

DORMER PRAMET



S6xx 系列铝合金整硬铣刀

ProLaunch 2021



SAFETY FIRST

Dormer Pramet's objective is **zero harm** to our people, the environment we work in, our customers and our suppliers.



ALARM



EMERGENCY
EXIT



ASSEMBLY
POINT



FIRST AID



PROTECTIVE
EQUIPMENT



EMERGENCY
NUMBER

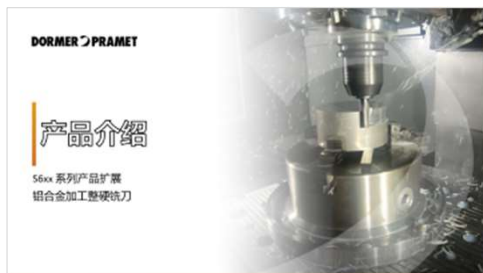


PSYCHOLOGICAL
SAFETY



产品预览

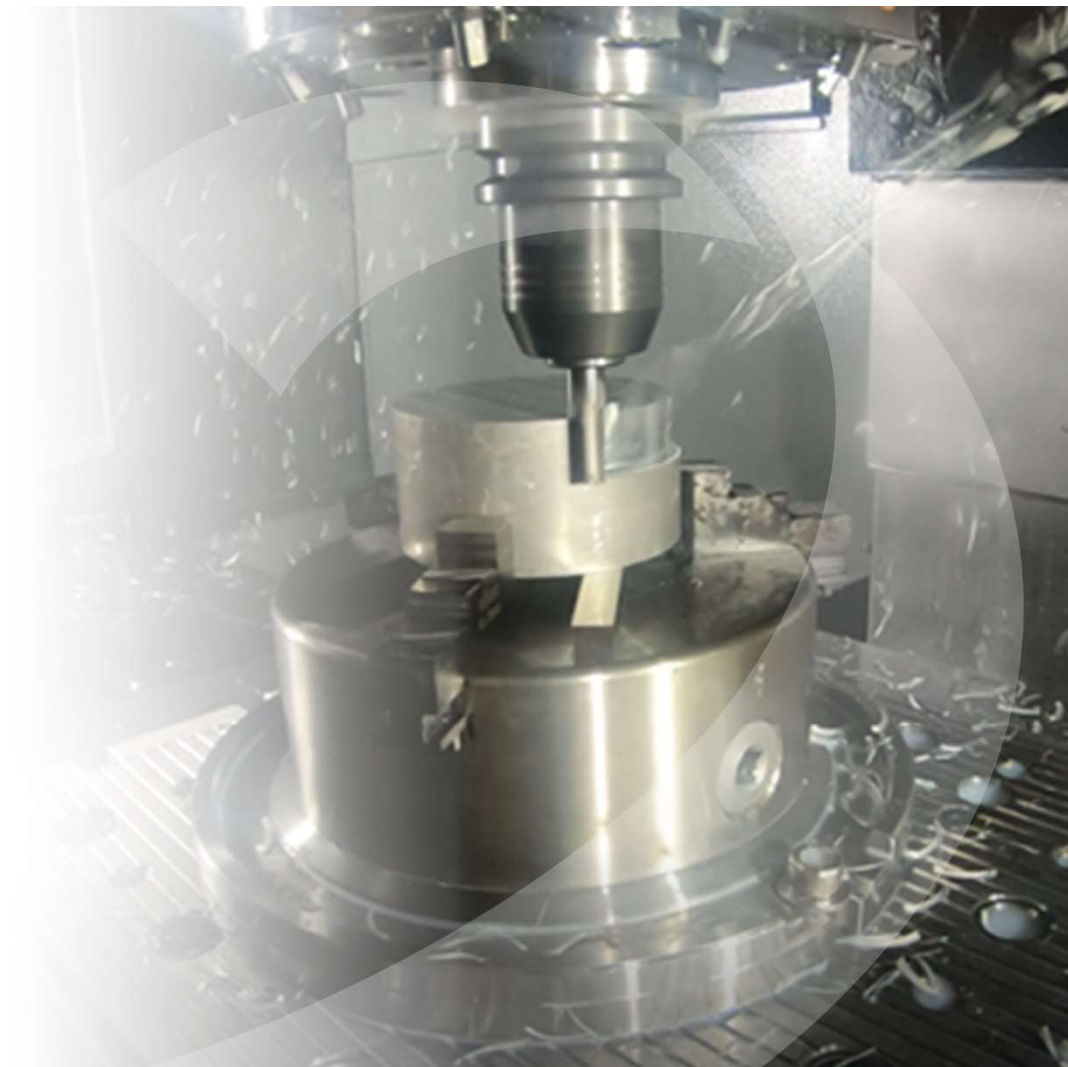
S6xx 铝用整硬铣刀



DORMER PRAMET

产品介绍

S6xx 系列产品扩展
铝合金加工整体硬铣刀



S6.. 铝合金加工整体硬质合金铣刀

产品介绍



扩展整硬铝用铣刀产品范围的原因

- 具有更多刃口的铣刀以提升加工效率
- 粗加工铣刀以提升金属去除率
- 现有产品系列中增加小直径产品

产品开发预期

- 3个刃口以提升进给率
- 有效的NRA粗加工槽型可提升金属去除率
- 4齿立铣刀带来更好的精加工表面光洁度，竞争力提升
- 增加小直径规格以提升产品的通用性

产品系列

介绍

Cutter	DC Range	NOF	APMX	Helix λ	Rake γ	Neck	Type	Surfacefinish	Pitch	Shank	P	M	K	S	N	H
End mill design																
S650	1.0 – 20.0	3	3 ~ 1.5xDC	40°	13°	No	W	bright	differential	DIN 6535 HA					■	
S614	3.0 – 16.0	3	6 ~ 3.5xDC	40°	13°	No	W	bright	standard	DIN 6535 HA					■	
S654	6.0 – 20.0	3	~ 2xDC	40°	15°	Yes	W / NRA	bright	differential	DIN 6535 HA					■	
S662	3.0 – 20.0	4	3 ~ 2xDC	40°	10°	No	W	bright	differential	DIN 6535 HA					■	
S610	2.0 – 20.0	2	3 ~ 2xDC	30°	20°	No	W	highly polished	standard	DIN 6535 HA					■	
S611	3.0 – 20.0	2	3 ~ 2xDC	30°	20°	Yes	W	highly polished	standard	DIN 6535 HA					■	
S638	6.2 – 20.30	2	~ 1.25xDC	30°	20°	Yes	W	highly polished	standard	DIN 6535 HA					■	
S637	2.0 – 12.0	1	5 ~ 2.5xDC	25°	20°	No	W	highly polished	standard	DIN 6535 HA					■	
S629	1.0 – 20.0	2	1.6 ~ 2.2xDC	30°	15°	Yes	W	highly polished	standard	DIN 6535 HA					■	

S650

介绍

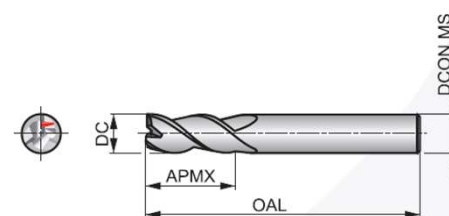
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S6501.0	1.00	4.00	3.00	40.0	3
S6501.5	1.50	4.00	4.50	40.0	3
S6502.0	2.00	4.00	6.50	40.0	3
S6502.5	2.50	4.00	6.50	40.0	3
S6503.0XD3	3.00	3.00	9.00	40.0	3
S6503.0XD6	3.00	6.00	9.00	50.0	3
S6504.0XD4	4.00	4.00	12.00	50.0	3
S6504.0XD6	4.00	6.00	12.00	50.0	3
S6505.0	5.00	6.00	15.00	50.0	3
S6506.0	6.00	6.00	16.00	50.0	3
S6508.0	8.00	8.00	20.00	64.0	3
S65010.0	10.00	10.00	22.00	70.0	3

Ordering code	DC	DCON MS	APMX	OAL	NOF
S65012.0	12.00	12.00	25.00	75.0	3
S65014.0	14.00	14.00	32.00	90.0	3
S65016.0	16.00	16.00	32.00	90.0	3
S65020.0*	20.00	20.00	38.00	100.0	3

*No 不等齿距 & FS断屑槽



- 3齿铣刀
- W型槽型可提升性能
- 表面光亮处理可防止刃口粘屑
- 通柄设计可提升刀具的可达性



SC
热胀刀柄



HC
液压刀柄



CC-HKS
强力刀柄



CC-ER
带精密夹头的ER刀柄



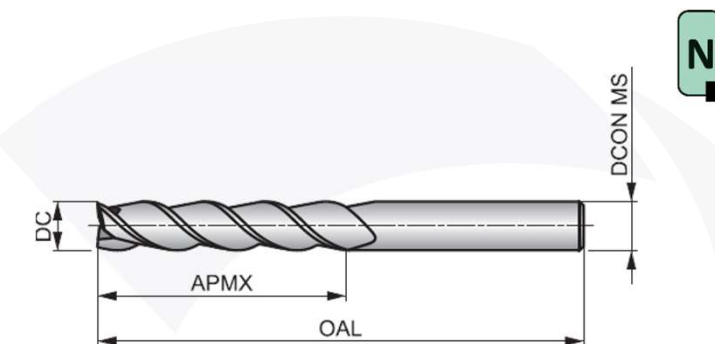
参数
DC
DCON MS
APMX
OAL
NOF

描述
切削直径
柄部直径
最大切深
总长
齿数

S614

介绍

Ordering code	DC	DCON MS	APMX	OAL	NOF
S6143.0XD3	3.00	3.00	19.00	60.0	3
S6143.0XD6	3.00	6.00	19.00	75.0	3
S6144.0XD4	4.00	4.00	19.00	60.0	3
S6144.0XD6	4.00	6.00	19.00	75.0	3
S6145.0	5.00	6.00	19.00	75.0	3
S6146.0	6.00	6.00	31.00	75.0	3
S6148.0	8.00	8.00	41.00	100.0	3
S61410.0	10.00	10.00	50.00	100.0	3
S61412.0	12.00	12.00	50.00	100.0	3
S61414.0	14.00	14.00	57.00	125.0	3
S61416.0	16.00	16.00	57.00	125.0	3



- 3齿铣刀
- W型槽型可提升性能
- 表面光亮处理可防止刃口粘屑
- 通柄设计可提升刀具的可达性
- 刃口加长处理



SC
热涨刀柄



HC
液压刀柄



CC-HKS
强力刀柄



CC-ER
带精密夹头的ER刀柄



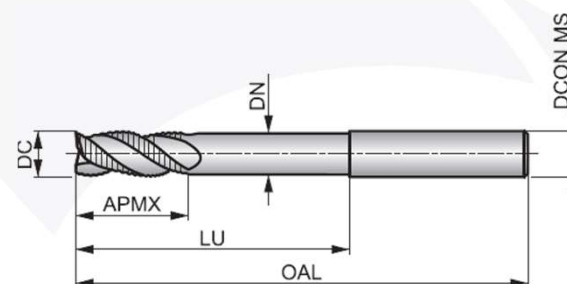
参数
DC
DCON MS
APMX
OAL
NOF

描述
切削直径
柄部直径
最大切深
总长
齿数

S654

介绍

Ordering code	DC [mm]	RE [mm]	DCON MS [mm]	APMX [mm]	OAL [mm]	NOF	LU [mm]	DN [mm]
S6546.0	6.00	0.10	6.00	13.00	75.0	3	40.00	5.50
S6548.0	8.00	0.10	8.00	20.00	75.0	3	40.00	7.40
S65410.0	10.00	0.10	10.00	22.00	100.0	3	60.00	9.20
S65412.0	12.00	0.12	12.00	26.00	100.0	3	60.00	11.00
S65416.0	16.00	0.16	16.00	32.00	125.0	3	75.00	15.00
S65420.0	20.00	0.20	20.00	40.00	150.0	3	100.00	19.00



N

- 3齿铣刀
- 表面光亮处理可防止刃口粘屑
- 通柄设计可提升刀具的可达性
- 短刃设计，刀杆加长处理
- NRA槽型主要用于粗加工



SC
热胀刀柄



HC
液压刀柄



CC-HKS
强力刀柄



CC-ER
带精密夹头的ER刀柄



参数
DC
RE
DCON MS
APMX
OAL
NOF
LU
DN

描述
切削直径
刀尖圆角
柄部直径
最大切深
总长
齿数
有效长度
颈部直径

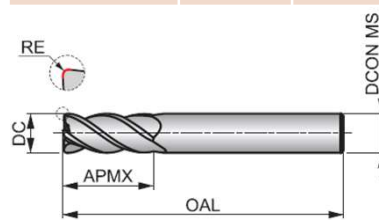
S662

介绍



Ordering code	DC [mm]	RE [mm]	DCON MS [mm]	APMX [mm]	OAL [mm]	NOF
S6623.0XR0.3	3.00	0.30	6.00	9.00	57.0	4
S6624.0XR0.3	4.00	0.30	6.00	12.00	57.0	4
S6624.0XR0.5	4.00	0.50	6.00	12.00	57.0	4
S6625.0XR0.3	5.00	0.30	6.00	15.00	57.0	4
S6625.0XR0.5	5.00	0.50	6.00	15.00	57.0	4
S6626.0XR1.0	6.00	1.0	6.00	16.00	57.0	4
S6626.0XR2.0	6.00	2.00	6.00	16.00	57.0	4
S6628.0XR0.5	8.00	0.50	8.00	20.00	64.0	4
S6628.0XR1.0	8.00	1.00	8.00	20.00	64.0	4
S6628.0XR2.0	8.00	2.00	8.00	20.00	64.0	4
S66210.0XR0.5	10.00	0.50	10.00	22.00	72.0	4
S66210.0XR1.0	10.00	1.00	10.00	22.00	72.0	4
S66210.0XR2.0	10.00	2.00	10.00	22.00	72.0	4
S66212.0XR1.0	12.00	1.00	12.00	26.00	83.0	4
S66212.0XR2.0	12.00	2.00	12.00	26.00	83.0	4

Ordering code	DC [mm]	RE [mm]	DCON MS [mm]	APMX [mm]	OAL [mm]	NOF
S66212.0XR2.5	12.00	2.50	12.00	26.00	83.0	4
S66212.0XR3.0	12.00	3.00	12.00	26.00	83.0	4
S66216.0XR1.0	16.00	1.00	16.00	32.00	92.0	4
S66216.0XR2.0	16.00	2.00	16.00	32.00	92.0	4
S66216.0XR3.0	16.00	3.00	16.00	32.00	92.0	4
S66216.0XR4.0	16.00	4.00	16.00	32.00	92.0	4
S66220.0XR2.0	20.00	2.00	20.00	38.00	104.0	4
S66220.0XR4.0	20.00	4.00	20.00	38.00	104.0	4



