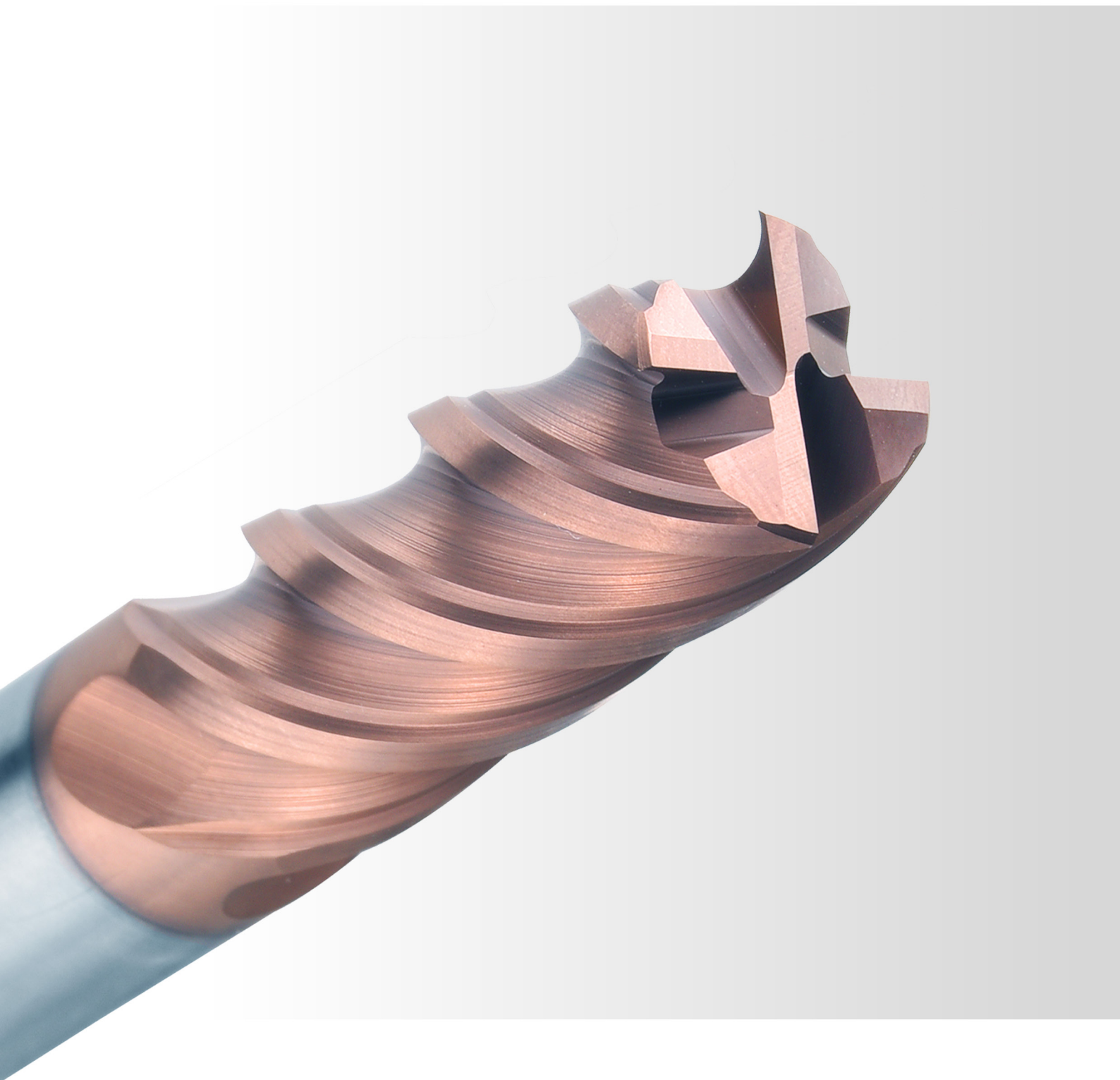




鳳之翼

产品目录

PRODUCT CATALOGUE



铣刀
End mills

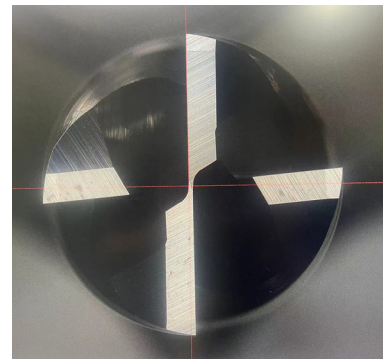
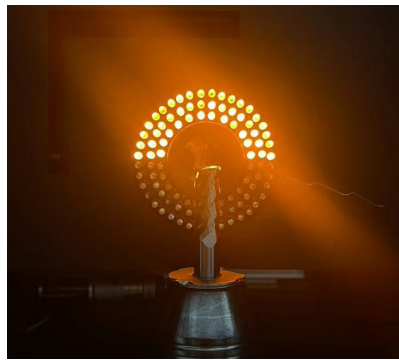
钻头
Drills

铰刀
Reamers

定制
Customization

公司介绍

Company Introduction



苏州风之翼精密切削技术有限公司，是一家以专业化的硬质合金刀具的生产、销售和服务为一体的综合性企业，风之翼公司拥有以德国进口的五轴联动、六轴联动 CNC 磨床、高精度螺纹磨床为代表的各种先进的生产设备，及德国进口全自动万能刀具测量仪、刀具投影仪等进口测量设备，来确保刀具的精密度和质量的稳定性。

主要产品是硬质合金钻头、铰刀、铣刀、复杂成型非标刀具。公司以降低客户刀具加工成本为目的，为客户提供整体的刀具解决方案的服务理念。主要客户是汽车、航空、船舶、军工、医疗、减速机、能源、风电、模具、机床等精密制造业中的高端用户。

质量是企业的基石

Quality is the cornerstone of an enterprise

Suzhou Phoenix Wing Precision Cutting Technology Co., Ltd. is a comprehensive enterprise specializing in the production, sales, and service of carbide cutting tools.

The company boasts advanced production equipment, including German-imported five-axis and six-axis CNC grinding machines, high-precision thread grinding machines, and other state-of-the-art machinery. To ensure the precision and stability of tool quality, we also utilize German-imported fully automatic universal tool measurement instruments and tool projectors.

Our main products include hard metal drill bits, reamers, end mills, and complex non-standard tools. The company aims to reduce customers' tool processing costs and provides integrated tool solution services. Our primary clients are high-end users in precision manufacturing industries such as automotive, aerospace, shipping, military, medical, reducers, energy, wind power, molds, and machine tools.



简介表

Guide lines



硬质合金
Solid carbide milling tools



可加工 HRC 硬度小于等于 HRC65° 的材料
Can be used to process hrc less than 65 materials



超级涂层
High temperature resistant coating for high hard materials



钢用涂层
Coatings for steel materials



软钢用涂层
Coatings for mild steel materials



不锈钢用涂层
Coatings for stainless steel materials



铝用涂层
Coatings for aluminium



2 刃
2-flute



3 刃
3-flute



4 刃
4-flute



5 刃
5-flute



6 刃
6-flute



钻头钻孔深度可以达到直径的 3 倍
The drilling depth can be up to 3 times the diameter of the drill bit



钻头钻孔深度可以达到直径的 5 倍
The drilling depth can be up to 5 times the diameter of the drill bit



钻头钻孔深度可以达到直径的 8 倍
The drilling depth can be up to 8 times the diameter of the drill bit



R 角
Corner radius



C 角
Corner Chamfer

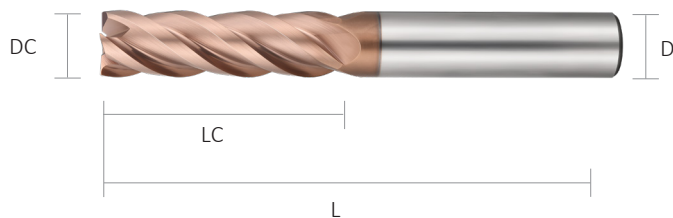
目录

Chapter Overview

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不锈钢用立铣刀 End Mills for Stainless Steel	015
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铝用立铣刀 End Mills for Aluminium	027
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FS510.610

- 高硬加工 -For high hardness materials
- 耐高温 -High temperature resistance
- 适用性强 -Strong applicability
- 标准产品 -Standard tools
- 精加工和粗加工 -Rough milling, finish-milling
- 不等分 4 刃 -Unequal division 4-flute



适合加工的材料

Suitable for materials

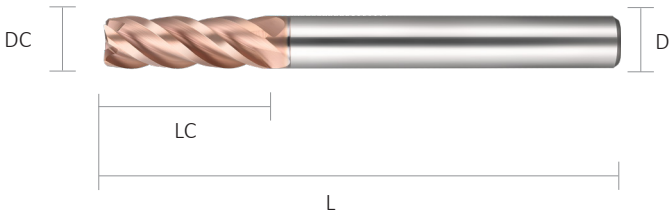


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D2*5*50L*SD4*4T	2	5	50	4
D2.5*6.5*50L*SD4*4T	2.5	6.5	50	4
D3*7.5*50L*SD4*4T	3	7.5	50	4
D4*10*50L*SD4*4T	4	10	50	4
D5*12.5*50L*SD6*4T	5	12.5	50	6
D6*15*50L*SD6*4T	6	15	50	6
D7*20*60L*SD6*4T	7	20	60	6
D8*20*60L*SD8*4T	8	20	60	8
D9*25*75L*SD10*4T	9	25	75	10
D10*25*75L*SD10*4T	10	25	75	10
D11*30*75L*SD12*4T	11	30	75	12
D12*30*75L*SD12*4T	12	30	75	12
D14*35*100L*SD14*4T	14	35	100	14
D16*40*100L*SD16*4T	16	40	100	16
D18*50*100L*SD18*4T	18	50	100	18
D20*50*100L*SD20*4T	20	50	100	20

FS511.610

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适合加工的材料

Suitable for materials

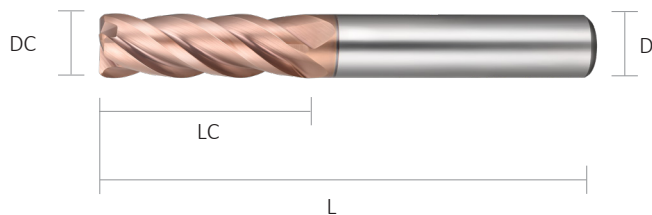


规格型号 Order code

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D4*15*100L*SD4*4T	4	15	100	4
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D6*20*75L*SD6*4T	6	20	75	6
D7*20*75L*SD8*4T	7	20	75	8
D8*20*75L*SD8*4T	8	20	75	8
D8*25*100L*SD8*4T	8	25	100	8
D9*25*100L*SD10*4T	9	25	100	10
D10*30*100L*SD10*4T	10	30	100	10
D11*30*100L*SD12*4T	11	30	100	12
D12*35*100L*SD12*4T	12	35	100	12
D14*40*150L*SD14*4T	14	40	150	14
D16*50*150L*SD16*4T	16	50	150	16
D18*55*150L*SD18*4T	18	55	150	18
D20*60*150L*SD20*4T	20	60	150	20

FS510.620

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- R 角 -Corner radius



适合加工的材料

Suitable for materials

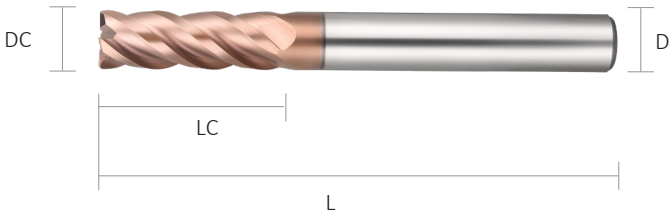


规格型号 Order code

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D2R0.2*5*50L*SD4*4T	R0.2	2	5	50	4
D2.5R0.2*6.5*50L*SD4*4T	R0.2	2.5	6.5	50	4
D3R0.2*7.5*50L*SD4*4T	R0.2	3	7.5	50	4
D4*R0.2*10*50L*SD4*4T	R0.2	4	10	50	4
D4*R0.5*10*50L*SD4*4T	R0.5	4	10	50	4
D4*R1*10*50L*SD4*4T	R1	4	10	50	4
D6*R0.2*15*50L*SD6*4T	R0.2	6	15	50	6
D6*R0.5*15*50L*SD6*4T	R0.5	6	15	50	6
D6*R1*15*50L*SD6*4T	R1	6	15	50	6
D8*R0.2*20*60L*SD8*4T	R0.2	8	20	60	8
D8*R0.5*20*60L*SD8*4T	R0.5	8	20	60	8
D8*R1*20*60L*SD8*4T	R1	8	20	60	8
D10*R0.5*25*75L*SD10*4T	R0.5	10	25	75	10
D10*R1*25*75L*SD10*4T	R1	10	25	75	10
D12*R0.5*30*75L*SD12*4T	R0.5	12	30	75	12
D12*R1*30*75L*SD12*4T	R1	12	50	75	12

