



ФРЕЗЫ С ТВЕРДОСПЛАВНЫМИ ГОЛОВКАМИ 2025



Model coding rules

合金铣刀头Solid Carbide Milling Heads

S	4	GP	10	055	185	R050	M5	JF530M
合金 Carbide	齿数 Flut	工件材料 Material	刃径 Diameter	刃长 Blade Length	工作长 Job Length	圆角 Corner Radius	柄部 Shank	材质 Material

倒角铣刀头Solid Carbide Angle Milling Heads

S	4	DJD	10	185	90		M5	JF530M
合金 Carbide	齿数 Flut	形式 Form	刃径 Diameter	工作长 Job Length	倒角角度 Chamfering Angle		柄部 Shank	材质 Material

内R倒角铣刀头Internal R chamfering Milling Heads

S	4	NR	10		185	R050	M5	JF530M
合金 Carbide	齿数 Flut	形式 Form	刃径 Diameter		工作长 Job Length	圆角 Corner Radius	柄部 Shank	材质 Material

螺纹铣刀头Solid Carbide Thread Milling Heads

KH	TW	1200	D	I	1.50	ISO	M5	JK10CA
1	三牙 Three Teeth	刃径 Diameter	齿数 Flut	内螺纹 Internal Thread	螺距 Pitch	标准 ISO	柄部 Shank	材质 Material



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Material profile

JF520M

基体材质适用于中低速，高进给切削，Si+TiAlN复合涂层，具有很好的红韧性。

非常适合加工硬度HRC35-50的钢件、不锈钢、铜合金、铸铁等。

The base material is suitable for low to medium speed, high feed cutting, Si+TiAlN composite coating, with good red toughness.

Very suitable for processing steel parts, stainless steel, copper alloy, cast iron, etc. with hardness HRC35-50

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JF530M

基体材质适用于中低速，高进给切削，ALCrN涂层，适合加工 $\leq$ HRC35的钢件，不锈钢、钛合金、高温合金材料。

The substrate material is suitable for low and medium speed, high feed cutting, ALCrN coating, suitable for machining $\leq$ HRC35 steel, stainless steel, titanium alloy, high temperature alloy materials.

JF500

优质微晶颗粒材料制成的硬质合金，非常好的韧性降低了刀具的磨损率，微晶粒结构使铣刀非常锋利。

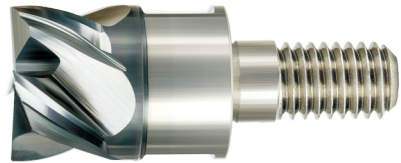
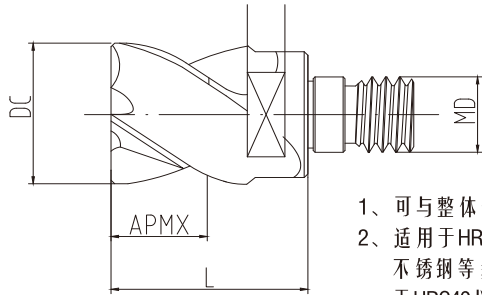
Carbide made of high quality microcrystalline grain material, very good toughness reduces the wear rate of the tool and the microcrystalline grain structure makes the milling cutter very sharp.

JFN05

高性能材质，DLC类金刚石涂层用于铝合金等有色材料的加工，韧性好，耐磨损的材质。

High-performance materials, DLC diamond-like coating is used for machining of aluminum alloys and other non-ferrous materials, toughness and wear-resistant materials.

Solid Carbide Endmill Heads S4GP



- 1、可与整体合金刀杆组合使用。

2、适用于HRC50以下的钢、预硬钢、调质钢、不锈钢等多种材料的高效加工，尤其适用于HRC40以下碳素钢、低碳合金钢等软材料的切削加工。

3、规格从D10到D32。
- 1、 Can be used in combination with integral alloy toolholder.

2、 Suitable for HRC50 below steel, pre-hardened steel, tempered steel, stainless steel and other materials for efficient processing, especially suitable for HRC40 below carbon steel, low carbon alloy steel and other soft materials cutting processing.

3、 Specifications from D10 to D32.

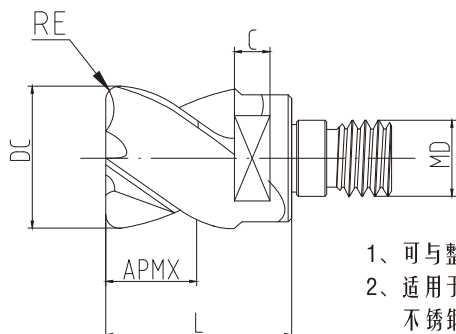
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S4GP12065195M6	12	M6	6.5	19.5	5.5	10	4			●	●
S4GP16085235M8	16	M8	8.5	23.5	7	14	4			●	●
S4GP20110260M10	20	M10	11	26	8.5	18	4			●	●
S4GP25135295M12	25	M12	13.5	29.5	11	23	4				
S4GP32170420M16	32	M16	17	42	15	30	4				

订货示例Order example：S4GP16085235M8 JF530M

●	常备库存 Running stock
○	订单生产 Order production

说明Description：1. 齿数、半径和表格中尺寸不同可非标定制；The number of teeth, radius and the size in the table are different can be customized non-standard；
2. Ap小于或等于表中尺寸具有更好性价比。Ap is smaller or equal to the dimensions in the table for better cost performance.

