ...

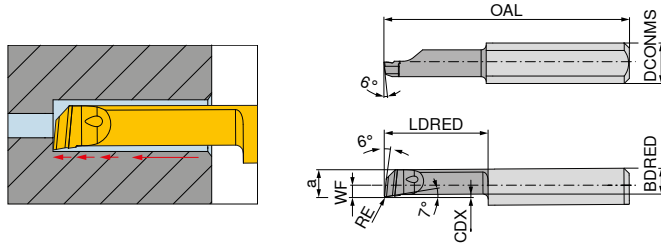
73 026 ...

052	052
082	082
102	102
103	103
151	151
154	154
201	201
204	204
251	251
254	254
304	304
307	307
350	350
353	353
354	354
400	400
403	403
404	404
406	406

→ v_c 请参见页码 59

UltraMini - 整体硬质合金刀具 - 镗孔

- ▲ 带断屑槽
- ▲ 高进给内孔车削
- ▲ CDX = 车削时最大切深



图示为右手刀具

规格型号	DCONMS _{h6}	WF	DMIN	a	OAL	LDRED	CDX	BDRED	RE	标准刀杆
	mm	mm	mm	mm	mm	mm	mm	mm	mm	
R/L X050.1-5	4		1.0	0.90	20	5	0.03	0.85	0.05	645.00...D
R/L X050.15-7	4		1.5	1.35	22	7	0.05	1.25	0.10	645.00...D
R/L X050.2-5	4		2.0	1.80	19	5	0.10	1.60	0.15	645.00...D
R/L X050.2-10	4		2.0	1.80	24	10	0.10	1.60	0.05	645.00...D
R/L X050.2-10	4		2.0	1.80	24	10	0.10	1.60	0.15	645.00...D
R/L X050.3-10	4	0.7	3.0	2.70	24	10	0.15	2.55	0.05	645.00...D
R/L X050.3-10	4	0.7	3.0	2.70	24	10	0.15	2.55	0.20	645.00...D
R/L X050.3-16	4	0.7	3.0	2.70	30	16	0.15	2.55	0.05	645.00...D
R/L X050.3-16	4	0.7	3.0	2.70	30	16	0.15	2.55	0.10	645.00...D
R/L X050.3-16	4	0.7	3.0	2.70	30	16	0.15	2.55	0.20	645.00...D
R/L X050.4-10	4	1.6	4.0	3.60	24	10	0.20	3.20	0.10	645.00...D
R/L X050.4-10	4	1.6	4.0	3.60	24	10	0.20	3.20	0.20	645.00...D
R/L X050.4-16	4	1.6	4.0	3.60	30	16	0.20	3.20	0.05	645.00...D
R/L X050.4-16	4	1.6	4.0	3.60	30	16	0.20	3.20	0.10	645.00...D
R/L X050.4-16	4	1.6	4.0	3.60	30	16	0.20	3.20	0.20	645.00...D
R/L X050.4-24	4	1.6	4.0	3.60	38	24	0.20	3.20	0.10	645.00...D
R/L X050.4-24	4	1.6	4.0	3.60	38	24	0.20	3.20	0.20	645.00...D
R/L X050.5-15	5	2.1	5.0	4.60	30	15	0.30	4.05	0.05	645.00...D
R/L X050.5-15	5	2.1	5.0	4.60	30	15	0.30	4.05	0.10	645.00...D
R/L X050.5-15	5	2.1	5.0	4.60	30	15	0.30	4.05	0.20	645.00...D
R/L X050.5-25	5	2.1	5.0	4.60	40	25	0.30	4.05	0.10	645.00...D
R/L X050.5-25	5	2.1	5.0	4.60	40	25	0.30	4.05	0.20	645.00...D
R/L X050.5-30	5	2.1	5.0	4.60	45	30	0.30	4.05	0.10	645.00...D
R/L X050.5-30	5	2.1	5.0	4.60	45	30	0.30	4.05	0.20	645.00...D
R/L X050.6-15	6	2.5	6.0	5.50	30	15	0.40	4.90	0.05	676.00...D
R/L X050.6-15	6	2.5	6.0	5.50	30	15	0.40	4.90	0.10	676.00...D
R/L X050.6-15	6	2.5	6.0	5.50	30	15	0.40	4.90	0.20	676.00...D
R/L X050.6-22	6	2.5	6.0	5.50	37	22	0.40	4.90	0.20	676.00...D
R/L X050.6-30	6	2.5	6.0	5.50	45	30	0.40	4.90	0.20	676.00...D
R/L X050.6-35	6	2.5	6.0	5.50	50	35	0.40	4.90	0.20	676.00...D
R/L X050.6-50	6	2.5	6.0	5.50	65	50	0.40	4.90	0.20	676.00...D
R/L X050.7-25	7	3.0	7.0	6.50	40	25	0.50	5.90	0.20	676.00...D
R/L X050.7-30	7	3.0	7.0	6.50	45	30	0.50	5.90	0.20	676.00...D

P	●	●
M	●	●
K	●	●
N	○	○
S	○	○
H	○	○
O	○	○



左手刀具

右手刀具

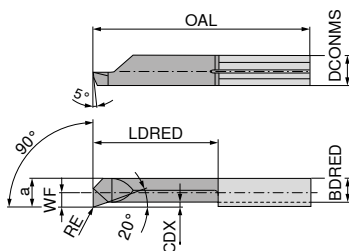
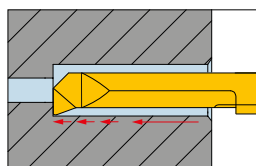
73 001 ...

73 000 ...

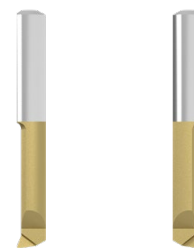
→ v_c 请参见页码 60+61

UltraMini – 整体硬质合金刀具 – 镗孔

▲ CDX = 车削时最大切深



图示为右手刀具



左手刀具

右手刀具

73 015 ...

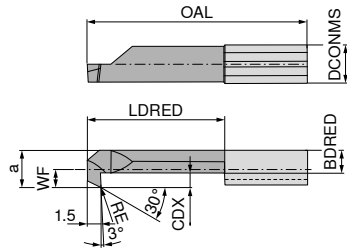
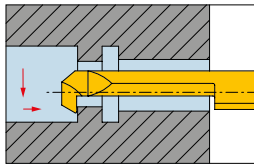
73 014 ...

规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	标准刀杆		
R/L 090.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.2	645.00...D	541	541
R/L 090.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.2	645.00...D	542	542
R/L 090.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.2	645.00...D	545	545
R/L 090.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.2	645.00...D	546	546
R/L 090.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.2	645.00...D	550	550
R/L 090.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.2	645.00...D	551	551
R/L 090.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.2	645.00...D	552	552
P											●	●
M											●	●
K											●	●
N											●	●
S											○	○
H											○	○
O											●	●

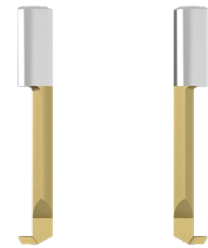
→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 背镗

▲ CDX = 车削时最大切深



图示为右手刀具



左手刀具

右手刀具

73 013 ...

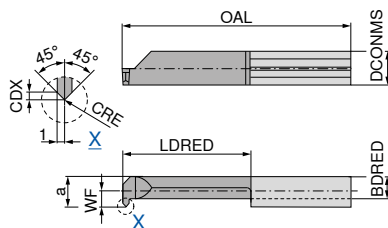
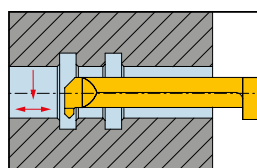
73 012 ...

规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	标准刀杆		
R/L 080.0003-15	4	0.6	3	2.6	29	15	0.5	2.0	0.10	645.00..-D	542	542
R/L 080.0003-20	4	0.6	3	2.6	34	20	0.5	2.0	0.10	645.00..-D	544	544
R/L 080.0004-15	4	1.5	4	3.5	29	15	0.8	2.4	0.15	645.00..-D	546	546
R/L 080.0004-25	4	1.5	4	3.5	39	25	0.8	2.4	0.15	645.00..-D	548	548
R/L 080.0005-20	5	1.9	5	4.4	35	20	1.0	3.3	0.20	645.00..-D	554	554
R/L 080.0005-30	5	1.9	5	4.4	45	30	1.0	3.3	0.20	645.00..-D	558	558
R/L 080.0006-20	6	2.3	6	5.3	35	20	1.8	3.4	0.20	676.00..-D	564	564
R/L 080.0006-30	6	2.3	6	5.3	45	30	1.8	3.4	0.20	676.00..-D	568	568
R/L 080.0007-20	7	2.7	7	6.3	35	20	2.5	3.8	0.20	676.00..-D	574	574
R/L 080.0007-30	7	2.7	7	6.3	45	30	2.5	3.8	0.20	676.00..-D	578	578
P											●	●
M											●	●
K											●	●
N											●	●
S											○	○
H											○	○
O											●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 镗孔/倒棱

▲ CDX = 车削时最大切深



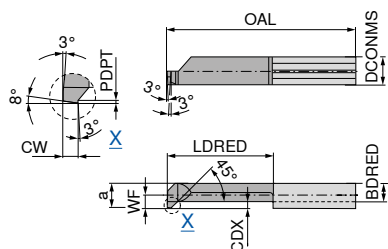
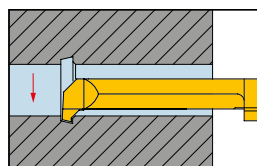
图示为右手刀具

规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CRE mm	标准刀杆	左手刀具 73 007 ...	右手刀具 73 006 ...
R/L 060.5-15	5	1.9	5.0	4.4	30	15	0.7	3.3	0.2	645.00...-D	551	551
R/L 060.5-20	5	1.9	5.0	4.4	35	20	0.7	3.3	0.2	645.00...-D	550	550
R/L 060.7-20	7	2.7	6.8	6.3	35	20	0.7	3.8	0.2	676.00...-D	570	570
P											●	●
M											●	●
K											●	●
N											●	●
S											○	○
H											○	○
O											●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 预切槽/倒棱

▲ CDX = 车削时最大切深



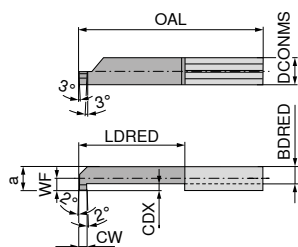
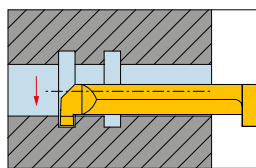
图示为右手刀具

规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	PDPT mm	标准刀杆	左手刀具 73 009 ...	右手刀具 73 008 ...
R/L 070.4-10	4	1.5	4	3.5	25	10	0.8	2.4	1	0.2	645.00...-D	410	410
R/L 070.4-16	4	1.5	4	3.5	30	16	0.8	2.4	1	0.2	645.00...-D	416	416
R/L 070.5-15	5	1.9	5	4.4	30	15	1.0	3.3	1	0.2	645.00...-D	551	551
R/L 070.5-20	5	1.9	5	4.4	35	20	1.0	3.3	1	0.2	645.00...-D	550	550
R/L 070.5-30	5	1.9	5	4.4	45	30	1.0	3.3	1	0.2	645.00...-D	530	530
R/L 070.6-30	6	2.3	6	5.3	45	30	1.0	4.2	1	0.2	676.00...-D	630	630
R/L 070.6-42	6	2.3	6	5.3	57	42	1.0	4.2	1	0.2	676.00...-D	642	642
P												●	●
M												●	●
K												●	●
N												●	●
S												○	○
H												○	○
O												●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 切槽

▲ CDX = 车削时最大切深



图示为右手刀具



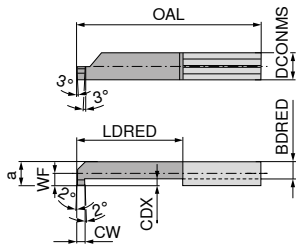
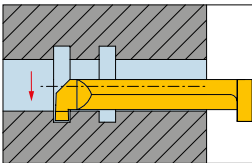
规格型号	DCONMS _{h6}	WF	DMIN	a	OAL	LDRED	CDX	BDRED	CW	标准刀杆	左手刀具		右手刀具		左手刀具		右手刀具	
											73 003 ...	73 002 ...	73 003 ...	73 002 ...	73 003 ...	73 002 ...	73 003 ...	73 002 ...
R/L 004.0100-10	4	1.5	4.0	3.5	24	10	0.8	2.4	1.0	645.00..D	040	040	540	540	540	540	540	540
R/L 004.0100-16	4	1.5	4.0	3.5	30	16	0.8	2.4	1.0	645.00..D	041	041	541	541	541	541	541	541
R/L 004.0100-20	4	1.5	4.0	3.5	34	20	0.8	2.4	1.0	645.00..D	042	042	542	542	542	542	542	542
R/L 005.0100-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.0	645.00..D	150	150	650	650	650	650	650	650
R/L 005.0150-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.5	645.00..D	154	154	654	654	654	654	654	654
R/L 005.0200-10	5	1.9	5.0	4.4	25	10	1.0	3.3	2.0	645.00..D	158	158	658	658	658	658	658	658
R/L 005.0100-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.0	645.00..D	151	151	651	651	651	651	651	651
R/L 005.0150-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.5	645.00..D	155	155	655	655	655	655	655	655
R/L 005.0200-15	5	1.9	5.0	4.4	30	15	1.0	3.3	2.0	645.00..D	159	159	659	659	659	659	659	659
R/L 005.0100-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.0	645.00..D	051	051	551	551	551	551	551	551
R/L 005.0150-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.5	645.00..D	052	052	552	552	552	552	552	552
R/L 005.0200-20	5	1.9	5.0	4.4	35	20	1.0	3.3	2.0	645.00..D	053	053	553	553	553	553	553	553
R/L 005.0100-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.0	645.00..D	152	152	652	652	652	652	652	652
R/L 005.0150-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.5	645.00..D	156	156	656	656	656	656	656	656
R/L 005.0200-25	5	1.9	5.0	4.4	40	25	1.0	3.3	2.0	645.00..D	250	250	750	750	750	750	750	750
R/L 005.0100-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.0	645.00..D	153	153	653	653	653	653	653	653
R/L 005.0150-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.5	645.00..D	157	157	657	657	657	657	657	657
R/L 005.0200-30	5	1.9	5.0	4.4	45	30	1.0	3.3	2.0	645.00..D	251	251	751	751	751	751	751	751
R/L 005.0100-35	5	1.9	5.0	4.4	50	35	1.0	3.3	1.0	645.00..D			680	680	680	680	680	680
R/L 006.0100-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.0	676.00..D	160	160	660	660	660	660	660	660
R/L 006.0150-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.5	676.00..D	164	164	664	664	664	664	664	664
R/L 006.0200-10	6	2.3	6.0	5.3	25	10	1.8	3.4	2.0	676.00..D	168	168	668	668	668	668	668	668
R/L 006.0100-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.0	676.00..D	161	161	661	661	661	661	661	661
R/L 006.0150-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.5	676.00..D	165	165	665	665	665	665	665	665
R/L 006.0200-15	6	2.3	6.0	5.3	30	15	1.8	3.4	2.0	676.00..D	169	169	669	669	669	669	669	669
R/L 006.0100-22	6	2.3	6.0	5.3	37	22	1.8	3.4	1.0	676.00..D	061	061	561	561	561	561	561	561
R/L 006.0150-22	6	2.3	6.0	5.3	37	22	1.8	3.4	1.5	676.00..D	062	062	562	562	562	562	562	562
R/L 006.0200-22	6	2.3	6.0	5.3	37	22	1.8	3.4	2.0	676.00..D	063	063	563	563	563	563	563	563
R/L 006.0100-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.0	676.00..D	162	162	662	662	662	662	662	662
R/L 006.0150-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.5	676.00..D	166	166	666	666	666	666	666	666
R/L 006.0200-25	6	2.3	6.0	5.3	40	25	1.8	3.4	2.0	676.00..D	260	260	760	760	760	760	760	760
R/L 006.0100-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.0	676.00..D	163	163	663	663	663	663	663	663
R/L 006.0150-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.5	676.00..D	167	167	667	667	667	667	667	667
R/L 006.0200-30	6	2.3	6.0	5.3	45	30	1.8	3.4	2.0	676.00..D	261	261	761	761	761	761	761	761
R/L 006.0100-35	6	2.3	6.0	5.3	50	35	1.8	3.4	1.0	676.00..D			682	682	682	682	682	682
R/L 006.0150-35	6	2.3	6.0	5.3	50	35	1.8	3.4	1.5	676.00..D			684	684	684	684	684	684
R/L 006.0100-42	6	2.3	6.0	5.3	57	42	1.8	3.4	1.0	676.00..D			685	685	685	685	685	685
R/L 007.0100-10	7	2.7	6.8	6.3	25	10	2.5	3.8	1.0	676.00..D	070	070	570	570	570	570	570	570
R/L 007.0150-10	7	2.7	6.8	6.3	25	10	2.5	3.8	1.5	676.00..D	075	075	575	575	575	575	575	575
R/L 007.0200-10	7	2.7	6.8	6.3	25	10	2.5	3.8	2.0	676.00..D	170	170	670	670	670	670	670	670
R/L 007.0100-15	7	2.7	6.8	6.3	30	15	2.5	3.8	1.0	676.00..D	071	071	571	571	571	571	571	571
R/L 007.0150-15	7	2.7	6.8	6.3	30	15	2.5	3.8	1.5	676.00..D	076	076	576	576	576	576	576	576
R/L 007.0200-15	7	2.7	6.8	6.3	30	15	2.5	3.8	2.0	676.00..D	171	171	671	671	671	671	671	671
R/L 007.0100-22	7	2.7	6.8	6.3	37	22	2.5	3.8	1.0	676.00..D	072	072	572	572	572	572	572	572
R/L 007.0150-22	7	2.7	6.8	6.3	37	22	2.5	3.8	1.5	676.00..D	077	077	577	577	577	577	577	577
R/L 007.0200-22	7	2.7	6.8	6.3	37	22	2.5	3.8	2.0	676.00..D	172	172	672	672	672	672	672	672
R/L 007.0100-25	7	2.7	6.8	6.3	40	25	2.5	3.8	1.0	676.00..D	073	073	573	573	573	573	573	573
R/L 007.0150-25	7	2.7	6.8	6.3	40	25	2.5	3.8	1.5	676.00..D	078	078	578	578	578	578	578	578
R/L 007.0200-25	7	2.7	6.8	6.3	40	25	2.5	3.8	2.0	676.00..D	173	173	673	673	673	673	673	673
R/L 007.0100-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.0	676.00..D	074	074	574	574	574	574	574	574
R/L 007.0150-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.5	676.00..D	079	079	579	579	579	579	579	579
R/L 007.0200-30	7	2.7	6.8	6.3	45	30	2.5	3.8	2.0	676.00..D	174	174	674	674	674	674	674	674
R/L 007.0100-35	7	2.7	7.0	6.3	50	35	2.5	3.8	1.0	676.00..D			688	688	688	688	688	688
R/L 007.0150-35	7	2.7	7.0	6.3	50	35	2.5	3.8	1.5	676.00..D			690	690	690	690	690	690
R/L 007.0200-35	7	2.7	7.0	6.3	50	35	2.5	3.8	2.0	676.00..D			692	692	692	692	692	692
R/L 007.0100-40	7	2.7	7.0	6.3	55	40	2.5	3.8	1.0	676.00..D			700	700	700	700	700	700
R/L 007.0150-40	7	2.7	7.0	6.3	55	40	2.5	3.8	1.5	676.00..D			702	702	702	702	702	702
R/L 007.0100-45	7	2.7	7.0	6.3	60	45	2.5	3.8	1.0	676.00..D			712	712	712	712	712	712
R/L 007.0100-50	7	2.7	7.0	6.3	65	50	2.5	3.8	1.0	676.00..D			714	714	714	714	714	714

P	●	●
M	●	●
K	●	●
N	○	○
S	○	○
H	○	○
O	●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 切槽

▲ CDX = 车削时最大切深



图示为右手刀具

TiAlN

TiAlN



左手刀具

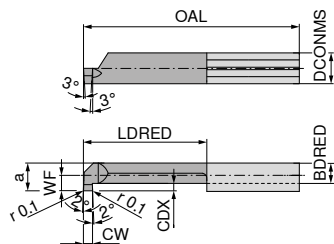
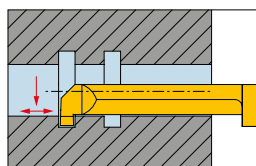
右手刀具

规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	标准刀杆	左手刀具 73 003 ...	右手刀具 73 002 ...
R/L 002.0050-5	4		2	1.8	19	5	0.4	1.2	0.5	645.00..-D	820	820
R/L 002.0050-10	4		2	1.8	24	10	0.4	1.2	0.5	645.00..-D	821	821
R/L 002.0050-15	4		2	1.8	29	15	0.4	1.2	0.5	645.00..-D	822	822
R/L 003.0070-5	4	0.7	3	2.7	19	5	0.6	1.9	0.7	645.00..-D	830	830
R/L 003.0070-10	4	0.7	3	2.7	24	10	0.6	1.9	0.7	645.00..-D	831	831
R/L 003.0070-16	4	0.7	3	2.7	30	16	0.6	1.9	0.7	645.00..-D	832	832
P											●	●
M											●	●
K											●	●
N											●	●
S											●	●
H											●	●
O											●	●

→ v_c 请参见页码 59

UltraMini – 内孔切槽/车削刀片

▲ CDX = 车削时最大切深



图示为右手刀

TiAlN

TiAlN



左手刀具

右手刀具

73 203 ...

73 202 ...

