

硬质合金铣刀目录 INDEX OF CARBIDE END MILLS

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硬质合金铣刀目录
INDEX OF CARBIDE END MILLS

页码 Page	形状 Appearance	产品记号 Abbreviation	式样 Specification	表面处理 Surface Treatment	库存尺寸 Stocked Sizes	含钴 Cobalt
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平头型 Square

279 ~ 280		CA-RG-EDS	2刃 铜·铝合金用短刃型 2 Flutes Short for Copper & Aluminum Alloys		1 ~ 20	○
281		DIA-EDS	2刃 短刃型 2 Flutes Short	DIA	0.5 ~ 12	○
281		DLC-EDS	2刃 短刃型 2 Flutes Short	DLC	0.5 ~ 12	○
282		MG-EDN	2刃中刃型 2 Flutes Medium		3 ~ 12	○
282		MG-STDN	2刃直刃成形用 2 Flutes Straight Reforming		1 ~ 12	○
283		FX-MG-EDL	2刃 长刃型 2 Flutes Long	FX	1 ~ 30	○
284		FX-MG-EXDL	FX涂层 2刃超长刃型 2 Flutes Extra Long	FX	3 ~ 30	○
285		MG-EDL	2刃 长刃型 2 Flutes Long		2.5 ~ 25	○
285		MG-EXDL	2刃 超长刃型 2 Flutes Extra Long		3 ~ 20	○
286		CA-RG-EDL	2刃 铜·铝合金·长刃型 2 Flutes Long for Copper & Aluminum Alloys		3 ~ 12	○
287		CA-ETS	3刃 铜·铝合金用短刃型 3 Flutes Short for Copper & Aluminum Alloys		3 ~ 20	○
288		DLC-ETS	3刃 短刃型 3 Flutes Short	DLC	3 ~ 20	○

INDEX OF CARBIDE END MILLS 硬质合金铣刀目录

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形状别目录

高速合金铣刀
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硬质合金铣刀目录
INDEX OF CARBIDE END MILLS

加工材料 Work Material														页码 Page	
碳素钢 Carbon Steel	合金钢 Alloy Steel	预硬钢 Prehardened Steel				不锈钢 Stainless Steel	铸铁 Cast Iron	铜合金 Copper Alloy	铝合金 Aluminium Alloy	石墨 Graphite	钛合金 Titanium Alloy	耐热合金 Heat Resistant Alloy	塑料 Plastic		复合材料 Composite Material CFRP
预硬钢 Prehardened Steel	工具钢 Tool Steel	淬火钢 Hardened Steel				球墨铸铁 Ductile Cast Iron	~35HRC	~350HB							
~40HRC		~45HRC	~55HRC	~60HRC	~65HRC										
								○	○				○		279 280
								○	○	○			○		281
								○	*	○			○		281
	○		○					○	○	○					282
	○							○	○	○					282
	○		○				○	○	○		○	○			283
	○		○				○	○	○		○				284
	○		○					○	○	○					285
	○		○					○	○	○					285
								○	○				○		286
								○	○				○		287
								○	*	○			○		288

○=Best
○=Good

*加工高硅（13%以上）的铸件、推荐使用超微结晶金刚石涂层铣刀。
*Ultra fine Diamond coating end mill is recommended for the applications as high Silicon content(over 13%)castings,Die-casting.

超微结晶DIA涂层 2刃短刀型
DIA Coated-2 Flutes-Short

DIA-EDS

切削条件 Cutting Conditions | P613



采用了 OSG 新开发的超微结晶金刚石涂层的铣刀。进行高硅铝合金以及石墨加工时实现超群的工具寿命。
OSG's patented Ultra Fine Grain Diamond coating. Shows long tool life on High Silicon contents alloys, and Graphite machining.



DLC涂层 2刃短刀型
DLC Coated-2 Flutes-Short

DLC-EDS

切削条件 Cutting Conditions | P609



采用了独特的超平滑新 DLC涂层的铣刀。针对常发生溶着问题的轧制铝合金等加工时发挥了很大的作用。
End mill with unique DLC coating with ultra lubrication. Works on extruded Aluminum eliminating weldings.



