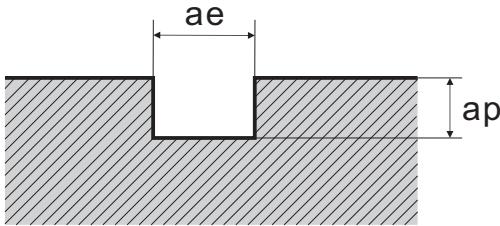


可转位玉米型铣削刀具 (推荐切削参数)

Indexable corn milling cutter (Recommended cutting parameters)

槽铣加工

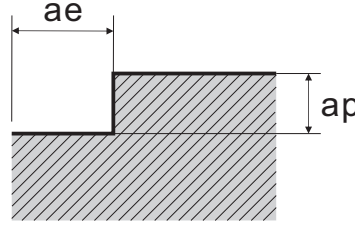
Groove milling



ae 与刀具直径一致 $ap \leq 0.5D$

方肩台阶铣

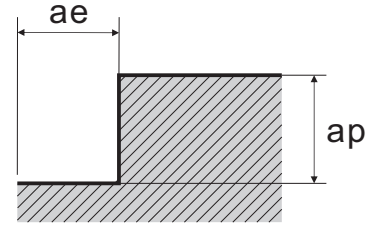
Step milling



$ae \leq 0.5D$ $ap \leq 1.2D$

深方肩台阶铣

Deep step milling



$ae \leq 0.2D$ ap 小于切削刃长

刀杆
刀盘

直角
台肩
立
铣刀

圆角
铣刀

球头
铣刀

钻铣
刀杆

倒角
刀杆

玉米
铣刀

三
面刃
槽刀

快
进给
系列

龙门
平面
铣刀

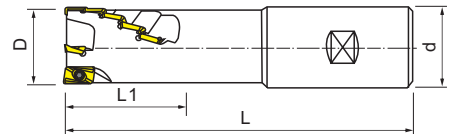
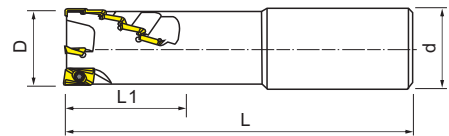
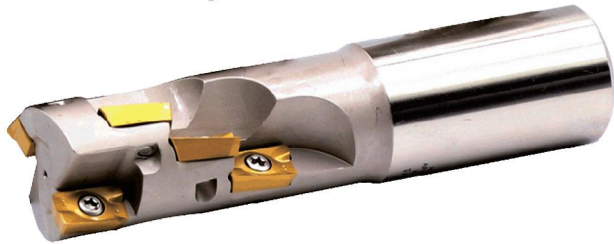
锁
牙式
刀柄

被加工材料 Processed Material	硬度 HB	刀片 材质 Inserts Material	切削用量 Cutting amount			
			方肩台阶铣 Square shoulder milling			
			Vc (m/min)	f (mm/z)		
精加工 Finish	中切削 Medium	重切削 Heavy				
低碳钢、 软钢 Mild Steels	≤ 180	ZP151 ZP163	270(240-350)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP201	220(180-300)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP153	270(200-360)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP152	240(180-350)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
高碳钢、 合金钢 Carbon Steel & Alloy Steels	180-280	ZP151 ZP163	240(210-320)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP201	200(160-280)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP153	240(180-360)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP152	220(150-330)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
合金 工具钢 Die Steel	280-350	ZP151 ZP163	220(180-300)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP201	180(150-250)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP153	220(160-340)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP152	200(120-300)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
不锈钢 Stainless Steels	≤ 270	ZP153	170(120-240)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP152	160(150-270)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP151	150(110-270)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
		ZP150	140(100-250)	0.1(0.08-0.2)	0.2(0.1-0.3)	0.25(0.2-0.35)
铸铁 Cast Iron	180-250	ZK50S	200(120-240)	0.1(0.08-0.2)	0.2(0.1-0.3)	
		ZK50	180(120-300)	0.1(0.08-0.2)	0.2(0.1-0.3)	
			-AL			
铝合金 Aluminum	---	ZK01	300-	0.2(0.08-0.4)		
		PCD	300-	0.2(0.08-0.4)		

