铣刀盘系列
FACE MILLING CUTTERS



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FACE MILLING CUTTERS

壳形铣刀 FACE MILL

AHUB	15	– 63	– 22	– 5T
BAP	400R	– 50	– 22	– 4T

	类型	刀片规格代号	刃径	安装孔径	刃数
	Type	Insert specification code	Flute diameter	Inner diameter	No. of flutes

立铣刀 END MILL

AHU	10	16 × 160 –	
BAP	300R	– 13 × 120 –	C12

	类型	刀片规格代号	刃径	总长	柄径	刃径 = 柄径，柄径省去
	Type	Insert specification code	Flute diameter	Overall length	Shank diameter	Flute-Dia=Shank-Dia, shank-Dia ignore

T217.69	– 08	06	– 06A
类型 Type	柄径 Shank diameter	刃径 Flute diameter	刀片规格代号 Insert specification code

T239	– 4R ×	110	– C10
类型 Type	刀片规格代号 Insert specification code	总长 Overall length	柄径 Shank diameter

特点：

◎采用抗震性工具钢材质

◎整体预硬后，再行精修，避免二次加工产生变形

Features:

◎ Use antiknock tool steel.

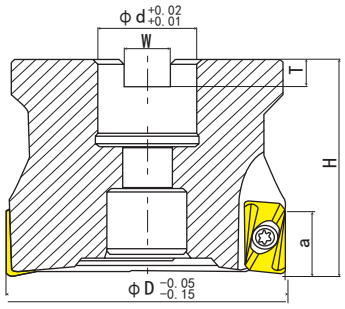
◎ Overall pre-hard first,then fine processing,avoid transformation when proceed twice.

可转位铣刀盘系列 FACE MILLING CUTTERS

BAP/TAP-90° 直角台肩壳形铣刀盘

BAP/TAP-90° RIGHT ANGLE SHOULDER FACE MILL CUTTERS





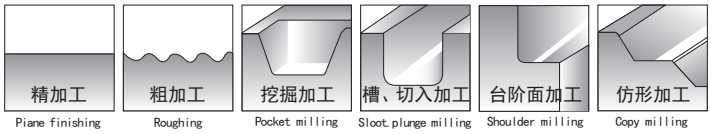
◎节能提示：请保留您的报废刀片 RAP 壳形铣刀还能使用

◎ Energy saving: please keep your scrap inserts RAP-75° ,shell-shaped milling cutter can be used.


P.E87


P.I30

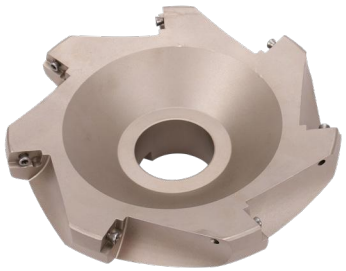

P.I32

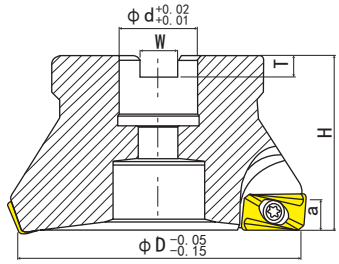


规格 / 型号 Model	尺寸 Size(mm)							刀片 Insert	螺钉 Screw	扳手 Wrench
	D	d	H	W	T	a	重量 KGS			
BAP300R-40-16-4T	40	16	40	8.4	6.3	9	0.35	APMT1135PDER	M2.5*6	T8
BAP300R-50-22-4T	50	22	50	10.4	6.3	9	0.4	APMT1135PDER	M2.5*6	T8
BAP300R-63-22-5T	63	22	50	10.4	6.3	9	0.65	APMT1135PDER	M2.5*6	T8
BAP400R-50-22-4T	50	22	50	10.4	6.3	14	0.4	APMT1604PDER	M4.0*9	T15
BAP400R-50-25.4-4T	50	25.4	50	10	6	14	0.4	APMT1604PDER	M4.0*9	T15
BAP400R-63-22-4T	63	22	50	10.4	6.3	14	0.65	APMT1604PDER	M4.0*9	T15
BAP400R-63-22-5T	63	22	50	10.4	6.3	14	0.65	APMT1604PDER	M4.0*9	T15
BAP400R-63-25.4-4T	63	25.4	50	10	6	14	0.65	APMT1604PDER	M4.0*9	T15
BAP400R-80-25.4-5T	80	25.4	50	10	6	14	1	APMT1604PDER	M4.0*9	T15
BAP400R-80-27-5T 反齿	80	27	50	12.4	7	14	1	APMT1604PDER	M4.0*9	T15
BAP400R-80-27-5T	80	27	50	12.4	7	14	1	APMT1604PDER	M4.0*9	T15
BAP400R-80-27-6T	80	27	50	12.4	7	14	1	APMT1604PDER	M4.0*9	T15
BAP400R-80-27-6T	80	27	50	12.4	7	14	1	APMT1604PDER	M4.0*9	T15
BAP400R-100-32-6T	100	32	50	14.4	8	14	1.25	APMT1604PDER	M4.0*9	T15
BAP400R-100-31.75-6T	100	31.75	50	13	8	14	1.25	APMT1604PDER	M4.0*9	T15
BAP400R-125-40-6T	125	40	63	16.4	9	14	3.1	APMT1604PDER	M4.0*9	T15
BAP400R-125-38.1-7T	125	38.1	63	16.4	10	14	3.1	APMT1604PDER	M4.0*9	T15
BAP400R-160-40-8T	160	40	63	16.4	9	14	5.1	APMT1604PDER	M4.0*9	T15
BAP400R-200-60-10T	200	60	63	25.7	14	14	6.78	APMT1604PDER	M4.0*9	T15
BAP400R-250-60-12T	250	60	63	25.7	14	14	10.5	APMT1604PDER	M4.0*9	T15

规格 / 型号 Model	F7030	F620	VP15TF	UP20M	NX2525	NX4545	UT120T	HTI10	NCM325	PC3545	PC3530	PC6510	PD2000	H01	H101	H102	KC25	PP30	PC35	刀片形状 Insert shape	尺寸 Size(mm) L1	L2	S1	F1	Re	
APMT1135PDER-H1	●	●	●★	●	●	●	●	●													11	6.35	3.5	1.5	0.4	MITSUBISHI(三菱)
APMT1135PDER-H2	●	●	●★	●	●	●	●	●													11	6.35	3.5	1.2	0.8	
APMT1135PDER-H3	●	●		●			●														11	6.35	3.5	0.8	1.2	
APMT1135PDER-H4	●	●		●			●														11	6.35	3.5	0.4	1.6	
APMT1135PDER-H6	●	●		●			●														11	6.35	3.5	0.4	2.4	
APMT1135PDER-MO	●																				11	6.35	3.5	1.8	0.2	
APMT1135PDER-M1	●																				11	6.35	3.5	1.5	0.4	
APMT1135PDER-M2	●	●	●★			●															11	6.35	3.5	1.2	0.8	
APGT1135PFER-G2								●													11	6.35	3.5	1.2	0.8	
APMT1604PDER-H1	●		●				●														16.5	9.525	4.76	1.7	0.4	
APMT1604PDER-H2	●	●	●★	●	●	●★	●	●													16.5	9.525	4.76	1.7	0.8	
APMT1604PDER-H4	●						●														16.5	9.525	4.76	1.7	1.6	
APMT1604PDER-H6	●						●														16.5	9.525	4.76	1.7	2.4	
APMT1604PDER-H8	●						●														16.5	9.525	4.76	1.7	3.2	
APGT1604PFER-M2	●	●	●★			●															16.5	9.525	4.76	1.7	0.8	
APMT1604PDER-G2	●							●													16.5	9.525	4.76	1.7	0.8	
APKT1604PDSR									●	●	●	●	●								16.4	9.525	4.76	-	0.8	KOPLOY 刀片
APKT1604PDFR-MA														●	●						16.4	9.525	4.76	-	0.8	