SPECIFICATION CHART
形状尺寸表

高硬度立铣刀
HSS END MILLS

可转位刀具
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CARBIDE SQUARE
硬质合金平头
铣刀

CARBIDE LONG
NECK SQUARE
硬质合金长颈型
平头铣刀

CARBIDE BALL NOSE
硬质合金球头
铣刀

CARBIDE BALL NOSE
WITH LONG NECK
硬质合金长颈型
球头铣刀

CARBIDE PENCIL
NECK BALL NOSE
硬质合金锥颈型
球头铣刀

CARBIDE CORNER RADIUS
硬质合金圆弧
R角铣刀

CARBIDE ROUGHING
硬质合金波纹
铣刀

CARBIDE TAPER
硬质合金锥形
铣刀

CARBIDE
COUNTERBORING
硬质合金沉孔
铣刀

CARBIDE CHAMFERING
硬质合金倒角
铣刀

ROUTER FOR CFRP
CFRP用铣刀

(单位:mm) (Unit:mm)

商品号 EDP No.	外径 DC	全长 LF	刃长 APMX	柄径 DCON	库存 Stock	重量 (g)
8504601	0.5	40	1	4	●	13
8504602	1		2.5		●	13
	1.2		□		—	
	1.4		□		—	
8504603	1.5		4		●	12
	1.6		□		—	
	1.8		□		—	
8504604	2		5		●	12
	2.5		□		—	
8504606	3		6		●	16
	3.5	□	—			
8504608	4	8	●	18		
	4.5	□	—			
8504610	5	10	●	19		
	5.5	□	—			
8504612	6	11	●	25		
	7	□	—			
8504616	8	13	●	42		
	9	□	—			
8504620	10	16	●	74		
	11	□	—			
8504622	12	19	●	110		
		□	—			

(单位:mm) (Unit:mm)

商品号 EDP No.	外径 DC	全长 LF	刃长 APMX	柄径 DCON	库存 Stock	重量 (g)
8528005	0.5	40	1	4	●	12
8528006	0.6		1.2		●	12
8528008	0.8		1.6		●	12
8528010	1		2		●	12
8528012	1.2		2.4		●	12
8528014	1.4		2.8		●	12
8528015	1.5		3		●	12
8528016	1.6		3.2		●	12
8528018	1.8		3.6		●	12
8528020	2		4		●	12
8528025	2.5	5	●	12		
8528030	3	6	●	12		
8528038	4	8	●	17		
8528040	5	10	●	19		
8528042	6	12	●	20		
8528044	7	14	●	40		
8528046	8	16	●	41		
8528048	9	18	●	72		
8528050	10	20	●	72		
8528051	11	22	●	106		
8528052	12	24	●	110		

加工材料 Work Material	碳素钢	合金钢	预硬钢	不锈钢	铸铁	铜合金	铝合金	石墨	钛合金	耐热合金	塑料
	Carbon Steel	Alloy Steel	Prehardened Steel	Stainless Steel	Cast Iron 球墨铸铁 Ductile Cast Iron	Copper Alloy	Aluminum Alloy	Graphite	Titanium Alloy	Heat Resistant Alloy	Plastic
商品记号 Abbreviation	预硬钢 Prehardened Steel	工具钢 Tool Steel	淬火钢 Hardened Steel								
	~ 40HRC		~ 45HRC ~ 55HRC ~ 60HRC ~ 65HRC	~ 35HRC	~ 350HB						
DIA-EDS						○	※	○			○
DLC-EDS						○	※	○			○

*加工高硅 (13%以上) 的铸件、推荐使用超微结晶金刚石涂层铣刀。

*Ultra fine Diamond coating end mill is recommended for the applications as high Silicon content (over 13%) castings, Die-casting.

库存标识 Inventory symbols

- = 标准库存品
standard stock item
- = 特定代理店库存品
Stocked by specific distributors. Contact us for price & availability.

- ▲ = 由新产品及后续产品取代 (请确认库存)
Scheduled to be replaced by new product or successor item