Solid Carbide Endmill Heads S4GP with Various Corner Radius



- 1、可与整体合金刀杆组合使用。
- 2、适用于HRC50以下的钢、预硬钢、调质钢、不锈钢等多种材料的高效加工，尤其适用于HRC40以下碳素钢、低碳合金钢等软材料的切削加工。
- 3、规格从D10到D32。

- 1、Can be used in combination with integral alloy toolholder.
- 2、Suitable for HRC50 below steel, pre-hardened steel, tempered steel, stainless steel and other materials for efficient processing, especially suitable for HRC40 below carbon steel, low carbon alloy steel and other soft materials cutting processing.
- 3、Specifications from D10 to D32.

型 号 Model	基本尺寸 Basic dimensions								材质 Material			
	DC	MD	APMX	L	RE	C	W	Z	JFN05	JF500	JF520M	JF530M
S4GP10055185R050M5	10	M5	5.5	18.5	0.5	5	8	4			●	●
S4GP12065195R050M6	12	M6	6.5	19.5	0.5	5.5	10	4			●	●
S4GP16085235R050M8	16	M8	8.5	23.5	0.5	7	14	4			●	●
S4GP20110260R050M10	20	M10	11	26	0.5	8.5	18	4			●	●
S4GP25135295R050M12	25	M12	13.5	29.5	0.5	11	23	4			○	○
S4GP32170420R050M16	32	M16	17	42	0.5	15	30	4			○	○
S4GP10055185R100M5	10	M5	5.5	18.5	1.0	5	8	4			●	●
S4GP12065195R100M6	12	M6	6.5	19.5	1.0	5.5	10	4			●	●
S4GP16085235R100M8	16	M8	8.5	23.5	1.0	7	14	4			●	●
S4GP20110260R100M10	20	M10	11	26	1.0	8.5	18	4			●	●
S4GP25135295R100M12	25	M12	13.5	29.5	1.0	11	23	4			○	○
S4GP32170042R100M16	32	M16	17	42	1.0	15	30	4			○	○
S4GP10055185R200M5	10	M5	5.5	18.5	2.0	5	8	4			●	●
S4GP12065195R200M6	12	M6	6.5	19.5	2.0	5.5	10	4			●	●
S4GP16085235R200M8	16	M8	8.5	23.5	2.0	7	14	4			●	●
S4GP20110260R200M10	20	M10	11	26	2.0	8.5	18	4			●	●
S4GP25135295R200M12	25	M12	13.5	29.5	2.0	11	23	4			○	○
S4GP32170042R200M16	32	M16	17	42	2.0	15	30	4			○	○
S4GP10055185R300M5	10	M5	5.5	18.5	3.0	5	8	4			●	●
S4GP12065195R300M6	12	M6	6.5	19.5	3.0	5.5	10	4			●	●
S4GP16085235R300M8	16	M8	8.5	23.5	3.0	7	14	4			●	●
S4GP20110260R300M10	20	M10	11	26	3.0	8.5	18	4			●	●
S4GP25135295R300M12	25	M12	13.5	29.5	3.0	11	23	4			○	○
S4GP32170042R300M16	32	M16	17	42	3.0	15	30	4			○	○
S4GP12065195R500M6	12	M6	6.5	19.5	5.0	5.5	10	4			●	●
S4GP16085235R500M8	16	M8	8.5	23.5	5.0	7	14	4			●	●
S4GP20110260R500M10	20	M10	11	26	5.0	8.5	18	4			●	●
S4GP25135295R500M12	25	M12	13.5	29.5	5.0	11	23	4			○	○
S4GP32170042R500M16	32	M16	17	42	5.0	15	30	4			○	○

订货示例 Order example: S4GP16085235R300M8 JF530M



常备库存 Running stock
订单生产 Order production

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A

Grooving

B

Threading

C

Turning

D

Drilling

M

Milling

F

Taps

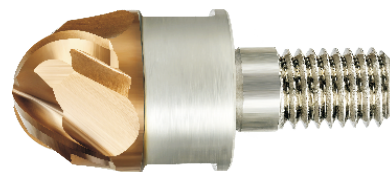
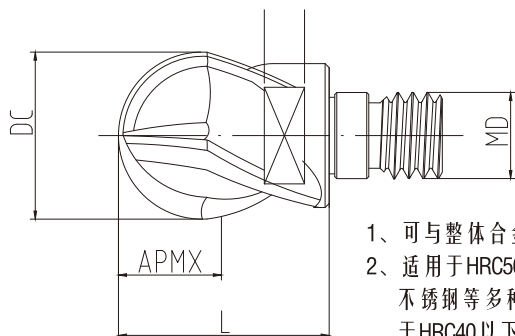
G

Special Tools

H

Technical Info

Solid Carbide Ball Nose Milling Heads S4GP



- 1、可与整体合金刀杆组合使用。
- 2、适用于HRC50以下的钢、预硬钢、调质钢、不锈钢等多种材料的高效加工，尤其适用于HRC40以下碳素钢、低碳合金钢等软材料的切削加工。
- 3、规格从D10到D32。

- 1、Can be used in combination with integral alloy toolholder.
- 2、Suitable for HRC50 below steel, pre-hardened steel, tempered steel, stainless steel and other materials for efficient processing, especially suitable for HRC40 below carbon steel, low carbon alloy steel and other soft materials cutting processing.
- 3、Specifications from D10 to D32.