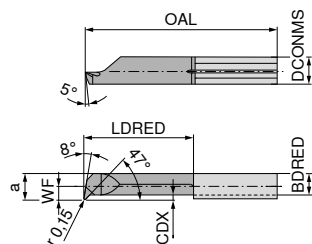
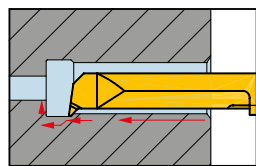
规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	标准刀杆		
R/L 004M0100-10	4	1.5	4.0	3.5	24	10	0.8	2.4	1.0	645.00..-D	800	800
R/L 004M0100-16	4	1.5	4.0	3.5	30	16	0.8	2.4	1.0	645.00..-D	802	802
R/L 004M0100-20	4	1.5	4.0	3.5	34	20	0.8	2.4	1.0	645.00..-D	804	804
R/L 005M0100-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.0	645.00..-D	806	806
R/L 005M0150-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.5	645.00..-D	816	816
R/L 005M0200-10	5	1.9	5.0	4.4	25	10	1.0	3.3	2.0	645.00..-D	826	826
R/L 005M0100-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.0	645.00..-D	808	808
R/L 005M0150-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.5	645.00..-D	818	818
R/L 005M0200-15	5	1.9	5.0	4.4	30	15	1.0	3.3	2.0	645.00..-D	828	828
R/L 005M0100-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.0	645.00..-D	810	810
R/L 005M0150-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.5	645.00..-D	820	820
R/L 005M0200-20	5	1.9	5.0	4.4	35	20	1.0	3.3	2.0	645.00..-D	830	830
R/L 005M0100-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.0	645.00..-D	812	812
R/L 005M0150-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.5	645.00..-D	822	822
R/L 005M0200-25	5	1.9	5.0	4.4	40	25	1.0	3.3	2.0	645.00..-D	832	832
R/L 005M0100-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.0	645.00..-D	814	814
R/L 005M0150-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.5	645.00..-D	824	824
R/L 005M0200-30	5	1.9	5.0	4.4	45	30	1.0	3.3	2.0	645.00..-D	834	834
R/L 006M0100-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.0	676.00..-D	836	836
R/L 006M0150-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.5	676.00..-D	846	846
R/L 006M0200-10	6	2.3	6.0	5.3	25	10	1.8	3.4	2.0	676.00..-D	856	856
R/L 006M0100-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.0	676.00..-D	838	838
R/L 006M0150-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.5	676.00..-D	848	848
R/L 006M0200-15	6	2.3	6.0	5.3	30	15	1.8	3.4	2.0	676.00..-D	858	858
R/L 006M0100-20	6	2.3	6.0	5.3	35	22	1.8	3.4	1.0	676.00..-D	840	840
R/L 006M0150-20	6	2.3	6.0	5.3	37	22	1.8	3.4	1.5	676.00..-D	850	850
R/L 006M0200-20	6	2.3	6.0	5.3	37	22	1.8	3.4	2.0	676.00..-D	860	860
R/L 006M0100-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.0	676.00..-D	842	842
R/L 006M0150-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.5	676.00..-D	852	852
R/L 006M0200-25	6	2.3	6.0	5.3	40	25	1.8	3.4	2.0	676.00..-D	862	862
R/L 006M0100-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.0	676.00..-D	844	844
R/L 006M0150-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.5	676.00..-D	854	854
R/L 006M0200-30	6	2.3	6.0	5.3	45	30	1.8	3.4	2.0	676.00..-D	864	864
R/L 007M0100-10	7	2.7	6.8	6.3	25	10	2.5	3.7	1.0	676.00..-D	866	866
R/L 007M0150-10	7	2.7	6.8	6.3	25	10	2.5	3.7	1.5	676.00..-D	876	876
R/L 007M0200-10	7	2.7	6.8	6.3	25	10	2.5	3.7	2.0	676.00..-D	886	886
R/L 007M0100-15	7	2.7	6.8	6.3	30	15	2.5	3.7	1.0	676.00..-D	868	868
R/L 007M0150-15	7	2.7	6.8	6.3	30	15	2.5	3.7	1.5	676.00..-D	878	878
R/L 007M0200-15	7	2.7	6.8	6.3	30	15	2.5	3.7	2.0	676.00..-D	888	888
R/L 007M0100-22	7	2.7	6.8	6.3	37	22	2.5	3.7	1.0	676.00..-D	870	870
R/L 007M0150-22	7	2.7	6.8	6.3	37	22	2.5	3.7	1.5	676.00..-D	880	880
R/L 007M0200-22	7	2.7	6.8	6.3	37	22	2.5	3.7	2.0	676.00..-D	890	890
R/L 007M0100-25	7	2.7	6.8	6.3	40	25	2.5	3.7	1.0	676.00..-D	872	872
R/L 007M0150-25	7	2.7	6.8	6.3	40	25	2.5	3.7	1.5	676.00..-D	882	882
R/L 007M0200-25	7	2.7	6.8	6.3	40	25	2.5	3.7	2.0	676.00..-D	892	892
R/L 007M0100-30	7	2.7	6.8	6.3	45	30	2.5	3.7	1.0	676.00..-D	874	874
R/L 007M0150-30	7	2.7	6.8	6.3	45	30	2.5	3.7	1.5	676.00..-D	884	884
R/L 007M0200-30	7	2.7	6.8	6.3	45	30	2.5	3.7	2.0	676.00..-D	894	894

P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	●	●
O	●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 镗孔/仿形车削

▲ CDX = 车削时最大切深



图示为右手刀具



规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	标准刀杆
R/L 047.2-10	4		2.0	1.7	24	10	0.4	1.2	645.00..-D
R/L 047.3-15	4	0.6	2.8	2.6	29	15	0.6	1.9	645.00..-D
R/L 047.4-10	4	1.5	4.0	3.5	24	10	0.6	2.8	645.00..-D
R/L 047.T4-20	4	1.5	4.0	3.5	34	20	0.6	2.8	645.00..-D
R/L 047.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	645.00..-D
R/L 047.5-15	5	1.9	5.0	4.4	30	15	0.8	3.5	645.00..-D
R/L 047.T5-25	5	1.9	5.0	4.4	40	25	0.8	3.5	645.00..-D
R/L 047.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	645.00..-D
R/L 047.T6-22	6	2.3	6.0	5.3	37	22	1.8	3.4	676.00..-D
R/L 047.T6-30	6	2.3	6.0	5.3	45	30	1.8	3.4	676.00..-D
R/L 047.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	676.00..-D

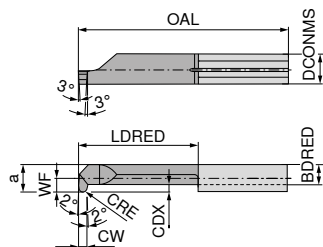
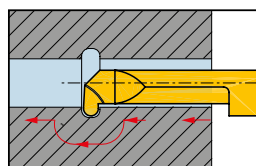
左手刀具
73 011 ...右手刀具
73 010 ...左手刀具
73 011 ...右手刀具
73 010 ...

P	●	●	●	●
M	●	●	●	●
K	●	●	●	●
N	●	●	●	●
S	○	○	●	●
H	○	○	●	●
O	●	●	●	●

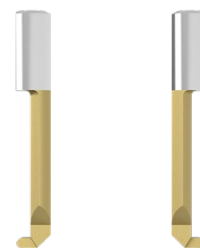
→ V_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 切槽/仿形车削

▲ CDX = 车削时最大切深



图示为右手刀具



左手刀具

右手刀具

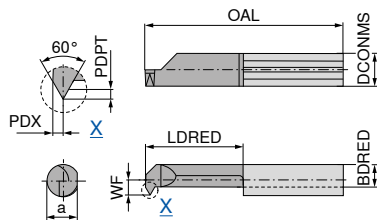
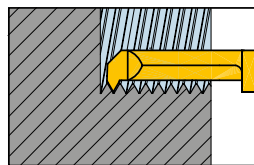
73 019 ...

73 018 ...

规格型号	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	CRE mm	标准刀杆		
R/L 006-0.75-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.5	0.75	676.00..-D	564	564
R/L 006-0.50-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.0	0.50	676.00..-D	562	562
R/L 006-1.00-25	6	2.3	6.0	5.3	40	25	1.8	3.4	2.0	1.00	676.00..-D	566	566
R/L 005-1.00-20	5	1.9	5.0	4.4	35	20	1.0	3.3	2.0	1.00	645.00..-D	556	556
R/L 007-0.50-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.0	0.50	676.00..-D	572	572
R/L 005-0.75-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.5	0.75	645.00..-D	554	554
R/L 007-0.75-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.5	0.75	676.00..-D	574	574
R/L 005-0.50-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.0	0.50	645.00..-D	552	552
R/L 007-1.00-30	7	2.7	6.8	6.3	45	30	2.5	3.8	2.0	1.00	676.00..-D	576	576
R/L 004-0.50-16	4	1.5	4.0	3.5	30	16	0.8	2.4	1.0	0.50	645.00..-D	541	541
P												●	●
M												●	●
K												●	●
N												●	●
S												○	○
H												○	○
O												●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 内螺纹车削 (半牙型)



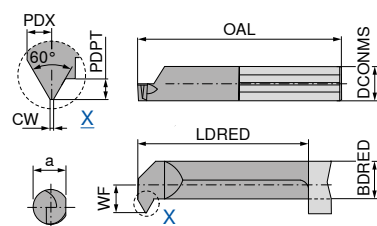
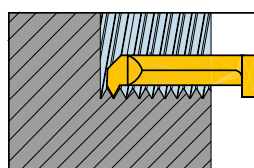
图示为右手刀具

左手刀具
73 101 ...右手刀具
73 100 ...左手刀具
73 101 ...右手刀具
73 100 ...

规格型号	DCONMS _{ns} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	标准刀杆
R/L 003.0105-8	4	0.50	0.30	2.4	2.3	22	8	1.8	0.27	0.33	645.00...D
R/L 004.0408-15	4	0.80	1.75	4.0	3.5	30	15	2.4	0.43	0.45	645.00...D
R/L 005.0510-15	5	1.00	1.90	4.8	4.4	30	15	3.3	0.55	0.55	645.00...D
R/L 005.0510-20	5	1.00	1.90	4.8	4.4	35	20	3.3	0.55	0.55	645.00...D
R/L 006.0612-15	6	1.25	2.30	6.0	5.3	30	15	3.4	0.68	0.65	676.00...D
R/L 006.0612-22	6	1.25	2.30	6.0	5.3	37	22	3.4	0.68	0.65	676.00...D
R/L 006.0815-15	6	1.50	2.30	6.0	5.3	30	15	3.4	0.81	0.75	676.00...D
R/L 006.0815-22	6	1.50	2.30	6.0	5.3	37	22	3.4	0.81	0.75	676.00...D
R/L 007.0815-15	7	1.50	2.70	7.0	6.3	30	15	3.8	0.81	0.75	676.00...D
P											●
M											●
K											●
N											●
S											○
H											○
O											●

→ v_c 请参见页码 59

UltraMini – 内螺纹车削刀片 (全牙型)



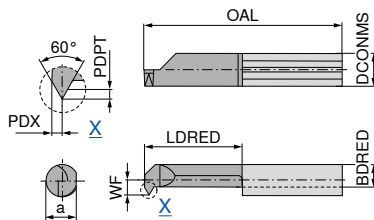
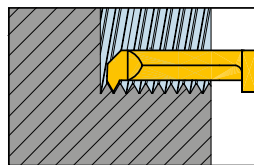
图示为右手刀具

左手刀具
73 209 ...右手刀具
73 208 ...

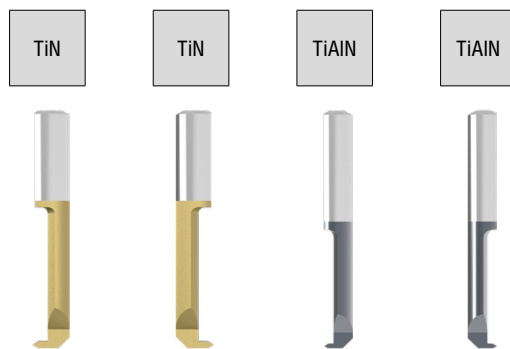
规格型号	DCONMS _{ns} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	CW mm	标准刀杆
R/L 105.0408-15	5	0.80	1.9	4.8	4.4	30	15	3.3	0.43	0.50	0.10	645.00...D
R/L 105.510-15	5	1.00	1.9	4.8	4.4	30	15	3.3	0.54	0.55	0.12	645.00...D
R/L 106.612-15	6	1.25	2.3	6.0	5.3	30	15	3.4	0.67	0.65	0.15	676.00...D
R/L 106.815-15	6	1.50	2.3	6.0	5.3	30	15	3.4	0.81	0.75	0.18	676.00...D
R/L 106.815-15	7	1.50	2.7	7.0	6.3	30	15	3.8	0.81	0.75	0.18	676.00...D
P												●
M												●
K												●
N												●
S												●
H												●
O												●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 内螺纹车削 (半牙型)



图示为右手刀具



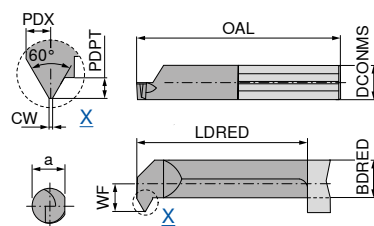
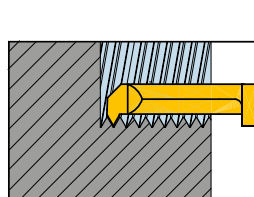
规格型号	DCONMS _{h6}	TP	WF	DMIN	a	OAL	LDRED	BDRED	PDPT	PDX	标准刀杆
R/L 004.0105-10	4	0.50	1.0	3.2	3.0	24	10	2.3	0.27	0.44	645.00...D
R/L 004.0205-15	4	0.50	1.5	4.0	3.5	30	15	2.4	0.27	0.35	645.00...D
R/L 005.0205-15	5	0.50	1.9	5.0	4.4	30	15	3.3	0.27	0.35	645.00...D
R/L 005.0205-20	5	0.50	1.9	5.0	4.4	35	20	3.3	0.27	0.35	645.00...D
R/L 005.0407-15	5	0.75	1.9	5.0	4.4	30	15	3.3	0.40	0.45	645.00...D
R/L 005.0407-20	5	0.75	1.9	5.0	4.4	35	20	3.3	0.40	0.45	645.00...D
R/L 006.0510-15	6	1.00	2.3	6.0	5.3	30	15	3.4	0.55	0.55	676.00...D
R/L 006.0510-22	6	1.00	2.3	6.0	5.3	37	22	3.4	0.55	0.55	676.00...D

左手刀具 73 103 ... 右手刀具 73 102 ... 左手刀具 73 103 ... 右手刀具 73 102 ...

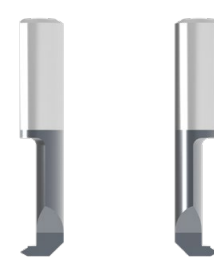
P	●	●	●	●
M	●	●	●	●
K	●	●	●	●
N	●	●	●	●
S	○	○	●	●
H	○	○	●	●
O	●	●	●	●

→ v_c 请参见页码 59

UltraMini – 内螺纹车削刀片 (全牙型)



图示为右手刀



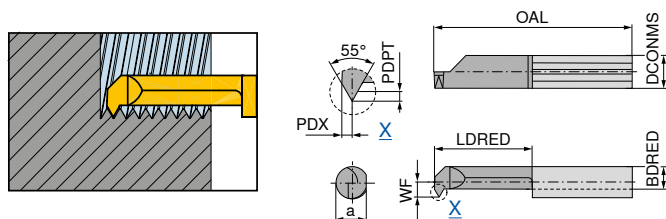
左手刀具 73 207 ... 右手刀具 73 206 ...

规格型号	DCONMS _{h6}	TP	WF	DMIN	a	OAL	LDRED	BDRED	PDPT	PDX	CW	标准刀杆
R/L 104.0205-15	5	0.50	1.5	4	3.5	30	15	2.4	0.27	0.35	0.06	645.00...D
R/L 105.0205-15	5	0.50	1.9	5	4.4	30	15	3.3	0.27	0.35	0.06	645.00...D
R/L 105.0407-15	5	0.75	1.9	5	4.4	30	15	3.3	0.40	0.45	0.09	645.00...D
R/L 106.0510-15	6	1.00	2.3	6	5.3	30	15	3.4	0.54	0.55	0.12	676.00...D

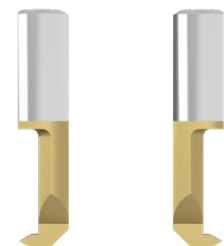
P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	●	●
O	●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 内螺纹车削 (半牙型)



图示为右手刀具



左手刀具

右手刀具

73 105 ...

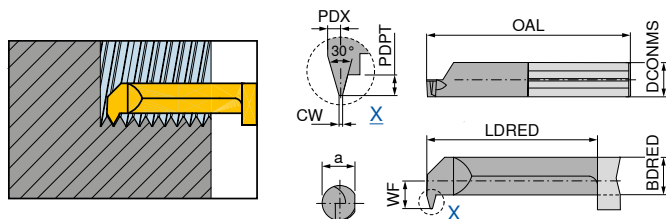
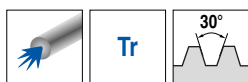
73 104 ...

规格型号	DCONMS _{h6} mm	TPI 1/"	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	标准刀杆		
R/L 005.5548-15	5	48 - 24	1.9	4.8	4.4	30	15	3.3	0.40	0.45	645.00..-D	552	552
R/L 006.5548-15	6	48 - 24	2.3	6.0	5.3	30	15	3.4	0.40	0.45	676.00..-D	562	562
R/L 006.5524-15	6	24 - 16	2.3	6.0	5.3	30	15	3.4	0.81	0.75	676.00..-D	563	563
R/L 007.5524-15	7	24 - 16	2.7	7.0	6.3	30	15	3.8	0.81	0.75	676.00..-D	572	572
P												●	●
M												●	●
K												●	●
N												●	●
S												○	○
H												○	○
O												●	●

→ v_c 请参见页码 59

UltraMini – 内螺纹车削刀片 (半牙型)

▲ 梯形螺纹 DIN 103



图示为右手刀



左手刀具

右手刀具

73 211 ...

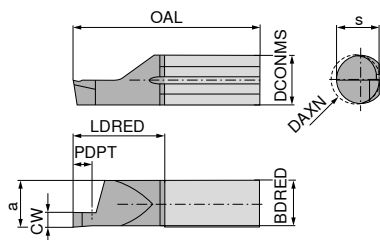
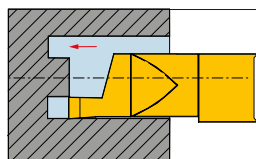
73 210 ...

规格型号	DCONMS _{h6} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	CW mm	标准刀杆		
R/L 007.1220-22	7	2	2.8	7	6.3	37	22	3.8	1.25	0.75	0.6	676.00..-D	222	222
R/L 007.1220-30	7	2	2.8	7	6.3	45	30	3.8	1.25	0.75	0.6	676.00..-D	230	230
R/L 007.1730-22	7	3	2.8	7	6.3	37	22	3.8	1.75	1.10	1.0	676.00..-D	322	322
R/L 007.1730-30	7	3	2.8	7	6.3	45	30	3.8	1.75	1.10	1.0	676.00..-D	330	330
P													●	●
M													●	●
K													●	●
N													●	●
S													●	●
H													●	●
O													●	●

→ v_c 请参见页码 59

12

UltraMini - 整体硬质合金刀具 - 轴向切槽



图示为右手刀具



左手刀具

73 051 ...

右手刀具

73 050 ...

左手刀具

73 053 ...

右手刀具

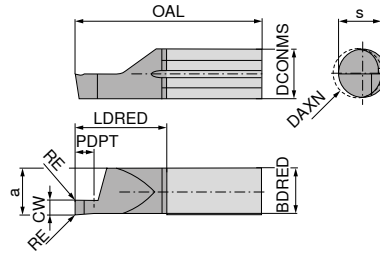
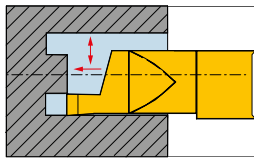
73 052 ...

规格型号	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	标准刀杆	左手刀具 73 051 ...	右手刀具 73 050 ...	左手刀具 73 053 ...	右手刀具 73 052 ...
R/L 010.1006-10	6	5.2	6	5.3	26	11	1.5	4.9	1.0	676.00..-D	561	561	561	561
R/L 010.1506-10	6	5.2	6	5.3	26	11	2.0	4.9	1.5	676.00..-D	563	563	563	563
R/L 010.1008-10	7	5.9	8	6.3	26	11	1.5	5.6	1.0	676.00..-D	571	571	571	571
R/L 010.1008-20	7	5.9	8	6.3	35	20	1.5	5.6	1.0	676.00..-D	671	671	671	671
R/L 010.1008-30	7	5.9	8	6.3	45	30	1.5	5.6	1.0	676.00..-D	771	771	771	771
R/L 010.1508-10	7	5.9	8	6.3	26	11	2.5	5.6	1.5	676.00..-D	573	573	573	573
R/L 010.1508-20	7	5.9	8	6.3	35	20	2.5	5.6	1.5	676.00..-D	673	673	673	673
R/L 010.1508-30	7	5.9	8	6.3	45	30	2.5	5.6	1.5	676.00..-D	773	773	773	773
R/L 010.2008-10	7	5.9	8	6.3	26	11	3.0	5.6	2.0	676.00..-D	575	575	575	575
R/L 010.2008-20	7	5.9	8	6.3	35	20	3.0	5.6	2.0	676.00..-D	675	675	675	675
R/L 010.2008-30	7	5.9	8	6.3	45	30	3.0	5.6	2.0	676.00..-D	775	775	775	775
R/L 010.2508-10	7	5.9	8	6.3	26	11	3.5	5.6	2.5	676.00..-D	577	577	577	577
R/L 010.2508-20	7	5.9	8	6.3	35	20	3.5	5.6	2.5	676.00..-D	677	677	677	677
R/L 010.2508-30	7	5.9	8	6.3	45	30	3.5	5.6	2.5	676.00..-D	777	777	777	777
R/L 010.3008-10	7	5.9	8	6.3	26	11	3.5	5.6	3.0	676.00..-D	579	579	579	579
R/L 010.3008-20	7	5.9	8	6.3	35	20	3.5	5.6	3.0	676.00..-D	679	679	679	679
R/L 010.3008-30	7	5.9	8	6.3	45	30	3.5	5.6	3.0	676.00..-D	779	779	779	779
P											●	●	●	●
M											●	●	●	●
K											●	●	●	●
N											●	●	●	●
S											○	○	○	○
H											○	○	●	●
O											●	●	●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 轴向切槽

▲ 带刀尖圆角



图示为右手刀具

TiAlN

TiAlN



左手刀具

右手刀具

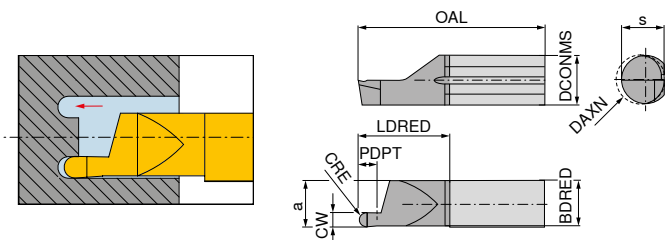
73 253 ...

73 252 ...