FS511.620

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- 不等分 4 刃 -Unequal division 4-flute
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适合加工的材料

Suitable for materials

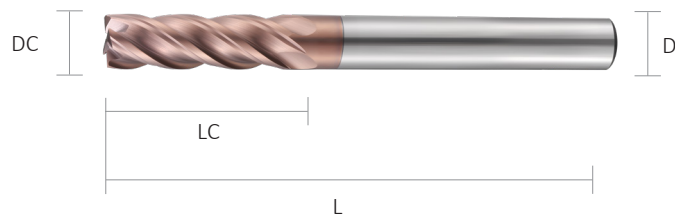


规格型号 Order code

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D6*R0.5*20*75L*SD6*4T	R0.5	6	20	75	6
D6*R1*20*75L*SD6*4T	R1	6	20	75	6
D6*R0.5*20*100L*SD6*4T	R0.5	6	20	100	6
D6*R1*20*100L*SD6*4T	R1	6	20	100	6
D8*R0.5*25*75L*SD8*4T	R0.5	8	25	75	8
D8*R1*25*75L*SD8*4T	R1	8	25	75	8
D8*R0.5*25*100L*SD8*4T	R0.5	8	25	100	8
D8*R1*25*100L*SD8*4T	R1	8	25	100	8
D10*R0.5*30*100L*SD10*4T	R0.5	10	30	100	10
D10*R1*30*100L*SD10*4T	R1	10	30	100	10
D12*R0.5*36*100L*SD12*4T	R0.5	12	36	100	12
D12*R1*36*100L*SD12*4T	R1	12	36	100	12

FS-S510.610

- FS 系列升级版
 - 标准产品
 - 提升抗崩抗震
 - 提升排屑
 - 不等分 4 刃
- Advanced end mills of FS series
 - Standard tools
 - Higher anti-broken level
 - Higher-chipping removal
 - Unequal division 4-flute



适合加工的材料

Suitable for materials

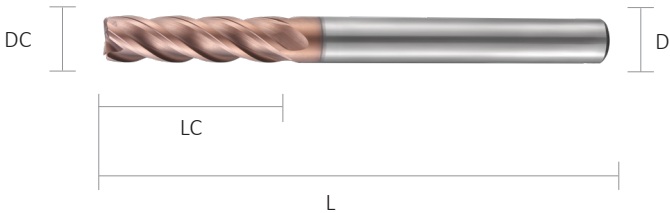


规格型号 Order code

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D1.5*4*50L*SD4*4T	1.5	4	50	4
D2*5*50L*SD4*4T	2	5	50	4
D2.5*6.5*50L*SD4*4T	2.5	6.5	50	4
D3*7.5*50L*SD4*4T	3	7.5	50	4
D4*10*50L*SD4*4T	4	10	50	4
D5*12.5*50L*SD6*4T	5	12.5	50	6
D6*15*50L*SD6*4T	6	15	50	6
D7*20*60L*SD6*4T	7	20	60	6
D8*20*60L*SD8*4T	8	20	60	8
D9*25*75L*SD10*4T	9	25	75	10
D10*25*75L*SD10*4T	10	25	75	10
D11*30*75L*SD12*4T	11	30	100	12
D12*30*75L*SD12*4T	12	30	100	12
D14*40*100L*SD14*4T	14	40	100	14
D16*40*100L*SD16*4T	16	40	100	16
D18*50*100L*SD18*4T	18	50	100	18
D20*50*100L*SD20*4T	20	50	100	20

FS-S511.610

- FS 系列升级版
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 - 提升排屑
 - 不等分 4 刃
- Advanced end mills of FS series
 - Standard tools
 - Higher anti-broken level
 - Higher-chipping removal
 - unequal division 4-flute



适合加工的材料

Suitable for materials

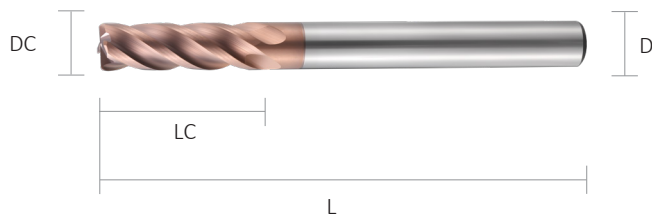


规格型号 Order code

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D6*20*75L*SD6*4T	6	20	75	6
D7*20*75L*SD8*4T	7	20	75	8
D8*20*75L*SD8*4T	8	20	75	8
D8*25*100L*SD8*4T	8	25	100	8
D9*25*100L*SD10*4T	9	25	100	10
D10*30*100L*SD10*4T	10	30	100	10
D11*36*100L*SD12*4T	11	36	100	12
D12*36*100L*SD12*4T	12	36	100	12
D14*50*150L*SD14*4T	14	50	150	14
D16*50*150L*SD16*4T	16	50	150	16
D18*55*150L*SD18*4T	18	55	150	18
D20*60*150L*SD20*4T	20	60	150	20

FS-S510.620

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 - Standard tools
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 - Higher-chipping removal
 - Unequal division 4-flute
 - Corner radius



适合加工的材料

Suitable for materials

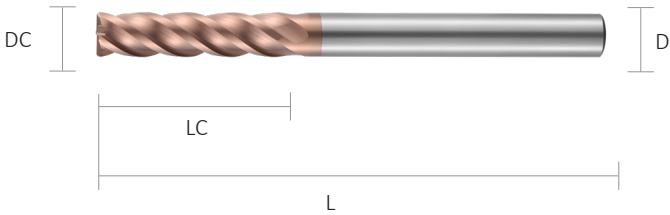


规格型号 Order code

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D2R0.2*5*50L*SD4*4T	R0.2	2	5	50	4
D2.5R0.2*6.5*50L*SD4*4T	R0.2	2.5	6.5	50	4
D3R0.2*7.5*50L*SD4*4T	R0.2	3	7.5	50	4
D4*R0.2*10*50L*SD4*4T	R0.2	4	10	50	4
D4*R0.5*10*50L*SD4*4T	R0.5	4	10	50	4
D4*R1*10*50L*SD4*4T	R1	4	10	50	4
D6*R0.2*15*50L*SD6*4T	R0.2	6	15	50	6
D6*R0.5*15*50L*SD6*4T	R0.5	6	15	50	6
D6*R1*15*50L*SD6*4T	R1	6	15	50	6
D8*R0.2*20*60L*SD8*4T	R0.2	8	20	60	8
D8*R0.5*20*60L*SD8*4T	R0.5	8	20	60	8
D8*R1*20*60L*SD8*4T	R1	8	20	60	8
D10*R0.5*25*75L*SD10*4T	R0.5	10	25	75	10
D10*R1*25*75L*SD10*4T	R1	10	25	75	10
D12*R0.5*30*75L*SD12*4T	R0.5	12	30	75	12
D12*R1*30*75L*SD12*4T	R1	12	50	75	12

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适合加工的材料

Suitable for materials

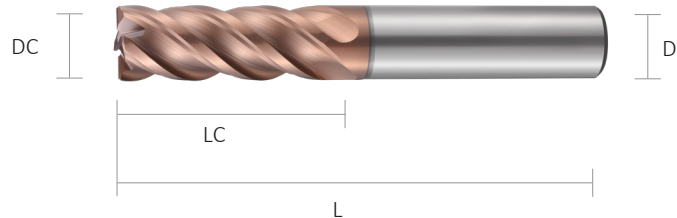


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D6*R0.5*20*75L*SD6*4T	R0.5	6	20	75	6
D6*R1*20*75L*SD6*4T	R1	6	20	75	6
D6*R0.5*20*100L*SD6*4T	R0.5	6	20	100	6
D6*R1*20*100L*SD6*4T	R1	6	20	100	6
D8*R0.5*25*75L*SD8*4T	R0.5	8	25	75	8
D8*R1*25*75L*SD8*4T	R1	8	25	75	8
D8*R0.5*25*100L*SD8*4T	R0.5	8	25	100	8
D8*R1*25*100L*SD8*4T	R1	8	25	100	8
D10*R0.5*30*100L*SD10*4T	R0.5	10	30	100	10
D10*R1*30*100L*SD10*4T	R1	10	30	100	10
D12*R0.5*36*100L*SD12*4T	R0.5	12	36	100	12
D12*R1*36*100L*SD12*4T	R1	12	36	100	12

FS-C510.610

- FS 系列升级版
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 - 提升排屑
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 - C 角
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 - Standard tools
 - Higher anti-broken level
 - Higher-chipping removal
 - Unequal division 4-flute
 - Corner Chamfer



适合加工的材料

Suitable for materials

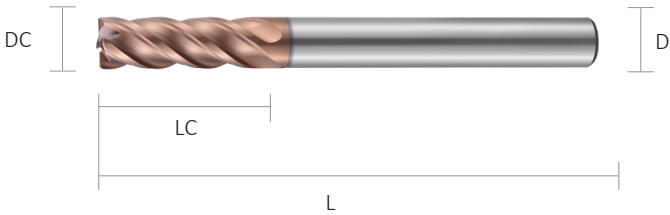


规格型号 Order code

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D4*C0.15*10*50L*SD4*4T	C0.15	4	10	50	4
D5*C0.15*12.5*50L*SD6*4T	C0.15	5	12.5	50	6
D6*C0.25*15*50L*SD6*4T	C0.25	6	15	50	6
D8*C0.25*20*60L*SD8*4T	C0.25	8	20	60	8
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D12*C0.35*30*75L*SD12*4T	C0.35	12	30	75	12
D14*C0.35*40*100L*SD14*4T	C0.35	14	40	100	14
D16*C0.5*40*100L*SD16*4T	C0.5	16	40	100	16
D18*C0.5*50*100L*SD18*4T	C0.5	18	50	100	18
D20*C0.5*50*100L*SD20*4T	C0.5	20	50	100	20

FS-C511.610

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适合加工的材料

Suitable for materials

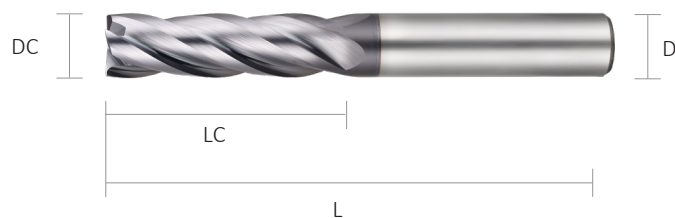


规格型号 Order code

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D4*C0.15*15*100L*SD4*4T	C0.15	4	15	100	4
D5*C0.15*15*75L*SD6*4T	C0.15	5	15	75	6
D5*C0.15*15*100L*SD6*4T	C0.15	5	15	100	6
D6*C0.25*20*75L*SD6*4T	C0.25	6	20	75	6
D6*C0.25*20*100L*SD6*4T	C0.25	6	20	100	6
D8*C0.25*20*75L*SD8*4T	C0.25	8	20	75	8
D8*C0.25*25*100L*SD8*4T	C0.25	8	25	100	8
D10*C0.25*30*100L*SD10*4T	C0.25	10	30	100	10
D12*C0.35*36*100L*SD12*4T	C0.35	12	36	100	12
D14*C0.35*50*150L*SD14*4T	C0.35	14	50	150	14
D16*C0.5*50*150L*SD16*4T	C0.5	16	50	150	16
D18*C0.5*55*150L*SD18*4T	C0.5	18	55	150	18
D20*C0.5*60*150L*SD20*4T	C0.5	20	60	150	20

FQ310.610

- 用于加工不锈钢
 - 标准产品
 - 粗加工和精加工
 - 不等分 4 刃
- For stainless steel
 - Standard tools
 - Rough milling, finish-milling
 - Unequal division 4-flute



适合加工的材料

Suitable for materials

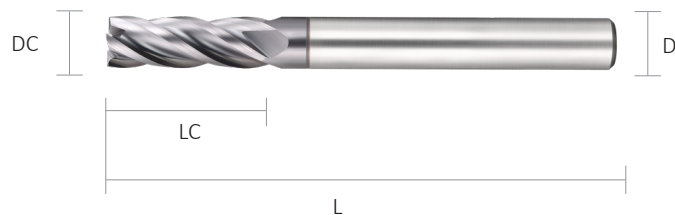


规格型号 Order code

	Dc 0-0.02	Lc	L	D
D1*3*50L*SD4*4T	1	3	50	4
D1.5*4*50L*SD4*4T	1.5	4	50	4
D2*5*50L*SD4*4T	2	5	50	4
D2.5*6.5*50L*SD4*4T	2.5	6.5	50	4
D3*7.5*50L*SD4*4T	3	7.5	50	4
D4*10*50L*SD4*4T	4	10	50	4
D4*12*50L*SD4*4T	4	12	50	4
D5*12.5*50L*SD6*4T	5	12.5	50	6
D5*15*50L*SD6*4T	5	15	50	6
D6*15*50L*SD6*4T	6	15	50	6
D6*18*50L*SD6*4T	6	18	50	8
D8*20*60L*SD8*4T	8	20	60	8
D8*24*60L*SD8*4T	8	24	60	8
D10*25*75L*SD10*4T	10	25	75	10
D10*30*75L*SD10*4T	10	30	75	10
D12*30*75L*SD12*4T	12	30	75	12
D12*36*75L*SD12*4T	12	36	75	12
D14*40*100L*SD14*4T	14	40	100	14
D16*45*100L*SD16*4T	16	50	100	16
D18*45*100L*SD18*4T	18	50	100	18
D20*50*100L*SD20*4T	20	50	100	20