型 号 Model	基本尺寸 Basic dimensions							材质 Material			
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S4GP16085235BM8	16	M8	8.5	23.5	7	14	4			●	●
S4GP20110260BM10	20	M10	11	26	8.5	18	4			●	●
S4GP25135295BM12	25	M12	13.5	29.5	11	23	4			○	○
S4GP32170042BM16	32	M16	17	42	15	30	4			○	○

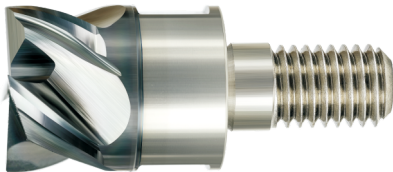
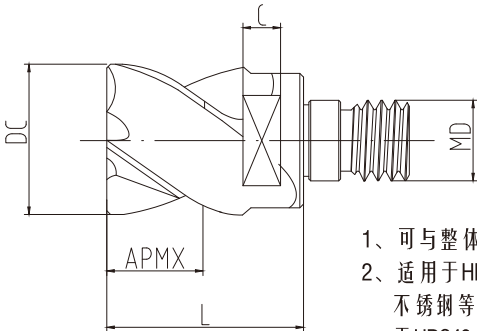
订货示例 Order example: S4GP16085235BM8 JF530M



常备库存 Running stock
订单生产 Order production

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Solid Carbide Endmill Heads S5GP



- 1、可与整体合金刀杆组合使用。

2、适用于HRC50以下的钢、预硬钢、调质钢、不锈钢等多种材料的高效加工，尤其适用于HRC40以下碳素钢、低碳合金钢等软材料的切削加工。

3、规格从D10到D32。
- 1、Can be used in combination with integral alloy toolholder.

2、suitable for HRC50 below steel, pre-hardened steel, tempered steel, stainless steel and other materials for efficient processing, especially suitable for HRC40 below carbon steel, low carbon alloy steel and other soft materials cutting processing.

3、Specifications from D10 to D32.

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S5GP10055185M5	10	M5	5.5	18.5	5	8	5			●	●
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S5GP16085235M8	16	M8	8.5	23.5	7	14	5			●	●
S5GP20110260M10	20	M10	11	26	8.5	18	5			●	●
S5GP25135295M12	25	M12	13.5	29.5	11	23	5			○	○
S5GP32170042M16	32	M16	17	42	15	30	5			○	○

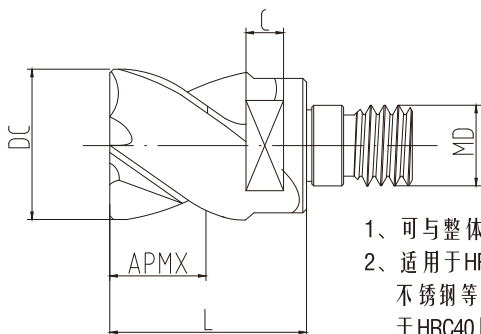
订货示例Order example：S5GP16085235M8 JF530M



常备库存 Running stock
订单生产 Order production

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Solid Carbide Endmill Heads S5GP with Various Corner Radius



- 1、可与整体合金刀杆组合使用。
- 2、适用于HRC50以下的钢、预硬钢、调质钢、不锈钢等多种材料的高效加工，尤其适用于HRC40以下碳素钢、低碳合金钢等软材料的切削加工。
- 3、规格从D10到D32。

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- 3、Specifications from D10 to D32.

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S5GP12065195R050M6	12	M6	6.5	19.5	0.5	5.5	10	5			●	●
S5GP16085235R050M8	16	M8	8.5	23.5	0.5	7	14	5			●	●
S5GP20110260R050M10	20	M10	11	26	0.5	8.5	18	5			●	●
S5GP25135295R050M12	25	M12	13.5	29.5	0.5	11	23	5			○	○
S5GP32170042R050M16	32	M16	17	42	0.5	15	30	5			○	○
S5GP10055185R100M5	10	M5	5.5	18.5	1.0	5	8	5			●	●
S5GP12065195R100M6	12	M6	6.5	19.5	1.0	5.5	10	5			●	●
S5GP16085235R100M8	16	M8	8.5	23.5	1.0	7	14	5			●	●
S5GP20110260R100M10	20	M10	11	26	1.0	8.5	18	5			●	●
S5GP25135295R100M12	25	M12	13.5	29.5	1.0	11	23	5			○	○
S5GP32170042R100M16	32	M16	17	42	1.0	15	30	5			○	○
S5GP10055185R200M5	10	M5	5.5	18.5	2.0	5	8	5			●	●
S5GP12065195R200M6	12	M6	6.5	19.5	2.0	5.5	10	5			●	●
S5GP16085235R200M8	16	M8	8.5	23.5	2.0	7	14	5			●	●
S5GP20110260R200M10	20	M10	11	26	2.0	8.5	18	5			●	●
S5GP25135295R200M12	25	M12	13.5	29.5	2.0	11	23	5			○	○
S5GP32170042R200M16	32	M16	17	42	2.0	15	30	5			○	○
S5GP10055185R300M5	10	M5	5.5	18.5	3.0	5	8	5			●	●
S5GP12065195R300M6	12	M6	6.5	19.5	3.0	5.5	10	5			●	●
S5GP16085235R300M8	16	M8	8.5	23.5	3.0	7	14	5			●	●
S5GP20110260R300M10	20	M10	11	26	3.0	8.5	18	5			●	●
S5GP25135295R300M12	25	M12	13.5	29.5	3.0	11	23	5			○	○
S5GP32170042R300M16	32	M16	17	42	3.0	15	30	5			○	○
S5GP12065195R500M6	12	M6	6.5	19.5	5.0	5.5	10	5			●	●
S5GP16085235R500M8	16	M8	8.5	23.5	5.0	7	14	5			●	●
S5GP20110260R500M10	20	M10	11	26	5.0	8.5	18	5			●	●
S5GP25135295R500M12	25	M12	13.5	29.5	5.0	11	23	5			○	○
S5GP32170042R500M16	32	M16	17	42	5.0	15	30	5			○	○