RAP-75° 壳形铣刀盘 RAP-75° FACE MILL CUTTERS



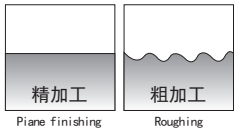


◎节能提示：使用 BAP300R/400R 系列的报废刀片“O”刀具损耗


P.E87


P.I30


P.I32



规格 / 型号 Model	尺寸 Size(mm)						重量 KGS	刀片 Insert	螺钉 Screw	扳手 Wrench
	D	d	H	W	T	a				
RAP300R-50-22-4T	50	22	50	10.4	6.3	5	0.4	APMT1135PDER	M2.5*6	T8
RAP300R-63-22-4T	63	22	50	10.4	6.3	5	0.65	APMT1135PDER	M2.5*6	T8
RAP300R-80-27-5T	80	27	50	12.4	7	5	1	APMT1135PDER	M2.5*6	T8
RAP300R-100-32-5T	100	32	50	14.4	8	5	1.25	APMT1135PDER	M2.5*6	T8
RAP300R-125-40-6T	125	40	50	16.4	9	5	3.1	APMT1135PDER	M2.5*6	T8
RAP300R-50-22-4T	80	27	50	12.4	7	5	0.4	APMT1135PDER	M2.5*6	T8
RAP400R-50-22-4T	50	22	50	10.4	6.3	8	0.4	APMT1604PDER	M4.0*9	T15
RAP400R-50-25.4-4T	50	25.4	50	10	6	8	0.4	APMT1604PDER	M4.0*9	T15
RAP400R-63-22-4T	63	22	50	10.4	6.3	8	0.65	APMT1604PDER	M4.0*9	T15
RAP400R-63-25.4-4T	63	25.4	50	10	6	8	0.65	APMT1604PDER	M4.0*9	T15
RAP400R-63-25.4-5T	63	25.4	50	10	6	8	0.65	APMT1604PDER	M4.0*9	T15
RAP400R-80-27-5T	80	27	50	12.4	7	8	1	APMT1604PDER	M4.0*9	T15
RAP400R-80-25.4-5T	80	25.4	50	10	6	8	1	APMT1604PDER	M4.0*9	T15
RAP400R-100-32-6T	100	32	50	14.4	8	8	1.25	APMT1604PDER	M4.0*9	T15
RAP400R-100-31.75-6T	100	31.75	50	13	8	8	1.25	APMT1604PDER	M4.0*9	T15
RAP400R-125-40-6T	125	40	60	16.4	9	8	3.1	APMT1604PDER	M4.0*9	T15
RAP400R-160-40-7T	160	40	60	16.4	9	8	5.1	APMT1604PDER	M4.0*9	T15
RAP400R-200-60-9T	200	60	60	25.7	14	8	6.7	APMT1604PDER	M4.0*9	T15
RAP400R-250-60-10T	250	60	60	25.7	14	8	10.5	APMT1604PDER	M4.0*9	T15
RAP400R-315-60-14T	315	60	60	25.7	14	8	-	APMT1604PDER	M4.0*9	T15
RAP400R-350-60-	350	60	60	25.7	14	8	-	APMT1604PDER	M4.0*9	T15
RAP400R-400-60-	400	60	60	25.7	14	8	-	APMT1604PDER	M4.0*9	T15

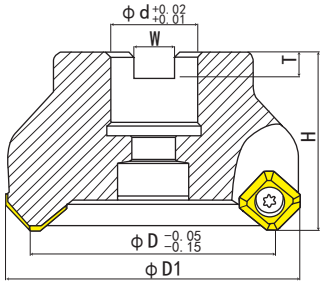
可配用刀片 INSERTS

规格 / 型号 Model	F7030	F620	VP15TF	UP20M	NX2525	NX4545	UT120T	HTI10	NCM325	PC3545	PC3530	PC6510	PD2000	H01	H101	H102	KC25	PP30	PC35	刀片形状 Insert shape	尺寸 Size(mm)					
																					L1	L2	S1	F1	Re	
APMT1135PDER-H1	●	●	●★	●	●	●	●	●													11	6.35	3.5	1.5	0.4	MITSUBISHI(三菱)
APMT1135PDER-H2	●	●	●★	●	●	●	●	●													11	6.35	3.5	1.2	0.8	
APMT1135PDER-H3	●	●		●			●														11	6.35	3.5	0.8	1.2	
APMT1135PDER-H4	●	●		●			●														11	6.35	3.5	0.4	1.6	
APMT1135PDER-H6	●	●		●			●														11	6.35	3.5	0.4	2.4	
APMT1135PDER-MO	●																				11	6.35	3.5	1.8	0.2	
APMT1135PDER-M1	●																				11	6.35	3.5	1.5	0.4	
APMT1135PDER-M2	●	●	●★			●															11	6.35	3.5	1.2	0.8	
APGT1135PFER-G2								●													11	6.35	3.5	1.2	0.8	
APMT1604PDER-H1	●		●				●														16.5	9.525	4.76	1.7	0.4	
APMT1604PDER-H2	●	●	●★	●	●	●★	●	●													16.5	9.525	4.76	1.7	0.8	
APMT1604PDER-H4	●						●														16.5	9.525	4.76	1.7	1.6	
APMT1604PDER-H6	●						●														16.5	9.525	4.76	1.7	2.4	
APMT1604PDER-H8	●						●														16.5	9.525	4.76	1.7	3.2	
APGT1604PFER-M2	●	●	●★			●															16.5	9.525	4.76	1.7	0.8	
APMT1604PDER-G2	●							●													16.5	9.525	4.76	1.7	0.8	
APKT1604PDSR									●	●	●	●	●								16.4	9.525	4.76	-	0.8	KOPLOY 刀片
APKT1604PDFR-MA														●	●						16.4	9.525	4.76	-	0.8	

可转位铣刀盘系列 FACE MILLING CUTTERS

KM-45°壳形铣刀盘 KM-45° FACE MILL CUTTERS





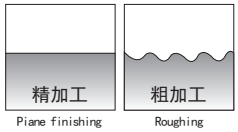
◎配有钢件、铸件、铝件、多种材质刀片

◎ Match blade with difference material,such as steel,Casting and Aluminum


P.E87


P.I30

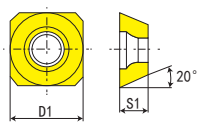

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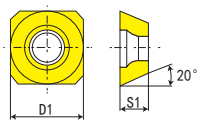


Piane finishing Roughing

规格 / 型号 Model	尺寸 Size(mm)						重量 KGS	刀片 Insert	螺钉 Screw	扳手 Wrench
	D	D1	d	H	W	T				
KM12-50-22-4T	50	64	22	50	10.4	6.3	0.5	SEHT1204	M5*11	T20
KM12-50-25.4-4T	50	64	25.4	50	10	6	0.5			
KM12-50-22-4T 反齿	50	64	22	50	10.4	6.3	0.5			
KM12-63-22-4T	63	77	22	50	10.4	6.3	0.75			
KM12-63-25.4-4T	63	77	25.4	50	10	6	0.75			
KM12-80-27-5T	80	94	25.4	50	10	6	1.2			
KM12-80-27-5T 反齿	80	94	27	50	12.4	7	1.2			
KM12-100-32-5T	100	114	32	50	14.4	8	1.8			
KM12-100-31.75-5T	100	114	31.75	50	13	8	1.8			
KM12-125-40-6T	125	139	40	63	16.4	9	3.8			
KM12-125-38.1-6T	125	139	38.1	63	16.2	10	3.8			
KM12-160-40-7T	160	174	40	63	16.4	9	5.2			
KM12-160-38.1-7T	160	174	38.1	63	16.2	10	5.2			
KM12-200-60-10T	200	214	60	63	25.7	14	6.8			
KM12-200-38.1-10T	200	214	38.1	63	16.2	9	6.8			
KM12-250-60-12T	250	264	60	63	25.7	14	10.5			
KM12-300-60-14T	300	314	60	63	25.7	14	-			
KM12-315-60-14T	315	329	60	63	25.7	14	-			
KM12-350-60-	350	364	60	63	25.7	14	-			
KM12-400-60-	400	414	60	63	25.7	14	-			

