



MILLING

铣削

产品概况

Product Overview

加工指南

Application Guide

铣削刀片&刀杆概况

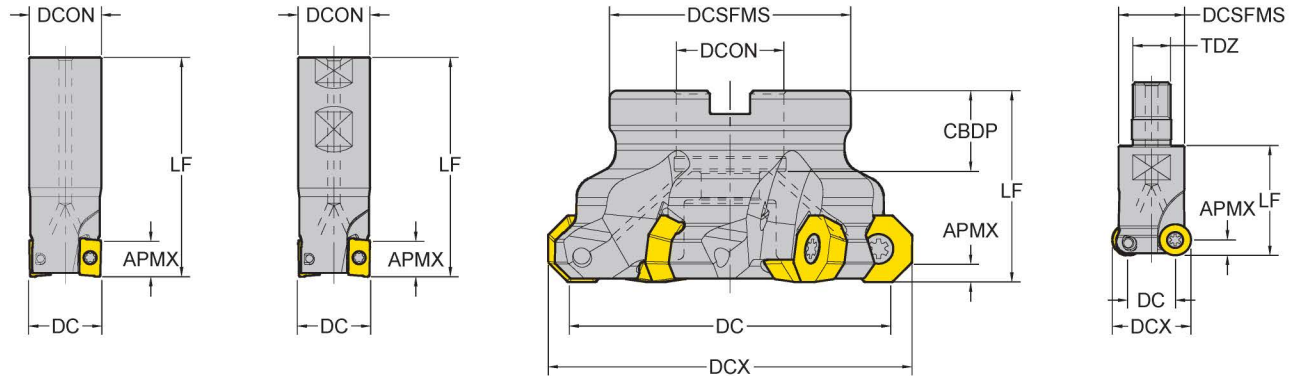
Milling Inserts & Cutter Overview

铣削刀片&刀杆

Milling Inserts & Cutter

Code Keys - Milling Cutters

编码 - 铣削刀杆



<C> Cylindrical
直柄

<W> Weldon
侧固

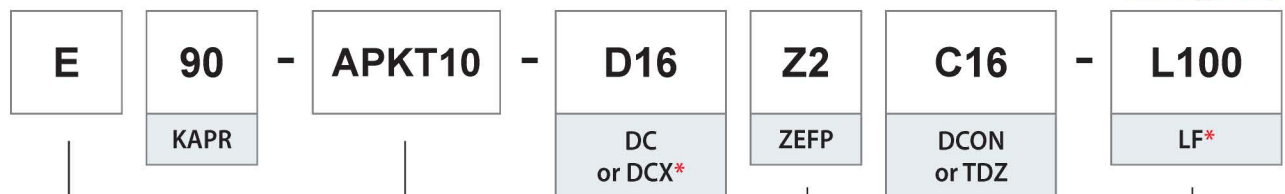
<S> Shell Mill
刀盘

<M> Modular
模块型

Cutting Angle
切削角度
(90°)

Cutter Diameter
刀杆直径
(Ø16)

Connection Type and Size 连接方式及尺寸
C - Cylindrical 直柄 W - Weldon 侧固
S - Shell Mill 刀盘 M - Modular 模块型
(Cylindrical 直柄 Ø16)



* Shank Type Only

* DCX for Round insert
* DCX为圆形刀片

Cutter Type 刀杆类型
E - Endmill Type 立铣刀
F - Facemill Type 面铣刀
M - Modular Type 模块型

Insert Series
刀片系列
(APKT 10)

Number of Teeth
刃数
(Z=2)

Functional Length
全长
(100mm)

Milling - Code System

Insert ISO Code System

铣削 - 编码系统
刀片ISO编码系统

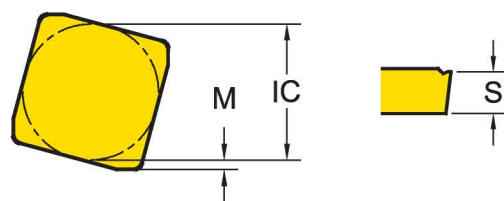
1 A Shape 形状	2 P Relief Angle (AN) 后角(AN)	3 K Tolerance 公差	4 T Clamping & Chipbreaker 夹紧 & 断屑槽	5 16 Insert Size 刀片尺寸	6 04 Insert Thickness (S) 刀片厚度(S)	7 08 Corner Radius 圆弧角
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1 - Shape 形状

Symbol 代码	Shape 形状	
H	Hexagonal 正六角形	
O	Octagonal 正八角形	
P	Pentagonal 正五边形	
S	Square 正方形	
T	Triangular 正三角形	
V	Rhombic 35° 菱形顶角35°	
W	Trigon 桃形	
L	Rectangular 长方形	
A	Parallelogram 80° 平行四边形55°	
R	.Round 圆形	

2 - Relief Angle (AN) 后角

Symbol 代码	Relief Angle 后角 (AN)	
N	No Relief Angle 无后角	
B	Relief 5° 后角 5°	
C	Relief 7° 后角 7°	
P	Relief 11° 后角 11°	
D	Relief 15° 后角 15°	
E	Relief 20° 后角 20°	
F	Relief 25° 后角 25°	
O	Special 订制	



3 - Tolerance Class 公差等级

Symbol 代码	Inner Circle 内接圆 IC (mm)	Nose Height 高度 M (mm)	Thickness 厚度 S (mm)
C	± 0.025	± 0.013	± 0.025
E	± 0.025	± 0.025	± 0.025
G	± 0.025	± 0.025	± 0.13
H	± 0.013	± 0.013	± 0.025
K*	± 0.05~0.15*	± 0.013	± 0.025
M*	± 0.05~0.15*	± 0.08~0.2*	± 0.13
U*	± 0.08~0.25*	± 0.13~0.38*	± 0.13

* Tolerance is different by insert IC size. Please see ISO 1832
* 刀片IC尺寸不同公差不同，详见ISO 1832

4 - Clamping & Chipbreaker 夹持 & 槽型

Symbol 代码	Clamping 夹持	Chipbreaker 槽型	Figure 示意图
N	No clamping hole 无孔	X	
R		One Face 单面	
W	Screw Hole 螺纹孔	X	
T		One Face 单面	
U		Both Faces 双面	
X		Special 订制	

5 - Insert Size 刀片尺寸

* No Standard for milling insert size
* 铣削刀片没有标准尺寸

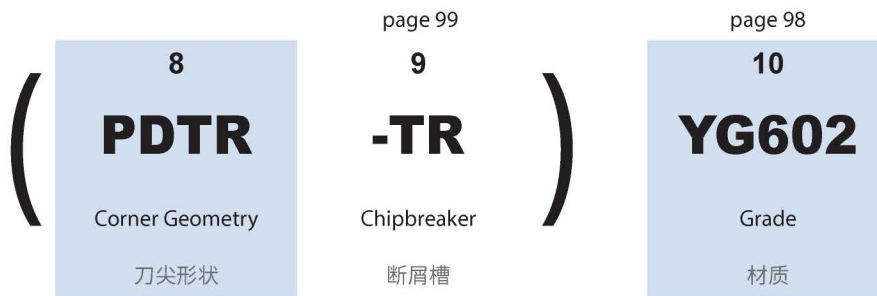
6 - Insert Thickness 刀片厚度

* No Standard for milling insert thickness
* 铣削刀片没有标准厚度

Milling - Code System

Insert ISO Code System

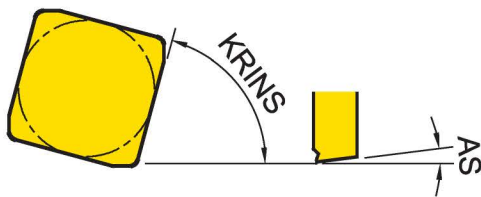
铣削 - 编码系统
刀片ISO编码系统



7 - Corner Radius (RE) 圆弧角

Symbol 代码	Thickness 厚度 - S (mm)	Symbol 代码	Thickness 厚度 - S (mm)
04	0.4	16	1.6
08	0.8	20	2.0
12	1.2	24	2.4

8 - Corner Geometry 刀尖形状



8-1 P Cutting Edge Angle (KRINS) 主偏角 (KRINS)	8-2 D Wiper Edge Clearance (AS) 修光刃后角 (AS)	8-3 T Edge Condition 刃部处理	8-4 R Feed Direction 切削方向
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*Refer to page. 99 for -AL, -ST, -TR... types
*参考99页-AL, -ST, -TR... 槽型

8-1 - Cutting Edge Angle (KRINS) 主偏角

Symbol 代码	Cutting Edge Angle 主偏角 (KRINS)
P	90°
A	45°
D	60°
E	75°
F	85°
Z	Special 订制

8-3 - Edge Condition 刃部处理

Symbol 代码	Edge Condition 刃部处理
F	Sharp 锋利
E	Rounded 圆角
T	Chamfered 倒角
S	Chamfered and Rounded 倒角及圆角

8-2 - Wiper Edge Clearance (AS) 修光刃后角

Symbol 代码	Wiper Edge Clearance 修光刃后角 (AS)
N	0°
P	11°
D	15°
E	20°
F	25°
Z	Special 订制

8-4 - Feed Direction 切削方向

Symbol 代码	Feed Direction 切削方向
R	Right-hand Insert 右手刀片
N	Neutral Insert 右, 左手刀片
L	Left-hand Insert 左手刀片

Milling Grades and Chipbreakers

铣削材质及断屑槽

Milling Grades 铣削材质

Milling Grades 铣削 材质		P Steel 钢					M Stainless steel 不锈钢				K Cast iron 铸铁				N Non-ferrous 非铁金属				S Superalloys 超耐热合金			
		P05	P15	P25	P35	P45	M05	M15	M25	M35	K05	K15	K25	K35	N05	N15	N25	N35	S05	S15	S25	S35
PVD	YG602			602					602				602							602		
	YG622			622									622									
	YG712			712																		
	YG603				603				603													603
	YG501												501									
CVD	YG5020												5020									
Uncoated	YG50														50							

YG602 P20 - P35 M20 - M40 K20 - K40 S15 - S25	 PVD - TiAlN	Universal grade for General Milling Application - Ultra Dense PVD Coating with optimal thermal resistance & strength - Sub-Micron substrate designed for demanding application	通用型，适用于普通铣削工况 - 超高密度PVD涂层具有出色的耐磨性 - 亚微米基层设计用于苛刻工况
YG622 P20 - P40 K20 - K40	 PVD - TiAlN	Optimized Grade for High Alloyed or Prehardened Steel Excellent hot hardness and oxidation resistance at high speed	最佳材质为高合金或预硬钢 在告诉加工上卓越耐热性及耐酸化性
YG712 P10 - P30	 PVD - AlTiCrN	General Milling Grade for Steel	钢件普通铣削材质
YG603 P30 - P50 M30 - M40 S30	 PVD - TiAlN	Tough Milling grade for Stainless Steel - New coating layer with high toughness and lubrication on ultra fine grain substrate with high toughness. - The toughest substrates provides excellent cutting performance in stainless steel	适应于不锈钢粗铣 - 在具有高韧性的超细晶粒基底上具有高韧性和润滑的新涂层。 - 在有硬度的不锈钢加工方面有卓越表现
YG501 K05 - K25 H05 - H25	 PVD - TiAlN	Hard Milling grade for Cast Iron - Substrate especially designed for high wear resistance - Excellent wear resistance in cast iron milling application	适应于铸铁粗铣 - 特别的高耐磨性设计的基体 - 在铸铁铣削应用中具有优异的耐磨性+
YG5020 K01-K30	 CVD TiCN - Al ₂ O ₃	CVD Milling grade for Cast Iron - CVD coating for Excellent wear resistance - Improved Toughness for chipping resistance	铸铁CVD涂层铣削 - CVD涂层具有优异的耐磨性 - 提高抗碎屑的韧性
YG50 N05 - N20	 Uncoated	Uncoated Milling Grade for Aluminium - Submicron carbide substrate for high wear resistance - Preventing built up edge with shining surface	铝的无涂层铣削等级 - 用于高耐磨性的亚微米碳化物基材 - 防止因表面光亮而形成的边缘