玉米铣刀

机夹式粗加工用铣刀 Milling cutter for rough machining

APK 玉米立铣刀杆 APK Corn End Milling Cutter

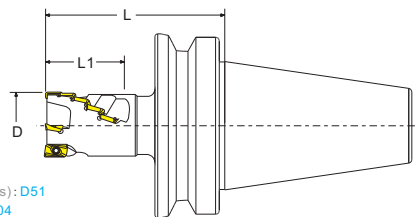


- 高效能型粗铣刀，能加工深孔。
- 尺寸可由刀杆随意变换深度，发挥最大效能。
- ★ High-performance-based rough milling, deep hole can be processed.
- ★ Arbor size can be arbitrarily change the depth of maximum efficiency.

切削参数 (Cutting Parameters): D51
零配件 (Spare Parts): P01-P04

型号 Cat. No	尺寸 Size				刀数 No. of Flutes	刀片数 T	刀片 Insert	螺钉 Screw	扳手 Wrench	Stock	Order Number	Price (RMB)
	D	d	L1	L								
C20-20AP11-28-125-2T	20	20	28	125	2	6				●	334500	1750
C20-20AP11-35-110-2T	20	20	35	110	2	8				●	334502	1040
C25-25AP11-38-130-2T	25	25	38	130	2	8	AP..1135..	M2.5X6	T8	●	334504	1900
C25-25AP11-35-120-2T	25	25	35	120	2	8				●	334506	1280
C32-32AP11-48-150-3T	32	32	48	150	3	12				●	334508	2750
C32-32AP16-55-135-2T	32	32	55	135	2	8				●	334510	1440
C32-40AP16-70-150-3T	40	32	70	150	3	12				●	334512	3000
C32-40AP16-55-135-2T	40	32	55	135	2	8	AP..1604..	M4.0X12	T15	●	334514	1680
C32-50AP16-55-135-4T	50	32	55	135	4	16				●	334516	1880
C50.8-50AP16-80-205-3T	50	50.8	80	205	3	18	APKT1504..	M5	T20	●	334518	5440
C50.8-50AP16-125-250-3T	50	50.8	125	250	3	29	SPMT45272..			●	334520	6480

AP 整体式玉米型粗铣刀 AP Integral Type Maize Rough Milling Cutter



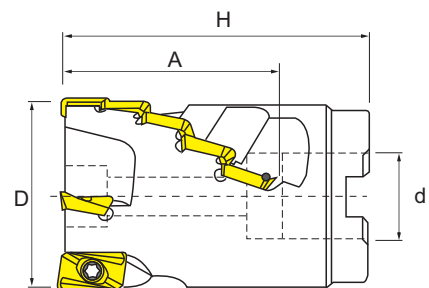
切削参数 (Cutting Parameters): D51
零配件 (Spare Parts): P01-P04

订购编码 Order	规格型号 Specification	Dimensions			刀片数 T	刃数 Edge	价格 Price
		D	L1	L			
334550	BT40-50AP16-70-125-4T	50	70	125	16	4	10000
334552	BT40-63AP16-110-160-4T	63	110	160	24	4	16800
334554	BT50-80AP16-165-250-4T	80	165	250	36	4	20000

配件(Accessory): 刀片: APMT1604.. 螺钉: M4X10 扳手: T15

APC 玉米型粗铣刀盘 Corn Type Rough Milling Cutter

- 高效能型粗铣刀，能加工深孔
- 尺寸可由刀杆随意变换深度，发挥最大效能
- ★ High-performance-based rough milling, deep hole can be processed.
- ★ Arbor size can be arbitrarily change the depth of maximum efficiency.



