

**KM**



**KM 系列刀具**  
**通用刀具**  
**KM series**  
**Universal end mills**



**昆山欧思克精密工具有限公司**  
**Kunshan OSK Precision Tools Co., Ltd**

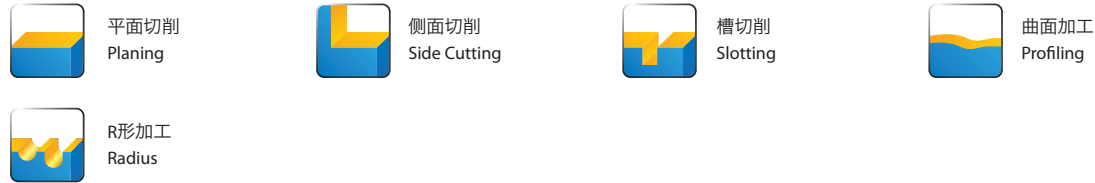
[www.osktool.com](http://www.osktool.com)

## 图标说明 / Meaning of icons

### 底刃形状 / Endteeth Type



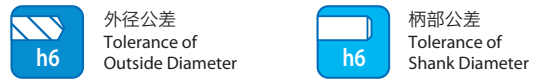
### 加工用途 / Applications



### 加工分类 / Type



### 尺寸公差 / Materials



### 涂层 / Coating



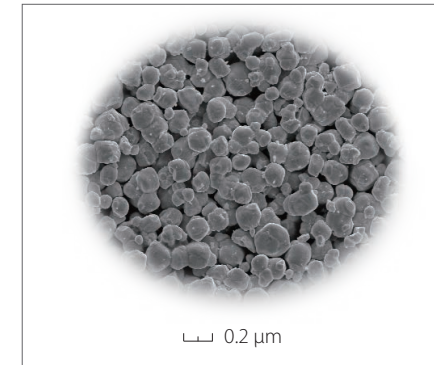
### 刀具技术参数 / Technical parameters of cutting tool



### 被加工材料 / Processed material



## KM 系列采用超细颗粒材料 / KM series of ultrafine particle materials

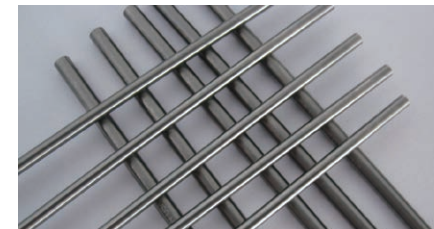


钨钢粉末颗粒  
Tungsten powder particles



钨钢粉末高温烧结炉  
Tungsten powder sintering furnace

## KM 系列使用的超细钨钢材料 / The use of KM series ultrafine tungsten carbide materials

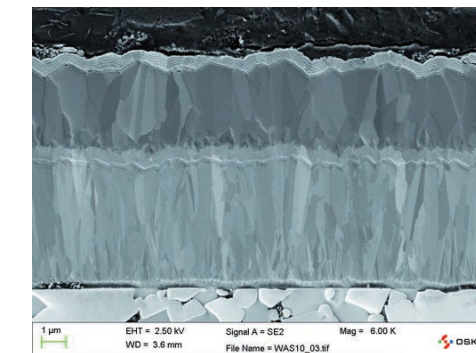


钨钢粗磨棒料  
Coarse grinding tungsten steel bar

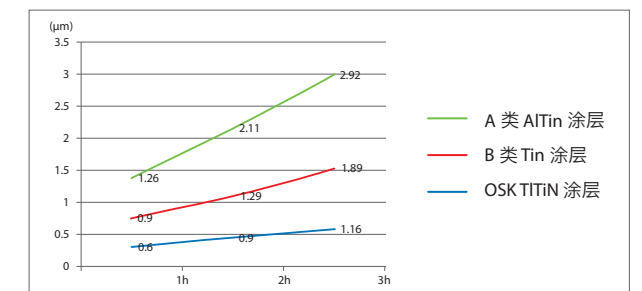


钨钢精磨棒料  
Tungsten steel grinding rod

## KM 系列采用超耐磨涂层 TiTiN KM series using super wear-resistant coating TiTiN



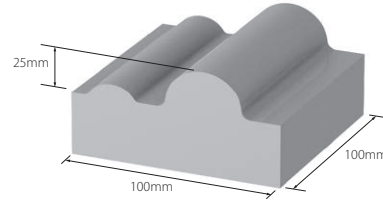
## KM 系列涂层与其它种类涂层对比 Comparison of KM series coating with other kinds of coating



相同参数, 时间, 材料 (SKD11) 加工磨损涂层对比  
The same parameters, time, material (SKD11) processing wear coating contrast contrast

## KM 系列 4 刃球头立铣刀对比 / Comparison of KM series 4 Flutes ball end mills

加工一个右图所示的模具。  
 模具材料: 热处理 H13  
 Comparison of time required for cutting the mold shown at right  
 Mold material: H13 (HRC46)



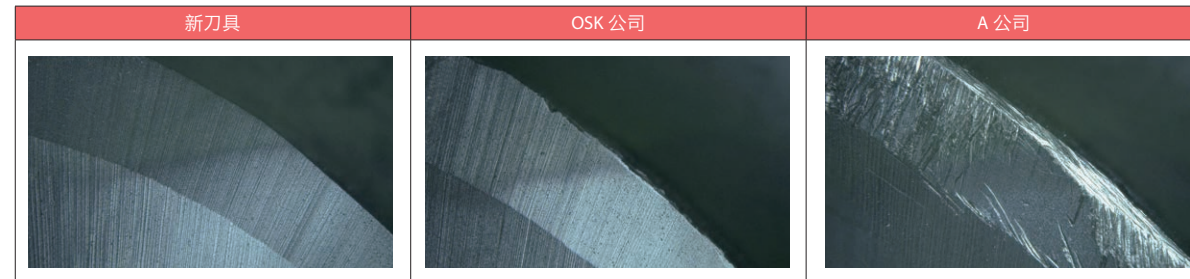
Product model	A 公司	OSK 产品
尺寸 Tool size	6xR3, 4 刃 Flutes	6xR3, 4 刃 Flutes
切削时间 Cutting time	135 分钟 Min	135 分钟 Min
切削方式 Cutting method	球面切削 Spherical cutting	球面切削 Spherical cutting
冷却方式 Cooling mode	油冷 Oil cooling	油冷 Oil cooling
切削参数 Cutting parameter	S=3000, F=400, Ap: 2mm, Ae: 2mm	S=3000, F=400, Ap: 2mm, Ae: 2mm

### 相同时间, 相同加工参数 / The same time, the same processing parameters

刀具球面磨损对比 / Tool Spherical wear contrast



刀具圆弧磨损对比 / Tool circular arc wear contrast



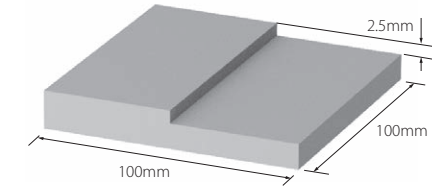
### KM 系列加工费用对比 / The same time, the same processing parameters

假设完成一个工件, 需要 300 分钟 / If we work a piece, we need 300 minutes to finish it.

	刀具费 ¥ Tool cost ¥	刀具更换时间 Tool change time	实际加工时间 (h) Actual processing time	机械 / 人工费 ¥ Mechanical/labor cost ¥	加工费用对比 ¥ Processing cost comparison ¥
A 公司	80x3	60 分钟 min	360	8.5 / 分钟	3300
OSK 产品	120x1	20 分钟 min	320	8.5 / 分钟	2840

## KM 系列 2 刃立铣刀对比 / Comparison of KM series 2 Flutes end mills

加工一个右图所示的模具。  
 模具材料: 热处理 H13  
 Comparison of time required for cutting the mold shown at right  
 Mold material: H13 (HRC46)



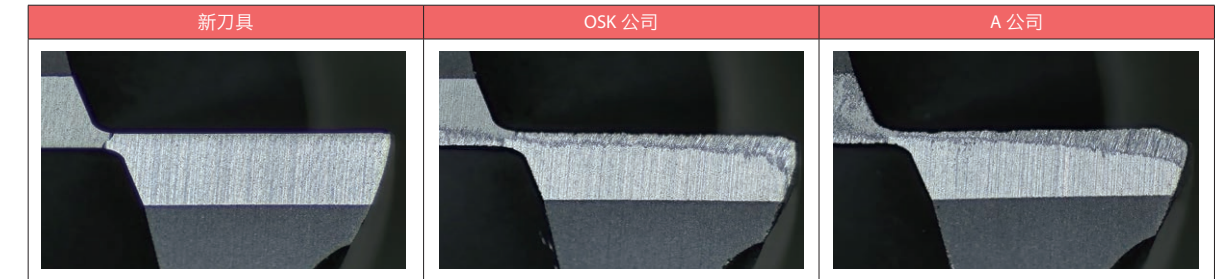
Product model	A 公司	OSK 产品
尺寸 Tool size	4.0mm, 2 刃 Flutes	4.0mm, 2 刃 Flutes
切削时间 Cutting time	180 分钟 Min	360 分钟 Min
切削方式 Cutting method	平面切削 Plane cutting	平面切削 Plane cutting
冷却方式 Cooling mode	气冷 Gas cooling	气冷 Gas cooling
切削参数 Cutting parameter	S=30000, F=120, Ap: 1D, Ae: 0.02D	S=30000, F=120, Ap: 1D, Ae: 0.02D

### 相同时间, 相同加工参数 / The same time, the same processing parameters

刀具球面磨损对比 / Tool Spherical wear contrast



刀具圆弧磨损对比 / Tool circular arc wear contrast



### KM 系列加工费用对比 / The same time, the same processing parameters

假设完成一个工件, 需要 380 分钟 / If we work a piece, we need 380 minutes to finish it.

	刀具费 ¥ Tool cost ¥	刀具更换时间 Tool change time	实际加工时间 (h) Actual processing time	机械 / 人工费 ¥ Mechanical/labor cost ¥	加工费用对比 ¥ Processing cost comparison ¥
A 公司	70x3	60 分钟 min	460	8.5 / 分钟	4120
OSK 产品	120x1	20 分钟 min	420	8.5 / 分钟	3690





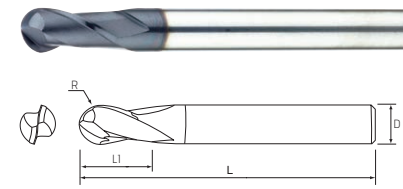
球头铣刀  
Ball End Mills

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KM-BR

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015

碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel	合金钢 (≥40 HRC) Alloy Steel, Tool Steel	淬硬钢 (40~50 HRC) Hardened Steel	淬硬钢 (50~60 HRC) Hardened Steel	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○



中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.