Milling Grades and Chipbreakers

Milling Chipbreakers 铣削断屑槽

-AL



- For Aluminum
- Very Sharp Geometry

- 铝加工
- 特别锋利形状

-ST



- For Stainless Steel, Super Alloy
- Sharp Geometry

- 不锈钢, 超耐热合金加工
- 锋利形状

General Inserts

(No Description)
普通型 (无断屑槽名)



- First Choice for General Application

- 普通工况的首选

-TR



- For Hardened Steels
- Reinforced Geometry

- 高硬度钢件加工
- 增强型形状

...W / ...N



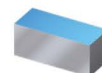
- For Hardened Material and Cast Irons

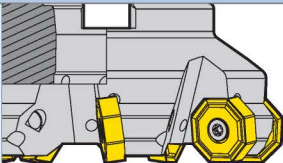
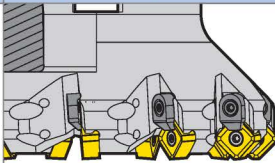
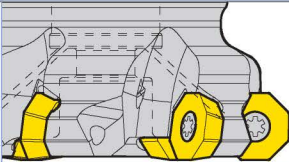
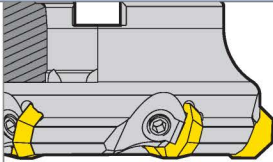
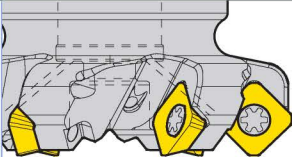
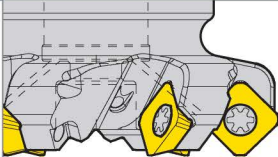
- 高硬度钢件及铸铁加工

Milling Overview

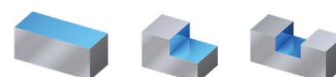
铣削概况

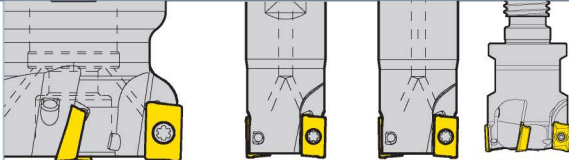
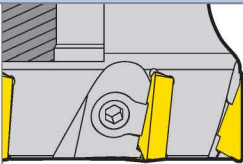
Face Milling 面铣削



Negative Octagonal 负角型 八角形				Negative Square 负角型 正方形			
Cutter			ONMU 0806			SNMX 1206	
APMX		5.5			6		
DC		Ø63~315			Ø50~200		
page		p. 103			p. 104		
Positive Octagonal 正角型 八角形							
Cutter			ODMT/ODMW 0605			OFER 0704	
APMX		3.5			5		
DC		Ø63~125			Ø63~160		
page		p. 105			p. 105		
Positive Square 正角型 正方形				ISO			
Cutter							SPKN/SPKR/SPCN 1203
APMX		6	6	6		8	
DC		Ø40~160	Ø50~160	Ø50~160		Ø50~200	
page		p. 106				p. 107	

Shoulder Milling 方肩铣削

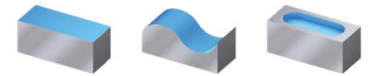


2 Corner Positive 2刀尖 正角型					
Cutter					
				APKT 1003	APKT 1604
APMX				10	16
DC				Ø16~100	Ø25~200
page				p.120-121	p.122-123
ISO					
Cutter					
		TPKN/TPKR/TPCN/TPUN 1603		TPKN/TPKR/TPCN/TPUN 2204	
APMX		12		18	
DC		Ø50~125		Ø63~315	
page		p. 124			

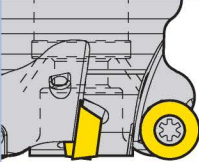
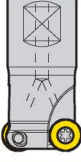
Milling Overview

铣削概况

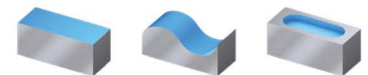
Profiling 仿形铣削



Round Positive 圆形 正角型

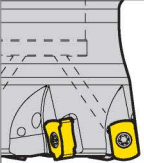
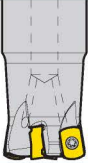
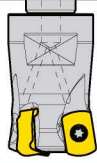
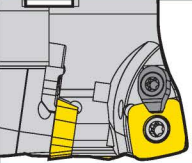
Cutter					
					0802 10T3 1204
APMX					4 5 6
DCX					Ø16~25 Ø20~63 Ø25~100
page					p. 131 p. 131 p. 132

High Feed Milling 高进给铣削



Negative 4 Corner 负角型 4刀尖

Positive 4 Corner 正角型 4刀尖

Cutter							
				0.9 1			1.8
APMX				Ø16~18 Ø20~50			Ø32~100
DCX							
page				p. 137			p. 138

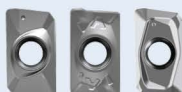
Modular Shank 模块型

Modular Shank for Modular Head 模块柄为模块头

Cutter		M08 ~ M16
page		p. 141

Milling Inserts Overview

铣削刀片概况

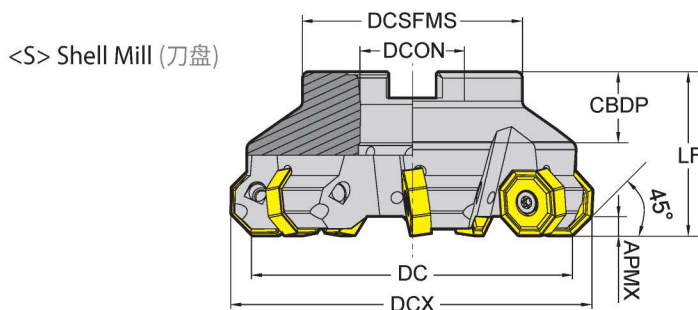
A 2 Corner 2刀尖	 Positive 正角型	ADKT	ADKT 1505	p. 125
		AOMT	AOMT 1236	p. 125
		APKT	APKT 1003, 1604	p. 126
		APMT	APMT 1135, 1504, 1604	p. 127
		APXT	APXT 1604	p. 128
E 4 Corner 4刀尖	 Negative 负角型	ENMX	ENMX, ENMX-TR	P. 139
O Octagon 八角形	 Positive 正角型	ODMT / ODMW	ODMT / ODMW 0605	p. 108
		OFER	OFER 0704	p. 109
	OFMT	OFMT 05T3		
	 Negative 负角型	ONMU / ONHU	ONMU / ONHU 0806	p. 110
R Round 圆形	 Positive Round 正角型 圆形  Positive 3 Corner 正角型 3刀尖	RDKT / RDKW	RDKT 0802, 10T3, 1204 RDKW 0501, 0702, 0802, 10T3, 1204	p. 133
		RDMT / RDMW	RDMT 0802, 0803, 10T3, 1204 RDMW 0802, 10T3, 1204	p. 134
		RPMT / RPMW	RPMT 08T2, 10T3, 1204 RPMW 1003, 1204	p. 135
		RBEX50	RBEX50	p. 136
S Square 正方形	 High Feed 高进给	SDMT / SDMW	SDMT 1204, SDMW 1204	p. 140
	 Positive 正角型	SEKT	SEKT 12T3, 1204	p. 113
		SEGT	SEGT12T3, 1204	p. 114
		SEMT	SEMT1204, 13T3	p. 115
		SPMT	SPMT 1204	p. 118
		SDKN, SDCN (45°)	SDKN, SDCN 1203, 1504	p. 111
		SEKN / SEKR (45°)	SEKR, SEKN 1203	p. 112
		SPKN / SPKR / SPCN(75°)	SPKN 1203, 1504 SPKR 1203 SPCN 1203, 1504	p. 117
	 ISO	SPUN	SPUN 1203	p. 119
	 Negative 负角型	SNMX	SNMX1206	p. 116
T Triangle 三角形	 ISO	TPKN / TPKR / TPCN(90°)	TPKN 1603, 2204 TPKR 1603, 2204 TPCN 2204	p. 129
		TPUN	TPUN 160308	p. 130

Milling - Face Milling - Cutter

Cutters for ONMU

铣削 - 面铣削 - 刀杆
刀杆为ONMU

Cutting Angle(切削角) : 45°
16 Corner Negative (刀尖 负角型)



ZEFP : Effective Number of Cutting Edges ZEFP : 有效刃数
CICT : Number of Inserts CICT : 刀片数
CDBP : Connection Bore Depth CDBP : 刀柄连接孔深度

□: p. 110 Unit(单位):mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	
ONMU 0806	5.5	F45 - ONMU08 - D63Z5S22	0493	63	75	5	40	Shellmill	22	22	49	-	-	●
		F45 - ONMU08 - D80Z6S27	0494	80	92	6	50		27	25	58	-	-	●
		F45 - ONMU08 - D100Z7S32	0495	100	112	7	50		32	26	67	-	-	●
		F45 - ONMU08 - D125Z8S40 - WOC	0496	125	137	8	63		40	32	87	-	-	X
		F45 - ONMU08 - D160Z10S40 - WOC	0497	160	172	10	63		40	32	107	66.7	-	X
		F45 - ONMU08 - D200Z12S60 - WOC	0498	200	212	12	63		60	40	130	101.6	-	X
		F45 - ONMU08 - D315Z16S60 - WOC	0499	315	327	16	63		60	40	220	101.6	177.8	X

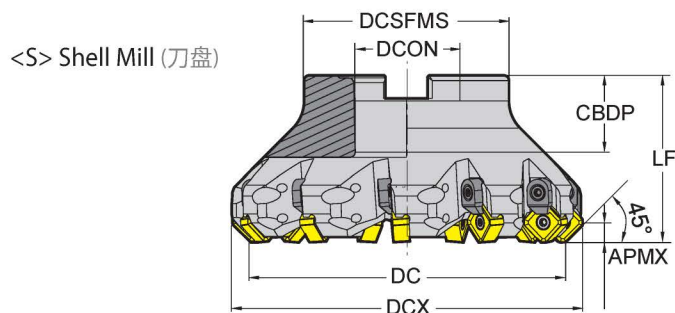
- ▶ ONHU is Available for Wiper Insert
- ▶ 可提供修光刃刀片ONHU

Milling - Face Milling - Cutter

Cutters for SNMX

铣削 - 面铣削 - 刀杆
刀杆为SNMX

Cutting Angle(切削角) : 45°
8 Corner Negative (刀尖 负角型)



ZEFP : Effective Number of Cutting Edges ZEFP : 有效刃数
CICT : Number of Inserts CICT : 刀片数
CDBP : Connection Bore Depth CDBP : 刀柄连接孔深度

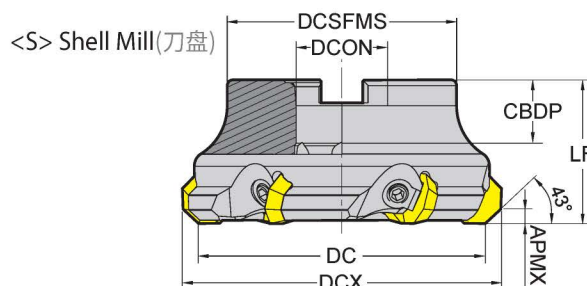
□: p. 116 Unit(单位): mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	
SNMX 1206	6.0	F45 - SNMX12 - D50Z4S22	0506	50	63	4	42	Shellmill	22	22	42	-	-	●
		F45 - SNMX12 - D50Z5S22	0507	50	63	5	42		22	22	42	-	-	●
		F45 - SNMX12 - D63Z6S22	0508	63	76	6	42		22	22	48	-	-	●
		F45 - SNMX12 - D63Z7S22	0509	63	76	7	42		22	22	48	-	-	●
		F45 - SNMX12 - D80Z7S27	0510	80	93	7	52		27	25	58	-	-	●
		F45 - SNMX12 - D80Z8S27	0511	80	93	8	52		27	25	58	-	-	●
		F45 - SNMX12 - D100Z10S32	0512	100	113	10	52		32	26	67	-	-	●
		F45 - SNMX12 - D100Z8S32	0513	100	113	8	52		32	26	67	-	-	●
		F45 - SNMX12 - D125Z11S40 - WOC	0514	125	138	11	65		40	32	80	-	-	X
		F45 - SNMX12 - D160Z12S40 - WOC	0515	160	173	12	65		40	32	110	66.7	-	X
		F45 - SNMX12 - D200Z14S60 - WOC	0516	200	213	14	65		60	40	130	101.6	-	X