规格型号	DCONMS ₁₆ mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	RE mm	标准刀杆		
R/L 510M1008-10	5	4.3	5	6.3	26	11	2	4.0	1.0	0.05	645.00..-D	510	510
R/L 510M1008-20	5	4.3	5	6.3	35	20	2	4.0	1.0	0.05	645.00..-D	610	610
R/L 510M1508-10	5	4.3	5	6.3	26	11	3	4.0	1.5	0.05	645.00..-D	515	515
R/L 510M1508-20	5	4.3	5	6.3	35	20	3	4.0	1.5	0.05	645.00..-D	615	615
R/L 510M2008-10	5	4.3	5	6.3	26	11	4	4.0	2.0	0.05	645.00..-D	520	520
R/L 510M2008-20	5	4.3	5	6.3	35	20	4	4.0	2.0	0.05	645.00..-D	620	620
R/L 010M1008-10	7	5.9	8	6.3	26	11	2	5.6	1.0	0.10	676.00..-D	800	800
R/L 010M1008-20	7	5.9	8	6.3	35	20	2	5.6	1.0	0.10	676.00..-D	810	810
R/L 010M1008-30	7	5.9	8	6.3	45	30	2	5.6	1.0	0.10	676.00..-D	820	820
R/L 010M1508-10	7	5.9	8	6.3	26	11	3	5.6	1.5	0.10	676.00..-D	802	802
R/L 010M1508-20	7	5.9	8	6.3	35	20	3	5.6	1.5	0.10	676.00..-D	812	812
R/L 010M1508-30	7	5.9	8	6.3	45	30	3	5.6	1.5	0.10	676.00..-D	822	822
R/L 010M2008-10	7	5.9	8	6.3	26	11	4	5.6	2.0	0.10	676.00..-D	804	804
R/L 010M2008-20	7	5.9	8	6.3	35	20	4	5.6	2.0	0.10	676.00..-D	814	814
R/L 010M2008-30	7	5.9	8	6.3	45	30	4	5.6	2.0	0.10	676.00..-D	824	824
R/L 010M2508-10	7	5.9	8	6.3	26	11	5	5.6	2.5	0.10	676.00..-D	806	806
R/L 010M2508-20	7	5.9	8	6.3	35	20	5	5.6	2.5	0.10	676.00..-D	816	816
R/L 010M2508-30	7	5.9	8	6.3	45	30	5	5.6	2.5	0.10	676.00..-D	826	826
R/L 010M3008-10	7	5.9	8	6.3	26	11	6	5.6	3.0	0.10	676.00..-D	808	808
R/L 010M3008-20	7	5.9	8	6.3	35	20	6	5.6	3.0	0.10	676.00..-D	818	818
R/L 010M3008-30	7	5.9	8	6.3	45	30	6	5.6	3.0	0.10	676.00..-D	828	828
P												●	●
M												●	●
K												●	●
N												●	●
S												●	●
H												●	●
O												●	●

→ v_c 请参见页码 59

UltraMini - 整体硬质合金刀具 - 轴向切槽 (全圆弧)



图示为右手刀具



左手刀具



右手刀具

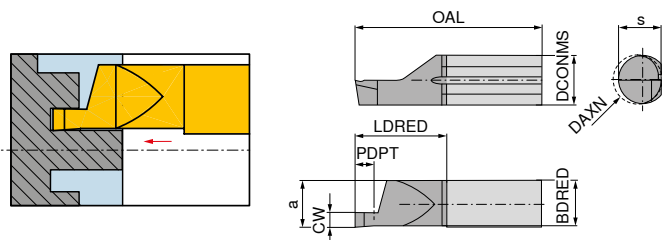
73 059 ...

73 058 ...

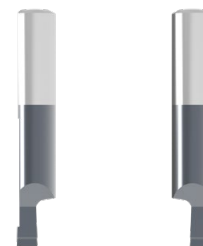
规格型号	DCONMS _{hg} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	CRE mm	标准刀杆		
R/L 610.1005-10	6	5.2	6	5.3	26	11	2	4.9	1.0	0.50	676.00..-D	071	071
R/L 610.1005-20	6	5.2	6	5.3	35	20	2	4.9	1.0	0.50	676.00..-D	171	171
R/L 610.1608-10	6	5.2	6	5.3	26	11	3	4.9	1.6	0.80	676.00..-D	073	073
R/L 610.1608-20	6	5.2	6	5.3	35	20	3	4.9	1.6	0.80	676.00..-D	173	173
R/L 610.2010-10	6	5.2	6	5.3	26	11	4	4.9	2.0	1.00	676.00..-D	075	075
R/L 610.2010-20	6	5.2	6	5.3	35	20	4	4.9	2.0	1.00	676.00..-D	175	175
R/L 610.2512-10	6	5.2	6	5.3	26	11	5	4.9	2.5	1.25	676.00..-D	077	077
R/L 610.2512-20	6	5.2	6	5.3	35	20	5	4.9	2.5	1.25	676.00..-D	177	177
R/L 610.3015-10	6	5.2	6	5.3	26	11	6	4.9	3.0	1.50	676.00..-D	079	079
R/L 610.3015-20	6	5.2	6	5.3	35	20	6	4.9	3.0	1.50	676.00..-D	179	179
R/L 010.1005-10	7	5.9	8	6.3	26	11	2	5.6	1.0	0.50	676.00..-D	571	571
R/L 010.1005-20	7	5.9	8	6.3	35	20	2	5.6	1.0	0.50	676.00..-D	671	671
R/L 010.1608-10	7	5.9	8	6.3	26	11	3	5.6	1.6	0.80	676.00..-D	573	573
R/L 010.1608-20	7	5.9	8	6.3	35	20	3	5.6	1.6	0.80	676.00..-D	673	673
R/L 010.2010-10	7	5.9	8	6.3	26	11	4	5.6	2.0	1.00	676.00..-D	575	575
R/L 010.2010-20	7	5.9	8	6.3	35	20	4	5.6	2.0	1.00	676.00..-D	675	675
R/L 010.2512-10	7	5.9	8	6.3	26	11	5	5.6	2.5	1.25	676.00..-D	577	577
R/L 010.2512-20	7	5.9	8	6.3	35	20	5	5.6	2.5	1.25	676.00..-D	677	677
R/L 010.3015-10	7	5.9	8	6.3	26	11	6	5.6	3.0	1.50	676.00..-D	579	579
R/L 010.3015-20	7	5.9	8	6.3	35	20	6	5.6	3.0	1.50	676.00..-D	679	679
P												●	●
M												●	●
K												●	●
N												●	●
S												●	●
H												●	●
O												●	●

→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 轴向切槽 (轴颈)



图示为右手刀具



左手刀具

右手刀具

73 061 ...

73 060 ...

规格型号	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	标准刀杆
R/L 620.1006-20	6	5.2	6	5.3	35	20	2	4.9	1.0	676.00..-D
R/L 620.1506-20	6	5.2	6	5.3	35	20	3	4.9	1.5	676.00..-D
R/L 620.2006-20	6	5.2	6	5.3	35	20	4	4.9	2.0	676.00..-D
R/L 620.2506-20	6	5.2	6	5.3	35	20	5	4.9	2.5	676.00..-D
R/L 620.3006-20	6	5.2	6	5.3	35	20	6	4.9	3.0	676.00..-D

561

561

563

563

565

565

567

567

569

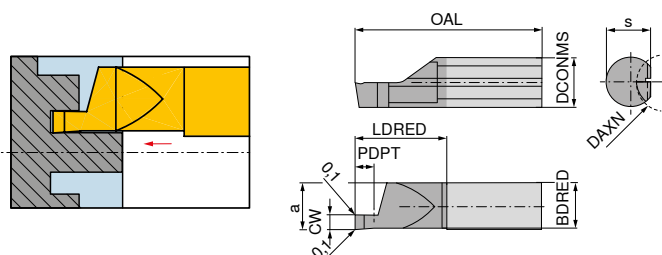
569

P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	●	●
O	●	●

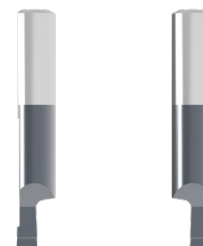
→ v_c 请参见页码 59

UltraMini – 整体硬质合金刀具 – 轴向切槽 (轴颈)

▲ 带刀尖圆角



图示为右手刀具



左手刀具

右手刀具

73 261 ...

73 260 ...

规格型号	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	标准刀杆
R/L 620M1006-20	6	5.2	6	5.3	35	20	2	4.9	1.0	676.00..-D
R/L 620M1506-20	6	5.2	6	5.3	35	20	3	4.9	1.5	676.00..-D
R/L 620M2006-20	6	5.2	6	5.3	35	20	4	4.9	2.0	676.00..-D
R/L 620M2506-20	6	5.2	6	5.3	35	20	5	4.9	2.5	676.00..-D
R/L 620M3006-20	6	5.2	6	5.3	35	20	6	4.9	3.0	676.00..-D

800

800

802

802

804

804

806

806

808

808

P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	●	●
O	●	●

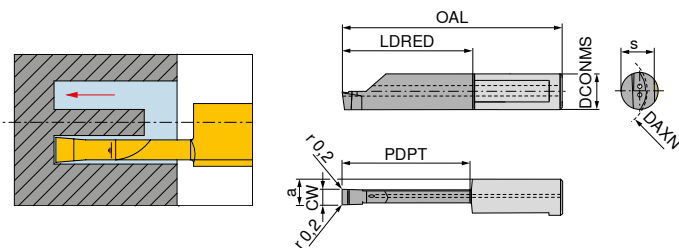
→ v_c 请参见页码 59

12

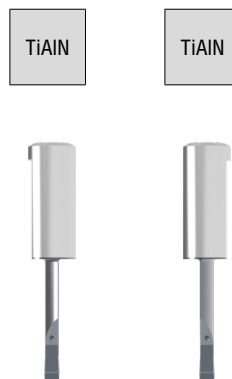
UltraMini – 整体硬质合金刀具 – 轴向切槽

▲ 冷却液压力最大70 bar

▲ 双冷却液孔



图示为右手刀具



左手刀具

右手刀具

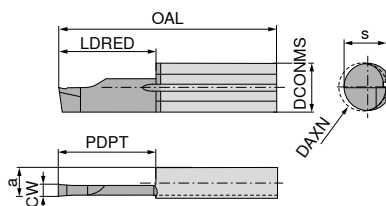
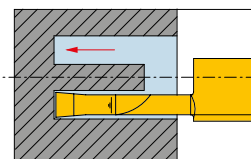
73 263 ...

73 262 ...

规格型号	DCONMS ₁₆ mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm	标准刀杆		
R/L 012.0200-10	8	5.00	12	7.3	30	10	10	2.0	687.00...D	700	700
R/L 012.0200-15	8	5.00	12	7.3	35	15	15	2.0	687.00...D	702	702
R/L 012.0250-10	8	5.25	12	7.3	30	10	10	2.5	687.00...D	704	704
R/L 012.0250-20	8	5.25	12	7.3	40	20	20	2.5	687.00...D	706	706
R/L 016.0300-10	8	5.50	16	7.3	30	10	10	3.0	687.00...D	800	800
R/L 016.0300-20	8	5.50	16	7.3	40	20	20	3.0	687.00...D	802	802
R/L 020.0300-25	8	5.50	20	7.3	45	25	25	3.0	687.00...D	804	804
R/L 020.0300-30	8	5.50	20	7.3	50	30	30	3.0	687.00...D	806	806
R/L 020.0300-35	8	5.50	20	7.3	55	35	35	3.0	687.00...D	808	808
R/L 020.0300-40	8	5.50	20	7.3	60	40	40	3.0	687.00...D	810	810
R/L 016.0400-10	8	6.00	16	7.3	30	10	10	4.0	687.00...D	812	812
R/L 016.0400-20	8	6.00	16	7.3	40	20	20	4.0	687.00...D	814	814
R/L 020.0400-25	8	6.00	20	7.3	45	25	25	4.0	687.00...D	816	816
R/L 020.0400-30	8	6.00	20	7.3	50	30	30	4.0	687.00...D	818	818
R/L 020.0400-35	8	6.00	20	7.3	55	35	35	4.0	687.00...D	820	820
R/L 020.0400-40	8	6.00	20	7.3	60	40	40	4.0	687.00...D	822	822
R/L 020.0500.20	8	6.50	20	7.3	40	20	20	5.0	687.00...D	824	824
R/L 020.0500.25	8	6.50	20	7.3	45	25	25	5.0	687.00...D	826	826
R/L 020.0500.30	8	6.50	20	7.3	50	30	30	5.0	687.00...D	828	828
R/L 020.0500.35	8	6.50	20	7.3	55	35	35	5.0	687.00...D	830	830
R/L 020.0500.40	8	6.50	20	7.3	60	40	40	5.0	687.00...D	832	832
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

→ v_c 请参见页码 59

UltraMini - 整体硬质合金刀具 - 轴向切槽



图示为右手刀具

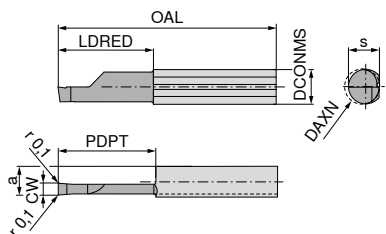
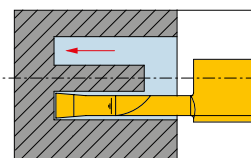
左手刀具
73 055 ...右手刀具
73 054 ...左手刀具
73 057 ...右手刀具
73 056 ...

规格型号	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm	标准刀杆				
R/L 015.2515-20	7	5.9	15	6.3	35	20	20	2.5	676.00..-D	572	572	572	572
R/L 015.3015-20	7	5.9	15	6.3	35	20	20	3.0	676.00..-D	574	574	574	574
R/L 015.3015-30	7	5.9	15	6.3	45	30	30	3.0	676.00..-D	674	674	674	674
P										●	●	●	●
M										●	●	●	●
K										●	●	●	●
N										●	●	●	●
S										○	○	●	●
H										○	○	●	●
O										●	●	●	●

→ v_c 请参见页码 59

UltraMini - 整体硬质合金刀具 - 轴向切槽

▲ 带刀尖圆角



图示为右手刀具

左手刀具
73 257 ...右手刀具
73 256 ...

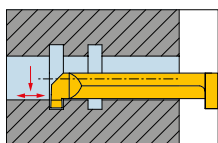
规格型号	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm	标准刀杆				
R/L 015M2515-20	7	5.9	8	6.3	35	20	20	2.5	676.00..-D		800		800
R/L 015M3015-20	7	5.9	8	6.3	35	20	20	3.0	676.00..-D		802		802
R/L 015M3015-30	7	5.9	8	6.3	45	30	30	3.0	676.00..-D		804		804
P										●	●	●	●
M										●	●	●	●
K										●	●	●	●
N										●	●	●	●
S										●	●	●	●
H										●	●	●	●
O										●	●	●	●

→ v_c 请参见页码 59

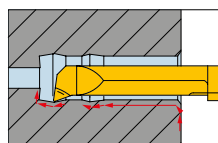
UltraMini – 套件: 内孔车削、切槽和倒角, 右旋

▲ 种类繁多的右手刀具

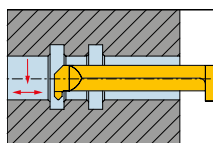
▲ K10F-TiN



切槽 (E)



仿形车削 (A)



倒角 (F)



73 085 ...

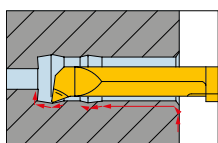
刀具	规格型号	订货编号:	孔径 mm	钻削深度 mm	切槽深度 mm	切槽宽度 mm	/个	图
刀片	R 004.0100-16	73 002 541	4	16	0,8	1,0	1	E
刀片	R 005.0150-20	73 002 552	5	20	1,0	1,5	1	E
刀片	R 005.0200-20	73 002 553	5	20	1,0	2,0	1	E
刀片	R 006.0150-22	73 002 562	6	22	1,8	1,5	1	E
刀片	R 006.0200-22	73 002 563	6	22	1,8	2,0	1	E
刀片	R 050.3-16	73 004 530	3	16			1	A
刀片	R 050.4-16	73 004 540	4	16			1	A
刀片	R 050.5-20	73 004 550	5	20			1	A
刀片	R 050.6-22	73 004 560	6	22			1	A
刀片	R 060.5-20	73 006 550	5	20			1	F
刀杆	645.0016-D	73 080 164					1	
刀杆	676.0016-D	73 080 166					1	
扳手	110.645	70 950 175					1	

999

UltraMini – 套件: 内孔车削

▲ 种类繁多的右手刀具

▲ K10F-TiN



73 085 ...

刀具	规格型号	订货编号:	孔径 mm	钻削深度 mm	/个
刀片	R 050.3-16	73 004 530	3	16	1
刀片	R 050.4-16	73 004 540	4	16	1
刀片	R 050.5-20	73 004 550	5	20	1
刀片	R 050.6-22	73 004 560	6	22	1
刀杆	645.0016-D	73 080 164			1
刀杆	676.0016-D	73 080 166			1
扳手	110.645	70 950 175			1

994

UltraMini – 套件: 刀杆



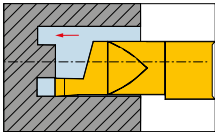
73 085 ...

刀具	规格型号	订货编号:	适用切削刀片直径 mm	/个
刀杆	645.0016-D	73 080 164	3 / 4 / 5	1
刀杆	676.0016-D	73 080 166	6 / 7	1
扳手	110.645	70 950 175		1

990

UltraMini – 套件: 轴向切槽

- ▲ 种类繁多的右手刀具
- ▲ K10F-TiN



73 085 ...

刀具	规格型号	订货编号:	孔径 mm	钻削深度 mm	切槽深度 mm	切槽宽度 mm	/个
刀片	R 010.1008-10	73 050 571	8	10	1,5	1,0	1
刀片	R 010.1508-10	73 050 573	8	10	2,5	1,5	1
刀片	R 010.2008-10	73 050 575	8	10	3,0	2,0	1
刀片	R 010.2508-20	73 050 677	8	20	3,5	2,5	1
刀片	R 010.3008-20	73 050 679	8	20	3,5	3,0	1
刀杆	676.0016-D	73 080 166					1
扳手	110.645	70 950 175					1

996

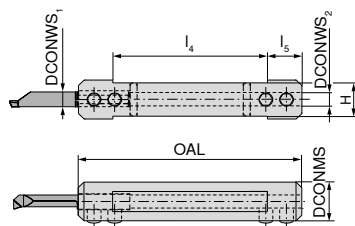
UltraMini – 标准刀杆

▲ 双头

▲ 孔径范围最小为0.5 mm

供货详情:

刀具接杆、内六角扳手



73 080 ...

规格型号	DCONWS ₁ mm	DCONWS ₂ mm	DCONMS mm	OAL mm	l ₄ mm	l ₅ mm	H mm	
687.0020-D	7	8	20.00	90	70	10	18.0	169
645.001905-D	4	5	19.05	90	70	10	17.2	170
687.0016-D	7	8	16.00	75	55	10	14.0	168
645.0022-D	4	5	22.00	90	70	10	20.0	171
676.0020-D	6	7	20.00	90	70	10	18.0	167
645.00254-D	4	5	25.40	95	75	10	23.4	172
676.0016-D	6	7	16.00	75	55	10	14.0	166
676.001905-D	6	7	19.05	90	70	10	17.2	173
645.0020-D	4	5	20.00	90	70	10	18.0	165
676.0022-D	6	7	22.00	90	70	10	20.0	174
645.0016-D	4	5	16.00	75	55	10	14.0	164
676.00254-D	6	7	25.40	95	75	10	23.4	175
645.0012-D	4	5	12.00	75	55	10	10.3	163



扳手-I



锁紧螺钉

70 950 ...

73 082 ...

备件

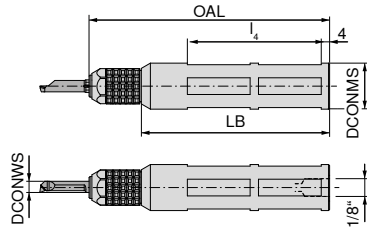
适用于:

73 080 169	SW2,5	175	M6x6	014
73 080 170	SW2,5	175	M5x6	001
73 080 168	SW2,5	175	M6x6	014
73 080 171	SW2,5	175	M5x8	008
73 080 167	SW2,5	175	M5x8	008
73 080 172	SW2,5	175	M5x8	008
73 080 166	SW2,5	175	M5x6	001
73 080 173	SW2,5	175	M5x6	001
73 080 165	SW2,5	175	M5x8	008
73 080 174	SW2,5	175	M5x8	008
73 080 164	SW2,5	175	M5x6	001
73 080 175	SW2,5	175	M5x8	008
73 080 163	SW2,5	175	M5x4	013

UltraMini – 快换刀杆

供货范围:

刀杆、锁紧螺母和夹紧楔



73 089 ...

规格型号	DCONWS	DCONMS _{g6}	OAL	LB	l ₄	
	mm	mm	mm	mm	mm	
UM600H.0012.4	4	12.00	115	90	64	124
UM600H.0016.4	4	16.00	115	90	64	164
UM600H.001905.4	4	19.05	115	90	64	194
UM600H.0020.4	4	20.00	115	90	64	204
UM600H.0022.4	4	22.00	115	90	64	224
UM600H.0025.4	4	25.00	115	90	64	254
UM600H.00254.4	4	25.40	115	90	64	264
UM600H.0028.4	4	28.00	115	90	64	284
UM600H.0012.5	5	12.00	115	90	64	125
UM600H.0016.5	5	16.00	115	90	64	165
UM600H.001905.5	5	19.05	115	90	64	195
UM600H.0020.5	5	20.00	115	90	64	205
UM600H.0022.5	5	22.00	115	90	64	225
UM600H.0025.5	5	25.00	115	90	64	255
UM600H.00254.5	5	25.40	115	90	64	265
UM600H.0028.5	5	28.00	115	90	64	285
UM600H.0012.6	6	12.00	115	90	64	126
UM600H.0016.6	6	16.00	115	90	64	166
UM600H.001905.6	6	19.05	115	90	64	196
UM600H.0020.6	6	20.00	115	90	64	206
UM600H.0022.6	6	22.00	115	90	64	226
UM600H.0025.6	6	25.00	115	90	64	256
UM600H.00254.6	6	25.40	115	90	64	266
UM600H.0028.6	6	28.00	115	90	64	286
UM600H.0012.7	7	12.00	115	90	64	127
UM600H.0016.7	7	16.00	115	90	64	167
UM600H.001905.7	7	19.05	115	90	64	197
UM600H.0020.7	7	20.00	115	90	64	207
UM600H.0022.7	7	22.00	115	90	64	227
UM600H.0025.7	7	25.00	115	90	64	257
UM600H.00254.7	7	25.40	115	90	64	267
UM600H.0028.7	7	28.00	115	90	64	287

12

 避免夹持不稳。使用冷却液供应时，确保施加适当的夹持力。可借助扳手拧紧。

备件

DCONWS

4	M4	104	111
5	M5	105	111
6	M6	106	111
7	M7	107	111



锁紧螺母
UM600H



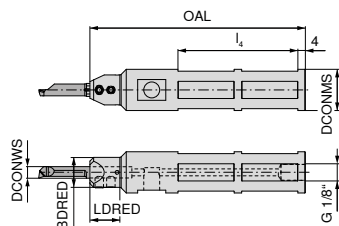
夹紧楔 UM600H

73 950 ...

