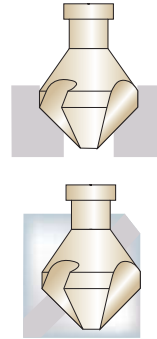
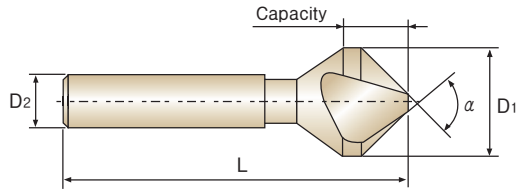


高速钢3刃沉孔刀

HSS THREE FLUTE COUNTERSINKS

- ▶ 自定心(3槽)
- ▶ 为90°螺帽钉做埋头孔而设计的
- ▶ 手用
- ▶ 纵向倒角和作等值线
- ▶ 加工时没有振动

- ▶ Self-centering(3 flutes).
- ▶ Designed for 90° capscrews countersinking.
- ▶ Hand using.
- ▶ Longitudinal chamfers and contouring.
- ▶ Works without vibrations


DIN 335C

REAMERS

COUNTER SINKS

COUNTER BORES

ROTARY BURRS

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°)	D1	D2	L(±1)	min/max
C1139043	C2139043	C3139043	90°	4.3	4	40	1.3 - 4.3
C1139050	C2139050	C3139050	90°	5.0	4	40	1.5 - 5
C1139060	C2139060	C3139060	90°	6.0	5	45	1.5 - 6
C1139063	C2139063	C3139063	90°	6.3	5	45	1.5 - 6.3
C1139070	C2139070	C3139070	90°	7.0	6	50	1.8 - 7
C1139080	C2139080	C3139080	90°	8.0	6	50	2 - 8
C1139083	C2139083	C3139083	90°	8.3	6	50	2 - 8.3
C1139100	C2139100	C3139100	90°	10.0	6	50	2.5 - 10
C1139104	C2139104	C3139104	90°	10.4	6	50	2.5 - 10.4
C1139115	C2139115	C3139115	90°	11.5	8	56	2.8 - 11.5
C1139124	C2139124	C3139124	90°	12.4	8	56	2.8 - 12.4
C1139150	C2139150	C3139150	90°	15.0	10	60	3.2 - 15
C1139165	C2139165	C3139165	90°	16.5	10	60	3.2 - 16.5
C1139190	C2139190	C3139190	90°	19.0	10	63	3.5 - 19
C1139205	C2139205	C3139205	90°	20.5	10	63	3.5 - 20.5
C1139230	C2139230	C3139230	90°	23.0	10	67	3.8 - 23
C1139250	C2139250	C3139250	90°	25.0	10	67	3.8 - 25
C1139300	C2139300	C3139300	90°	30.0	12	71	4.2 - 30
C1139310	C2139310	C3139310	90°	31.0	12	71	4.2 - 31

- ▶ 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
±0.05	h9

HSS

CARBIDE



COUNTERSINKS

推荐的切削条件

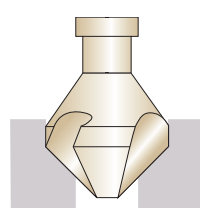
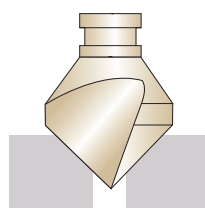
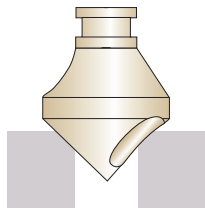
RECOMMENDED CUTTING CONDITIONS

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)