- 4齿铣刀
- W型槽型可提升性能
- 表面光亮处理可防止刀口粘屑
- 通柄设计可提升刀具的可达性
- 短刃+刀口圆角设计



SC
热胀刀柄



HC
液压刀柄



CC-HKS
强力刀柄



CC-ER
带精密夹头的ER刀柄



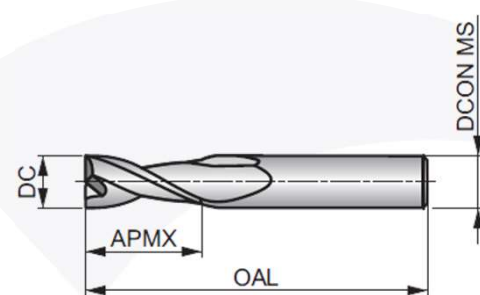
参数
DC
RE
DCON MS
APMX
OAL
NOF

描述
切削直径
刀尖圆角
柄部直径
最大切深
总长
齿数

S610

介绍

Ordering code	DC [mm]	RE [mm]	DCON MS [mm]	APMX [mm]	OAL [mm]	NOF
S6102.0	2.00	0.10	4.00	6.50	40.0	2
S6103.0XD3	3.00	0.10	3.00	9.00	40.0	2
S6103.0XD6	3.00	0.10	6.00	9.00	40.0	2
S6104.0XD4	4.00	0.10	4.00	12.00	50.0	2
S6104.0XD6	4.00	0.10	6.00	12.00	50.0	2
S6105.0	5.00	0.10	6.00	15.00	50.0	2
S6106.0	6.00	0.10	6.00	20.00	50.0	2
S6108.0	8.00	0.10	8.00	20.00	64.0	2
S61010.0	10.00	0.10	10.0	22.00	75.0	2
S61012.0	12.00	0.10	12.00	25.00	75.0	2
S61014.0	14.00	0.10	14.00	32.00	90.0	2
S61016.0	16.00	0.10	16.00	32.00	90.00	2
S61020.0	20.00	0.10	20.00	38.00	100.0	2



N

- 2齿铣刀
- 表面抛光+光亮处理可防止刃口粘屑
- 通柄设计可提升刀具的可达性
- 短刃+标准长度设计可提升刚性



参数
DC
RE
DCON MS
APMX
OAL
NOF

描述
切削直径
刀尖圆角
柄部直径
最大切深
总长
齿数



SC
热胀刀柄



HC
液压刀柄



CC-HKS
强力刀柄

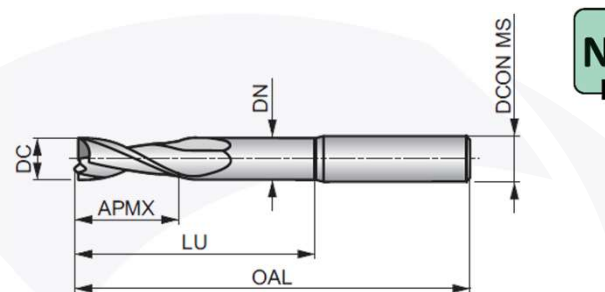


CC-ER
带精密夹头的ER刀柄

S611

介绍

Ordering code	DC [mm]	RE [mm]	DCON MS [mm]	APMX [mm]	OAL [mm]	NOF	LU [mm]	DN [mm]
S6113.0XD3	3.00	0.10	3.00	9.00	40.0	2	15.00	2.80
S6113.0XD6	3.00	0.10	6.00	9.00	50.0	2	15.00	2.80
S6114.0XD4	4.00	0.10	4.00	12.00	50.00	2	20.00	3.70
S6114.0XD6	4.00	0.10	6.00	12.00	50.0	2	20.00	3.70
S6115.0	5.00	0.10	6.00	15.00	50.0	2	20.00	4.60
S6116.0	6.00	0.10	6.00	16.00	80.0	2	40.00	5.50
S6118.0	8.00	0.10	8.00	20.00	80.0	2	40.00	7.40
S61110.0	10.00	0.10	10.00	22.00	100.00	2	60.00	9.20
S61112.0	12.00	0.10	12.00	25.00	100.00	2	60.00	11.00
S61114.0	14.00	0.10	14.00	32.00	125.00	2	75.00	13.00
S61116.0	16.00	0.10	16.00	32.00	125.00	2	75.00	15.00
S61120.0	20.00	0.10	20.00	38.00	125.0	2	75.00	19.00



- 2齿铣刀
- 表面抛光+光亮处理可防止刃口粘屑
- 通柄设计可提升刀具的可达性
- 短刃+刀杆加长设计



参数
DC
RE
DCON MS
APMX
OAL
NOF
LU
DN

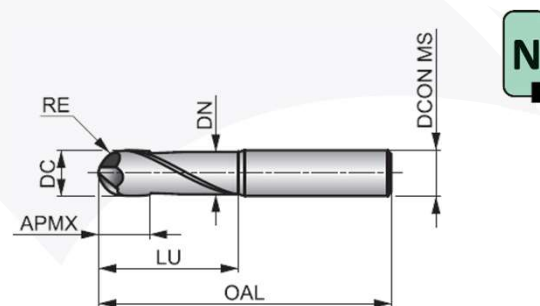
描述
切削直径
刀尖圆角
柄部直径
最大切深
总长
齿数
有效长度
颈部直径

S629

介绍

Ordering code	DC [mm]	RE [mm]	DCON MS [mm]	APMX [mm]	OAL [mm]	NOF	LU [mm]	DN [mm]
S6291.0*	1.00	0.50	4.00	0.80	50.0	2	10.00	0.90
S6291.5*	1.50	0.75	4.00	1.20	50.0	2	12.00	1.40
S6292.0*	2.00	1.00	4.00	1.60	60.0	2	18.00	1.90
S6293.0	3.00	1.50	6.00	5.00	57.0	2	20.00	2.80
S6294.0	4.00	2.00	6.00	6.00	57.0	2	20.00	3.70
S6296.0	6.00	3.00	6.00	8.00	57.0	2	20.00	5.50
S6298.0	8.00	4.00	8.00	10.00	64.0	2	25.00	7.40
S62910.0	10.00	5.0	10.00	12.00	75.0	2	35.00	9.20
S62912.0	12.00	6.00	12.00	14.00	75.00	2	35.00	11.00
S62916.0	16.00	8.00	16.00	18.00	90.00	2	45.00	15.00
S62920.0	20.00	10.0	20.00	22.00	100.00	2	50.00	19.00

*前角 11°



- 2齿球头铣刀
- 表面抛光+光亮处理可防止刀口粘屑
- 通柄设计可提升刀具的可达性
- 短刃+标准长度设计可提升刚性

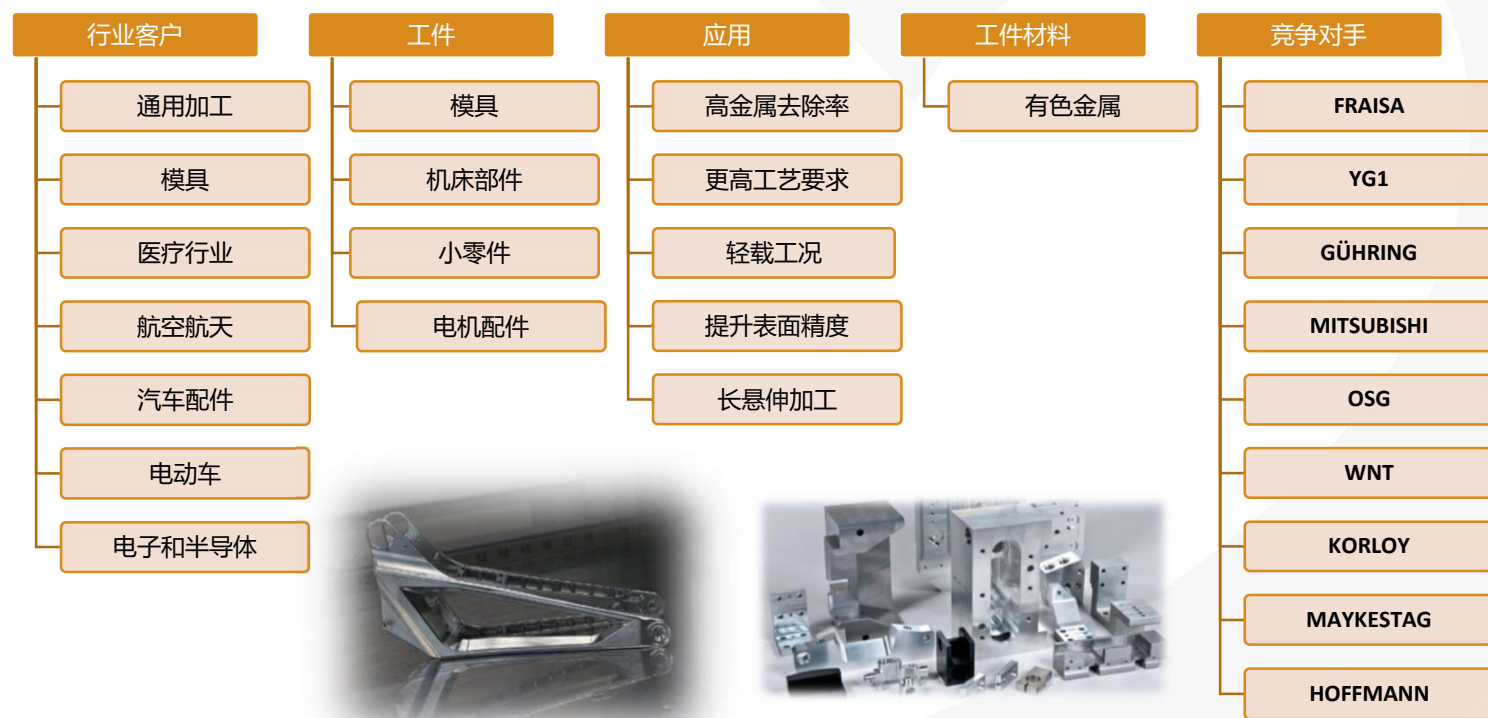


参数
DC
RE
DCON MS
APMX
OAL
NOF
LU
DN

描述
切削直径
刀尖圆角
柄部直径
最大切深
总长
齿数
有效长度
颈部直径

应用推荐

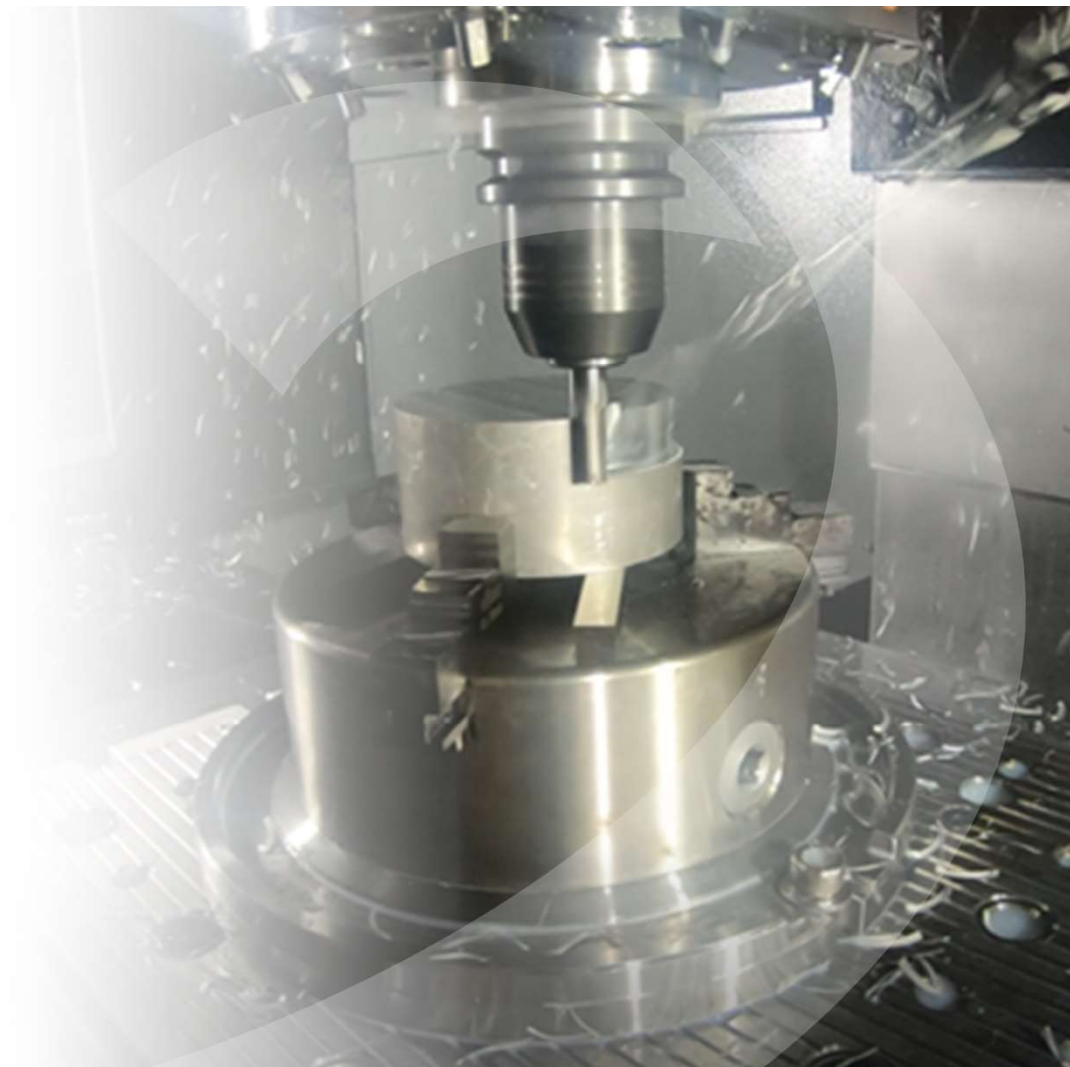
介绍



DORMER PRAMET

特点&优势

S6xx 产品扩展
硬质合金铝用铣刀



有色金属材料(N-材料组)

ISO group		WMG (Work Material Group)	Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Examples of material (UNS, EN, DIN, SS, STN, B.S, UNE, CN, AFNOR, GOST, UNI)
N	N1	■ N1.1 Commercially pure wrought aluminum	< 60 HB	≤ 240	UNS A91200, EN AL99.6, DIN 3.0205, SS 4010, STN 424009, BS 1C, UNE L-3001, GB L5, AFNOR A4, GOST АДС, UNI 3567
		■ N1.2 Wrought aluminum alloys half hard tempered	60 - 100 HB	> 240 ≤ 400	UNS A93004, EN AlMn0.5Mg0.5, DIN 3.0505, SS 4054, STN 424432, BS N31, UNE L-3831, GB LF2, AFNOR A-M1, GOST АМu, UNI 3568
		■ N1.3 Wrought aluminum alloys full hard tempered	100 - 150 HB	> 400 ≤ 590	UNS A95083, EN AlMg4.5Mn0.7, DIN 3.3547, SS 4140, STN 424415, BS N8, UNE L-3321, GB AlMg4.5Mn, AFNOR A-G4.5Mn, GOST Аmg 4.5
	N2	■ N2.1 Cast aluminium alloys	< 75 HB	≤ 240	UNS A02080, EN AlCu4S, BS LM11, STN 424331, UNE Al Si1Cu, GOST AMg5K, UNI G-ALSi7Mg
		■ N2.2	75 - 90 HB	> 240 ≤ 270	UNS A02420, EN AlCu4Ni2Mg2, SS AlSi7MgFe, BS LM6, STN 424519, UNE Al-7SiMg, AFNOR A-S7G, GOST AK7, UNI G-ALSi7Mg
		■ N2.3	90 - 140 HB	> 270 ≤ 440	UNS A03360, EN G-ALCu4NiMg2, SS AlSi10Mg, STN 424336, BS LM 30, AFNOR A-S10G, UNI G-ALSi9Mg
	N3	■ N3.1 Free-cutting copper-alloys materials with excellent machining properties			UNS C14700, EN CuPb1P, DIN 2.1498, STN 423214, BS C111, AFNOR CuZn35Pb2, GOST L63-3, UNI CuS(P0.01)
		■ N3.2 Short-chip copper-alloys with good to moderate machining properties			UNS C81540, EN CuNi2SiCr, DIN 2.0857, STN 423220, BS NS113, UNE CuSn12, AFNOR CuZn40, GOST L60, UNI P-CuZn-40
		■ N3.3 Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties			UNS C10100, EN CuAg0.1, DIN 2.1203, SS 5010, UNE CUSi3Mn1, AFNOR Cu-C2, GOST M1f, UNI Cu-OF
	N4	■ N4.1 Thermoplastic polymers			ABS, Acryl, Duraplast, Elastomer, EP, Epoxid, FEP, Fluor, Gummi, Kautschuk, Latex, MF, MPF, PA, PAI, PC, PE, PEEK, PEI, PES, PET, PF,
		■ N4.2 Thermosetting polymers			Aramid, Epoxy, Fluoropolymer, Mehacrylate, Melamine, Phenolic, Polyester, Polyimide, Polymethacrylimide, Polyurethane
		N4.3 Reinforced polymers or composites			CFK, GFK, GMT, Honeycomb, Kevlar, LFT, Organo, SMC
	N5	N5.1 Graphite			CGM-1, CM-00, GM-10, GM-11, GR030, GR030PI, GR060, GR060PI, GR125, MC-01, MC-01RO, MC-03, MC-03M