FQ311.610

- 用于加工不锈钢
 - 标准产品
 - 粗加工和精加工
 - 不等分 4 刃
- For stainless steel
 - Standard tools
 - Rough milling, finish-milling
 - Unequal division 4-flute



适合加工的材料

Suitable for materials

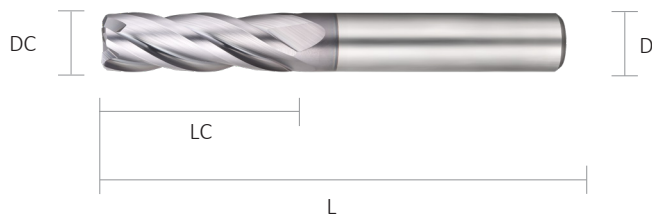


规格型号 Order code

	Dc 0-0.02	Lc	L	D
D4*15*75L*SD4*4T	4	15	75	4
D4*15*100L*SD4*4T	4	15	100	4
D5*15*100L*SD6*4T	5	15	100	6
D6*20*75L*SD6*4T	6	20	75	6
D6*20*100L*SD6*4T	6	20	100	6
D8*20*75L*SD8*4T	8	20	75	8
D8*25*100L*SD8*4T	8	25	100	8
D9*25*100L*SD10*4T	9	25	100	10
D10*30*100L*SD10*4T	10	30	100	10
D12*36*100L*SD12*4T	11	36	100	12
D12*36*100L*SD12*4T	12	36	100	12
D14*40*150L*SD14*4T	14	40	150	14
D16*50*150L*SD16*4T	16	50	150	16
D18*55*150L*SD18*4T	18	55	150	18
D20*60*150L*SD20*4T	20	60	150	20

FQ310.620

- 用于加工不锈钢
 - 标准产品
 - 粗加工和精加工
 - 不等分 4 刃
 - R 角
- For stainless steel
 - Standard tools
 - Rough milling, finish-milling
 - Unequal division 4-flute
 - Corner radius



适合加工的材料

Suitable for materials

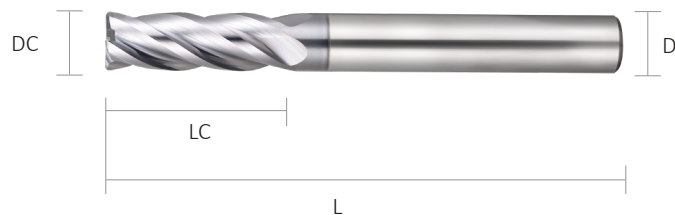


规格型号 Order code

	R	Dc 0-0.02	Lc	L	D
D1R0.2*3*50L*SD4*4T	R0.2	1	3	50	4
D1.5R0.2*4*50L*SD4*4T	R0.2	1.5	4	50	4
D2R0.2*5*50L*SD4*4T	R0.2	2	5	50	4
D2.5R0.2*6.5*50L*SD4*4T	R0.2	2.5	6.5	50	4
D3R0.2*7.5*50L*SD4*4T	R0.2	3	7.5	50	4
D4*R0.2*10*50L*SD4*4T	R0.2	4	10	50	4
D4*R0.5*10*50L*SD4*4T	R0.5	4	10	50	4
D4*R1*10*50L*SD4*4T	R1	4	10	50	4
D6*R0.2*15*50L*SD6*4T	R0.2	6	15	50	6
D6*R0.5*15*50L*SD6*4T	R0.5	6	15	50	6
D6*R1*15*50L*SD6*4T	R1	6	15	50	6
D8*R0.2*20*60L*SD8*4T	R0.2	8	20	60	8
D8*R0.5*20*60L*SD8*4T	R0.5	8	20	60	8
D8*R1*20*60L*SD8*4T	R1	8	20	60	8
D10*R0.5*25*75L*SD10*4T	R0.5	10	25	75	10
D10*R1*25*75L*SD10*4T	R1	10	25	75	10
D12*R0.5*30*75L*SD12*4T	R0.5	12	30	75	12
D12*R1*30*75L*SD12*4T	R1	12	30	75	12

FQ311.620

- 用于加工不锈钢 -For stainless steel
- 标准产品 -Standard tools
- 粗加工和精加工 -Rough milling, finish-milling
- 不等分 4 刃 -Unequal division 4-flute
- R 角 -Corner radius



适合加工的材料

Suitable for materials

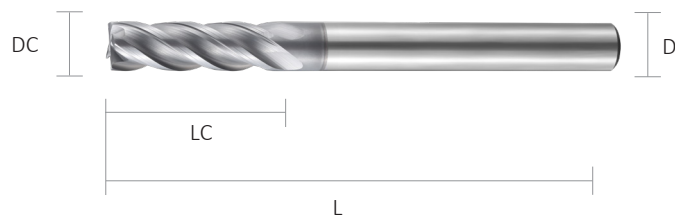


规格型号 Order code

	R	Dc 0-0.02	Lc	L	D
D4*R0.5*12*75L*SD4*4T	R0.5	4	12	75	4
D4*R0.5*12*100L*SD4*4T	R0.5	4	12	100	4
D6*R0.5*20*75L*SD6*4T	R0.5	6	20	75	6
D6*R1*20*75L*SD6*4T	R1	6	20	75	6
D6*R0.5*20*100L*SD6*4T	R0.5	6	20	100	6
D6*R1*20*100L*SD6*4T	R1	6	20	100	6
D8*R0.5*25*75L*SD8*4T	R0.5	8	25	75	8
D8*R1*25*75L*SD8*4T	R1	8	25	75	8
D8*R0.5*25*100L*SD8*4T	R0.5	8	25	100	8
D8*R1*25*100L*SD8*4T	R1	8	25	100	8
D10*R0.5*30*100L*SD10*4T	R0.5	10	30	100	10
D10*R1*30*100L*SD10*4T	R1	10	30	100	10
D12*R0.5*36*100L*SD12*4T	R0.5	12	36	100	12
D12*R1*36*100L*SD12*4T	R1	12	36	100	12

FG210.610

- 用于加工软钢 -For mild steel
- 标准产品 -Standard tools
- 粗加工和精加工 -Rough milling, finish-milling
- 不等分 4 刃 -Unequal division 4-flute



适合加工的材料

Suitable for materials



规格型号 Order code

	Dc 0-0.02	Lc	L	D
D1*3*50L*SD4*4T	1	3	50	4
D1.5*4*50L*SD4*4T	1.5	4	50	4
D2*5*50L*SD4*4T	2	5	50	4
D2.5*6.5*50L*SD4*4T	2.5	6.5	50	4
D3*7.5*50L*SD4*4T	3	7.5	50	4
D4*10*50L*SD4*4T	4	10	50	4
D4*12*50L*SD4*4T	4	12	50	4
D5*12.5*50L*SD6*4T	5	12.5	50	6
D5*15*50L*SD6*4T	5	15	50	6
D6*15*50L*SD6*4T	6	15	50	6
D6*18*50L*SD6*4T	6	18	50	8
D8*20*60L*SD8*4T	8	20	60	8
D8*24*60L*SD8*4T	8	24	60	8
D10*25*75L*SD10*4T	10	25	75	10
D10*30*75L*SD10*4T	10	30	75	10
D12*30*75L*SD12*4T	12	30	75	12
D12*30*75L*SD12*4T	12	30	75	12
D14*40*100L*SD14*4T	14	40	100	14
D16*50*100L*SD16*4T	16	50	100	16
D18*50*100L*SD18*4T	18	50	100	18
D20*50*100L*SD20*4T	20	50	100	20

高效软钢用圆鼻刀



FG210.620

- 用于加工软钢

- 标准产品

- 粗加工和精加工

- 不等分 4 刃

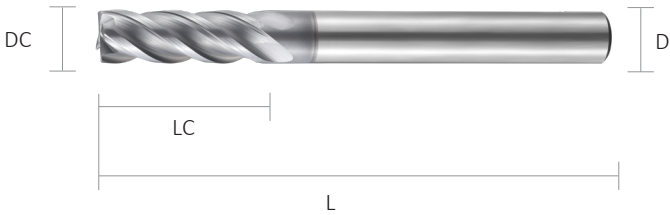
- R 角
- For mild steel

-Standard tools

-Rough milling, finish-milling

-Unequal division 4-flute

-Corner radius



适合加工的材料

Suitable for materials



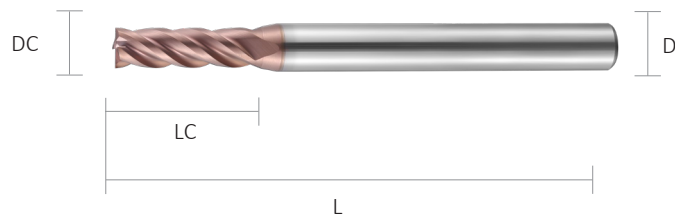
规格型号 Order code

	R	Dc 0-0.02	Lc	L	D
D1R0.2*3*50L*SD4*4T	R0.2	1	3	50	4
D1.5R0.2*4*50L*SD4*4T	R0.2	1.5	4	50	4
D2R0.2*5*50L*SD4*4T	R0.2	2	5	50	4
D2.5R0.2*6.5*50L*SD4*4T	R0.2	2.5	6.5	50	4
D3R0.2*7.5*50L*SD4*4T	R0.2	3	7.5	50	4
D4*R0.2*10*50L*SD4*4T	R0.2	4	10	50	4
D4*R0.5*10*50L*SD4*4T	R0.5	4	10	50	4
D4*R1*10*50L*SD4*4T	R1	4	10	50	4
D6*R0.2*15*50L*SD6*4T	R0.2	6	15	50	6
D6*R0.5*15*50L*SD6*4T	R0.5	6	15	50	6
D6*R1*15*50L*SD6*4T	R1	6	15	50	6
D8*R0.2*20*60L*SD8*4T	R0.2	8	20	60	8
D8*R0.5*20*60L*SD8*4T	R0.5	8	20	60	8
D8*R1*20*60L*SD8*4T	R1	8	20	60	8
D10*R0.5*25*75L*SD10*4T	R0.5	10	25	75	10
D10*R1*25*75L*SD10*4T	R1	10	25	75	10
D12*R0.5*30*75L*SD12*4T	R0.5	12	30	75	12
D12*R1*30*75L*SD12*4T	R1	12	30	75	12

FH210.610

- 用于加工钢件
- 标准产品
- 粗加工和精加工
- 不等分 4 刃

- For steel
- Standard tools
- Rough milling, finish-milling
- Unequal division 4-flute



适合加工的材料

Suitable for materials

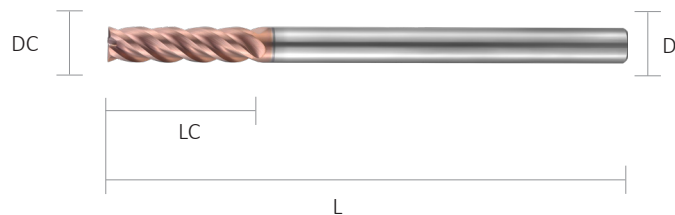


规格型号 Order code

	Dc 0-0.02	Lc	L	D
D1*3*50L*SD4*4T	1	3	50	4
D1.5*4*50L*SD4*4T	1.5	4	50	4
D2*5*50L*SD4*4T	2	5	50	4
D2.5*6.5*50L*SD4*4T	2.5	6.5	50	4
D3*7.5*50L*SD4*4T	3	7.5	50	4
D4*10*50L*SD4*4T	4	10	50	4
D4*12*50L*SD4*4T	4	12	50	4
D5*12.5*50L*SD6*4T	5	12.5	50	6
D5*15*50L*SD6*4T	5	15	50	6
D6*15*50L*SD6*4T	6	15	50	6
D6*18*50L*SD6*4T	6	18	50	8
D8*20*60L*SD8*4T	8	20	60	8
D8*24*60L*SD8*4T	8	24	60	8
D10*25*75L*SD10*4T	10	25	75	10
D10*30*75L*SD10*4T	10	30	75	10
D12*30*75L*SD12*4T	12	30	75	12
D12*36*75L*SD12*4T	12	36	75	12
D14*35*100L*SD14*4T	14	35	100	14
D16*45*100L*SD16*4T	16	45	100	16
D18*45*100L*SD18*4T	18	45	100	18
D20*50*100L*SD20*4T	20	50	100	20