73 950 ...

UltraMini – 刀杆, 适用高压内冷

▲ 适用于高冷却液压力的刀杆



73 088 ...

规格型号	DCONWS	BDRED	DCONMS _{g8}	OAL	LDRED	l ₄	
	mm	mm	mm	mm	mm	mm	
UMST.0016.4	4	16	16.00	115	24	42	164
UMST.001905.4	4	16	19.05	115	24	42	194
UMST.0020.4	4	16	20.00	115	24	42	204
UMST.0022.4	4	16	22.00	115	24	42	224
UMST.00254.4	4	16	25.40	115	24	42	264
UMST.0028.4	4	16	28.00	115	24	42	284
UMST.0016.5	5	16	16.00	115	24	42	165
UMST.001905.5	5	16	19.05	115	24	42	195
UMST.0020.5	5	16	20.00	115	24	42	205
UMST.0022.5	5	16	22.00	115	24	42	225
UMST.00254.5	5	16	25.40	115	24	42	265
UMST.0028.5	5	16	28.00	115	24	42	285
UMST.0016.6	6	16	16.00	115	24	42	166
UMST.001905.6	6	16	19.05	115	24	42	196
UMST.0020.6	6	16	20.00	115	24	42	206
UMST.0022.6	6	16	22.00	115	24	42	226
UMST.00254.6	6	16	25.40	115	24	42	266
UMST.0028.6	6	16	28.00	115	24	42	286
UMST.0016.7	7	16	16.00	115	24	42	167
UMST.001905.7	7	16	19.05	115	24	42	197
UMST.0020.7	7	16	20.00	115	24	42	207
UMST.0022.7	7	16	22.00	115	24	42	227
UMST.00254.7	7	16	25.40	115	24	42	267
UMST.0028.7	7	16	28.00	115	24	42	287
UMST.0016.8	8	16	16.00	115	24	42	168
UMST.001905.8	8	16	19.05	115	24	42	198
UMST.0020.8	8	16	20.00	115	24	42	208
UMST.0022.8	8	16	22.00	115	24	42	228
UMST.00254.8	8	16	25.40	115	24	42	268
UMST.0028.8	8	16	28.00	115	24	42	288



最大 150 bar



扳手-D



锁紧螺钉

80 950 ...

73 950 ...

备件

DCONWS

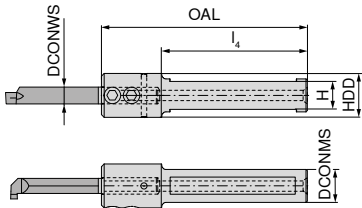
4	T10	104	M5x0,5x6T10	050
5	T10	104	M5x0,5x6T10	050
6	T10	104	M5x0,5x6T10	050
7	T10	104	M5x0,5x6T10	050
8	T10	104	M5x0,5x6T10	050

UltraMini – 单头刀杆

▲ 单头

供货详情:

刀具接杆、内六角扳手



规格型号	DCONWS	HDD	DCONMS	OAL	l ₄	H	73 081 ...
640.0012-D	4	16	12	75	53	10.2	264
650.0012-D	5	16	12	75	53	10.2	265
660.0012-D	6	16	12	75	53	10.2	266
670.0012-D	7	16	12	75	53	10.2	267
680.0012-D	8	16	12	75	53	10.2	268

备件

DCONWS

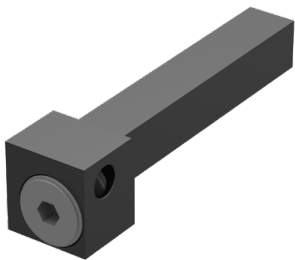
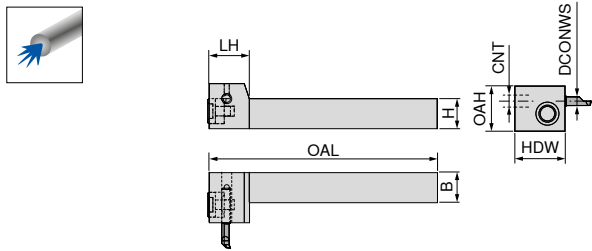
DCONWS	70 950 ...	73 082 ...
4	SW2,5 175	M5x0,5x6 010
5	SW2,5 175	M5x0,5x6 010
6	SW2,5 175	M5x0,5x6 010
7	SW2,5 175	M5x0,5x6 010
8	SW2,5 175	M5x0,5x6 010



UltraMini – 方刀杆

供货详情:

刀杆及内六角扳手



左手刀具
73 083 ...

右手刀具
73 084 ...

规格型号	DCONWS	OAL	LH	B	HDW	H	OAH	CNT		
	mm	mm	mm	mm	mm	mm	mm			
R/L .IK.UHCM.1212.4	4	90	17	12	20	12	18	M5		
R/L .IK.UHCM.1212.5	5	90	17	12	20	12	18	M5		
R/L .IK.UHCM.1212.6	6	90	17	12	20	12	21	M5		
R/L .IK.UHCM.1212.7	7	90	17	12	20	12	21	M5		

124
125
126
127

124
125
126
127

1 适配的冷却接口可以查阅我们的走心机刀具样本。

备件

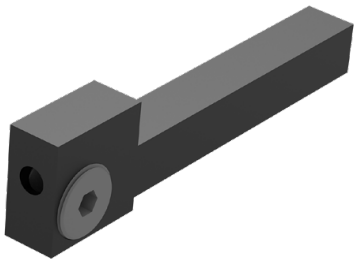
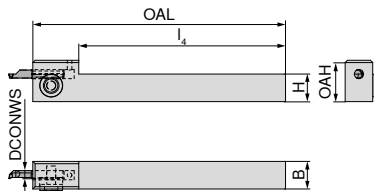
DCONWS

4	SW5	050	UM 12	011
5	SW5	050	UM 12	011
6	SW5	050	UM 16	012
7	SW5	050	UM 16	012

UltraMini – 方刀杆

供货详情:

刀杆及内六角扳手



73 086 ...

规格型号	DCONWS	OAL	I ₄	B	H	OAH	
	mm	mm	mm	mm	mm	mm	
UM.1010.4	4	100	75	10	10	20	104
UM.1010.5	5	100	75	10	10	20	105
UM.1212.4	4	100	75	12	12	22	124
UM.1212.5	5	100	75	12	12	22	125
UM.1212.6	6	100	75	12	12	22	126

备件

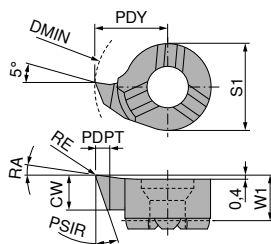
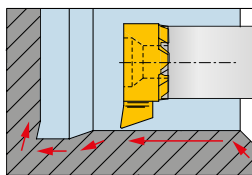
DCONWS

4	SW5	050	UM 12	011
5	SW5	050	UM 12	011
6	SW5	050	UM 16	012

MiniCut - 整体硬质合金切削头 - 镗孔/仿形车削

CWX500

CWX500



图示为右手刀具



左手刀具

右手刀具

73 324 ...

73 322 ...

尺寸	规格型号	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	RA °		
08	8,00. R/L .3,30.18°	7.8	3.3	3.5	4.65	6.0	0.20	0.6	18	8	033	033
	8,00. R/L .3,50.18°	7.8	3.5	3.5	4.65	6.0	0.05	0.6	18	8	035	035
	8,00. R/L .3,50.20°	7.8	3.5	3.5	4.65	6.0	0.20	0.6	20	20	135	135
09	9,00. R/L .3,60.18°	9.0	3.6	3.6	5.50	6.2	0.20	0.8	18	8	136	136
	9,00. R/L .3,60.20°	9.0	3.6	3.6	5.50	6.2	0.20	0.8	20	20	236	236
11	9,80. R/L .3,90.18°	9.8	3.9	4.2	5.50	8.0	0.20	1.0	18	8	139	139
	11,00. R/L .3,90.18°	11.0	3.9	4.2	6.70	8.0	0.20	1.0	18	8	339	339
	11,00. R/L .4,20.20°	11.0	4.2	4.2	6.70	8.0	0.20	1.0	20	20	342	342
14	14,00. R/L .5,00.18°	13.8	5.0	5.1	8.70	9.0	0.20	1.5	18	8	550	550
	14,00. R/L .5,30.20°	14.0	5.3	5.3	8.70	9.0	0.20	1.5	20	20	553	553
16	15,50. R/L .5,00.18°	15.5	5.0	5.4	9.70	11.0	0.20	1.5	18	8	750	750
P											●	●
M											●	●
K											●	●
N											●	●
S											●	●
H											●	●
O											●	●

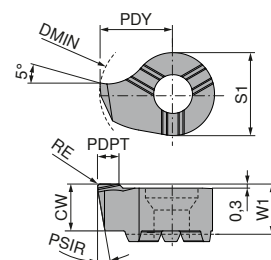
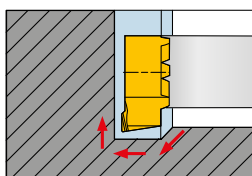
→ v_c 请参见页码 59

MiniCut - 整体硬质合金切削头 - 仿形车削

▲ 带断屑槽

CWX500

CWX500



图示为右手刀具



左手刀具

右手刀具

73 388 ...

73 386 ...

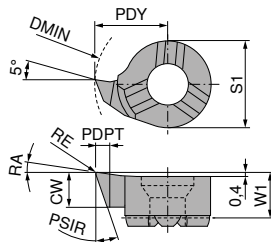
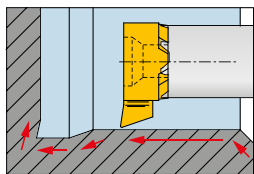
尺寸	规格型号	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °		
08	8,00. R/L .3,40.10°	8	3.4	3.5	4.65	6.0	0.2	0.5	10	13400	13400
09	9,00. R/L .3,50.10°	9	3.5	3.6	5.50	6.2	0.2	0.5	10	136	136
11	11,00. R .4,10.10°	11	4.1	4.2	6.70	8.0	0.2	0.5	10	14100	14100
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

→ v_c 请参见页码 59

12

MiniCut – 用于仿形车削 – 硬质材料车削的 CBN 刀头

▲ 56 至 65 HRC



图示为右手刀具

左手刀具
CBN右手刀具
CBN

73 368 ...

73 366 ...

尺寸	规格型号	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	RA °		
08	8,00. R/L .3,30.18°	7.8	3.3	3.5	4.65	6	0.2	0.39	18	8		033
11	11,00. R/L .3,90.18°	11.0	3.9	4.2	6.70	8	0.2	0.55	18	8		139
14	14,00. R/L .5,00.18°	13.8	5.0	5.3	8.70	9	0.2	0.69	18	8		550
16	16,00. R/L .5,00.18°	15.5	5.0	5.4	9.70	11	0.2	0.77	18	8		750
P												
M												
K												
N												
S											○	○
H											●	●
O												

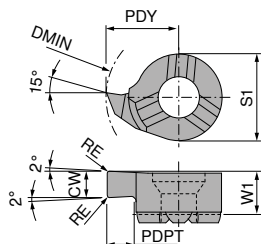
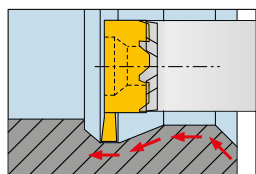
→ v_c 请参见页码 59

MiniCut – 整体硬质合金切削头 – 镗孔

▲ CDX = $a_{p_{max}}$ (取决于材料)

CWX500

CWX500



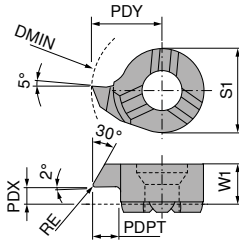
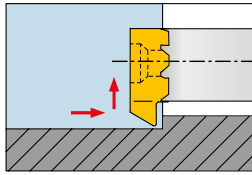
图示为右手刀具

尺寸	规格型号	DMIN mm	CW ^{+0.05} mm	PDPT mm	W1 mm	PDY mm	S1 mm	RE mm	CDX mm	左手刀具		右手刀具	
										73 316 ...		73 314 ...	
08	8,00. R/L 1,50.1,0	8	1.5	1.0	3.3	4.8	6.0	0.2	0.2		015		015
	8,00. R/L 2,00.1,0	8	2.0	1.0	3.3	4.8	6.0	0.2	0.2		020		020
09	9,00. R/L 1,50.2,0	9	1.5	2.0	3.6	5.5	6.2	0.2	0.2		115		115
	9,00. R/L 1,50.3,0	10	1.5	3.0	3.6	6.5	6.2	0.2	0.2		121		121
	9,00. R/L 2,00.2,0	9	2.0	2.0	3.6	5.5	6.2	0.2	0.2		120		120
	9,00. R/L 2,00.3,0	10	2.0	3.0	3.6	6.5	6.2	0.2	0.2		122		122
11	11,00. R/L 1,50.2,3	11	1.5	2.3	4.2	6.7	8.0	0.2	0.2		315		315
	11,00. R/L 2,00.2,3	11	2.0	2.3	4.2	6.7	8.0	0.2	0.2		320		320
14	14,00. R/L 1,50.4,0	14	1.5	4.0	5.3	9.0	9.0	0.2	0.2		515		515
	14,00. R/L 1,50.5,5	16	1.5	5.5	5.2	10.5	9.0	0.2	0.2		516		516
	14,00. R/L 1,50.6,5	17	1.5	6.5	5.2	11.5	9.0	0.2	0.2		517		517
	14,00. R/L 2,00.4,0	14	2.0	4.0	5.3	9.0	9.0	0.2	0.2		520		520
	14,00. R/L 2,00.5,5	16	2.0	5.5	5.2	10.5	9.0	0.2	0.2		521		521
	14,00. R/L 2,00.6,5	17	2.0	6.5	5.2	11.5	9.0	0.2	0.2		522		522
	14,00. R/L 2,50.5,5	16	2.5	5.5	5.2	10.5	9.0	0.2	0.2		525		525
	14,00. R/L 2,50.6,5	17	2.5	6.5	5.2	11.5	9.0	0.2	0.2		526		526
	14,00. R/L 3,00.5,5	16	3.0	5.5	5.2	10.5	9.0	0.2	0.2		530		530
	14,00. R/L 3,00.6,5	17	3.0	6.5	5.2	11.5	9.0	0.2	0.2		531		531
16	16,00. R/L 2,00.4,3	16	2.0	4.3	5.4	10.2	11.0	0.2	0.2		720		720
P											●		●
M											●		●
K											●		●
N											●		●
S											●		●
H											●		●
O											●		●

→ v_c 请参见页码 59

MiniCut – 整体硬质合金切削头 – 反镗

▲ $CDX = ap_{max}$ (取决于材料)



图示为右手刀具

CWX500

CWX500



左手刀具

73 332 ...

右手刀具

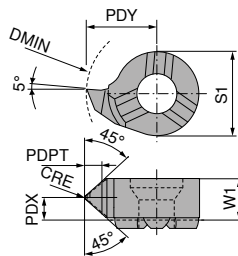
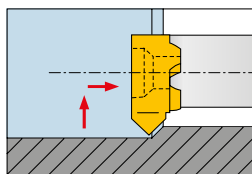
73 330 ...

尺寸	规格型号	DMIN mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	RE mm	CDX mm		
08	8,00. R/L .30°1,3	7.8	1.3	3.50	1.0	4.65	6.0	0.2	0.6	013	013
09	9,00. R/L .30°1,7	9.0	1.7	3.55	1.2	5.50	6.2	0.2	0.8	117	117
	9,00. R/L .30°2,3	10.0	2.3	3.55	1.2	6.50	6.2	0.2	0.8	123	123
11	11,00. R/L .30°2,3	11.0	2.3	4.30	1.6	6.70	8.0	0.2	1.0	323	323
14	14,00. R/L .30°3,5	13.8	3.5	5.40	2.4	8.70	9.0	0.2	1.5	535	535
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

→ v_c 请参见页码 59

MiniCut – 整体硬质合金切削头 – 镗孔/倒角

▲ $CDX = ap_{max}$ (取决于材料)



图示为右手刀具

CWX500

CWX500



左手刀具

73 336 ...

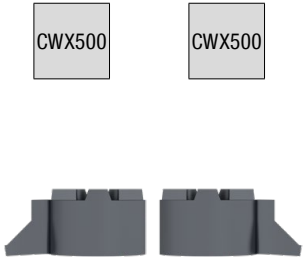
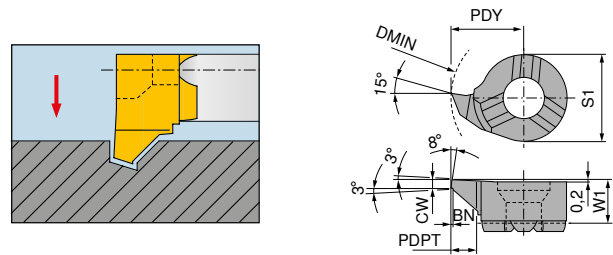
右手刀具

73 334 ...

尺寸	规格型号	DMIN mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	CRE mm	CDX mm		
08	8,00. R/L .45°1,4	8	1.4	3.50	1.8	4.8	6.0	0.2	0.6	010	010
09	9,00. R/L .45°1,3	9	1.3	3.55	1.8	5.5	6.2	0.2	0.8	110	110
11	11,00. R/L .45°1,5	11	1.5	4.30	2.2	6.7	8.0	0.2	1.0	310	310
14	14,00. R/L .45°1,5	14	1.5	5.40	2.8	9.0	9.0	0.2	1.2	510	510
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

→ v_c 请参见页码 59

MiniCut – 整体硬质合金切削头 – 预切槽/倒角



图示为右手刀具

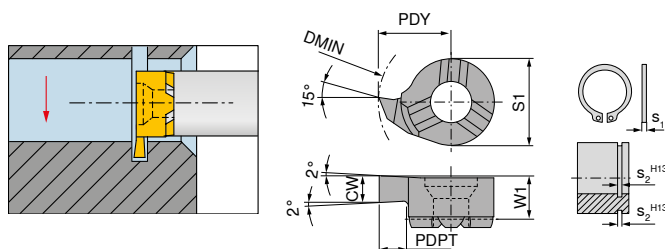
尺寸	规格型号	DMIN mm	CW mm	PDPT mm	W1 mm	PDY mm	S1 mm	BN mm	左手刀具		右手刀具	
									73 340 ...		73 338 ...	
08	8,00. R/L .1,00.45°	8	1	1.0	3.3	4.8	6.0	0.2		100		100
09	9,00. R/L .1,00.45°	9	1	1.5	3.6	5.5	6.2	0.2		215		215
11	11,00. R/L .1,00.45°	11	1	1.5	4.2	6.7	8.0	0.2		315		315
14	14,00. R/L .1,00.45°	14	1	1.5	5.3	9.0	9.0	0.2		515		515
16	16,00. R/L .1,00.45°	16	1	1.5	5.4	10.2	11.0	0.2		715		715
P									●		●	
M									●		●	
K									●		●	
N									●		●	
S									●		●	
H									●		●	
O									●		●	

→ v_c 请参见页码 59

MiniCut - 整体硬质合金切削头 - 切槽

CWX500

CWX500



图示为右手刀具

左手刀具

右手刀具

73 312 ...

73 310 ...