订货示例 Order example: S5GP16085235R300M8 JF530M



常备库存 Running stock

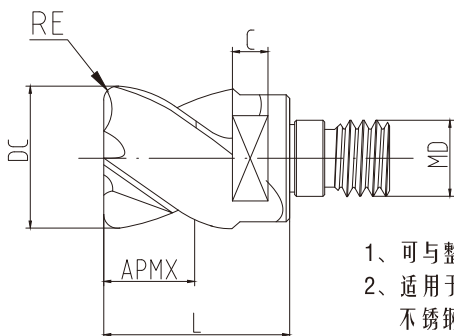
订单生产 Order production

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Solid Carbide Endmill Heads S6GP



- 1、可与整体合金刀杆组合使用。
2、适用于HRC50以下的钢、预硬钢、调质钢、不锈钢等多种材料的高效加工，尤其适用于HRC40以下碳素钢、低碳合金钢等软材料的切削加工。
3、规格从D10到D32。
- 1、 Can be used in combination with integral alloy toolholder.
2、 Suitable for HRC50 below steel, pre-hardened steel, tempered steel, stainless steel and other materials for efficient processing, especially suitable for HRC40 below carbon steel, low carbon alloy steel and other soft materials cutting processing.
3、 Specifications from D10 to D32.

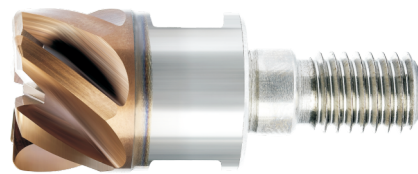
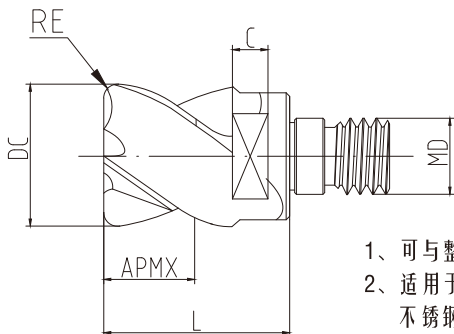
型 号 Model	基本尺寸 Basic dimensions							材质 Material			
	DC	MD	APMX	L	C	W	Z	JFN05	JF500	JF520M	JF530M
S6GP10055185M5	10	M5	5.5	18.5	5	8	6			●	●
S6GP12065195M6	12	M6	6.5	19.5	5.5	10	6			●	●
S6GP16085235M8	16	M8	8.5	23.5	7	14	6			●	●
S6GP20110260M10	20	M10	11	26	8.5	18	6			●	●
S6GP25135295M12	25	M12	13.5	29.5	11	23	6			○	○
S6GP32170042M16	32	M16	17	42	15	30	6			○	○

订货示例Order example：S6GP16085235M8 JF530M

●	常备库存 Running stock
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说明Description：1. 齿数、半径和表格中尺寸不同可非标定制；The number of teeth, radius and the size in the table are different can be customized non-standard;
2. Ap小于或等于表中尺寸具有更好性价比。
Ap is smaller or equal to the dimensions in the table for better cost performance.

Solid Carbide Endmill Heads S6GP with Various Corner Radius



- 1、可与整体合金刀杆组合使用。
- 2、适用于HRC50以下的钢、预硬钢、调质钢、不锈钢等多种材料的高效加工，尤其适用于HRC40以下碳素钢、低碳合金钢等软材料的切削加工。
- 3、规格从D10到D32。

- 1、Can be used in combination with integral alloy toolholder.
- 2、Suitable for HRC50 below steel, pre-hardened steel, tempered steel, stainless steel and other materials for efficient processing, especially suitable for HRC40 below carbon steel, low carbon alloy steel and other soft materials cutting processing.
- 3、Specifications from D10 to D32.