Milling - Face Milling - Cutter Cutters for OFER

铣削 - 面铣削 - 刀杆
刀杆为OFER

Cutting Angle(切削角) : 43°
8 Corner Positive(刀尖 正角型)



ZEFP : Effective Number of Cutting Edges ZEFP : 有效刃数
CICT : Number of Inserts CICT : 刀片数
CDBP : Connection Bore Depth CDBP : 刀柄连接孔深度

□ : p. 109 Unit(单位):mm

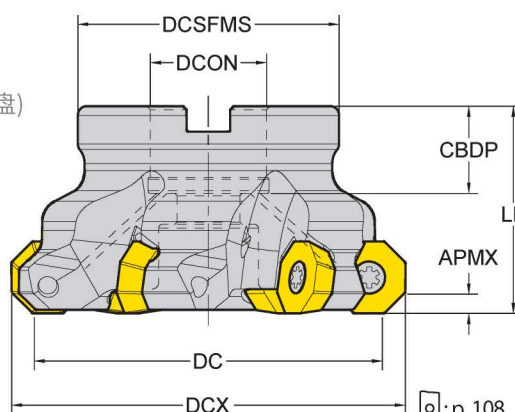
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	
OFER 0704	5.0	F43 - OFER07 - D63Z4S22 - WOC	0484	63	75	4	45	Shellmill	22	22	48	-	-	X
		F43 - OFER07 - D80Z5S27 - WOC	0485	80	92	5	50		27	25	58	-	-	X
		F43 - OFER07 - D100Z6S32 - WOC	0486	100	112	6	50		32	26	80	-	-	X
		F43 - OFER07 - D125Z8S40 - WOC	0487	125	137	8	63		40	32	85	-	-	X
		F43 - OFER07 - D160Z9S40 - WOC	0488	160	172	9	63		40	32	110	66.7	-	X

Milling - Face Milling - Cutter Cutters for ODMT, ODMW

铣削 - 面铣削 - 刀杆
刀杆为ODMT, ODMW

Cutting Angle(切削角) : 43°
8 Corner Positive(刀尖 正角型)

<S> Shell Mill(刀盘)



ZEFP : Effective Number of Cutting Edges ZEFP : 有效刃数
CICT : Number of Inserts CICT : 刀片数
CDBP : Connection Bore Depth CDBP : 刀柄连接孔深度

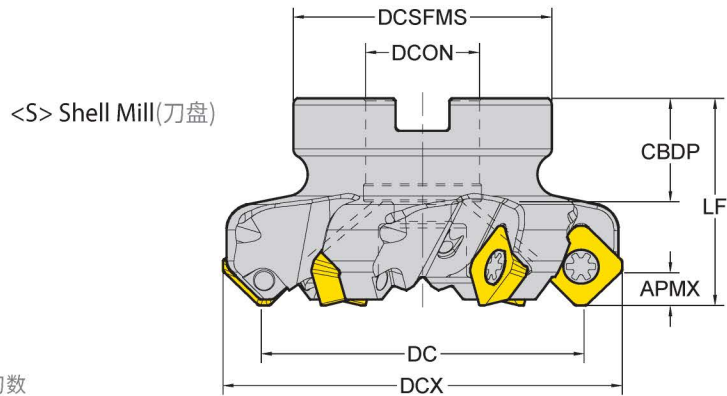
□ : p. 108 Unit(单位):mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	
ODMT ODMW 0605	3.5	F43 - ODMT06 - D63Z5S22	0001	63	73	5	40	Shellmill	22	20	50	-	-	●
		F43 - ODMT06 - D80Z6S27	0002	80	90	6	50		27	23	56	-	-	●
		F43 - ODMT06 - D100Z7S32	0003	100	110	7	50		32	26	78	-	-	●
		F43 - ODMT06 - D125Z8S40	0004	125	135	8	63		40	28	89	-	-	●

Milling - Face Milling - Cutter Cutters for SEKT, SEGT

铣削 - 面铣削 - 刀杆
刀杆为SEKT, SEGT

Cutting Angle(切削角) : 45°
4 Corner Positive(刀尖 正角型)



ZEFP : Effective Number of Cutting Edges ZEFP : 有效刃数
CICT : Number of Inserts CICT : 刀片数
CDBP : Connection Bore Depth CDBP : 刀柄连接孔深度

□: p. 113/114 Unit(单位):mm

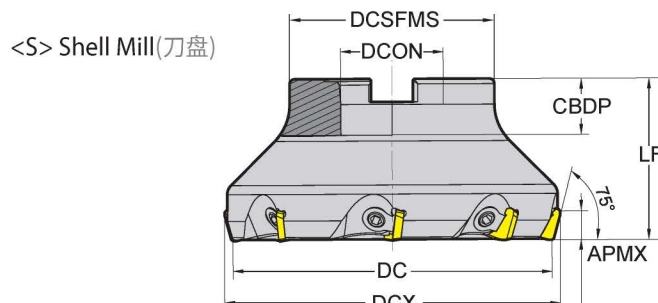
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	
SEKT SEGT 12T3	6.0	F45 - SE12T3 - D50Z4S22	0500	50	63	4	40	Shellmill	22	22	48	-	-	●
		F45 - SE12T3 - D63Z5S22	0501	63	76	5	40		22	22	48	-	-	●
		F45 - SE12T3 - D80Z6S27	0502	80	93	6	50		27	25	58	-	-	●
		F45 - SE12T3 - D100Z7S32	0503	100	113	7	50		32	26	65	-	-	●
		F45 - SE12T3 - D125Z8S40 - WOC	0504	125	138	8	63		40	32	85	-	-	X
		F45 - SE12T3 - D160Z10S40 - WOC	0505	160	173	10	63		40	32	110	66.7	-	X
SEKT SEGT 1204	6.0	F45 - SEKT12 - D40Z4S16	0031	40	54	4	40	Shellmill	16	18	32	-	-	●
		F45 - SEKT12 - D50Z5S22	0032	50	64	5	40		22	20	48	-	-	●
		F45 - SEKT12 - D63Z4S22	0033	63	77	4	40		22	20	50	-	-	●
		F45 - SEKT12 - D63Z6S22	0034	63	77	6	40		22	20	50	-	-	●
		F45 - SEKT12 - D80Z4S27	0035	80	94	4	50		27	22	56	-	-	●
		F45 - SEKT12 - D80Z7S27	0036	80	94	7	50		27	22	56	-	-	●
		F45 - SEKT12 - D100Z8S32	0037	100	114	8	50		32	25	78	-	-	●
		F45 - SEKT12 - D125Z10S40	0038	125	139	10	63		40	29	90	-	-	●
		F45 - SEKT12 - D160Z12S40	0039	160	174	12	63		40	30	114	-	-	X

Milling - Face Milling - Cutter

Cutters for SPKN, SPKR, SPCN

铣削 - 面铣削 - 刀杆
刀杆为SPKN, SPKR, SPCN

Cutting Angle(切削角) : 75°
4 Corner Positive(刀尖 正角型) ISO



ZEFP : Effective Number of Cutting Edges ZEFP : 有效刃数
CICT : Number of Inserts CICT : 刀片数
CBDP : Connection Bore Depth CBDP : 刀柄连接孔深度

□ : p. 117 Unit(单位): mm

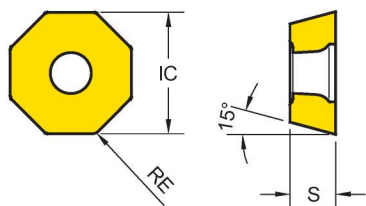
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
SPKN SPKR SPCN 1203	8.0	F75 - SPKN12 - D50Z4S22 - WOC	0611	50	56	4	40	Shellmill	22	22	42	-	-	X
		F75 - SPKN12 - D63Z5S22 - WOC	0612	63	69	5	40		22	22	48	-	-	X
		F75 - SPKN12 - D80Z6S27 - WOC	0613	80	86	6	50		27	25	58	-	-	X
		F75 - SPKN12 - D100Z7S32 - WOC	0614	100	106	7	50		32	26	65	-	-	X
		F75 - SPKN12 - D125Z8S40 - WOC	0615	125	131	8	63		40	32	80	-	-	X
		F75 - SPKN12 - D160Z9S40 - WOC	0616	160	166	9	63		40	32	110	66.7	-	X
		F75 - SPKN12 - D200Z12S60 - WOC	0617	200	206	12	63		60	40	130	101.6	-	X

Milling - Face Milling - Inserts

铣削 - 面铣削 - 刀杆

ODMT, ODMW - Face Milling Positive (8 Corners)

ODMT, ODMW - 面铣削 正角型 (8刀尖)



Series	IC	S
ODM* 0605	15.9	5.6

EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

● : Stock item 常备库存

○ : Order made item 按订单生产

ODMT ODMW	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
ODMT General 通用型 	ODMT 060508	0.8	0.21 ~ 0.35		● 0030					
ODMW Hard Materials 高硬度材料 	ODMW 060508	0.8	0.26 ~ 0.40		● 0031					

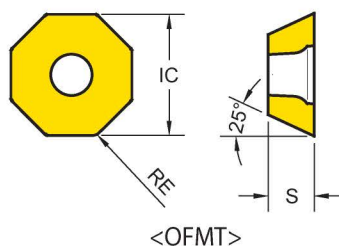
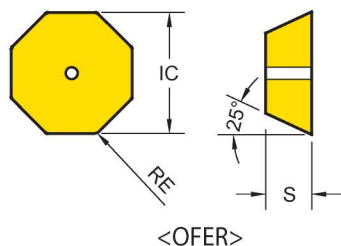
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Face Milling - Inserts

铣削 - 面铣削 - 刀杆

OFER, OFMT - Face Milling Positive (8 Corners)

OFER, OFMT - 面铣削 正角型 (8刀尖)



Series	IC	S
OFER 0704	18.05	4.78
OFMT 05T3	12.73	4.06

EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

●: Stock item 常备库存

○: Order made item 按订单生产

OFER	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
	OFER 070405	0.5	0.22 ~ 0.50		● 0209					

OFER
General
通用型



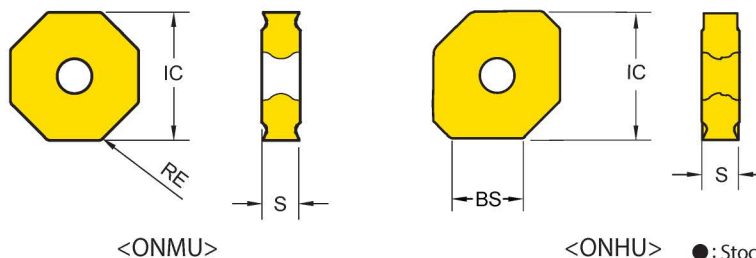
OFMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
	OFMT 05T308	0.8	0.15 ~ 0.25		● 0032					

OFMT
General
通用型



Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Series	IC	S
ON*U 0806	20.2	5.8



EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30		S30	K15	K15
S20				H15	

●: Stock item 常备库存

○: Order made item 按订单生产

ONMU ONHU	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
	ONMU 080608	0.8	0.22 ~ 0.50		● 0233					● 0414
ONMU General 通用型										
	ONHU 080612		0.08 ~ 0.25	10.6						● 0482
ONHU Wiper Insert 修光刀										

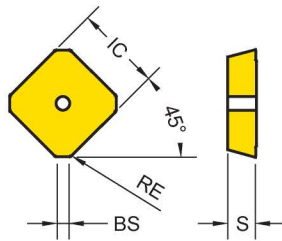
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Face Milling - Inserts

铣削 - 面铣削 - 刀杆

SDKN / CN - Face Milling Positive (4 Corners ISO)

SDKN/CN - 面铣削 正角型 (4刀尖ISO)



Series	AS	IC	S
SD** 1203	15°	12.7	3.18
SD** 1504	15°	15.88	4.76

EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

● : Stock item 常备库存

○ : Order made item 按订单生产

SDKN SDCN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
SDKN Hard Materials 高硬度材料	SDKN 1203 AETN	0.5	0.22 ~ 0.35	1.85	● 0058					
	SDKN 1203 AETN - PW	0.4	0.22 ~ 0.35	1.98	● 0253					
	SDKN 1203 AETN - GW	1.3	0.22 ~ 0.35	1.85	● 0251					
	SDKN 1504 AETN	0.45	0.22 ~ 0.35	2	● 0059					
	SDKN 1504 AETN - PW	0.4	0.22 ~ 0.40	1.95	● 0288					
	SDKN 1504 AETN - GW	1.3	0.22 ~ 0.40	2.05	● 0286					
SDCN Ground insert 无槽型	SDCN 1203 AESN - M		0.05 ~ 0.2	2.04			● 0135			
	SDCN 1504 AESN - M		0.05 ~ 0.2	2.19			● 0150			
	SDCN 1504 AESN - MR	1	0.05 ~ 0.2	2.19			● 0201			

- PW : for Improved Surface Roughness

- GW : Ground Wiper

- M : for Mold & Die

- MR : for Mold & Die Roughing

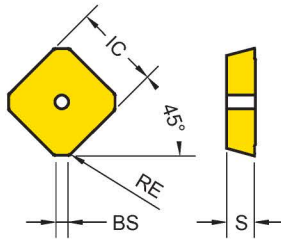
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Face Milling - Inserts

铣削 - 面铣削 - 刀杆

SEKR / N - Face Milling Positive (4 Corners ISO)

SEKR/N - 面铣削 正角型 (4刀尖ISO)



Series	AS	IC	S
SEK* 1203	20°	12.7	3.2

EDP 1200..

