

HSS



Being the best through innovation



COUNTERSINK

- 修边, 倒角, 锥形扩孔, HSS&HSS-E&含钴8%

Deburring, Chamfering, Countersinking, HSS & HSS-E & 8% Cobalt

SELECTION GUIDE

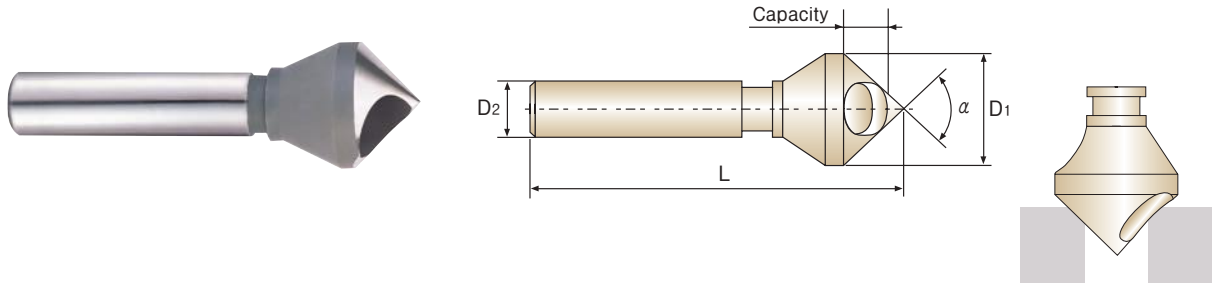
项目 ITEM	型号 MODEL	规格 DESCRIPTION	尺寸		页 PAGE
			最小	最大	
			SIZE		
			MIN	MAX	
C1109 C2109 C3109		高速钢带孔的去毛刺刀具 HSS DEBURRING TOOL with HOLE	D10.0	D50.0	1041
C1119 C2119 C3119		高速钢单刃倒角刀具 HSS SINGLE FLUTE CHAMFERING CUTTERS	D10.0	D50.0	1042
C1139 C2139 C3139		高速钢3刃沉孔刀 HSS THREE FLUTE COUNTERSINKS	D4.3	D31.0	1043
		推荐的切削条件 RECOMMENDED CUTTING CONDITIONS			1044

高速钢带孔的去毛刺刀具

HSS DEBURRING TOOL with HOLE

- ▶ 用于轻金属和塑料
- ▶ 用于去毛刺和小的倒角
- ▶ 最好的表面粗糙度
- ▶ 加工时没有振动

- ▶ For light metals and plastics.
- ▶ For deburring and small chamfers.
- ▶ Best surface finish.
- ▶ 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°)	D1	D2	L(±1)	min/max
C1109100	C2109100	C3109100	90°	10.0	6	45	2 - 5
C1109150	C2109150	C3109150	90°	15.0	8	55	6 - 14
C1109200	C2109200	C3109200	90°	20.0	10	65	8 - 18
C1109250	C2109250	C3109250	90°	25.0	12	78	10 - 23
C1109300	C2109300	C3109300	90°	30.0	12	88	12 - 28
C1109350	C2109350	C3109350	90°	35.0	16	110	14 - 33
C1109400	C2109400	C3109400	90°	40.0	16	115	16 - 38
C1109450	C2109450	C3109450	90°	45.0	16	120	18 - 43
C1109500	C2109500	C3109500	90°	50.0	16	130	20 - 48

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

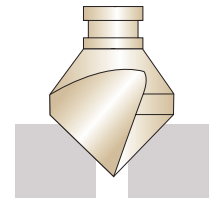
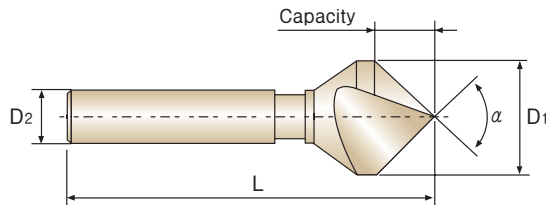
刃部公差 Nominal Dia. Tolerance(mm)	柄部公差 Shank Dia. Tolerance
+0.3	h9

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°)	D1	D2	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

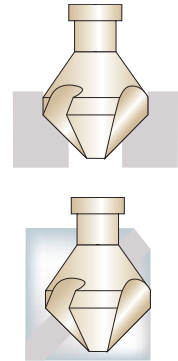
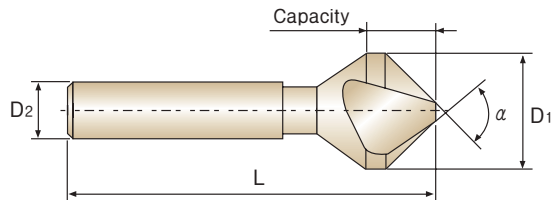
- ▶ TiN&TiCN涂层可根据您的要求加工
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刃部公差 Nominal Dia. Tolerance(mm)	柄部公差 Shank Dia. Tolerance
+0.3	h9

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
335 C

单位(Unit) : mm

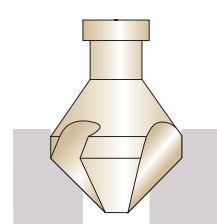
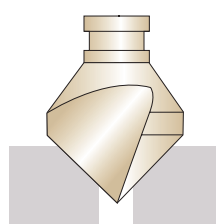
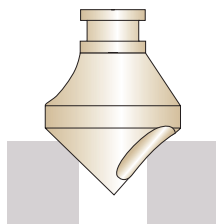
型号 EDP No. (uncoating)			角度 Angle	刃部直径 Nominal Diameter	柄部直径 Shank Diameter	全长 Overall Length	生产量 Capacity
HSSCo8	HSS-E	HSS	α (-1°)	D1	D2	L(±1)	min/max
C1139043	C2139043	C3139043	90°	4.3	4	40	1.3 - 4.3
C1139050	C2139050	C3139050	90°	5.0	4	40	1.5 - 5
C1139060	C2139060	C3139060	90°	6.0	5	45	1.5 - 6
C1139063	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



REAMERS

COUNTER
SINKSCOUNTER
BORESROTARY
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)