KM-BR 2 刃球刀 / 2 Flutes Ball End Mills

Product model 产品型号	Radius 半径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM2BR0050S04	R0.5	2	50	4	■
KM2BR0050S06	R0.5	2	50	6	■
KM2BR0075S04	R0.75	3	50	4	■
KM2BR0075S06	R0.75	3	50	6	■
KM2BR0100S04	R1.0	4	50	4	■
KM2BR0100S06	R1.0	4	50	6	■
KM2BR0125S04	R1.25	5	50	4	■
KM2BR0125S06	R1.25	5	50	6	■
KM2BR0150S03	R1.5	6	50	3	□
KM2BR0150S04	R1.5	6	50	4	■
KM2BR0150S06	R1.5	6	50	6	■
KM2BR0200S04	R2.0	8	50	4	■
KM2BR0200S06	R2.0	8	50	6	■
KM2BR0250S06	R2.5	10	50	5	□
KM2BR0250S06	R2.5	10	50	6	■
KM2BR0300S06	R3.0	12	50	6	■
KM2BR0350S08	R3.5	14	60	8	■
KM2BR0400S08	R4.0	16	60	8	■
KM2BR0450S10	R4.5	18	75	10	■
KM2BR0500S10	R5.0	20	75	10	■
KM2BR0600S12	R6.0	24	75	12	■
KM2BR0700S14	R7.0	24	100	14	■
KM2BR0800S16	R8	24	100	16	■
KM2BR1000S20	R10	30	100	20	■
KM2BR1250S25	R12.5	35	100	25	□



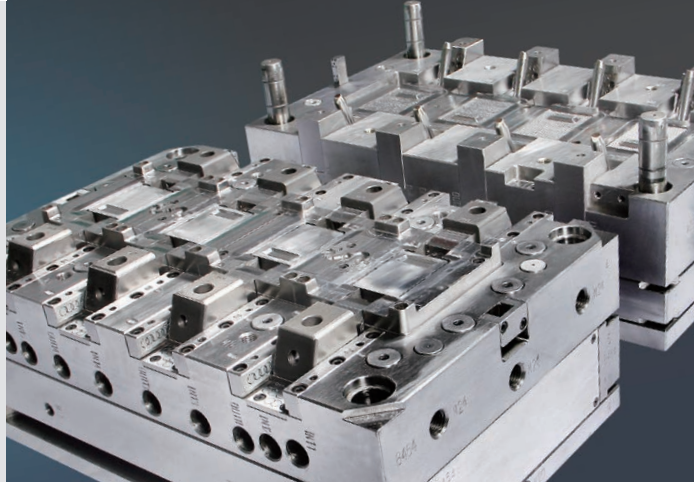
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端铣刀  
End Mills



圆角铣刀  
Corner Radius End Mills

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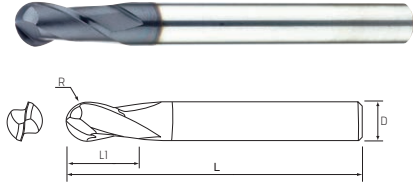
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加工参数  
Parameters

# KM-BR

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015

碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○



### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5µm), 高速加工时发挥出出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5µm) WC grade.



## KM-BR 2刃加长球刀 / 2 Flutes Lengthen Ball End Mills

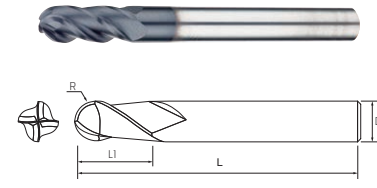
Product model 产品型号	Radius 半径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM2BR0100L075S04	R1	4	75	4	■
KM2BR0100L100S04	R1	4	100	4	■
KM2BR0100L075S06	R1	4	75	6	□
KM2BR0100L100S06	R1	4	100	6	□
KM2BR0125L075S04	R1.25	5	75	4	■
KM2BR0125L100S04	R1.25	5	100	4	■
KM2BR0125L075S06	R1.25	5	75	4	□
KM2BR0125L100S06	R1.25	5	100	6	□
KM2BR0150L075S03	R1.5	6	75	3	□
KM2BR0150L075S04	R1.5	6	75	4	■
KM2BR0150L100S04	R1.5	6	100	4	■
KM2BR0150L075S06	R1.5	6	75	6	□
KM2BR0150L100S06	R1.5	6	100	6	□
KM2BR0200L075S04	R2	8	75	4	■
KM2BR0200L100S04	R2	8	100	4	■
KM2BR0200L075S06	R2	8	75	6	■
KM2BR0200L100S06	R2	8	100	6	■
KM2BR0250L075S05	R2.5	10	75	5	□
KM2BR0250L100S05	R2.5	10	100	5	□
KM2BR0250L075S06	R2.5	10	75	6	■
KM2BR0250L100S06	R2.5	10	100	6	■
KM2BR0300L075S06	R3	12	75	6	■
KM2BR0300L100S06	R3	12	100	6	■
KM2BR0400L075S08	R4	16	75	8	■
KM2BR0400L100S08	R4	16	100	9	■
KM2BR0500L100S10	R5	20	100	10	■
KM2BR0500L150S10	R5	20	150	10	■
KM2BR0600L100S12	R6	24	100	12	■
KM2BR0600L150S12	R6	24	150	12	■
KM2BR0800L150S16	R8	32	150	16	■
KM2BR1000L150S20	R10	40	150	20	■
KM2BR1000L150S20	R10	40	200	20	□
KM2BR1250L150S25	R12.5	50	150	25	□
KM2BR1250L200S25	R12.5	50	200	25	□

■大量库存 (Large Stock) ■少量库存 (Low Stock) □需要订制 (Customized)

# KM-BR

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015

碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○



### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5µm), 高速加工时发挥出出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

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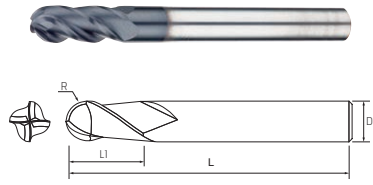
## KM-BR 4刃球铣刀 / 4 Flutes Ball End Mills

Product Model 产品型号	Radius 半径	Length of Cut 刃长	Overall Length 全长	Shank Diameter 柄径	Stock 库存情况
KM4BR0150S04	R1.5	6	50	4	□
KM4BR0150S06	R1.5	6	50	6	□
KM4BR0200S04	R2.0	8	50	4	□
KM4BR0200S06	R2.0	8	50	6	□
KM4BR0250S06	R2.5	10	50	5	□
KM4BR0250S06	R2.5	10	50	6	□
KM4BR0300S06	R3.0	12	50	6	□
KM4BR0350S08	R3.5	14	60	8	□
KM4BR0400S08	R4.0	16	60	8	□
KM4BR0450S10	R4.5	18	75	10	□
KM4BR0500S10	R5.0	20	75	10	□
KM4BR0600S12	R6.0	24	75	12	□
KM4BR0700S14	R7.0	24	100	14	□
KM4BR0800S16	R8	24	100	16	□
KM4BR1000S20	R10	30	100	20	□
KM4BR1250S25	R12.5	35	100	25	□

■大量库存 (Large Stock) ■少量库存 (Low Stock) □需要订制 (Customized)

# KM-BR

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

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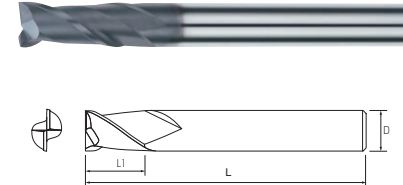
## KM-BR 4 刃加长球刀 / 4 Flutes Lengthen Ball End Mills

Product model 产品型号	Radius 半径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM4BR0200L075S04	R2	8	75	4	■
KM4BR0200L100S04	R2	8	100	4	■
KM4BR0200L075S06	R2	8	75	6	■
KM4BR0200L100S06	R2	8	100	6	■
KM4BR0250L100S05	R2.5	10	100	5	□
KM4BR0250L075S06	R2.5	10	75	6	■
KM4BR0250L100S06	R2.5	10	100	6	■
KM4BR0300L075S06	R3	12	75	6	■
KM4BR0300L100S06	R3	12	100	6	■
KM4BR0400L075S08	R4	16	75	8	■
KM4BR0400L100S08	R4	16	100	9	■
KM4BR0500L100S10	R5	20	100	10	■
KM4BR0500L150S10	R5	20	150	10	■
KM4BR0600L100S12	R6	24	100	12	■
KM4BR0600L150S12	R6	24	150	12	■
KM4BR0800L150S16	R8	32	150	16	■
KM4BR1000L150S20	R10	40	150	20	■
KM4BR1000L150S20	R10	40	200	20	□
KM4BR1250L150S25	R12.5	50	150	25	□
KM4BR1250L200S25	R12.5	50	200	25	□

■ 大量库存 (Large Stock) ■ 少量库存 (Low Stock) □ 需要订制 (Customized)

# KM-ED

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
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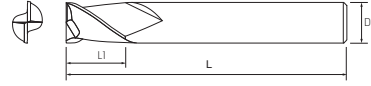
## KM-ED 2 刃铣刀 / 2 Flutes End Mills

Product model 产品型号	Diameter 直径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM2ED0100S04	1	3	50	4	■
KM2ED0100S06	1	3	50	6	■
KM2ED0150S04	1.5	4	50	4	■
KM2ED0150S06	1.5	4	50	6	■
KM2ED0200S04	2	6	50	4	■
KM2ED0200S06	2	6	50	6	■
KM2ED0250S04	2.5	8	50	4	■
KM2ED0250S06	2.5	8	50	6	■
KM2ED0300S04	3	8	50	4	■
KM2ED0300S06	3	9	50	6	■
KM2ED0400S04	4	12	50	4	■
KM2ED0400S06	4	12	50	6	■
KM2ED0500S06	5	15	50	6	■
KM2ED0600S06	6	15	50	6	■
KM2ED0700S08	7	20	60	8	■
KM2ED0800S08	8	20	60	8	■
KM2ED0900S10	9	30	75	10	■
KM2ED1000S10	10	30	75	10	■
KM2ED1100S12	11	30	75	12	■
KM2ED1200S12	12	30	75	12	■
KM2ED1400S14	14	32	100	14	■
KM2ED1600S16	16	45	100	16	■
KM2ED2000S20	20	45	100	20	■
KM2ED2500S20	25	45	100	25	□

■ 大量库存 (Large Stock) ■ 少量库存 (Low Stock) □ 需要订制 (Customized)

# KM-ED

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.