硬质合金铣刀切削条件基准表

CUTTING CONDITIONS FOR CARBIDE END MILLS

DLC涂层 2刃短刀型 DLC-EDS

DLC COATED 2 FLUTES SHORT

加工材料 Work Material	铝合金展伸材 Aluminum Alloy Expanding Material A7075				铝合金铸件·压铸 Aluminum Alloy Casting·Die Casting Si13%未満				镁合金·铜合金 Magnesium Alloy·Copper Alloy AZ91·AZ80A·C1100		铜合金 Copper Alloy C1100	
	标准条件 Regular Milling		高速铣削用 High Speed Milling		标准条件 Regular Milling		高速铣削用 High Speed Milling		标准条件 Regular Milling		高速铣削用 High Speed Milling	
外径 Mill Dia. (mm)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)
0.5	32,000	180	50,000	550	32,000	180	50,000	500	32,000	160	50,000	450
0.6	32,000	200	50,000	650	32,000	200	50,000	600	32,000	180	50,000	550
0.8	32,000	220	50,000	850	32,000	220	50,000	800	29,000	200	50,000	650
1	32,000	220	50,000	1,000	32,000	220	50,000	950	23,000	220	42,000	700
1.2	32,000	230	50,000	1,200	32,000	230	50,000	1,150	19,000	220	36,000	700
1.4	32,000	260	50,000	1,400	32,000	260	50,000	1,250	16,500	220	31,000	700
1.5	32,000	280	50,000	1,600	32,000	280	48,000	1,250	15,500	220	29,500	700
1.6	32,000	320	50,000	1,700	32,000	320	45,000	1,250	14,500	220	28,000	700
1.8	32,000	360	50,000	1,850	32,000	360	41,000	1,250	13,000	220	26,500	750
2	32,000	420	50,000	2,000	32,000	420	38,000	1,250	11,500	220	24,000	750
2.5	25,000	600	48,000	2,100	25,000	600	31,000	1,250	9,500	250	20,000	750
3	21,000	700	40,000	2,100	21,000	700	26,000	1,250	7,950	250	17,000	750
4	15,500	725	33,000	2,250	15,500	725	20,000	1,350	5,950	280	14,000	800
5	12,500	760	31,000	2,800	12,500	760	19,200	1,650	4,750	295	12,500	950
6	10,500	830	26,000	2,800	10,500	830	15,900	1,700	3,950	310	10,500	1,000
8	7,950	890	19,500	2,900	7,950	890	12,000	1,800	2,950	300	7,900	1,000
10	6,350	995	15,500	3,200	6,350	995	9,600	1,900	2,350	365	6,350	1,100
12	5,300	1,050	13,000	3,200	5,300	1,050	8,000	1,900	1,950	390	5,300	1,100

切深量
Depth
of Cut

1. 请使用高精度和高刚性的设备及夹具。
2. 加工铝合金时请使用水溶性切削液。
3. 镁合金切削时请注意切削油选用, 请咨询切削厂家。注意处理切屑。
4. 加工高硅铝合金铸件时推荐使用金刚石涂层铣刀。

1. Use a rigid and precise machine and holder.
2. Use a water soluble cutting fluid for milling aluminum alloys.
3. Please note the following points on machining Mg alloy. To select appropriate cutting fluid, consult with lubricant manufacturers. Chips must be handled carefully, because they cause fire.
4. Diamond coated end mill is recommended for machining Aluminum casting or die casting alloy with high Si.

DLC 涂层2刃长颈短刀型 DLC-LN-EDS

DLC COATED 2 FLUTES LONG NECK SHORT

加工材料 Work Material	铝合金展伸材 Aluminum Alloy Expanding Material A7075				铝合金铸件·压铸 Aluminum Alloy Casting·Die Casting Si13%未満				镁合金·铜合金 Magnesium Alloy·Copper Alloy AZ91·AZ80A·C1100		铜合金 Copper Alloy C1100	
	标准条件 Regular Milling		高速铣削用 High Speed Milling		标准条件 Regular Milling		高速铣削用 High Speed Milling		标准条件 Regular Milling		高速铣削用 High Speed Milling	
外径 Mill Dia. (mm)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)	转速 Speed (min ⁻¹)	进给速度 Feed (mm/min)
0.5	32,000	100	50,000	550	32,000	100	50,000	550	32,000	100	50,000	450
1	32,000	190	50,000	1,000	32,000	190	50,000	1,000	23,000	140	42,000	700
1.5	32,000	250	45,000	1,200	32,000	250	45,000	1,200	15,500	145	29,500	700
2	25,500	300	34,000	1,200	25,500	300	34,000	1,200	11,500	150	24,000	750
2.5	20,000	430	27,000	1,200	20,000	430	27,000	1,200	9,500	175	20,000	750
3	17,000	510	23,000	1,200	17,000	510	23,000	1,200	7,950	220	17,000	750
4	12,500	520	17,000	1,200	12,500	520	17,000	1,200	5,950	235	13,000	750
5	10,000	540	13,500	1,200	10,000	540	13,500	1,200	4,750	250	10,000	750
6	8,500	600	11,000	1,200	8,500	600	11,000	1,200	3,950	250	8,000	750

切深量
Depth
of Cut

1. 请使用高精度和高刚性的设备及夹具。
2. 加工铝合金时请使用水溶性切削液。
3. 镁合金切削时请注意切削油选用, 请咨询切削厂家。注意处理切屑。
4. 加工高硅铝合金铸件时推荐使用金刚石涂层铣刀。

1. Use a rigid and precise machine and holder.
2. Use a water soluble cutting fluid for milling aluminum alloys.
3. Please note the following points on machining Mg alloy. To select appropriate cutting fluid, consult with lubricant manufacturers. Chips must be handled carefully, because they cause fire.
4. Diamond coated end mill is recommended for machining Aluminum casting or die casting alloy with high Si.