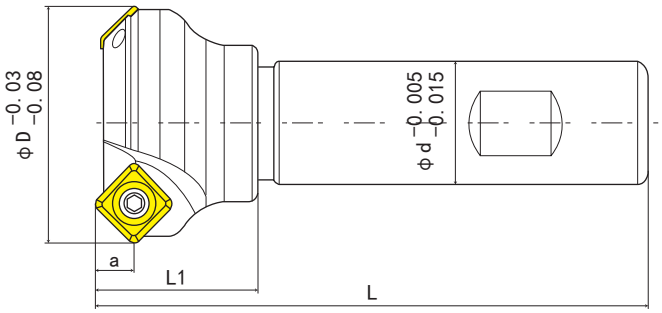
可配用刀片 INSERTS

规格 / 型号 Model	WAP25	WAP35	WTP35	WXP45	WPM	WXM35	WAK15	WAK25	WKM	WK10	NCM325	PC3535	PC9350	PC6510	PC230	CN30	H01	刀片形状 Insert shape	尺寸 Size(mm) D1	S1	排屑槽	
SEHT 1204AFN		●	●	●		●				●									12.7	4.76	有	WALTER（瓦尔特）
1204AFN-K88										●									12.7	4.76	有	
SEHW 1204AFN	●	●	●		●	●	●	●	●										12.7	4.76	无	
SECA 1204AFSN											●	●							12.7	4.76	无	KORLOY（刀片）
1204AFTN													●		●	●			12.7	4.76	无	
1204AFFN														●					12.7	4.76	无	
1204AFEN											●								12.7	4.76	无	
SEHT 1204AFFN-M																	●		12.7	4.76	无	

规格 / 型号 Model	H101	H102	KC25	PP30	PC35	PTE25	PFZ	MP91M	PMG	GH1	SK10	刀片形状 Insert shape	尺寸 Size(mm) D1	S1	排屑槽	
SEET 1204AFSN-M01						●							12.7	4.76	有	STELLRAM（使特龙）
1204AFFN-F01									●				12.7	4.76	有	
SEHT 1204AF4B							●	●					12.7	4.76	有	
1204AFFN										●			12.7	4.76	有	
SEHW 1204AFN											●		12.7	4.76	无	

KM 立铣刀 KM END MILL



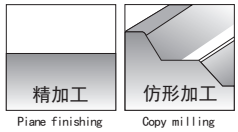


◎采用抗震性工具钢材质
◎整体预硬后，再行精修，避免二次加工产生变形

◎ Use antiknock tool steel.
◎ Overall pre-hard first,then fine processing,avoid transformation when proceed twice.

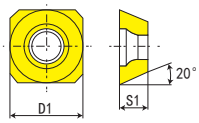

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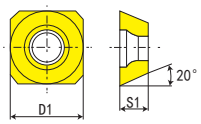

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规格 / 型号 Model	刃数 Teeth	尺寸 Size(mm)					刀片 Insert	螺钉 Screw	扳手 Wrench
		D	d	L	L1	a			
KM09-25*120-C20	4	25	20	120	-	4.5	SEEX09T3	A30070E M3*7	T8F T8
KM09-25*120-C25	4	25	25	120	32	4.5			
KM09-32*120-C25	4	32	25	120	-	4.5			
KM09-32*120-C32	4	32	32	120	32	4.5			
KMO12-32*120-C20	3	32	20	120	-	6	SEHT1204	A50110D M5*11	T20F T20
KMO12-32*120-C25	3	32	25	120	-	6			
KMO12-40*120-C20	3	40	20	120	-	6			
KMO12-40*120-C25	3	40	25	120	-	6			
KMO12-40*120-C32	3	40	32	120	-	6			
KM12-50*120-C20	3	50	20	120	-	6			
KM12-50*120-C25	3	50	25	120	35	6			
KM12-50*120-C32	3	50	32	120	35	6			
KM12-63*120-C20	3	63	20	120	-	6			
KMO12-63*120-C25	3	63	25	120	35	6			
KMO12-63*120-C32	3	63	32	120	35	6			

可配用刀片 INSERTS

规格 / 型号 Model	WAP25	WAP35	WTP35	WXP45	WPM	WXM35	WAK15	WAK25	WKM	WK10	NCM325	PC3535	PC9350	PC6510	PC230	CN30	H01	刀片形状 Insert shape	尺寸 Size(mm) D1	S1	排屑槽	
SEHT 1204AFN		●	●	●		●				●									12.7	4.76	有	WALTER（瓦尔特）
1204AFN-K88										●									12.7	4.76	有	
SEHW 1204AFN	●	●	●		●	●	●	●	●										12.7	4.76	无	
SECA 1204AFSN											●	●							12.7	4.76	无	KORLOY（刀片）
1204AFTN													●		●	●			12.7	4.76	无	
1204AFFN														●					12.7	4.76	无	
1204AFEN											●								12.7	4.76	无	
SEHT 1204AFFN-M																	●		12.7	4.76	无	

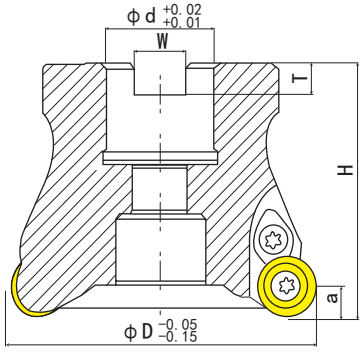
规格 / 型号 Model	PTE25	PFZ	MP91M	PMG	GH1	SK10	刀片形状 Insert shape	尺寸 Size(mm) D1	S1	排屑槽	
SEET 1204AFSN-M01	●							12.7	4.76	有	STELLRAM（使特龙）
1204AFFN-F01				●				12.7	4.76	有	
SEET 1204AF4B		●	●					12.7	4.76	有	
1204FFN					●			12.7	4.76	有	
SEHW 1204AFN						●		12.7	4.76	无	

可转位铣刀盘系列 FACE MILLING CUTTERS

EMR/EMRW 5R 通用型圆鼻壳形铣刀盘

EMR/EMRW 5R ROUND DOWEL FACE MILL CUTTERS

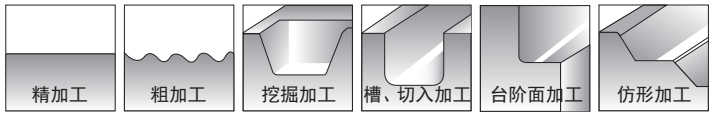





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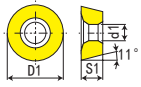


规格 / 型号 Model	尺寸 Size(mm)						重量 KGS	刀片 Insert	压板 Clamp	螺钉 screw	扳手 Wrench
	D	d	H	W	T	a					
EMR-5R-40-16-4T	40	16	42	8.5	5	5	0.3	RPMW1003 MO	A-5R	A4100J A35100F M4*10 N3.5*10	T15F T15
EMR-5R-40-22-4T	40	22	42	10.4	6.3	5	0.3				
EMR-5R-50-22-4T	50	22	50	10.4	6.3	5	0.35				
EMR-5R-63-22-4T	63	22	50	10.4	6.3	5	0.55				
EMR-5R-63-22-5T	63	22	50	10.4	6.3	5	0.55				
EMR-5R-63-25.4-4T	63	25.4	50	10	6	5	0.55				
EMR-5R-80-27-5T	80	27	50	12.4	7	5	0.9				
EMR-5R-80-27-6T	80	27	50	12.4	7	5	0.9				
EMR-5R-80-25.4-6T	80	25.4	50	10	6	5	0.9				
EMR-5R-100-32-6T	100	32	50	14.4	7	5	1.2				
EMR-5R-100-31.75-6T	100	31.75	50	13	8	5	1.2				
EMR-5R-125-40-6T	125	40	63	16.4	9	5	3.2				
EMR-5R-160-40-8T	160	40	63	16.4	9	5	5.2				
EMR-5R-200-60-10T	200	60	63	25.7	14	5	6.8				
EMR-5R-250-60-12T	250	60	63	25.7	14	5	10.5				