切削参数 (Cutting Parameters): D51
零配件 (Spare Parts): P01-P04

型号 Cat. No	尺寸 Size				刀片数 T	刀片 Insert	螺钉 Screw	扳手 Wrench	Stock	Order Number	Price (RMB)
	D	d	A	H							
D50AP16-22-42-65-3T	50	22	42	65	9				●	334530	2750
D50AP16-22-70-90-4T	50	22	70	90	16				●	334532	3040
D63AP16-27-42-65-4T	63	27	42	65	12				●	334534	3000
D63AP16-22-70-90-4T	63	22	70	90	16				●	334536	3280
D80AP16-32-70-100-5T	80	32	70	100	16				●	334538	3750
D80AP16-27-110-135-4T	80	27	110	135	24	APKT1604	M4	T15	●	334540	3720

刀杆
刀盘

直角
台肩
立
铣刀

圆角
铣刀

球头
铣刀

钻铣
刀杆

倒角
刀杆

玉米
铣刀

三面
刃槽
刀

快
进给
系列

龙门
平面
铣刀

锁
牙式
刀柄

侧铣槽铣
有孔
粗铣加工
LPMT
SPMT

切削形态: ● 稳定切削 Stable Cutting ● 一般切削 General Cutting ⊕ 不稳定切削 Unstable Cutting

P	钢	Steel	●●●●●●●●
M	不锈钢	Stainless Steel	●●●●●●●●
K	铸铁	Iron	●●●●●●●●
N	铝/铜/镁/锌/塑料/木材	Aluminum/Copper/Magnesium/Zinc/Plastic/Wood	●●●●●●●●
S	硬质合金/粉末冶金	Carbide/Powder Metallurgy	●●●●●●●●
H	钛/高温合金/碳纤维	Titanium/Superalloy/Carbon Fiber	●●●●●●●●

刀杆
刀盘

用途	产品图片	几何尺寸	规格型号	尺寸 Dimension (mm)				配套刀柄	适用材料
				r _ε	A	B	T		
直角肩 立铣刀			APKT 150412-PM	1.2	16.33	12.7	4.76	刀柄: (Toolholder) D53-D54	●●●●
			150412-KM	1.2	16.33	12.7	4.76		
LPMT 150412-PM	1.2	16.33	12.7	4.76	●●●●				
150412-KM	1.2	16.33	12.7	4.76					
圆角 铣刀			SPMT 120408-PM	0.8	12.7	12.7	4.76	刀柄: (Toolholder) D53-D54	●●●●
			120408-KM	0.8	12.7	12.7	4.76		

直角肩
立铣刀

圆角
铣刀

球头
铣刀

钻铣
刀杆

倒角
刀杆

玉米
铣刀

三
面刃
槽刀

快
进给
系列

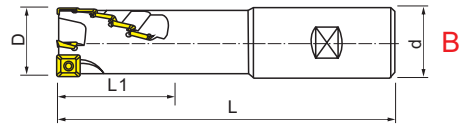
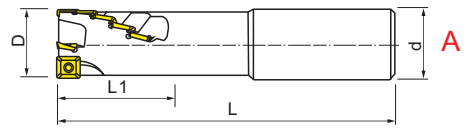
龙门
平面
铣刀

锁
牙式
刀柄

SPM 玉米立铣刀杆

SPM Corn End Mill

切削参数 (Cutting Parameters): D51
零配件 (Spare Parts): P01-P04



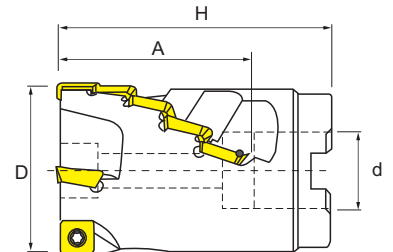
- 高效能型粗铣刀, 能加工深孔。
- 尺寸可由刀杆随意变换深度, 发挥最大效能。
- ★ High-performance-based rough milling, deep hole can be processed.
- ★ Arbor size can be arbitrarily change the depth of maximum efficiency.