尺寸	规格型号	DMIN mm	CW mm	PDPT mm	W1 mm	S1 mm	S2 H13 mm	PDY mm	S1 mm		
08	8,00. R/L .073.1,0	8	0.73	1.0	3.3	0.6	0.7	4.8	6.0	073	073
	8,00. R/L .083.1,0	8	0.83	1.0	3.3	0.7	0.8	4.8	6.0	083	083
	8,00. R/L .093.1,0	8	0.93	1.0	3.3	0.8	0.9	4.8	6.0	093	093
	8,00. R/L .100.1,0	8	1.00	1.0	3.3			4.8	6.0	110	110
	8,00. R/L .120.1,0	8	1.20	1.0	3.3	1.0	1.1	4.8	6.0	112	112
	8,00. R/L .140.1,0	8	1.40	1.0	3.3	1.2	1.3	4.8	6.0	114	114
	8,00. R/L .150.1,0	8	1.50	1.0	3.3			4.8	6.0	115	115
	8,00. R/L .170.1,0	8	1.70	1.0	3.3	1.5	1.6	4.8	6.0	117	117
	8,00. R/L .200.1,0	8	2.00	1.0	3.3			4.8	6.0	120	120
09	9,00. R/L .073.1,2	9	0.73	1.2	3.6	0.6	0.7	5.5	6.2	173	173
	9,00. R/L .083.1,3	9	0.83	1.3	3.6	0.7	0.8	5.5	6.2	183	183
	9,00. R/L .093.1,5	9	0.93	1.5	3.6	0.8	0.9	5.5	6.2	193	193
	9,00. R/L .100.1,8	9	1.00	1.8	3.6			5.5	6.2	210	210
	9,00. R/L .120.1,8	9	1.20	1.8	3.6	1.0	1.1	5.5	6.2	212	212
	9,00. R/L .140.1,8	9	1.40	1.8	3.6	1.2	1.3	5.5	6.2	214	214
	9,00. R/L .150.1,8	9	1.50	1.8	3.6			5.5	6.2	215	215
	9,00. R/L .170.1,8	9	1.70	1.8	3.6	1.5	1.6	5.5	6.2	217	217
	9,00. R/L .200.1,8	9	2.00	1.8	3.6			5.5	6.2	220	220
	9,00. R/L .250.1,8	9	2.50	1.8	3.6			5.5	6.2	225	225
	9,00. R/L .300.1,8	9	3.00	1.8	3.6			5.5	6.2	230	230
11	11,00. R/L .073.1,2	11	0.73	1.2	4.2	0.6	0.7	6.7	8.0	373	373
	11,00. R/L .083.1,3	11	0.83	1.3	4.2	0.7	0.8	6.7	8.0	383	383
	11,00. R/L .093.1,5	11	0.93	1.5	4.2	0.9	0.9	6.7	8.0		393
	11,00. L .093.1,5	11	0.93	1.5	4.2	0.8	0.9	6.7	8.0	393	
	11,00. R/L .100.2,3	11	1.00	2.3	4.2			6.7	8.0	310	310
	11,00. R/L .120.2,3	11	1.20	2.3	4.2	1.0	1.1	6.7	8.0	312	312
	11,00. R/L .140.2,3	11	1.40	2.3	4.2	1.2	1.3	6.7	8.0	314	314
	11,00. R/L .150.2,3	11	1.50	2.3	4.2			6.7	8.0	315	315
	11,00. R/L .170.2,3	11	1.70	2.3	4.2	1.5	1.6	6.7	8.0	317	317
	11,00. R/L .200.2,3	11	2.00	2.3	4.2			6.7	8.0	320	320
	11,00. R/L .250.2,3	11	2.50	2.3	4.2			6.7	8.0	325	325
	11,00. R/L .300.2,3	11	3.00	2.3	4.2			6.7	8.0	330	330
14	14,00. R/L .073.1,2	14	0.73	1.2	5.3	0.6	0.7	9.0	9.0	573	573
	14,00. R/L .083.1,3	14	0.83	1.3	5.3	0.7	0.8	9.0	9.0	583	583
	14,00. R/L .093.1,5	14	0.93	1.5	5.3	0.8	0.9	9.0	9.0	593	593
	14,00. R/L .120.4,0	14	1.20	4.0	5.3	1.0	1.1	9.0	9.0	512	512
	14,00. R/L .140.4,0	14	1.40	4.0	5.3	1.2	1.3	9.0	9.0	514	514
	14,00. R/L .150.4,0	14	1.50	4.0	5.3			9.0	9.0	515	515
	14,00. R/L .170.4,0	14	1.70	4.0	5.3	1.5	1.6	9.0	9.0	517	517
	14,00. R/L .200.4,0	14	2.00	4.0	5.3			9.0	9.0	520	520
	14,00. R/L .250.4,0	14	2.50	4.0	5.3			9.0	9.0	525	525
	14,00. R/L .300.4,0	14	3.00	4.0	5.3			9.0	9.0	530	530
16	16,00. R/L .073.1,2	16	0.73	1.2	5.4	0.6	0.7	10.2	11.0	773	773
	16,00. R/L .083.1,3	16	0.83	1.3	5.4	0.7	0.8	10.2	11.0	783	783
	16,00. R/L .093.1,5	16	0.93	1.5	5.4	0.8	0.9	10.2	11.0	793	793
	16,00. R/L .120.4,3	16	1.20	4.3	5.4	1.0	1.1	10.2	11.0	712	712
	16,00. R/L .140.4,3	16	1.40	4.3	5.4	1.2	1.3	10.2	11.0	714	714
	16,00. R/L .150.4,3	16	1.50	4.3	5.4			10.2	11.0	715	715
	16,00. R/L .170.4,3	16	1.70	4.3	5.4	1.5	1.6	10.2	11.0	717	717
	16,00. R/L .200.4,3	16	2.00	4.3	5.4			10.2	11.0	720	720
	16,00. R/L .250.4,3	16	2.50	4.3	5.4			10.2	11.0	725	725
	16,00. R/L .300.4,3	16	3.00	4.3	5.4			10.2	11.0	730	730
	16,00. R/L .350.4,3	16	3.50	4.3	5.4			10.2	11.0	735	735
	16,00. R/L .400.4,3	16	4.00	4.3	5.4			10.2	11.0	740	740

P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	●	●
O	●	●

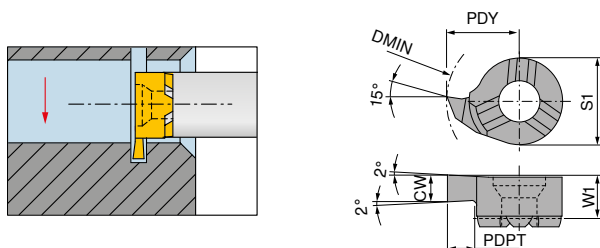
→ v_c 请参见页码 59

MiniCut - 整体硬质合金切削头 - 切槽

▲ 深槽加工 (最大槽深 T_{max} 5.5 mm)

CW500

CW500



图示为右手刀具

尺寸	规格型号	DMIN mm	CW ^{+0.03} mm	PDPT mm	W1 mm	PDY mm	S1 mm	左手刀具 73 372 ...	右手刀具 73 370 ...
14	14,00. R/L 1,50.5,5	16	1.5	5.5	5.2	10.5	9	715	715
	14,00. R/L 2,00.5,5	16	2.0	5.5	5.2	10.5	9	720	720
	14,00. R/L 2,50.5,5	16	2.5	5.5	5.2	10.5	9	725	725
	14,00. R/L 3,00.5,5	16	3.0	5.5	5.2	10.5	9	730	730
P								●	●
M								●	●
K								●	●
N								●	●
S								●	●
H								●	●
O								●	●

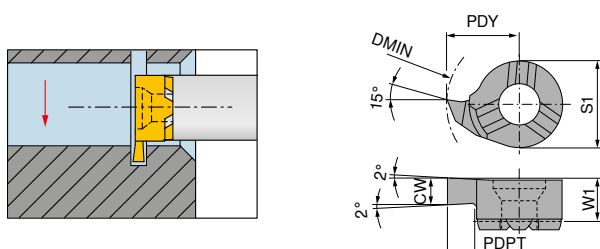
→ v_c 请参见页码 59

MiniCut - 整体硬质合金切削头 - 切槽

▲ 深槽加工 (最大槽深 T_{max} 6.5 mm)

CW500

CW500



图示为右手刀具

尺寸	规格型号	DMIN mm	CW ^{+0.03} mm	PDPT mm	W1 mm	PDY mm	S1 mm	左手刀具 73 384 ...	右手刀具 73 382 ...
14	14,00. R/L 1,50.6,5	17	1.5	6.5	5.2	11.5	9	515	515
	14,00. R/L 2,00.6,5	17	2.0	6.5	5.2	11.5	9	520	520
	14,00. R/L 2,50.6,5	17	2.5	6.5	5.2	11.5	9	525	525
	14,00. R/L 3,00.6,5	17	3.0	6.5	5.2	11.5	9	530	530
P								●	●
M								●	●
K								●	●
N								●	●
S								●	●
H								●	●
O								●	●

→ v_c 请参见页码 59

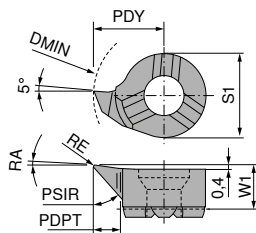
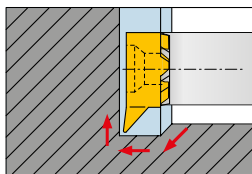
12

MiniCut – 整体硬质合金切削头 – 内径退刀槽加工

▲ $CDX = ap_{max}$ (取决于材料)

CWX500

CWX500



图示为右手刀具

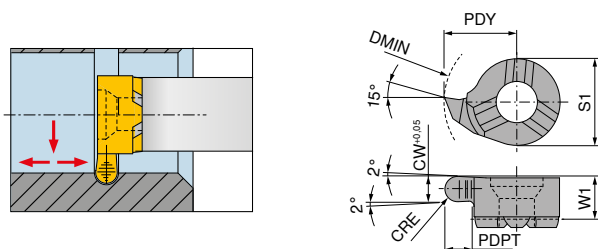
尺寸	规格型号	DMIN mm	PDPT mm	W1 mm	PDY mm	S1 mm	RE mm	CDX mm	PSIR °	RA °	左手刀具		右手刀具	
											73 328 ...		73 326 ...	
08	8,00. R/L .30°1,0	7.8	1.0	3.5	4.65	6.0	0.2	0.4	30	3	010		010	
	8,00. R/L .47°1,2	7.8	1.2	3.5	4.65	6.0	0.2	0.4	47	3	012		012	
09	9,00. R/L .47°1,5	9.0	1.5	3.6	5.50	6.2	0.2	0.5	47	3	115		115	
11	11,00. R/L .30°2,3	11.0	2.3	4.2	6.70	8.0	0.2	0.6	30	3	423		423	
	11,00. R/L .47°2,3	11.0	2.3	4.2	6.70	8.0	0.2	0.6	47	3	323		323	
14	13,70. R/L .47°3,0	13.7	3.0	5.3	8.70	9.0	0.2	0.8	47	3	530		530	
	13,70. R/L .30°4,0	13.7	4.0	5.3	8.70	9.0	0.2	0.8	30	3	540		540	
16	15,80. R/L .30°4,3	15.8	4.3	5.4	10.20	11.0	0.2	1.0	30	3	744		744	
P											●		●	
M											●		●	
K											●		●	
N											●		●	
S											●		●	
H											●		●	
O											●		●	

→ v_c 请参见页码 59

MiniCut - 整体硬质合金切削头 - 切槽/仿形车削 (全圆弧)

CWX500

CWX500

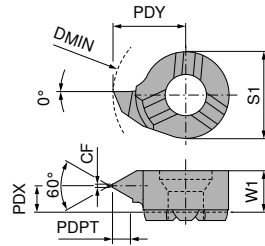
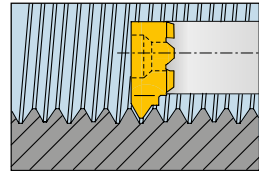


图示为右手刀具

尺寸	规格型号	DMIN mm	CW mm	PDPT mm	W1 mm	PDY mm	S1 mm	CRE mm	左手刀具		右手刀具	
									73 320 ...		73 318 ...	
08	8,00. R/L .0,80.1,0	8	0.8	1.0	3.3	4.8	6.0	0.4		008		008
	8,00. R/L .1,20.1,0	8	1.2	1.0	3.3	4.8	6.0	0.6		012		012
	8,00. R/L .1,80.1,0	8	1.8	1.0	3.3	4.8	6.0	0.9		018		018
	8,00. R/L .2,00.1,0	8	2.0	1.0	3.3	4.8	6.0	1.0		020		020
09	9,00. R/L .0,80.1,6	9	0.8	1.6	3.6	5.5	6.2	0.4		108		108
	9,00. R/L .1,20.1,6	9	1.2	1.6	3.6	5.5	6.2	0.6		112		112
	9,00. R/L .1,80.1,6	9	1.8	1.6	3.6	5.5	6.2	0.9		118		118
	9,00. R/L .2,00.1,6	9	2.0	1.6	3.6	5.5	6.2	1.0		120		120
11	11,00. R/L .0,80.2,3	11	0.8	2.3	4.2	6.7	8.0	0.4		308		308
	11,00. R/L .1,20.2,3	11	1.2	2.3	4.2	6.7	8.0	0.6		312		312
	11,00. R/L .1,60.2,3	11	1.6	2.3	4.2	6.7	8.0	0.8		316		316
	11,00. R/L .1,80.2,3	11	1.8	2.3	4.2	6.7	8.0	0.9		318		318
	11,00. R/L .2,00.2,3	11	2.0	2.3	4.2	6.7	8.0	1.0		320		320
	11,00. R/L .2,40.2,3	11	2.4	2.3	4.2	6.7	8.0	1.2		324		324
	11,00. R/L .3,00.2,3	11	3.0	2.3	4.2	6.7	8.0	1.5		330		330
14	14,00. R/L .0,80.4,0	14	0.8	4.0	5.3	9.0	9.0	0.4		508		508
	14,00. R/L .1,20.4,0	14	1.2	4.0	5.3	9.0	9.0	0.6		512		512
	14,00. R/L .1,80.4,0	14	1.8	4.0	5.3	9.0	9.0	0.9		518		518
	14,00. R/L .2,00.4,0	14	2.0	4.0	5.3	9.0	9.0	1.0		520		520
	14,00. R/L .2,20.4,0	14	2.2	4.0	5.3	9.0	9.0	1.1		522		522
	14,00. R/L .3,00.4,0	14	3.0	4.0	5.3	9.0	9.0	1.5		530		530
16	16,00. R/L .1,60.4,3	16	1.6	4.3	5.4	10.2	11.0	0.8		716		716
	16,00. R/L .1,80.4,3	16	1.8	4.3	5.4	10.2	11.0	0.9		718		718
	16,00. R/L .2,00.4,3	16	2.0	4.3	5.4	10.2	11.0	1.0		720		720
	16,00. R/L .2,20.4,3	16	2.2	4.3	5.4	10.2	11.0	1.1		722		722
	16,00. R/L .2,40.4,3	16	2.4	4.3	5.4	10.2	11.0	1.2		724		724
	16,00. R/L .3,00.4,3	16	3.0	4.3	5.4	10.2	11.0	1.5		730		730
	16,00. R/L .3,20.4,3	16	3.2	4.3	5.4	10.2	11.0	1.6		732		732
	16,00. R/L .4,00.4,3	16	4.0	4.3	5.4	10.2	11.0	2.0		740		740
P									●		●	
M									●		●	
K									●		●	
N									●		●	
S									●		●	
H									●		●	
O									●		●	

→ v_c 请参见页码 59

MiniCut - 整体硬质合金切削头 - 内螺纹车削 (半牙型)



图示为右手刀具

CWX500

CWX500



左手刀具

73 344 ...

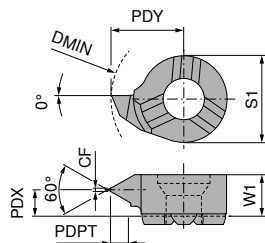
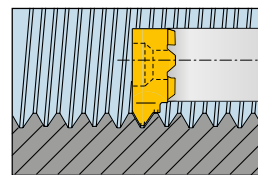
右手刀具

73 342 ...

尺寸	规格型号	DMIN mm	TP mm	CF mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm		
08	8,00. R/L .0,5/0,75.60°	8	0,5 - 0,75	0.06	0.43	3.50	2.7	4.8	6.0		
	8,00. R/L .1,0/1,25.60°	8	1,0 - 1,25	0.12	0.70	3.50	2.7	4.8	6.0		
	8,00. R/L .1,5/1,75.60°	8	1,5 - 1,75	0.18	0.95	3.50	2.5	4.8	6.0		
09	9,00. R/L .0,5/0,75.60°	9	0,5 - 0,75	0.06	0.27	3.55	3.2	5.5	6.2		
	9,00. R/L .1,0/1,25.60°	9	1,0 - 1,25	0.12	0.54	3.55	3.0	5.5	6.2		
	9,00. R/L .1,5/1,75.60°	9	1,5 - 1,75	0.18	0.81	3.55	2.8	5.5	6.2		
	9,00. R/L .1,75/2,0.60°	9	1,75 - 2,0	0.20	0.95	3.55	2.6	5.5	6.2		
	9,00. R/L .2,0/2,5.60°	9	2,0 - 2,5	0.25	1.08	3.55	2.5	5.5	6.2		
	9,00. R/L .2,5/3,0.60°	9	2,5 - 3,0	0.31	1.35	3.55	2.1	5.5	6.2		
	9,00. R/L .3,0/3,5.60°	9	3,0 - 3,5	0.37	1.62	3.55	1.9	5.5	6.2		
11	11,00. R/L .0,5/0,75.60°	11	0,5 - 0,75	0.06	0.75	4.30	3.5	6.7	8.0		
	11,00. R/L .1,0/1,25.60°	11	1,0 - 1,25	0.12	0.55	4.30	3.5	6.7	8.0		
	11,00. R/L .1,5/1,75.60°	11	1,5 - 1,75	0.18	0.81	4.30	3.5	6.7	8.0		
	11,00. R/L .2,0/2,5.60°	11	2,0 - 2,5	0.25	1.08	4.30	3.0	6.7	8.0		
	11,00. R/L .2,5/3,0.60°	11	2,5 - 3,0	0.31	1.35	4.30	3.0	6.7	8.0		
14	14,00. R/L .1,0/1,25.60°	14	1,0 - 1,25	0.12	0.55	5.40	4.7	9.0	9.0		
	14,00. R/L .1,5/1,75.60°	14	1,5 - 1,75	0.18	0.81	5.40	4.5	9.0	9.0		
	14,00. R/L .2,0/2,5.60°	14	2,0 - 2,5	0.25	1.08	5.40	4.2	9.0	9.0		
	14,00. R/L .2,5/3,0.60°	14	2,5 - 3,0	0.31	1.35	5.40	4.7	9.0	9.0		
16	16,00. R/L .1,0/1,25.60°	16	1,0 - 1,25	0.12	0.55	5.50	4.7	10.2	11.0		
	16,00. R/L .1,5/1,75.60°	16	1,5 - 1,75	0.18	0.81	5.50	4.5	10.2	11.0		
	16,00. R/L .2,0/2,5.60°	16	2,0 - 2,5	0.25	1.08	5.50	4.2	10.2	11.0		
	16,00. R/L .2,5/3,0.60°	16	2,5 - 3,0	0.31	1.35	5.50	4.2	10.2	11.0		
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

→ v_c 请参见页码 59

MiniCut - 整体硬质合金切削头 - 内螺纹车削 (半牙型)

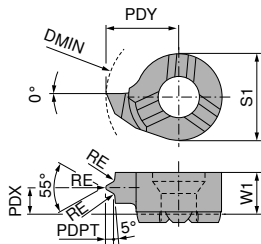
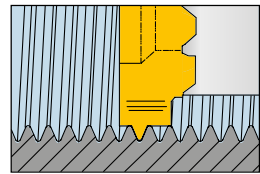
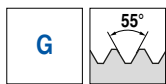


图示为右手刀具

尺寸	规格型号	DMIN mm	TP mm	CF mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	左手刀具		右手刀具	
										73 348 ...		73 346 ...	
09	9,00. R/L .0,5.60°	9	0.50	0.06	0.27	3.55	3.25	5.5	6.2	405		405	
	9,00. R/L .1,0.60°	9	1.00	0.12	0.54	3.55	3.00	5.5	6.2	410		410	
	9,00. R/L .1,5.60°	9	1.50	0.18	0.81	3.55	2.80	5.5	6.2	415		415	
	9,00. R/L .1,75.60°	9	1.75	0.20	0.95	3.55	2.70	5.5	6.2	418		418	
	9,00. R/L .2,0.60°	9	2.00	0.25	1.08	3.55	2.60	5.5	6.2	420		420	
	9,00. R/L .2,5.60°	9	2.50	0.31	1.35	3.55	2.50	5.5	6.2	425		425	
	9,00. R/L .3,0.60°	9	3.00	0.37	1.62	3.55	2.20	5.5	6.2	430		430	
11	11,00. R/L .1,0.60°	11	1.00	0.12	0.54	4.30	3.50	6.7	8.0	314		314	
	11,00. R/L .1,5.60°	11	1.50	0.18	0.81	4.30	3.50	6.7	8.0	316		316	
	11,00. R/L .2,0.60°	11	2.00	0.25	1.08	4.30	3.20	6.7	8.0	310		310	
	11,00. R/L .2,5.60°	11	2.50	0.31	1.35	4.30	3.00	6.7	8.0	320		320	
	11,00. R/L .3,0.60°	11	3.00	0.37	1.62	4.30	2.90	6.7	8.0	330		330	
14	14,00. R/L .0,5.60°	14	0.50	0.06	0.27	5.40	3.50	9.0	9.0	510		510	
	14,00. R/L .1,0.60°	14	1.00	0.12	0.54	5.40	3.50	9.0	9.0	512		512	
	14,00. R/L .1,5.60°	14	1.50	0.18	0.81	5.40	3.30	9.0	9.0	514		514	
	14,00. R/L .2,0.60°	14	2.00	0.25	1.08	5.40	4.20	9.0	9.0	610		610	
	14,00. R/L .2,5.60°	14	2.50	0.31	1.35	5.40	4.70	9.0	9.0	520		520	
16	16,00. R/L .1,0.60°	16	1.00	0.12	0.54	5.50	4.70	10.2	11.0	712		712	
	16,00. R/L .1,5.60°	16	1.50	0.18	0.81	5.50	4.50	10.2	11.0	714		714	
	16,00. R/L .2,0.60°	16	2.00	0.25	1.08	5.50	4.20	10.2	11.0	716		716	
	16,00. R/L .2,5.60°	16	2.50	0.31	1.35	5.50	4.20	10.2	11.0	710		710	
	16,00. R/L .3,0.60°	16	3.00	0.37	1.62	5.50	4.00	10.2	11.0	720		720	
	16,00. R/L .3,5.60°	16	3.50	0.43	1.89	5.50	3.80	10.2	11.0	730		730	
	16,00. R/L .4,0.60°	16	4.00	0.50	2.16	5.50	3.60	10.2	11.0	740		740	
P										●		●	
M										●		●	
K										●		●	
N										●		●	
S										●		●	
H										●		●	
O										●		●	

→ v_c 请参见页码 59

MiniCut - 整体硬质合金切削头 - 内螺纹车削 (半牙型)



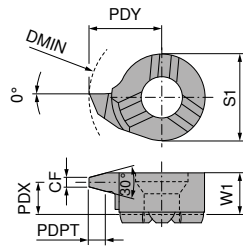
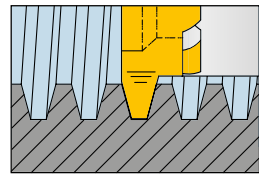
图示为右手刀具

尺寸	规格型号	DMIN mm	TP mm	TPI 1/"	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	RE mm	左手刀具		右手刀具	
											73 352 ...		73 350 ...	
11	11,00. R/L .1,814.55°	11	1.814	14	1.16	4.30	3.0	6.7	8	0.24		306		306
	11,00. R/L .1,337.55°	11	1.337	19	0.85	4.30	2.7	6.7	8	0.18		304		304
14	14,00. R/L .1,814.55°	14	1.814	14	1.16	5.35	3.6	9.0	9	0.24		506		506
	14,00. R/L .1,337.55°	14	1.337	19	0.85	5.35	3.8	9.0	9	0.18		504		504
16	16,00. R/L .2,309.55°	16	2.309	11	1.48	5.50	3.5	10.2	11	0.31		708		708
	16,00. R/L .1,814.55°	16	1.814	14	1.16	5.50	3.9	10.2	11	0.24		706		706
P											●		●	
M											●		●	
K											●		●	
N											●		●	
S											●		●	
H											●		●	
O											●		●	

→ v_c 请参见页码 59

MiniCut – 整体硬质合金切削头 – 内螺纹车削 (半牙型)