型 号 Model	基本尺寸 Basic dimensions								材质 Material			
	DC	MD	APMX	L	RE	C	W	Z	JFN05	JF500	JF520M	JF530M
S6GP10055185R050M5	10	M5	5.5	18.5	0.5	5	8	6			●	●
S6GP12065195R050M6	12	M6	6.5	19.5	0.5	5.5	10	6			●	●
S6GP16085235R050M8	16	M8	8.5	23.5	0.5	7	14	6			●	●
S6GP20110260R050M10	20	M10	11	26	0.5	8.5	18	6			●	●
S6GP25135295R050M12	25	M12	13.5	29.5	0.5	11	23	6			●	●
S6GP32170042R050M16	32	M16	17	42	0.5	15	30	6			●	●
S6GP10055185R100M5	10	M5	5.5	18.5	1.0	5	8	6			●	●
S6GP12065195R100M6	12	M6	6.5	19.5	1.0	5.5	10	6			●	●
S6GP16085235R100M8	16	M8	8.5	23.5	1.0	7	14	6			●	●
S6GP20110260R100M10	20	M10	11	26	1.0	8.5	18	6			●	●
S6GP25135295R100M12	25	M12	13.5	29.5	1.0	11	23	6			●	●
S6GP32170042R100M16	32	M16	17	42	1.0	15	30	6			●	●
S6GP10055185R200M5	10	M5	5.5	18.5	2.0	5	8	6			●	●
S6GP12065195R200M6	12	M6	6.5	19.5	2.0	5.5	10	6			●	●
S6GP16085235R200M8	16	M8	8.5	23.5	2.0	7	14	6			●	●
S6GP20110260R200M10	20	M10	11	26	2.0	8.5	18	6			●	●
S6GP25135295R200M12	25	M12	13.5	29.5	2.0	11	23	6			●	●
S6GP32170042R200M16	32	M16	17	42	2.0	15	30	6			●	●
S6GP10055185R300M5	10	M5	5.5	18.5	3.0	5	8	6			●	●
S6GP12065195R300M6	12	M6	6.5	19.5	3.0	5.5	10	6			●	●
S6GP16085235R300M8	16	M8	8.5	23.5	3.0	7	14	6			●	●
S6GP20110260R300M10	20	M10	11	26	3.0	8.5	18	6			●	●
S6GP25135295R300M12	25	M12	13.5	29.5	3.0	11	23	6			●	●
S6GP32170042R300M16	32	M16	17	42	3.0	15	30	6			●	●
S6GP12065195R500M6	12	M6	6.5	19.5	5.0	5.5	10	6			●	●
S6GP16085235R500M8	16	M8	8.5	23.5	5.0	7	14	6			●	●
S6GP20110260R500M10	20	M10	11	26	5.0	8.5	18	6			●	●
S6GP25135295R500M12	25	M12	13.5	29.5	5.0	11	23	6			●	●
S6GP32170042R500M16	32	M16	17	42	5.0	15	30	6			●	●

订货示例 Order example: S6GP16085235R300M8 JF530M



常备库存 Running stock



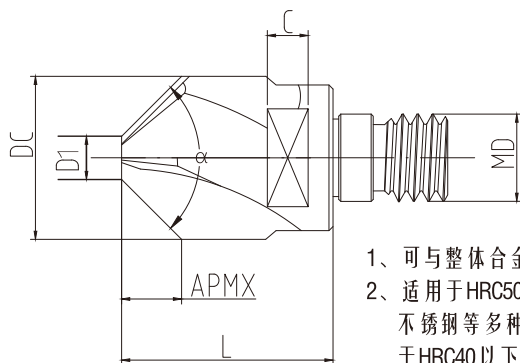
订单生产 Order production

说明 Description: 1. 齿数、半径和表格中尺寸不同可非标定制; The number of teeth, radius and the size in the table are different can be customized non-standard;

2. Ap小于或等于表中尺寸具有更好性价比。

Ap is smaller or equal to the dimensions in the table for better cost performance.

Solid Carbide Heads for Chamfering 60°/90°/120°



- 1、可与整体合金刀杆组合使用。
- 2、适用于HRC50以下的钢、预硬钢、调质钢、不锈钢等多种材料的高效加工，尤其适用于HRC40以下碳素钢、低碳合金钢等软材料的切削加工。
- 3、规格从D10到D20。

- 1、Can be used in combination with integral alloy toolholder.
- 2、Suitable for HRC50 below steel, pre-hardened steel, tempered steel, stainless steel and other materials for efficient processing, especially suitable for HRC40 below carbon steel, low carbon alloy steel and other soft materials cutting processing.
- 3、Specifications from D10 to D20.

型 号 Model	基本尺寸 Basic dimensions									材质 Material			
	DC	MD	APMX	L	D1	C	W	α	Z	JFN05	JF500	JF520M	JF530M
S4DJD1018560M5	10	M5	7	18.5	2	5	8	60°	4			●	●
S4DJD1219560M6	12	M6	8.7	19.5	2	5.5	10	60°	4			●	●
S4DJD1623560M8	16	M8	11.3	23.5	3	7	14	60°	4			●	●
S4DJD2026060M10	20	M10	13	26	5	8.5	18	60°	4			●	●

型 号 Model	基本尺寸 Basic dimensions									材质 Material			
	DC	MD	APMX	L	D1	C	W	α	Z	JFN05	JF500	JF520M	JF530M
S4DJD1018590M5	10	M5	4	18.5	2	5	8	90°	4			●	●
S4DJD1219590M6	12	M6	5	19.5	2	5.5	10	90°	4			●	●
S4DJD1623590M8	16	M8	6.5	23.5	3	7	14	90°	4			●	●
S4DJD2026090M10	20	M10	7.5	26	5	8.5	18	90°	4			●	●