## KM-BR 2 刃加长铣刀 / 2 Flutes Lengthen End Mills



Product model 产品型号	Diameter 直径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM2ED0100L075S04	1	4	75	4	■
KM2ED0100L100S04	1	4	100	4	■
KM2ED0100L075S06	1	4	75	6	■
KM2ED0100L100S06	1	4	100	6	□
KM2ED0150L075S04	1.5	6	75	4	■
KM2ED0150L100S04	1.5	6	100	4	■
KM2ED0150L075S06	1.5	6	75	6	■
KM2ED0150L100S06	1.5	6	100	6	□
KM2ED0200L075S04	2	8	75	4	■
KM2ED0200L100S04	2	8	100	4	■
KM2ED0200L075S06	2	8	75	6	■
KM2ED0200L100S06	2	8	100	6	□
KM2ED0250L075S04	2.5	10	75	4	■
KM2ED0250L100S04	2.5	10	100	4	■
KM2ED0250L075S06	2.5	10	75	6	■
KM2ED0250L100S06	2.5	10	100	6	□
KM2ED0300L075S03	3	12	75	3	□
KM2ED0300L075S04	3	12	75	4	■
KM2ED0300L100S04	3	12	100	4	■
KM2ED0300L075S06	3	12	75	6	■
KM2ED0300L100S06	3	12	100	6	□
KM2ED0400L075S04	4	15	75	4	■
KM2ED0400L100S04	4	15	100	4	■
KM2ED0400L075S06	4	15	75	6	■
KM2ED0400L100S06	4	15	100	6	□
KM2ED0500L075S05	5	20	75	5	□
KM2ED0500L075S06	5	20	75	6	■
KM2ED0500L100S06	5	20	100	6	■
KM2ED0600L075S06	6	25	75	6	■
KM2ED0600L100S06	6	25	100	6	■
KM2ED0800L075S08	8	30	75	8	■
KM2ED0800L100S08	8	30	100	8	■
KM2ED1000L100S10	10	40	100	10	■
KM2ED1000L150S10	10	40	150	10	■
KM2ED1200L100S12	12	45	100	12	■
KM2ED1200L150S12	12	45	150	12	■
KM2ED1600L150S16	16	50	150	16	■
KM2ED1600L200S16	16	50	200	16	■
KM2ED2000L150S20	20	60	150	20	■
KM2ED2000L200S20	20	80	200	20	□
KM2ED2500L150S25	25	70	150	25	□
KM2ED2500L200S25	25	80	200	25	□

■大量库存 (Large Stock) ■少量库存 (Low Stock) □需要订制 (Customized)

# KM-ED

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.

## KM-BRL 3 刃铣刀 / 3 Flutes End End Mills



Product model 产品型号	Diameter 直径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM3ED0100S04	1	3	50	4	□
KM3ED0100S06	1	3	50	6	□
KM3ED0150S04	1.5	4	50	4	□
KM3ED0150S06	1.5	4	50	6	□
KM3ED0200S04	2	6	50	4	□
KM3ED0200S06	2	6	50	6	□
KM3ED0250S04	2.5	8	50	4	□
KM3ED0250S06	2.5	8	50	6	□
KM3ED0300S04	3	8	50	4	□
KM3ED0300S06	3	9	50	6	□
KM3ED0400S04	4	12	50	4	□
KM3ED0400S06	4	12	50	6	□
KM3ED0500S06	5	15	50	6	□
KM3ED0600S06	6	15	50	6	□
KM3ED0700S08	7	20	60	8	□
KM3ED0800S08	8	20	60	8	□
KM3ED0900S10	9	30	75	10	□
KM3ED1000S10	10	30	75	10	□
KM3ED1100S12	11	30	75	12	□
KM3ED1200S12	12	30	75	12	□
KM3ED1400S14	14	32	100	14	□
KM3ED1600S16	16	45	100	16	□
KM3ED2000S20	20	45	100	20	□
KM3ED2500S20	25	45	100	25	□

■大量库存 (Large Stock) ■少量库存 (Low Stock) □需要订制 (Customized)



# KM-ED

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.



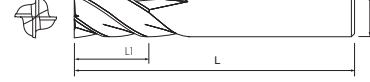
## KM-BRL 3 刃加长铣刀 / 3 Flutes Lengthen End Mills

Product model 产品型号	Diameter 直径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM3ED0100L075S04	1	4	75	4	□
KM3ED0100L100S04	1	4	100	4	□
KM3ED0100L075S06	1	4	75	6	□
KM3ED0100L100S06	1	4	100	6	□
KM3ED0150L075S04	1.5	6	75	4	□
KM3ED0150L100S04	1.5	6	100	4	□
KM3ED0150L075S06	1.5	6	75	6	□
KM3ED0150L100S06	1.5	6	100	6	□
KM3ED0200L075S04	2	8	75	4	□
KM3ED0200L100S04	2	8	100	4	□
KM3ED0200L075S06	2	8	75	6	□
KM3ED0200L100S06	2	8	100	6	□
KM3ED0250L075S04	2.5	10	75	4	□
KM3ED0250L100S04	2.5	10	100	4	□
KM3ED0250L075S06	2.5	10	75	6	□
KM3ED0250L100S06	2.5	10	100	6	□
KM3ED0300L075S03	3	12	75	3	□
KM3ED0300L075S04	3	12	75	4	□
KM3ED0300L100S04	3	12	100	4	□
KM3ED0300L075S06	3	12	75	6	□
KM3ED0300L100S06	3	12	100	6	□
KM3ED0400L075S04	4	15	75	4	□
KM3ED0400L100S04	4	15	100	4	□
KM3ED0400L075S06	4	15	75	6	□
KM3ED0400L100S06	4	15	100	6	□
KM3ED0500L075S05	5	20	75	5	□
KM3ED0500L075S06	5	20	75	6	□
KM3ED0500L100S06	5	20	100	6	□
KM3ED0600L075S06	6	25	75	6	□
KM3ED0600L100S06	6	25	100	6	□
KM3ED0800L075S08	8	30	75	8	□
KM3ED0800L100S08	8	30	100	8	□
KM3ED1000L100S10	10	40	100	10	□
KM3ED1000L150S10	10	40	150	10	□
KM3ED1200L100S12	12	45	100	12	□
KM3ED1200L150S12	12	45	150	12	□
KM3ED1600L150S16	16	50	150	16	□
KM3ED1600L200S16	16	50	200	16	□
KM3ED2000L150S20	20	60	150	20	□
KM3ED2000L200S20	20	80	200	20	□
KM3ED2500L150S25	25	70	150	25	□
KM3ED2500L200S25	25	80	200	25	□

■ 大量库存 (Large Stock) ■ 少量库存 (Low Stock) □ 需要订制 (Customized)

# KM-ED

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.



## KM-BRL 4 刃铣刀 / 4 Flutes End Mills

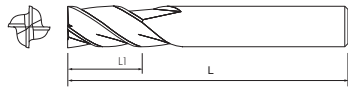
Product model 产品型号	Diameter 直径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM4ED0100S04	1	3	50	4	■
KM4ED0100S06	1	3	50	6	■
KM4ED0150S04	1.5	4	50	4	■
KM4ED0150S06	1.5	4	50	6	■
KM4ED0200S04	2	6	50	4	■
KM4ED0200S06	2	6	50	6	■
KM4ED0250S04	2.5	8	50	4	■
KM4ED0250S06	2.5	8	50	6	■
KM4ED0300S04	3	8	50	4	■
KM4ED0300S06	3	9	50	6	■
KM4ED0400S04	4	12	50	4	■
KM4ED0400S06	4	12	50	6	■
KM4ED0500S06	5	15	50	6	■
KM4ED0600S06	6	15	50	6	■
KM4ED0700S08	7	20	60	8	■
KM4ED0800S08	8	20	60	8	■
KM4ED0900S10	9	30	75	10	■
KM4ED1000S10	10	30	75	10	■
KM4ED1100S12	11	30	75	12	■
KM4ED1200S12	12	30	75	12	■
KM4ED1400S14	14	32	100	14	■
KM4ED1600S16	16	45	100	16	■
KM4ED2000S20	20	45	100	20	■
KM4ED2500S20	25	45	100	25	□

■ 大量库存 (Large Stock) ■ 少量库存 (Low Stock) □ 需要订制 (Customized)



# KM-ED

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.



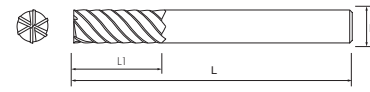
## KM-BRL 4 刃加长铣刀 / 4 Flutes Lengthen End Mills

Product model 产品型号	Diameter 直径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM4ED0100L075S04	1	4	75	4	■
KM4ED0100L100S04	1	4	100	4	■
KM4ED0100L075S06	1	4	75	6	■
KM4ED0100L100S06	1	4	100	6	□
KM4ED0150L075S04	1.5	6	75	4	■
KM4ED0150L100S04	1.5	6	100	4	■
KM4ED0150L075S06	1.5	6	75	6	■
KM4ED0150L100S06	1.5	6	100	6	□
KM4ED0200L075S04	2	8	75	4	■
KM4ED0200L100S04	2	8	100	4	■
KM4ED0200L075S06	2	8	75	6	■
KM4ED0200L100S06	2	8	100	6	□
KM4ED0250L075S04	2.5	10	75	4	■
KM4ED0250L100S04	2.5	10	100	4	■
KM4ED0250L075S06	2.5	10	75	6	■
KM4ED0250L100S06	2.5	10	100	6	□
KM4ED0300L075S03	3	12	75	3	□
KM4ED0300L075S04	3	12	75	4	■
KM4ED0300L100S04	3	12	100	4	■
KM4ED0300L075S06	3	12	75	6	■
KM4ED0300L100S06	3	12	100	6	□
KM4ED0400L075S04	4	15	75	4	■
KM4ED0400L100S04	4	15	100	4	■
KM4ED0400L075S06	4	15	75	6	■
KM4ED0400L100S06	4	15	100	6	□
KM4ED0500L075S05	5	20	75	5	□
KM4ED0500L075S06	5	20	75	6	■
KM4ED0500L100S06	5	20	100	6	■
KM4ED0600L075S06	6	25	75	6	■
KM4ED0600L100S06	6	25	100	6	■
KM4ED0800L075S08	8	30	75	8	■
KM4ED0800L100S08	8	30	100	8	■
KM4ED1000L100S10	10	40	100	10	■
KM4ED1000L150S10	10	40	150	10	■
KM4ED1200L100S12	12	45	100	12	■
KM4ED1200L150S12	12	45	150	12	■
KM4ED1600L150S16	16	50	150	16	■
KM4ED1600L200S16	16	50	200	16	■
KM4ED2000L150S20	20	60	150	20	■
KM4ED2000L200S20	20	80	200	20	□
KM4ED2500L150S25	25	70	150	25	□
KM4ED2500L200S25	25	80	200	25	□

■ 大量库存 (Large Stock) ■ 少量库存 (Low Stock) □ 需要订制 (Customized)

# KM-ED

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.