▲ 梯形螺纹 DIN103



CWX500

CWX500



图示为右手刀具

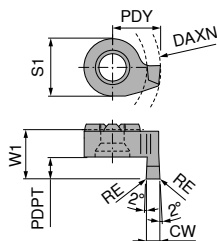
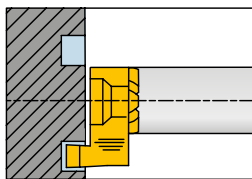
尺寸	规格型号	DMIN mm	TP mm	CF mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	左手刀具		右手刀具	
										73 356 ...		73 354 ...	
09	9,00. R/L .1,5.30°	9	1.5	0.47	0.90	3.55	3.00	5.5	6.2	415		415	
	9,00. R/L .2,0.30°	9	2.0	0.60	1.25	3.55	2.85	5.5	6.2	420		420	
	9,00. R/L .3,0.30°	9	3.0	0.96	1.75	3.55	2.25	5.5	6.2	430		430	
	9,00. R/L .4,0.30°	10	4.0	1.33	2.25	3.55	2.25	5.5	6.2	440		440	
11	11,00. R/L .1,5.30°	11	1.5	0.47	0.90	4.30	3.70	6.7	8.0	315		315	
	11,00. R/L .2,0.30°	11	2.0	0.60	1.25	4.30	3.50	6.7	8.0	320		320	
	11,00. R/L .3,0.30°	11	3.0	0.96	1.75	4.30	3.20	6.7	8.0	330		330	
	11,00. R/L .4,0.30°	11	4.0	1.33	2.25	3.95	2.60	6.7	8.0	340		340	
14	14,00. R/L .2,0.30°	14	2.0	0.60	1.25	5.30	4.30	9.0	9.0	520		520	
	14,00. R/L .3,0.30°	14	3.0	0.96	1.75	5.30	4.00	9.0	9.0	530		530	
	14,00. R/L .4,0.30°	14	4.0	1.33	2.25	5.30	3.60	9.0	9.0	540		540	
	14,00. R/L .5,0.30°	14	5.0	1.69	2.75	5.30	3.30	9.0	9.0	550		550	
16	16,00. R/L .2,0.30°	16	2.0	0.60	1.25	5.50	4.50	9.7	11.0	720		720	
	16,00. R/L .3,0.30°	16	3.0	0.96	1.75	5.50	4.30	9.7	11.0	730		730	
	16,00. R/L .4,0.30°	16	4.0	1.33	2.25	5.50	4.00	9.7	11.0	740		740	
	16,00. R/L .5,0.30°	16	5.0	1.69	2.75	5.50	3.55	9.7	11.0	750		750	
	16,00. R/L .6,0.30°	16	6.0	1.92	3.50	5.50	3.30	10.2	11.0	760		760	
P										●		●	
M										●		●	
K										●		●	
N										●		●	
S										●		●	
H										●		●	
O										●		●	

→ v_c 请参见页码 59

MiniCut - 整体硬质合金切削头 - 轴向切槽

CWX500

CWX500



图示为右手刀具

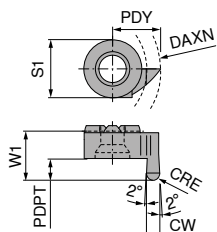
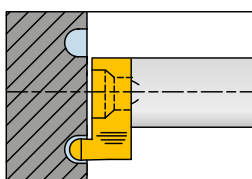
尺寸	规格型号	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	RE mm	S1 mm	左手刀具 73 364 ...	右手刀具 73 362 ...
14	14,00. R/L .1,0,1,5	14	1.0	1.5	8.3	9		9	510	510
	14,00. R/L .1,5,2,5	14	1.5	2.5	8.3	9	0.2	9	515	515
	14,00. R/L .2,0,3,0	14	2.0	3.0	8.3	9	0.2	9	520	520
	14,00. R/L .2,0,5,0	14	2.0	5.0	10.3	9	0.2	9	620	620
	14,00. R/L .2,5,3,0	14	2.5	3.0	8.3	9	0.2	9	525	525
	14,00. R/L .2,5,5,0	14	2.5	5.0	10.3	9	0.2	9	625	625
	14,00. R/L .3,0,3,0	14	3.0	3.0	8.3	9	0.2	9	530	530
	14,00. R/L .3,0,5,0	14	3.0	5.0	10.3	9	0.2	9	630	630
P									●	●
M									●	●
K									●	●
N									●	●
S									●	●
H									●	●
O									●	●

→ v_c 请参见页码 59

MiniCut - 整体硬质合金切削头 - 轴向切槽 (全圆弧)

CWX500

CWX500



图示为右手刀具

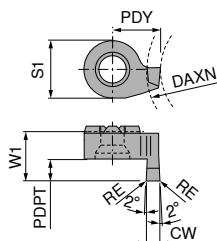
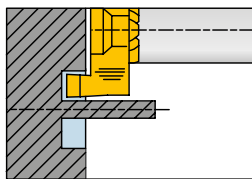
尺寸	规格型号	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	CRE mm	S1 mm	左手刀具 73 376 ...	右手刀具 73 374 ...
14	14,00. R/L .1,0,1,5	14	1.0	1.5	8.3	9	0.5	9	510	510
	14,00. R/L .1,6,2,5	14	1.6	2.5	8.3	9	0.8	9	516	516
	14,00. R/L .2,0,3,0	14	2.0	3.0	8.3	9	1.0	9	520	520
	14,00. R/L .2,5,3,0	14	2.5	3.0	8.3	9	1.2	9	525	525
	14,00. R/L .3,0,3,0	14	3.0	3.0	8.3	9	1.5	9	530	530
P									●	●
M									●	●
K									●	●
N									●	●
S									●	●
H									●	●
O									●	●

→ v_c 请参见页码 59

MiniCut – 整体硬质合金切削头 – 轴向切槽 (轴颈)

CWX500

CWX500



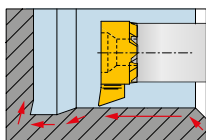
图示为右手刀具

尺寸	规格型号	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	RE mm	S1 mm	左手刀具		右手刀具	
									73 360 ...		73 358 ...	
14	14/12. R/L .1,0,1,5	12	1.0	1.5	8.3	7.0		9	310		310	
	14/12. R/L .1,5,2,5	12	1.5	2.5	8.3	7.5	0.2	9	315		315	
	14/12. R/L .2,0,3,0	12	2.0	3.0	8.3	8.0	0.2	9	320		320	
	14/12. R/L .2,0,5,0	12	2.0	5.0	10.3	8.0	0.2	9	420		420	
	14/12. R/L .2,5,3,0	12	2.5	3.0	8.3	8.5	0.2	9	325		325	
	14/12. R/L .2,5,5,0	12	2.5	5.0	10.3	8.5	0.2	9	425		425	
	14/12. R/L .3,0,3,0	12	3.0	3.0	8.3	9.0	0.2	9	330		330	
	14/12. R/L .3,0,5,0	12	3.0	5.0	10.3	9.0	0.2	9	430		430	
P									●		●	
M									●		●	
K									●		●	
N									●		●	
S									●		●	
H									●		●	
O									●		●	

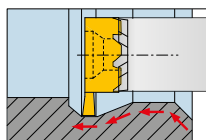
→ v_c 请参见页码 59

MiniCut – 套件

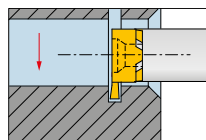
- ▲ 丰富的09 尺寸系列
- ▲ CWX 500



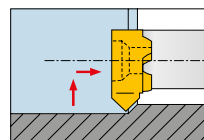
仿形车削 (K)



仿形车削 (A)



切槽 (E)



倒角 (F)

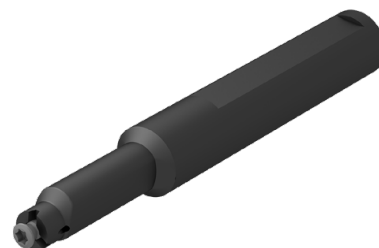
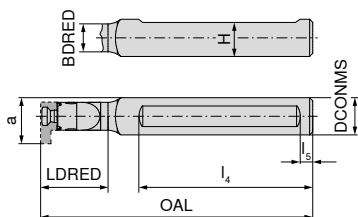


73 528 ...

规格	刀具	规格型号	订货编号:	孔径 mm	宽度 mm	切槽深度 mm	/个	图	125
09	切槽刀片	9,00. R .1,00,1,8	73 310 210	9	1,00	1,8	1	E	
	NC 精车刀片	9,00. R .2,00,2,0	73 314 120	9	2,0 +0,05	2,0	1	A	
	仿形车削刀片	9,00. R .3,60,10°	73 386 136	9	3,6		1	K	
	仿形车削刀片	9,00. R .3,60,20°	73 322 236	9	3,6		1	K	
	倒角刀片	9,00. R .45°,1,3	73 334 110	9		1,3	1	F	
	刀杆	9,00/16.N.25,1,0	73 522 125				1		
	扳手		70 950 105				1		

12

MiniCut – 钢质刀杆



73 522 ...

尺寸	规格型号	a mm	DCONMS ₁₇ mm	OAL mm	l ₄ mm	LDRED mm	BDRED mm	H mm	l ₅ mm	
08	8,00/16.N.12.1,0	7.8	16	80	60	12	6.0	15.0	5	012
	8,00/16.N.22.1,0	7.8	16	90	60	22	6.0	15.0	5	122
09	9,00/16.N.14.1,8	8.6	16	95	60	14	7.4	15.0	5	014
	9,00/16.N.25.1,8	8.6	16	105	60	25	7.4	15.0	5	125
11	11,00/16.N.16.2,3	10.7	16	97	60	16	8.0	14.5	5	016
	11,00/16.N.29.2,3	10.7	16	110	60	29	8.0	14.5	5	129
14	14,00/16.N.18.4,0	13.8	16	100	60	18	11.0	14.5	5	018
	14,00/16.N.38.4,0	13.8	16	120	60	38	11.0	14.5	5	138
16	16,00/16.N.22.4,3	15.7	16	100	60	22	11.0	14.5	5	022
	16,00/16.N.42.4,3	15.7	16	120	60	42	11.0	14.5	5	142



扳手-D



刀片螺钉

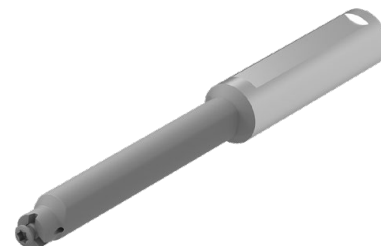
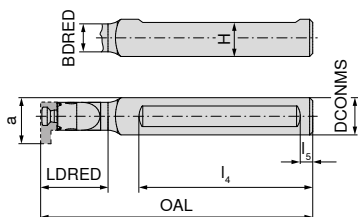
80 950 ...

73 082 ...

备件
尺寸

08	T08	110	M2,6	002
09	T08	110	M2,6	002
11	T10	112	M3,5	003
14	T15	113	M4	004
16	T20	114	M5	005

MiniCut – 硬质合金抗振刀杆



73 520 ...

尺寸	规格型号	a mm	DCONMS ₁₇ mm	OAL mm	l ₄ mm	LDRED mm	BDRED mm	H mm	l ₅ mm	
08	8,00/12.N.21.1,0 HM	7.8	12	80	48	21	6.0	11.0	5	021
	8,00/12.N.30.1,0 HM	7.8	12	90	48	30	6.0	11.0	5	030
	8,00/12.N.42.1,0 HM	7.8	12	100	48	42	6.0	11.0	5	042
	8,00/12.N.50.1,0 HM	7.8	12	115	48	50	6.0	11.0	5	050
09	9,00/12.N.22.1,0 HM	8.6	12	90	60	22	7.4	11.0	5	222
	9,00/12.N.30.2,0 HM	8.6	12	98	60	30	7.4	11.0	5	230
	9,00/12.N.42.3,0 HM	8.6	12	110	60	42	7.4	11.0	5	242
	9,00/12.N.56.4,0 HM	8.6	12	122	60	56	7.4	11.0	5	256
11	11,00/12.N.29.2,3 HM	10.7	12	95	60	29	8.0	10.5	5	129
	11,00/12.N.42.2,3 HM	10.7	12	110	60	42	8.0	10.5	5	142
	11,00/12.N.56.2,3 HM	10.7	12	120	60	56	8.0	10.5	5	156
	11,00/12.N.64.2,3 HM	10.7	12	130	60	64	8.0	10.5	5	164
14	14,00/12.N.34.4,0 HM	13.8	12	100	60	34	11.0	10.5	5	234
	14,00/12.N.45.4,0 HM	13.8	12	110	60	45	11.0	10.5	5	245
	14,00/12.N.64.4,0 HM	13.8	12	130	60	64	11.0	10.5	5	264
	14,00/16.N.34.4,0 HM	13.8	16	100	60	34	11.0	14.5	5	334
	14,00/16.N.45.4,0 HM	13.8	16	110	60	45	11.0	14.5	5	345
	14,00/16.N.64.4,0 HM	13.8	16	130	60	64	11.0	14.5	5	364
	14,00/16.N.75.4,0 HM	13.8	16	145	60	75	11.0	14.5	5	375
16	16,00/12.N.40.4,3 HM	15.7	12	130	60	40	11.0	10.5	5	440
	16,00/12.N.56.4,3 HM	15.7	12	130	60	56	11.0	10.5	5	456
	16,00/12.N.80.4,3 HM	15.7	12	150	60	80	11.0	10.5	5	480
	16,00/16.N.40.4,3 HM	15.7	16	130	60	40	11.0	14.5	5	540
	16,00/16.N.56.4,3 HM	15.7	16	130	60	56	11.0	14.5	5	556
	16,00/16.N.80.4,3 HM	15.7	16	150	60	80	11.0	14.5	5	580



扳手-D



刀片螺钉

80 950 ...

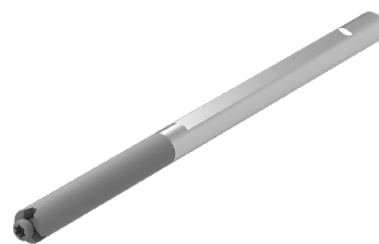
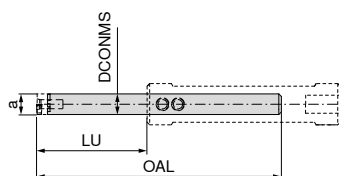
73 082 ...

备件
尺寸

08	T08	110	M2,6	002
09	T08	110	M2,6	002
11	T10	112	M3,5	003
14	T15	113	M4	004
16	T20	114	M5	005

12

MiniCut – HM – 多功能刀杆



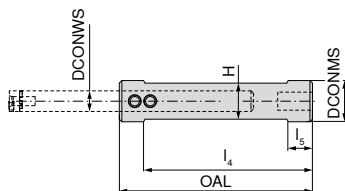
尺寸	规格型号	DCONMS mm	OAL mm	LU mm	a mm	
08	8,0/6.N16/2	6	65	18	8	818
	8,0/6.N40/4	6	103	40	8	840
11	11,0/8.N20/2	8	79	20	11	120 ¹⁾
	11,0/8.N50/4	8	129	50	11	150 ¹⁾

1) 带内冷却液孔

备件 尺寸		80 950 ...		73 082 ...
08	T08	110	M2,6	002
11	T10	112	M3,5	003



MiniCut – 整体硬质合金多功能刀杆基座



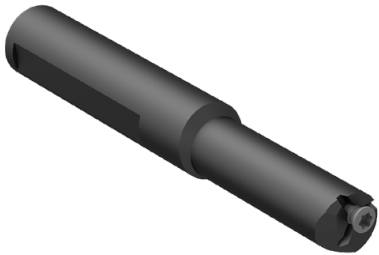
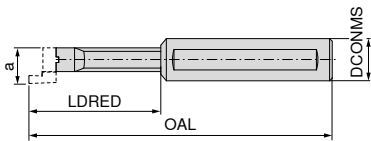
尺寸	规格型号	DCONWS mm	DCONMS mm	H mm	OAL mm	l4 mm	l5 mm	
08	8/16.75	6	16	14	75	55	10	816
	8/20.90	6	20	18	90	70	10	820
11	11/16.75	8	16	14	75	55	10	116
	11/20.90	8	20	18	90	70	10	120

备件 适用于:		70 950 ...		73 082 ...
73 526 816	SW2,5	175	M5x0,5x6	010
73 526 820	SW2,5	175	M5x0,5x6	010
73 526 116	SW2,5	175	M5x0,5x4	009
73 526 120	SW2,5	175	M5x0,5x6	010



MiniCut – 钢质刀杆

▲ 适用于轴向加工

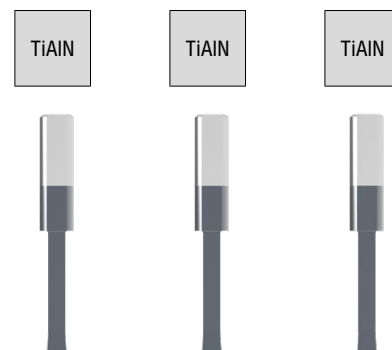
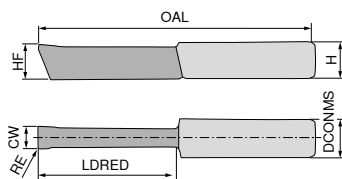


尺寸	规格型号	a mm	DCONMS mm	OAL mm	LDRED mm	左手刀具		右手刀具	
						73 523 ...		73 524 ...	
14	14,0/16. R/L .25.1,0	13.5	16	90	25	025		025	
	14,0/16. R/L .45.1,0	13.5	16	110	45	145		145	

备件
尺寸
14

扳手-D	刀片螺钉
80 950 ...	73 082 ...
T15	M4
113	004

SlotCut – 刀片 – DIN 138

▲ b_1 = 切槽宽度

规格型号	b_1 P9/JS9/C11	CW	HF	RE	OAL	LDRED	DMIN	DCONMS _{h6}	H	适用刀杆
NPU.0198.01.1	2	1.98	5.5	0.10	38	12.5	6	7	6.3	NHU
NPU.0200.01.1	2	2.01	5.5	0.10	38	12.5	6	7	6.3	NHU
NPU.0210.03.1	2	2.10	5.5	0.35	38	12.5	6	7	6.3	NHU
NPU.0298.01.1	3	2.98	6.2	0.10	38	12.5	7	7	6.3	NHU
NPU.0300.01.1	3	3.01	6.2	0.10	38	12.5	7	7	6.3	NHU
NPU.0310.03.1	3	3.10	6.2	0.35	38	12.5	7	7	6.3	NHU
NPU.0310.05.1	3	3.10	6.2	0.50	38	12.5	7	7	6.3	NHU
NPU.0398.01.1	4	3.98	6.2	0.10	40	15.0	7	7	6.3	NHU
NPU.0398.02.2	4	3.98	6.2	0.20	50	25.0	7	7	6.3	NHU
NPU.0400.01.1	4	4.01	6.2	0.10	40	15.0	7	7	6.3	NHU
NPU.0400.02.1	4	4.01	6.2	0.20	40	15.0	7	7	6.3	NHU
NPU.0400.02.2	4	4.01	6.2	0.20	50	25.0	7	7	6.3	NHU
NPU.0410.05.1	4	4.10	6.2	0.50	40	15.0	7	7	6.3	NHU
NPU.0410.05.2	4	4.10	6.2	0.50	50	25.0	7	7	6.3	NHU
NPU.0498.02.2	5	4.98	5.8	0.20	50	25.0	7	7	6.3	NHU
NPU.0500.02.2	5	5.01	5.8	0.20	50	25.0	8	7	6.3	NHU

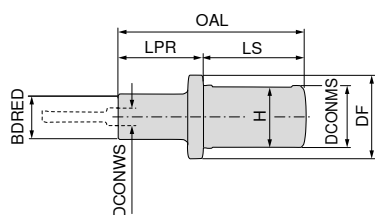
73 600 ...	73 601 ...	73 602 ...
098	099	099
099	100	100
100	101	101
101	102	102
102	103	103
103	104	104

公差 C 11 用于 73 600, 公差 JS 9 用于 73 601, 公差 P 9 用于 73 602

SlotCut – 刀杆

供货详情:

螺钉夹持式刀杆, 无刀片



规格型号	DCONWS	BDRED	DCONMS _{g6}	DF	OAL	LS	LPR	H	刀片
NHU.25	7	18	25	33	73	40	33	23	NPU
NHU.32	7	20	32	40	73	40	33	30	NPU

73 610 ...

025
032

扳手-I



锁紧螺钉

70 950 ...

73 082 ...

备件

适用于:

73 610 025

73 610 032

SW2,5

SW2,5

175

175

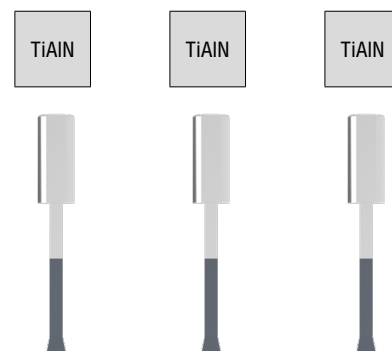
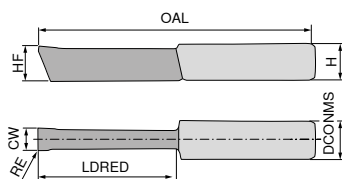
M5x6

M5x6

001

001

SlotCut – 刀片 – DIN 138

▲ b_1 = 切槽宽度

规格型号	b_1 JS9/P9/C11	CW	HF	RE	OAL	LDRED	DMIN	DCONMS _{g6}	H	适用刀杆
NP10.398.02.2	4	3.98	9	0.2	50	25	10	10	9.2	NH 10
NP10.398.02.3	4	3.98	9	0.2	66	41	10	10	9.2	NH 10
NP10.400.02.2	4	4.01	9	0.2	50	25	10	10	9.2	NH 10
NP10.400.02.3	4	4.01	9	0.2	66	41	10	10	9.2	NH 10
NP10.410.05.2	4	4.10	9	0.5	50	25	10	10	9.2	NH 10
NP10.410.05.3	4	4.10	9	0.5	66	41	10	10	9.2	NH 10
NP10.498.02.2	5	4.98	9	0.2	50	25	10	10	9.2	NH 10
NP10.498.02.3	5	4.98	9	0.2	66	41	10	10	9.2	NH 10
NP10.500.02.2	5	5.01	9	0.2	50	25	10	10	9.2	NH 10
NP10.500.02.3	5	5.01	9	0.2	66	41	10	10	9.2	NH 10
NP10.510.05.2	5	5.10	9	0.5	50	25	10	10	9.2	NH 10
NP10.510.05.3	5	5.10	9	0.5	66	41	10	10	9.2	NH 10

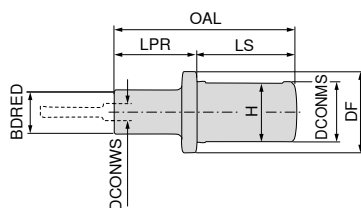
73 606 ...	73 607 ...	73 608 ...
	101	
	102	
		101
101		102
102		
	103	
	104	
		103
		104
103		
104		

1 公差 C 11 用于 73 606, 公差 P 9 用于 73 607, 公差 JS 9 用于 73 608

SlotCut – 刀杆

供货详情:

螺钉夹持式刀杆, 无刀片



12

规格型号	DCONWS	BRED	DCONMS _{g6}	DF	OAL	LS	LPR	H	刀片
NH10.0025.1	10	20	25	33	73	40	33	23	NP10
NH10.0032.1	10	20	32	40	73	40	33	30	NP10

73 612 ...