型号 Cat. No	尺寸 Size				图示 Figure	刃数 No. of flutes	刀片 Insert				螺钉 Screw	扳手 Wrench	Stock	Order Number	Price (RMB)
	D	d	L1	L			T		T						
SPM-32-120-40-C32	32	32	40	120	A	3				M4	T15	●	334600	1200	
SPM-32-150-40-C32	32	32	40	150	A	3			SCMT09T304			●	334602	1300	
SPM-38-120-40-C32	38	32	40	120	A	3				M4	T15	●	334604	1400	
SPM-38-150-40-C32	38	32	40	150	A	3			SCMT09T308			●	334606	1500	
SPM-40-150-50L-32	40	32	50	150	A	4	2	P27215-3	12	SDMT090308	M4	T15	●	334608	1600
SPM-40-170-56L-C42	40	42	56	170	B	2	1	LPMT1504	15	SPMT1204	M5	T20	●	334610	1800
SPM-50-200-77L-C42	50	42	77	200	B	4	2	LPMT1504	14	SPMT1204	M5	T20	●	334612	2000
SPM-50-250-158-C42	50	42	158	250	B	4	2	LPMT1504	30	SPMT1204	M5	T20	●	334614	2200

SPC 玉米型粗铣刀盘

Corn Type Rough Milling Cutter

切削参数 (Cutting Parameters): D51
零配件 (Spare Parts): P01-P04



- 高效能型粗铣刀, 能加工深孔。
- 尺寸可由刀杆随意变换深度, 发挥最大效能。
- ★ High-performance-based rough milling, deep hole can be processed.
- ★ Arbor size can be arbitrarily change the depth of maximum efficiency.

型号 Cat. No	尺寸 Size					刀片 Insert				螺钉 Screw	扳手 Wrench	Stock	Order Number	Price (RMB)
	D	d	A	H	刃数T		T		T					
SPC-80-31.75-80L	80	31.75	67	80	6	LPMT1504	3	SPMT1204	18	M5	T20	●	334400	3200
SPC-80-32-80L	80	32	67	80	6							●	334402	3200
SPC-100-40-100L	100	40	77	100	8	LPMT1504	4	SPMT1204	24	M5	T20	●	334404	4500

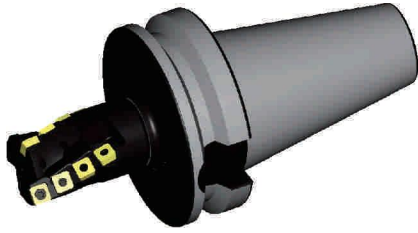
玉米铣刀

机夹式粗加工用铣刀 Milling cutter for rough machining

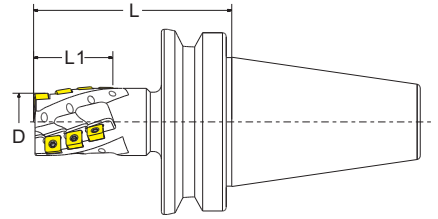
SPC 整体式玉米型粗铣刀

SPC Integral Type Maize Rough Milling Cutter

切削参数 (Cutting Parameters): D51
零配件 (Spare Parts): P01-P04



- 整体式结构, 切削刚性更好!
- 多种切深长度, 灵活选择。
- ★ The overall structure, cutting better rigidity!
- ★ A variety of cutting length, flexible choice.