◎注：可做到 φ300, 接受非标定制

◎ Notice:can make φ300,nonstandard as custom order

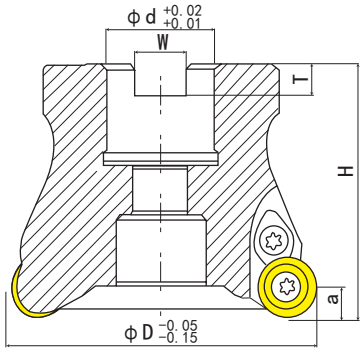
可配用刀片 INSERTS

规格 / 型号 Model	UP20M	NX2525	UT120T	F7030	VP15TF	SH8020	SH8250	JC3535	NIT	NAT	UMS	DX25	KT9	H101	H102	KC25	PP30	PC35	刀片形状 Insert shape	尺寸 Size(mm) D1	S1	排屑槽	
RPMW1003MO	●	●	●																	10	3.18	无	MITSUBISHI (三菱)
RPMW1003MOEN						●★	●★													10	3.18	无	HITACHI (日立)
RPMW1003MOEN								●	●	●	●	●	●							10	3.18	无	DIJET (黛杰)

EMR/EMRW 6R 通用型圆鼻壳形铣刀盘

EMR/EMRW 6R ROUND DOWEL FACE MILL CUTTERS

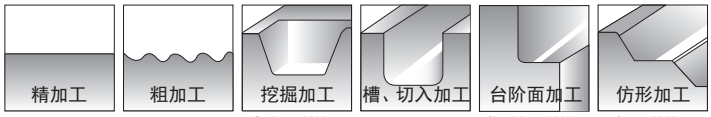





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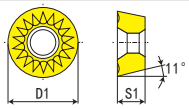
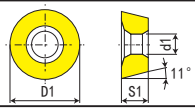


规格 / 型号 Model	尺寸 Size(mm)						重量 KGS	刀片 Insert	压板 Clamp	螺钉 screw	扳手 Wrench
	D	d	H	W	T	a					
EMR-6R-40-16-3T	40	16	42	8.5	5	6	0.3	RPMT1204 MO	A-6R	A40100J M4*10	T15F T15
EMR-6R-50-22-4T	50	22	50	10.4	6.3	6	0.35				
EMR-6R-50-25.4-4T	50	25.4	50	10	6	6	0.35				
EMR-6R-63-22-4T	63	22	50	10.4	6.3	6	0.55				
EMR-6R-63-22-5T	63	22	50	10.4	6.3	6	0.55				
EMR-6R-63-25.4-4T	63	25.4	50	10	6	6	0.55				
EMR-6R-80-27-5T	80	27	50	12.4	7	6	0.85				
EMR-6R-80-27-6T	80	27	50	12.4	7	6	0.85				
EMR-6R-80-25.4-5T	80	25.4	50	10	6	6	0.85				
EMR-6R-80-25.4-6T	80	25.4	50	10	6	6	0.85				
EMR-6R-100-32-6T	100	32	50	14.4	8	6	1.2				
EMR-6R-100-31.75-6T	100	31.75	50	13	8	6	1.2				
EMR-6R-125-40-6T	125	40	63	16.4	9	6	3.2				
EMR-6R-160-40-8T	160	40	63	16.4	9	6	5.2				
EMR-6R-200-60-10T	200	60	63	25.7	14	6	6.8				
EMR-6R-250-60-12T	250	60	63	25.7	14	6	10.5				

◎注：可做到 φ300, 接受非标定制

◎ Notice:can make φ300,nonstandard as custom order

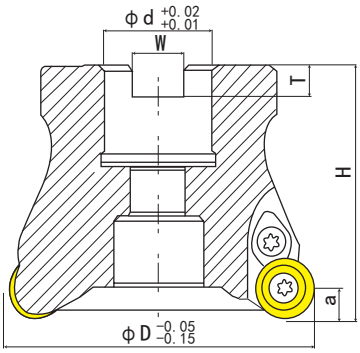
可配用刀片 INSERTS

规格 / 型号 Model	F7030	F620	VP15TF	NX4545	UT120T	TN100M	PR510	PR660	PP730	KW10	H101	H102	KC25	PP30	PC35	刀片形状 Insert shape	尺寸 Size(mm) D1	S1	排屑槽	
RPMT1204MOE-JS	●	●★	●★														12	4.76	有	MITSUBISHI (三菱)
RPMT1204MO							●	●	●	●							12	4.76	有	KYOCERA (京瓷)
1204MO-H						●	●	●	●	●							12	4.76	有	
RPMW1204MOE	●	●		●	●	●											12	4.76	无	MITSUBISHI (三菱)
1204MOT			●														12	4.76	无	

可转位铣刀盘系列 FACE MILLING CUTTERS

TRS 通用型圆鼻壳形铣刀盘 TRS ROUND DOWEL FACE MILL CUTTERS

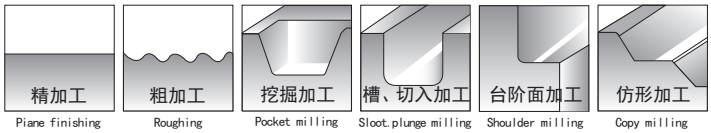




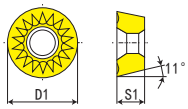

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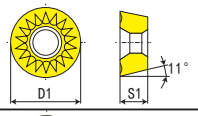
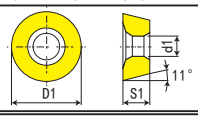

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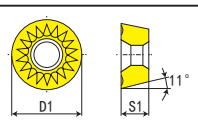

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规格 / 型号 Model	尺寸 Size(mm)							刀片 Insert	压板 Clamp	螺钉 Screw	扳手 Wrench
	D	d	H	W	T	a	重量 KGS				
TRS-5R-40-16-4T	40	16	42	8.5	5	5	0.3	RDMT10T3	Y-5R	A4100J A35100F M4*10 N3.5*10	T15F T15
TRS-5R-40-22-4T	40	22	42	10.4	6.3	5	0.3				
TRS-5R-50-22-4T	50	22	50	10.4	6.3	5	0.35				
TRS-5R-63-22-4T	63	22	50	10.4	6.3	5	0.55				
TRS-5R-63-22-5T	63	22	50	10.4	6.3	5	0.55				
TRS-5R-80-27-5T	80	27	50	12.4	7	5	0.85				
TRS-5R-80-27-6T	80	27	50	12.4	7	5	0.85				
TRS-5R-100-32-6T	100	32	50	14.4	8	5	1.25				
TRS-5R-125-40-6T	125	40	60	16.4	9	5	3.2				
TRS-5R-160-40-8T	160	40	60	16.4	9	5	5.2				
TRS-5R-200-60-10T	200	60	60	25.7	14	5	6.8				
TRS-5R-250-60-12T	250	60	60	25.4	14	5	10.5				
TRS-6R-50-22-4T	50	22	50	10.4	6.3	6	0.35	RDHW1204	Y-5R	M4.0*9	T15
TRS-6R-63-22-4T	63	22	50	10.4	6.3	6	0.55				
TRS-6R-80-27-6T	80	27	50	12.4	7	6	0.85				
TRS-6R-100-32-6T	100	32	50	14.4	8	6	1.25				
TRS-6R-125-40-6T	125	40	60	16.4	9	6	3.2				
TRS-6R-160-40-8T	160	40	60	16.4	9	6	5.2				
TRS-8R-63-22-4T	63	22	50	10.4	6.3	8	0.55	RDMT1604	Y-8R	M5.0*12	T20
TRS-8R-80-27-6T	80	27	50	12.4	7	8	0.85				
TRS-8R-100-32-6T	100	32	50	14.4	8	8	1.25				
TRS-8R-125-40-6T	125	40	60	16.4	9	8	3.2				

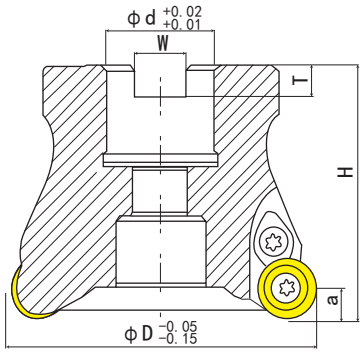
规格 / 型号 Model	UP20M	NX2525	UT120T	F7030	VP15TF	SH8020	SH8250	JC3535	NIT	NAT	UMS	DX25	KT9	H101	H102	KC25	PP30	PC35	刀片形状 Insert shape	尺寸 Size(mm) D1	S1	排屑槽	
RPMT10T3MOE				●	●															10	3.97	有	MITSUBISHI (三菱)
RDMT10T3MOTN						●★	●★													10	3.97	有	HITACHI (日立)