● : Stock item 常备库存

○ : Order made item 按订单生产

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

SEKR SEKN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
SEKR General 通用型	SEKR 1203 AFTN	0.4	0.14 ~ 0.30	1.4	● 0051					
	SEKR 1203 AFTN -PW	0.4	0.14 ~ 0.30	1.4	● 0296					
SEKN Hard Materials 高硬度材料	SEKN 1203 AFTN	0.4	0.22 ~ 0.35	1.4	● 0054					
	SEKN 1203 AFTN -PW	0.4	0.22 ~ 0.35	1.4	● 0297					
	SEKN 1203 AFTN -GW	0.4	0.23 ~ 0.35	2	● 0304					

- PW : for Improved Surface Roughness

- PW : 提高表面粗糙度

- GW : Ground Wiper

- GW : 修光刃

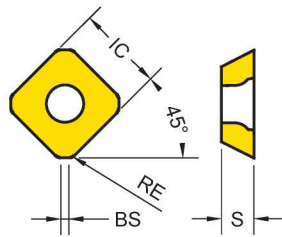
Cutting Speed 切削速度			Vc (m/min.)											
ISO	VDI	Sub Group 分组	YG602		YG622		YG712		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel 非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel 低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel 高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic 铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel 奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron 灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron 球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al) 非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium 超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials 高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Face Milling - Inserts

铣削 - 面铣削 - 刀杆

SEKT - Face Milling Positive (4 Corners)

SEKT - 面铣削 正角型 (4刀尖)



Series	IC	S
SEKT 1204	12.7	4.9
SEKT 12T3	13.4	4

EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

●: Stock item 常备库存

○: Order made item 按订单生产

SEKT 1204	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
SEKT 1204 General 通用型	SEKT 1204 AFTN	1.1	0.20 ~ 0.35	1.18	● 0055					
-ST Stainless Steel Super Alloy 不锈钢 超耐热合金	SEKT 1204 - ST	1.1	0.08 ~ 0.30	1.18	● 0257					

SEKT 12T3	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
SEKT 12T3 General 通用型	SEKT 12T3 AGTN	1.5	0.15 ~ 0.30	1.3	● 0056					
-ST Stainless Steel Super Alloy 不锈钢 超耐热合金	SEKT 12T3 - ST	1.5	0.08 ~ 0.30	1.3	● 0271					

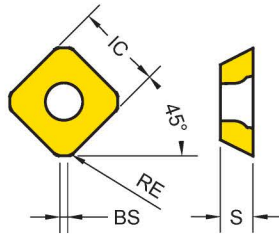
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Face Milling - Inserts

SEGT - Face Milling Positive (4 Corners)

铣削 - 面铣削 - 刀杆

SEGT - 面铣削 正角型 (4刀尖)



Series	IC	S
SEGT 1204	12.74	4.91
SEGT 12T3	13.4	4.03

EDP 1200..

P25	P30	P20	P40			
M30			M35			
K30	K30			K15	K15	
S20			S30	H15		N15

● : Stock item 常备库存

○ : Order made item 按订单生产

SEGT 1204	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020	YG50
	SEGT 1204-AL	1.1	0.1~0.35	2.01							○ 0467

-AL

Aluminium



SEGT 12T3	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020	YG50
	SEGT 12T3-AL	1.5	0.1~0.35	1.94							○ 0468

-AL

Aluminium



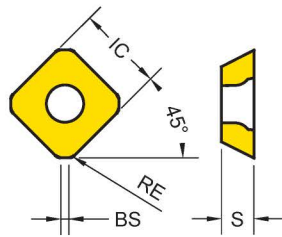
Cutting Speed 切削速度				Vc (m/min.)													
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020		YG50	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350	-	-
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	300	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-	-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-	-	-

Milling - Face Milling - Inserts

铣削 - 面铣削 - 刀杆

SEMT - Face Milling Positive (4 Corners)

SEMT - 面铣削 正角型 (4刀尖)



Series	IC	S
SEMT1204	12.92	5.1
SEMT13T3	13.4	4.0

EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

●: Stock item 常备库存

○: Order made item 按订单生产

SEMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
SEMT 1204 General 通用型	SEMT 1204 AFTN	1.2	0.26 ~ 0.4	1.24	● 0052					
SEMT 13T3 General 通用型	SEMT 13T3 AGSN	1.5	0.15 ~ 0.3	1.31	● 0203					

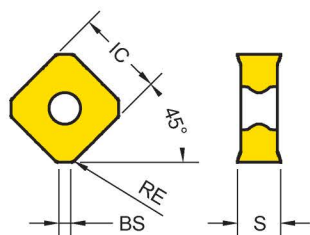
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Face Milling - Inserts

SNMX - Face Milling Negative (8 Corners)

铣削 - 面铣削 - 刀杆

SNMX - 面铣削 负角型 (8刀尖)



Series	IC	S
SNMX 1206	12.7	6.25

EDP 1200..

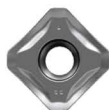
● : Stock item 常备库存

○ : Order made item 按订单生产

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

SNMX	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
	SNMX 1206 ANN	0.8	0.16 ~ 0.34	1.7	● 0231					

SNMX
General
通用型



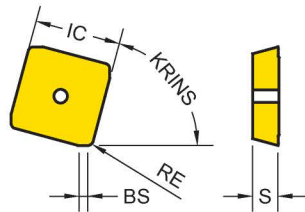
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Face Milling - Inserts

铣削 - 面铣削 - 刀杆

SPKN / R / CN - Face Milling Positive (4 Corners ISO)

SPKN/R/CN - 面铣削 正角型 (4刀尖 ISO)



Series	KRINS	AS	IC	S
SP** 1203	75°	11°	12.7	3.18
SP** 1504	75°	11°	15.88	4.76

EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

● : Stock item 常备库存

○ : Order made item 按订单生产

SPKR SPKN SPCN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
SPKR General 通用型	SPKR 1203 EDTR	0.8	0.15 ~ 0.35	1.4	● 0050					
	SPKR 1203 EDTR -PW	0.8	0.15 ~ 0.35	1.4	● 0298					
SPKN Hard Materials 高硬度材料	SPKN 1203 EDTR	0.8	0.16 ~ 0.34	1.4	● 0048					
	SPKN 1203 EDTR -PW	0.8	0.20 ~ 0.35	1.4	● 0279					
	SPKN 1203 EDTR -GW	0.6	0.15 ~ 0.28	1.51	● 0280					
	SPKN 1504 EDTR		0.15 ~ 0.34	1.3	● 0049					
	SPKN 1504 EDTR -PW		0.25 ~ 0.40	1.3	● 0299					
	SPKN 1504 EDTR -GW	0.8	0.25 ~ 0.4	2.2	● 0305					
SPCN Ground insert 无槽型	SPCN 1203 EDSR - M	0.8	0.1 ~ 0.2	1.82			● 0081			
	SPCN 1203 EDSR - MR	0.8	0.1 ~ 0.2	1.77			● 0198			
	SPCN 1504 EDSR - M	0.8	0.1 ~ 0.2	1.92			● 0098			
	SPCN 1504 EDSR - MR	0.8	0.1 ~ 0.2	1.86			● 0199			

- PW : for Improved Surface Roughness

- GW : Ground Wiper

- M : for Mold & Die

- MR : for Mold & Die Roughing

- PW : 提高表面粗糙度

- GW : 修光刃

- M : 用于模具工件

- MR : 用于模具工件粗加工

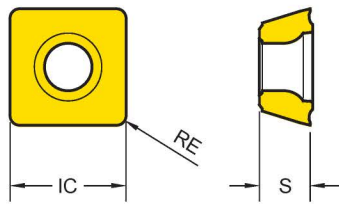
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Face Milling - Inserts

SPMT - Universal Positive (4 Corners)

铣削 - 面铣削 - 刀杆

SPMT - 面铣削 正角型 (4刀尖)



Series	AS	IC	S
SPMT 1204	11°	12.7	4.81

EDP 1200..

● : Stock item 常备库存

○ : Order made item 按订单生产

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

SPMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
	SPMT 120408	0.8	0.15 ~ 0.3		● 0223					

SPMT
General
通用型



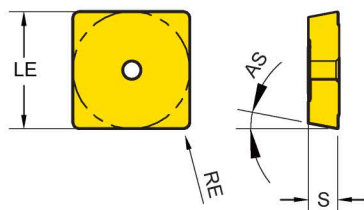
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Face Milling - Inserts

铣削 - 面铣削 - 刀杆

SPUN - Universal Positive (4 Corners ISO)

SPUN - 通用型 正角型 (4刀尖 ISO)



Series	AS	IC	S
SPUN 1203	11°	12.7	3.2

EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

●: Stock item 常备库存

○: Order made item 按订单生产

SPUN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
	SPUN 120308	0.8			● 0224					

SPUN
General
通用型



TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

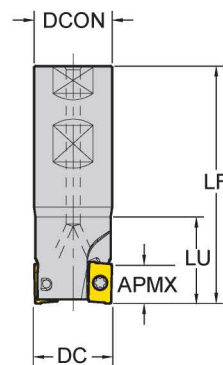
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Shoulder Milling - Cutter Cutters for APKT

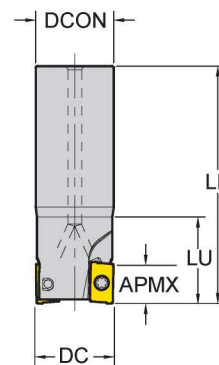
铣削 - 方肩铣削 - 刀杆
刀杆为APKT

Cutting Angle(切削角) : 90°
2 Corner Positive(刀尖 正角型)

<W> Weldon(侧固)



<C> Cyndrical(直柄)



ZEFP : Effective Number of Cutting Edges ZEFP : 有效刃数
CICT : Number of Inserts CICT : 刀片数
CBDP : Connection Bore Depth CBDP : 刀柄连接孔深度