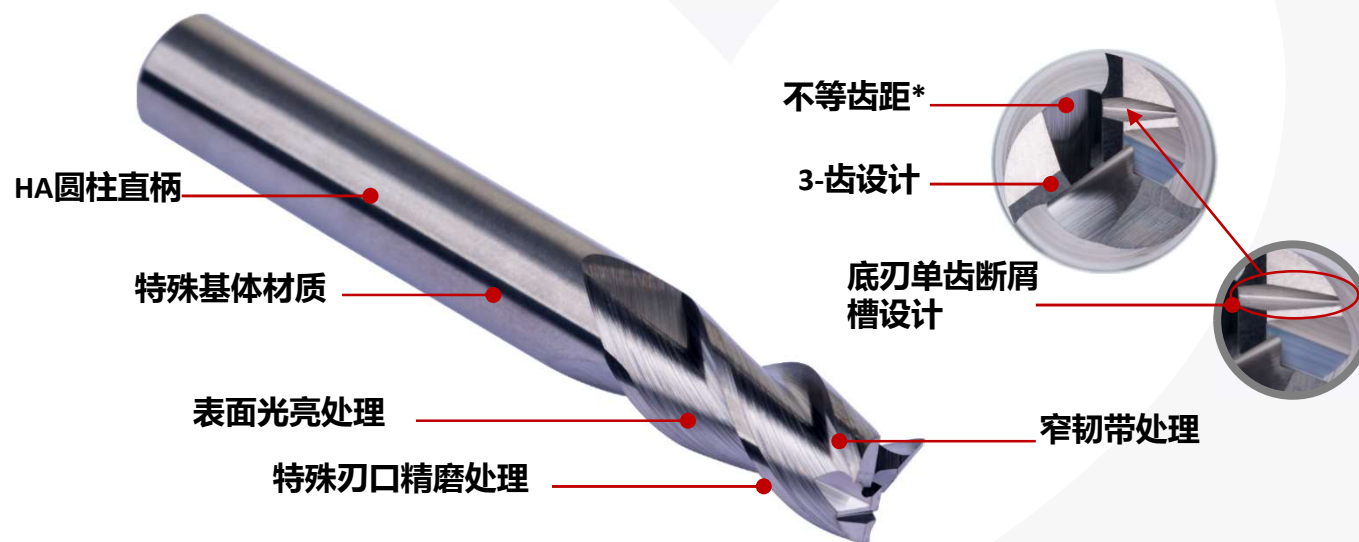


S650

产品设计特点

HM	W	NOF 3 $\neq$
	λ 40°	γ 13°
DIN 6535HA		DC h9

- 40°螺旋角
- 13°前角



N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2
780 O	608 O	393 O	393 N	352 N	252 N	410 N	241 N	123 N	410 P	158 P

DCON MS tolerance h6.

* DC 20.0mm 为常规设计, 不带不等齿距和断屑槽

S614

产品设计特点

HM	W	NOF 3
	λ 40°	γ 13°
DIN 6535HA		DC h9
	DORMER	

- 40°螺旋角
- 13°前角

HA圆柱直柄

特殊基体材质

表面光亮处理

特殊刃口精磨处理

3-齿设计

小刀尖圆角设计

窄韧带处理

N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2
■ 638 G	■ 480 G	■ 321 G	■ 321 F	■ 288 F	■ 206 F	■ 336 F	■ 197 F	■ 101 F	■ 336 I	■ 130 I

DCON MS tolerance h6.

S654

产品设计特点

HM	W NRA	NOF 3 $\neq$
	λ 40°	γ 15°
DIN 6535HA		DC h9
	DORMER	

- 40°螺旋角
- 15°前角



N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2
709 O	533 O	357 O	357 N	320 N	229 N	373 N	219 N	112 N	373 P	144 P

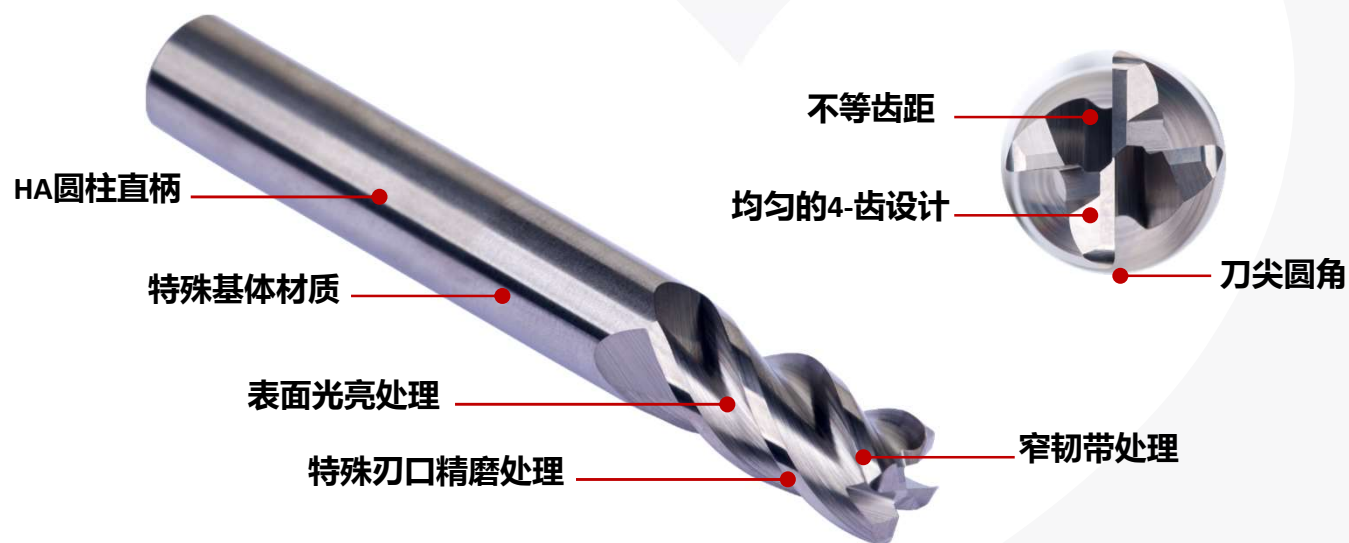
DCON MS tolerance h6; RE ± 0.02 mm

S662

产品设计特点

HM	W	NOF 4 $\pm$
	λ 40°	γ 10°
DIN 6535HA		DC h9

- 40°螺旋角
- 10°前角



N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2
■ 709 O	■ 533 O	■ 357 O	■ 357 N	■ 320 N	■ 229 N	■ 373 N	■ 219 N	■ 112 N	■ 373 P	■ 144 P

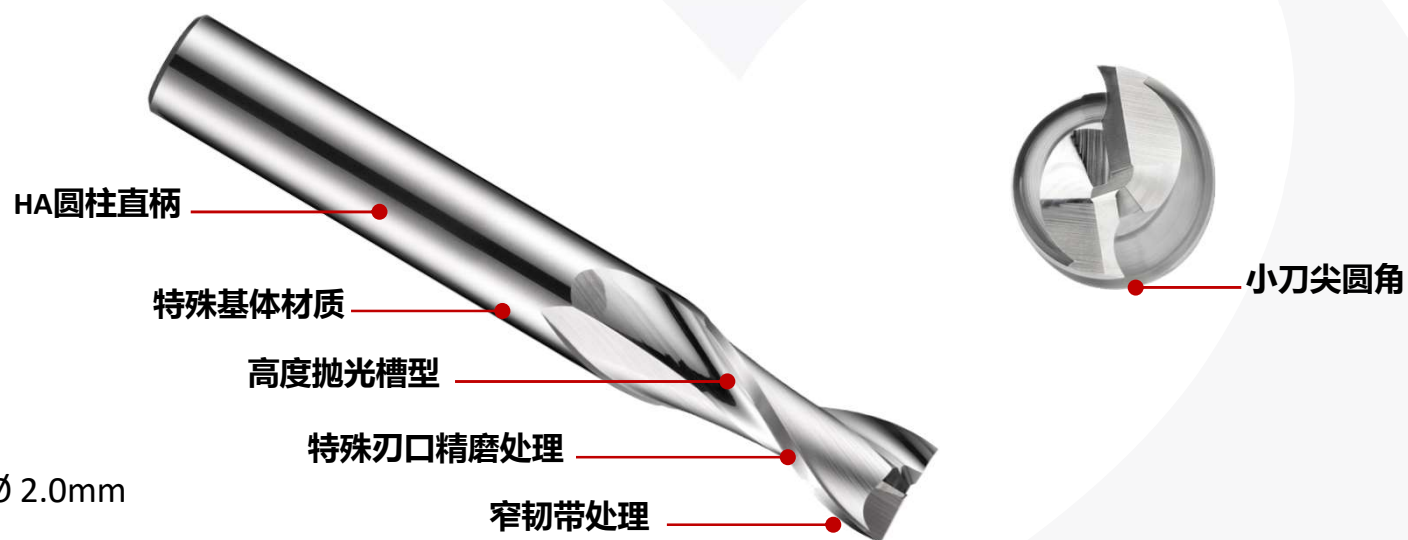
DCON MS tolerance h6; RE $\pm 0.01\text{mm}$

S610

产品设计特点

HM	W	NOF 2
	λ 30°	γ 20°
DIN 6535HA	Hi	DC h9

- 30°螺旋角
- 20°前角
- 2015年开始销售
- 此次产品扩展至 $\varnothing$ 2.0mm



N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2
709 P	533 P	357 P	357 O	320 O	229 O	373 O	219 O	112 O	373 R	144 R

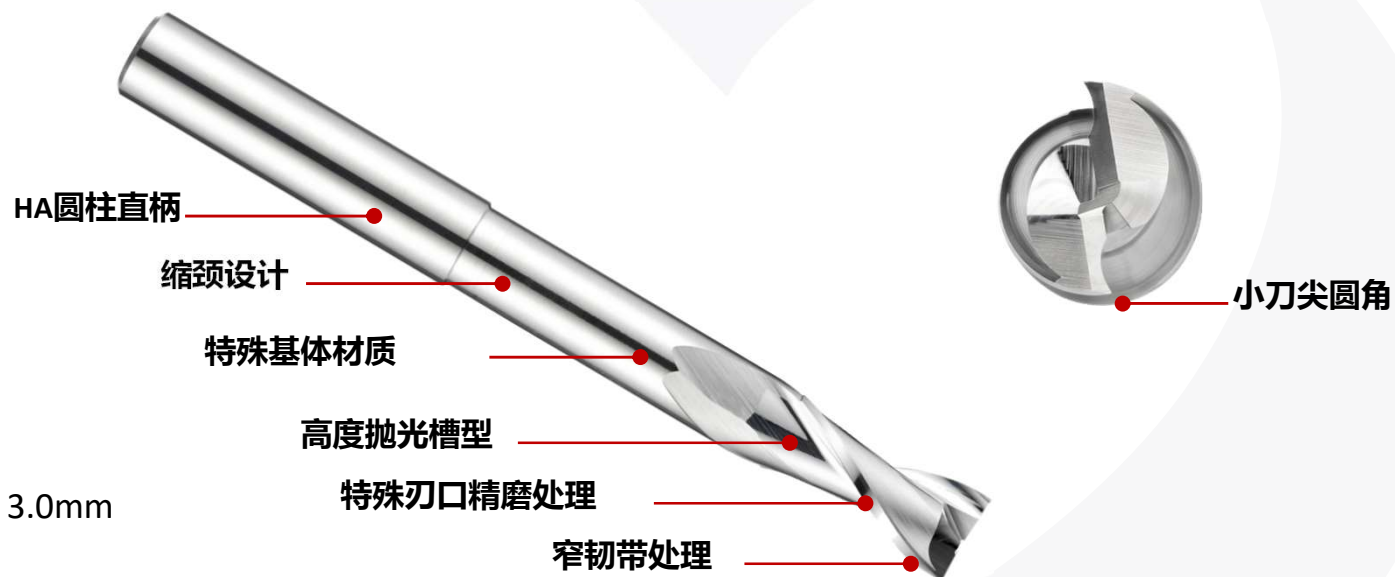
DCON MS tolerance h6; RE $\pm$ 0.02mm

S611

产品设计特点

HM	W	NOF 2
	λ 30°	γ 20°
DIN 6535HA	Hi	DC h9
	DORMER	

- 30°螺旋角
- 20°前角
- 2015年开始销售
- 此次产品扩展至 $\varnothing$ 3.0mm



N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2
■ 638 P	■ 480 P	■ 321 P	■ 321 O	■ 288 O	■ 206 O	■ 336 O	■ 197 O	■ 101 O	■ 336 R	■ 130 R

DCON MS tolerance h6; RE $\pm$ 0.02mm

S629

产品设计特点

HM	W	NOF 2
	λ 30°	γ 15°
DIN 6535HA		DC h9
	DORMER	

- 30°螺旋角
- 15°前角
- 2015年开始销售
- 此次产品扩展至 $\varnothing 1.0\text{mm}$

HA圆柱直柄

特殊基体材质

缩颈设计

特殊刃口精磨处理

均匀的两齿设计

大前角设计

N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2
709 N	533 N	357 N	357 N	320 N	229 N	373 N	219 N	112 N	373 O	144 O