规格 / 型号 Model	F7030	F620	VP15TF	NX4545	UT120T	TN100M	PR510	PR660	PP730	KW10	H101	H102	KC25	PP30	PC35	刀片形状 Insert shape	尺寸 Size(mm) D1	S1	排屑槽	
RPMT1204MOE-JS	●	●★	●★														12	4.76	有	MITSUBISHI (三菱)
RPMT1204MO							●	●	●	●							12	4.76	有	KYOCERA (京瓷)
1204MO-H						●	●	●	●	●							12	4.76	有	
RPMW1204MOE	●	●		●	●	●											12	4.76	无	MITSUBISHI (三菱)
1204MOT			●														12	4.76	无	

规格 / 型号 Model	F7030	F620	VP15TF	NX4545	UT120T	TN100M	PR510	PR660	PP730	KW10	H101	H102	KC25	JP4020	CY250	刀片形状 Insert shape	尺寸 Size(mm) D1	S1	排屑槽	
RDMX1604														●	●		16	6.35	有	HITACHI (日立)
RDMT1604														●	●		16	6.35	有	

R200 通用型圆鼻壳形铣刀盘 R200 ROUND DOWEL FACE MILL CUTTERS

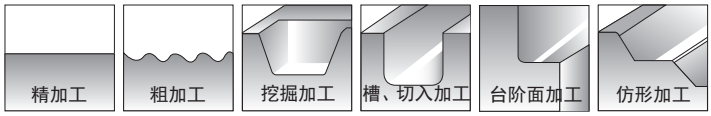




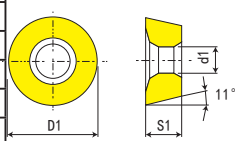
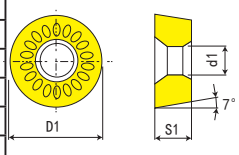
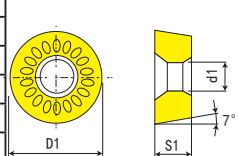

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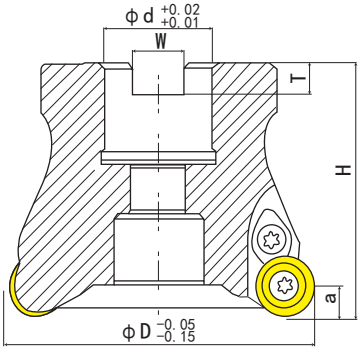
规格 / 型号 Model	尺寸 Size(mm)						刀片 Insert	压板 Clamp	螺钉 Screw	扳手 Wrench
	D	d	H	W	T	a				
R200-5R-50-22-4T	50	22	50	10.4	6.3	5	RC □ T10T3MO	A-6R	A40100J/A35100J M4*10/M3.5*10	T15F T15
R200-5R-63-22-4T	63	22	50	10.4	6.3	5				
R200-5R-80-27-6T	80	27	50	12.4	7	5				
R200-5R-100-32-6T	100	32	50	14.4	7	5				
R200-6R-50-22-4T	50	22	50	10.4	6.3	6	RC □ T1204MO	A-6R	A40100J/A35100J M4*10/M3.5*10	T15F T15
R200-6R-63-22-4T	63	22	50	10.4	6.3	6				
R200-6R-80-27-6T	80	27	50	12.4	7	6				
R200-6R-100-32-6T	100	32	50	14.4	8	6				
R200-8R-63-22-4T	63	22	50	10.4	6.3	8	RC □ T1606MO	A-8R	A50120J M5*12	T20F T20
R200-8R-80-27-6T	80	27	50	12.4	7	8				
R200-8R-100-32-6T	100	32	50	14.4	8	8				
R200-8R-125-40-6T	125	40	63	16.4	9	8				
R200-8R-160-40-8T	160	40	63	16.4	9	8				

规格 / 型号 Model	530	1025	2030	2040	3020	3040	4020	4030	4040	H10F	H13A	SM30	H101	H102	KC25	PP30	PC35	刀片形状 Insert shape	D1	d1	S1	
RCHT10T3MO-PL	●	●																	10	4.0	3.97	SANDVIK (山特维克)
10T3MO-KL											●								10	4.0	3.97	
10T3MO-ML			●	●															10	4.0	3.97	
RCHT1204MO-PL	●	●																	12	4.0	4.76	
1204MO-KL											●								12	4.0	4.76	
1204MO-ML			●	●															12	4.0	4.76	
RCHT1606MO-PL	●	●																	16	5.5	6.35	
1606MO-KL											●								16	5.5	6.35	
1606MO-ML			●	●															16	5.5	6.35	
RCKT10T3MO-PM							●	●	●										10	4.0	3.97	SANDVIK (山特维克)
10T3MO-KM					●	●													10	4.0	3.97	
10T3MO-WM	●									●		●							10	4.0	3.97	
10T3MO-MM			●	●															10	4.0	3.97	
RCKT1204MO-PM							●	●	●										12	4.0	4.76	
1204MO-KM					●	●													12	4.0	4.76	
1204MO-WM	●									●		●							12	4.0	4.76	
1204MO-MM			●	●															12	4.0	4.76	
RCKT1606MO-PM							●	●	●										16	5.5	6.35	
1606MO-KM					●	●													16	5.5	6.35	
1606MO-WM	●									●		●							16	5.5	6.35	
1606MO-MM			●	●															16	5.5	6.35	
RCKT10T3MO-PH							●	●	●										10	4.0	3.97	SANDVIK (山特维克)
10T3MO-KH					●	●													10	4.0	3.97	
10T3MO-WH												●							10	4.0	3.97	
RCKT1204MO-PH							●	●	●										12	4.0	4.76	
1204MO-KH					●	●													12	4.0	4.76	
1204MO-WH												●							12	4.0	4.76	
RCKT1606MO-PH							●	●	●										16	5.5	6.35	
1606MO-KH					●	●													16	5.5	6.35	
1606MO-WH												●							16	5.5	6.35	

可转位铣刀盘系列 FACE MILLING CUTTERS

R200 通用型圆鼻壳形铣刀盘 R200 ROUND DOWEL FACE MILL CUTTERS

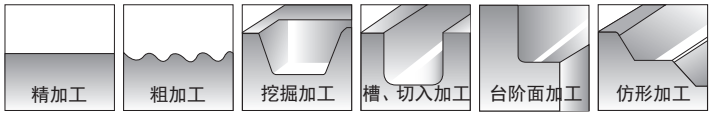




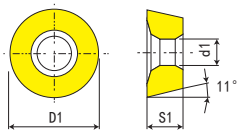
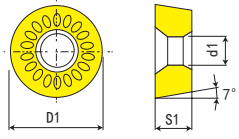
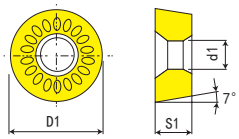

P.E87


P.I30

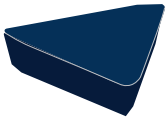

P.I32



规格 / 型号 Model	尺寸 Size(mm)						刀片 Insert	压板 Clamp	螺钉 Screw	扳手 Wrench
	D	d	H	W	T	a				
R200-5R-50-25.4-4T	50	25.4	50	10	6	5	RC □ T10T3MO	A-6R	A40100J/A35100J M4*10/M3.5*10	T15F T15
R200-5R-63-25.4-4T	63	25.4	50	10	6	5				
R200-5R-80-25.4-6T	80	25.4	50	10	6	5				
R200-5R-100-31.75-6T	100	31.75	50	13	8	5				
R200-6R-50-25.4-4T	50	25.4	50	10	6	6	RC □ T1204MO	A-6R	A40100J/A35100J M4*10/M3.5*10	T15F T15
R200-6R-63-25.4-4T	63	25.4	50	10	6	6				
R200-6R-80-25.4-6T	80	25.4	50	10	6	6				
R200-6R-100-31.75-6T	100	31.75	50	13	8	6				
R200-8R-63-25.4-4T	63	25.4	50	10	6	8	RC □ T1606MO	A-8R	A50120J M5*12	T20F T20
R200-8R-80-25.4-6T	80	25.4	50	10	6	8				
R200-8R-100-31.75-6T	100	31.75	50	13	8	8				
R200-8R-125-38.1-6T	125	38.1	50	16.2	10	8				
R200-8R-160-38.1-8T	160	38.1	50	16.2	10	8				