## KM-BRL 6 刃铣刀 / 6 Flutes End Mills

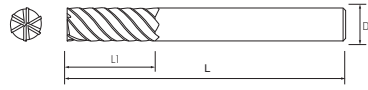
Product model 产品型号	Diameter 直径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM6ED0400S04	4	12	50	4	□
KM6ED0400S06	4	12	50	6	□
KM6ED0500S06	5	15	50	6	□
KM6ED0600S06	6	15	50	6	□
KM6ED0700S08	7	20	60	8	□
KM6ED0800S08	8	20	60	8	□
KM6ED0900S10	9	30	75	10	□
KM6ED1000S10	10	30	75	10	□
KM6ED1100S12	11	30	75	12	□
KM6ED1200S12	12	30	75	12	□
KM6ED1400S14	14	32	100	14	□
KM6ED1600S16	16	45	100	16	□
KM6ED2000S20	20	45	100	20	□
KM6ED2500S20	25	45	100	25	□

■ 大量库存 (Large Stock) ■ 少量库存 (Low Stock) □ 需要订制 (Customized)

# KM-ED

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015

碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○



### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.

## KM-BRL 6 刃加长铣刀 / 6 Flutes Lengthen End Mills



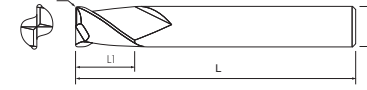
Product model 产品型号	Diameter 直径	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM6ED0400L075S04	4	15	75	4	□
KM6ED0400L100S04	4	15	100	4	□
KM6ED0400L075S06	4	15	75	6	□
KM6ED0400L100S06	4	15	100	6	□
KM6ED0500L075S05	5	20	75	5	□
KM6ED0500L075S06	5	20	75	6	□
KM6ED0500L100S06	5	20	100	6	□
KM6ED0600L075S06	6	25	75	6	□
KM6ED0600L100S06	6	25	100	6	□
KM6ED0800L075S08	8	30	75	8	□
KM6ED0800L100S08	8	30	100	8	□
KM6ED1000L100S10	10	40	100	10	□
KM6ED1000L150S10	10	40	150	10	□
KM6ED1200L100S12	12	45	100	12	□
KM6ED1200L150S12	12	45	150	12	□
KM6ED1600L150S16	16	50	150	16	□
KM6ED1600L200S16	16	50	200	16	□
KM6ED2000L150S20	20	60	150	20	□
KM6ED2000L200S20	20	80	200	20	□
KM6ED2500L150S25	25	70	150	25	□
KM6ED2500L200S25	25	80	200	25	□

■ 大量库存 (Large Stock)    ▣ 少量库存 (Low Stock)    □ 需要订制 (Customized)

# KM-BD

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015

碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○



### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.

## KM-BD 2 刃圆鼻铣刀 / 2 Flutes Corner Radius End Mills

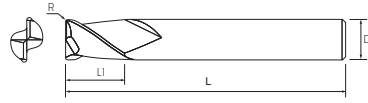


Product model 产品型号	Diameter 直径	Corner Radius 圆鼻	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM2BD0100R010S04	1	R0.1	3	50	4	▣
KM2BD0100R020S04	1	R0.2	3	50	4	■
KM2BD0150R020S04	1.5	R0.2	3	50	4	▣
KM2BD0200R010S04	2	R0.1	5	50	4	▣
KM2BD0200R020S04	2	R0.2	5	50	4	■
KM2BD0200R030S04	2	R0.3	5	50	4	▣
KM2BD0200R050S04	2	R0.5	5	50	4	▣
KM2BD0250R010S04	2.5	R0.1	6	50	4	▣
KM2BD0250R020S04	2.5	R0.2	6	50	4	■
KM2BD0250R030S04	2.5	R0.3	6	50	4	▣
KM2BD0250R050S04	2.5	R0.5	6	50	4	■
KM2BD0300R010S04	3	R0.1	7.5	50	4	▣
KM2BD0300R020S04	3	R0.2	7.5	50	4	■
KM2BD0300R030S04	3	R0.3	7.5	50	4	▣
KM2BD0300R050S04	3	R0.5	7.5	50	4	■
KM2BD0300R100S04	3	R1.0	7.5	50	4	▣
KM2BD0400R010S04	4	R0.1	10	50	4	▣
KM2BD0400R020S04	4	R0.2	10	50	4	■
KM2BD0400R030S04	4	R0.3	10	50	4	▣
KM2BD0400R050S04	4	R0.5	10	50	4	■
KM2BD0400R100S04	4	R1.0	10	50	4	▣
KM2BD0500R020S06	5	R0.2	13	50	6	■
KM2BD0500R030S06	5	R0.3	13	50	6	▣
KM2BD0500R050S06	5	R0.5	13	50	6	■
KM2BD0500R100S06	5	R1.0	13	50	6	▣
KM2BD0600R020S06	6	R0.2	15	50	6	▣
KM2BD0600R030S06	6	R0.3	15	50	6	▣
KM2BD0600R050S06	6	R0.5	15	50	6	■
KM2BD0600R100S06	6	R1.0	15	50	6	▣
KM2BD0600R150S06	6	R1.5	15	50	6	▣
KM2BD0600R200S06	6	R2.0	15	50	6	□
KM2BD0800R020S08	8	R0.2	20	60	8	▣
KM2BD0800R050S08	8	R0.5	20	60	8	■
KM2BD0800R100S08	8	R1.0	20	60	8	■
KM2BD0800R150S08	8	R1.5	20	60	8	▣
KM2BD0800R200S08	8	R2.0	20	60	8	▣
KM2BD0800R250S08	8	R2.5	20	60	8	□
KM2BD1000R020S10	10	R0.2	25	75	10	□
KM2BD1000R050S10	10	R0.5	25	75	10	■
KM2BD1000R100S10	10	R1.0	25	75	10	■
KM2BD1000R150S10	10	R1.5	25	75	10	▣

■ 大量库存 (Large Stock)    ▣ 少量库存 (Low Stock)    □ 需要订制 (Customized)

# KM-BD

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.



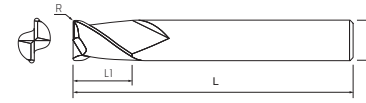
## KM-BD 2 刃圆鼻铣刀 / 2 Flutes Corner Radius End Mills

Product model 产品型号	Diameter 直径	Corner Radius 圆鼻	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM2BD1000R200S10	10	R2.0	25	75	10	■
KM2BD1000R250S10	10	R2.5	25	75	10	■
KM2BD1200R020S12	12	R0.2	30	75	12	■
KM2BD1200R050S12	12	R0.5	30	75	12	■
KM2BD1200R100S12	12	R1.0	30	75	12	■
KM2BD1200R150S12	12	R1.5	30	75	12	■
KM2BD1200R200S12	12	R2.0	30	75	12	■
KM2BD1200R250S12	12	R2.5	30	75	12	□
KM2BD1200R300S12	12	R3.0	30	75	12	□
KM2BD1600R020S16	16	R0.2	40	100	16	■
KM2BD1600R050S16	16	R0.5	40	100	16	■
KM2BD1600R100S16	16	R1.0	40	100	16	■
KM2BD1600R150S16	16	R1.5	40	100	16	■
KM2BD1600R200S16	16	R2.0	40	100	16	■
KM2BD1600R250S16	16	R2.5	40	100	16	□
KM2BD1600R300S16	16	R3.0	40	100	16	□

■大量库存 (Large Stock) ■少量库存 (Low Stock) □需要订制 (Customized)

# KM-BD

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.



## KM-BD 2 刃加长圆鼻铣刀 / 2 Flutes Length Corner Radius End Mills

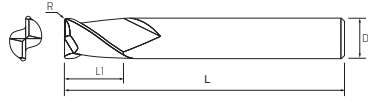
Product model 产品型号	Diameter 直径	Corner Radius 圆鼻	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM2BD0300R020L075S06	3	R0.2	7.5	75	6	■
KM2BD0300R030L075S06	3	R0.3	7.5	75	6	■
KM2BD0300R050L075S06	3	R0.5	7.5	75	6	■
KM2BD0300R100L075S06	3	R1.0	7.5	75	6	■
KM2BD0400R010L075S06	4	R0.1	10	75	6	■
KM2BD0400R020L075S06	4	R0.2	10	75	6	■
KM2BD0400R030L075S06	4	R0.3	10	75	6	■
KM2BD0400R050L075S06	4	R0.5	10	75	6	■
KM2BD0400R100L075S06	4	R1.0	10	75	6	■
KM2BD0500R020L075S06	5	R0.2	13	75	6	■
KM2BD0500R030L075S06	5	R0.3	13	75	6	■
KM2BD0500R050L075S06	5	R0.5	13	75	6	■
KM2BD0500R100L075S06	5	R1.0	13	75	6	■
KM2BD0600R020L075S06	6	R0.2	15	75	6	■
KM2BD0600R030L075S06	6	R0.3	15	75	6	■
KM2BD0600R050L075S06	6	R0.5	15	75	6	■
KM2BD0600R100L075S06	6	R1.0	15	75	6	■
KM2BD0600R150L075S06	6	R1.5	15	75	6	■
KM2BD0600R200L075S06	6	R2.0	15	75	6	■
KM2BD0800R020L075S08	8	R0.2	20	75	8	■
KM2BD0800R050L075S08	8	R0.5	20	75	8	■
KM2BD0800R100L075S08	8	R1.0	20	75	8	■
KM2BD0800R150L075S08	8	R1.5	20	75	8	■
KM2BD0800R200L075S08	8	R2.0	20	75	8	■
KM2BD0800R250L075S08	8	R2.5	20	75	8	■
KM2BD0300R020L100S06	3	R0.2	7.5	100	6	■
KM2BD0300R030L100S06	3	R0.3	7.5	100	6	■
KM2BD0300R050L100S06	3	R0.5	7.5	100	6	■
KM2BD0300R100L100S06	3	R1.0	7.5	100	6	■
KM2BD0400R010L100S06	4	R0.1	10	100	6	■
KM2BD0400R020L100S06	4	R0.2	10	100	6	■
KM2BD0400R030L100S06	4	R0.3	10	100	6	■
KM2BD0400R050L100S06	4	R0.5	10	100	6	■
KM2BD0400R100L100S06	4	R1.0	10	100	6	■
KM2BD0500R020L100S06	5	R0.2	13	100	6	■
KM2BD0500R030L100S06	5	R0.3	13	100	6	■
KM2BD0500R050L100S06	5	R0.5	13	100	6	■
KM2BD0500R100L100S06	5	R1.0	13	100	6	■
KM2BD0600R020L100S06	6	R0.2	15	100	6	■
KM2BD0600R030L100S06	6	R0.3	15	100	6	■
KM2BD0600R050L100S06	6	R0.5	15	100	6	■