型 号 Model	基本尺寸 Basic dimensions									材质 Material			
	DC	MD	APMX	L	D1	C	W	α	Z	JFN05	JF500	JF520M	JF530M
S4DJD1018560M5	10	M5	5.5	18.5	2	5	8	120°	4			●	●
S4DJD1219560M6	12	M6	6.5	19.5	2	5.5	10	120°	4			●	●
S4DJD1623560M8	16	M8	8.5	23.5	3	7	14	120°	4			●	●
S4DJD2026060M10	20	M10	11	26	5	8.5	18	120°	4			●	●

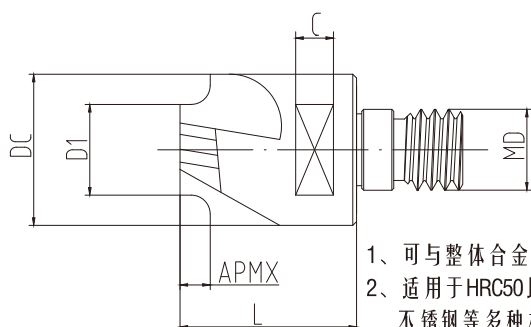
订货示例 Order example: S4DJD1018590M5 JF520M



● 常备库存 Running stock

○ 订单生产 Order production

Solid Carbide Corner Rounding Heads



- 1、可与整体合金刀杆组合使用。
- 2、适用于HRC50以下的钢、预硬钢、调质钢、不锈钢等多种材料的高效加工，尤其适用于HRC40以下碳素钢、低碳合金钢等软材料的切削加工。
- 3、规格从D10到D20。

- 1、Can be used in combination with integral alloy toolholder.
- 2、Suitable for HRC50 below steel, pre-hardened steel, tempered steel, stainless steel and other materials for efficient processing, especially suitable for HRC40 below carbon steel, low carbon alloy steel and other soft materials cutting processing.
- 3、Specifications from D10 to D20.

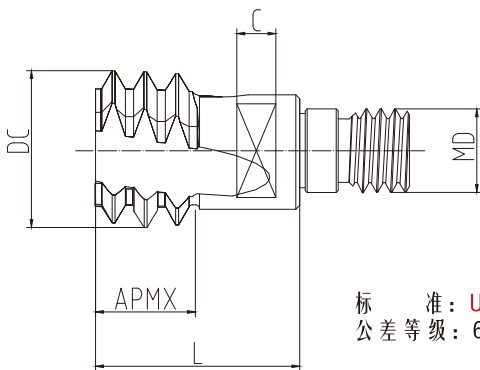
型 号 Model	基本尺寸 Basic dimensions									材 质 Material			
	DC	MD	APMX	L	D1	C	W	R	Z	JFN05	JF500	JF520M	JF530M
S4NR10185R050M5	10	M5	1	18.5	5	5	8	0.5	4			●	●
S4NR10185R100M5	10	M5	1.5	18.5	5	5	8	1	4			●	●
S4NR10185R150M5	10	M5	2	18.5	5	5	8	1.5	4			●	●
S4NR10185R200M5	10	M5	2.5	18.5	5	5	8	2	4			●	●
S4NR12195R050M6	12	M6	1	19.5	5	5.5	10	0.5	4			●	●
S4NR12195R100M6	12	M6	1.5	19.5	5	5.5	10	1	4			●	●
S4NR12195R150M6	12	M6	2	19.5	5	5.5	10	1.5	4			●	●
S4NR12195R200M6	12	M6	2.5	19.5	5	5.5	10	2	4			●	●
S4NR16235R050M8	16	M8	1	23.5	6	7	14	0.5	4			●	●
S4NR16235R100M8	16	M8	1.5	23.5	6	7	14	1	4			●	●
S4NR16235R150M8	16	M8	2	23.5	6	7	14	1.5	4			●	●
S4NR16235R200M8	16	M8	2.5	23.5	6	7	14	2	4			●	●
S4NR16235R250M8	16	M8	3	23.5	6	7	14	2.5	4			●	●
S4NR16235R300M8	16	M8	3.5	23.5	6	7	14	3	4			●	●
S4NR20260R050M10	20	M10	1	26	8	8.5	18	0.5	4			●	●
S4NR20260R100M10	20	M10	1.5	26	8	8.5	18	1	4			●	●
S4NR20260R150M10	20	M10	2	26	8	8.5	18	1.5	4			●	●
S4NR20260R200M10	20	M10	2.5	26	8	8.5	18	2	4			●	●
S4NR20260R250M10	20	M10	3	26	8	8.5	18	2.5	4			●	●
S4NR20260R300M10	20	M10	3.5	26	8	8.5	18	3	4			●	●

订货示例 Order example: S4NR12195R200M6 JF520M

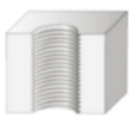
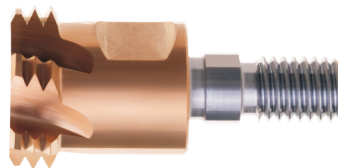