规格 / 型号 Model	530	1025	2030	2040	3020	3040	4020	4030	4040	H10F	H13A	SM30	H101	H102	KC25	PP30	PC35	刀片形状 Insert shape	尺寸 Size(mm) D1	d1	S1	
RCHT10T3MO-PL	●	●																	10	4.0	3.97	SANDVIK (山特维克)
10T3MO-KL											●								10	4.0	3.97	
10T3MO-ML			●	●															10	4.0	3.97	
RCHT1204MO-PL	●	●																	12	4.0	4.76	
1204MO-KL											●								12	4.0	4.76	
1204MO-ML			●	●															12	4.0	4.76	
RCHT1606MO-PL	●	●																	16	5.5	6.35	
1606MO-KL											●								16	5.5	6.35	
1606MO-ML			●	●															16	5.5	6.35	
RCKT10T3MO-PM							●	●	●										10	4.0	3.97	SANDVIK (山特维克)
10T3MO-KM					●	●													10	4.0	3.97	
10T3MO-WM	●									●		●							10	4.0	3.97	
10T3MO-MM			●	●															10	4.0	3.97	
RCKT1204MO-PM							●	●	●										12	4.0	4.76	
1204MO-KM					●	●													12	4.0	4.76	
1204MO-WM	●									●		●							12	4.0	4.76	
1204MO-MM			●	●															12	4.0	4.76	
RCKT1606MO-PM							●	●	●										16	5.5	6.35	
1606MO-KM					●	●													16	5.5	6.35	
1606MO-WM	●									●		●							16	5.5	6.35	
1606MO-MM			●	●															16	5.5	6.35	
RCKT10T3MO-PH							●	●	●										10	4.0	3.97	SANDVIK (山特维克)
10T3MO-KH					●	●													10	4.0	3.97	
10T3MO-WH												●							10	4.0	3.97	
RCKT1204MO-PH							●	●	●										12	4.0	4.76	
1204MO-KH					●	●													12	4.0	4.76	
1204MO-WH												●							12	4.0	4.76	
RCKT1606MO-PH							●	●	●										16	5.5	6.35	
1606MO-KH					●	●													16	5.5	6.35	
1606MO-WH												●							16	5.5	6.35	

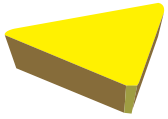
TP 台肩壳形铣刀 TP SHOULDER FACE MILL



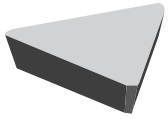
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铸铁用 材质 KC25



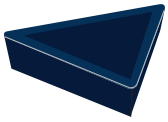
XPKN 220412
钢用 材质 PP30



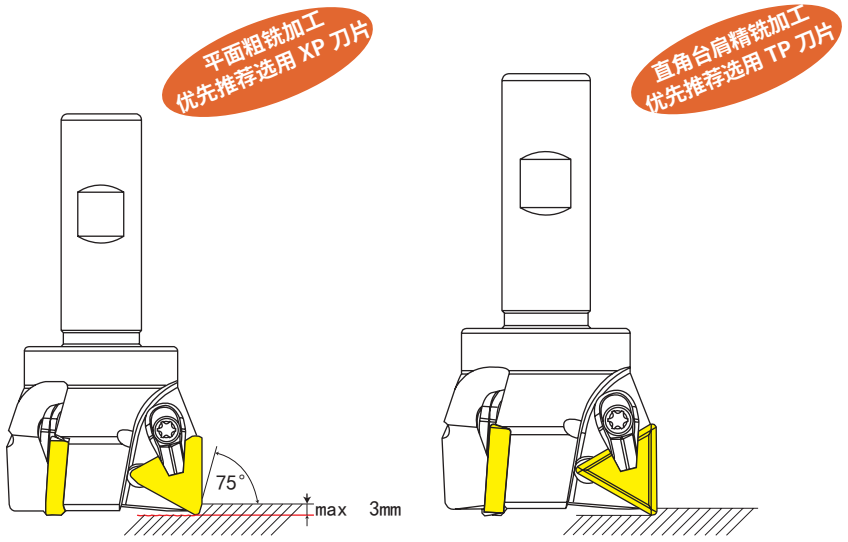
TPKN 2204PDR
钢用 材质 PP20



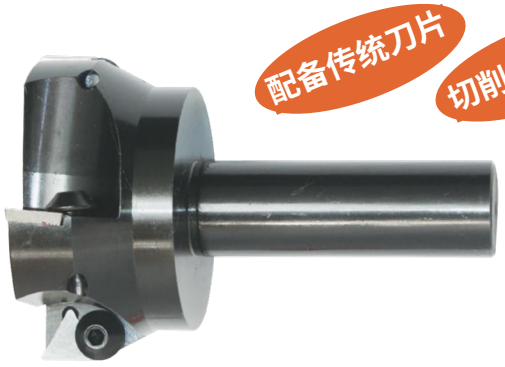
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钢用 材质 PJ20

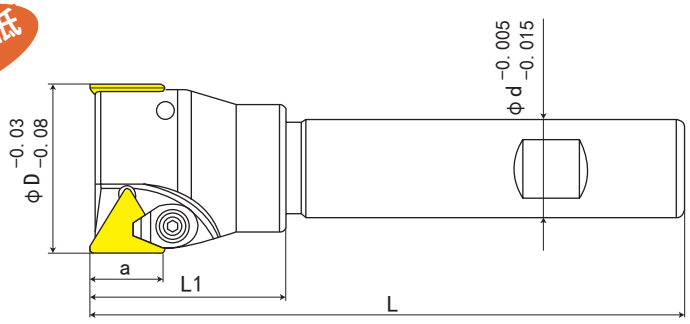


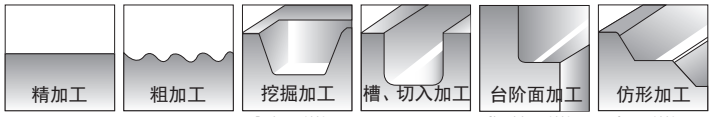
TPKN 220408
钢用 材质 PP30



TP 台肩壳形铣刀 TP SHOULDER FACE MILL







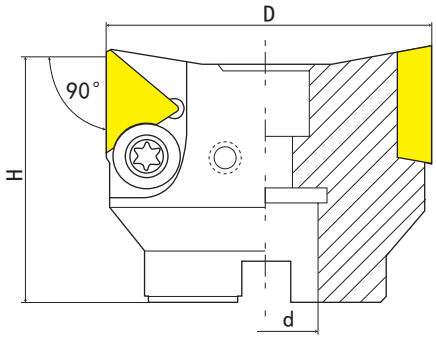
规格 / 型号 Model	刃数 Teeth	尺寸 Size(mm)					刀片 Insert	压板 Clamp	螺钉 Screw	扳手 Wrench
		D	d	L	L1	a				
TP16-30*100-C20	2	30	20	100	45	14	TPMN1603 TPKN1603	AMS-4	A40100J M4*10	T15
TP16-35*100-C20	2	35	20	100	45	14				
TP16-35*105-C25	2	35	25	105	45	14				
TP16-35*110-C32	2	35	32	110	45	14				
TP16-40*110-C20	3	40	20	110	45	14				
TP16-40*110-C25	3	40	25	110	45	14				
TP16-40*115-C32	3	40	32	115	45	14				
TP22-50*110-C20	3	50	20	110	42	20	TPMN2204 TPKN2204 XPKR220412 XPKN220408	CSY-20	A50110D M5*11	T20
TP22-50*110-C25	3	50	25	110	42	20				
TP22-50*115-C32	3	50	32	115	42	20				
TP22-63*110-C20	3	63	20	110	42	20				
TP22-63*110-C25	3	63	25	110	42	20				
TP22-63*110-C32	3	63	32	110	42	20				