FH211.610

- 用于加工钢件 -For steel
- 标准产品 -Standard tools
- 粗加工和精加工 -Rough milling, finish-milling
- 不等分 4 刃 -Unequal division 4-flute



适合加工的材料

Suitable for materials

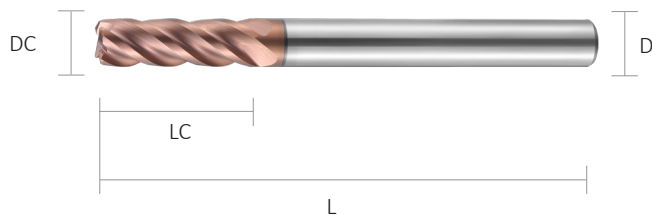


规格型号 Order code

	Dc 0-0.02	Lc	L	D
D4*15*75L*SD4*4T	4	15	75	4
D4*15*100L*SD4*4T	4	15	100	4
D5*15*100L*SD6*4T	5	15	100	6
D6*20*75L*SD6*4T	6	20	75	6
D6*20*100L*SD6*4T	6	20	100	6
D8*20*75L*SD8*4T	8	20	75	8
D8*25*100L*SD8*4T	8	25	100	8
D9*25*100L*SD10*4T	9	25	100	10
D10*30*100L*SD10*4T	10	30	100	10
D12*36*100L*SD12*4T	12	36	100	12
D12*36*100L*SD12*4T	12	36	100	12
D14*40*150L*SD14*4T	14	40	150	14
D16*50*150L*SD16*4T	16	50	150	16
D18*55*150L*SD18*4T	18	55	150	18
D20*60*150L*SD20*4T	20	60	150	20

FH210.620

- 用于加工钢件
 - 标准产品
 - 粗加工和精加工
 - 不等分 4 刃
 - R 角
- For steel
 - Standard tools
 - Rough milling, finish-milling
 - Unequal division 4-flute
 - Corner radius



适合加工的材料

Suitable for materials



规格型号 Order code

	R	Dc 0-0.02	Lc	L	D
D1R0.2*3*50L*SD4*4T	R0.2	1	3	50	4
D1.5R0.2*4*50L*SD4*4T	R0.2	1.5	4	50	4
D2R0.2*5*50L*SD4*4T	R0.2	2	5	50	4
D2.5R0.2*6.5*50L*SD4*4T	R0.2	2.5	6.5	50	4
D3R0.2*7.5*50L*SD4*4T	R0.2	3	7.5	50	4
D4*R0.2*10*50L*SD4*4T	R0.2	4	10	50	4
D4*R0.5*10*50L*SD4*4T	R0.5	4	10	50	4
D4*R1*10*50L*SD4*4T	R1	4	10	50	4
D6*R0.2*15*50L*SD6*4T	R0.2	6	15	50	6
D6*R0.5*15*50L*SD6*4T	R0.5	6	15	50	6
D6*R1*15*50L*SD6*4T	R1	6	15	50	6
D8*R0.2*20*60L*SD8*4T	R0.2	8	20	60	8
D8*R0.5*20*60L*SD8*4T	R0.5	8	20	60	8
D8*R1*20*60L*SD8*4T	R1	8	20	60	8
D10*R0.5*25*75L*SD10*4T	R0.5	10	25	75	10
D10*R1*25*75L*SD10*4T	R1	10	25	75	10
D12*R0.5*30*75L*SD12*4T	R0.5	12	30	75	12
D12*R1*30*75L*SD12*4T	R1	12	50	75	12

钢用加长圆鼻刀



FH211.620

- 用于加工钢件

- 标准产品

- 粗加工和精加工

- 不等分 4 刃

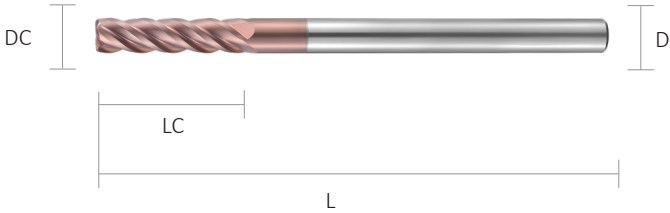
- R 角
- For steel

-Standard tools

-Rough milling, finish-milling

-Unequal division 4-flute

-Corner radius



适合加工的材料

Suitable for materials



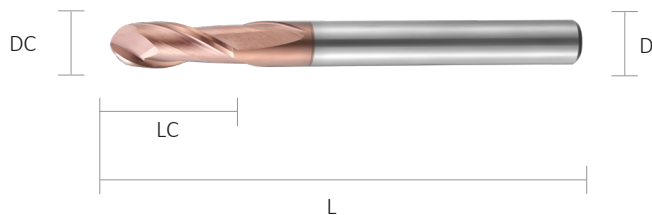
规格型号 Order code

	R	Dc 0-0.02	Lc	L	D
D4*R0.5*12*75L*SD4*4T	R0.5	4	12	75	4
D4*R0.5*12*100L*SD4*4T	R0.5	4	12	100	4
D6*R0.5*20*75L*SD6*4T	R0.5	6	20	75	6
D6*R1*20*75L*SD6*4T	R1	6	20	75	6
D6*R0.5*20*100L*SD6*4T	R0.5	6	20	100	6
D6*R1*20*100L*SD6*4T	R1	6	20	100	6
D8*R0.5*25*75L*SD8*4T	R0.5	8	25	75	8
D8*R1*25*75L*SD8*4T	R1	8	25	75	8
D8*R0.5*25*100L*SD8*4T	R0.5	8	25	100	8
D8*R1*25*100L*SD8*4T	R1	8	25	100	8
D10*R0.5*30*100L*SD10*4T	R0.5	10	30	100	10
D10*R1*30*100L*SD10*4T	R1	10	30	100	10
D12*R0.5*36*100L*SD12*4T	R0.5	12	36	100	12
D12*R1*36*100L*SD12*4T	R1	12	36	100	12

FS510.630

- 可用于加工高硬度金属
- 耐高温
- 适用性强
- 标准产品
- 粗加工和精加工

- For high hardness materials
- High temperature resistance
- Strong applicability
- Standard tools
- Rough milling, finish-milling



适合加工的材料

Suitable for materials

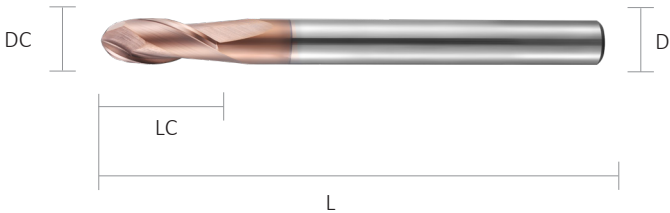


规格型号 Order code

	R	Lc	L	D
R0.5*2*50*SD4*2T	R0.5	2	50	4
R0.75*3*50L*SD4*2T	R0.75	3	50	4
R1.0*4*50L*SD4*2T	R1	4	50	4
R1.5*6*50L*SD4*2T	R1.5	6	50	4
R2*8*50L*SD4*2T	R2	8	50	4
R3*12*50L*SD6*2T	R3	12	50	6
R4*16*60L*SD8*2T	R4	16	60	8
R5*20*75L*SD10*2T	R6	20	75	10
R6*25*75L*SD12*2T	R6	25	75	12
R8*32*100L*SD16*2T	R8	32	100	16
R10*40*100L*SD20*2T	R10	40	100	20

FS511.630

- 可用于加工高硬度金属 -For high hardness materials
- 耐高温 -High temperature resistance
- 适用性强 -Strong applicability
- 标准产品 -Standard tools
- 粗加工和精加工 -Rough milling, finish-milling



适合加工的材料

Suitable for materials

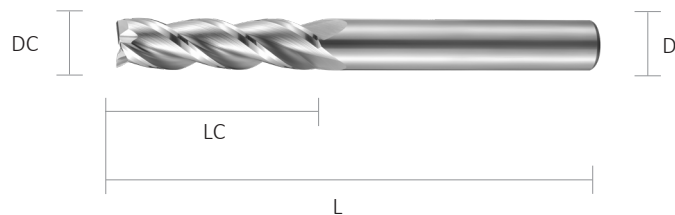


规格型号 Order code

	R	Lc	L	D
R0.5*2*75L*SD4*2T	R0.5	2	75	4
R0.75*3*75L*SD4*2T	R0.75	3	75	4
R1.0*4*75L*SD4*2T	R1	4	75	4
R1.5*6*75L*SD4*2T	R1.5	6	75	4
R2*8*75L*SD4*2T	R2	8	75	4
R3*12*75L*SD6*2T	R3	12	75	6
R4*16*75L*SD8*2T	R4	16	75	8
R5*20*100L*SD10*2T	R6	20	100	10
R6*25*100L*SD12*2T	R6	25	100	12

FN410.610

- 高效排屑
- 标准产品
- 粗加工和精加工
- High-chipping removal
- Standard tools
- Rough milling, finish-milling



适合加工的材料

Suitable for materials

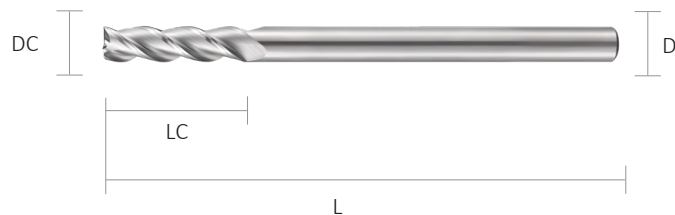


规格型号 Order code

	Dc 0-0.02	Lc	L	D
D1*3*50L*SD4*3T	1	3	50	4
D1.5*4.5*50L*SD4*3T	1.5	4.5	50	4
D2*6*50L*SD4*3T	2	6	50	4
D2.5*7.5*50L*SD4*3T	2.5	7.5	50	4
D3*9*50L*SD4*3T	3	9	50	4
D4*12*50L*SD4*3T	4	12	50	4
D5*15*50L*SD6*3T	5	15	50	6
D6*18*50L*SD6*3T	6	18	50	6
D8*24*60L*SD8*3T	8	24	60	8
D10*30*75L*SD10*3T	10	30	75	10
D12*36*75L*SD12*3T	12	36	75	12
D14*42*100L*SD14*3T	14	42	100	14
D16*48*100L*SD16*3T	16	48	100	16
D18*50*100L*SD18*3T	18	50	100	18
D20*60*100L*SD20*3T	20	60	100	20

FN511.610

- 高效排屑
 - 标准产品
 - 粗加工和精加工
- High-chipping removal
 - Standard tools
 - Rough milling, finish-milling



适合加工的材料

Suitable for materials

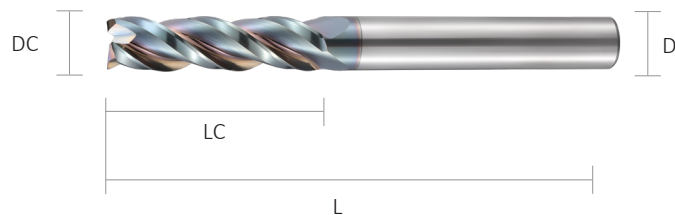


规格型号 Order code

	Dc 0-0.02	Lc	L	D
D4*15*75L*SD4*3T	4	15	75	4
D4*15*100L*SD4*3T	4	15	100	4
D5*15*75L*SD6*3T	5	15	75	6
D5*15*100L*SD6*3T	5	15	100	6
D6*20*75L*SD6*3T	6	20	75	6
D6*20*100L*SD6*3T	6	20	100	6
D8*25*75L*SD8*3T	8	25	75	8
D8*25*100L*SD8*3T	8	25	100	8
D10*30*100L*SD10*3T	10	30	100	10
D12*36*100L*SD12*3T	12	36	100	12
D14*42*150L*SD14*3T	14	42	150	14
D16*48*150L*SD16*3T	16	48	150	16
D18*50*150L*SD18*3T	18	50	150	18
D20*60*150L*SD20*3T	20	60	150	20

FN410.611

- 更好的排屑
- 标准产品
- 粗加工和精加工
- 更好的寿命
- 可干切
- Better solution for Stringy Chips
- Wrapped
- Standard tools
- Rough milling, finish-milling
- Better service life
- No cutting fluid can be used