■大量库存 (Large Stock) ■少量库存 (Low Stock) □需要订制 (Customized)

# KM-BD

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015

碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○



### 中硬度钢 (HRC50)

- 含硅涂层处理，耐磨性极佳。
- 高精度公差控制，适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm)，高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.



## KM-BD 2刃加长圆鼻铣刀 / 2 Flutes Length Corner Radius End Mills

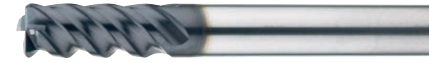
Product model 产品型号	Diameter 直径	Corner Radius 圆鼻	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM2BD0600R100L100S06	6	R1.0	15	100	6	■
KM2BD0600R150L100S06	6	R1.5	15	100	6	■
KM2BD0600R200L100S06	6	R2.0	15	100	6	■
KM2BD0800R020L100S08	8	R0.2	20	100	8	■
KM2BD0800R050L100S08	8	R0.5	20	100	8	■
KM2BD0800R100L100S08	8	R1.0	20	100	8	■
KM2BD0800R150L100S08	8	R1.5	20	100	8	■
KM2BD0800R200L100S08	8	R2.0	20	100	8	■
KM2BD0800R250L100S08	8	R2.5	20	100	8	■
KM2BD1000R020L100S10	10	R0.2	25	100	10	■
KM2BD1000R050L100S10	10	R0.5	25	100	10	■
KM2BD1000R100L100S10	10	R1.0	25	100	10	■
KM2BD1000R150L100S10	10	R1.5	25	100	10	■
KM2BD1000R200L100S10	10	R2.0	25	100	10	■
KM2BD1000R250L100S10	10	R2.5	25	100	10	■
KM2BD1200R020L100S12	12	R0.2	30	100	12	■
KM2BD1200R050L100S12	12	R0.5	30	100	12	■
KM2BD1200R100L100S12	12	R1.0	30	100	12	■
KM2BD1200R150L100S12	12	R1.5	30	100	12	■
KM2BD1200R200L100S12	12	R2.0	30	100	12	■
KM2BD1200R250L100S12	12	R2.5	30	100	12	■
KM2BD1200R300L100S12	12	R3.0	30	100	12	■
KM2BD1600R050L150S16	16	R0.5	40	150	16	■
KM2BD1600R100L150S16	16	R1.0	40	150	16	■
KM2BD1600R150L150S16	16	R1.5	40	150	16	■
KM2BD1600R200L150S16	16	R2.0	40	150	16	■
KM2BD1600R250L150S16	16	R2.5	40	150	16	■
KM2BD1600R300L150S16	16	R3.0	40	150	16	■

■大量库存 (Large Stock) ■少量库存 (Low Stock) □需要订制 (Customized)

# KM-BD

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015

碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○



### 中硬度钢 (HRC50)

- 含硅涂层处理，耐磨性极佳。
- 高精度公差控制，适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm)，高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.



## KM-BD 4刃圆鼻铣刀 / 4 Flutes Corner Radius End Mills

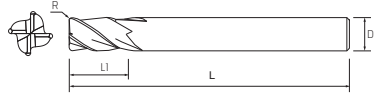
Product model 产品型号	Diameter 直径	Corner Radius 圆鼻	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM4BD0100R010S04	1	R0.1	3	50	4	■
KM4BD0100R020S04	1	R0.2	3	50	4	■
KM4BD0150R020S04	1.5	R0.2	3	50	4	■
KM4BD0200R010S04	2	R0.1	5	50	4	■
KM4BD0200R020S04	2	R0.2	5	50	4	■
KM4BD0200R030S04	2	R0.3	5	50	4	■
KM4BD0200R050S04	2	R0.5	5	50	4	■
KM4BD0250R010S04	2.5	R0.1	6	50	4	■
KM4BD0250R020S04	2.5	R0.2	6	50	4	■
KM4BD0250R030S04	2.5	R0.3	6	50	4	■
KM4BD0250R050S04	2.5	R0.5	6	50	4	■
KM4BD0300R010S04	3	R0.1	7.5	50	4	■
KM4BD0300R020S04	3	R0.2	7.5	50	4	■
KM4BD0300R030S04	3	R0.3	7.5	50	4	■
KM4BD0300R050S04	3	R0.5	7.5	50	4	■
KM4BD0300R100S04	3	R1.0	7.5	50	4	■
KM4BD0400R010S04	4	R0.1	10	50	4	■
KM4BD0400R020S04	4	R0.2	10	50	4	■
KM4BD0400R030S04	4	R0.3	10	50	4	■
KM4BD0400R050S04	4	R0.5	10	50	4	■
KM4BD0400R100S04	4	R1.0	10	50	4	■
KM4BD0500R020S06	5	R0.2	13	50	6	■
KM4BD0500R030S06	5	R0.3	13	50	6	■
KM4BD0500R050S06	5	R0.5	13	50	6	■
KM4BD0500R100S06	5	R1.0	13	50	6	■
KM4BD0600R020S06	6	R0.2	15	50	6	■
KM4BD0600R030S06	6	R0.3	15	50	6	■
KM4BD0600R050S06	6	R0.5	15	50	6	■
KM4BD0600R100S06	6	R1.0	15	50	6	■
KM4BD0600R150S06	6	R1.5	15	50	6	■
KM4BD0600R200S06	6	R2.0	15	50	6	□
KM4BD0800R020S08	8	R0.2	20	60	8	■
KM4BD0800R050S08	8	R0.5	20	60	8	■
KM4BD0800R100S08	8	R1.0	20	60	8	■
KM4BD0800R150S08	8	R1.5	20	60	8	■
KM4BD0800R200S08	8	R2.0	20	60	8	■
KM4BD0800R250S08	8	R2.5	20	60	8	□
KM4BD1000R020S10	10	R0.2	25	75	10	□
KM4BD1000R050S10	10	R0.5	25	75	10	■
KM4BD1000R100S10	10	R1.0	25	75	10	■
KM4BD1000R150S10	10	R1.5	25	75	10	■

■大量库存 (Large Stock) ■少量库存 (Low Stock) □需要订制 (Customized)



# KM-BD

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.

## KM-BD 4 刃圆鼻铣刀 / 4 Flutes Corner Radius End Mills

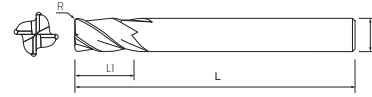


Product model 产品型号	Diameter 直径	Corner Radius 圆鼻	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM4BD1000R200S10	10	R2.0	25	75	10	■
KM4BD1000R250S10	10	R2.5	25	75	10	■
KM4BD1200R020S12	12	R0.2	30	75	12	■
KM4BD1200R050S12	12	R0.5	30	75	12	■
KM4BD1200R100S12	12	R1.0	30	75	12	■
KM4BD1200R150S12	12	R1.5	30	75	12	■
KM4BD1200R200S12	12	R2.0	30	75	12	■
KM4BD1200R250S12	12	R2.5	30	75	12	□
KM4BD1200R300S12	12	R3.0	30	75	12	□
KM4BD1600R020S16	16	R0.2	40	100	16	■
KM4BD1600R050S16	16	R0.5	40	100	16	■
KM4BD1600R100S16	16	R1.0	40	100	16	■
KM4BD1600R150S16	16	R1.5	40	100	16	■
KM4BD1600R200S16	16	R2.0	40	100	16	■
KM4BD1600R250S16	16	R2.5	40	100	16	□
KM4BD1600R300S16	16	R3.0	40	100	16	□

■ 大量库存 (Large Stock) ■ 少量库存 (Low Stock) □ 需要订制 (Customized)

# KM-BD

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015



碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○

### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.