□: p. 126 Unit(单位):mm

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CBDP	DCSFMS	PCD1	PCD2	
APKT 1003	10.0	E90 - APKT10 - D16Z2C16 - L100	0083	16	2	-	100	Cylindrical	16	-	-	-	-	●
		E90 - APKT10 - D16Z2C16 - L120	0532	16	2	30	120		16	-	-	-	-	●
		E90 - APKT10 - D16Z2C16 - L150	0154	16	2	50	150		16	-	-	-	-	●
		E90 - APKT10 - D16Z2C16 - L200	0533	16	2	100	200		16	-	-	-	-	●
		E90 - APKT10 - D20Z2C20 - L250	0534	20	2	150	250		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L100	0535	20	3	30	100		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L120	0085	20	3	-	120		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L150	0536	20	3	50	150		20	-	-	-	-	●
		E90 - APKT10 - D20Z3C20 - L200	0270	20	3	100	200		20	-	-	-	-	●
		E90 - APKT10 - D25Z3C25 - L100	0537	25	3	30	100		25	-	-	-	-	●
		E90 - APKT10 - D25Z3C25 - L120	0186	25	3	30	120		25	-	-	-	-	●
		E90 - APKT10 - D30Z4C25 - L100	0122	30	4	30	100		25	-	-	-	-	●
		E90 - APKT10 - D30Z4C25 - L120	0086	30	4	30	120		25	-	-	-	-	●
		E90 - APKT10 - D32Z4C25 - L100	0538	32	4	35	100		25	-	-	-	-	●
		E90 - APKT10 - D32Z4C25 - L150 - WOC	0539	32	4	35	150		25	-	-	-	-	X
		E90 - APKT10 - D12Z1W16 - L100	0540	12	1	30	100	Weldon	16	-	-	-	-	●
		E90 - APKT10 - D14Z1W16 - L100	0541	14	1	30	100		16	-	-	-	-	●
		E90 - APKT10 - D16Z2W16 - L100	0542	16	2	30	100		16	-	-	-	-	●
		E90 - APKT10 - D16Z2W16 - L85	0082	16	2	-	85		16	-	-	-	-	●
		E90 - APKT10 - D18Z2W16 - L100	0543	18	2	30	100		16	-	-	-	-	●

▶ NEXT PAGE

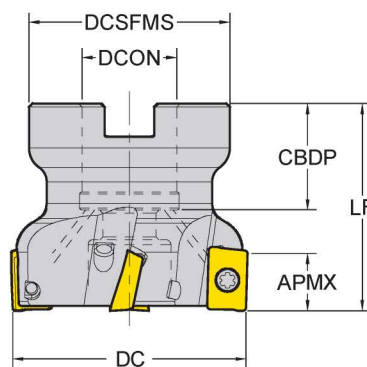
Milling - Shoulder Milling - Cutter

Cutters for APKT

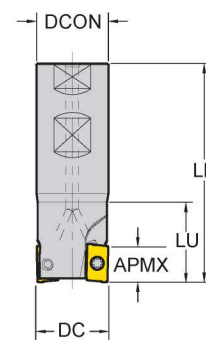
铣削 - 方肩铣削 - 刀杆
刀杆为APKT

Cutting Angle(切削角) : 90°
2 Corner Positive(刀尖 正角型)

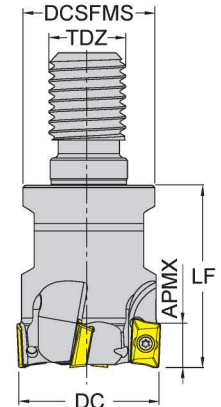
<S> Shell Mill (刀盘)



<W> Weldon(侧固)



<M> Modular(侧固)



ZEFP : Effective Number of Cutting Edges ZEFP : 有效刃数
CICT : Number of Inserts CICT : 刀片数
CDBP : Connection Bore Depth CDBP : 刀柄连接孔深度

□ : p. 126 Unit(单位):mm

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON /TDZ	CDBP	DCSFMS	PCD1	PCD2	
APKT 1003	10.0	E90 - APKT10 - D20Z3W20 - L100	0461	20	3	30	100	Weldon	20	-	-	-	-	●
		E90 - APKT10 - D20Z3W20 - L90	0084	20	3	-	90		20	-	-	-	-	●
		E90 - APKT10 - D22Z3W20 - L100	0544	22	3	30	100		20	-	-	-	-	●
		E90 - APKT10 - D25Z3W25 - L100	0545	25	3	30	100		25	-	-	-	-	●
		E90 - APKT10 - D25Z4W25 - L100	0546	25	4	30	100		25	-	-	-	-	●
		E90 - APKT10 - D32Z4W32 - L150 - WOC	0547	32	4	50	150		32	-	-	-	-	X
		F90 - APKT10 - D40Z4S16	0087	40	4	-	40	Shellmill	16	18	34	-	-	●
		F90 - APKT10 - D40Z5S16	0472	40	5	-	40		16	20	36	-	-	●
		F90 - APKT10 - D50Z6S22	0215	50	6	-	40		22	22	42	-	-	●
		F90 - APKT10 - D50Z7S22	0088	50	7	-	40		22	20	42	-	-	●
		F90 - APKT10 - D63Z7S22	0548	63	7	-	40		22	22	48	-	-	●
		F90 - APKT10 - D80Z8S27	0549	80	8	-	50		27	25	58	-	-	●
		F90 - APKT10 - D100Z9S32	0550	100	9	-	50		32	26	65	-	-	●
		M90 - APKT10 - D16Z2M08	0551	16	2	-	30	Modular	M08	-	14.75	-	-	●
		M90 - APKT10 - D20Z3M10	0552	20	3	-	30		M10	-	18	-	-	●
		M90 - APKT10 - D25Z3M12	0553	25	3	-	35		M12	-	21	-	-	●
		M90 - APKT10 - D32Z4M16	0554	32	4	-	35		M16	-	29	-	-	●
		M90 - APKT10 - D40Z5M16	0555	40	5	-	43		M16	-	29	-	-	●
		M90 - APKT10 - D42Z5M16	0556	42	5	-	43		M16	-	29	-	-	●

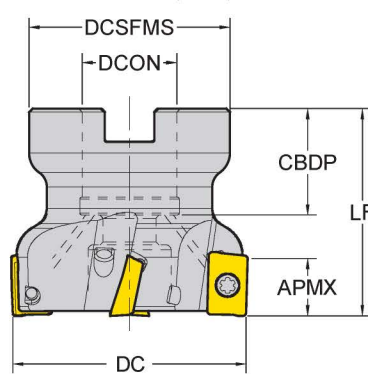
Milling - Shoulder Milling - Cutter

Cutters for APKT

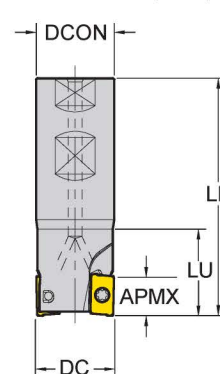
铣削 - 方肩铣削 - 刀杆
刀杆为APKT

Cutting Angle(切削角) : 90°
2 Corner Positive(刀尖 正角型)

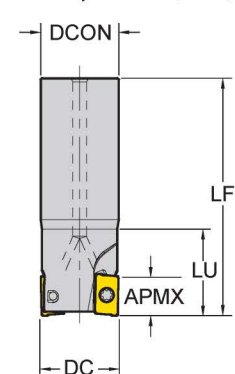
<S> Shell Mill(刀盘)



<W> Weldon(侧固)



<C> Cyindrical(直柄)



ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CDBP : Connection Bore Depth

ZEFP : 有效刃数
CICT : 刀片数
CDBP : 刀柄连接孔深度

□ : p. 126

Unit(单位):mm

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	
APKT 1604	16.0	E90 - APKT16 - D25Z2C20 - L100	0091	25	2	-	100	Cylindrical	20	-	-	-	-	●
		E90 - APKT16 - D25Z2C20 - L100 - WOC	0243	25	2	35	100		20	-	-	-	-	X
		E90 - APKT16 - D25Z2C25 - L250 - WOC	0557	25	2	100	250		25	-	-	-	-	X
		E90 - APKT16 - D32Z2C32 - L250 - WOC	0558	32	2	100	250		32	-	-	-	-	X
		E90 - APKT16 - D32Z3C25 - L110	0094	32	3	-	110		25	-	-	-	-	●
		E90 - APKT16 - D32Z3C25 - L200	0559	32	3	40	200		25	-	-	-	-	●
		E90 - APKT16 - D32Z3C32 - L150 - WOC	0250	32	3	50	150		32	-	-	-	-	X
		E90 - APKT16 - D32Z3C32 - L250 - WOC	0560	32	3	100	250		32	-	-	-	-	X
		E90 - APKT16 - D40Z4C32 - L150 - WOC	0561	40	4	40	150	Weldon	32	-	-	-	-	X
		E90 - APKT16 - D25Z2W25 - L100	0562	25	2	35	100		25	-	-	-	-	●
		E90 - APKT16 - D25Z2W25 - L110	0092	25	2	-	110		25	-	-	-	-	●
		E90 - APKT16 - D28Z3W25 - L100	0563	28	3	40	100		25	-	-	-	-	●
		E90 - APKT16 - D30Z3W25 - L110	0564	30	3	40	110		25	-	-	-	-	●
		E90 - APKT16 - D32Z3W25 - L110	0093	32	3	-	110		25	-	-	-	-	●
		E90 - APKT16 - D32Z3W32 - L110	0565	32	3	40	110		32	-	-	-	-	●
		E90 - APKT16 - D36Z3W32 - L110	0566	36	3	40	110		32	-	-	-	-	●
		F90 - APKT16 - D40Z4S16	0275	40	4	-	40	Shellmill	16	20	36	-	-	●
		F90 - APKT16 - D50Z5S22	0095	50	5	-	40		22	20	45	-	-	●

► NEXT PAGE

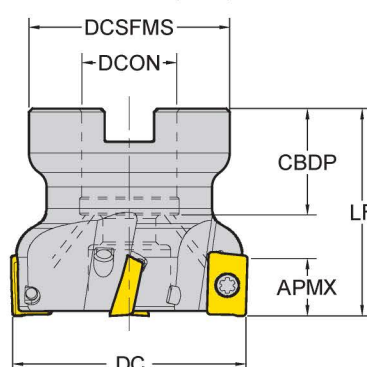
Milling - Shoulder Milling - Cutter

Cutters for APKT

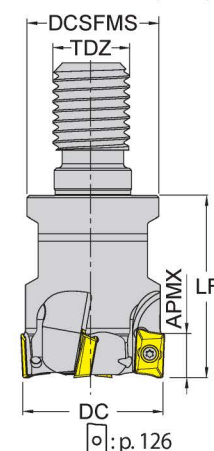
铣削 - 方肩铣削 - 刀杆
刀杆为APKT

Cutting Angle(切削角) : 90°
2 Corner Positive(刀尖 正角型)

<S> Shell Mill(刀盘)



<M> Modular(侧固)



Unit(单位):mm

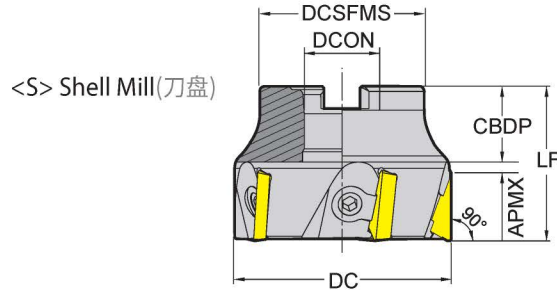
ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CDBP : Connection Bore Depth

ZEFP : 有效刀数
CICT : 刀片数
CDBP : 刀柄连接孔深度

Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON /TDZ	CDBP	DCSFMS	PCD1	PCD2	
APKT 1604	16.0	F90 - APKT16 - D52Z5S22	0567	52	5	-	40	Shellmill	22	22	42	-	-	●
		F90 - APKT16 - D63Z6S22	0096	63	6	-	40		22	20	50	-	-	●
		F90 - APKT16 - D80Z7S27	0097	80	7	-	50		27	23	56	-	-	●
		F90 - APKT16 - D100Z8S32	0181	100	8	-	50		32	26	65	-	-	●
		F90 - APKT16 - D125Z9S40 - WOC	0238	125	9	-	63		40	32	80	-	-	X
		F90 - APKT16 - D160Z10S40 - WOC	0568	160	10	-	63		40	32	110	66.7	-	X
		F90 - APKT16 - D200Z12S60 - WOC	0569	200	12	-	63		60	40	130	101.6	-	X
		M90 - APKT16 - D25Z2M12	0570	25	2	-	43	Modular	M12	-	21	-	-	●
		M90 - APKT16 - D32Z3M16	0571	32	3	-	43		M16	-	29	-	-	●
		M90 - APKT16 - D42Z4M16	0572	42	4	-	43		M16	-	29	-	-	●