适合加工的材料

Suitable for materials

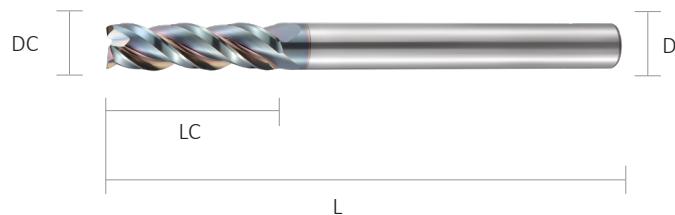


规格型号 Order code

	Dc 0-0.02	Lc	L	D
D1*3*50L*SD4*3T	1	3	50	4
D1.5*4.5*50L*SD4*3T	1.5	4.5	50	4
D2*6*50L*SD4*3T	2	6	50	4
D2.5*7.5*50L*SD4*3T	2.5	7.5	50	4
D3*9*50L*SD4*3T	3	9	50	4
D4*12*50L*SD4*3T	4	12	50	4
D5*15*50L*SD6*3T	5	15	50	6
D6*18*50L*SD6*3T	6	18	50	6
D8*24*60L*SD8*3T	8	24	60	8
D10*30*75L*SD10*3T	10	30	75	10
D12*36*75L*SD12*3T	12	36	75	12
D14*42*100L*SD14*3T	14	42	100	14
D16*48*100L*SD16*3T	16	48	100	16
D18*50*100L*SD18*3T	18	50	100	18
D20*60*100L*SD20*3T	20	60	100	20

FN511.611

- 更好的排屑
 - 标准产品
 - 粗加工和精加工
 - 更好的寿命
 - 可干切
- Better solution for Stringy Chips
 - Wrapped
 - Standard tools
 - Rough milling, finish-milling
 - Better service life
 - No cutting fluid can be used



适合加工的材料

Suitable for materials



规格型号 Order code

	Dc 0-0.02	Lc	L	D
D4*15*75L*SD4*3T	4	15	75	4
D4*15*100L*SD4*3T	4	15	100	4
D5*15*75L*SD6*3T	5	15	75	6
D5*15*100L*SD6*3T	5	15	100	6
D6*20*75L*SD6*3T	6	20	75	6
D6*20*100L*SD6*3T	6	20	100	6
D8*25*75L*SD8*3T	8	25	75	8
D8*25*100L*SD8*3T	8	25	100	8
D10*30*100L*SD10*3T	10	30	100	10
D12*36*100L*SD12*3T	12	36	100	12
D14*42*150L*SD14*3T	14	42	150	14
D16*48*150L*SD16*3T	16	48	150	16
D18*50*150L*SD18*3T	18	50	150	18
D20*60*150L*SD20*3T	20	60	150	20

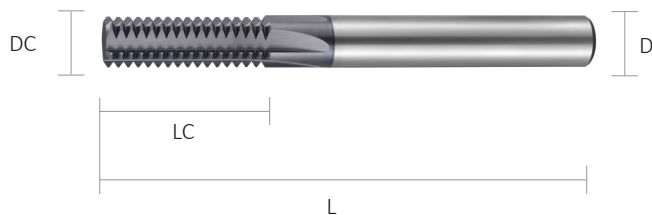
FX510.810

-ISO 公制螺纹

- 内冷和外冷

-ISO metric screw thread

-Internal cooling/External cooling



适合加工的材料

Suitable for materials



规格型号 Order code

	Pitch	Dc 0-0.02	Lc	L	D	Z
D6P0.5*16.5*65L*SD6*4T	0.5	6	16.5	65	6	4
D6P1*17*65L*SD6*4T	1	6	17	65	6	4
D6P1.25*17.8*65L*SD6*4T	1.25	6	17.8	65	6	4
D7.5P1*21*70L*SD8*4T	1	7.5	21	70	8	4
D7.5P1.25*22.5*70L*SD8*4T	1.25	7.5	22.5	70	8	4
D7.5P1.5*22.5*70L*SD8*4T	1.5	7.5	22.5	70	8	4
D9.5P1.25*26.3*80L*SD10*4T	1.25	9.5	26.3	80	10	4
D9.5P1.5*25.5*80L*SD10*4T	1.5	9.5	25.5	80	10	4
D9.5P1.75*26.3*80L*SD10*4T	1.75	9.5	26.3	80	10	4
D10P0.5*28.5*90L*SD10*4T	0.5	10	28.5	90	10	4
D10P0.75*29.3*90L*SD10*4T	0.75	10	29.3	90	10	4
D10P1*29*90L*SD10*4T	1	10	29	90	10	4
D10P1.5*30*90L*SD10*4T	1.5	10	30	90	10	4
D10P2*30*90L*SD10*4T	2	10	30	90	10	4
D12P1*33*100L*SD12*4T	1	12	33	100	12	4
D12P1.5*34.5*100L*SD12*4T	1.5	12	34.5	100	12	4
D12P2*34*100L*SD12*4T	2	12	34	100	12	4
D14P1.5*40.5*110L*SD14*4T	1.5	14	40.5	110	14	4
D14P2.5*40*110L*SD16*4T	2.5	14	40	110	16	4
D16P1.5*42*110L*SD16*4T	1.5	16	42	110	16	4
D16P2.5*42.5*110L*SD16*4T	2.5	16	42.5	110	16	4
D20P1.5*49.5*120L*SD20*5T	1.5	20	49.5	120	20	5
D20P2*50*120L*SD20*5T	2	20	50	120	20	5
D20P3*50*120L*SD20*5T	3	20	50	120	20	5

超微粒钨钢涂层螺旋槽螺纹铣刀

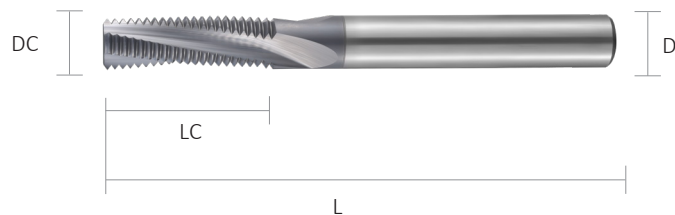
FX511.810

-ISO 公制螺纹

-ISO metric screw thread

- 内冷和外冷

-Internal cooling/External cooling



适合加工的材料

Suitable for materials



规格型号 Order code

	Pitch	Dc 0-0.02	Lc	L	D	Z
D6P0.5*16.5*65L*SD6*4T	0.5	6	16.5	65	6	4
D6P1*17*65L*SD6*4T	1	6	17	65	6	4
D6P1.25*17.8*65L*SD6*4T	1.25	6	17.8	65	6	4
D7.5P1*21*70L*SD8*4T	1	7.5	21	70	8	4
D7.5P1.25*22.5*70L*SD8*4T	1.25	7.5	22.5	70	8	4
D7.5P1.5*22.5*70L*SD8*4T	1.5	7.5	22.5	70	8	4
D9.5P1.25*26.3*80L*SD10*4T	1.25	9.5	26.3	80	10	4
D9.5P1.5*25.5*80L*SD10*4T	1.5	9.5	25.5	80	10	4
D9.5P1.75*26.3*80L*SD10*4T	1.75	9.5	26.3	80	10	4
D10P0.5*28.5*90L*SD10*4T	0.5	10	28.5	90	10	4
D10P0.75*29.3*90L*SD10*4T	0.75	10	29.3	90	10	4
D10P1*29*90L*SD10*4T	1	10	29	90	10	4
D10P1.5*30*90L*SD10*4T	1.5	10	30	90	10	4
D10P2*30*90L*SD10*4T	2	10	30	90	10	4
D12P1*33*100L*SD12*4T	1	12	33	100	12	4
D12P1.5*34.5*100L*SD12*4T	1.5	12	34.5	100	12	4
D12P2*34*100L*SD12*4T	2	12	34	100	12	4
D14P1.5*40.5*110L*SD14*4T	1.5	14	40.5	110	14	4
D14P2.5*40*110L*SD16*4T	2.5	14	40	110	16	4
D16P1.5*42*110L*SD16*4T	1.5	16	42	110	16	4
D16P2.5*42.5*110L*SD16*4T	2.5	16	42.5	110	16	4
D20P1.5*49.5*120L*SD20*5T	1.5	20	49.5	120	20	5
D20P2*50*120L*SD20*5T	2	20	50	120	20	5
D20P3*50*120L*SD20*5T	3	20	50	120	20	5

FX510.860

- 适用于多种材料的铰孔应用
- 高精度
- 内冷和外冷
- Suitable for reaming applications in a variety of materials
- High precision
- Internal cooling/External cooling



适合加工的材料

Suitable for materials

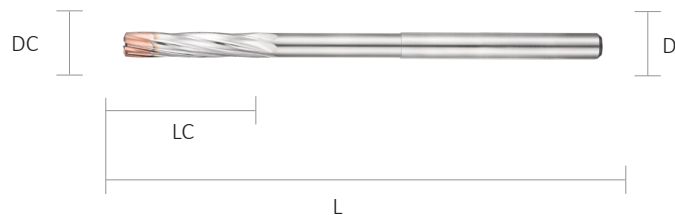


规格型号 Order code

	Dc 0-0.02	Lc	L	D	Z
D1*6*34L*SD1*4T	1	6	34	1	4
D1.5*8*40L*SD1.5*4T	1.5	8	40	1.5	4
D2*11*49L*SD2*4T	2	11	49	2	4
D2.5*14*57L*SD2.5*4T	2.5	14	57	2.5	4
D3*15*61L*SD3*4T	3	15	61	3	4
D3.5*18*70L*SD3.5*4T	3.5	18	70	3.5	4
D4*19*75L*SD4*4T	4	19	75	4	4
D4.5*21*80L*SD4.5*4T	4.5	21	80	4.5	4
D5*23*86L*SD5*6T	5	23	86	5	6
D6*26*93L*SD6*6T	6	26	93	6	6
D7*31*109L*SD7*6T	7	31	109	7	6
D8*33*117L*SD8*6T	8	33	117	8	6
D9*36*125L*SD9*6T	9	36	125	9	6
D10*38*133L*SD10*6T	10	38	133	10	6
D11*41*142L*SD10-11*6T	11	40	142	11	6
D12*44*151L*SD10-12*6T	12	44	151	12	6
D13*44*151L*SD10*6T	13	44	151	13	6
D14*47*160L*SD12.5*6T	14	47	160	14	6
D15*50*162L*SD12.5*6T	15	50	162	15	6
D16*52*170L*SD12.5*6T	16	52	170	16	6
D18*56*182L*SD14*6T	18	56	182	18	6
D20*60*195L*SD16*6T	20	60	195	20	6

FX511.860

- 适用于多种材料的铰孔应用
- 高精度
- 内冷和外冷
- Suitable for reaming applications in a variety of materials
- High precision
- Internal cooling/External cooling



适合加工的材料

Suitable for materials



规格型号 Order code

	Dc 0-0.02	Lc	L	D	Z
D1*6*34L*SD1*4T	1	6	34	1	4
D1.5*8*40L*SD1.5*4T	1.5	8	40	1.5	4
D2*11*49L*SD2*4T	2	11	49	2	4
D2.5*14*57L*SD2.5*4T	2.5	14	57	2.5	4
D3*15*61L*SD3*4T	3	15	61	3	4
D3.5*18*70L*SD3.5*4T	3.5	18	70	3.5	4
D4*19*75L*SD4*4T	4	19	75	4	4
D4.5*21*80L*SD4.5*4T	4.5	21	80	4.5	4
D5*23*86L*SD5*6T	5	23	86	5	6
D6*26*93L*SD6*6T	6	26	93	6	6
D7*31*109L*SD7*6T	7	31	109	7	6
D8*33*117L*SD8*6T	8	33	117	8	6
D9*36*125L*SD9*6T	9	36	125	9	6
D10*38*133L*SD10*6T	10	38	133	10	6
D11*41*142L*SD10-11*6T	11	40	142	11	6
D12*44*151L*SD10-12*6T	12	44	151	12	6
D13*44*151L*SD10*6T	13	44	151	13	6
D14*47*160L*SD12.5*6T	14	47	160	14	6
D15*50*162L*SD12.5*6T	15	50	162	15	6
D16*52*170L*SD12.5*6T	16	52	170	16	6
D18*56*182L*SD14*6T	18	56	182	18	6
D20*60*195L*SD16*6T	20	60	195	20	6