## KM-BD 4 刃加长圆鼻铣刀 / 4 Flutes Length Corner Radius End Mills



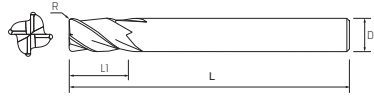
Product model 产品型号	Diameter 直径	Corner Radius 圆鼻	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM4BD0300R020L075S06	3	R0.2	7.5	75	6	■
KM4BD0300R030L075S06	3	R0.3	7.5	75	6	■
KM4BD0300R050L075S06	3	R0.5	7.5	75	6	■
KM4BD0300R100L075S06	3	R1.0	7.5	75	6	■
KM4BD0400R010L075S06	4	R0.1	10	75	6	■
KM4BD0400R020L075S06	4	R0.2	10	75	6	■
KM4BD0400R030L075S06	4	R0.3	10	75	6	■
KM4BD0400R050L075S06	4	R0.5	10	75	6	■
KM4BD0400R100L075S06	4	R1.0	10	75	6	■
KM4BD0500R020L075S06	5	R0.2	13	75	6	■
KM4BD0500R030L075S06	5	R0.3	13	75	6	■
KM4BD0500R050L075S06	5	R0.5	13	75	6	■
KM4BD0500R100L075S06	5	R1.0	13	75	6	■
KM4BD0600R020L075S06	6	R0.2	15	75	6	■
KM4BD0600R030L075S06	6	R0.3	15	75	6	■
KM4BD0600R050L075S06	6	R0.5	15	75	6	■
KM4BD0600R100L075S06	6	R1.0	15	75	6	■
KM4BD0600R150L075S06	6	R1.5	15	75	6	■
KM4BD0600R200L075S06	6	R2.0	15	75	6	■
KM4BD0800R020L075S08	8	R0.2	20	75	8	■
KM4BD0800R050L075S08	8	R0.5	20	75	8	■
KM4BD0800R100L075S08	8	R1.0	20	75	8	■
KM4BD0800R150L075S08	8	R1.5	20	75	8	■
KM4BD0800R200L075S08	8	R2.0	20	75	8	■
KM4BD0800R250L075S08	8	R2.5	20	75	8	■
KM4BD0300R020L100S06	3	R0.2	7.5	100	6	■
KM4BD0300R030L100S06	3	R0.3	7.5	100	6	■
KM4BD0300R050L100S06	3	R0.5	7.5	100	6	■
KM4BD0300R100L100S06	3	R1.0	7.5	100	6	■
KM4BD0400R010L100S06	4	R0.1	10	100	6	■
KM4BD0400R020L100S06	4	R0.2	10	100	6	■
KM4BD0400R030L100S06	4	R0.3	10	100	6	■
KM4BD0400R050L100S06	4	R0.5	10	100	6	■
KM4BD0400R100L100S06	4	R1.0	10	100	6	■
KM4BD0500R020L100S06	5	R0.2	13	100	6	■
KM4BD0500R030L100S06	5	R0.3	13	100	6	■
KM4BD0500R050L100S06	5	R0.5	13	100	6	■
KM4BD0500R100L100S06	5	R1.0	13	100	6	■
KM4BD0600R020L100S06	6	R0.2	15	100	6	■
KM4BD0600R030L100S06	6	R0.3	15	100	6	■
KM4BD0600R050L100S06	6	R0.5	15	100	6	■

■ 大量库存 (Large Stock) ■ 少量库存 (Low Stock) □ 需要订制 (Customized)

# KM-BD

直径 Diameter D (mm)	公差 Tolerance(mm)
R0.25<D<R6	0 ~ -0.01
D>R6	0 ~ -0.015

碳钢、合金钢 (<35 HRC) Carbon Steel, Alloy Steel (<35 HRC)	合金钢 (≥40 HRC) Alloy Steel, Tool Steel (≥40 HRC)	淬硬钢 (40~50 HRC) Hardened Steel (40~50 HRC)	淬硬钢 (50~60 HRC) Hardened Steel (50~60 HRC)	钛合金 Titanium alloy	不锈钢 Stainless steel	铝合金 Aluminium alloy	石墨 Graphite
●	●	●	●	○	○	○	○



### 中硬度钢 (HRC50)

- 含硅涂层处理, 耐磨性极佳。
- 高精度公差控制, 适合超精密加工。
- 卓越的刃部光洁度使被加工材料的表面光洁度非常优秀。
- 采用超微粒子超硬合金 (0.5μm), 高速加工时发挥出色性能。

### Endmills for pre-hardened and hardened steel (HRC50)

- Good wear resistance by TiTiN coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Outstanding performance at high speed machining by ultra fine (0.5μm) WC grade.



## KM-BD 4 刃加长圆鼻铣刀 / 4 Flutes Length Corner Radius End Mills

Product model 产品型号	Diameter 直径	Corner Radius 圆鼻	Length of Cut 刃长	Overall length 全长	Shank diameter 柄径	Stock 库存情况
KM4BD0600R100L100S06	6	R1.0	15	100	6	■
KM4BD0600R150L100S06	6	R1.5	15	100	6	■
KM4BD0600R200L100S06	6	R2.0	15	100	6	■
KM4BD0800R20L100S08	8	R0.2	20	100	8	■
KM4BD0800R050L100S08	8	R0.5	20	100	8	■
KM4BD0800R100L100S08	8	R1.0	20	100	8	■
KM4BD0800R150L100S08	8	R1.5	20	100	8	■
KM4BD0800R200L100S08	8	R2.0	20	100	8	■
KM4BD0800R250L100S08	8	R2.5	20	100	8	■
KM4BD1000R020L100S10	10	R0.2	25	100	10	■
KM4BD1000R050L100S10	10	R0.5	25	100	10	■
KM4BD1000R100L100S10	10	R1.0	25	100	10	■
KM4BD1000R150L100S10	10	R1.5	25	100	10	■
KM4BD1000R200L100S10	10	R2.0	25	100	10	■
KM4BD1000R250L100S10	10	R2.5	25	100	10	■
KM4BD1200R020L100S12	12	R0.2	30	100	12	■
KM4BD1200R050L100S12	12	R0.5	30	100	12	■
KM4BD1200R100L100S12	12	R1.0	30	100	12	■
KM4BD1200R150L100S12	12	R1.5	30	100	12	■
KM4BD1200R200L100S12	12	R2.0	30	100	12	■
KM4BD1200R250L100S12	12	R2.5	30	100	12	■
KM4BD1200R300L100S12	12	R3.0	30	100	12	■
KM4BD1600R050L150S16	16	R0.5	40	150	16	■
KM4BD1600R100L150S16	16	R1.0	40	150	16	■
KM4BD1600R150L150S16	16	R1.5	40	150	16	■
KM4BD1600R200L150S16	16	R2.0	40	150	16	■
KM4BD1600R250L150S16	16	R2.5	40	150	16	■
KM4BD1600R300L150S16	16	R3.0	40	150	16	■

■ 大量库存 (Large Stock)    ■ 少量库存 (Low Stock)    □ 需要订制 (Customized)

# KM-PARAMETER

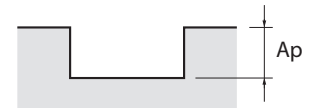
## OSK-KM 系列常用刀具切削参数参考表

### Reference table for cutting parameters of osk-km series common cutting tools

#### KM2ED&KM4ED

刀具规格 Tool specification (mm)	合金钢 HRC30~40 Alloy steel HRC30~40				预硬钢 HRC40~50 Pre hardened steel HRC40~50			
	转速 (S) RPM	进给 (F) FEED	切深 (AP) mm	切宽 (AE) mm	转速 (S) RPM	进给 (F) FEED	切深 (AP) mm	切宽 (AE) mm
D0.5	25000	800	0.02~0.03	0.03~0.6	20000	800	0.02~0.03	0.03~0.6
D1	20000	1000	0.03~0.04	0.03~1.0	18000	1000	0.03~0.04	0.03~1.0
D1.5	18000	1200	0.04~0.05	0.04~1.5	17000	1200	0.04~0.05	0.04~1.5
D2	17000	1500	0.04~0.06	0.04~2.0	16000	1500	0.04~0.06	0.04~2.0
D3	16000	1600	0.05~0.08	0.05~3.0	15000	1600	0.05~0.08	0.05~3.0
D4	13000	1800	0.05~0.1	0.06~4.0	12000	1800	0.05~0.1	0.06~4.0
D6	9000	2000	0.05~0.2	0.08~6.0	8000	2000	0.05~0.2	0.08~6.0
D8	8000	2200	0.06~0.3	0.1~8.0	7000	2200	0.06~0.3	0.08~8.0
D10	6000	2400	0.08~0.5	0.12~10.0	5500	2400	0.06~0.4	0.1~10.0
D12	5500	2800	0.08~0.6	0.14~12.0	5000	2600	0.08~0.5	0.12~12.0
D14	4500	3000	0.1~0.7	0.16~14.0	4200	2800	0.1~0.6	0.14~14.0
D16	4000	3400	0.12~0.8	0.18~16.0	3800	3000	0.12~0.7	0.16~16.0
D20	3200	3600	0.15~1.0	0.2~20.0	3000	3200	0.15~0.8	0.18~20.0
D25	2800	4000	0.18~1.2	0.24~25.0	2500	3500	0.18~1.0	0.2~25.0

加工方式  
Processing mode



每齿进给 (FZ)= 进给 (F)÷ 转速 (S)÷ 刀具刃数 (Z)

线速 (V)= 转速 (S)×3.14 (圆周率) × 刀具直径 (D)÷1000

以上所有参数值仅为精修和半精修建议参数表, 进给值根据客户的切深切宽数值作适当调整。

同等规格的参数在不同材质、不同机台性能和不同环境下, 加工的参数一般是不一样的, 正常情况下客户需要根据自身现场工况来进行适当的调整, 谢谢!

FZ (mm/t)= feed/teeth=F/S/T

Vs(m/min)=RPM\*3.14\*D/1000

The above data is taken for reference when finishing & semi-finishing. F need to be adjusted according to ap & ae.

The cutting data is to be selected by the material, MTB, workpiece, fixture & machining strategy. It could be optimized & adjusted accordingly.

代码编号: 转速 =S 进给 =F 刀具直径 =D 每齿进给 =FZ 线速度 =V 刀具刃数 =Z 圆周率 =3.14 常数 =1000

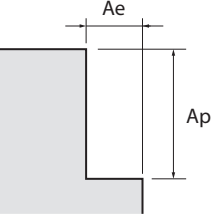
S= RPM, F = Feed, D=Diameter, FZ= Feed/teeth, V= m/min, Z= Teeth,