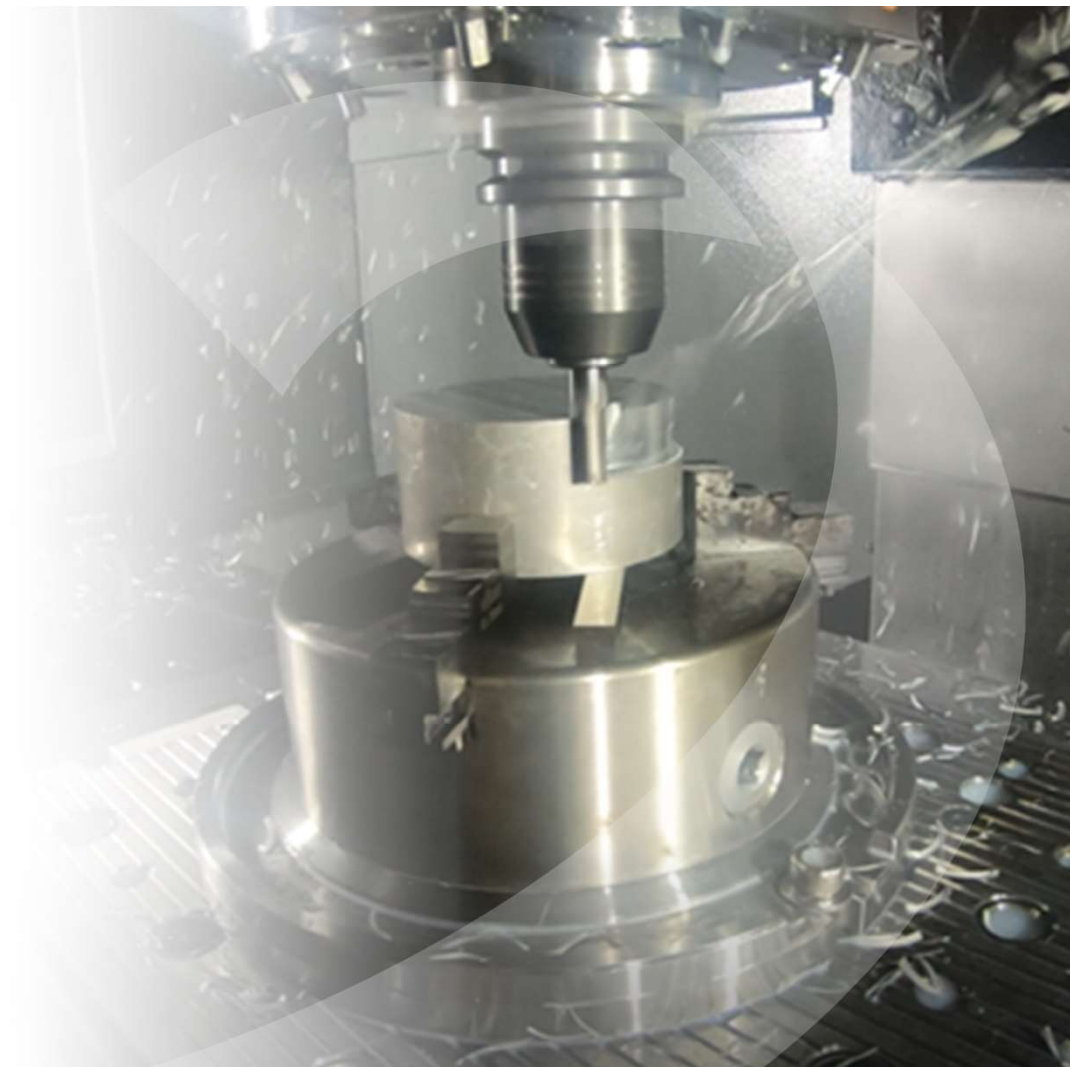
DCON MS tolerance h6; RE +0/-0.02mm

DORMER PRAMET

测试情况

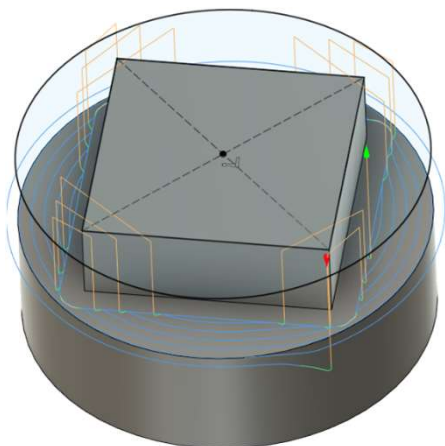
S6xx 系列

整体硬质合金铝用铣刀



S662 – 4-齿带刀尖圆角铣刀

试验中心测试情况



Work-material AA 6082
WMG N1.2 (70HB)

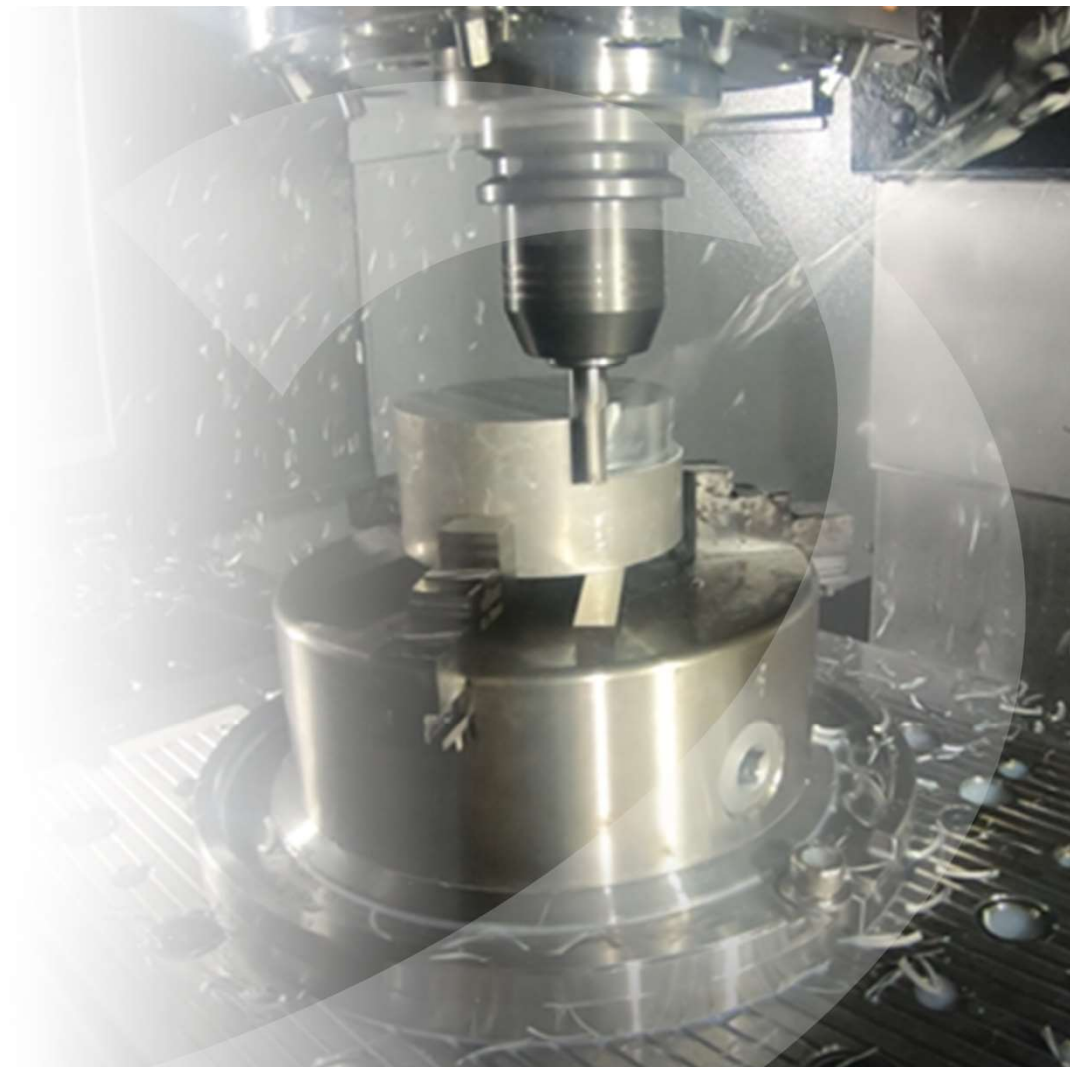
OPERATION	a_p mm	a_e mm	DC mm	RPM	V_c m/min	V_f mm/min	f_z mm/z	h_{max} mm	Q cm ³ /min
方肩铣 Dormer S66212.0	20.00 (1.66 x DC)	3.60 (0.30 x DC)	12.0	10600	400	8500	0.20	0.183	611.15

DORMER PRAMET

加工推荐

S6xx 系列

整体硬质合金铝用铣刀



新图标

如何识别?

基体材料

HM HM 硬质合金

刀具类型

W W 软材料槽型

NRA NRA HRA粗加工刃型

FS FS FS断屑槽

W NRA W-槽型 + HRA粗加工刃型

齿

Z 2 齿数

Z 4 齿数 + 不等齿距设计

刀具长度

切削长度

切削角度

$\lambda 12^\circ$ $\lambda 25^\circ$ 螺旋角

$\gamma 10^\circ$ $\gamma 20^\circ$ 前角

$\lambda \neq 10^\circ$ $\lambda \neq$ 不等螺旋角

刀柄

DIN 6535HA 标准柄

表面处理

表面光亮处理

表面抛光处理

涂层

TiSiN TiSiN 涂层

冷却

内冷

刀具公差

h9 DC h9 切削直径公差

切削方向

切削方向

刀具标准

DIN 6527K DIN 6527K 长度标准

DORMER DORMER 长度标准

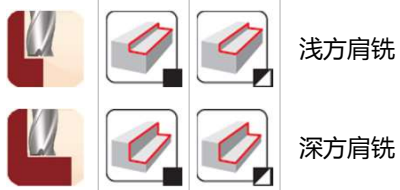
新图标

加工推荐

开槽工序



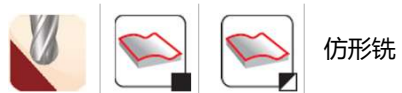
方肩铣



面铣



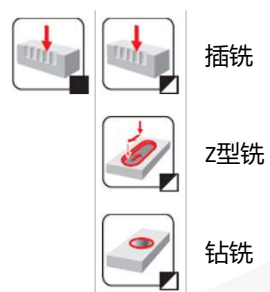
仿形铣



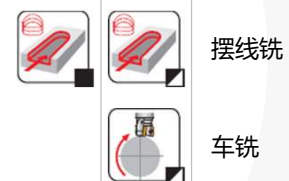
坡走铣



插铣



其他工序



切削数据

怎样识别数据?

新WMG 材料组

■ 首选

▣ 次选

切削数据仅在产品页

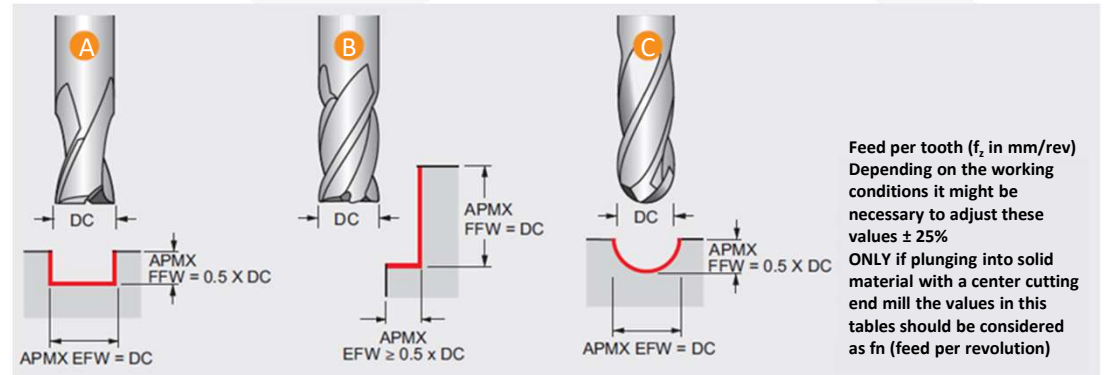
P1.1 ■ 199 J	P1.2 ■ 223 J	P1.3 ■ 230 J	P2.1 ■ 170 J	P2.2 ■ 150 J	P2.3 ■ 133 I	P3.1 ■ 138 J
M2.2 ■ 84 I	M3.1 ■ 94 I	M3.2 ■ 81 I	K1.1 ■ 196 J	K1.2 ■ 145 J	K1.3 ■ 109 J	K2.1 ■ 202 J
K4.3 ■ 91 I	K4.4 ■ 78 I	K4.5 ■ 65 I	K5.1 ■ 187 I	K5.2 ■ 141 I	K5.3 ■ 109 I	S1.2 ■ 69 I

Product Family Code														
		S722HB	S765HB	S768	S770HB	S771HB	S772HB	S773HB	S791	S561	S610	S611	S614	S629
		3.00 - 20.00	6.00 - 20.00	4.00 - 20.00	10.00 - 20.00	10.00 - 20.00	10.00 - 20.00	10.00 - 20.00	6.00 - 16.00	1.00 - 20.00	2.00 - 20.00	3.00 - 20.00	3.00 - 16.00	1.00 - 20.00
														
P	P1	■	■	■	■	■	■	■	■	■	■	■	■	■
	P2	■	■	■	■	■	■	■	■	■	■	■	■	■
	P3	■	■	■	■	■	■	■	■	■	■	■	■	■
	P4	■	■	■	■	■	■	■	■	■	■	■	■	■
M	M1	■	■	■	■	■	■	■	■	■	■	■	■	■
	M2	■	■	■	■	■	■	■	■	■	■	■	■	■
	M3	■	■	■	■	■	■	■	■	■	■	■	■	■
	M4	■	■	■	■	■	■	■	■	■	■	■	■	■
K	K1	■	■	■	■	■	■	■	■	■	■	■	■	■
	K2	■	■	■	■	■	■	■	■	■	■	■	■	■
	K3	■	■	■	■	■	■	■	■	■	■	■	■	■
	K4	■	■	■	■	■	■	■	■	■	■	■	■	■
	K5	■	■	■	■	■	■	■	■	■	■	■	■	■
N	N1	■	■	■	■	■	■	■	■	■	■	■	■	■
	N2	■	■	■	■	■	■	■	■	■	■	■	■	■
	N3	■	■	■	■	■	■	■	■	■	■	■	■	■
	N4	■	■	■	■	■	■	■	■	■	■	■	■	■
	N5	■	■	■	■	■	■	■	■	■	■	■	■	■
S	S1	■	■	■	■	■	■	■	■	■	■	■	■	■
	S2	■	■	■	■	■	■	■	■	■	■	■	■	■
	S3	■	■	■	■	■	■	■	■	■	■	■	■	■
	S4	■	■	■	■	■	■	■	■	■	■	■	■	■
H	H1	■	■	■	■	■	■	■	■	■	■	■	■	■
	H2	■	■	■	■	■	■	■	■	■	■	■	■	■
	H3	■	■	■	■	■	■	■	■	■	■	■	■	■
	H4	■	■	■	■	■	■	■	■	■	■	■	■	■

新的预览页仅展示适用性，不包括具体参数

切削数据

如何计算速度和进给等参数?



How to use this table to find the feed per tooth (f_z):

1. Find your Alpha Code on the product page (example: 170J, „J“ is the Alpha Code).
2. Find the closest diameter for your cutting application in the top row of the table.
3. Find your Alpha Code in the left column of the table.
4. The intersection (cell) of the Diameter and Alpha Code is the feed per tooth (f_z).

FOR SOLID
CARBIDE
MILLING
CUTTERS ONLY

P1.1	P1.2	P1.3	P2.1	P2.2
■ 199 J	■ 223 J	■ 230 J	■ 170 J	■ 150 J
M2.2	M3.1	M3.2	K1.1	K1.2
■ 84 I	■ 94 I	■ 81 I	■ 196 J	■ 145 J
K4.3	K4.4	K4.5	K5.1	K5.2
■ 91 I	■ 78 I	■ 65 I	■ 187 I	■ 141 I

	1.00	2.00	3.00	4.00	5.00	6.00	7.00	8.00	9.00	10.00	12.00	14.00	16.00	18.00	20.00	22.00	25.00
I	0.003	0.006	0.011	0.019	0.024	0.030	0.032	0.036	0.039	0.042	0.049	0.054	0.061	0.066	0.073	0.079	0.088
J	0.004	0.009	0.014	0.026	0.033	0.041	0.044	0.048	0.053	0.057	0.066	0.074	0.083	0.090	0.099	0.107	0.120
K	0.006	0.012	0.019	0.035	0.044	0.054	0.059	0.064	0.070	0.076	0.088	0.098	0.110	0.120	0.132	0.142	0.160

校正因子

如何校正速度和进给?