FQ210.903

-DIN6537 标准制造

- 定心力强

- 槽内抛光

- 内冷和外冷

-DIN6537

-Good centering performance

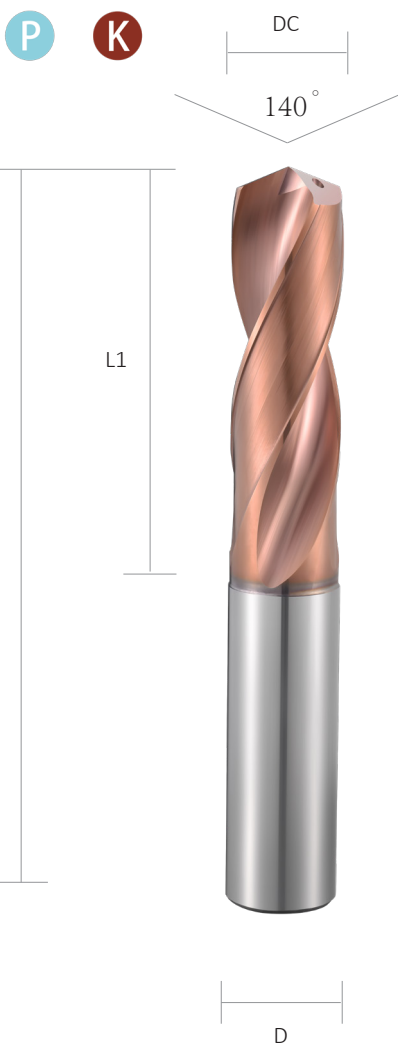
-Fine polished flute

-Internal cooling/External cooling



适合加工的材料

Suitable for materials



Dc 0-0.02	L1	L	D
3.00	20	62	4
3.10	20	62	4
3.20	20	62	4
3.30	20	62	4
3.40	20	62	4
3.50	20	62	4
3.60	20	62	4
3.70	20	62	4
3.80	24	66	4
3.90	24	66	4
4.00	24	66	4
4.10	24	66	6
4.20	24	66	6
4.30	24	66	6
4.40	24	66	6
4.50	24	66	6
4.60	24	66	6
4.70	24	66	6
4.80	28	66	6
4.90	28	66	6
5.00	28	66	6
5.10	28	66	6
5.20	28	66	6
5.30	28	66	6
5.40	28	66	6
5.50	28	66	6
5.60	28	66	6
5.70	28	66	6
5.80	28	66	6
5.90	28	66	6
6.00	28	66	6
6.10	34	79	8
6.20	34	79	8
6.30	34	79	8
6.40	34	79	8
6.50	34	79	8
6.60	34	79	8
6.70	34	79	8
6.80	34	79	8
6.90	34	79	8
7.00	34	79	8
7.10	41	79	8
7.20	41	79	8
7.30	41	79	8
7.40	41	79	8
7.50	41	79	8
7.60	41	79	8
7.70	41	79	8
7.80	41	79	8
7.90	41	79	8
8.00	41	79	8

Dc 0-0.02	L1	L	D
8.10	47	89	10
8.20	47	89	10
8.30	47	89	10
8.40	47	89	10
8.50	47	89	10
8.60	47	89	10
8.70	47	89	10
8.80	47	89	10
8.90	47	89	10
9.00	47	89	10
9.10	47	89	10
9.20	47	89	10
9.30	47	89	10
9.40	47	89	10
9.50	47	89	10
9.60	47	89	10
9.70	47	89	10
9.80	47	89	10
9.90	47	89	10
10.00	47	89	10
10.10	55	102	12
10.20	55	102	12
10.30	55	102	12
10.40	55	102	12
10.50	55	102	12
10.60	55	102	12
10.70	55	102	12
10.80	55	102	12
10.90	55	102	12
11.00	55	102	12
11.10	55	102	12
11.20	55	102	12
11.30	55	102	12
11.40	55	102	12
11.50	55	102	12
11.60	55	102	12
11.70	55	102	12
11.80	55	102	12
11.90	55	102	12
12.00	55	102	12
12.10	60	107	14
12.20	60	107	14
12.30	60	107	14
12.40	60	107	14
12.50	60	107	14
12.60	60	107	14
12.70	60	107	14
12.80	60	107	14
12.90	60	107	14
13.00	60	107	14
13.50	60	107	14

Dc 0-0.02	L1	L	D
14.00	60	107	14
14.50	65	115	16
15.00	65	115	16
15.50	65	115	16
16.00	65	115	16
16.50	73	123	18
17.00	73	123	18
17.50	73	123	18
18.00	73	123	18
18.50	79	131	20
19.00	79	131	20
19.50	79	131	20
20.00	79	131	20

FQ210.913

-DIN6537 标准制造

- 定心力强

- 槽内抛光

- 内冷和外冷

-DIN6537

-Good centering performance

-Fine polished flute

-Internal cooling/External cooling



适合加工的材料

Suitable for materials



DC

140°

L1

L

D

Dc 0-0.02	L1	L	D
3.00	28	66	4
3.10	28	66	4
3.20	28	66	4
3.30	28	66	4
3.40	28	66	4
3.50	28	66	4
3.60	28	66	4
3.70	28	66	4
3.80	36	74	4
3.90	36	74	4
4.00	36	74	4
4.10	36	74	6
4.20	36	74	6
4.30	36	74	6
4.40	36	74	6
4.50	36	74	6
4.60	36	74	6
4.70	36	74	6
4.80	44	82	6
4.90	44	82	6
5.00	44	82	6
5.10	44	82	6
5.20	44	82	6
5.30	44	82	6
5.40	44	82	6
5.50	44	82	6
5.60	44	82	6
5.70	44	82	6
5.80	44	82	6
5.90	44	82	6
6.00	44	82	6
6.10	53	91	8
6.20	53	91	8
6.30	53	91	8
6.40	53	91	8
6.50	53	91	8
6.60	53	91	8
6.70	53	91	8
6.80	53	91	8
6.90	53	91	8
7.00	53	91	8
7.10	53	91	8
7.20	53	91	8
7.30	53	91	8
7.40	53	91	8
7.50	53	91	8
7.60	53	91	8
7.70	53	91	8
7.80	53	91	8
7.90	53	91	8
8.00	53	91	8

Dc 0-0.02	L1	L	D
8.10	61	103	10
8.20	61	103	10
8.30	61	103	10
8.40	61	103	10
8.50	61	103	10
8.60	61	103	10
8.70	61	103	10
8.80	61	103	10
8.90	61	103	10
9.00	61	103	10
9.10	61	103	10
9.20	61	103	10
9.30	61	103	10
9.40	61	103	10
9.50	61	103	10
9.60	61	103	10
9.70	61	103	10
9.80	61	103	10
9.90	61	103	10
10.00	61	103	10
10.10	71	118	12
10.20	71	118	12
10.30	71	118	12
10.40	71	118	12
10.50	71	118	12
10.60	71	118	12
10.70	71	118	12
10.80	71	118	12
10.90	71	118	12
11.00	71	118	12
11.10	71	118	12
11.20	71	118	12
11.30	71	118	12
11.40	71	118	12
11.50	71	118	12
11.60	71	118	12
11.70	71	118	12
11.80	71	118	12
11.90	71	118	12
12.00	71	118	12
12.10	77	124	14
12.20	77	124	14
12.30	77	124	14
12.40	77	124	14
12.50	77	124	14
12.60	77	124	14
12.70	77	124	14
12.80	77	124	14
12.90	77	124	14
13.00	77	124	14
13.50	77	124	14

Dc 0-0.02	L1	L	D
14.00	77	124	14
14.50	83	133	16
15.00	83	133	16
15.50	83	133	16
16.00	83	133	16
16.50	93	143	18
17.00	93	143	18
17.50	93	143	18
18.00	93	143	18
18.50	101	153	20
19.00	101	153	20
19.50	101	153	20
20.00	101	153	20

FP210.903

-DIN6537 标准制造

- 定心力强

- 槽内抛光

- 内冷和外冷

-DIN6537

-Good centering performance

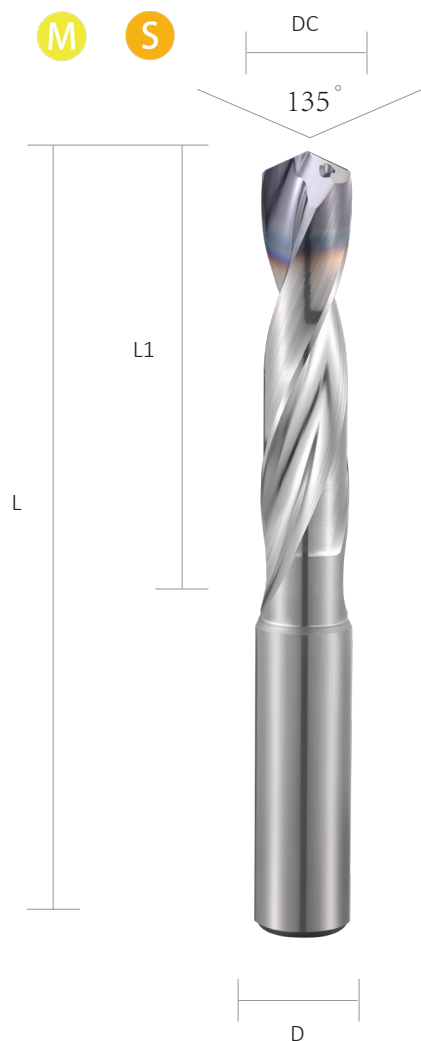
-Fine polished flute

-Internal cooling/External cooling



适合加工的材料

Suitable for materials



Dc 0-0.02	L1	L	D
3.00	20	62	4
3.10	20	62	4
3.20	20	62	4
3.30	20	62	4
3.40	20	62	4
3.50	20	62	4
3.60	20	62	4
3.70	20	62	4
3.80	24	66	4
3.90	24	66	4
4.00	24	66	4
4.10	24	66	6
4.20	24	66	6
4.30	24	66	6
4.40	24	66	6
4.50	24	66	6
4.60	24	66	6
4.70	24	66	6
4.80	28	66	6
4.90	28	66	6
5.00	28	66	6
5.10	28	66	6
5.20	28	66	6
5.30	28	66	6
5.40	28	66	6
5.50	28	66	6
5.60	28	66	6
5.70	28	66	6
5.80	28	66	6
5.90	28	66	6
6.00	28	66	6
6.10	34	79	8
6.20	34	79	8
6.30	34	79	8
6.40	34	79	8
6.50	34	79	8
6.60	34	79	8
6.70	34	79	8
6.80	34	79	8
6.90	34	79	8
7.00	34	79	8
7.10	41	79	8
7.20	41	79	8
7.30	41	79	8
7.40	41	79	8
7.50	41	79	8
7.60	41	79	8
7.70	41	79	8
7.80	41	79	8
7.90	41	79	8
8.00	41	79	8

Dc 0-0.02	L1	L	D
8.10	47	89	10
8.20	47	89	10
8.30	47	89	10
8.40	47	89	10
8.50	47	89	10
8.60	47	89	10
8.70	47	89	10
8.80	47	89	10
8.90	47	89	10
9.00	47	89	10
9.10	47	89	10
9.20	47	89	10
9.30	47	89	10
9.40	47	89	10
9.50	47	89	10
9.60	47	89	10
9.70	47	89	10
9.80	47	89	10
9.90	47	89	10
10.00	47	89	10
10.10	55	102	12
10.20	55	102	12
10.30	55	102	12
10.40	55	102	12
10.50	55	102	12
10.60	55	102	12
10.70	55	102	12
10.80	55	102	12
10.90	55	102	12
11.00	55	102	12
11.10	55	102	12
11.20	55	102	12
11.30	55	102	12
11.40	55	102	12
11.50	55	102	12
11.60	55	102	12
11.70	55	102	12
11.80	55	102	12
11.90	55	102	12
12.00	55	102	12
12.10	60	107	14
12.20	60	107	14
12.30	60	107	14
12.40	60	107	14
12.50	60	107	14
12.60	60	107	14
12.70	60	107	14
12.80	60	107	14
12.90	60	107	14
13.00	60	107	14
13.50	60	107	14

Dc 0-0.02	L1	L	D
14.00	60	107	14
14.50	65	115	16
15.00	65	115	16
15.50	65	115	16
16.00	65	115	16
16.50	73	123	18
17.00	73	123	18
17.50	73	123	18
18.00	73	123	18
18.50	79	131	20
19.00	79	131	20
19.50	79	131	20
20.00	79	131	20

FP210.913

-DIN6537 标准制造

- 定心力强

- 槽内抛光

- 内冷和外冷

-DIN6537

-Good centering performance

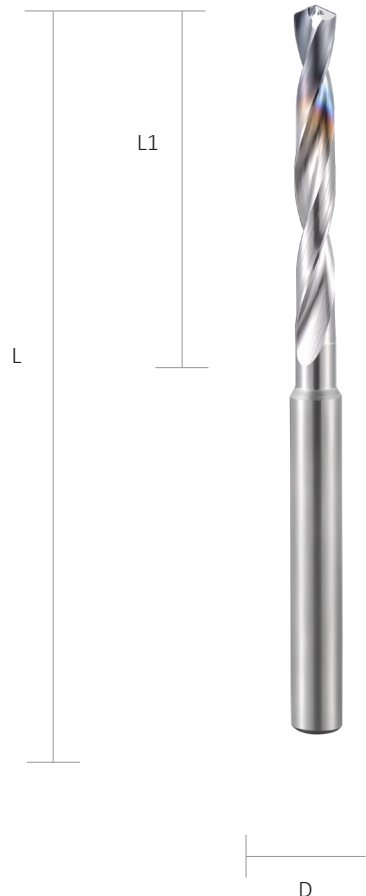
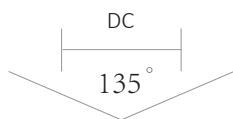
-Fine polished flute