025
032

备件

73 612 032	SW3	176	M6x5,5	031
73 612 025	SW3	176	M6x5,5	031



扳手-I

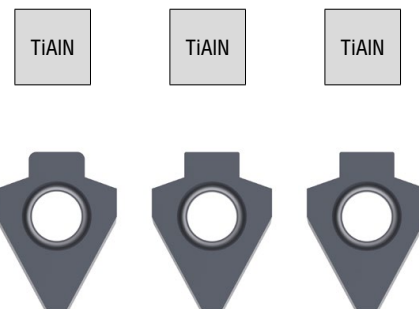
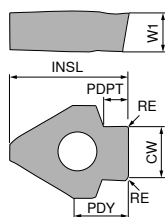


锁紧螺钉

70 950 ...

70 950 ...

SlotCut – 刀片 – DIN 138

▲ b_1 = 切槽宽度

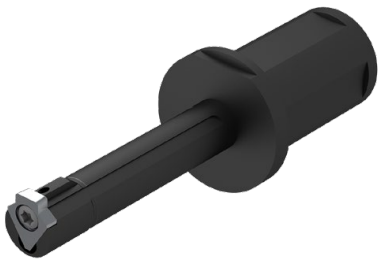
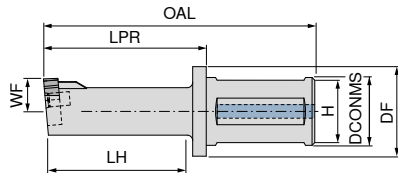
规格型号	b_1 P9/JS9/C11 mm	CW mm	RE mm	PDY mm	INSL mm	PDPT mm	DMIN mm	W1 mm	适用刀杆	73 603 ...	73 604 ...	73 605 ...
NV15.0398.02	4	3.98	0.20	6.5	13.0	2.3	15	3.2	NHV 15			110
NV15.0401.02	4	4.01	0.20	6.5	13.0	2.3	15	3.2	NHV 15		110	
NV15.0410.050	4	4.10	0.50	6.5	13.0	2.2	15	3.2	NHV 15	108		111
NV15.0498.02	5	4.98	0.20	6.5	13.0	2.8	15	3.2	NHV 15		111	
NV15.0501.02	5	5.01	0.20	6.5	13.0	2.8	15	3.2	NHV 15			
NV15.0510.050	5	5.10	0.50	6.5	13.0	2.5	15	3.2	NHV 15	109		112
NV15.0598.02	6	5.98	0.20	6.5	13.0	3.3	15	3.2	NHV 15		112	
NV15.0601.02	6	6.01	0.20	6.5	13.0	3.3	15	3.2	NHV 15			
NV15.0612.085	6	6.12	0.85	6.5	13.0	2.6	15	3.2	NHV 15	110		
NPV.0498.02	5	4.98	0.20	8.0	17.3	2.7	22	5.3	NHV 22			100
NPV.0501.02	5	5.01	0.20	8.0	17.3	2.7	22	5.3	NHV 22		100	
NPV.0598.02	6	5.98	0.20	8.0	17.3	3.4	22	5.3	NHV 22			101
NPV.0601.02	6	6.01	0.20	8.0	17.3	3.4	22	5.3	NHV 22		101	
NPV.0612.085	6	6.12	0.85	8.0	17.3	2.6	22	5.3	NHV 22	101		
NPV.0713.085	7	7.13	0.85	8.0	17.3	3.3	22	5.3	NHV 22	102		
NPV.0798.02	8	7.98	0.20	8.0	17.3	4.1	22	5.3	NHV 22/30			102
NPV.0801.02	8	8.01	0.20	8.0	17.3	4.1	22	5.3	NHV 22/30		102	
NPV.0813.105	8	8.13	1.05	8.0	17.3	3.4	22	5.3	NHV 22/30	103		
NPV.0998.03	10	9.98	0.30	8.0	17.3	4.2	30	5.3	NHV 30			103
NPV.1001.03	10	10.01	0.30	8.0	17.3	4.2	30	5.3	NHV 30		103	
NPV.1013.105	10	10.13	1.05	10.9	20.2	4.2	40	5.3	NHV 38	104		104
NPV.1197.03	12	11.97	0.30	10.9	20.2	5.7	40	5.3	NHV 38			
NPV.1202.05	20	12.02	0.50	10.9	20.2	8.5	40	5.3	NHV 38		105	
NPV.1202.03	12	12.02	0.30	10.9	20.2	5.7	40	5.3	NHV 38		104	
NPV.1215.135	12	12.15	1.35	10.9	20.2	5.1	40	5.3	NHV 38	105		
NPV.1215.175	16	12.15	1.75	10.9	20.2	6.6	40	5.3	NHV 38	106		
NPV.1215.225	24	12.15	2.25	10.9	20.2	8.5	40	5.3	NHV 38	107		
NPV.1397.03	14	13.97	0.30	10.9	20.1	7.5	45	5.3	NHV 45			106
NPV.1402.03	14	14.02	0.30	10.9	20.1	7.5	45	5.3	NHV 45		106	
NPV.1597.03	16	15.97	0.30	10.9	20.1	7.5	45	5.3	NHV 45			107
NPV.1602.03	16	16.02	0.30	10.9	20.1	7.5	45	5.3	NHV 45		107	
NPV.1797.05	18	17.97	0.50	10.9	20.1	9.5	45	5.3	NHV 45			108
NPV.1802.05	18	18.02	0.50	10.9	20.1	9.5	45	5.3	NHV 45		108	
NPV.1997.05	20	19.97	0.50	10.9	20.1	10.0	45	5.3	NHV 45			109
NPV.2002.05	20	20.02	0.50	10.9	20.1	10.0	45	5.3	NHV 45		109	

公差 C 11 用于 73 603, 公差 JS 9 用于 73 604, 公差 P 9 用于 73 605

SlotCut – 刀杆

供货详情:

螺钉夹持式刀杆, 无刀片



73 613 ...

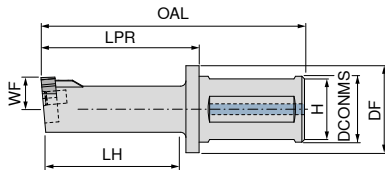
规格型号	DCONMS _{g6} mm	DMIN mm	DF mm	OAL mm	LH mm	LPR mm	H mm	WF mm	刀片
NHV.15.1	25	15	33	75	25	35	23	8.4	NV15
NHV.15.2	25	15	33	90	40	50	23	8.4	NV15
NHV.15.3	25	15	33	110	60	70	23	8.4	NV15

025
125
225

SlotCut – 刀杆

供货详情:

螺钉夹持式刀杆, 无刀片



73 611 ...

规格型号	DCONMS _{g6} mm	DMIN mm	DF mm	OAL mm	LH mm	LPR mm	H mm	WF mm	刀片
NHV.22	25	22	33	100	50	60	23	12.0	NPV
NHV.30	32	30	45	100	50	60	30	16.5	NPV
NHV.30	32	30	45	125	75	85	30	16.5	NPV
NHV.38	32	38	45	100	50	60	30	22.0	NPV
NHV.38	32	38	45	125	75	85	30	22.0	NPV
NHV.45	40	45	55	120	50	60	38	24.0	NPV
NHV.45	40	45	55	175	105	115	38	24.0	NPV
NHV.45	40	45	55	225	155	165	38	24.0	NPV

025
032
532
132
632
040
140
240

12

备件

DCONMS_{g6}

25
32
40



80 950 ...



73 082 ...

T20	114	M5x13	007
T20	114	M5x13	007
T20	114	M5x13	007

切削参数推荐表材料示例

	子材料组	索引	成分/结构/热处理		抗拉强度 N/mm² / HB / HRC	物料编号	材料命名体系	物料编号	材料命名体系
P	非合金钢	P.1.1	≤ 0.15 % C	退火	420 N/mm² / 125 HB	1.0401	C15	1.1141	Ck15
		P.1.2	≤ 0.45 % C	退火	640 N/mm² / 190 HB	1.1191	C45E	1.0718	9SMnPb28
		P.1.3		调质	840 N/mm² / 250 HB	1.1191	C45E	1.0535	C55
		P.1.4	≤ 0.75 % C	退火	910 N/mm² / 270 HB	1.1223	C60R	1.0535	C55
		P.1.5		调质	1010 N/mm² / 300 HB	1.1223	C60R	1.0727	45S20
	低合金钢	P.2.1		退火	610 N/mm² / 180 HB	1.7131	16MnCr5	1.6587	17CrNiMo6
		P.2.2		调质	930 N/mm² / 275 HB	1.7131	16MnCr5	1.6587	17CrNiMo6
		P.2.3		调质	1010 N/mm² / 300 HB	1.7225	42CrMo4	1.3505	100Cr6
		P.2.4		调质	1200 N/mm² / 375 HB	1.7225	42CrMo4	1.3505	100Cr6
	高合金钢及高合金工具钢	P.3.1		退火	680 N/mm² / 200 HB	1.4021	X20Cr13	1.4034	X46Cr13
		P.3.2		淬火和调质	1100 N/mm² / 300 HB	1.2343	X38CrMoV5-1	1.4034	X46Cr13
		P.3.3		淬火和调质	1300 N/mm² / 400 HB	1.2343	X38CrMoV5-1	1.4034	X46Cr13
	不锈钢	P.4.1	铁素体/马氏体	退火	680 N/mm² / 200 HB	1.4016	X6Cr17	1.2316	X36CrMo16
		P.4.2	马氏体	调质	1010 N/mm² / 300 HB	1.4112	X90CrMoV18	1.2316	X36CrMo16
M	不锈钢	M.1.1	奥氏体/奥氏体-铁素体	淬火	610 N/mm² / 180 HB	1.4301	X5CrNi18-10	1.4571	X6CrNiMoTi17-12-2
		M.2.1	奥氏体	调质	300 HB	1.4841	X15CrNiSi25-21	1.4539	X1NiCrMoCu25-20-5
		M.3.1	奥氏体/铁素体 (双相)		780 N/mm² / 230 HB	1.4462	X2CrNiMoN22-5-3	1.4501	X2CrNiMoCuWN25-7-4
K	灰铸铁	K.1.1	珠光体/铁素体		350 N/mm² / 180 HB	0.6010	GG-10	0.6025	GG-25
		K.1.2	珠光体 (马氏体)		500 N/mm² / 260 HB	0.6030	GG-30	0.6045	GG-45
	球墨铸铁	K.2.1	铁素体		540 N/mm² / 160 HB	0.7040	GGG-40	0.7060	GGG-60
		K.2.2	珠光体		845 N/mm² / 250 HB	0.7070	GGG-70	0.7080	GGG-80
	可锻铸铁	K.3.1	铁素体		440 N/mm² / 130 HB	0.8035	GTW-35-04	0.8045	GTW-45
		K.3.2	珠光体		780 N/mm² / 230 HB	0.8165	GTS-65-02	0.8170	GTS-70-02
N	锻造铝合金	N.1.1	不可硬化材料		60 HB	3.0255	Al99,5	3.3315	AlMg1
		N.1.2	可硬化材料	时效硬化	340 N/mm² / 100 HB	3.1355	AlCuMg2	3.2315	AlMgSi1
	铸造铝合金	N.2.1	≤ 12 % Si, 不可硬化		250 N/mm² / 75 HB	3.2581	G-AlSi12	3.2163	G-AlSi9Cu3
		N.2.2	≤ 12 % Si, 硬化	时效硬化	300 N/mm² / 90 HB	3.2134	G-AlSi5Cu1Mg	3.2373	G-AlSi9Mg
		N.2.3	> 12 % Si, 不可硬化		440 N/mm² / 130 HB		G-AlSi17Cu4Mg		G-AlSi18CuNiMg
	铜和铜合金 (青铜、黄铜)	N.3.1	易切削合金, PB > 1 %		375 N/mm² / 110 HB	2.0380	CuZn39Pb2 (Ms58)	2.0410	CuZn44Pb2
		N.3.2	CuZn, CuSnZn		300 N/mm² / 90 HB	2.0331	CuZn15	2.4070	CuZn28Sn1As
		N.3.3	CuSn, 无铅铜和电解铜		340 N/mm² / 100 HB	2.0060	E-Cu57	2.0590	CuZn40Fe
	镁合金	N.4.1	镁、镁合金		70 HB	3.5612	MgAl6Zn	3.5312	MgAl3Zn
S	耐热合金	S.1.1	铁基耐热合金	退火	680 N/mm² / 200 HB	1.4864	X12NiCrSi 36-16	1.4865	G-X40NiCrSi38-18
		S.1.2		时效硬化	950 N/mm² / 280 HB	1.4980	X6NiCrTiMoVB25-15-2	1.4876	X10NiCrAlTi32-20
		S.2.1	镍基或钴基耐热合金	退火	840 N/mm² / 250 HB	2.4631	NiCr20TiAl (Nimonic80A)	3.4856	NiCr22Mo9Nb
		S.2.2		时效硬化	1180 N/mm² / 350 HB	2.4668	NiCr19Nb5Mo3 (Inconel 718)	2.4955	NiFe25Cr20NbTi
		S.2.3		铸造	1080 N/mm² / 320 HB	2.4765	CoCr20W15Ni	1.3401	G-X120Mn12
	钛合金	S.3.1	纯钛		400 N/mm²	3.7025	Ti99,8	3.7034	Ti99,7
		S.3.2	α+β合金	时效硬化	1050 N/mm² / 320 HB	3.7165	TiAl6V4	Ti-6246	Ti-6Al-2Sn-4Zr-6Mo
		S.3.3	β合金		1400 N/mm² / 410 HB	Ti555.3	Ti-5Al-5V-5Mo-3Cr	R56410	Ti-10V-2Fe-3Al
H	淬硬钢	H.1.1		淬火和调质	46-55 HRC				
		H.1.2		淬火和调质	56-60 HRC				
		H.1.3		淬火和调质	61-65 HRC				
		H.1.4		淬火和调质	66-70 HRC				
	冷硬铸铁	H.2.1		铸造	400 HB				
	硬化铸铁	H.3.1		淬火和调质	55 HRC				
O	非金属材料	O.1.1	硬质塑料		≤ 150 N/mm²				
		O.1.2	热塑性塑料		≤ 100 N/mm²				
		O.2.1	芳纶纤维增强		≤ 1000 N/mm²				
		O.2.2	玻璃/碳纤维增强		≤ 1000 N/mm²				
		O.3.1	石墨						

* 抗拉强度

切削参数推荐值

	UltraMini K10F 无涂层	UltraMini K10F-TiN	UltraMini K10-TiAlN	UltraMini DPX 57S	MiniCut CWX500	UltraMini TiAlN+	MiniCut CBN
材料组	v _c (m/min)						
P.1.1		90	110	110	160	110	
P.1.2		80	100	100	140	100	
P.1.3		60	80	80	140	80	
P.1.4		60	80	80	110	80	
P.1.5		60	60	60	100	60	
P.2.1		60	80	80	110	80	
P.2.2		60	60	60	100	60	
P.2.3		50	60	60	90	60	
P.2.4		50	60	60	80	60	
P.3.1		50	60	60	80	60	
P.3.2		30	50	50	70	50	
P.3.3		30	30	30	50	30	
P.4.1		60	70	70	100	70	
P.4.2		50	60	60	90	60	
M.1.1		60	80	80	80	80	
M.2.1		50	60	60	70	60	
M.3.1		40	50	50	60	50	
K.1.1		80	100	100	90	100	
K.1.2		60	70	70	100	70	
K.2.1		60	60	60	80	60	
K.2.2		50	60	60	70	60	
K.3.1		80	100	100	120	100	
K.3.2		70	80	80	100	80	
N.1.1	100	200	230	230	290	230	
N.1.2	100	180	220	220	280	220	
N.2.1	90	160	190	190	240	190	
N.2.2	70	140	170	170	200	170	
N.2.3	50	80	100	100	120	100	
N.3.1	80	140	170	170	210	170	
N.3.2	70	120	140	140	180	140	
N.3.3	50	100	120	120	130	120	
N.4.1	50	100	120	120	100	120	
S.1.1		30	50	50	50	50	
S.1.2		30	30	30	30	30	30
S.2.1		30	50	50	50	50	50
S.2.2		30	30	30	40	30	30
S.2.3			30	30	30	30	30
S.3.1		30	50	50	50	50	
S.3.2		20	30	30	40	30	
S.3.3			20	20	30	20	20
H.1.1		30	40	40	50	40	40
H.1.2			30	30	40	30	30
H.1.3				20		30	30
H.1.4							
H.2.1							
H.3.1		20	30	30	40	30	30
O.1.1	50	90	110	110	150	110	
O.1.2	50	100	120	120	150	120	
O.2.1		90	110	110	130	110	
O.2.2		60	80	80	100	80	
O.3.1	50	100	120	120	150	120	

	UltraMini	MiniCut
	f (mm/r)	
镗孔、仿形车削	0,02-0,05	0,03-0,10
镗孔、仿形车削 - 硬质材料加工	0,02-0,06	0,03-0,10
车削和仿形车削 - 超级合金	0,02-0,08	
镗孔	0,02-0,05	0,01-0,03
反镗	0,02-0,04	0,03-0,10
镗孔、倒角	0,01-0,03	0,03-0,10
预切槽、倒角	0,01-0,02	0,01-0,03
切槽	0,01-0,02	0,01-0,03
内径退刀槽加工	0,01-0,03	0,03-0,08
切槽、仿形车削	0,01-0,02	0,01-0,03
轴向切槽	0,02-0,05	0,02-0,05

 切削参数受外部条件影响较为明显，例如：刀具和工件夹持的稳定性、材料和机床类型！根据实际使用情况切削参数可以依据推荐值进行大约±20%调整。

切削参数推荐值 - 73 000 ... /73 001 ...