OSK-KM 系列常用刀具切削参数参考表

Reference table for cutting parameters of osk-km series common cutting tools

KM2ED&KM4ED								
刀具规格 Tool specification (mm)	合金钢 HRC30~40 Alloy steel HRC30~40				预硬钢 HRC40~50 Pre hardened steel HRC40~50			
	转速 (S) RPM	进给 (F) FEED	切深 (AP) mm	切宽 (AE) mm	转速 (S) RPM	进给 (F) FEED	切深 (AP) mm	切宽 (AE) mm
D0.5	12000	100	0.1D~2.5D	0.01D~0.03D	10000	80	0.1D~2.5D	0.01D~0.02D
D1	8000	120	0.1D~2.5D	0.01D~0.03D	7500	100	0.1D~2.5D	0.01D~0.02D
D1.5	7000	130	0.1D~2.5D	0.01D~0.03D	6500	120	0.1D~2.5D	0.01D~0.02D
D2	6000	150	0.1D~2.5D	0.01D~0.03D	5500	130	0.1D~2.5D	0.01D~0.02D
D3	5000	180	0.1D~2.5D	0.01D~0.03D	4800	160	0.1D~2.5D	0.01D~0.02D
D4	4200	220	0.1D~2.5D	0.01D~0.03D	4000	200	0.1D~2.5D	0.01D~0.02D
D6	3000	260	0.1D~2.5D	0.01D~0.03D	2800	240	0.1D~2.5D	0.01D~0.02D
D8	2600	300	0.1D~2.5D	0.01D~0.03D	2400	260	0.1D~2.5D	0.01D~0.02D
D10	2400	320	0.1D~2.5D	0.01D~0.03D	2200	300	0.1D~2.5D	0.01D~0.02D
D12	2200	340	0.1D~2.5D	0.01D~0.03D	2000	320	0.1D~2.5D	0.01D~0.02D
D14	2000	360	0.1D~2.5D	0.01D~0.03D	1800	340	0.1D~2.5D	0.01D~0.02D
D16	1800	380	0.1D~2.5D	0.01D~0.03D	1600	360	0.1D~2.5D	0.01D~0.02D
D20	1600	400	0.1D~2.5D	0.01D~0.03D	1400	380	0.1D~2.5D	0.01D~0.02D
D25	1200	420	0.1D~2.5D	0.01D~0.03D	1000	400	0.1D~2.5D	0.01D~0.02D

加工方式 Processing mode	
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每齿进给 (FZ)= 进给 (F)÷ 转速 (S)÷ 刀具刃数 (Z)  
 线速 (V)= 转速 (S)×3.14 (圆周率) × 刀具直径 (D)÷1000  
 以上所有参数值仅为精修和半精修建议参数表, 进给值根据客户的切深切宽数值作适当调整。  
 同等规格的参数在不同材质、不同机台性能和不同环境下, 加工的参数是不一样的, 正常情况下客户需要根据自身现场工况来进行适当的调整, 谢谢!

FZ (mm/t)= feed/teeth=F/S/T  
 Vs(m/min)=RPM\*3.14\*D/1000  
 The above data is taken for reference when finishing & semi-finishing. F need to be adjusted according to ap & ae.  
 The cutting data is to be selected by the material, MTB, workpiece, fixture & machining strategy. It could be optimized & adjusted accordingly.

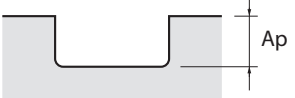
代码编号: 转速=S 进给=F 刀具直径=D 每齿进给=FZ 线速度=V 刀具刃数=Z 圆周率=3.14 常数=1000  
 S= RPM, F = Feed, D=Diameter, FZ= Feed/teeth, V= m/min, Z= Teeth,

OSK-KM 系列常用刀具切削参数参考表

Reference table for cutting parameters of osk-km series common cutting tools

KM2BD&KM4BD								
刀具规格 Tool specification (mm)	合金钢 HRC30~40 Alloy steel HRC30~40				预硬钢 HRC40~50 Pre hardened steel HRC40~50			
	转速 (S) RPM	进给 (F) FEED	切深 (AP) mm	切宽 (AE) mm	转速 (S) RPM	进给 (F) FEED	切深 (AP) mm	切宽 (AE) mm
D1RXX	18000	1200	0.03~0.06	0.03~1.0	17000	1000	0.03~0.05	0.03~1.0
D1.5RXX	17000	1500	0.04~0.08	0.04~1.5	16000	1400	0.04~0.07	0.04~1.5
D2RXX	16000	1600	0.04~0.1	0.04~2.0	15000	1500	0.04~0.08	0.04~2.0
D3RXX	15000	1800	0.05~0.2	0.05~3.0	14000	1600	0.05~0.1	0.05~3.0
D4RXX	13000	2000	0.06~0.25	0.06~4.0	12000	1800	0.05~0.2	0.06~4.0
D6RXX	8500	2200	0.08~0.3	0.08~6.0	8000	2000	0.06~0.25	0.08~6.0
D8RXX	7000	2400	0.1~0.4	0.09~8.0	6500	2200	0.08~0.3	0.09~8.0
D10RXX	6000	2400	0.12~0.5	0.1~10.0	5500	2400	0.1~0.4	0.1~10.0
D12R1	5500	2800	0.14~0.6	0.12~12.0	5000	2600	0.12~0.5	0.12~12.0
D14R1	4500	3000	0.16~0.7	0.14~14.0	4200	2800	0.14~0.6	0.14~14.0
D16R1	4000	3400	0.18~0.8	0.16~16.0	3800	3000	0.16~0.7	0.16~16.0

加工方式 Processing mode	
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每齿进给 (FZ)= 进给 (F)÷ 转速 (S)÷ 刀具刃数 (Z)  
 线速 (V)= 转速 (S)×3.14 (圆周率) × 刀具直径 (D)÷1000  
 以上所有参数值仅为精修和半精修建议参数表, 进给值根据客户的切深切宽数值作适当调整。  
 同等规格的参数在不同材质、不同机台性能和不同环境下, 加工的参数是不一样的, 正常情况下客户需要根据自身现场工况来进行适当的调整, 谢谢!

FZ (mm/t)= feed/teeth=F/S/T  
 Vs(m/min)=RPM\*3.14\*D/1000  
 The above data is taken for reference when finishing & semi-finishing. F need to be adjusted according to ap & ae.  
 The cutting data is to be selected by the material, MTB, workpiece, fixture & machining strategy. It could be optimized & adjusted accordingly.

代码编号: 转速=S 进给=F 刀具直径=D 每齿进给=FZ 线速度=V 刀具刃数=Z 圆周率=3.14 常数=1000  
 S= RPM, F = Feed, D=Diameter, FZ= Feed/teeth, V= m/min, Z= Teeth,

OSK-KM 系列常用刀具切削参数参考表

Reference table for cutting parameters of osk-km series common cutting tools

KM2BD&KM4BD								
刀具规格 Tool specification (mm)	合金钢 HRC30~40 Alloy steel HRC30~40				预硬钢 HRC40~50 Pre hardened steel HRC40~50			
	转速 (S) RPM	进给 (F) FEED	切深 (AP) mm	切宽 (AE) mm	转速 (S) RPM	进给 (F) FEED	切深 (AP) mm	切宽 (AE) mm
D1R0.2	15000	200	0.1D~2.5D	0.01D~0.03D	15000	200	0.1D~2.5D	0.01D~0.02D
D1.5R0.2	14000	300	0.1D~2.5D	0.01D~0.03D	14000	300	0.1D~2.5D	0.01D~0.02D
D2R0.2	12000	300	0.1D~2.5D	0.01D~0.03D	12000	300	0.1D~2.5D	0.01D~0.02D
D3R0.2	10000	400	0.1D~2.5D	0.01D~0.03D	10000	400	0.1D~2.5D	0.01D~0.02D
D4R0.2	8000	500	0.1D~2.5D	0.01D~0.03D	8000	500	0.1D~2.5D	0.01D~0.02D
D6R0.2	6000	600	0.1D~2.5D	0.01D~0.03D	6000	600	0.1D~2.5D	0.01D~0.02D
D8R0.2	5000	800	0.1D~2.5D	0.01D~0.03D	5000	800	0.1D~2.5D	0.01D~0.02D
D10R0.2	2400	320	0.1D~2.5D	0.01D~0.03D	2200	300	0.1D~2.5D	0.01D~0.02D
D12R0.5	2200	340	0.1D~2.5D	0.01D~0.03D	2000	320	0.1D~2.5D	0.01D~0.02D
D14R1	2000	360	0.1D~2.5D	0.01D~0.03D	1800	340	0.1D~2.5D	0.01D~0.02D
D16R1	1800	380	0.1D~2.5D	0.01D~0.03D	1600	360	0.1D~2.5D	0.01D~0.02D

加工方式  
Processing mode

每齿进给 (FZ)= 进给 (F)÷ 转速 (S)÷ 刀具刃数 (Z)  
 线速 (V)= 转速 (S)×3.14 (圆周率) × 刀具直径 (D)÷1000  
 以上所有参数值仅为精修和半精修建议参数表, 进给值根据客户的切深切宽数值作适当调整。  
 同等规格的参数在不同材质、不同机台性能和不同环境下, 加工的参数一般是不一样的, 正常情况下客户需要根据自身现场工况来进行适当的调整, 谢谢!

FZ (mm/t)= feed/teeth=F/S/T  
 Vs(m/min)=RPM\*3.14\*D /1000  
 The above data is taken for reference when finishing & semi-finishing. F need to be adjusted according to ap & ae.  
 The cutting data is to be selected by the material, MTB, workpiece, fixture & machining strategy. It could be optimized & adjusted accordingly.

代码编号: 转速 =S 进给 =F 刀具直径 =D 每齿进给 =FZ 线速度 =V 刀具刃数 =Z 圆周率 =3.14 常数 =1000  
 S= RPM, F = Feed, D=Diameter, FZ= Feed/teeth, V= m/min, Z= Teeth,

OSK-KM 系列常用刀具切削参数参考表

Reference table for cutting parameters of osk-km series common cutting tools

KM2BR								
刀具规格 Tool specification (mm)	合金钢 HRC30~40 Alloy steel HRC30~40				预硬钢 HRC40~50 Pre hardened steel HRC40~50			
	转速 (S) RPM	进给 (F) FEED	切深 (AP) mm	切宽 (AE) mm	转速 (S) RPM	进给 (F) FEED	切深 (AP) mm	切宽 (AE) mm
R0.25	22000	600	0.02~0.04	0.015~0.3	22000	600	0.02~0.03	0.015~0.2
R0.3	20000	800	0.02~0.06	0.02~0.4	20000	800	0.02~0.05	0.02~0.3
R0.5	19000	1000	0.02~0.08	0.02~0.6	19000	1000	0.02~0.06	0.02~0.5
R0.75	18000	1200	0.03~0.1	0.03~0.7	18000	1200	0.03~0.08	0.03~0.6
R1	16000	1500	0.03~0.12	0.03~0.9	16000	1500	0.03~0.1	0.03~0.8
R1.5	13000	1600	0.04~0.2	0.04~1.1	13000	1600	0.04~0.15	0.04~1.0
R2	12000	1800	0.04~0.3	0.04~1.2	12000	1800	0.04~0.2	0.04~1.1
R2.5	10000	1900	0.05~0.4	0.05~1.3	10000	1900	0.05~0.3	0.05~1.2
R3	8500	2000	0.05~0.5	0.05~1.4	8500	2000	0.05~0.4	0.05~1.3
R4	7000	2400	0.06~0.55	0.06~1.5	7000	2400	0.05~0.46	0.06~1.4
R5	6000	2800	0.07~0.6	0.06~1.6	6000	2800	0.06~0.5	0.06~1.5
R6	5500	3200	0.07~0.65	0.07~1.7	5500	3200	0.06~0.55	0.07~1.6

加工方式  
Processing mode

每齿进给 (FZ)= 进给 (F)÷ 转速 (S)÷ 刀具刃数 (Z)  
 线速 (V)= 转速 (S)×3.14 (圆周率) × 刀具直径 (D)÷1000  
 以上所有参数值仅为精修和半精修建议参数表, 进给值根据客户的切深切宽数值作适当调整。  
 同等规格的参数在不同材质、不同机台性能和不同环境下, 加工的参数一般是不一样的, 正常情况下客户需要根据自身现场工况来进行适当的调整, 谢谢!