Cutting Angle(切削角) : 90°

3 Corner Positive(刀尖 正角型) ISO


ZEFP : Effective Number of Cutting Edges
CICT : Number of Inserts
CDBP : Connection Bore Depth

ZEFP : 有效刃数
CICT : 刀片数
CDBP : 刀柄连接孔深度

p. 129/130

Unit(单位):mm

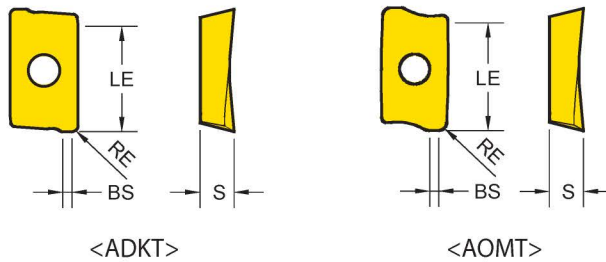
Series	APMX	Designation	EDP 1700..	DC	ZEFP	LU	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	
TPKN TPKR TPCN TPUN 1603	12.0	F90 - TPKN16 - D50Z4S22 - WOC	0618	50	4	-	40	Shellmill	22	22	42	-	-	X
		F90 - TPKN16 - D63Z6S22 - WOC	0619	63	6	-	45		22	22	48	-	-	X
		F90 - TPKN16 - D80Z7S27 - WOC	0620	80	7	-	50		27	25	58	-	-	X
		F90 - TPKN16 - D125Z8S40 - WOC	0621	125	8	-	63		40	32	80	-	-	X
TPKN TPKR TPCN TPUN 2204	18.0	F90 - TPKN22 - D63Z5S22 - WOC	0622	63	5	-	45	Shellmill	22	22	48	-	-	X
		F90 - TPKN22 - D80Z6S27 - WOC	0623	80	6	-	50		27	25	58	-	-	X
		F90 - TPKN22 - D100Z7S32 - WOC	0624	100	7	-	50		32	26	65	-	-	X
		F90 - TPKN22 - D125Z8S40 - WOC	0625	125	8	-	63		40	32	80	-	-	X
		F90 - TPKN22 - D160Z9S40 - WOC	0626	160	9	-	63		40	32	110	66.7	-	X
		F90 - TPKN22 - D200Z12S60 - WOC	0627	200	12	-	63		60	40	130	101.6	-	X
		F90 - TPKN22 - D250Z15S60 - WOC	0628	250	15	-	63		60	40	160	101.6	-	X
		F90 - TPKN22 - D315Z18S60 - WOC	0629	315	18	-	63		60	40	220	101.6	177.8	X

Milling - Shoulder Milling - Inserts

铣削 - 方肩铣削 - 刀片

ADKT / AOMT - Shoulder Milling Positive (2 Corner)

ADKT/AOMT - 方肩铣削 正角型 (2刀尖)



Series	LE	IC	S
ADKT 1505	13.7	9.7	5.8
AOMT 1236	10.5	6.6	3.6

EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

● : Stock item 常备库存
○ : Order made item 按订单生产

ADKT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
	ADKT 150508 PDTR	0.8	0.16 ~ 0.30	1.87	● 0220					

ADKT
General
通用型



AOMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
	AOMT 123604 PDTR	0.4	0.08 ~ 0.22	1.07	● 0217					
	AOMT 123608 PDTR	0.8	0.08 ~ 0.24	0.91	● 0218					

AOMT
General
通用型



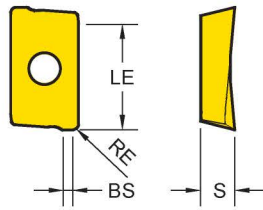
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Shoulder Milling - Inserts

APKT - Shoulder Milling Positive (2 Corner)

铣削 - 方肩铣削 - 刀片

APKT - 方肩铣削 正角型 (2刀尖)



Series	LE	IC	S
APKT 1003	9.9	6.7	3.6
APKT 1604	15.2	9.4	5.3

EDP 1200..

● : Stock item 常备库存

○ : Order made item 按订单生产

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

APKT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
APKT General 通用型	APKT 100305 PDTR	0.5	0.15 ~ 0.24	0.86	● 0005					
	APKT 100308 PDTR	0.8	0.15 ~ 0.24	0.9	● 0004					
	APKT 160404 PDTR	0.4	0.15 ~ 0.25	1.11	● 0003					
	APKT 160408 PDTR	0.8	0.15 ~ 0.30	1.32	● 0001					
	APKT 160412 PDTR	1.2	0.15 ~ 0.32	1.13	● 0002					
	APKT 160416 PDTR	1.6	0.15 ~ 0.34	1.13	● 0006					
	APKT 160424 PDTR	2.4	0.15 ~ 0.38		● 0255					
-ST Stainless Steel Super Alloy 不锈钢 超耐热合金	APKT 100305 - ST	0.5	0.08 ~ 0.22	0.86	● 0278					
	APKT 160408 - ST	0.8	0.08 ~ 0.25	1.32	● 0270					
-TR Hardened Steel 高硬度钢件	APKT 160404 - TR	0.4	0.26 ~ 0.40	2.12	● 0492	● 0505				
	APKT 160408 - TR	0.8	0.26 ~ 0.40	1.32	● 0256	● 0337				
	APKT 160412 - TR	1.2	0.26 ~ 0.40	2.4	● 0493	● 0523				
	APKT 160416 - TR	1.6	0.26 ~ 0.40	2.4	● 0472	● 0524				
	APKT 160424 - TR	2.4	0.26 ~ 0.40	1.5	● 0494	● 0520				

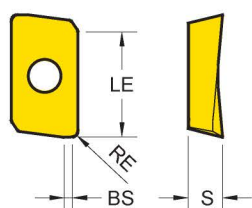
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Shoulder Milling - Inserts

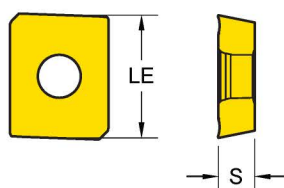
铣削 - 方肩铣削 - 刀片

APMT - Shoulder Milling Positive (2 Corner)

APMT - 方肩铣削 正角型 (2刀尖)



<APMT>



<APMT 1504>

●: Stock item 常备库存
○: Order made item 按订单生产

Series	LE	IC	S
APMT 1135	9.5	6.2	3.5
APMT 1604	14.6	9.2	4.76
APMT 1504	14	12.7	4.76

EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

APMT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
APMT General 通用型	APMT 113504 PDTR	0.4	0.15 ~ 0.22	1.26	● 0009					
	APMT 113508 PDTR	0.8	0.15 ~ 0.25	1.07	● 0010					
	APMT 160408 PDTR	0.8	0.16 ~ 0.30	1.11	● 0008		● 0423	● 0465	● 0464	
APMT 1504 General 通用型	APMT 1504		0.14 ~ 0.28		● 0276	● 0445				

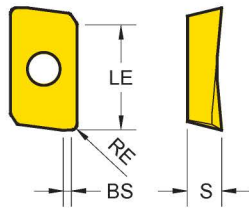
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Shoulder Milling - Inserts

APXT - Shoulder Milling Positive (2 Corner)

铣削 - 方肩铣削 - 刀片

APXT - 方肩铣削 正角型 (2刀尖)



Series	LE	IC	S
APXT 1604	14.6	9.2	4.8

EDP 1200..

P25	P30	P20	P40			
M30			M35			
K30	K30			K15	K15	
S20			S30	H15		N15
YG602	YG622	YG712	YG603	YG501	YG5020	YG50

● : Stock item 常备库存
○ : Order made item 按订单生产

APXT	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020	YG50
	APXT 160408 -AL	0.8	0.1 ~ 1.3	1.75							○ 0528
-AL Aluminium											



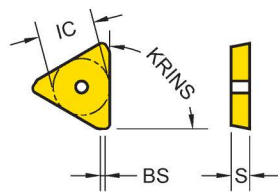
Cutting Speed 切削速度				Vc (m/min.)													
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020		YG50	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350	-	-
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	300	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-	-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-	-	-

Milling - Shoulder Milling - Inserts

铣削 - 方肩铣削 - 刀片

TPKN / KR / CN - Shoulder Milling Positive (3 Corner ISO)

TPKN/KR/CN - 方肩铣削 正角型 (3刀尖 ISO)



Series	KRINS	IC	S
TP** 1603	90°	9.53	3.18
TP** 2204	90°	12.7	4.76

EDP 1200..

● : Stock item 常备库存

○ : Order made item 按订单生产

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

TPKR TPKN TPCN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
TPKR General 通用型	TPKR 1603 PDTR		0.15 ~ 0.28	1.2	● 0060					
	TPKR 1603 PDTR -PW		0.11 ~ 0.20	1.2	● 0300					
	TPKR 2204 PDTR		0.18 ~ 0.35	1.7	● 0061					
	TPKR 2204 PDTR -PW		0.18 ~ 0.35	1.7	● 0301					
TPKN Hard Materials 高硬度材料	TPKN 1603 PDTR		0.15 ~ 0.30	1.2	● 0062					
	TPKN 1603 PDTR -PW		0.15 ~ 0.28	1.2	● 0302					
	TPKN 1603 PDTR-GW		0.15 ~ 0.3	1.62	● 0306					
	TPKN 2204 PDTR		0.17 ~ 0.30	1.7	● 0063					
	TPKN 2204 PDTR -PW		0.24 ~ 0.40	1.7	● 0303					
	TPKN 2204 PDTR-GW		0.24 ~ 0.4	2.49	● 0307					
TPCN Ground insert 无槽型	TPCN 2204 PDSR -M		0.05 ~ 0.2	1.76			● 0180			
	TPCN 2204 PDSR -MR		0.05 ~ 0.2	1.76			● 0202			

- PW : for Improved Surface Roughness

- GW : Ground Wiper

- M : for Mold & Die

- MR : for Mold & Die Roughing

- PW : 提高表面粗糙度

- GW : 修光刃

- M : 用于模具工件

- MR : 用于模具工件粗加工

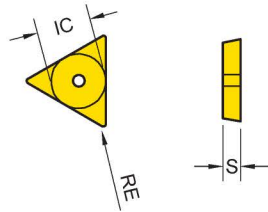
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Shoulder Milling - Inserts

TPUN - Universal Positive (3 Corners ISO)

铣削 - 方肩铣削 - 刀片

TPUN - 方肩铣削 正角型 (3刀尖 ISO)



Series	IC	S
TPUN 1603	9.53	3.18

EDP 1200..