		粗车										
材料组	UltraMini DPX77S	$\varnothing \leq 2 \text{ mm}$ 刀尖半径 (mm)			$\varnothing 2,5-4 \text{ mm}$ 刀尖半径 (mm)				$\varnothing \geq 5 \text{ mm}$ 刀尖半径 (mm)			
	v_c (m/min)	0,05	0,1	0,15	0,05	0,1	0,15	0,2 / 0,4	0,05	0,1	0,15	0,2 / 0,4
		f (mm/r)			f (mm/r)				f (mm/r)			
P.1.1	110	0,026-0,076	0,029-0,082	0,031-0,088	0,053-0,151	0,058-0,165	0,062-0,176	0,064-0,184	0,099-0,284	0,108-0,309	0,116-0,33	0,121-0,345
P.1.2	100	0,026-0,076	0,029-0,082	0,031-0,088	0,053-0,151	0,058-0,165	0,062-0,176	0,064-0,184	0,099-0,284	0,108-0,309	0,116-0,33	0,121-0,345
P.1.3	80	0,026-0,076	0,029-0,082	0,031-0,088	0,053-0,151	0,058-0,165	0,062-0,176	0,064-0,184	0,099-0,284	0,108-0,309	0,116-0,33	0,121-0,345
P.1.4	80	0,023-0,065	0,025-0,071	0,026-0,076	0,046-0,13	0,05-0,142	0,053-0,151	0,055-0,158	0,085-0,244	0,093-0,266	0,099-0,284	0,104-0,297
P.1.5	60	0,024-0,068	0,026-0,074	0,028-0,079	0,048-0,136	0,052-0,148	0,055-0,158	0,058-0,166	0,089-0,255	0,097-0,278	0,104-0,297	0,109-0,311
P.2.1	80	0,024-0,068	0,026-0,074	0,028-0,079	0,048-0,136	0,052-0,148	0,055-0,158	0,058-0,166	0,089-0,255	0,097-0,278	0,104-0,297	0,109-0,311
P.2.2	60	0,021-0,06	0,023-0,066	0,025-0,07	0,042-0,121	0,046-0,132	0,049-0,141	0,052-0,147	0,079-0,227	0,087-0,247	0,092-0,264	0,097-0,276
P.2.3	60	0,019-0,054	0,021-0,059	0,022-0,063	0,038-0,109	0,042-0,119	0,044-0,127	0,046-0,132	0,071-0,204	0,078-0,222	0,083-0,238	0,087-0,248
P.2.4	60	0,018-0,051	0,02-0,056	0,021-0,06	0,036-0,103	0,039-0,112	0,042-0,12	0,044-0,125	0,067-0,193	0,074-0,21	0,079-0,224	0,082-0,235
P.3.1	60	0,021-0,06	0,023-0,066	0,025-0,07	0,042-0,121	0,046-0,132	0,049-0,141	0,052-0,147	0,079-0,227	0,087-0,247	0,092-0,264	0,097-0,276
P.3.2	50	0,02-0,057	0,022-0,063	0,023-0,067	0,04-0,115	0,044-0,125	0,047-0,134	0,049-0,14	0,075-0,215	0,082-0,235	0,088-0,251	0,092-0,262
P.3.3	30	0,016-0,045	0,017-0,049	0,018-0,053	0,032-0,091	0,035-0,099	0,037-0,106	0,039-0,11	0,06-0,17	0,065-0,185	0,069-0,198	0,072-0,207
P.4.1	70	0,022-0,064	0,024-0,069	0,026-0,074	0,044-0,127	0,048-0,138	0,052-0,148	0,054-0,155	0,083-0,238	0,091-0,26	0,097-0,277	0,101-0,29
P.4.2	60	0,021-0,06	0,023-0,066	0,025-0,07	0,042-0,121	0,046-0,132	0,049-0,141	0,052-0,147	0,079-0,227	0,087-0,247	0,092-0,264	0,097-0,276
M.1.1	80	0,015-0,042	0,016-0,046	0,017-0,049	0,03-0,085	0,032-0,092	0,034-0,099	0,036-0,103	0,056-0,159	0,061-0,173	0,065-0,185	0,068-0,193
M.2.1	60	0,013-0,038	0,014-0,041	0,015-0,044	0,026-0,076	0,029-0,082	0,031-0,088	0,032-0,092	0,05-0,142	0,054-0,155	0,058-0,165	0,06-0,173
M.3.1	50	0,014-0,039	0,015-0,043	0,016-0,046	0,028-0,079	0,03-0,086	0,032-0,092	0,033-0,096	0,052-0,147	0,056-0,161	0,06-0,172	0,063-0,179
K.1.1	100	0,026-0,076	0,029-0,082	0,031-0,088	0,053-0,151	0,058-0,165	0,062-0,176	0,064-0,184	0,099-0,284	0,108-0,309	0,116-0,33	0,121-0,345
K.1.2	70	0,024-0,068	0,026-0,074	0,028-0,079	0,048-0,136	0,052-0,148	0,055-0,158	0,058-0,166	0,089-0,255	0,097-0,278	0,104-0,297	0,109-0,311
K.2.1	60	0,024-0,068	0,026-0,074	0,028-0,079	0,048-0,136	0,052-0,148	0,055-0,158	0,058-0,166	0,089-0,255	0,097-0,278	0,104-0,297	0,109-0,311
K.2.2	60	0,021-0,059	0,022-0,064	0,024-0,069	0,041-0,118	0,045-0,129	0,048-0,137	0,05-0,144	0,077-0,221	0,084-0,241	0,09-0,257	0,094-0,269
K.3.1	100	0,025-0,073	0,028-0,079	0,03-0,084	0,051-0,145	0,055-0,158	0,059-0,169	0,062-0,177	0,095-0,272	0,104-0,297	0,111-0,317	0,116-0,331
K.3.2	80	0,021-0,06	0,023-0,066	0,025-0,07	0,042-0,121	0,046-0,132	0,049-0,141	0,052-0,147	0,079-0,227	0,087-0,247	0,092-0,264	0,097-0,276
N.1.1	230	0,032-0,091	0,035-0,099	0,037-0,106	0,064-0,181	0,069-0,198	0,074-0,211	0,077-0,221	0,119-0,34	0,13-0,371	0,139-0,396	0,145-0,414
N.1.2	220	0,031-0,089	0,034-0,097	0,036-0,104	0,062-0,178	0,068-0,194	0,073-0,208	0,076-0,217	0,117-0,335	0,128-0,365	0,136-0,389	0,142-0,407
N.2.1	190	0,03-0,085	0,032-0,092	0,034-0,099	0,059-0,169	0,065-0,185	0,069-0,197	0,072-0,206	0,111-0,318	0,121-0,346	0,129-0,37	0,135-0,386
N.2.2	170	0,029-0,083	0,032-0,091	0,034-0,097	0,058-0,166	0,063-0,181	0,068-0,194	0,071-0,202	0,109-0,312	0,119-0,34	0,127-0,363	0,133-0,38
N.2.3	100	0,029-0,082	0,031-0,089	0,033-0,095	0,057-0,163	0,062-0,178	0,067-0,19	0,07-0,199	0,107-0,306	0,117-0,334	0,125-0,356	0,13-0,373
N.3.1	170	0,03-0,085	0,032-0,092	0,034-0,099	0,059-0,169	0,065-0,185	0,069-0,197	0,072-0,206	0,111-0,318	0,121-0,346	0,129-0,37	0,135-0,386
N.3.2	140	0,028-0,08	0,031-0,087	0,033-0,093	0,056-0,16	0,061-0,175	0,065-0,187	0,068-0,195	0,105-0,301	0,115-0,328	0,122-0,35	0,128-0,366
N.3.3	120	0,027-0,077	0,029-0,084	0,031-0,09	0,054-0,154	0,059-0,168	0,063-0,18	0,066-0,188	0,101-0,289	0,11-0,315	0,118-0,337	0,123-0,352
N.4.1	120	0,027-0,077	0,029-0,084	0,031-0,09	0,054-0,154	0,059-0,168	0,063-0,18	0,066-0,188	0,101-0,289	0,11-0,315	0,118-0,337	0,123-0,352
S.1.1	50	0,024-0,068	0,026-0,074	0,028-0,079	0,048-0,136	0,052-0,148	0,055-0,158	0,058-0,166	0,089-0,255	0,097-0,278	0,104-0,297	0,109-0,311
S.1.2	30	0,019-0,053	0,02-0,058	0,022-0,062	0,037-0,106	0,04-0,115	0,043-0,123	0,045-0,129	0,069-0,198	0,076-0,216	0,081-0,231	0,085-0,242
S.2.1	50	0,018-0,051	0,02-0,056	0,021-0,06	0,036-0,103	0,039-0,112	0,042-0,12	0,044-0,125	0,067-0,193	0,074-0,21	0,079-0,224	0,082-0,235
S.2.2	30	0,014-0,039	0,015-0,043	0,016-0,046	0,028-0,079	0,03-0,086	0,032-0,092	0,033-0,096	0,052-0,147	0,056-0,161	0,06-0,172	0,063-0,179
S.2.3	30	0,015-0,042	0,016-0,046	0,017-0,049	0,03-0,085	0,032-0,092	0,034-0,099	0,036-0,103	0,056-0,159	0,061-0,173	0,065-0,185	0,068-0,193
S.3.1	50	0,024-0,068	0,026-0,074	0,028-0,079	0,048-0,136	0,052-0,148	0,055-0,158	0,058-0,166	0,089-0,255	0,097-0,278	0,104-0,297	0,109-0,311
S.3.2	30	0,019-0,054	0,021-0,059	0,022-0,063	0,038-0,109	0,042-0,119	0,044-0,127	0,046-0,132	0,071-0,204	0,078-0,222	0,083-0,238	0,087-0,248
S.3.3	20	0,013-0,038	0,014-0,041	0,015-0,044	0,026-0,076	0,029-0,082	0,031-0,088	0,032-0,092	0,05-0,142	0,054-0,155	0,058-0,165	0,06-0,173
H.1.1	40	0,013-0,038	0,014-0,041	0,015-0,044	0,026-0,076	0,029-0,082	0,031-0,088	0,032-0,092	0,05-0,142	0,054-0,155	0,058-0,165	0,06-0,173
H.1.2	30	0,011-0,03	0,012-0,033	0,012-0,035	0,021-0,06	0,023-0,066	0,025-0,07	0,026-0,074	0,036-0,102	0,039-0,111	0,042-0,119	0,043-0,124
H.1.3												
H.1.4												
H.2.1	30	0,014-0,041	0,016-0,044	0,017-0,048	0,029-0,082	0,031-0,089	0,033-0,095	0,035-0,099	0,054-0,153	0,058-0,167	0,062-0,178	0,065-0,186
H.3.1	30	0,013-0,036	0,014-0,04	0,015-0,042	0,025-0,073	0,028-0,079	0,03-0,084	0,031-0,088	0,048-0,136	0,052-0,148	0,055-0,158	0,058-0,166
O.1.1	110	0,031-0,089	0,034-0,097	0,036-0,104	0,062-0,178	0,068-0,194	0,073-0,208	0,076-0,217	0,117-0,335	0,128-0,365	0,136-0,389	0,142-0,407
O.1.2	120	0,028-0,079	0,03-0,086	0,032-0,092	0,055-0,157	0,06-0,171	0,064-0,183	0,067-0,191	0,103-0,295	0,112-0,321	0,12-0,343	0,126-0,359
O.2.1	110	0,017-0,05	0,019-0,054	0,02-0,058	0,035-0,1	0,038-0,109	0,041-0,116	0,043-0,121	0,065-0,187	0,071-0,204	0,076-0,218	0,08-0,228
O.2.2	80	0,017-0,048	0,018-0,053	0,02-0,056	0,034-0,097	0,037-0,105	0,039-0,113	0,041-0,118	0,064-0,181	0,069-0,198	0,074-0,211	0,077-0,221
O.3.1	120											

 切削参数受外部条件影响较为明显, 例如: 刀具和工件夹持的稳定性、材料和机床类型! 根据实际使用情况切削参数可以依据推荐值进行大约±20%调整。

精车														
材料组	$\varnothing \leq 2 \text{ mm}$ 刀尖半径 (mm)				$\varnothing 2.5-4 \text{ mm}$ 刀尖半径 (mm)					$\varnothing \geq 5 \text{ mm}$ 刀尖半径 (mm)				
	0,05	0,1	0,15		0,05	0,1	0,15	0,2	0,4	0,05	0,1	0,15	0,2	0,4
	f (mm/r)				f (mm/r)					f (mm/r)				
P	P.1.1	0,007-0,019	0,008-0,022	0,009-0,025	0,017-0,049	0,02-0,058	0,023-0,065	0,025-0,072	0,032-0,092	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	P.1.2	0,007-0,019	0,008-0,022	0,009-0,025	0,017-0,049	0,02-0,058	0,023-0,065	0,025-0,072	0,032-0,092	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	P.1.3	0,007-0,019	0,008-0,022	0,009-0,025	0,017-0,049	0,02-0,058	0,023-0,065	0,025-0,072	0,032-0,092	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	P.1.4	0,006-0,016	0,007-0,019	0,008-0,022	0,015-0,042	0,017-0,05	0,02-0,056	0,022-0,061	0,028-0,079	0,023-0,065	0,027-0,077	0,03-0,086	0,033-0,095	0,043-0,122
	P.1.5	0,006-0,017	0,007-0,02	0,008-0,023	0,016-0,044	0,018-0,052	0,02-0,059	0,023-0,064	0,029-0,083	0,024-0,068	0,028-0,08	0,032-0,09	0,035-0,099	0,045-0,128
	P.2.1	0,006-0,017	0,007-0,02	0,008-0,023	0,016-0,044	0,018-0,052	0,02-0,059	0,023-0,064	0,029-0,083	0,024-0,068	0,028-0,08	0,032-0,09	0,035-0,099	0,045-0,128
	P.2.2	0,005-0,015	0,006-0,018	0,007-0,02	0,014-0,04	0,016-0,046	0,018-0,052	0,02-0,057	0,026-0,074	0,021-0,061	0,025-0,071	0,028-0,08	0,031-0,088	0,04-0,114
	P.2.3	0,005-0,014	0,006-0,016	0,006-0,018	0,012-0,036	0,015-0,042	0,016-0,047	0,018-0,051	0,023-0,066	0,019-0,055	0,022-0,064	0,025-0,072	0,028-0,079	0,036-0,102
	P.2.4	0,005-0,013	0,005-0,015	0,006-0,017	0,012-0,034	0,014-0,039	0,015-0,044	0,017-0,049	0,022-0,063	0,018-0,052	0,021-0,061	0,024-0,068	0,026-0,075	0,034-0,097
	P.3.1	0,005-0,015	0,006-0,018	0,007-0,02	0,014-0,04	0,016-0,046	0,018-0,052	0,02-0,057	0,026-0,074	0,021-0,061	0,025-0,071	0,028-0,08	0,031-0,088	0,04-0,114
	P.3.2	0,005-0,014	0,006-0,017	0,007-0,019	0,013-0,038	0,015-0,044	0,017-0,049	0,019-0,054	0,025-0,07	0,02-0,058	0,024-0,068	0,027-0,076	0,029-0,084	0,038-0,108
	P.3.3	0,004-0,011	0,005-0,013	0,005-0,015	0,01-0,03	0,012-0,035	0,014-0,039	0,015-0,043	0,019-0,055	0,016-0,046	0,019-0,053	0,021-0,06	0,023-0,066	0,03-0,085
	P.4.1	0,006-0,016	0,007-0,019	0,007-0,021	0,015-0,041	0,017-0,049	0,019-0,055	0,021-0,06	0,027-0,078	0,022-0,064	0,026-0,075	0,029-0,084	0,032-0,092	0,042-0,119
	P.4.2	0,005-0,015	0,006-0,018	0,007-0,02	0,014-0,04	0,016-0,046	0,018-0,052	0,02-0,057	0,026-0,074	0,021-0,061	0,025-0,071	0,028-0,08	0,031-0,088	0,04-0,114
M	M.1.1	0,004-0,011	0,004-0,012	0,005-0,014	0,01-0,028	0,011-0,032	0,013-0,036	0,014-0,04	0,018-0,052	0,015-0,043	0,017-0,05	0,02-0,056	0,022-0,062	0,028-0,08
	M.2.1	0,003-0,01	0,004-0,011	0,004-0,013	0,009-0,025	0,01-0,029	0,011-0,033	0,013-0,036	0,016-0,046	0,013-0,038	0,016-0,045	0,018-0,05	0,019-0,055	0,025-0,071
	M.3.1	0,003-0,01	0,004-0,012	0,005-0,013	0,009-0,026	0,011-0,03	0,012-0,034	0,013-0,037	0,017-0,048	0,014-0,04	0,016-0,046	0,018-0,052	0,02-0,057	0,026-0,074
K	K.1.1	0,007-0,019	0,008-0,022	0,009-0,025	0,017-0,049	0,02-0,058	0,023-0,065	0,025-0,072	0,032-0,092	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	K.1.2	0,006-0,017	0,007-0,02	0,008-0,023	0,016-0,044	0,018-0,052	0,02-0,059	0,023-0,064	0,029-0,083	0,024-0,068	0,028-0,08	0,032-0,09	0,035-0,099	0,045-0,128
	K.2.1	0,006-0,017	0,007-0,02	0,008-0,023	0,016-0,044	0,018-0,052	0,02-0,059	0,023-0,064	0,029-0,083	0,024-0,068	0,028-0,08	0,032-0,09	0,035-0,099	0,045-0,128
	K.2.2	0,005-0,015	0,006-0,017	0,007-0,02	0,013-0,039	0,016-0,045	0,018-0,051	0,02-0,056	0,025-0,072	0,021-0,059	0,024-0,069	0,027-0,078	0,03-0,086	0,039-0,111
	K.3.1	0,006-0,018	0,007-0,021	0,008-0,024	0,017-0,047	0,019-0,056	0,022-0,062	0,024-0,069	0,031-0,089	0,026-0,073	0,03-0,085	0,034-0,096	0,037-0,106	0,048-0,136
	K.3.2	0,005-0,015	0,006-0,018	0,007-0,02	0,014-0,04	0,016-0,046	0,018-0,052	0,02-0,057	0,026-0,074	0,021-0,061	0,025-0,071	0,028-0,08	0,031-0,088	0,04-0,114
N	N.1.1	0,008-0,023	0,009-0,027	0,011-0,03	0,02-0,058	0,024-0,068	0,027-0,077	0,03-0,084	0,038-0,109	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	N.1.2	0,008-0,022	0,009-0,026	0,01-0,03	0,02-0,058	0,024-0,068	0,027-0,077	0,03-0,084	0,038-0,109	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	N.2.1	0,007-0,021	0,009-0,025	0,01-0,028	0,019-0,055	0,023-0,065	0,025-0,073	0,028-0,08	0,036-0,103	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	N.2.2	0,007-0,021	0,009-0,024	0,01-0,028	0,019-0,054	0,022-0,064	0,025-0,072	0,028-0,079	0,036-0,102	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	N.2.3	0,007-0,021	0,008-0,024	0,009-0,027	0,019-0,053	0,022-0,062	0,025-0,07	0,027-0,077	0,035-0,1	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	N.3.1	0,007-0,021	0,009-0,025	0,01-0,028	0,019-0,055	0,023-0,065	0,025-0,073	0,028-0,08	0,036-0,103	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	N.3.2	0,007-0,02	0,008-0,024	0,009-0,027	0,018-0,052	0,021-0,061	0,024-0,069	0,027-0,076	0,034-0,098	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	N.3.3	0,007-0,019	0,008-0,023	0,009-0,026	0,018-0,05	0,021-0,059	0,023-0,066	0,026-0,073	0,033-0,094	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	N.4.1	0,007-0,019	0,008-0,023	0,009-0,026	0,018-0,05	0,021-0,059	0,023-0,066	0,026-0,073	0,033-0,094	0,027-0,078	0,032-0,091	0,036-0,102	0,039-0,112	0,051-0,145
S	S.1.1	0,006-0,017	0,007-0,02	0,008-0,023	0,016-0,044	0,018-0,052	0,02-0,059	0,023-0,064	0,029-0,083	0,024-0,068	0,028-0,08	0,032-0,09	0,035-0,099	0,045-0,128
	S.1.2	0,005-0,013	0,005-0,016	0,006-0,018	0,012-0,035	0,014-0,04	0,016-0,046	0,018-0,05	0,023-0,065	0,019-0,053	0,022-0,062	0,025-0,07	0,027-0,077	0,035-0,099
	S.2.1	0,005-0,013	0,005-0,015	0,006-0,017	0,012-0,034	0,014-0,039	0,015-0,044	0,017-0,049	0,022-0,063	0,018-0,052	0,021-0,061	0,024-0,068	0,026-0,075	0,034-0,097
	S.2.2	0,003-0,01	0,004-0,012	0,005-0,013	0,009-0,026	0,011-0,03	0,012-0,034	0,013-0,037	0,017-0,048	0,014-0,04	0,016-0,046	0,018-0,052	0,02-0,057	0,026-0,074
	S.2.3	0,004-0,011	0,004-0,012	0,005-0,014	0,01-0,028	0,011-0,032	0,013-0,036	0,014-0,04	0,018-0,052	0,015-0,043	0,017-0,05	0,02-0,056	0,022-0,062	0,028-0,08
	S.3.1	0,006-0,017	0,007-0,02	0,008-0,023	0,016-0,044	0,018-0,052	0,02-0,059	0,023-0,064	0,029-0,083	0,024-0,068	0,028-0,08	0,032-0,09	0,035-0,099	0,045-0,128
	S.3.2	0,005-0,014	0,006-0,016	0,006-0,018	0,012-0,036	0,015-0,042	0,016-0,047	0,018-0,051	0,023-0,066	0,019-0,055	0,022-0,064	0,025-0,072	0,028-0,079	0,036-0,102
	S.3.3	0,003-0,01	0,004-0,011	0,004-0,013	0,009-0,025	0,01-0,029	0,011-0,033	0,013-0,036	0,016-0,046	0,013-0,038	0,016-0,045	0,018-0,05	0,019-0,055	0,025-0,071
H	H.1.1	0,003-0,01	0,004-0,011	0,004-0,013	0,009-0,025	0,01-0,029	0,011-0,033	0,013-0,036	0,016-0,046	0,013-0,038	0,016-0,045	0,018-0,05	0,019-0,055	0,025-0,071
	H.1.2	0,003-0,008	0,003-0,009	0,004-0,01	0,007-0,02	0,008-0,023	0,009-0,026	0,01-0,029	0,013-0,037	0,011-0,03	0,012-0,036	0,014-0,04	0,015-0,044	0,02-0,057
	H.1.3													
	H.1.4													
	H.2.1	0,004-0,01	0,004-0,012	0,005-0,014	0,009-0,027	0,011-0,031	0,012-0,035	0,014-0,039	0,017-0,05	0,014-0,041	0,017-0,048	0,019-0,054	0,021-0,059	0,027-0,077
	H.3.1	0,003-0,009	0,004-0,011	0,004-0,012	0,008-0,024	0,01-0,028	0,011-0,031	0,012-0,034	0,016-0,044	0,013-0,036	0,015-0,043	0,017-0,048	0,018-0,053	0,024-0,068
	H.3.2													
O	O.1.1	0,008-0,022	0,009-0,026	0,01-0,03	0,02-0,058	0,024-0,068	0,027-0,077	0,03-0,084	0,038-0,109	0,027-0,076	0,031-0,089	0,035-0,1	0,039-0,11	0,05-0,142
	O.1.2	0,007-0,02	0,008-0,023	0,009-0,026	0,018-0,051	0,021-0,06	0,024-0,068	0,026-0,074	0,034-0,096	0,028-0,079	0,032-0,093	0,036-0,104	0,04-0,114	0,052-0,148
	O.2.1	0,004-0,013	0,005-0,015	0,006-0,017	0,011-0,033	0,013-0,038	0,015-0,043	0,017-0,047	0,021-0,061	0,018-0,05	0,021-0,059	0,023-0,066	0,025-0,073	0,033-0,094
	O.2.2	0,004-0,012	0,005-0,014	0,006-0,016	0,011-0,032	0,013-0,037	0,015-0,042	0,016-0,046	0,021-0,059	0,017-0,049	0,02-0,057	0,022-0,064	0,025-0,07	0,032-0,091
	O.3.1													

插刀 - 使用建议

SlotCut

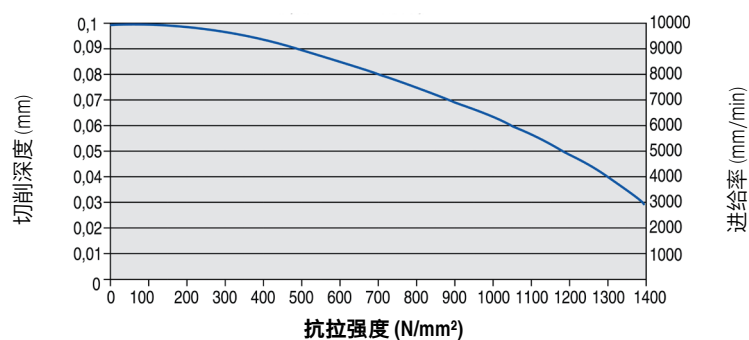
越来越多的中小批量生产采用高精度插刀。

要在一台机床上通过一次装夹加工此类凹槽，需要专门应用“插刀”。

SlotCut 系统支持最常见键槽公差的槽加工。为此提供四种选择。其中两种设计基于硬质合金解决方案，可成功用于小直径加工。对于较大直径，则更适合采用刀片式的设计。

在车床和加工中心进行插削现已成为非常经济的加工方式，可在最短时间内提供高精度的结果。

插刀加工参数推荐值



数据很大程度上取决于工况并且仅代表近似值，例如机床稳定性、应用和材料等因素。可能需要对数据进行增减调整。



操作建议

- ▲ 避免断续切削。
- ▲ 退出时，将刀具从凹槽中提起。
- ▲ 应尽可能使键槽位于零件顶部，以方便排屑！
- ▲ 使用冷却液将可增加刀具寿命，提高表面质量。
- ▲ 确保在键槽末端留有余量。
- ▲ 刀具调整不可或缺，因此必须考虑刀具直径。



图标索引

UltraMini



镗孔、仿形车削



高进给车削



车削和仿形车削 - 超级合金



镗孔



反镗



镗孔、倒角



预切槽、倒角



切槽



内径退刀槽加工



切槽、仿形车削



内螺纹车削



轴向切槽

MiniCut



镗孔、仿形车削



镗孔



反镗



镗孔、倒角



预切槽、倒角



切槽



内径退刀槽加工



切槽、仿形车削



内螺纹车削



轴向切槽

涂层



TiAlN+

- ▲ TiAlN 复合涂层
- ▲ 最高耐温: 1000 °C



TiN

- ▲ TiN 涂层
- ▲ 最高耐温: 450 °C



TiAlN

- ▲ TiAlN 复合涂层
- ▲ 最高耐温: 900 °C



CWX500

- ▲ 硬质合金, TiAlN 涂层
- ▲ 通用硬质合金牌号, 可用于几乎所有材料



DXP77S

- ▲ TiAlN+X 涂层
- ▲ 最高耐温: 900 °C



DPX57S

- ▲ TiCrN 涂层
- ▲ 最高耐温: 900 °C

螺纹标准



M

公制 ISO 标准螺纹



MF

公制 ISO 细牙螺纹



G

惠氏螺纹



Tr

公制 ISO 梯形螺纹

螺纹牙型角



30°



55°



60°

冷却



带内冷供应