

HSS

CARBIDE



COUNTERSINKS

C1119 SERIES

C2119 SERIES

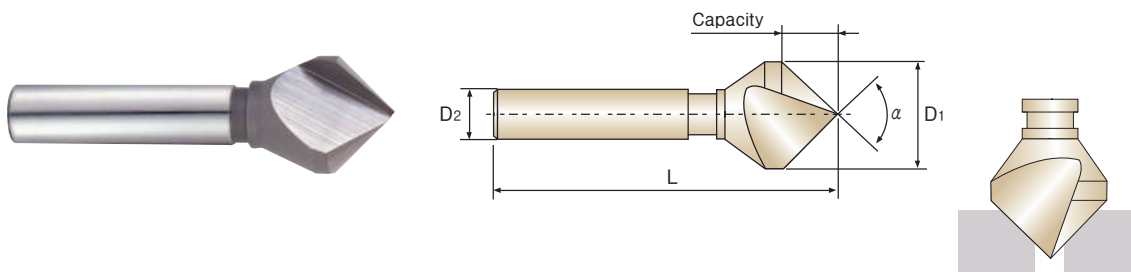
C3119 SERIES

高速钢单刃倒角刀具

HSS SINGLE FLUTE CHAMFERING CUTTERS

- ▶ 用于木头和硬塑料
- ▶ 可以在薄板上钻孔
- ▶ 容易再研磨
- ▶ 加工时没有振动

- ▶ For wood and hard plastics.
- ▶ Can drill in sheet materials.
- ▶ Easy to resharpen.
- ▶ Works without vibrations.



单位(Unit) : mm

型号 EDP No. (uncoating)			角度 Angle	刃部直径 Nominal Diameter	柄部直径 Shank Diameter	全长 Overall Length	生产量 Capacity
HSSCo8	HSS-E	HSS	α (-1°)	D ₁	D ₂	L(±1)	min/max
C1119100	C2119100	C3119100	90°	10.0	6	45	1 - 10
C1119150	C2119150	C3119150	90°	15.0	8	55	2 - 15
C1119200	C2119200	C3119200	90°	20.0	10	65	2 - 20
C1119250	C2119250	C3119250	90°	25.0	12	78	3 - 25
C1119300	C2119300	C3119300	90°	30.0	12	88	3 - 30
C1119350	C2119350	C3119350	90°	35.0	16	110	4 - 35
C1119400	C2119400	C3119400	90°	40.0	16	115	5 - 40
C1119450	C2119450	C3119450	90°	45.0	16	120	10 - 45
C1119500	C2119500	C3119500	90°	50.0	16	130	12 - 50

- ▶ TiN&TiCN涂层可根据您的要求加工
TiN & TiCN coating are available on your request.

刃部公差 Nominal Dia. Tolerance(mm)	柄部公差 Shank Dia. Tolerance
+0.3	h9

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推荐的切削条件

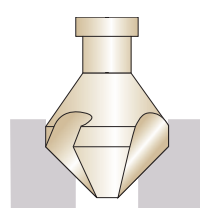
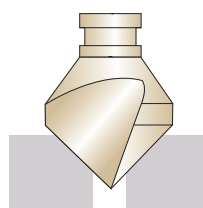
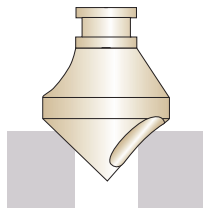
RECOMMENDED CUTTING CONDITIONS

REAMERS

COUNTER
SINKS

COUNTER
BORES

ROTARY
BURRS



材质 Material	V	S			V	S			V	S		
		Ø ≤ 10	Ø ≤ 20	Ø ≤ 30		Ø ≤ 10	Ø ≤ 20	Ø ≤ 30		Ø ≤ 10	Ø ≤ 20	Ø ≤ 30
钢 ≤ 500N/mm ² Steels ≤ 500N/mm ²	35-45	0.20	0.22	0.24	35-45	0.20	0.22	0.24	17-22	0.30	0.32	0.36
钢 500-800N/mm ² Steels 500~800N/mm ²	20-30	0.14	0.17	0.20	20-30	0.14	0.17	0.20	10-15	0.28	0.30	0.31
钢 800-1000N/mm ² Steels 800~1000N/mm ²	15-20	0.11	0.12	0.14	15-20	0.11	0.12	0.14	8-12	0.24	0.26	0.28
钢-不锈钢 1000-1300N/mm ² Steels-Stainless Steel 1000~1300N/mm ²	12-15	0.10	0.12	0.15	12-15	0.10	0.12	0.15	6-8	0.20	0.20	0.22
不锈钢 Stainless Steels	6-8	0.07	0.08	0.09	6-8	0.07	0.08	0.09	4-6	0.08	0.09	0.10
铸铁 Cast Iron	20-40	0.15	0.24	0.28	20-40	0.15	0.24	0.28	15-25	0.13	0.19	0.24
铝 Aluminum	50-60	0.22	0.25	0.27	50-60	0.22	0.25	0.27	35-45	0.27	0.30	0.35
黄铜-青铜 Brass-Bronze	30-40	0.23	0.25	0.28	30-40	0.23	0.25	0.28	20-30	0.30	0.30	0.31
铜 Copper	20-30	0.22	0.25	0.27	20-30	0.22	0.25	0.27	10-15	0.29	0.30	0.31
塑料 Plastics	50-100	0.50	0.60	0.65	50-100	0.50	0.60	0.65	35-70	0.40	0.45	0.50

V: 切削速度, Cutting Speed(m/min)
S: 每转进给, Feed per Revolution(mm/rev)