配件(Accessory):
刀片: LPMT1504..
SPMT1204..
螺钉: M5X12
扳手: T20

订购编码 Order	规格型号 Specification	Dimensions			刀片数 T	刃数 Edge	价格 Price
		D	L1	L			
334214	BT40-SPC40-60	40	60	107		4	8000
334216	BT40-SPC50-60	50	60	117		4	8000
334218	BT50-SPC50-60	50	60	138		4	9000
334220	BT50-SPC63-80	63	80	153		4	9000
334222	BT50-SPC80-120	80	120	188		4	10000
334224	BT50-SPC80-150	80	150	203		4	11000

刀杆
刀盘

直角
台肩
立
铣刀

圆角
铣刀

球头
铣刀

钻铣
刀杆

倒角
刀杆

玉米
铣刀

三
面刃
槽刀

快
进给
系列

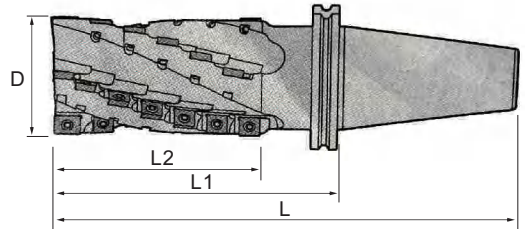
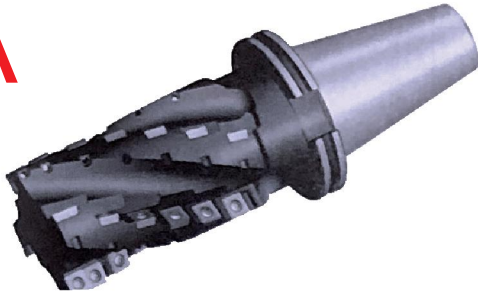
龙
门
平
面
铣
刀

锁
牙
式
刀
柄

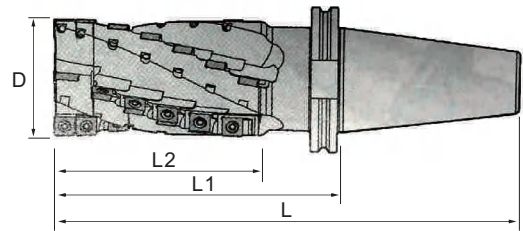
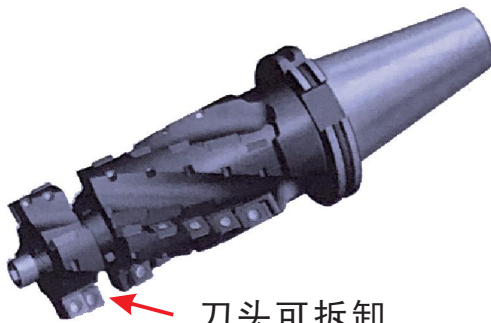
HMP01 整体式玉米型粗铣刀

HMP01 Integral Type Maize Rough Milling Cutter

A



B



刀头可拆卸
Detachable head

切削参数 (Cutting Parameters): D51
零配件 (Spare Parts): P01-P04

型号 Cat. No	尺寸 Size				图示 Figure	槽数 Edges	刀片 Insert				螺钉 Screw	扳手 Wrench	Order Number	Price (RMB)
	D	L2	L1	L			T		T					
HMP01- 050-84-BT50-SP12	50	84	145	246	A	4	2		16				334620	9000
063-74-BT50-SP12	63	74	135	236	A	4	2		14				334622	9000
063-104-BT50-SP12	63	104	165	266	A	4	2	AKPT1504	20	SPMT1204	M5x13	T20	334624	9000
063-134-BT50-SP12	63	134	195	296	A	4	2		26				334626	10000
080-104-BT50-SP12	80	104	165	266	A	4	2		20				334628	10000
080-144-BT50-SP12	80	144	205	306	A	4	2		28				334630	12000
HMP01- 050-84EC-BT50-SP12	50	84	145	246	B	4	2		16				334632	10000
063-74EC-BT50-SP12	63	74	135	236	B	4	2		14				334634	10000
063-104EC-BT50-SP12	63	104	165	266	B	4	2	AKPT1504	20	SPMT1204	M5x13	T20	334635	12000
063-134EC-BT50-SP12	63	134	195	296	B	4	2		26				334636	13000
080-104EC-BT50-SP12	80	104	165	266	B	4	2		20				334637	12000
080-144EC-BT50-SP12	80	144	205	306	B	4	2		28				334639	13000