1 铣槽

铣槽工序中，不同切深下的线速度 v_c 和每齿进给 f_z 的校正因子

APMX FFW / DC	25%	50%	100%	150%				
	1.25	1.00	0.75	0.50				
	1.25	1.00	0.75	0.50				

2 方肩铣

方肩铣切宽<50%时的线速度 v_c 和每齿进给 f_z 的校正因子

APMX EFW / DC	5%	10%	15%	20%	25%	30%	40%	≥ 50%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.00
	2.29	1.67	1.40	1.25	1.15	1.09	1.02	1.00

推荐不要在正好50%切宽的工况下应用

校正因子

如何计算球头铣刀的校正因子?

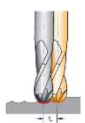
3a 平面仿形铣 (球头铣)

不同切深下的平面仿形铣的线速度 v_c 校正因子

APMX FFW / DC	5%	10%	15%	20%	25%	30%	40%	50%
	2.29	1.67	1.40	1.25	1.15	1.09	1.02	1.00

3b

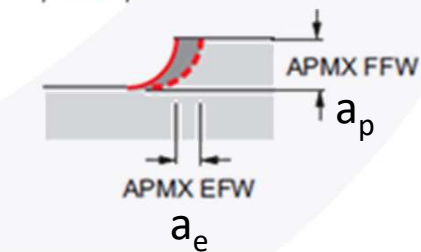
偏移量 f_e (步距) 可达到的理论粗糙度 R_{th}

$\varnothing DC$	μm	2	4	8	16	32	63	125	250
2		0.13	0.18	0.25	0.36	0.50	0.70	0.97	1.32
3		0.15	0.22	0.31	0.44	0.62	0.86	1.20	1.66
4		0.18	0.25	0.36	0.50	0.71	1.00	1.39	1.94
5		0.20	0.28	0.40	0.56	0.80	1.12	1.56	2.18
6		0.22	0.31	0.44	0.62	0.87	1.22	1.71	2.40
8		0.25	0.36	0.51	0.71	1.01	1.41	1.98	2.78

3c

偏移量 $< 50\% \times D$ 时, 不同切深下的平面仿形中每齿进给 f_z 的校正因子

APMX FFW	APMX EFW	5%	10%	15%	20%	25%	30%	35%	40%	50%
5%		5.26	3.82	3.21	2.87	2.65	2.50	2.40	2.34	2.29
10%		3.82	2.78	2.33	2.08	1.92	1.82	1.75	1.70	1.67
15%		3.21	2.33	1.96	1.75	1.62	1.53	1.47	1.43	1.40
20%		2.87	2.08	1.75	1.56	1.44	1.36	1.31	1.28	1.25
25%		2.65	1.92	1.62	1.44	1.33	1.26	1.21	1.18	1.15
30%		2.50	1.82	1.53	1.36	1.26	1.19	1.14	1.11	1.09

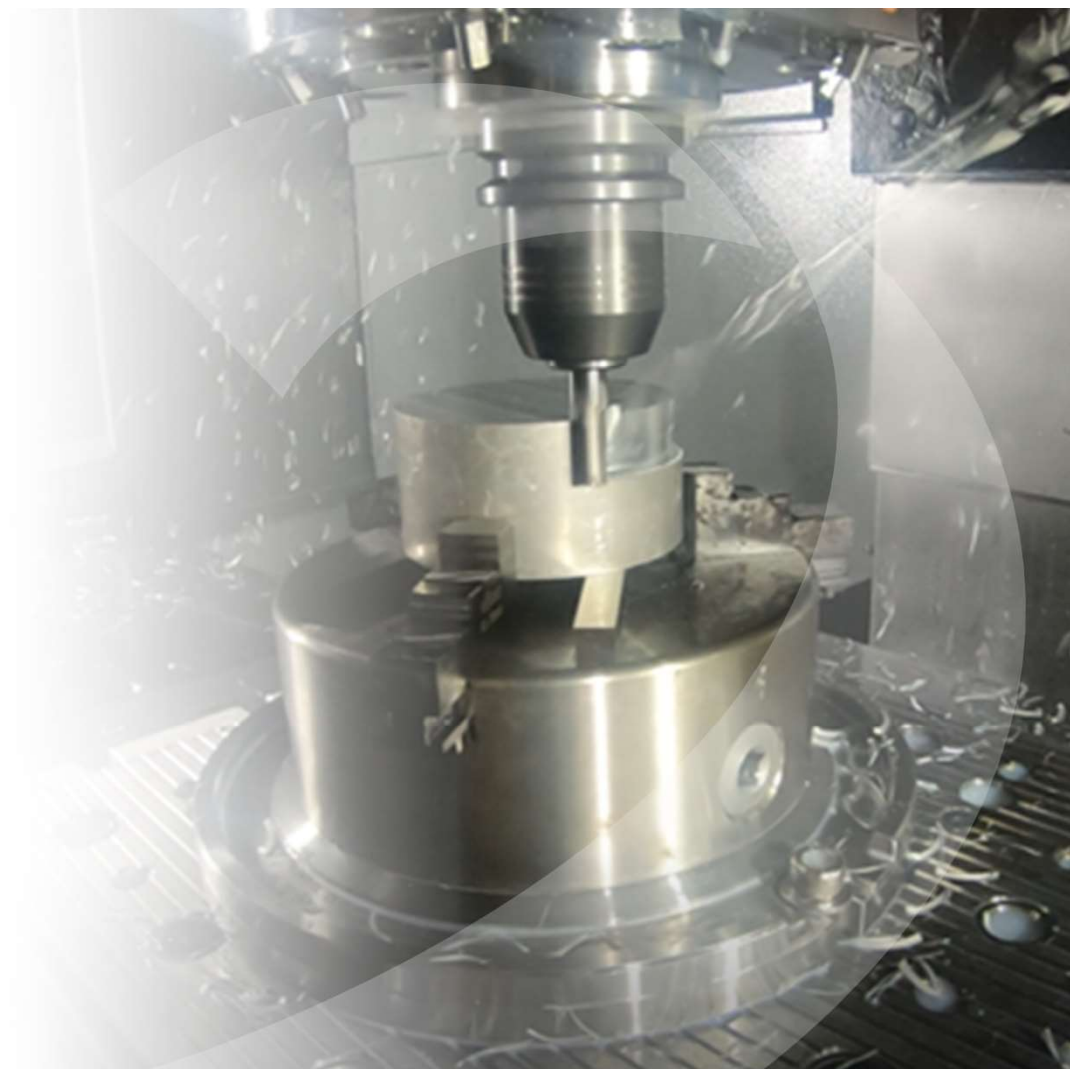




销售信息

S6xx 系列

整体硬质合金铝用铣刀



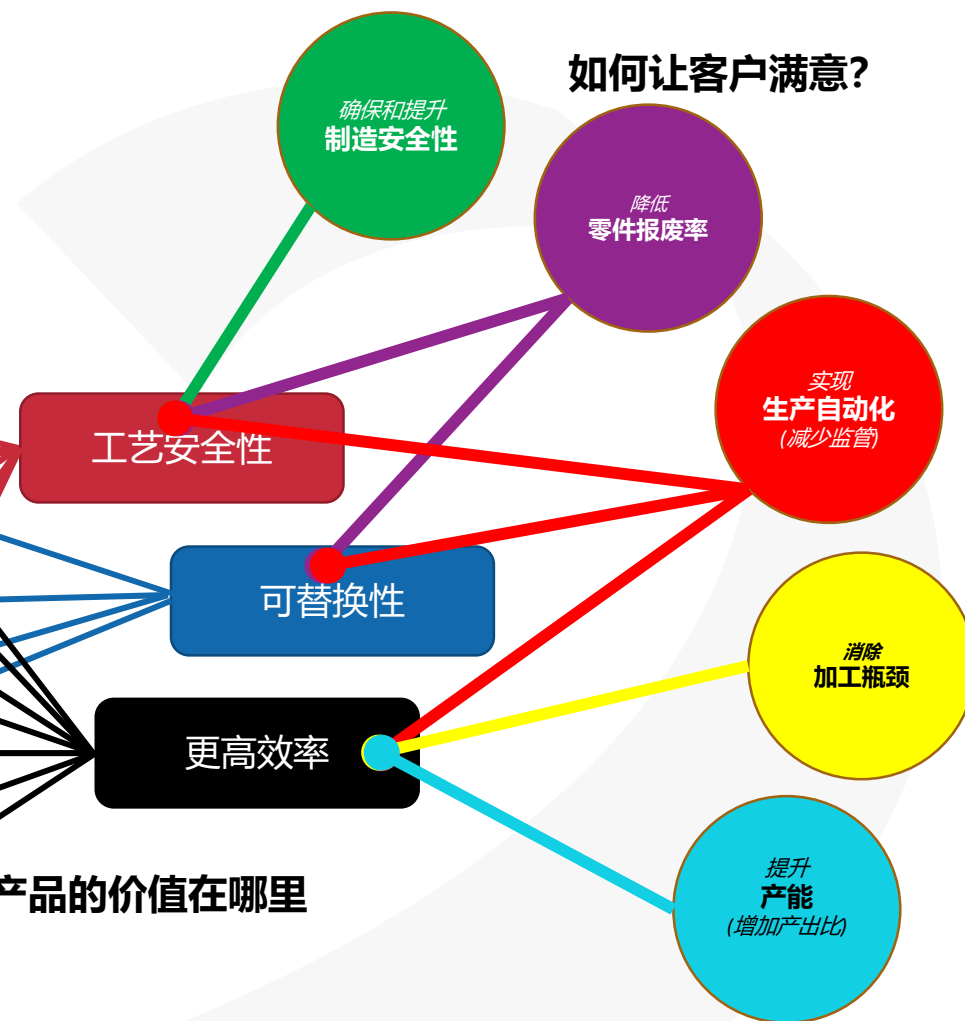
销售信息

产品的卖点在哪里？

产品特点	产品优势
特殊基体材质	可实现更高线速度
不等齿距	降低振动
	效率最大化
3-齿设计	提升切削的光顺性
	降低主轴应力
4-齿设计 带刀尖圆角	增强底刀强度
正前角	提供光顺切削
铝合金专用槽型	提升加工有色金属时的性能
	工件表面更优质
	降低积屑瘤的风险
缩颈设计	方肩铣时避免与墙壁接触
NRA/W 刃型	提升断屑能力
	降低主轴负载
	提升金属去除率

产品的价值在哪里

如何让客户满意？



DORMER PRAMET



SIMPLY
RELIABLE



/DormerPrametSocial



Dormer Pramet



@DormerPramet



Dormer Pramet



dormerpramet.com

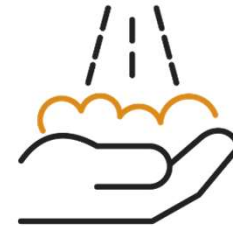
COVID-19 PRECAUTIONS



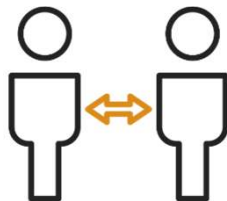
**FOLLOW LOCAL
GUIDELINES**



**STAY HOME WHEN
FEELING SICK**



**WASH YOUR HANDS
CAREFULLY**



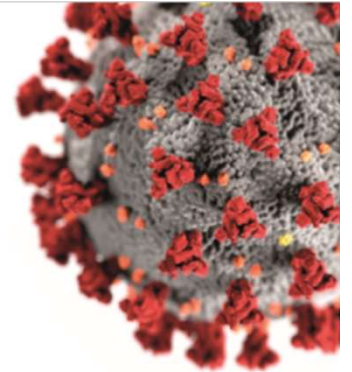
**OBSERVE PHYSICAL
DISTANCING GUIDELINES**



**COUGH AND SNEEZE
CORRECTLY**



**AVOID TOUCHING
YOUR FACE**



SC 热胀刀柄 HOLDERS

Tooling systems

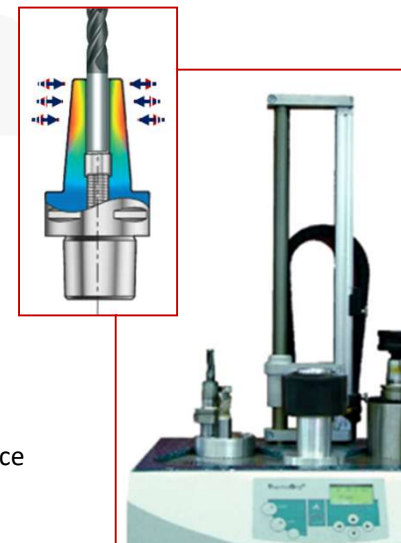
描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	3 - 20	•	•	•		•	•	•			•	•
	25 - 32		•	•			•	•			•	•

SC



Form AD/B
 $\nabla \leq 0,003$
 G6,3 15.000 min⁻¹

- Requires a shrink-fit device
- For h6 shanks
- For finishing
- High torque transmission
- High levels of accuracy
- Extremely rigid



S650									
介绍	规格	材料	重量	长度	直径	内径	螺纹	孔距	备注
1	10	SK30	0.15	100	30	10	M10	100	
2	15	SK40	0.25	150	40	15	M15	150	
3	20	SK50	0.40	200	50	20	M20	200	
4	25	SK60	0.60	250	60	25	M25	250	
5	30	SK80	1.00	300	80	30	M30	300	
6	40	SK100	1.50	400	100	40	M40	400	
7	50	SK125	2.50	500	125	50	M50	500	
8	63	SK160	4.00	630	160	63	M63	630	
9	80	SK200	6.00	800	200	80	M80	800	
10	100	SK250	10.00	1000	250	100	M100	1000	

HC 液压刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	6 – 20	•	•	•		•	•	•			•	•
	25 – 32		•	•			•	•			•	•
	40			•								

HC



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



HC-C



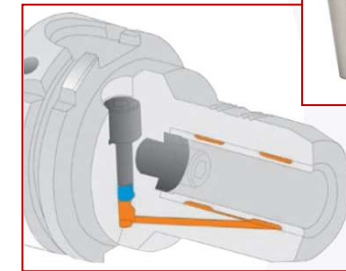
HC-C-S

Sealed for tough coolant

Torque

Clamping- $\varnothing$ mm	Moment (Nm)
6	10
8	20
10	40
12	50
14	80
16	100
18	150
20	200
25	250
32	400
40	550

- Easy handling
- For h6 shanks
- **For finishing and super finishing**
- Medium-high torque transmission
- High run-out accuracy
- Dampen vibrations in low speed range



HKS 强力刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
High-performance Chuck	3 – 20		•	•			•	•			•	•
	25 – 32		•	•			•	•			•	•

HKS



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



HKS-C

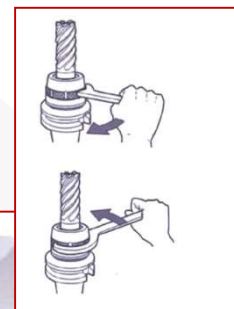
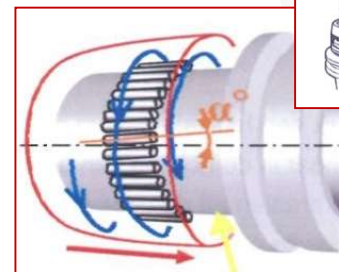


HKS-C-S

Sealed for tough coolant

Size	20mm	25mm
Clamping torque	50-70 Nm	80-100 Nm
Clamping force	780 Nm	2000 Nm

- Easy handling
- For h6 shanks
- **For operations involving high MRR**
- High retention force
- High torque transmission
- Highest stability
- Accurate
- Flexible



5650

介绍

规格	材料	重量	长度	直径	精度	表面粗糙度	热处理	检验
5650-1	45#	0.15kg	100mm	16mm	IT6	0.8	调质	尺寸
5650-2	45#	0.15kg	100mm	16mm	IT6	0.8	调质	尺寸
5650-3	45#	0.15kg	100mm	16mm	IT6	0.8	调质	尺寸
5650-4	45#	0.15kg	100mm	16mm	IT6	0.8	调质	尺寸
5650-5	45#	0.15kg	100mm	16mm	IT6	0.8	调质	尺寸
5650-6	45#	0.15kg	100mm	16mm	IT6	0.8	调质	尺寸
5650-7	45#	0.15kg	100mm	16mm	IT6	0.8	调质	尺寸
5650-8	45#	0.15kg	100mm	16mm	IT6	0.8	调质	尺寸
5650-9	45#	0.15kg	100mm	16mm	IT6	0.8	调质	尺寸
5650-10	45#	0.15kg	100mm	16mm	IT6	0.8	调质	尺寸

5650-1 5650-2 5650-3 5650-4 5650-5 5650-6 5650-7 5650-8 5650-9 5650-10

ER COLLET CHUCK

Tooling systems

ER Collet chuck are not the first choice to recommend for holding indexable milling cutters. However if a customer wants to, we should recommend to use at least high precision collets (ER-C-P or ER-C-SC4)!