常备库存 Running stock
订单生产 Order production

Solid Carbide Heads with Threaded Connection for Internal ISO Metric Thread



标准：USA NBS H28
公差等级：6H



通孔



盲孔

◇螺旋角15°

◇可加工：□HRC40钢件、铸铁、
不锈钢、耐热合金、铝合金

◇Helical Angle 15°

◇Work materials : ≤HRC40 Low-carbon steel、Cast iron、Heat t-resistant Material、ALUMINUM alloy

首选	●
备选	○

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

螺距	螺纹 Thread		产品订货号	结构尺寸Dimensions mm							齿数	螺纹底孔	JK10CA	JK20CB	JK10F
Pitch	M/粗牙	MF/细牙	Ordering Code	DC	MD	APMX	C	W	L	Z		mm			
1.50		M14×1.5	KHTW1200DI1.50ISO-M5	12	M5	4.5	5	8	20.5	4		12.5	✓	✓	✓
1.50		M16×1.5	KHTW1400DI1.50ISO-M6	14	M6	4.5	5.5	10	20.5	4		14.5	✓	✓	✓
1.50		M20×1.5	KHTW1800FI1.50ISO-M8	18	M8	4.5	7	14	33	6		18.5	✓	✓	✓
1.50		M24×1.5	KHTW2000FI1.50ISO-M8	20	M8	4.5	7	14	33	6		22.5	✓	✓	✓
2.00	M14×2		KHTW1160DI2.00ISO-M5	11.6	M5	6	5	8	20.5	4		12.0	✓	✓	✓
2.00	M16×2		KHTW1360DI2.00ISO-M6	13.6	M6	6	5.5	10	20.5	4		14.0	✓	✓	✓
2.50	M20×2.5		KHTW1710FI2.50ISO-M8	17.1	M8	7.5	7	14	33	6		17.5	✓	✓	✓
3.00	M24×3.0		KHTW2000FI3.00ISO-M8	20	M8	9	7	14	33	6		21.0	✓	✓	✓

订货示例Order example：KHTW2000FI1.50ISO-M8 JK10CA

●
○

常备库存 Running stock
订单生产 Order production

A

Grooving

B

Threading

C

Turning

D

Drilling

M

Milling

F

Taps

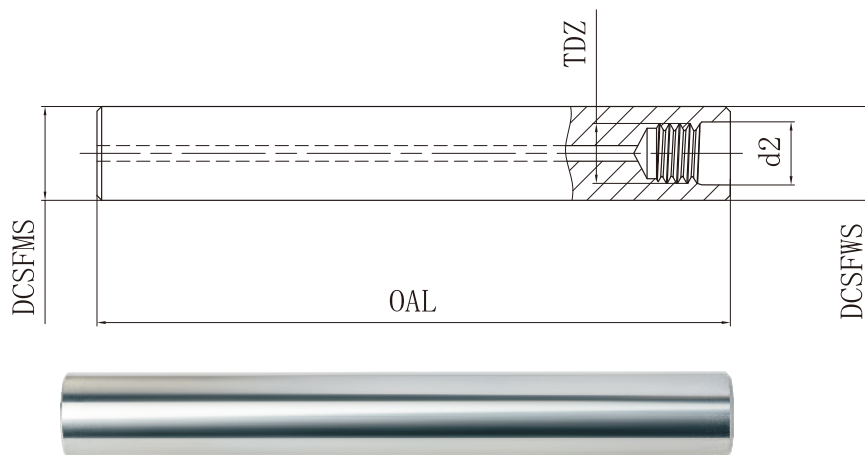
G

Special Tools

H

Technical Info

Cylindrical Shanks Carrying Interchangeable Milling Heads



型 号 Model	Overall dimensions				
	DCSFMS	TDZ	d2	OAL	DCSFMS
XCH10-100-M5	10	M5	5.5	100	10
XCH10-150-M5	10	M5	5.5	150	10
XCH10-200-M5	10	M5	5.5	200	10
XCH12-100-M6	12	M6	6.5	100	12
XCH12-150-M6	12	M6	6.5	150	12
XCH12-200-M6	12	M6	6.5	200	12
XCH16-100-M8	16	M8	8.5	100	16
XCH16-150-M8	16	M8	8.5	150	16
XCH16-200-M8	16	M8	8.5	200	16
XCH16-250-M8	16	M8	8.5	250	16
XCH20-100-M10	20	M10	10.5	100	20
XCH20-150-M10	20	M10	10.5	150	20
XCH20-200-M10	20	M10	10.5	200	20
XCH20-250-M10	20	M10	10.5	250	20
XCH25-100-M12	25	M12	12.5	100	25
XCH25-150-M12	25	M12	12.5	150	25
XCH25-200-M12	25	M12	12.5	200	25
XCH25-250-M12	25	M12	12.5	250	25
XCH25-300-M12	25	M12	12.5	300	25
XCH25-350-M12	25	M12	12.5	350	25
XCH32-100-M16	32	M16	16.5	100	32
XCH32-150-M16	32	M16	16.5	150	32
XCH32-200-M16	32	M16	16.5	200	32
XCH32-250-M16	32	M16	16.5	250	32
XCH32-300-M16	32	M16	16.5	300	32
XCH32-350-M16	32	M16	16.5	350	32