◎采用抗震性工具钢材质
◎整体预硬后，再行精修，避免二次加工产生变形
◎接受其它规格定制

可转位铣刀盘系列 FACE MILLING CUTTERS

TP90 度直角面铣刀盘 TP90° SQUARE FACE MILL HEAD

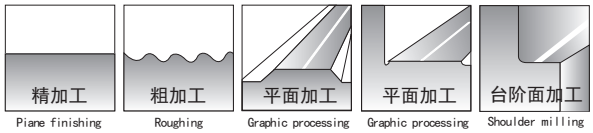





P.E87


P.I30


P.I32



规格 / 型号 Model	刃数 NTeeth	尺寸 Size(mm)			重量 KGS	刀片 Insert	伞型压板 Screw	扳手 Wrench
		D	d	H				
TP90-50-22-3T	3	50	22	50	0.40	TPMN1603	M6	WRN-M3T
TP90-63-22-3T	3	63	22	50	0.75	TPMN2204	M8	WRN-M4T
TP90-80-27-4T	4	80	27	50	1.00	TPMN2204	M8	WRN-M4T
TP90-100-32-4T	4	100	32	50	1.25	TPMN2204	M8	WRN-M4T
TP90-125-40-6T	6	125	40	60	2.70	TPMN2204	M8	WRN-M4T

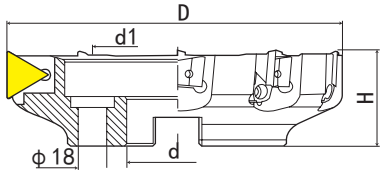
◎适用 Suitable：三菱刀片 MITSUBISHI Insert

◎铣削加工，小马力铣床及 M/C 加工用
◎隅角 90 度

◎ Milling in milling machine with a low power and machine center.
◎ Angle：90°

TP90 度直角面铣刀盘 TP90° SQUARE FACE MILL HEAD

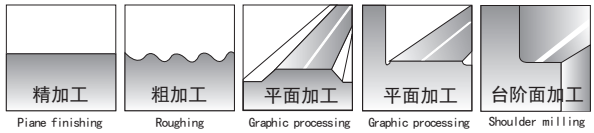





P.E87

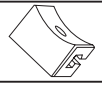

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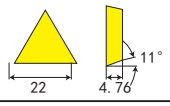

P.I32



规格 / 型号 Model	刃数 Teeth	尺寸 Size(mm)				重量 KGS
		D	d	d1	H	
TP90-160-50.8-8T	8	160	50.8	-	63	7.30
TP90-200-47.625-10T	10	200	47.625	101.6	63	-
TP90-250-47.625-12T	12	250	47.625	101.6	63	-
TP90-300-47.625-14T	14	300	47.625	101.6	63	-

规格 / 型号 Model	刃数 Teeth	尺寸 Size(mm)				重量 KGS
		D	d	d1	H	
TP90-160-40-8T	8	160	40	-	63	5.60
TP90-200-60-10T	10	200	60	101.6	63	-
TP90-250-60-12T	12	250	60	101.6	63	-
TP90-300-60-14T	14	300	60	101.6	63	-

替换零件 Replacing fittings				
E01	E04	E03	E03	E02
				
M5*16	CL-S	FC3050-TP2204-75	SV-128170-15	TH-40

使用刀片规格 Insert specification

TPKN2204

◎注：只要更换刀片座，同一个 TP 刀头可重复利用

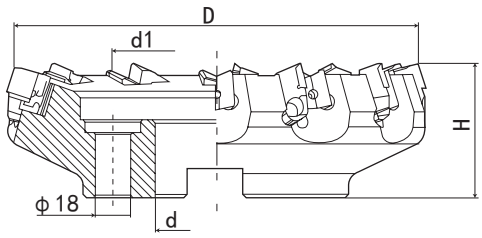
◎铣削加工，小马力铣床及 M/C 加工用
◎隅角 90 度

◎ NOTICE：If replacing insert seat,the TP head mill can use again.

◎ Milling in milling machine with a low power and machine center.
◎ Angle：90°

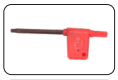
FP45 度平面铣刀盘 FP45° FACE MILL HEAD

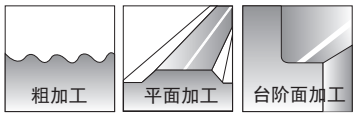





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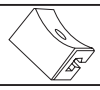

P.I30


P.I32

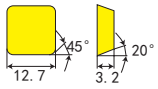
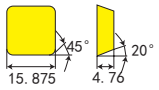


规格 / 型号 Model	刃数 Teeth	尺寸 Size(mm)				
		D	d	d1	H	重量 KGS
FP45-80-25.4-5T	5	80	25.4	-	50	1.90
FP45-100-31.75-5T	5	100	31.75	-	50	2.40
FP45-125-38.1-6T	6	125	38.1	-	63	5.50
FP45-160-50.8-8T	8	160	50.8	-	63	7.30
FP45-200-47.625-10T	10	200	47.625	101.6	63	11.45
FP45-250-47.625-12T	12	250	47.625	101.6	63	13.65
FP45-300-47.625-14T	14	300	47.625	101.6	63	22.10

规格 / 型号 Model	刃数 Teeth	尺寸 Size(mm)				
		D	d	d1	H	重量 KGS
FP45-80-27-5T	5	80	27	-	50	2.05
FP45-100-32-5T	5	100	32	-	50	2.55
FP45-125-40-6T	6	125	40	-	63	5.70
FP45-160-40-8T	8	160	40	-	63	7.50
FP45-200-60-10T	10	200	60	101.6	63	11.70
FP45-250-60-12T	12	250	60	101.6	63	13.90
FP45-300-60-14T	14	300	60	101.6	63	22.40

替换零件 Replacing fittings			
E01	E03	E03	E02
			
M5*16	FC2550	SV-128170-15	TH-40

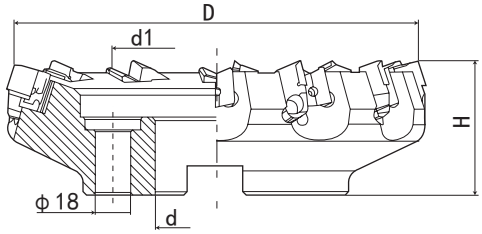
◎ 注：只要更换刀片座，同一个FP规格刀盘可使用SEKN1203,SEKN1504二种刀片

使用刀片规格 Insert specification	
	
SEKN1203	SEKN1504

◎ NOTICE: If replacing insert seat,the FP head mill can use SEKN1203 and SEKN1504.

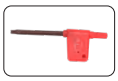
FP75 度平面铣刀盘 FP75° FACE MILL HEAD

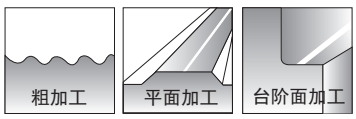





P.E87

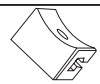

P.I30


P.I32

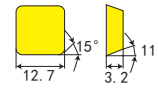
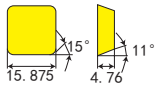


规格 / 型号 Model	刃数 Teeth	尺寸 Size(mm)				
		D	d	d1	H	重量 KGS
FP75-80-25.4-5T	5	80	25.4	-	50	1.90
FP75-100-31.75-6T	6	100	31.75	-	50	2.40
FP75-125-38.1-8T	8	125	38.1	-	63	5.50
FP75-160-50.8-10T	10	160	50.8	-	63	7.30
FP75-200-47.625-12T	12	200	47.625	101.6	63	11.45
FP75-250-47.625-14T	14	250	47.625	101.6	63	13.65
FP75-300-47.625-16T	16	300	47.625	101.6	63	22.10

规格 / 型号 Model	刃数 Teeth	尺寸 Size(mm)				
		D	d	d1	H	重量 KGS
FP75-80-27-5T	5	80	27	-	50	2.05
FP75-100-32-6T	6	100	32	-	50	2.55
FP75-125-40-8T	8	125	40	-	63	5.70
FP75-160-40-10T	10	160	40	-	63	7.50
FP75-200-60-12T	12	200	60	101.6	63	11.70
FP75-250-60-14T	14	250	60	101.6	63	13.90
FP75-300-60-16T	16	300	60	101.6	63	22.40

替换零件 Replacing fittings			
E01	E03	E03	E02
			
M5*16	FC2550	SV-128170-15	TH-40

◎ 注：只要更换刀片座，同一个FP规格刀盘可使用SPUN120308，SPKN1504EDTR-20二种刀片

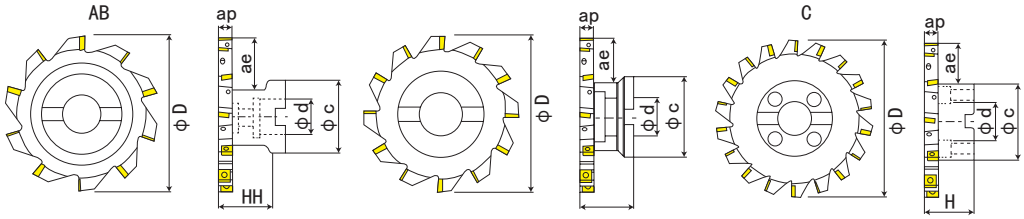
使用刀片规格 Insert specification	
	
SPUN120308	SPKN1504EDTR-20

◎ NOTICE: If replacing insert seat,the FP head mill can use SPUN120308 and SPKN1504EDTR-20.