● : Stock item 常备库存

○ : Order made item 按订单生产

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

TPUN	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
	TPUN 160308	0.8	0.08 ~ 0.15		● 0064					
TPUN										

Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Profiling - Cutter

Cutters for RDKT, RDKW

铣削 - 仿形铣削 - 刀杆
刀杆为RDKT, RDKW

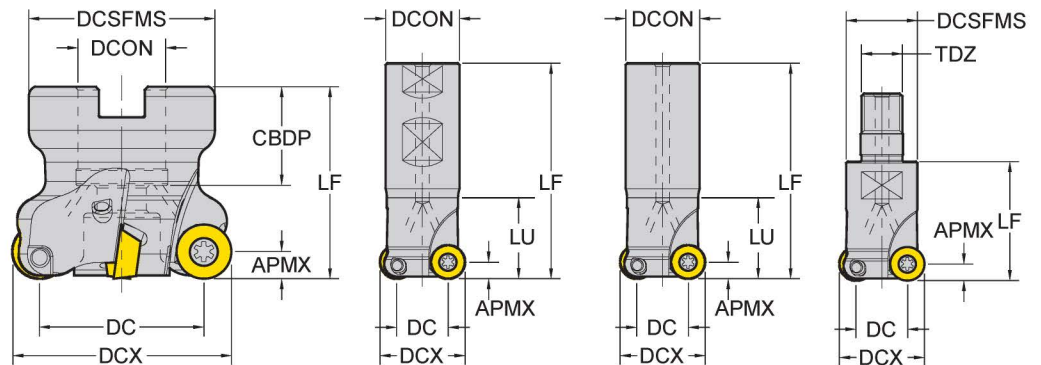
Round Positive

<S> Shell Mill(刀盘)

<W> Weldon(侧固)

<C> Cyindrical(直柄)

<M> Modular(侧固)



ZEFP : Effective Number of Cutting Edges ZEFP : 有效刃数
CDBP : Connection Bore Depth CDBP : 刀柄连接孔深度

□: p. 133 Unit(单位): mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LU	LF	TYPE	DCON /TDZ	CDBP	DCSFMS	
RDKT RDKW 0802	4.0	E - RDKT08 - D16Z2C16 - L160	0005	8	16	2	-	160	Cylindrical	16	-	-	●
		E - RDKT08 - D20Z2C20 - L180	0007	12	20	2	-	180		20	-	-	●
		E - RDKT08 - D25Z3C20 - L180	0009	17	25	3	-	180		20	-	-	●
		M - RDKT08 - D16Z2M08	0010	8	16	2	-	23	Modular	M08	-	13	●
		M - RDKT08 - D20Z2M10	0011	12	20	2	-	30		M10	-	18	●
		M - RDKT08 - D25Z3M12	0012	17	25	3	-	35		M12	-	21	●
RDKT RDKW 10T3	5.0	E - RDKT10 - D20Z2C20 - L150 - WOC	0576	10	20	2	60	150	Cylindrical	20	-	-	X
		E - RDKT10 - D20Z2C20 - L180	0013	10	20	2	-	180		20	-	-	●
		E - RDKT10 - D25Z2C25 - L150 - WOC	0299	15	25	2	60	150		25	-	-	X
		E - RDKT10 - D25Z2C25 - L180	0015	15	25	2	-	180		25	-	-	●
		E - RDKT10 - D20Z2W20 - L150 - WOC	0577	10	20	2	60	150	Weldon	20	-	-	X
		E - RDKT10 - D25Z2W25 - L150 - WOC	0578	15	25	2	60	150		25	-	-	X
		E - RDKT10 - D32Z3W32 - L150 - WOC	0579	22	32	3	60	150		32	-	-	X
		F - RDKT10 - D40Z5S16	0019	30	40	5	-	40	Shellmill	16	18	34	●
		F - RDKT10 - D50Z5S22	0580	40	50	5	-	50		22	22	42	●
		F - RDKT10 - D50Z6S22	0020	40	50	6	-	50		22	22	42	●
		F - RDKT10 - D63Z6S22	0581	53	63	6	-	50		22	22	48	●
		M - RDKT10 - D20Z2M10	0017	10	20	2	-	30	Modular	M10	-	18	●
		M - RDKT10 - D25Z3M12	0018	15	25	3	-	35		M12	-	21	●

Milling - Profiling - Cutter

Cutters for RDKT, RDKW

铣削 - 仿形铣削 - 刀杆
刀杆为RDKT, RDKW

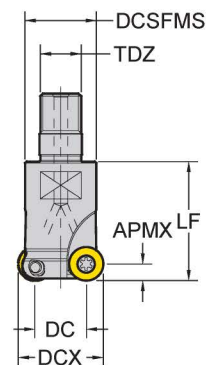
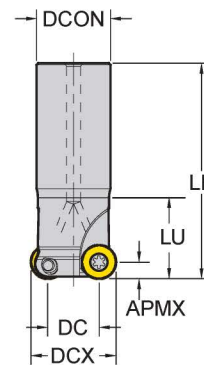
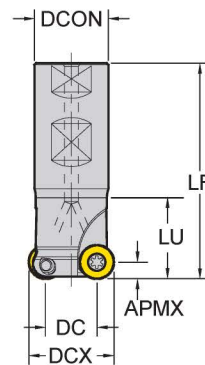
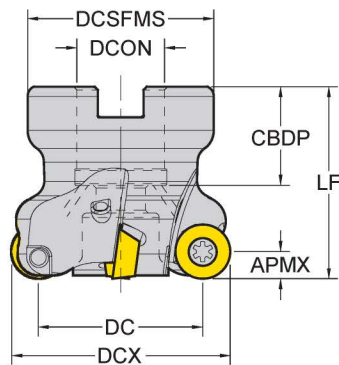
Round Positive

<S> Shell Mill(刀盘)

<W> Weldon(侧固)

<C> Cyindrical(直柄)

<M> Modular(侧固)



ZEFP : Effective Number of Cutting Edges
CDBP : Connection Bore Depth

ZEFP : 有效刃数
CDBP : 刀柄连接孔深度

□: p. 133 Unit(单位):mm

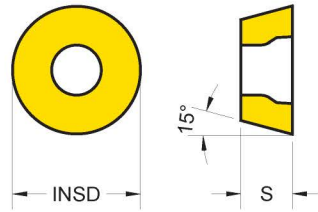
Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LU	LF	TYPE	DCON /TDZ	CDBP	DCSFMS	
RDKT RDKW 1204	6.0	E - RDKT12 - D25Z2C25 - L180	0021	13	25	2	-	180	Cylindrical	25	-	-	●
		E - RDKT12 - D32Z2C32 - L200	0023	20	32	2	-	200		32	-	-	●
		E - RDKT12 - D32Z3C32 - L160	0024	20	32	3	-	160		32	-	-	●
		E - RDKT12 - D32Z3C32 - L160 - WOC	0582	20	32	3	70	160		32	-	-	X
		E - RDKT12 - D33Z3C32 - L160 - WOC	0583	21	33	3	70	160		32	-	-	X
		E - RDKT12 - D32Z3W32 - L160 - WOC	0584	20	32	3	50	160	Weldon	32	-	-	X
		F - RDKT12 - D40Z4S16	0028	28	40	4	-	40	Shellmill	16	18	34	●
		F - RDKT12 - D50Z5S22	0029	38	50	5	-	50		22	22	42	●
		F - RDKT12 - D52Z5S22	0585	40	52	5	-	50		22	22	42	●
		F - RDKT12 - D63Z6S22	0030	51	63	6	-	50		22	20	48	●
		F - RDKT12 - D80Z7S27	0586	68	80	7	-	50		27	25	58	●
		F - RDKT12 - D100Z7S32	0587	88	100	7	-	50		32	26	65	●
		F - RDKT12 - D100Z8S32	0588	88	100	8	-	50		32	26	65	●
		M - RDKT12 - D25Z2M12	0026	13	25	2	-	35	Modular	M12	-	21	●
		M - RDKT12 - D32Z3M16	0027	20	32	3	-	42		M16	-	29	●
		M - RDKT12 - D42Z4M16	0589	30	42	4	-	43		M16	-	29	●

Milling - Profiling - Inserts

铣削 - 仿形铣削 - 刀片

RDKT / W - Profiling Positive (Round)

RDKT/W - 仿形铣削 正角型 (圆形)



Series	INSD	S	Series	INSD	S
RDK* 0501	5	1.4	RDK* 10T3	10	4.0
RDK* 0702	7	2.4	RDK* 1204	12	4.8
RDK* 0802	8	2.4			

EDP 1200..

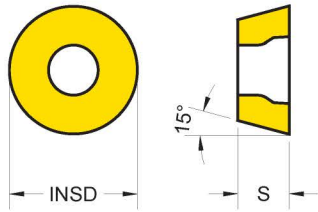
P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

● : Stock item 常备库存

○ : Order made item 按订单生产

RDKT RDKW	Designation	Fz (mm/tooth)	YG602	YG622	YG712	YG603	YG501	YG5020
RDKT General 通用型	RDKT 0802M0	0.15 ~ 0.25	● 0035					
	RDKT 10T3M0	0.15 ~ 0.28	● 0041					
	RDKT 1204M0	0.20 ~ 0.30	● 0034					
-ST Stainless Steel Super Alloy 不锈钢 超耐热合金	RDKT 0802M0 - ST	0.08 ~ 0.25	● 0292					
	RDKT 10T3M0 - ST	0.08 ~ 0.28	● 0293					
	RDKT 1204M0 - ST	0.10 ~ 0.30	● 0294					
-TR Hardened Steel 高硬度钢件	RDKT 0802M0 - TR	0.18 ~ 0.35	● 0284	● 0339				
	RDKT 10T3M0 - TR	0.22 ~ 0.40	● 0285	● 0338				
	RDKT 1204M0 - TR	0.22 ~ 0.40	● 0272	● 0340				
RDKW Hard Materials 高硬度材料	RDKW 0501M0	0.10 ~ 0.20	● 0207					
	RDKW 0702M0	0.12 ~ 0.25	● 0208					
	RDKW 0802M0	0.13 ~ 0.25	● 0043					
	RDKW 10T3M0	0.16 ~ 0.30	● 0040					
	RDKW 1204M0	0.16 ~ 0.35	● 0042					

Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-



Series	INSD	S	Series	INSD	S
RDM* 0802	8	2.38	RDM* 10T3	10	3.97
RDM* 0803	8	3.18	RDM* 1204	12	4.76

EDP 1200..

● : Stock item 常备库存

○ : Order made item 按订单生产

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	
YG602	YG622	YG712	YG603	YG501	YG5020
● 0245					
● 0225					
● 0246					
● 0226					
● 0227					
● 0228					
● 0229					

RDMT RDMW	Designation	Fz (mm/tooth)				
RDMT General 通用型	RDMT 0802M0	0.15 ~ 0.25	● 0245			
	RDMT 0803M0	0.15 ~ 0.25	● 0225			
	RDMT 10T3M0	0.18 ~ 0.28	● 0246			
	RDMT 1204M0	0.2 ~ 0.3	● 0226			
RDMW Hard Materials 高硬度材料	RDMW 0802M0	0.05 ~ 0.15	● 0227			
	RDMW 10T3M0	0.1 ~ 0.25	● 0228			
	RDMW 1204M0	0.16 ~ 0.3	● 0229			

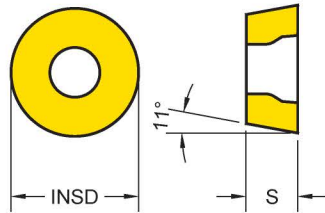
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Profiling - Inserts

铣削 - 仿形铣削 - 刀片

RPMT / W - Profiling Positive (Round)

RPMT/W - 仿形铣削 正角型 (圆形)



Series	INSD	S
RPM* 08T2	8	2.78
RPM* 10T3	10	3.97
RPM* 1204	12	4.76

EDP 1200..

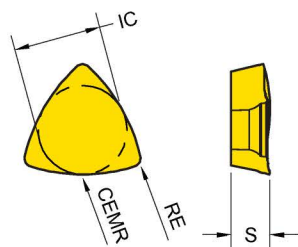
P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

● : Stock item 常备库存

○ : Order made item 按订单生产

RPMT RPMW	Designation	Fz (mm/tooth)	YG602	YG622	YG712	YG603	YG501	YG5020
RPMT General 通用型	RPMT 08T2M0	0.10 ~ 0.24	● 0038					
	RPMT 10T3M0	0.16 ~ 0.30	● 0036					
	RPMT 1204M0	0.20 ~ 0.35	● 0037		● 0415	● 0463	● 0462	
-ST Stainless Steel Super Alloy 不锈钢 超耐热合金	RPMT 1204M0 - ST	0.10 ~ 0.30	● 0230					
RPMW Hard Materials 高硬度材料	RPMW 1003M0	0.16 ~ 0.30	● 0204					
	RPMW 1204M0	0.16 ~ 0.35	● 0039					

Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-



Series	CEMR	IC	S
RBEX50	25	12.7	5.55

EDP 1200..