订货示例 Order example: XCH16-200-M8



常备库存 Running stock
订单生产 Order production

Cutting Data

被加工材料 Materials	钢 件 Steels		不 锈 钢 Stainless Steel		钛 合 金 Titanium alloy		高 温 合 金 Hightemperature alloys	
加工形态								
刀具直径 Tool Diameter	切削速度 Vc (m/min)	进给速度 Feed(mm/z)	切削速度 Vc (m/min)	进给速度 Feed(mm/z)	切削速度 (Vcm/min)	进给速度 Feed(mm/z)	切削速度 Vc (m/min)	进给速度 Feed(mm/z)
10	50-80	0.05-0.1	40-60	0.04-0.08	30-50	0.03-0.08	15-25	0.05-0.08
12	50-80	0.05-0.1	40-60	0.04-0.08	30-50	0.03-0.08	15-25	0.05-0.08
16	50-80	0.05-0.1	40-60	0.04-0.08	30-50	0.03-0.08	15-25	0.05-0.08
20	60-100	0.08-0.15	60-80	0.08-0.12	40-60	0.05-0.10	20-30	0.08-0.12
25	60-100	0.08-0.15	60-80	0.08-0.12	40-60	0.05-0.10	20-30	0.08-0.12
32	60-100	0.08-0.15	60-80	0.08-0.12	40-60	0.05-0.10	20-30	0.08-0.12

使用注意事项

- (1)在装夹锁牙刀头时，请务必严守推荐扭矩(请参照P***【装夹时的注意事项】)
- (2)请尽量使用专用或扭矩控制扳手。
- (3)推荐使用水溶性切削油。
- (4)请严格控制有效的刀杆夹持长度。
- (5)倾斜切入时，铁屑不易排出，请使用推荐加工参数的30~60%数值来切削。
- (6)请确保在机床精度、刚性、夹具精度、工件装夹精度及刚性都没问题的环境下使用
- (7)机床的最高转速低于推荐参数时，请与主轴转速同比例降低进给速度。
- (8)主轴转速请勿超过推荐数值。

Precautions for use

- (1) Be sure to observe the recommended torque when clamping the lock bit (refer to P*** [Precautions for Clamping]).
- (2) Please use a special or torque control wrench as much as possible.
- (3) Water-soluble cutting oil is recommended.
- (4) Please strictly control the effective toolholder clamping length.
- (5) When cutting at an angle, the iron chips are not easy to be discharged, so please use 30~60% of the recommended machining parameters to cut.
- (6) Please make sure to use it in an environment where machine accuracy, rigidity, fixture accuracy, workpiece clamping accuracy and rigidity are not a problem.
- (7) If the maximum speed of the machine is lower than the recommended parameters, reduce the feed rate in the same proportion as the spindle speed.
- (8) Do not exceed the recommended spindle speed.



CMH015

Precautions to be taken when clamping the milling cutter head

一、刀具在大悬长加工时，请参照下表合理降低加工参数

When the tool is machined with large overhang length, please refer to the following table to reasonably reduce the machining parameters

1、侧壁加工Sidewall machining

L/D	主轴转速Speed (r/min)	进给速度Feed (mm/mim)	备注Remarks
< 4D	0%	0%	——
5-6D	下调25%	下调30%	——
7-8D	下调40%	下调50%	刀具直径D20以上不建议使用 Not recommended for tool diameters above D20

2、沟槽加工Groove machining

L/D	主轴转速Speed (r/min)	进给速度Feed (mm/mim)	备注Remarks
< 4D	0%	0%	0.15D以下
5-6D	不推荐Not recommended		
7-8D	不推荐Not recommended		

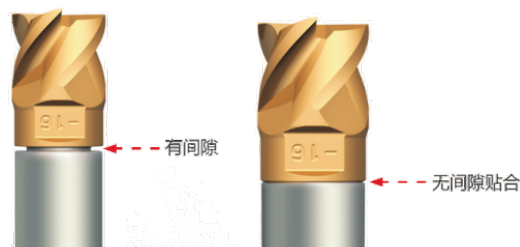
二、装夹时注意事项Precautions for Clamping

刀具直径DTool diameter D	扳手尺寸Wrench Size		推荐扭矩Recommended torque
10	8		10~11N.m
12	10		10~11N.m
16	14		10~11N.m
20	18		10~16N.m
25	23		15~20N.m
32	30		20~25N.m

注：任何刀体在供货时均不提供扳手 No wrench is supplied with any cutter body

- 1.使用干净的棉布等除去接口锥面、端面和螺纹处的油污、灰尘。
- 2.夹紧时若用手直接接触刀头刃口，有可能会受伤，请使用防护用具。
- 3.装完刀头时，若刀头、刀杆端面之间有间隙，请用扳手扭紧至完全贴合。
- 4.如操作要求严格，请使用推荐扭矩安装刀头。

1. Use a clean cotton cloth to remove oil and dust from the interface taper, end face and threads.
2. If you touch the cutting edge of the cutterhead directly with your hand during clamping, you may be injured, so please use protective equipment.
3. If there is a gap between the cutterhead and the end face of the cutterbar after loading the cutterhead, please use a wrench to tighten it until it fits perfectly.
4. If the operation requirements are strict, please use the recommended torque to install the cutterhead.





WC-Co