可转位铣刀盘系列 FACE MILLING CUTTERS

SMP 三面刃铣刀（刀盘型） SMP SIDE MILLS






P.E87


P.I30


P.I32

规格 / 型号 Model	尺寸 Size(mm)						齿数 Z	刀片 Insert	螺钉 Clamp screw	扳手 Wrench
	D	H	d	W	T	a				
SMP-80*8-A22-06-10	80	45	22	21	8	40	10	MP □ T060304	M2.5*6.5	T8
SMP-100*8-B27-06-14	100	55	27	24	8	40	14			
SMP-100*10-B27-06-14	100	55	27	24	10	40	14			
SMP-125*10-B32-06-16	125	65	32	33	10	45	16	MP □ T080305	M3*8	T8
SMP-125*12-B32-08-12	125	65	32	33	12	45	12			
SMP-160*12-B40-08-14	160	80	40	45	12	50	14			
SMP-200*12-C40-08-18	200	92	40	53	12	50	18			
SMP-125*16-B32-12-10	125	65	32	30	16	50	10			
SMP-160*16-B40-12-12	160	80	40	45	16	60	12	MP □ T20408	M5*12	T20
SMP-160*18-B40-12-12	160	80	40	45	18	60	12			
SMP-200*16-C40-12-12	200	92	40	53	16	50	14			
SMP-200*18-C40-12-14	200	92	40	53	18	50	14			
SMP-200*20-C40-12-14	200	92	40	53	20	50	14			

铣削加工切削条件的选择方法 HOW TO SELECT CUTTING CONDITIONS FOR MILLING

◎切削速度（Vc）Cutting Speed

$$Vc=\frac{\pi\times D\times n}{1000}(m/min)$$

转速（n）Revolution

$$n=\frac{1000\times Vc}{\pi\times D}(min^{-1})$$

Vc：切削速度 m/min cutting speed
D：刀径 mm Cutter diameter
n：转速 min^{-1} RPM
π：圆周率 3.1416 Circumference ratio

◎进给速度 （Vf）Feed rate

$$Vf=fz\times z\times n(mm/min)$$

每刃进给（fz）Feed rate per tooth

$$fz=\frac{Vf}{Z\times n}(mm/tooth)$$

Vf：进给速度 m/min Feed rate
Z：刃数 Number of flutes
n：转速 min RPM
fz：每刃进给 mm/tooth feed per tooth

◎加工时间（Tc）

$$Tc=\frac{L}{Vf}(min)$$

Tc：加工时间 min cutting time
Vf：每分钟的工作台进给速度
Feed rate per minute of table
L：转工作台总进给长度（工件长度＋铣刀直径）mm
Overall table feed length(workpiece length+grinder dia.

◎切削动力（Ne）Feed rate

$$Ne=\frac{apxaexVfxKs}{60x106x\eta}(KW)$$

Ne：切削动力 kw
Cutting power(horsepower)
ae：切削宽度 mm
Cutting with
η：机械效率（0.6-0.8）
Mechanical effciency
ap：切削深度 mm
Cutting depth
Vf：进给速度 mm/min
Feed rate
Ks：比切削阻力 kg/mm2
Relative cutting resistance
（参照下表 Refer to the table below）

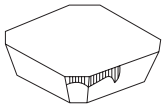
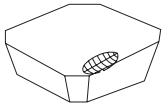
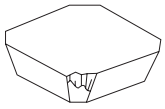
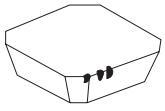
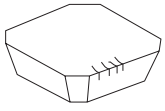
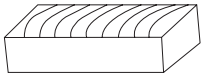
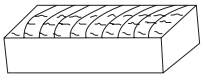
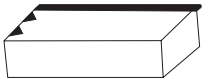
KS（比切削阻力） Specific cutting resistance

工件材料 Work Materials	被拉伸强度（N/mm2）及硬度 Tensile stength (N/mm2) or hardness	对于每刃进给的比切削阻力（N/mm2）ks Ks:Specific cutting resistance （N/mm2）for feed tooth				
		0.1mm/tooth	0.2mm/tooth	0.3mm/tooth	0.4mm/tooth	0.6mm/tooth
软钢 Mild steels	520	2200	1950	1820	1700	1580
中碳钢 Medium steels	620	1980	1800	1730	1600	1570
硬钢 Hard steels	720	2520	2200	2040	1850	1740
工具钢 Tool steels	670	1980	1800	1730	1700	1600
	770	2030	1800	1750	1700	1580
铬锰钢 Chrome manganese steels	770	2300	2000	1880	1750	1660
	630	2750	2300	2060	1800	1780
铬钼钢 Chrome molybdenum steels	730	2540	2250	2140	2000	1800
	600	2180	2000	1860	1800	1670
镍铬钼钢 Nickel chrome molybdenum steels	940	2000	1800	1680	1600	1500
	352HB	2100	1900	1760	1700	1530
铸钢 Cast steels	520	2800	2500	2320	2200	2040
硬质铸铁 Hard cast steels	46HRC	3000	2700	2500	2400	2200
米汉纳铸铁 Meehanite cast steels	360	2180	2000	1750	1600	1470
灰铸铁 Gray cast steels	200HB	1750	1400	1240	1050	970
黄铜 Yellow cipper	500	1150	950	800	700	630
轻合金 (Al-Mg) Light Alloy (Al-Mg)	160	580	480	400	350	320
轻合金 (Al-Si) Light Alloy (Al-Si)	200	700	600	490	450	390

可转位铣刀盘系列 FACE MILLING CUTTERS

螺纹铣刀片（UNUNC UNF UNEF UNS） THREAD MILLING INSERT

〈对策〉
〈Countermeasurs〉
○：效果好
Very Effective
●：有效果
Effective
▼：效果相反
Not Effective
↑：增加、增大
Increase,Make it Large
↓：减少、减小
Reduce,Make it Small

	刀片材料 Insert Grade				刀具形状 Tool Shape							切削条件 Cutting Condition					
	使用韧性高的材料 Use tough grade	使用耐磨损性的高的材料 Use abrasion resistant grade	使用金属陶瓷 Use cermet material	使用涂层材料 Use coated grode	改变磨量 Chang the honing	改变前角 Change rake	改变后角 Change relief angle	加厚刀片 Make insert thicker	加大R角 Increase corner R	使用精密级刀片 Use precision class inserts	改变刃数 Use inserts of different flute number	安装修刀刃 Attach flat drag	改变切削速度 Change cutting speed	改变进给量 Change the feed rate	改变切削深度 Change cut-in amount	使用切削液 Splash cutting fluid	减小接触角 Reduce the engage angle	
后隙面磨损（侧面） Abraded Relief Surface（Fland） 		○		○	●↓		↑●		●				●↓					
前刀面磨损（月牙） Abraded Rake Surface（Crater） 		●	●	●		↑●							●↓	●↓		●		
动挚性崩裂 Shoch Chipping 	○				↑○	●↓	●↓	●	●					●↓			●	
熔着性崩裂 Welding Chipping 	●		●	○	●↓	↑●							↑○			○		
热裂 Thermal Crack 	●							●					●↓			▼		
精加工面 Finish Surface 			○		●↓	↑●	↑●			○		○	↑●	●↓	●↓	○		
颤动 Chattering Vibration 					●↓	↑●	↑●				●↓		●↓	●↓	●↓			
精刃带缺损●毛刺 Edge Chipping Burr 					●↓	↑●	↑●		●		↑●			●↓	●↓		●	