-Internal cooling/External cooling



适合加工的材料

Suitable for materials



Dc 0-0.02	L1	L	D
3.00	28	66	4
3.10	28	66	4
3.20	28	66	4
3.30	28	66	4
3.40	28	66	4
3.50	28	66	4
3.60	28	66	4
3.70	28	66	4
3.80	36	74	4
3.90	36	74	4
4.00	36	74	4
4.10	36	74	6
4.20	36	74	6
4.30	36	74	6
4.40	36	74	6
4.50	36	74	6
4.60	36	74	6
4.70	36	74	6
4.80	44	82	6
4.90	44	82	6
5.00	44	82	6
5.10	44	82	6
5.20	44	82	6
5.30	44	82	6
5.40	44	82	6
5.50	44	82	6
5.60	44	82	6
5.70	44	82	6
5.80	44	82	6
5.90	44	82	6
6.00	44	82	6
6.10	53	91	8
6.20	53	91	8
6.30	53	91	8
6.40	53	91	8
6.50	53	91	8
6.60	53	91	8
6.70	53	91	8
6.80	53	91	8
6.90	53	91	8
7.00	53	91	8
7.10	53	91	8
7.20	53	91	8
7.30	53	91	8
7.40	53	91	8
7.50	53	91	8
7.60	53	91	8
7.70	53	91	8
7.80	53	91	8
7.90	53	91	8
8.00	53	91	8

Dc 0-0.02	L1	L	D
8.10	61	103	10
8.20	61	103	10
8.30	61	103	10
8.40	61	103	10
8.50	61	103	10
8.60	61	103	10
8.70	61	103	10
8.80	61	103	10
8.90	61	103	10
9.00	61	103	10
9.10	61	103	10
9.20	61	103	10
9.30	61	103	10
9.40	61	103	10
9.50	61	103	10
9.60	61	103	10
9.70	61	103	10
9.80	61	103	10
9.90	61	103	10
10.00	61	103	10
10.10	71	118	12
10.20	71	118	12
10.30	71	118	12
10.40	71	118	12
10.50	71	118	12
10.60	71	118	12
10.70	71	118	12
10.80	71	118	12
10.90	71	118	12
11.00	71	118	12
11.10	71	118	12
11.20	71	118	12
11.30	71	118	12
11.40	71	118	12
11.50	71	118	12
11.60	71	118	12
11.70	71	118	12
11.80	71	118	12
11.90	71	118	12
12.00	71	118	12
12.10	77	124	14
12.20	77	124	14
12.30	77	124	14
12.40	77	124	14
12.50	77	124	14
12.60	77	124	14
12.70	77	124	14
12.80	77	124	14
12.90	77	124	14
13.00	77	124	14
13.50	77	124	14

Dc 0-0.02	L1	L	D
14.00	77	124	14
14.50	83	133	16
15.00	83	133	16
15.50	83	133	16
16.00	83	133	16
16.50	93	143	18
17.00	93	143	18
17.50	93	143	18
18.00	93	143	18
18.50	101	153	20
19.00	101	153	20
19.50	101	153	20
20.00	101	153	20

FP210.923

-DIN6537 标准制造

- 定心力强

- 槽内抛光

- 内冷和外冷

-DIN6537

-Good centering performance

-Fine polished flute

-Internal cooling/External cooling



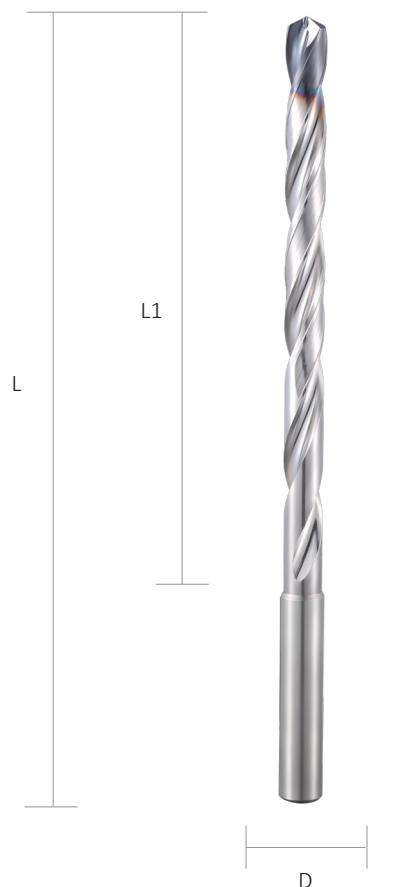
适合加工的材料

Suitable for materials



DC

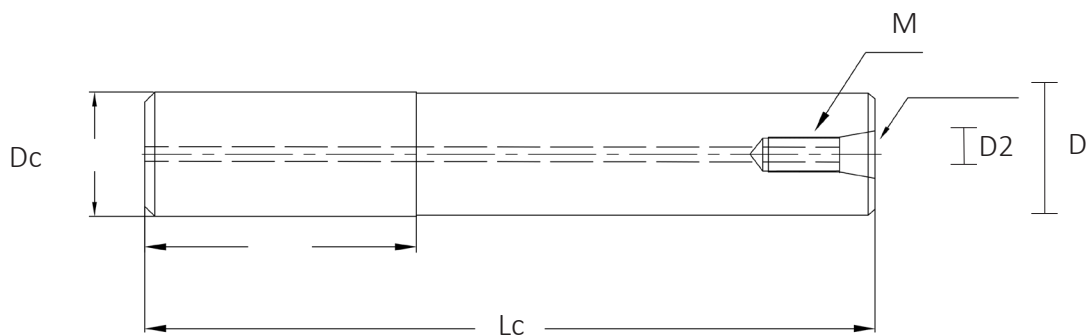
135°



Dc 0-0.02	L1	L	D
3.00	34	75	4
3.10	34	75	4
3.20	34	75	4
3.30	34	75	4
3.40	34	75	4
3.50	34	75	4
3.60	34	75	4
3.70	34	75	4
3.80	42	83	4
3.90	42	83	4
4.00	42	83	4
4.10	50	90	6
4.20	50	90	6
4.30	50	90	6
4.40	50	90	6
4.50	50	90	6
4.60	50	90	6
4.70	50	90	6=
4.80	50	90	6
4.90	50	90	6
5.00	50	97	6
5.10	57	97	6
5.20	57	97	6
5.30	57	97	6
5.40	57	97	6
5.50	57	97	6
5.60	57	97	6
5.70	57	97	6
5.80	57	97	6
5.90	57	97	6
6.00	57	97	6
6.10	66	106	8
6.20	66	106	8
6.30	66	106	8
6.40	66	106	8
6.50	66	106	8
6.60	66	106	8
6.70	66	106	8
6.80	66	106	8
6.90	76	116	8
7.00	76	116	8
7.10	76	116	8
7.20	76	116	8
7.30	76	116	8
7.40	76	116	8
7.50	76	116	8
7.60	76	116	8
7.70	76	116	8
7.80	76	116	8
7.90	76	116	8
8.00	76	116	8

Dc 0-0.02	L1	L	D
8.10	87	131	10
8.20	87	131	10
8.30	87	131	10
8.40	87	131	10
8.50	87	131	10
8.60	87	131	10
8.70	87	131	10
8.80	87	131	10
8.90	87	131	10
9.00	87	131	10
9.10	95	139	10
9.20	95	139	10
9.30	95	139	10
9.40	95	139	10
9.50	95	139	10
9.60	95	139	10
9.70	95	139	10
9.80	95	139	10
9.90	95	139	10
10.00	95	139	10
10.10	106	155	12
10.20	106	155	12
10.30	106	155	12
10.40	106	155	12
10.50	106	155	12
10.60	106	155	12
10.70	106	155	12
10.80	106	155	12
10.90	106	155	12
11.00	106	155	12
11.10	114	163	12
11.20	114	163	12
11.30	114	163	12
11.40	114	163	12
11.50	114	163	12
11.60	114	163	12
11.70	114	163	12
11.80	114	163	12
11.90	114	163	12
12.00	114	163	12
12.10	133	182	14
12.20	133	182	14
12.30	133	182	14
12.40	133	182	14
12.50	133	182	14
12.60	133	182	14
12.70	133	182	14
12.80	133	182	14
12.90	133	182	14
13.00	133	182	14
13.50	133	182	14

Dc 0-0.02	L1	L	D
14.00	133	204	14
14.50	152	204	16
15.00	152	204	16
15.50	152	204	16
16.00	152	223	16
16.50	171	223	18
17.00	171	223	18
17.50	171	223	18
18.00	171	223	18
18.50	190	244	20
19.00	190	244	20
19.50	190	244	20
20.00	190	244	20



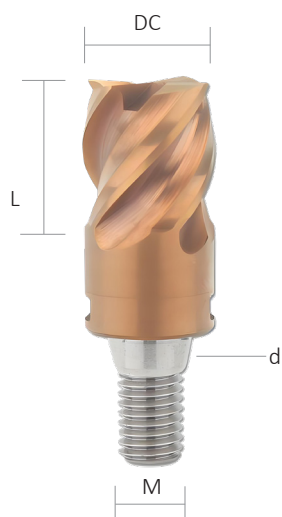
FL210

- 抗震性佳
- 节约方便，刀头多样
- 粗加工和精加工
- Good seismic performance
- Economize, Diversity
- Rough milling, finish-milling

Dc	M	Lc	D2	D
6	M3*0.5	60	3.5	6
6	M3*0.5	120	3.5	6
8	M4*0.7	60	4.5	8
8	M4*0.7	100	4.5	8
8	M4*0.7	120	4.5	8
10	M5*0.8	75	5.5	10
10	M5*0.8	100	5.5	10
10	M5*0.8	150	5.5	10
12	M6*1.0	75	6.5	12
12	M6*1.0	100	6.5	12
12	M6*1.0	150	6.5	12
12	M6*1.0	200	6.5	12
16	M8*1.25	100	8.5	16
16	M8*1.25	150	8.5	16
16	M8*1.25	200	8.5	16
16	M8*1.25	250	8.5	16
20	M10*1.5	100	10.5	20
20	M10*1.5	150	10.5	20
20	M10*1.5	200	10.5	20
20	M10*1.5	250	10.5	20
20	M10*1.5	300	10.5	20
20	M10*1.5	400	10.5	20
25	M12*1.75	100	12.5	25
25	M12*1.75	150	12.5	25
25	M12*1.75	200	12.5	25
25	M12*1.75	250	12.5	25
25	M12*1.75	300	12.5	25
25	M12*1.75	350	12.5	25
32	M16*2.0	150	17	32
32	M16*2.0	200	17	32
32	M16*2.0	250	17	32
32	M16*2.0	300	17	32
32	M16*2.0	400	17	32
42	M20*2.5	250	21	42
42	M20*2.5	300	21	42
42	M20*2.5	400	21	42
42	M20*2.5	500	21	42

适合加工的材料

Suitable for materials



平刀刀头

Dc 0-0.02		d	M
10	10	5.5	5
12	12	6.5	6
16	16	8.5	8
20	20	10.5	10
25	25	12.5	12
35	35	17	16

L



球头刀刀头

Dc 0-0.02	R	L	d	M
10	R5.0	10	8.5	5
12	R6.0	12	8.5	6
16	R8.0	16	8.5	8
20	R10.0	20	10.5	10
25	R12.5	25	12.5	12

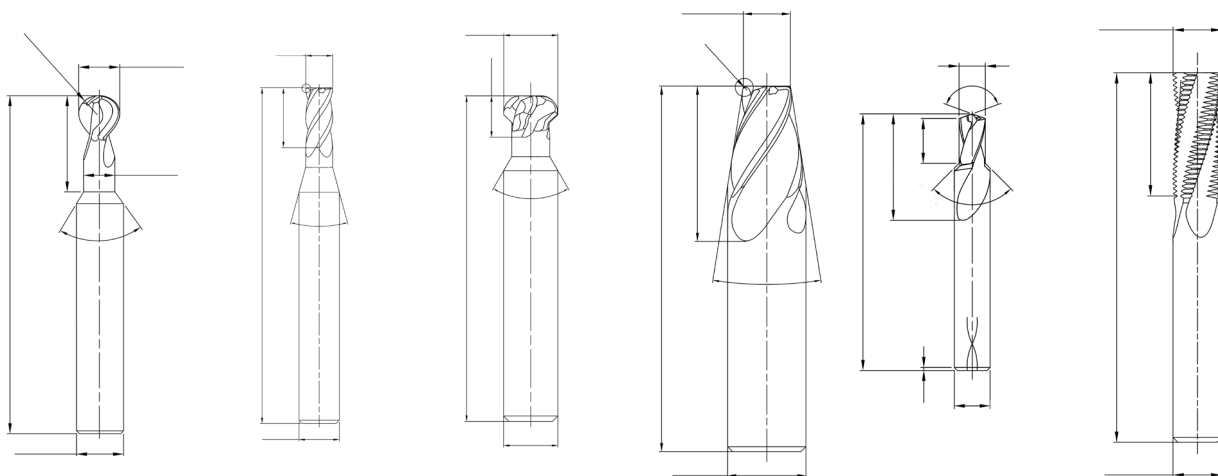


圆鼻刀刀头

Dc 0-0.02	R	L	d	M
10	R0.5	10	8.5	5
10	R1.0	10	8.5	5
10	R2.0	10	8.5	5
12	R1.0	12	8.5	6
12	R2.0	12	8.5	6
12	R3.0	12	8.5	6
16	R1.0	16	8.5	8
16	R2.0	16	8.5	8
16	R3.0	16	8.5	8
20	R2.0	20	10.5	10
20	R3.0	20	10.5	10
20	R4.0	20	10.5	10

— 如果需要刀具定制请和我们沟通，我们也可以根据您的需求提供方案。

-We are available for special tools and standard tools order. We can provide solutions according to your processed products, or we can manufacture according to your needs.