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A		DIN 228-1					
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100	MT2	MT3	MT4	MT5	MT6	
ER Collet Chuck	1 – 10 (ER16)	●	●	●		●	●	●			●		●					
	2 – 16 (ER25)	●	●	●		●	●	●	●		●	●	●	●	●			
	2 – 20 (ER32)	●	●	●		●	●	●	●	●	●	●		●	●			
	3 – 26 (ER40)	●	●	●		●	●	●	●	●	●	●				●		

CC-ER



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



- Medium torque transmission
- Low to medium run-out accuracy
- Assembly requires some instruction (read instructions) 
- Moderate repeatability
- Dampen vibration
- Not suited for high speeds
- Flexible (broader range of collets than OZ system)
- Clean carefully
- Rotate the tool to achieve best run-out



SC 热胀刀柄 HOLDERS

Tooling systems

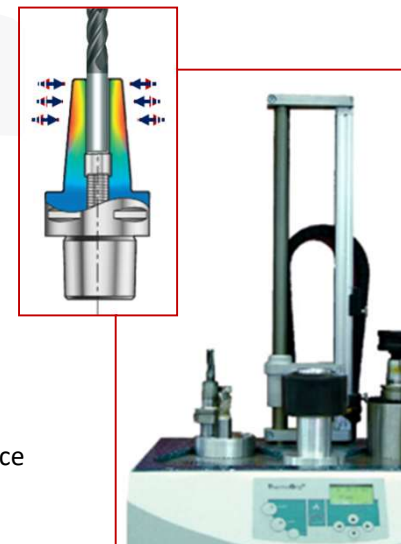
描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	3 - 20	•	•	•		•	•	•			•	•
	25 - 32		•	•			•	•			•	•

SC



Form AD/B
 $\nabla \leq 0,003$
 G6.3 15.000 min⁻¹

- Requires a shrink-fit device
- For h6 shanks
- For finishing
- High torque transmission
- High levels of accuracy
- Extremely rigid



5614

介绍

规格	长度	重量	最大夹紧力	最大扭矩	最大转速
100	100	1.5	1000	100	15000
125	125	2.5	1500	150	15000
160	160	4.5	2500	250	15000
200	200	8.5	4000	400	15000
250	250	15.0	6000	600	15000
315	315	25.0	10000	1000	15000
400	400	45.0	15000	1500	15000
500	500	80.0	25000	2500	15000
630	630	150.0	40000	4000	15000
800	800	250.0	60000	6000	15000
1000	1000	450.0	100000	10000	15000

产品特点:

- 高精度
- 高刚性
- 高扭矩
- 高转速
- 高寿命

HC 液压刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	6 – 20	•	•	•		•	•	•			•	•
	25 – 32		•	•			•	•			•	•
	40			•								

HC



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹

HC-C



HC-C-S

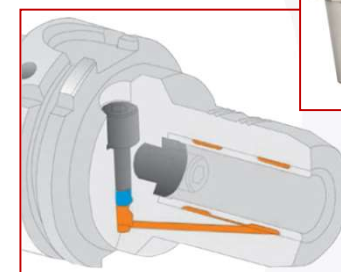
Sealed for tough coolant



Torque

Clamping- $\varnothing$ mm	Moment (Nm)
6	10
8	20
10	40
12	50
14	80
16	100
18	150
20	200
25	250
32	400
40	550

- Easy handling
- For h6 shanks
- **For finishing and super finishing**
- Medium-high torque transmission
- High run-out accuracy
- Dampen vibrations in low speed range



HKS 强力刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
High-performance Chuck	3 – 20		•	•			•	•			•	•
	25 – 32		•	•			•	•			•	•

HKS



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



HKS-C

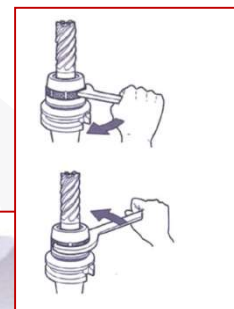
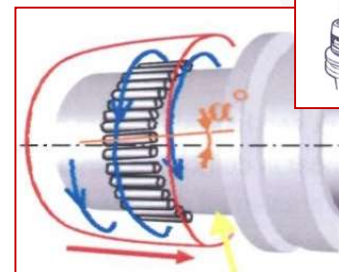


HKS-C-S

Sealed for through coolant

Size	20mm	25mm
Clamping torque	50-70 Nm	80-100 Nm
Clamping force	780 Nm	2000 Nm

- Easy handling
- For h6 shanks
- **For operations involving high MRR**
- High retention force
- High torque transmission
- Highest stability
- Accurate
- Flexible



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Tooling systems

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描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A		DIN 228-1					
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100	MT2	MT3	MT4	MT5	MT6	
ER Collet Chuck	1 – 10 (ER16)	●	●	●		●	●	●			●		●					
	2 – 16 (ER25)	●	●	●		●	●	●	●		●	●	●	●	●			
	2 – 20 (ER32)	●	●	●		●	●	●	●	●	●	●		●	●			
	3 – 26 (ER40)	●	●	●		●	●	●	●	●	●	●				●		

CC-ER



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



- Medium torque transmission
- Low to medium run-out accuracy
- Assembly requires some instruction (read instructions) 
- Moderate repeatability
- Dampen vibration
- Not suited for high speeds
- Flexible (broader range of collets than OZ system)
- Clean carefully
- Rotate the tool to achieve best run-out



SC 热胀刀柄 HOLDERS

Tooling systems

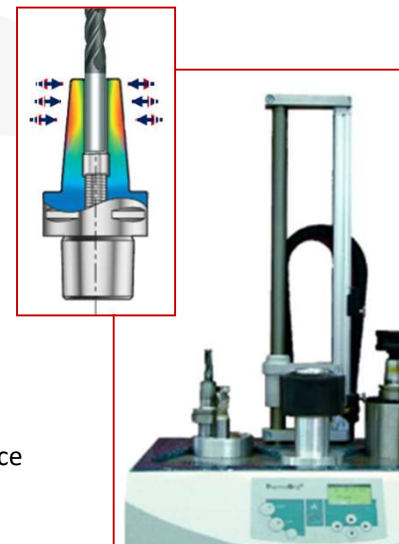
描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	3 - 20	•	•	•		•	•	•			•	•
	25 - 32		•	•			•	•			•	•

SC



Form AD/B
 $\nabla \leq 0,003$
 G6.3 15.000 min⁻¹

- Requires a shrink-fit device
- For h6 shanks
- For finishing
- High torque transmission
- High levels of accuracy
- Extremely rigid



HC 液压刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	6 – 20	•	•	•		•	•	•			•	•
	25 – 32		•	•			•	•			•	•
	40			•								

HC



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



HC-C



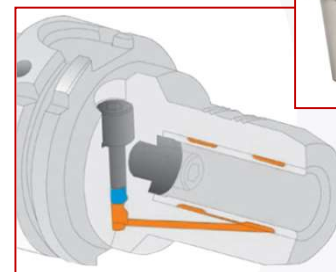
HC-C-S

Sealed for tough coolant

Torque

Clamping- $\varnothing$ mm	Moment (Nm)
6	10
8	20
10	40
12	50
14	80
16	100
18	150
20	200
25	250
32	400
40	550

- Easy handling
- For h6 shanks
- **For finishing and super finishing**
- Medium-high torque transmission
- High run-out accuracy
- Dampen vibrations in low speed range



HKS 强力刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
High-performance Chuck	3 – 20		•	•			•	•			•	•
	25 – 32		•	•			•	•			•	•

HKS



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



HKS-C

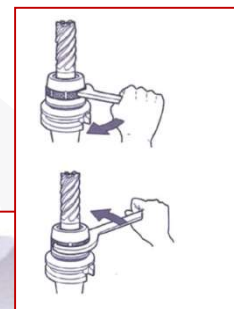
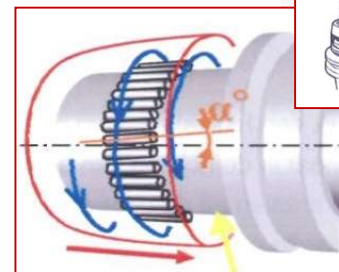


HKS-C-S

Sealed for tough coolant

Size	20mm	25mm
Clamping torque	50-70 Nm	80-100 Nm
Clamping force	780 Nm	2000 Nm

- Easy handling
- For h6 shanks
- **For operations involving high MRR**
- High retention force
- High torque transmission
- Highest stability
- Accurate
- Flexible



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描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A		DIN 228-1				
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100	MT2	MT3	MT4	MT5	MT6
ER Collet Chuck	1 – 10 (ER16)	●	●	●		●	●	●			●		●				
	2 – 16 (ER25)	●	●	●		●	●	●	●		●	●	●	●	●		
	2 – 20 (ER32)	●	●	●		●	●	●	●	●	●	●		●	●		
	3 – 26 (ER40)	●	●	●		●	●	●	●	●	●	●				●	

CC-ER



- Medium torque transmission
- Low to medium run-out accuracy
- Assembly requires some instruction (read instructions) 
- Moderate repeatability
- Dampen vibration
- Not suited for high speeds
- Flexible (broader range of collets than OZ system)
- Clean carefully
- Rotate the tool to achieve best run-out



SC 热胀刀柄 HOLDERS

Tooling systems

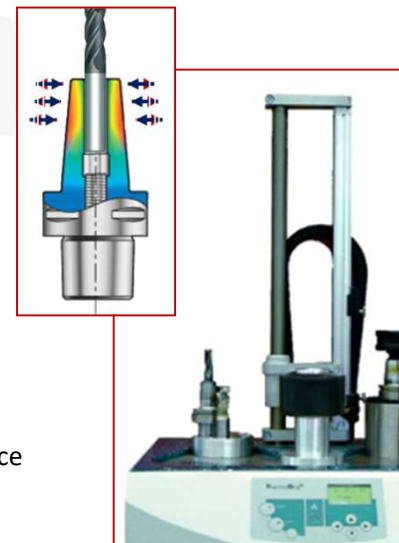
描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	3 - 20	•	•	•		•	•	•			•	•
	25 - 32		•	•			•	•			•	•

SC



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹

- Requires a shrink-fit device
- For h6 shanks
- For finishing
- High torque transmission
- High levels of accuracy
- Extremely rigid



5662

介绍

规格	材料	重量	长度	直径	精度	公差	表面粗糙度	热处理	涂层	备注
SK30	SK30	0.15	100	30	IT6	±0.005	0.4	调质	无	
SK40	SK40	0.25	100	40	IT6	±0.005	0.4	调质	无	
SK50	SK50	0.45	100	50	IT6	±0.005	0.4	调质	无	
SK60	SK60	0.85	100	60	IT6	±0.005	0.4	调质	无	
BT30	BT30	0.15	100	30	IT6	±0.005	0.4	调质	无	
BT40	BT40	0.25	100	40	IT6	±0.005	0.4	调质	无	
BT50	BT50	0.45	100	50	IT6	±0.005	0.4	调质	无	
SK40	SK40	0.25	100	40	IT6	±0.005	0.4	调质	无	
SK50	SK50	0.45	100	50	IT6	±0.005	0.4	调质	无	
HSK63	HSK63	0.15	100	63	IT6	±0.005	0.4	调质	无	
HSK100	HSK100	0.85	100	100	IT6	±0.005	0.4	调质	无	

HC 液压刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	6 – 20	•	•	•		•	•	•			•	•
	25 – 32		•	•			•	•			•	•
	40			•								

HC



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



HC-C



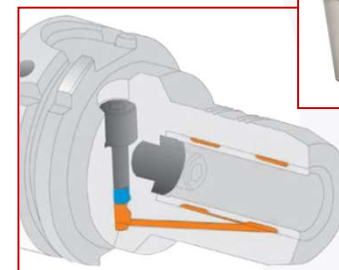
HC-C-S

Sealed for tough coolant

Torque

Clamping- $\varnothing$ mm	Moment (Nm)
6	10
8	20
10	40
12	50
14	80
16	100
18	150
20	200
25	250
32	400
40	550

- Easy handling
- For h6 shanks
- **For finishing and super finishing**
- Medium-high torque transmission
- High run-out accuracy
- Dampen vibrations in low speed range



5662

介绍

规格	10	12	16	20	25	32	40
最大夹持直径 (mm)	10	12	16	20	25	32	40
最大夹持长度 (mm)	100	120	160	200	250	320	400
最大夹持重量 (kg)	0.5	0.8	1.2	1.8	2.5	3.5	5.0
最大夹持力 (kN)	1.0	1.5	2.0	3.0	4.0	5.5	7.5
最大夹持力矩 (Nm)	10	20	40	80	150	250	400
最大夹持力矩 (kgf·cm)	100	200	400	800	1500	2500	4000
最大夹持力矩 (lbf·in)	7.2	14.4	28.8	57.6	115.2	192.0	294.4
最大夹持力矩 (kgf·m)	0.1	0.2	0.4	0.8	1.5	2.5	4.0
最大夹持力矩 (lbf·ft)	0.007	0.014	0.029	0.058	0.115	0.192	0.294
最大夹持力矩 (N·m)	10	20	40	80	150	250	400
最大夹持力矩 (kgf·cm)	100	200	400	800	1500	2500	4000
最大夹持力矩 (lbf·in)	7.2	14.4	28.8	57.6	115.2	192.0	294.4
最大夹持力矩 (kgf·m)	0.1	0.2	0.4	0.8	1.5	2.5	4.0
最大夹持力矩 (lbf·ft)	0.007	0.014	0.029	0.058	0.115	0.192	0.294

HKS 强力刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
High-performance Chuck	3 – 20		•	•			•	•			•	•
	25 – 32		•	•			•	•			•	•

HKS



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



HKS-C

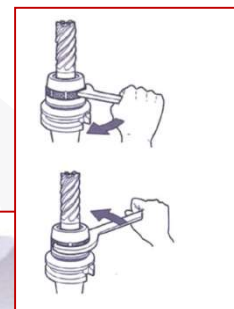
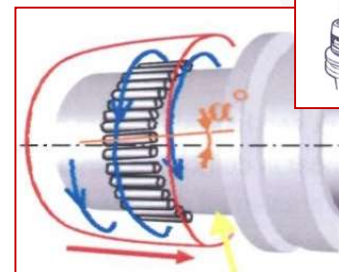


HKS-C-S

Sealed for through coolant

Size	20mm	25mm
Clamping torque	50-70 Nm	80-100 Nm
Clamping force	780 Nm	2000 Nm

- Easy handling
- For h6 shanks
- **For operations involving high MRR**
- High retention force
- High torque transmission
- Highest stability
- Accurate
- Flexible