FZ (mm/t)= feed/teeth=F/S/T  
 Vs(m/min)=RPM\*3.14\*D /1000  
 The above data is taken for reference when finishing & semi-finishing. F need to be adjusted according to ap & ae.  
 The cutting data is to be selected by the material, MTB, workpiece, fixture & machining strategy. It could be optimized & adjusted accordingly.

代码编号: 转速 =S 进给 =F 刀具直径 =D 每齿进给 =FZ 线速度 =V 刀具刃数 =Z 圆周率 =3.14 常数 =1000  
 S= RPM, F = Feed, D=Diameter, FZ= Feed/teeth, V= m/min, Z= Teeth,



被加工材料对照表

Comparison table of processed materials

钢号	中国	美国	日本	德国
	GB	ASTM	JIS	DIN
优质碳素结构钢	08F	1006	S09CK	C10
	08	1008	S9CK	C10
	10F	1010		
	10	1010,1012	S10C	C10,CK10
	15	1015	S15C	C15,CK15
	20	1020	S20C	C22,CK22
	5	1025	S25C	CK25
	30	1030	S30C	
	35	1035	S35C	C35,CK35
	40	1040	S40C	
	45	1045	S45C	C45,CK45
	50	1050	S50C	CK53
	55	1055	S55C	
	60	1060	S58C	C60,CK60
	15Mn	1016,1115	SB46	14Mn4
	20Mn	1021,1022		
	30Mn	1030,1033	S30C	
	40Mn	1036,1040	S40C	40Mn4
	45Mn	1043,1045	S45C	
	50Mn	1050,1052	S53C	
合金结构钢	20Mn2	1320,1321	SMn420	20Mn5
	30Mn2	1330	SMn433H	30Mn5
	35Mn2	1335	SMn438(H)	36Mn5
	40Mn2	1340	SMn443	-
	45Mn2	1345	SMn443	46Mn7
	50Mn2	-	-	-
	20MnV	-	-	20MnV6
	35SiMn	-	-	37MnSi5
	42SiMn	-	-	46MnSi4
	40B	TS14B35	-	-
	45B	50B46H	-	-
	40MnB	50B40	-	-
	45MnB	50B44	-	-
	15Cr	5115	SCr415(H)	15Cr3
	20Cr	5120	SCr420H	20Cr4
	30Cr	5130	SCr430	28Cr4
	35Cr	5132	SCr430(H)	34Cr4
	40Cr	5140	SCr440	41Cr4
	45Cr	5145,5147	SCr445	-
	38CrSi	-	-	-
12CrMo	-	-	13CrMo44	
15CrMo	A-387Cr.B	STC42, STT42, STB42	16CrMo44	
20CrMo	4119,4118	STC42, STT42, STB42	20CrMo44	
25CrMo	4125	-	25CrMo4	
30CrMo	4130	SCM420	-	
42CrMo	4140	-	42CrMo4	
35CrMo	4135	SCM3	34CrMo4	
12CrMoV	-	-	-	
12Cr1MoV	-	-	13CrMoV42	
25Cr2Mo1VA	-	-	-	
20CrV	6120	-	22CrV4	
40CrV	6140	-	42CrV6	

被加工材料对照表

Comparison table of processed materials

钢号	中国	美国	日本	德国
	GB	ASTM	JIS	DIN
合金结构钢	50CrVA	6150	SUP10	50CrV4
	15CrMn	-	-	-
	20CrMn	5152	SUP9	-
	30CrMnSiA	-	-	-
	40CrNi	3140H	SNC236	40NiCr6
	20CrNi3A	3316	-	20NiCr14
	30CrNi3A	3325,3330	SNC631H, SNC631	28NiCr10
	20MnMoB	80B20	-	-
	38CrMoA1A	-	SACM645	41CrA1Mo07
	40CrNiMoA	4340	SNCM439	40NiCrMo22
弹簧钢	60	1060	S58C	C60
	85	C1085 1084	SUP3	-
	65Mn	1566	-	-
	55Si2Mn	9255	SUP6	55Si7
	60Si2MnA	9260 9260H	SUP7	65Si7
滚动轴承钢	50CrVA	6150	SUP10	50CrV4
	GCr9	E51100 51100	SUJ1	105Cr4
滚动轴承钢	GCr9SiMn	-	SUJ3	-
	GCr15	E52100 52100	SUJ2	100Cr6
易切削钢	GCr15SiMn	-	-	100CrMn6
	Y12	C1109	SUM12	-
	Y15	B1113	SUM22	10S20
	Y20	C1120	SUM32	22S20
耐磨钢	Y30	C1130	SUM42	35S20
	Y40Mn	C144	-	40S20
	ZGMn13	-	SCMnH11	X120Mn12
碳素工具	T7	W1-7	SK7, SK6	C70W1
	T8	-	SK6, SK5	-
	T8A	W1-0.8C	-	C80W1
	T8Mn	-	SK5	-
	T10	W1-1.0C	SK3	-
	T12	W1-1.2C	SK2	C125W
	T12A	W1-1.2C	-	C125W2
合金工具钢	T13	-	SK1	C135W
	8MnSi	-	-	C75W3
	9SiCr	-	-	90CrSi5
	Gr2	L3	-	100Cr6
	Cr06	W5	SKS8	140Cr3
	9Cr2	L	-	100Cr6
	W	F1	SK21	120W4
	Cr12	D3	SKD1	X210Cr12
	Cr12MoV	D2	SKD11	X165CrMoV46
	9Mn2V	02	-	90MnV8
	9CrWMn	01	SKS3	-
	CrWMn	07	SKS31	105WCr6
	3Cr2W8V	H21	SKD5	X30WCrV93

**被加工材料对照表**  
**Comparison table of processed materials**

钢号	中国	美国	日本	德国
	GB	ASTM	JIS	DIN
合金工具钢	5CrMnMo	-	SKT5	40CrMnM07
	5CrNiMo	L6	SKT4	55NiCrMoV6
	4Cr5MoSiV	H11	SKD61	X38CrMoV51
	4CrW2Si	-	SKS41	35WCrV7
	5CrW2Si	S1	-	45WCrV7
高工具钢	W18Cr4V	T1	SKH2	S18-0-1
	W6Mo5Cr4V2	N2	SKH9	S6-5-2
	W18Cr4VCo5	T4	SKH3	S18-1-2-5
	W2Mo9Cr4VCo8	M42	-	S2-10-1-8
不锈钢	1Cr18Ni9	302 S30200	SUS302	X12CrNi188
	Y1Cr18Ni9	303 S30300	SUS303	X12CrNiS188
	0Cr19Ni9	304 S30400	SUS304	X5CrNi189
	00Cr19Ni11	304L S30403	SUS304L	X2CrNi189
	0Cr18Ni11Ti	321 S32100	SUS321	X10CrNiTi189
不锈钢	0Cr13A1	405 S40500	SUS405	X7CrA113
	1Cr17	430 S43000	SUS430	X8Cr17
	1Cr13	410 S41000	SUS410	X10Cr13
	2Cr13	420 S42000	SUS420J1	X20Cr13
	3Cr13		SUS420J2	-
	7Cr17	440A S44002	SUS404A	-
	0Cr17Ni7A1	631 S17700	SUS631	X7CrNiA1177
耐热钢	2Cr23Ni13	309 S30900	SUH309	-
	2Cr25Ni21	310 S31000	SUH310	CrNi2520
	0Cr25Ni20	310S S31008	SUS310S	-
	0Cr17Ni12Mo2	316 S31600	SUS316	X5CrNiMo1810
	0Cr18Ni11Nb	347 S34700	SUS347	X10CrNiNb189
	1Cr13Mo		SUS410J1	-
	1Cr17Ni2	431 S43100	SUS431	X22CrNi17
	0Cr17Ni7A1	631 S17700	SUS631	X7CrNiA1177

**Note**

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# KM-ED-200100-R05-N20-L75-S04

FLUTES	
200050	20: 2 刃 (2 Flutes) / 0050: 0.5mm
400100	40: 4 刃 (4 Flutes) / 0100: 1.0mm
601200	60: 6 刃 (6 Flutes) / 1200: 12.0mm

OTHER	
R:	圆鼻 Corner Radius
N:	有效长 Effective Length
L:	全长 Overall Length
S:	柄径 Shank Dia
R05	圆鼻 R0.5mm Corner Radius R0.5mm
N20	深沟 20mm Effective Length 35mm
L75	全长 75mm Overall Length 75mm
S04	柄径 4.0mm Shank Dia 4.0mm

TYPE	
ED	平刀 End Mills
EDL	加长平刀 Length End Mills
EDN	深沟平刀 Rib End Mills
BR	球刀 Ball End Mills
BRL	加长球刀 Length Ball End Mills
BRN	深沟球刀 Rib Ball End Mills
CR	圆鼻刀 Corner Radius End Mills
CRL	加长圆鼻刀 Length Corner Radius End Mills
CRN	深沟圆鼻刀 Length Corner Radius End Mills

PRODUCT SERIES	
KM	HRC50 高效高速铣刀 HRC50 High Efficiency High Speed End Mills
KHM	HRC60 高速高硬铣刀 HRC60 High Speed High Hard End Mills
KSM	不锈钢专用铣刀 Stainless Steel Special End Mills
KAM	铝专用铣刀 Aluminum End Mills
KDM	石墨铣刀 Graphite End Mills
SPM	HRC55 微径深沟铣刀 HRC55 Micro Rib End Mills
SHM	HRC65 微径深沟铣刀 HRC65 Micro Rib End Mills







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