— 图片仅供参考

— Images are for reference only

钻头加工参数



硬质合金钻头	P								M			
材料分类	冷轧钢 低碳钢 易切钢		结构钢 渗碳钢 表面硬化钢 铸钢		渗碳钢 表面硬化钢 调质钢 中 / 高碳素钢		特殊钢 冷作钢 渗碳钢		铁素体结构 马氏体结构		奥氏体	
强度极限	≤600N/mm ²		≤800N/mm ²		≤1000N/mm ²		≤1200N/mm ²		≤950N/mm ²		≤950N/mm ²	
加工条件	m/min	mm/r	m/min	mm/r	m/min	mm/r	m/min	mm/r	m/min	mm/r	m/min	mm/r
DC	外冷 External Cooling											
3.0	50-70	0.08-0.12	50-60	0.06-0.10	40-60	0.06-0.10	30-50	0.05-0.10	20-30	0.05-0.10	15-25	0.05-0.10
4.0	50-70	0.10-0.15	50-60	0.06-0.10	40-60	0.06-0.10	30-50	0.05-0.10	20-30	0.05-0.10	15-25	0.05-0.10
5.0	50-70	0.10-0.15	50-60	0.10-0.15	40-60	0.10-0.15	30-50	0.05-0.10	20-30	0.05-0.10	20-30	0.05-0.10
6.0	50-70	0.15-0.20	50-60	0.10-0.15	40-60	0.10-0.15	30-50	0.10-0.15	20-30	0.05-0.10	25-35	0.05-0.10
8.0	60-80	0.20-0.30	50-70	0.15-0.25	50-70	0.15-0.25	40-60	0.10-0.15	20-40	0.08-0.15	25-40	0.08-0.15
10.0	60-80	0.20-0.30	50-70	0.15-0.25	50-70	0.15-0.25	40-60	0.15-0.20	20-40	0.08-0.15	30-40	0.08-0.15
12.0	60-80	0.20-0.30	50-70	0.20-0.30	50-70	0.20-0.30	40-60	0.15-0.20	20-40	0.08-0.15	30-50	0.08-0.15
16.0	70-90	0.25-0.30	60-80	0.20-0.30	50-70	0.20-0.30	40-60	0.20-0.25	30-50	0.10-0.20	30-50	0.10-0.20
20.0	70-90	0.25-0.35	60-80	0.20-0.30	50-70	0.20-0.30	40-60	0.20-0.25	30-50	0.10-0.20	30-50	0.10-0.20
DC	内冷 Interbal Cooling											
3.0	60-80	0.08-0.12	50-70	0.06-0.10	50-70	0.06-0.10	40-60	0.05-0.10	30-40	0.05-0.10	20-30	0.05-0.10
4.0	60-80	0.10-0.15	50-70	0.06-0.10	50-70	0.06-0.10	40-60	0.05-0.10	30-40	0.05-0.10	20-30	0.05-0.10
5.0	60-80	0.10-0.15	50-70	0.10-0.15	50-70	0.10-0.15	40-60	0.05-0.10	30-40	0.05-0.10	25-35	0.05-0.10
6.0	60-80	0.15-0.20	50-70	0.10-0.15	50-70	0.10-0.15	40-60	0.10-0.15	30-40	0.05-0.10	30-40	0.05-0.10
8.0	70-90	0.20-0.30	60-80	0.15-0.25	60-80	0.15-0.25	50-70	0.10-0.15	40-50	0.08-0.15	30-45	0.08-0.15
10.0	70-90	0.20-0.30	60-80	0.15-0.25	60-80	0.15-0.25	50-70	0.15-0.20	40-50	0.08-0.15	30-45	0.08-0.15
12.0	70-90	0.20-0.30	60-80	0.20-0.30	60-80	0.20-0.30	50-70	0.15-0.20	40-50	0.08-0.15	30-50	0.08-0.15
16.0	80-100	0.25-0.30	70-90	0.20-0.30	60-80	0.20-0.30	50-70	0.20-0.25	50-60	0.10-0.20	30-50	0.10-0.20
20.0	80-100	0.25-0.35	70-90	0.20-0.30	60-80	0.20-0.30	50-70	0.20-0.25	50-60	0.10-0.20	30-50	0.10-0.20

硬质合金钻头	K				N			
材料分类	片状石墨铸铁		球墨铸铁		锻铝 铜		铸铝 铜	
强度极限	100-450N/mm ²		350-900N/mm ²					
加工条件	m/min	mm/r	m/min	mm/r	m/min	mm/r	m/min	mm/r
DC	外冷 External Cooling							
3.0	60-90	0.10-0.15	40-70	0.08-0.12	80-100	0.08-0.10	100-120	0.08-0.10
4.0	60-90	0.10-0.15	40-70	0.10-0.15	80-100	0.10-0.15	100-120	0.10-0.15
5.0	60-90	0.15-0.20	40-70	0.10-0.15	80-100	0.10-0.15	100-120	0.10-0.15
6.0	60-90	0.15-0.20	40-70	0.15-0.20	80-100	0.10-0.15	100-120	0.10-0.15
8.0	70-100	0.20-0.30	50-80	0.20-0.30	100-120	0.15-0.20	110-130	0.15-0.20
10.0	70-100	0.20-0.30	50-80	0.20-0.30	100-120	0.15-0.20	110-130	0.15-0.20
12.0	70-100	0.20-0.30	50-80	0.20-0.30	100-120	0.20-0.30	110-130	0.20-0.30
16.0	80-110	0.25-0.30	60-90	0.25-0.30	100-120	0.25-0.30	120-150	0.25-0.30
20.0	80-110	0.25-0.35	60-90	0.25-0.35	100-120	0.25-0.35	120-150	0.25-0.35
DC	内冷 Interbal Cooling							
3.0	70-100	0.08-0.12	50-80	0.08-0.12	100-120	0.08-0.10	150-180	0.08-0.10
4.0	70-100	0.10-0.15	50-80	0.10-0.15	100-120	0.10-0.15	150-180	0.10-0.15
5.0	70-100	0.10-0.15	50-80	0.10-0.15	100-120	0.10-0.15	150-180	0.10-0.15
6.0	70-100	0.15-0.20	50-80	0.15-0.20	100-120	0.10-0.15	150-180	0.10-0.15
8.0	80-110	0.20-0.30	60-90	0.20-0.30	120-140	0.15-0.20	180-220	0.15-0.20
10.0	80-110	0.20-0.30	60-90	0.20-0.30	120-140	0.15-0.20	180-220	0.15-0.20
12.0	80-110	0.20-0.30	60-90	0.20-0.30	120-140	0.20-0.30	180-220	0.20-0.30
16.0	90-120	0.25-0.30	70-100	0.25-0.30	140-160	0.25-0.30	220-250	0.25-0.30
20.0	90-120	0.25-0.35	70-100	0.25-0.35	140-160	0.25-0.35	220-250	0.25-0.35

铣刀加工参数

钢用立铣刀	P						H				K	
材料分类	碳钢		低合金钢 (<24 HRC)		高合金钢 (<30 HRC)		硬化钢 (30-38 HRC)		硬化钢 (38-48 HRC)		铸铁	
VC m/min	120		120		80		65		60		120	
加工条件	min-1	mm/min	min-1	mm/min	min-1	mm/min	min-1	mm/min	min-1	mm/min	min-1	mm/min
DC	侧面切削 Side Milling											
3.0	10600	683	10600	683	8280	530	6550	389	6400	105	10600	683
4.0	6350	735	6350	735	4950	590	3950	413	3800	120	6350	735
5.0	4550	875	4550	875	3550	625	2800	448	2730	125	4550	875
6.0	3540	875	3540	875	2760	600	2200	413	2100	125	3540	875
8.0	3185	770	3185	770	2480	600	1975	413	1900	125	3185	770
10.0	3650	770	3650	770	2070	595	1645	375	1595	120	3650	770
12.0	2275	670	2275	670	1770	560	1410	350	1365	120	2275	670
16.0	1990	670	1990	670	1550	520	1230	312	1190	100	1990	670
20.0	1590	535	1590	535	1240	415	985	277	950	90	1590	535
DC	沟槽切削 Slotting											
3.0	10600	600	10600	600	8280	430	6550	290	6400	105	10600	600
4.0	6350	635	6350	635	4950	500	3950	325	3800	120	6350	635
5.0	4550	775	4550	775	3550	525	2800	348	2730	125	4550	775
6.0	3540	775	3540	775	2760	500	2200	313	2100	125	3540	775
8.0	3185	650	3185	650	2480	500	1975	313	1900	125	3185	650
10.0	3650	670	3650	670	2070	490	1645	288	1595	120	3650	670
12.0	2275	560	2275	560	1770	460	1410	275	1365	120	2275	560
16.0	1990	660	1990	660	1550	420	1230	240	1190	100	1990	660
20.0	1590	500	1590	500	1240	360	985	200	950	90	1590	500

铝用立铣刀	N	
材料分类	铝	
VC m/min	200	
加工条件	min-1	mm/min
DC	侧面切削 Side Milling	
3.0	21000	950
4.0	15500	1000
5.0	12500	1100
6.0	10500	1200
8.0	8000	1300
10.0	6350	1500
12.0	5300	1550
16.0	4000	1550
20.0	3150	1500
DC	沟槽切削 Slotting	
3.0	21000	670
4.0	15500	700
5.0	12500	745
6.0	10500	820
8.0	8000	860
10.0	6350	960
12.0	5300	1050
16.0	4000	1050
20.0	3150	1050

多用途立铣刀	H								M		S	
材料分类	硬化钢 (30-38 HRC)		硬化钢 (38-48 HRC)		硬化钢 (48-56 HRC)		硬化钢 (56-68 HRC)		不锈钢		钛合金	
VC m/min	65		60		55		50		65		30	
加工条件	min-1	mm/min	min-1	mm/min	min-1	mm/min	min-1	mm/min	min-1	mm/min	min-1	mm/min
DC	侧面切削 Side Milling											
3.0	6550	389	6400	105	5760	95	5120	84	6550	389	3200	130
4.0	3950	413	3800	120	3420	108	3040	96	3950	413	2400	150
5.0	2800	448	2730	125	2457	113	2184	100	2800	448	2000	160
6.0	2200	413	2100	125	1890	113	1680	100	2200	413	1600	145
8.0	1975	413	1900	125	1710	113	1520	100	1975	413	1200	120
10.0	1645	375	1595	120	1436	108	1276	96	1645	375	1000	145
12.0	1410	350	1365	120	1228	108	1092	96	1410	350	800	150
16.0	1230	312	1190	100	1071	90	952	80	1230	312	600	150
20.0	985	277	950	90	855	81	760	72	985	277	480	130
DC	沟槽切削 Slotting											
3.0	6550	290	6400	105	5760	95	5120	84	6550	290	3200	180
4.0	3950	325	3800	120	3420	108	3040	96	3950	325	2400	180
5.0	2800	348	2730	125	2457	113	2184	100	2800	348	2000	190
6.0	2200	313	2100	125	1890	113	1680	100	2200	313	1600	190
8.0	1975	313	1900	125	1710	113	1520	100	1975	313	1200	170
10.0	1645	288	1595	120	1436	108	1276	96	1645	288	1000	160
12.0	1410	275	1365	120	1228	108	1092	96	1410	275	800	160
16.0	1230	240	1190	100	1071	90	952	80	1230	240	600	150
20.0	985	200	950	90	855	81	760	72	985	200	480	160

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