5662

介绍

规格	材料	重量	长度	直径	公差	表面粗糙度	热处理	硬度	应用
SK30	SK30	0.15kg	100mm	30mm	±0.01mm	0.4μm	调质	HRC28-30	通用
SK40	SK40	0.25kg	100mm	40mm	±0.01mm	0.4μm	调质	HRC28-30	通用
SK50	SK50	0.45kg	100mm	50mm	±0.01mm	0.4μm	调质	HRC28-30	通用
SK60	SK60	0.75kg	100mm	60mm	±0.01mm	0.4μm	调质	HRC28-30	通用
BT30	BT30	0.15kg	100mm	30mm	±0.01mm	0.4μm	调质	HRC28-30	通用
BT40	BT40	0.25kg	100mm	40mm	±0.01mm	0.4μm	调质	HRC28-30	通用
BT50	BT50	0.45kg	100mm	50mm	±0.01mm	0.4μm	调质	HRC28-30	通用
SK40	SK40	0.25kg	100mm	40mm	±0.01mm	0.4μm	调质	HRC28-30	通用
SK50	SK50	0.45kg	100mm	50mm	±0.01mm	0.4μm	调质	HRC28-30	通用
HSK63	HSK63	0.15kg	100mm	63mm	±0.01mm	0.4μm	调质	HRC28-30	通用
HSK100	HSK100	0.75kg	100mm	100mm	±0.01mm	0.4μm	调质	HRC28-30	通用

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Tooling systems

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描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A		DIN 228-1					
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100	MT2	MT3	MT4	MT5	MT6	
ER Collet Chuck	1 – 10 (ER16)	●	●	●		●	●	●			●		●					
	2 – 16 (ER25)	●	●	●		●	●	●	●		●	●	●	●	●			
	2 – 20 (ER32)	●	●	●		●	●	●	●	●	●	●		●	●			
	3 – 26 (ER40)	●	●	●		●	●	●	●	●	●	●				●		

CC-ER



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



- Medium torque transmission
- Low to medium run-out accuracy
- Assembly requires some instruction (read instructions)
- Moderate repeatability
- Dampen vibration
- Not suited for high speeds
- Flexible (broader range of collets than OZ system)
- Clean carefully
- Rotate the tool to achieve best run-out



SC 热胀刀柄 HOLDERS

Tooling systems

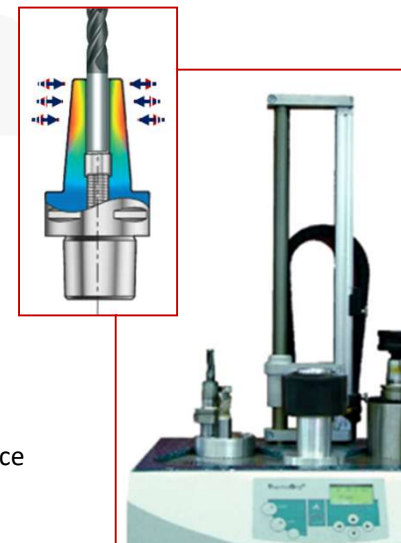
描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	3 - 20	•	•	•		•	•	•			•	•
	25 - 32		•	•			•	•			•	•

SC



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹

- Requires a shrink-fit device
- For h6 shanks
- For finishing
- High torque transmission
- High levels of accuracy
- Extremely rigid



5610

介绍

规格	长度	重量	最大夹紧力	最大扭矩	最大转速
100	100	1.2	1000	100	15000
125	125	1.5	1250	125	15000
160	160	2.0	1600	160	15000
200	200	2.5	2000	200	15000
250	250	3.0	2500	250	15000
315	315	3.5	3150	315	15000
400	400	4.0	4000	400	15000
500	500	4.5	5000	500	15000
630	630	5.0	6300	630	15000
800	800	5.5	8000	800	15000
1000	1000	6.0	10000	1000	15000

产品特点

- 高精度
- 高刚性
- 高扭矩
- 高转速
- 高寿命

应用范围

- 精密加工
- 高速加工
- 重载加工
- 高精度加工

HC 液压刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	6 – 20	•	•	•		•	•	•			•	•
	25 – 32		•	•			•	•			•	•
	40			•								

HC



HC-C



HC-C-S

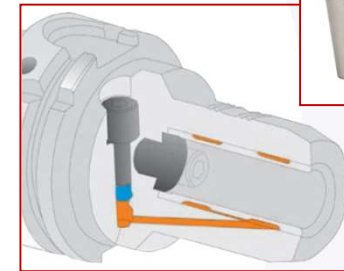
Sealed for tough coolant



Torque

Clamping- $\varnothing$ mm	Moment (Nm)
6	10
8	20
10	40
12	50
14	80
16	100
18	150
20	200
25	250
32	400
40	550

- Easy handling
- For h6 shanks
- **For finishing and super finishing**
- Medium-high torque transmission
- High run-out accuracy
- Dampen vibrations in low speed range



HKS 强力刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
High-performance Chuck	3 – 20		•	•			•	•			•	•
	25 – 32		•	•			•	•			•	•

HKS



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



HKS-C

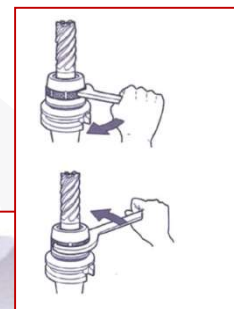
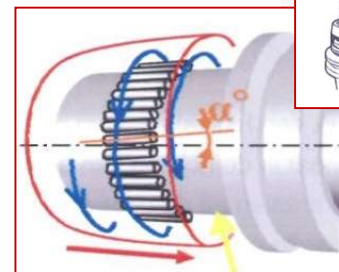


HKS-C-S

Sealed for tough coolant

Size	20mm	25mm
Clamping torque	50-70 Nm	80-100 Nm
Clamping force	780 Nm	2000 Nm

- Easy handling
- For h6 shanks
- **For operations involving high MRR**
- High retention force
- High torque transmission
- Highest stability
- Accurate
- Flexible



5610

介绍

规格	100	125	160	200	250	315	400	500	630	800	1000
最大夹持直径 (mm)	10	12.5	16	20	25	31.5	40	50	63	80	100
最大夹持长度 (mm)	100	125	160	200	250	315	400	500	630	800	1000
最大夹持力 (kN)	1.5	2.5	4.0	6.3	10.0	16.0	25.0	40.0	63.0	100.0	160.0
最大夹持扭矩 (Nm)	15	25	40	63	100	160	250	400	630	1000	1600

产品特点:

- 高精度: 符合 DIN 69871 标准
- 高刚性: 采用高强度材料制造
- 高稳定性: 采用先进的加工工艺
- 高可靠性: 经过严格的测试和验证

ER COLLET CHUCK

Tooling systems

ER Collet chuck are not the first choice to recommend for holding indexable milling cutters. However if a customer wants to, we should recommend to use at least high precision collets (ER-C-P or ER-C-SC4)!

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A		DIN 228-1				
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100	MT2	MT3	MT4	MT5	MT6
ER Collet Chuck	1 – 10 (ER16)	●	●	●		●	●	●			●		●				
	2 – 16 (ER25)	●	●	●		●	●	●	●		●	●	●	●	●		
	2 – 20 (ER32)	●	●	●		●	●	●	●	●	●	●		●	●		
	3 – 26 (ER40)	●	●	●		●	●	●	●	●	●	●				●	

CC-ER



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



- Medium torque transmission
- Low to medium run-out accuracy
- Assembly requires some instruction (read instructions) 
- Moderate repeatability
- Dampen vibration
- Not suited for high speeds
- Flexible (broader range of collets than OZ system)
- Clean carefully
- Rotate the tool to achieve best run-out



SC 热胀刀柄 HOLDERS

Tooling systems

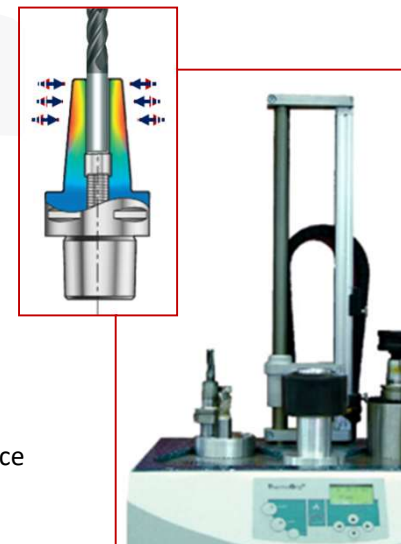
描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	3 - 20	•	•	•		•	•	•			•	•
	25 - 32		•	•			•	•			•	•

SC



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹

- Requires a shrink-fit device
- For h6 shanks
- For finishing
- High torque transmission
- High levels of accuracy
- Extremely rigid



5611									
介绍									
系列	规格	最大直径 (mm)	最大长度 (mm)	最大重量 (kg)	最大扭矩 (Nm)	最大转速 (min ⁻¹)	最大进给 (mm/min)	最大切削力 (kN)	最大切削速度 (m/min)
SC	SC30	30	100	0.5	100	10000	1000	10	100
SC	SC40	40	100	0.8	150	10000	1000	15	100
SC	SC50	50	100	1.2	200	10000	1000	20	100
SC	SC60	60	100	1.8	300	10000	1000	30	100
SC	SC80	80	100	3.0	500	10000	1000	50	100
SC	SC100	100	100	5.0	800	10000	1000	80	100

HC 液压刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	6 – 20	•	•	•		•	•	•			•	•
	25 – 32		•	•			•	•			•	•
	40			•								

HC



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



HC-C



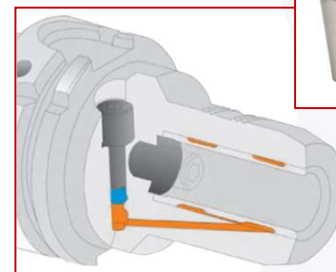
HC-C-S

Sealed for tough coolant

Torque

Clamping- $\varnothing$ mm	Moment (Nm)
6	10
8	20
10	40
12	50
14	80
16	100
18	150
20	200
25	250
32	400
40	550

- Easy handling
- For h6 shanks
- **For finishing and super finishing**
- Medium-high torque transmission
- High run-out accuracy
- Dampen vibrations in low speed range



Tooling systems



HKS-C

Size

Class

Cl

*Sealed for though
coolant*

5611

介紹

型號	規格	材料	長度	重量	價格	備註
5611-01	1/4"	304	100	0.05	100	
5611-02	1/4"	304	150	0.08	150	
5611-03	1/4"	304	200	0.12	200	
5611-04	1/4"	304	250	0.15	250	
5611-05	1/4"	304	300	0.18	300	
5611-06	1/4"	304	350	0.22	350	
5611-07	1/4"	304	400	0.25	400	
5611-08	1/4"	304	450	0.28	450	
5611-09	1/4"	304	500	0.32	500	
5611-10	1/4"	304	550	0.35	550	
5611-11	1/4"	304	600	0.38	600	
5611-12	1/4"	304	650	0.42	650	
5611-13	1/4"	304	700	0.45	700	
5611-14	1/4"	304	750	0.48	750	
5611-15	1/4"	304	800	0.52	800	
5611-16	1/4"	304	850	0.55	850	
5611-17	1/4"	304	900	0.58	900	
5611-18	1/4"	304	950	0.62	950	
5611-19	1/4"	304	1000	0.65	1000	
5611-20	1/4"	304	1050	0.68	1050	
5611-21	1/4"	304	1100	0.72	1100	
5611-22	1/4"	304	1150	0.75	1150	
5611-23	1/4"	304	1200	0.78	1200	
5611-24	1/4"	304	1250	0.82	1250	
5611-25	1/4"	304	1300	0.85	1300	
5611-26	1/4"	304	1350	0.88	1350	
5611-27	1/4"	304	1400	0.92	1400	
5611-28	1/4"	304	1450	0.95	1450	
5611-29	1/4"	304	1500	0.98	1500	
5611-30	1/4"	304	1550	1.02	1550	
5611-31	1/4"	304	1600	1.05	1600	
5611-32	1/4"	304	1650	1.08	1650	
5611-33	1/4"	304	1700	1.12	1700	
5611-34	1/4"	304	1750	1.15	1750	
5611-35	1/4"	304	1800	1.18	1800	
5611-36	1/4"	304	1850	1.22	1850	
5611-37	1/4"	304	1900	1.25	1900	
5611-38	1/4"	304	1950	1.28	1950	
5611-39	1/4"	304	2000	1.32	2000	
5611-40	1/4"	304	2050	1.35	2050	
5611-41	1/4"	304	2100	1.38	2100	
5611-42	1/4"	304	2150	1.42	2150	
5611-43	1/4"	304	2200	1.45	2200	
5611-44	1/4"	304	2250	1.48	2250	
5611-45	1/4"	304	2300	1.52	2300	
5611-46	1/4"	304	2350	1.55	2350	
5611-47	1/4"	304	2400	1.58	2400	
5611-48	1/4"	304	2450	1.62	2450	
5611-49	1/4"	304	2500	1.65	2500	
5611-50	1/4"	304	2550	1.68	2550	
5611-51	1/4"	304	2600	1.72	2600	
5611-52	1/4"	304	2650	1.75	2650	
5611-53	1/4"	304	2700	1.78	2700	
5611-54	1/4"	304	2750	1.82	2750	
5611-55	1/4"	304	2800	1.85	2800	
5611-56	1/4"	304	2850	1.88	2850	
5611-57	1/4"	304	2900	1.92	2900	
5611-58	1/4"	304	2950	1.95	2950	
5611-59	1/4"	304	3000	1.98	3000	
5611-60	1/4"	304	3050	2.02	3050	
5611-61	1/4"	304	3100	2.05	3100	
5611-62	1/4"	304	3150	2.08	3150	
5611-63	1/4"	304	3200	2.12	3200	
5611-64	1/4"	304	3250	2.15	3250	
5611-65	1/4"	304	3300	2.18	3300	
5611-66	1/4"	304	3350	2.22	3350	
5611-67	1/4"	304	3400	2.25	3400	
5611-68	1/4"	304	3450	2.28	3450	
5611-69	1/4"	304	3500	2.32	3500	
5611-70	1/4"	304	3550	2.35	3550	
5611-71	1/4"	304	3600	2.38	3600	
5611-72	1/4"	304	3650	2.42	3650	
5611-73	1/4"	304	3700	2.45	3700	
5611-74	1/4"	304	3750	2.48	3750	
5611-75	1/4"	304	3800	2.52	3800	
5611-76	1/4"	304	3850	2.55	3850	
5611-77	1/4"	304	3900	2.58	3900	
5611-78	1/4"	304	3950	2.62	3950	
5611-79	1/4"	304	4000	2.65	4000	
5611-80	1/4"	304	4050	2.68	4050	
5611-81	1/4"	304	4100	2.72	4100	
5611-82	1/4"	304	4150	2.75	4150	
5611-83	1/4"	304	4200	2.78	4200	
5611-84	1/4"	304	4250	2.82	4250	
5611-85	1/4"	304	4300	2.85	4300	
5611-86	1/4"	304	4350	2.88	4350	
5611-87	1/4"	304	4400	2.92	4400	
5611-88	1/4"	304	4450	2.95	4450	
5611-89	1/4"	304	4500	2.98	4500	
5611-90	1/4"	304	4550	3.02	4550	
5611-91	1/4"	304	4600	3.05	4600	
5611-92	1/4"	304	4650	3.08	4650	
5611-93	1/4"	304	4700	3.12	4700	
5611-94	1/4"	304	4750	3.15	4750	
5611-95	1/4"	304	4800	3.18	4800	
5611-96	1/4"	304	4850	3.22	4850	
5611-97	1/4"	304	4900	3.25	4900	
5611-98	1/4"	304	4950	3.28	4950	
5611-99	1/4"	304	5000	3.32	5000	
5611-100	1/4"	304	5050	3.35	5050	

5611-01 1/4" 304 100 0.05 100

5611-02 1/4" 304 150 0.08 150

5611-03 1/4" 304 200 0.12 200

5611-04 1/4" 304 250 0.15 250

5611-05 1/4" 304 300 0.18 300

5611-06 1/4" 304 350 0.22 350

5611-07 1/4" 304 400 0.25 400

5611-08 1/4" 304 450 0.28 450

5611-09 1/4" 304 500 0.32 500

5611-10 1/4" 304 550 0.35 550

5611-11 1/4" 304 600 0.38 600

5611-12 1/4" 304 650 0.42 650

5611-13 1/4" 304 700 0.45 700

5611-14 1/4" 304 750 0.48 750

5611-15 1/4" 304 800 0.52 800

5611-16 1/4" 304 850 0.55 850

5611-17 1/4" 304 900 0.58 900

5611-18 1/4" 304 950 0.62 950

5611-19 1/4" 304 1000 0.65 1000

5611-20 1/4" 304 1050 0.68 1050

5611-21 1/4" 304 1100 0.72 1100

5611-22 1/4" 304 1150 0.75 1150

5611-23 1/4" 304 1200 0.78 1200

5611-24 1/4" 304 1250 0.82 1250

5611-25 1/4" 304 1300 0.85 1300

5611-26 1/4" 304 1350 0.88 1350

5611-27 1/4" 304 1400 0.92 1400

5611-28 1/4" 304 1450 0.95 1450

5611-29 1/4" 304 1500 0.98 1500

5611-30 1/4" 304 1550 1.02 1550

5611-31 1/4" 304 1600 1.05 1600

5611-32 1/4" 304 1650 1.08 1650

5611-33 1/4" 304 1700 1.12 1700

5611-34 1/4" 304 1750 1.15 1750

5611-35 1/4" 304 1800 1.18 1800

5611-36 1/4" 304 1850 1.22 1850

5611-37 1/4" 304 1900 1.25 1900

5611-38 1/4" 304 1950 1.28 1950

5611-39 1/4" 304 2000 1.32 2000

5611-40 1/4" 304 2050 1.35 2050

5611-41 1/4" 304 2100 1.38 2100

5611-42 1/4" 304 2150 1.42 2150

5611-43 1/4" 304 2200 1.45 2200

5611-44 1/4" 304 2250 1.48 2250

5611-45 1/4" 304 2300 1.52 2300

5611-46 1/4" 304 2350 1.55 2350

5611-47 1/4" 304 2400 1.58 2400

5611-48 1/4" 304 2450 1.62 2450

5611-49 1/4" 304 2500 1.65 2500

5611-50 1/4" 304 2550 1.68 2550

5611-51 1/4" 304 2600 1.72 2600

5611-52 1/4" 304 2650 1.75 2650

5611-53 1/4" 304 2700 1.78 2700

5611-54 1/4" 304 2750 1.82 2750

5611-55 1/4" 304 2800 1.85 2800

5611-56 1/4" 304 2850 1.88 2850

5611-57 1/4" 304 2900 1.92 2900

5611-58 1/4" 304 2950 1.95 2950

5611-59 1/4" 304 3000 1.98 3000

5611-60 1/4" 304 3050 2.02 3050

5611-61 1/4" 304 3100 2.05 3100

5611-62 1/4" 304 3150 2.08 3150

5611-63 1/4" 304 3200 2.12 3200

5611-64 1/4" 304 3250 2.15 3250

5611-65 1/4" 304 3300 2.18 3300

5611-66 1/4" 304 3350 2.22 3350

5611-67 1/4" 304 3400 2.25 3400

5611-68 1/4" 304 3450 2.28 3450

5611-69 1/4" 304 3500 2.32 3500

5611-70 1/4" 304 3550 2.35 3550

5611-71 1/4" 304 3600 2.38 3600

5611-72 1/4" 304 3650 2.42 3650

5611-73 1/4" 304 3700 2.45 3700

5611-74 1/4" 304 3750 2.48 3750

5611-75 1/4" 304 3800 2.52 3800

5611-76 1/4" 304 3850 2.55 3850

5611-77 1/4" 304 3900 2.58 3900

5611-78 1/4" 304 3950 2.62 3950

5611-79 1/4" 304 4000 2.65 4000

5611-80 1/4" 304 4050 2.68 4050

5611-81 1/4" 304 4100 2.72 4100

5611-82 1/4" 304 4150 2.75 4150

5611-83 1/4" 304 4200 2.78 4200

5611-84 1/4" 304 4250 2.82 4250

5611-85 1/4" 304 4300 2.85 4300

- Easy handling
- For h6 shanks
- **For operations involving high MRR**
- High retention force
- High torque transmission
- Highest stability
- Accurate
- Flexible

ER COLLET CHUCK

Tooling systems

ER Collet chuck are not the first choice to recommend for holding indexable milling cutters. However if a customer wants to, we should recommend to use at least high precision collets (ER-C-P or ER-C-SC4)!

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A		DIN 228-1				
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100	MT2	MT3	MT4	MT5	MT6
ER Collet Chuck	1 – 10 (ER16)	●	●	●		●	●	●			●		●				
	2 – 16 (ER25)	●	●	●		●	●	●	●		●	●	●	●	●		
	2 – 20 (ER32)	●	●	●		●	●	●	●	●	●	●		●	●		
	3 – 26 (ER40)	●	●	●		●	●	●	●	●	●	●				●	

CC-ER



Form AD/B
 $\nabla \leq 0,003$
 G6,3
 15.000 min⁻¹



- Medium torque transmission
- Low to medium run-out accuracy
- Assembly requires some instruction (read instructions) 
- Moderate repeatability
- Dampen vibration
- Not suited for high speeds
- Flexible (broader range of collets than OZ system)
- Clean carefully
- Rotate the tool to achieve best run-out



SC 热胀刀柄 HOLDERS

Tooling systems

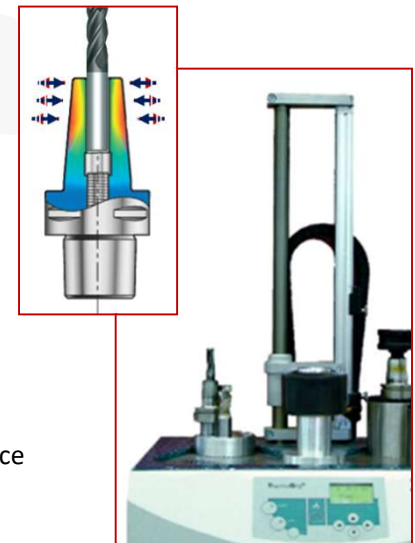
描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	3 - 20	•	•	•		•	•	•			•	•
	25 - 32		•	•			•	•			•	•

SC



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹

- Requires a shrink-fit device
- For h6 shanks
- For finishing
- High torque transmission
- High levels of accuracy
- Extremely rigid



5629 介绍

系列	规格	最大直径 (mm)	最大长度 (mm)	最大重量 (kg)	最大转速 (min ⁻¹)	最大扭矩 (Nm)	最大功率 (kW)	最大切削力 (kN)	最大切削速度 (m/min)	最大进给速度 (mm/min)	最大背吃刀量 (mm)	最大切削深度 (mm)	最大切削宽度 (mm)	最大切削长度 (mm)	最大切削直径 (mm)	最大切削长度 (mm)	最大切削直径 (mm)	最大切削长度 (mm)
HSK63	HSK63-1	63	100	1.5	10000	150	15	15	150	1500	15	15	15	150	150	150	150	150
HSK100	HSK100-1	100	150	2.5	10000	250	25	25	250	2500	25	25	25	250	250	250	250	250

• 适用于高速加工
 • 适用于高精度加工
 • 适用于高扭矩加工
 • 适用于高功率加工

HC 液压刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
液压刀柄	6 – 20	•	•	•		•	•	•			•	•
	25 – 32		•	•			•	•			•	•
	40			•								

HC



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹

HC-C



HC-C-S

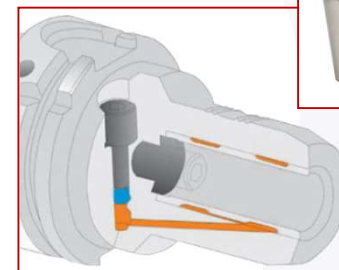
Sealed for tough coolant



Torque

Clamping- $\varnothing$ mm	Moment (Nm)
6	10
8	20
10	40
12	50
14	80
16	100
18	150
20	200
25	250
32	400
40	550

- Easy handling
- For h6 shanks
- **For finishing and super finishing**
- Medium-high torque transmission
- High run-out accuracy
- Dampen vibrations in low speed range



HKS 强力刀柄

Tooling systems

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
High-performance Chuck	3 – 20		•	•			•	•			•	•
	25 – 32		•	•			•	•			•	•

HKS



Form AD/B
 $\nabla \leq 0,003$
 G6.3
 15.000 min⁻¹



HKS-C

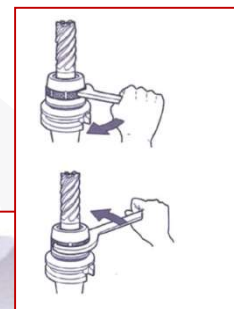
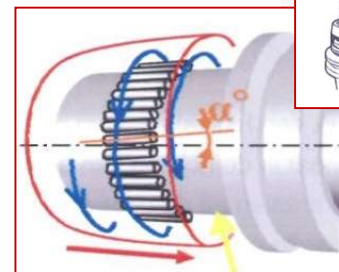


HKS-C-S

Sealed for through coolant

Size	20mm	25mm
Clamping torque	50-70 Nm	80-100 Nm
Clamping force	780 Nm	2000 Nm

- Easy handling
- For h6 shanks
- **For operations involving high MRR**
- High retention force
- High torque transmission
- Highest stability
- Accurate
- Flexible



5629

介绍

规格	10	16	20	25	32	40	50	63	80	100	125	160	200	250	315	400	500	630	800	1000	1250	1600	2000	2500	3150	4000	5000	6300	8000	10000	12500	16000	20000	25000	31500	40000	50000	63000	80000	100000	125000	160000	200000	250000	315000	400000	500000	630000	800000	1000000	1250000	1600000	2000000	2500000	3150000	4000000	5000000	6300000	8000000	10000000	12500000	16000000	20000000	25000000	31500000	40000000	50000000	63000000	80000000	100000000	125000000	160000000	200000000	250000000	315000000	400000000	500000000	630000000	800000000	1000000000	1250000000	1600000000	2000000000	2500000000	3150000000	4000000000	5000000000	6300000000	8000000000	10000000000	12500000000	16000000000	20000000000	25000000000	31500000000	40000000000	50000000000	63000000000	80000000000	100000000000	125000000000	160000000000	200000000000	250000000000	315000000000	400000000000	500000000000	630000000000	800000000000	1000000000000	1250000000000	1600000000000	2000000000000	2500000000000	3150000000000	4000000000000	5000000000000	6300000000000	8000000000000	10000000000000	12500000000000	16000000000000	20000000000000	25000000000000	31500000000000	40000000000000	50000000000000	63000000000000	80000000000000	100000000000000	125000000000000	160000000000000	200000000000000	250000000000000	315000000000000	400000000000000	500000000000000	630000000000000	800000000000000	1000000000000000	1250000000000000	1600000000000000	2000000000000000	2500000000000000	3150000000000000	4000000000000000	5000000000000000	6300000000000000	8000000000000000	10000000000000000	12500000000000000	16000000000000000	20000000000000000	25000000000000000	31500000000000000	40000000000000000	50000000000000000	63000000000000000	80000000000000000	100000000000000000	125000000000000000	160000000000000000	200000000000000000	250000000000000000	315000000000000000	400000000000000000	500000000000000000	630000000000000000	800000000000000000	1000000000000000000	1250000000000000000	1600000000000000000	2000000000000000000	2500000000000000000	3150000000000000000	4000000000000000000	5000000000000000000	6300000000000000000	8000000000000000000	10000000000000000000	12500000000000000000	16000000000000000000	20000000000000000000	25000000000000000000	31500000000000000000	40000000000000000000	50000000000000000000	63000000000000000000	80000000000000000000	100000000000000000000	125000000000000000000	160000000000000000000	200000000000000000000	250000000000000000000	315000000000000000000	400000000000000000000	500000000000000000000	630000000000000000000	800000000000000000000	1000000000000000000000	1250000000000000000000	1600000000000000000000	2000000000000000000000	2500000000000000000000	3150000000000000000000	4000000000000000000000	5000000000000000000000	6300000000000000000000	8000000000000000000000	10000000000000000000000	12500000000000000000000	16000000000000000000000	20000000000000000000000	25000000000000000000000	31500000000000000000000	40000000000000000000000	50000000000000000000000	63000000000000000000000	80000000000000000000000	100000000000000000000000	125000000000000000000000	160000000000000000000000	200000000000000000000000	250000000000000000000000	315000000000000000000000	400000000000000000000000	500000000000000000000000	630000000000000000000000	800000000000000000000000	1000000000000000000000000	1250000000000000000000000	1600000000000000000000000	2000000000000000000000000	2500000000000000000000000	3150000000000000000000000	4000000000000000000000000	5000000000000000000000000	6300000000000000000000000	8000000000000000000000000	10000000000000000000000000	12500000000000000000000000	16000000000000000000000000	20000000000000000000000000	25000000000000000000000000	31500000000000000000000000	40000000000000000000000000	50000000000000000000000000	63000000000000000000000000	80000000000000000000000000	100000000000000000000000000	125000000000000000000000000	160000000000000000000000000	200000000000000000000000000	250000000000000000000000000	315000000000000000000000000	400000000000000000000000000	500000000000000000000000000	630000000000000000000000000	800000000000000000000000000	1000000000000000000000000000	1250000000000000000000000000	1600000000000000000000000000	2000000000000000000000000000	2500000000000000000000000000	3150000000000000000000000000	4000000000000000000000000000	5000000000000000000000000000	6300000000000000000000000000	8000000000000000000000000000	10000000000000000000000000000	12500000000000000000000000000	16000000000000000000000000000	20000000000000000000000000000	25000000000000000000000000000	31500000000000000000000000000	40000000000000000000000000000	50000000000000000000000000000	63000000000000000000000000000	80000000000000000000000000000	100000000000000000000000000000	125000000000000000000000000000	160000000000000000000000000000	200000000000000000000000000000	250000000000000000000000000000	315000000000000000000000000000	400000000000000000000000000000	500000000000000000000000000000	630000000000000000000000000000	800000000000000000000000000000	1000000000000000000000000000000	1250000000000000000000000000000	160000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ER COLLET CHUCK

Tooling systems

ER Collet chuck are not the first choice to recommend for holding indexable milling cutters. However if a customer wants to, we should recommend to use at least high precision collets (ER-C-P or ER-C-SC4)!

描述	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A		DIN 228-1					
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100	MT2	MT3	MT4	MT5	MT6	
ER Collet Chuck	1 – 10 (ER16)	●	●	●		●	●	●			●		●					
	2 – 16 (ER25)	●	●	●		●	●	●	●		●	●	●	●	●			
	2 – 20 (ER32)	●	●	●		●	●	●	●	●	●	●		●	●			
	3 – 26 (ER40)	●	●	●		●	●	●	●	●	●	●				●		

CC-ER



- Medium torque transmission
- Low to medium run-out accuracy
- Assembly requires some instruction (read instructions) 
- Moderate repeatability
- Dampen vibration
- Not suited for high speeds
- Flexible (broader range of collets than OZ system)
- Clean carefully
- Rotate the tool to achieve best run-out