● : Stock item 常备库存

○ : Order made item 按订单生产

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	
YG602	YG622	YG712	YG603	YG501	YG5020
● 0277	● 0443				

RBEX50	Designation	RE (mm)	Fz (mm/tooth)					
	RBEX 50	1.2	0.2 ~ 0.4					

RBEX50

General
通用型



Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

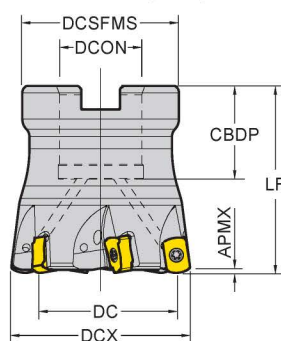
Milling - High Feed Milling - Cutter

Cutters for ENMX

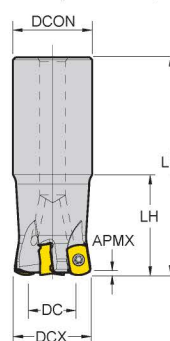
铣削 - 高进给 - 刀杆
刀杆为ENMX

Cutting Angle(切削角) : 10°
4 Corner Negative(刀尖 负角型)

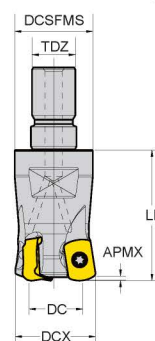
<S> Shell Mill(刀盘)



<C> Cyndrical(直柄)



<M> Modular(侧固)



ZEFP : Effective Number of Cutting Edges ZEFP : 有效刀数
CDBP : Connection Bore Depth CDBP : 刀柄连接孔深度

□: p. 139 Unit(单位): mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	Type	DCON /TDZ	LH	CDBP	DCSFMS	
ENMX	0.9	EHF-ENMX06-D16Z2C16-L100	0644	9.0	16	2	100	Cylindrical	16	30	-	-	●
		EHF-ENMX06-D16Z2C16-L150	0645	9.0	16	2	150		16	50	-	-	●
		EHF-ENMX06-D17Z2C16-L100	0674	10.0	17	2	100		16	20	-	-	●
		EHF-ENMX06-D17Z2C16-L150	0473	10.0	17	2	150		16	20	-	-	●
	1	EHF-ENMX06-D20Z3C20-L130	0463	12.6	20	3	130	Cylindrical	20	50	-	-	●
		EHF-ENMX06-D20Z3C20-L160	0646	12.6	20	3	160		20	80	-	-	●
		EHF-ENMX06-D21Z3C20-L150	0475	13.6	21	3	150		20	20	-	-	●
		EHF-ENMX06-D21Z3C20-L200	0476	13.6	21	3	200		20	20	-	-	●
		EHF-ENMX06-D25Z4C25-L140	0647	17.6	25	4	140		25	60	-	-	●
		EHF-ENMX06-D25Z4C25-L180	0464	17.6	25	4	180		25	80	-	-	●
		EHF-ENMX06-D25Z4C25-L250	0648	17.6	25	4	250		25	120	-	-	●
		EHF-ENMX06-D26Z4C25-L150	0479	18.6	26	4	150		25	30	-	-	●
		EHF-ENMX06-D26Z4C25-L200	0480	18.6	26	4	200		25	30	-	-	●
		EHF-ENMX06-D32Z5C32-L150	0649	24.6	32	5	150		32	70	-	-	●
		EHF-ENMX06-D32Z5C32-L200	0465	24.6	32	5	200		32	100	-	-	●
	0.9	MHF-ENMX06-D16Z2M08	0691	9.0	16	2	23	Modular	M08		-	13	●
		MHF-ENMX06-D18Z2M08	0730	11.0	18	2	23		M08		-	13	●
	1	MHF-ENMX06-D20Z3M10	0692	12.6	20	3	30	Modular	M10		-	18	●
		MHF-ENMX06-D25Z4M12	0693	17.6	25	4	35		M12		-	21	●
		MHF-ENMX06-D32Z5M16	0694	24.6	32	5	42		M16		-	29	●
		MHF-ENMX06-D35Z5M16	0695	27.6	35	5	42		M16		-	29	●
		MHF-ENMX06-D40Z6M16	0732	32.6	40	6	42		M16		-	29	●
		MHF-ENMX06-D42Z6M16	0696	34.6	42	6	42		M16		-	29	●
	1	FHF-ENMX06-D40Z6S16	0482	32.6	40	6	40	Shell Mill	16		18	37	●
		FHF-ENMX06-D50Z6S22	0471	42.6	50	6	50		22		25	42	●

Technical Information 技术资料

		Unit:mm		
DCX	APMXR	RP	UTCN	Overcut
Cutting Diameter Maximum	Radial AP Max	Programmed Corner R	Uncut Thickness	
刀杆外圆直径	最大径向切削深度	设定拐角半径	未切削厚度	刀补
16	3.5	R2.0	0.31	0.00
16~	3.7	R2.5	0.18	0.18
		R3.0	0.07	0.36

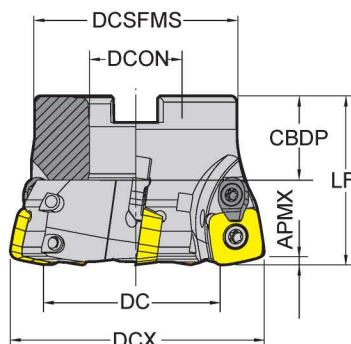
Milling - High Feed Milling - Cutter

Cutters for SDMT, SDMW

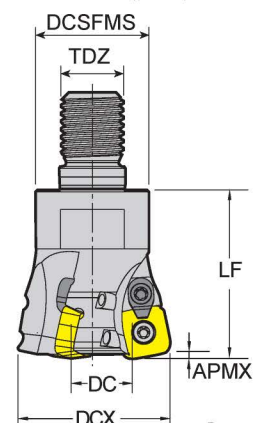
铣削 - 高进给 - 刀杆
刀杆为SDMT,SDMW

Cutting Angle(切削角) : 10°
4 Corner Positive(刀尖 正角型)

<S> Shell Mill(刀盘)



<M> Modular(侧固)



ZEFP : Effective Number of Cutting Edges
CDBP : Connection Bore Depth

ZEFP : 有效刃数
CDBP : 刀柄连接孔深度

□ : p. 140 Unit(单位):mm

Series	APMX	Designation	EDP 1700..	DC	DCX	ZEFP	LF	TYPE	DCON /TDZ	CBDP	DCSFMS	
SDMT SDMW 1204	1.8	FHF - SDMW12 - D50Z4S22	0604	32.4	50	4	40	Shellmill	22	22	42	●
		FHF - SDMW12 - D63Z5S22	0605	45.4	63	5	40		22	22	48	●
		FHF - SDMW12 - D80Z6S27	0606	62.4	80	6	50		27	25	58	●
		FHF - SDMW12 - D100Z8S32	0607	82.4	100	8	50		32	26	65	●
		MHF - SDMW12 - D32Z2M16	0608	14.4	32	2	43	Modular	M16	-	29	●
		MHF - SDMW12 - D40Z3M16	0609	22.4	40	3	43		M16	-	29	●

Technical Information 技术资料

			Unit:mm		
APMXR	RP	UTCN	APMXR	RP	UTCN
Radial AP Max	Programmed Corner R	Uncut Thickness	最大径向切削深度	设定拐角半径	未切削厚度
8.6	R3.5	0.94			

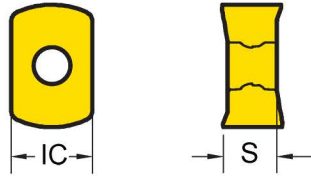
Milling - High Feed Milling - Inserts

铣削 - 高进给 - 刀片

ENMX - High Feed Negative (4 Corners)

ENMX - 高进给 负角型 (4刀尖)

Series	IC	S
ENMX 0604	6.3	4.21



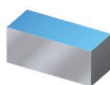
EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

●: Stock item 常备库存

○: Order made item 按订单生产

ENMX	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
ENMX General 通用型	ENMX 0604		0.3 ~ 2.0		● 0474					
- TR Hardened Steel 高硬度钢件	ENMX 0604-TR		0.3 ~ 2.5		● 0459					



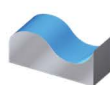
General
通用的



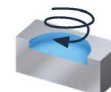
Plunging
下陷



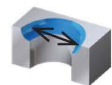
Ramping
斜坡



Profiling
轮廓



Helical Interpolation
螺旋插补



Enlarge Hole
扩大孔

DCX	APMX	APMXR	RMPX	RP	UTCN	Diameter	Diameter	Pitch	Ae
External Cutter Diameter	Maximum Depth of Cut	Maximum Radial Depth of Cut	Maximum Ramping Angle(°)	Programmed Corner Radius	Uncut Thickness	Minimum Cutting Diameter	Maximum Cutting Diameter	Helical Interpolation Pitch	Enlarge Width
刀杆外圆直径	最大切削深度	最大径向切削深度	最大爬坡角度	设定拐角半径	未切削厚度	切削最小直径	刀杆外圆直径	螺旋插补螺距	扩展宽度
16	0.9	3.5	3.6°	R2.0	0.3	21	30	0.9	12.5
20	1	3.7	3.3°	R2.0	0.31	29	38	1	16.3
25	1	3.7	2.2°	R2.0	0.31	39	48	1	21.3
32	1	3.7	1.5°	R2.0	0.31	53	62	1	28.3
40	1	3.7	1.1°	R2.0	0.31	69	78	1	36.3
50	1	3.7	0.8°	R2.0	0.31	89	98	1	46.3

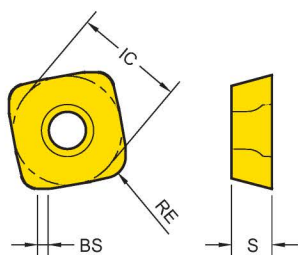
Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - High Feed Milling - Inserts

SDMT / W - High Feed Positive (4 Corners)

铣削 - 高进给 - 刀片

SDMT/W - 高进给 正角型 (4刀尖)



Series	IC	S
SDM* 1204	12.7	4.7

EDP 1200..

P25	P30	P20	P40		
M30			M35		
K30	K30			K15	K15
S20			S30	H15	

● : Stock item 常备库存

○ : Order made item 按订单生产

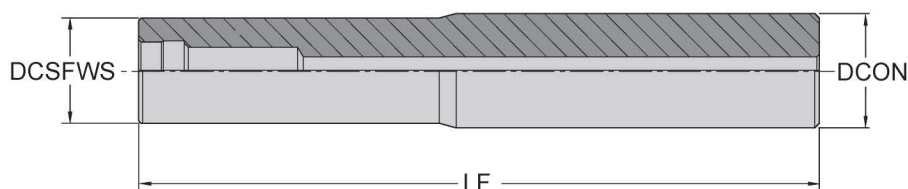
SDMT SDMW	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG603	YG501	YG5020
-ST Stainless Steel Super Alloy 不锈钢 超耐热合金	SDMT 120420-ST	1.9	0.60 ~ 1.20	1.45	● 0274					
SDMW Hard Materials 高硬度材料	SDMW 120420	1.9	0.60 ~ 1.40	1.4	● 0273	● 0341				

Cutting Speed 切削速度				Vc (m/min.)											
ISO	VDI	Sub Group 分组		YG602		YG622		YG712		YG603		YG501		YG5020	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	140	380	140	400	170	300	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	低合金钢	120	300	120	320	180	250	70	210	-	-	-	-
	10~11	High-Alloyed Steel	高合金钢	70	150	70	170	100	140	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	120	200	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	奥氏体不锈钢	130	250	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	120	250	120	270	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	球墨铸铁	130	220	130	240	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45	-	-	-	-	20	40			-	-
H	38~41	Hard Materials	高硬材料	40	80	40	100	-	-	-	-	50	90	-	-

Milling - Modular Shank

Modular Shanks

铣削 - 模块型
模块型柄



Unit(単位):mm

Series	Designation	EDP 1700..	DCSFWS	LF	TYPE	DCON	
M08	EM - M08 - D16ZC16 - L100	0634	13	100	Cylindrical	16	●
	EM - M08 - D16ZC16 - L130	0635	15	130		16	●
M10	EM - M10 - D20ZC20 - L130	0636	18	130	Cylindrical	20	●
M12	EM - M12 - D25ZC25 - L150	0637	25	150	Cylindrical	25	●
	EM - M12 - D25ZC25 - L200	0638	23	200		25	●
	EM - M12 - D25ZC25 - L250	0639	23	250		25	●
M16	EM - M16 - D32ZC32 - L150	0640	30	150	Cylindrical	32	●
	EM - M16 - D32ZC32 - L200	0641	30	200		32	●
	EM - M16 - D32ZC32 - L250	0642	30	250		32	●
	EM - M16 - D32ZC32 - L300	0643	30	300		32	●

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION