DORMER PRAMET

S791 锥鼓硬质合金铣刀

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

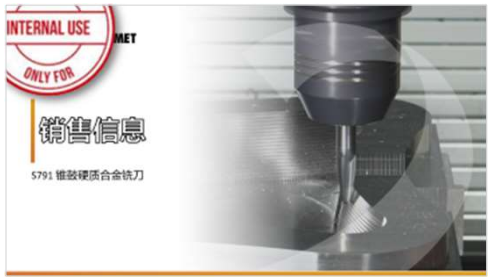
PROTECTIVE EQUIPMENT

EMERGENCY NUMBER

PSYCHOLOGICAL SAFETY

产品预览

S791 锥鼓硬质合金铣刀



DORMER PRAMET

产品介绍

S791 锥鼓硬质合金铣刀

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介绍

为什么要引入锥鼓铣刀

- 需要可以实现更大相切铣削的立铣刀
- 需要更高效和更高精度的铣刀实现大型部件的快速铣削

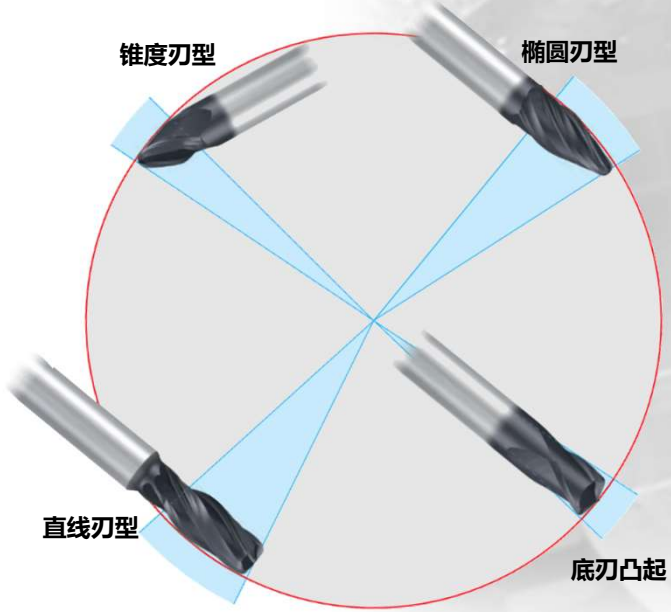
产品有点

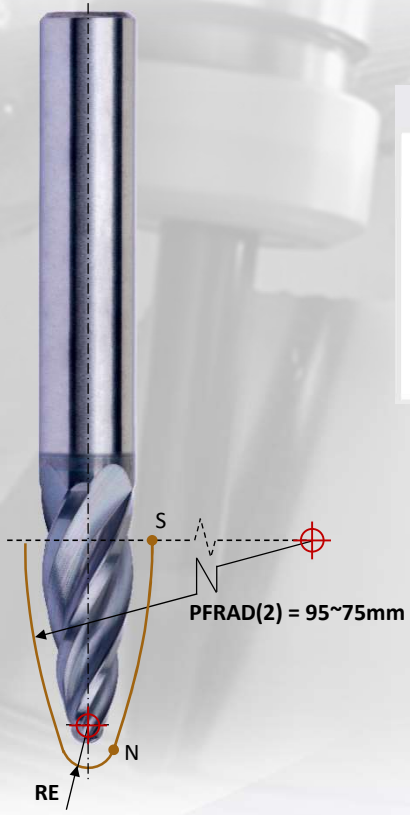
- **通用性** – 与工件的基础面积更大
- **有效性** – 更少的步距以及更快的高质量精加工可节约大幅时间
- **竞争性** – 更好的表面质量，更少的抛光时间
- **高效率** – 3和4齿设计可实现高效加工

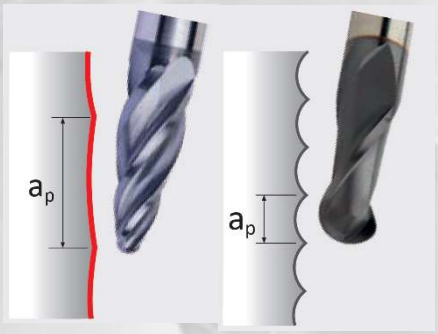
在5轴机床上使用CAD/CAM程序

S791 锥鼓硬质合金铣刀

介绍







产品预览

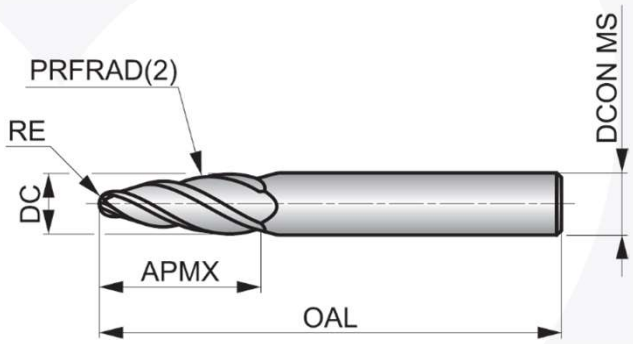
介绍

型号	DC Range	NOF	APMX	螺旋角 λ	前角 γ	缩颈	RE	PFRAD(2)	涂层	柄部标准	P	M	K	S	N	H
立铣刀																
S791	6.0 – 16.0	3 - 4	3.6 ~ 2xDC	30°	8°	No	1.00 – 3.00	95.0 – 75.0	AlCrN	DIN 6535 HA	■	■	■	◪	■	

S791

介绍

订货号	DC [mm]	RE [mm]	PRFRAD(2) [mm]	DCON MS [mm]	APMX [mm]	OAL [mm]	NOF
S7916.0	6.00	1.00	95.0	6.00	22.00	67.0	3
S7918.0	8.00	1.00	90.0	8.00	25.00	75.0	3
S79110.0	10.00	2.00	85.0	10.00	26.00	75.0	4
S79112.0	12.00	2.00	80.0	12.00	28.00	83.0	4
S79116.0	16.00	3.00	75.0	16.00	31.00	90.0	4



SC
热涨刀柄

HC
液压刀柄

参数	描述
DC	切削直径
RE	刀尖圆角
PRFRAD(2)	刃型圆弧
DCON MS	柄部直径
APMX	最大切深
OAL	全长
NOF	齿数

应用市场

介绍

仅适用于可实现 CAD/CAM 编程的工况!

行业	工件	应用	工件材料	竞争对手
模具	模具部件	提升表面精度	钢件	FRAISA
航空航天	航空部件	减少加工时间	不锈钢	YG1
汽轮机/水轮机	叶片	轻载加工	铸铁	MTSUBISHI
			有色金属	OSG
			耐热合金	HOFFMANN
				EMUGE FRANKEN

DORMER PRAMET

特点&优势

S791 锥鼓硬质合金铣刀

钢件 (P-材料组)

ISO group		WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Examples of material (AISI, EN, DIN, SS, STN, BS, UNE, GB, AFNOR, GOST, UNI)
P	P1	P1.1	**Free machining steel** *(carbon steels with increased machinability)*	sulfurized	< 240 HB	≤ 830	AISI **1108,** EN **15S22,** DIN **1.0723,** SS **1922,** ČSN **11120,** BS **210A15,** UNE **F.210F,** GB **Y15,** AFNOR **10F1,** GOST **A30,** UNI **CF10S20**
		P1.2		sulfurized and phosphorized	< 180 HB	≤ 620	AISI **1211,** EN **11SMn30,** DIN **1.0715,** SS **1912,** ČSN **11109,** BS **230M7,** UNE **F.2111,** GB **Y15,** AFNOR **S250,** GOST **A40G,** UNI **CF9SMn28**
		P1.3		sulfurized/phosphorized and leaded	< 180 HB	≤ 620	AISI **12L13,** EN **11SMnPb30,** DIN **1.0718,** SS **1914,** ČSN **12110,** BS **210M16,** UNE **F.2114,** GB **Y15Pb,** AFNOR **S250Pb,** GOST **AS35G2,** UNI **CF10SPb20**
	P2	P2.1	**Plain carbon steel** *(steels comprised of mainly iron and carbon)*	containing <0.25%C	< 180 HB	≤ 620	AISI **1015,** EN **C15,** DIN **1.0401,** SS **1350,** ČSN **11301 ,** BS **080A15,** UNE **F.111,** GB **15,** AFNOR **C18RR,** GOST **St2ps,** UNI **Fe360**
		P2.2		containing <0.55%C	< 240 HB	≤ 830	AISI **1030,** EN **C30,** DIN **1.0528,** SS **1550,** ČSN **12031,** BS **080M32,** UNE **F.1130,** GB **30,** AFNOR **AF50C30,** GOST **30G,** UNI **Fe590**
		P2.3		containing >0.55%C	< 300 HB	≤ 1030	AISI **1060,** EN **C60,** DIN **1.0601,** SS **1655,** ČSN **12061,** BS **080A62,** UNE **F513,** GB **60,** AFNOR **1C60,** GOST **60G,** UNI **C60**
	P3	P3.1	**Alloy steel** *(carbon steels with an alloying content ≤ 10%)*	annealed	< 180 HB	≤ 620	AISI **3415, 4140, 4340, 6150, 8620,** EN **15NiCr13, 42CrMo4, 41NiCrMo7-3-2,** DIN **1.5732, 1.7223, 1.6563, 1.8159, 1.6523,** SS **2244, 2541, 2230, 2506,** ČSN **15020,** BS **1501-240,** UNE **F.2601,** GB **16Mo,** AFNOR **15D3,** GOST **15M,** UNI **16Mo3KW**
		P3.2		hardened and tempered	180 - 260 HB	> 620 ≤ 900	
		P3.3			260 - 360 HB	> 900 ≤ 1240	
	P4	P4.1	**Tool steel** *(special alloy steel for tools, dies and molds)*	annealed	< 26 HRC	≤ 900	AISI **D2,** EN **X155CrVMo12-1,** DIN **1.2370,** SS **2736,** ČSN **19573,** BS **BD2,** UNE **F.520A,** GB **Cr12Mo1V1,** AFNOR **Z160CDV12,** GOST **Ch12MF,** UNI **X155CrVMo121KU**
		P4.2		hardened and tempered	26 - 39 HRC	> 900 ≤ 1240	
		P4.3			39 - 45 HRC	> 1240 ≤ 1450	

不锈钢(M-材料组)

ISO group		WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Examples of material (AISI, EN, DIN, SS, STN, B.S, UNE, CN, AFNOR, GOST, UNI)
M	M1	■ M1.1	**Ferritic stainless steel** *(straight chromium non-hardenable alloys)*		< 160 HB	≤ 520	AISI S429, EN X7Cr14, DIN 1.4001, SS 2326, BS 434S17, UNE F.3401, AFNOR Z8C12, GOST 08Ch13, UNI X6CrTi12
		■ M1.2			160 - 220 HB	> 520 ≤ 700	AISI 446, EN X10CrAl24, DIN 1.4762, SS 2322, ČSN 17113, BS 430S17, UNE F.3154, GB 10Cr17, AFNOR Z10CAS24, GOST 12Ch17, UNI X16Cr26
	M2	■ M2.1	**Martensitic stainless steel** *(straight chromium hardenable alloys)*	annealed	< 200 HB	≤ 670	AISI 430F, EN X14CrMoS17, DIN 1.4104, SS 2383, ČSN 17140, BS 410S21, UNE F.3117, AFNOR Z10CF17, UNI X10CrS17
		■ M2.2		quenched and tempered	200 - 280 HB	> 670 ≤ 950	AISI 440C, EN X105CrMo17, DIN 1.4125, SS 2385, ČSN 17023, BS 425C11, UNE F.3402; GB 102Cr17Mo, AFNOR Z100CD17, GOST 95Ch18, UNI GX6CrNi 13 04
		M2.3		precipitation-hardened	280 - 380 HB	> 950 ≤ 1300	AISI 420, EN X45Cr13, DIN 1.4034, ČSN 17029, BS 425C11, UNE F.3405, AFNOR Z44C14, GOST 20X17H12, UNI X30Cr13
	M3	◩ M3.1	**Austenitic stainless steel** *(chromium-nickel and chromium-nickel-manganese alloys)*		< 200 HB	≤ 750	AISI 304, 309, 5848 EN X5CrNi18-12, X15CrNiSi20-12, X45CrNiW18-9, DIN 1.4303, 1.4828, 1.4873, SS 2352, ČSN 17249, BS 305S17, UNE F.3513, GB 10Cr18Ni12, AFNOR Z8CN18.12, UNI X7CrNi18 10
		◩ M3.2			200 - 260 HB	> 750 ≤ 870	
		◩ M3.3			260 - 300 HB	> 870 ≤ 1040	
	M4	◩ M4.1	**Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel** *(alloys with austenitic-ferritic microstructure, austenitic alloys with > 20%Ni)*		< 300 HB	≤ 990	AISI 329, EN X1-NiCrMoCU25-20-5, DIN 1.4539, SS 2562, ČSN 17265, BS 318S13, UNE F.3552, GB 022Cr25NiMo2N, AFNOR Z1NCDU25.20
		M4.2	Precipitation hardening austenitic stainless steel		300 - 380 HB	≤ 1320	AISI 631 (17-7PH), EN X7CrNiAL17-7, DIN 1.4568, SS 2388, ČSN 17465, BS 301S13, UNE F.3217, GB 07Cr17Ni7Al, AFNOR 29CNA17-07

铸铁(K-材料组)

ISO group		WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Examples of material (ASTM, EN, DIN, SS, STN, B.S, UNE, CN, AFNOR, GOST, UNI)
K	K1	K1.1	**Gray iron or Automotive Gray iron** *(iron-carbon castings with a lamellar graphite microstructure)*	ferritic or ferritic-pearlitic	< 180 HB	≤ 190	ASTM **A48 Grade 20,** EN**-JL-100,** DIN **GG-10 (0.6010),** STN **422410**
		K1.2		ferritic-pearlictic or pearlitic	180 - 240 HB	> 190 ≤ 310	ASTM **A48 Grade 30,** EN**-JL-1030,** DIN **GG-20 (0.6020),** SS **0120,** STN **422420**
		K1.3		pearlitic	240 - 280 HB	> 310 ≤ 390	ASTM **A48 Grade 50,** EN**-JL-1060,** DIN **GG-35 (0.6035),** SS **0135,** STN **422435**
	K2	K2.1	**Malleable iron** *(iron-carbon castings with a graphite-free microstructure)*	ferritic	< 160 HB	≤ 400	ASTM **A602 Grade M3210,** EN**-JM-1130,** DIN **GTS-35 (0.8135),** SS **0815**
		K2.2		ferritic or pearlitic	160 - 200 HB	> 400 ≤ 550	ASTM **A602 Grade M4504 (F20001),** EN**-JM-1040,** DIN **GTS-50-05 (0.8045**
		K2.3		pearlitic	200 - 240 HB	> 550 ≤ 660	ASTM **A602 Grade M7002,** EN**-JM-1140,** DIN **GTS-45 (0.8145),** STN **422540**
	K3	K3.1	**Ductile iron** *(iron-carbon castings with a nodular graphite microstructure)*	ferritic	< 180 HB	≤ 560	ASTM **A536 Grade 60-40-18,** EN**-JS-1030,** DIN **GGG-40 (0.7040),** STN **422304**
		K3.2		ferritic or pearlitic	180 - 220 HB	> 560 ≤ 680	ASTM **A536 Grade 80-55-06,** EN**-JS-1050,** DIN **GGG-50 (0.7050),** STN **422305**
		K3.3		pearlitic	220 - 260 HB	> 680 ≤ 800	ASTM **A536 Grade 100-70-03,** EN**-JS-1060,** DIN **GGG-60 (0.7060),** STN **422306**
	K4	K4.1	**Austenitic gray iron** *(iron-carbon alloy castings with an austenitic lamellar graphite microstructure)*		< 180 HB	≤ 190	ASTM **A436 Type 1 (L-NiCuCr 15 6 2),** DIN **GGL-NiMn 13 7 (0.6652)**
		K4.2	**Austenitic ductile iron** *(iron-carbon alloy castings with an austenitic nodular graphite microstructure)*		< 240 HB	≤ 740	ASTM **A439 Type D-2B (S-NiCr 20 3),** DIN **GGG-NiMn 23 4,** GOST **ЧН19Х3Ш**
		K4.3	**Austempered ductile iron** *(iron-carbon alloy castings with an ausferrite microstructure)*		< 280 HB	> 840 ≤ 980	ASTM **A897 Grade 110-70-11**
		K4.4			280 - 320 HB	> 980 ≤ 1130	ASTM **A897 Grade 125-80-10,** EN**-JS-1100,** DIN **GGG-90 (5.3400)**
		K4.5			320 - 360 HB	> 1130 ≤ 1280	ASTM **A897 Grade 2 (150-110-07),** EN**-JS-1110,** DIN **GGG-100 (5.3403)**
	K5	K5.1	**Compacted graphite iron** *(iron-carbon castings with a vermicular graphite structure)*	ferritic	< 180 HB	≤ 400	ASTM **A842 Grade 300,** EN**-GJV-300,** DIN **GGV 30,** GOST **ЧВГ30,**
		K5.2		ferritic-pearlitic	180 - 220 HB	> 400 ≤ 450	ASTM **A842 Grade 350,** EN**-GJV-350,** DIN **GGV 35 (5.2200),** GOST **ЧВГ30,**
		K5.3		pearlitic	220 - 260 HB	> 450 ≤ 500	ASTM **A842 Grade 450,** EN**-GJV-450,** DIN **GGV 45,** GOST **ЧВГ45,**

有色金属(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 АМц, 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 Amg 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

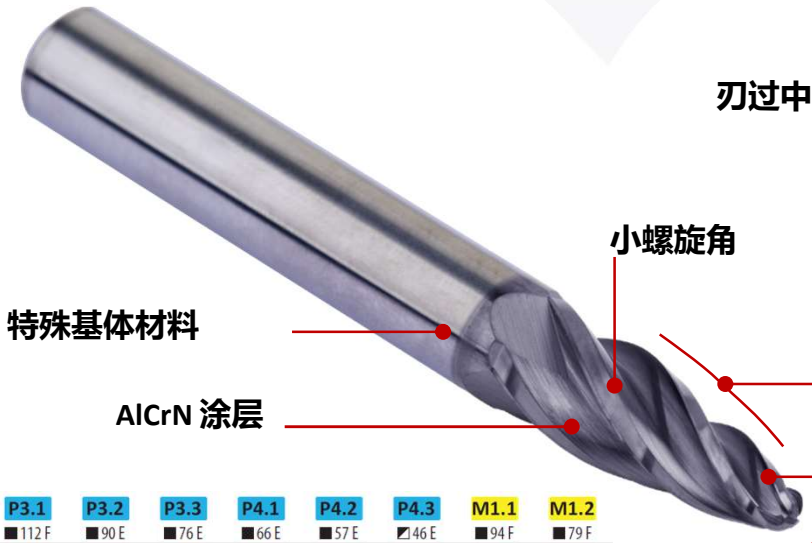
耐热合金(S-材料组)

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)
S	S1	◩ S1.1	Titanium or titanium alloys	< 200 HB	≤ 660	UNS R50250 (Grade 1), EN Ti 99.6, DIN 3.7035, BS TA.2, UNE Ti-Po2, AFNOR T-40, GOST BT1-00
		◩ S1.2		200 - 280 HB	> 660 ≤ 950	UNS R56404 (Grade 29), EN Ti2Cu, DIN 3.7124, BS TA.21, UNE Ti-P11, AFNOR T-U2
		S1.3		280 - 360 HB	> 950 ≤ 1200	UNS R54250 (Grade 38), EN TiAl6V4, DIN 3.7165, ČSN TiAl6VELI, BS TA. 13, UNE Ti-P63, AFNOR T-A6V, GOST BT6
	S2	◩ S2.1	Fe-based high-temperature alloys	< 200 HB	≤ 690	UNS N08801 (Incoloy 801), EN X8 NiCrAlTi31-21, DIN 1.4959, BS NA 15, AFNOR Z8NC33-21
		S2.2		200 - 280 HB	> 690 ≤ 970	UNS N19907, EN X6NiCrTiMoVB25-15-2, DIN 1.4980, SS 2570, BS HR52, AFNOR Z6NCTDV25.15B, GOST 36HXTЮ
	S3	◩ S3.1	Ni-based high-temperature alloys	< 280 HB	≤ 940	UNS A09706 (Inconel 706), EN NiCr25FeAl, DIN 2.4856, ČSN Inconel 625, BS HR 6, UNE F.3313, GB 1Cr16Ni35, AFNOR NC22FeDNB, GOST XH38BT
		S3.2		280 - 360 HB	> 940 ≤ 1200	UNS N07001, EN NiCr20Co13Mo4Ti3Al, DIN 2.4654, BS HR 2, ČSN Waspaloy, AFNOR NCKD 20ATV, GOST XH80TБЮ
	S4	◩ S4.1	Co-based high-temperature alloys	< 240 HB	≤ 800	UNS R30016 (Stellite 6b), EN CoCr20W15Ni, DIN 2.4964, AFNOR KC 20 WN, GOST ЛК52
		S4.2		240 - 320 HB	> 800 ≤ 1070	UNS R30016 (Stellite 6b), EN CoCr20W15Ni, DIN 2.4964, AFNOR KC 20 WN, GOST ЛК52

S791

产品特点

HM	N	NOF 3-4
	λ 30°	γ 8°
DIN 6535HA	AlCrN	
DORMER		



刃过中心

小螺旋角

特殊基体材料

大相切角度

AlCrN 涂层

正前角槽型

球头设计

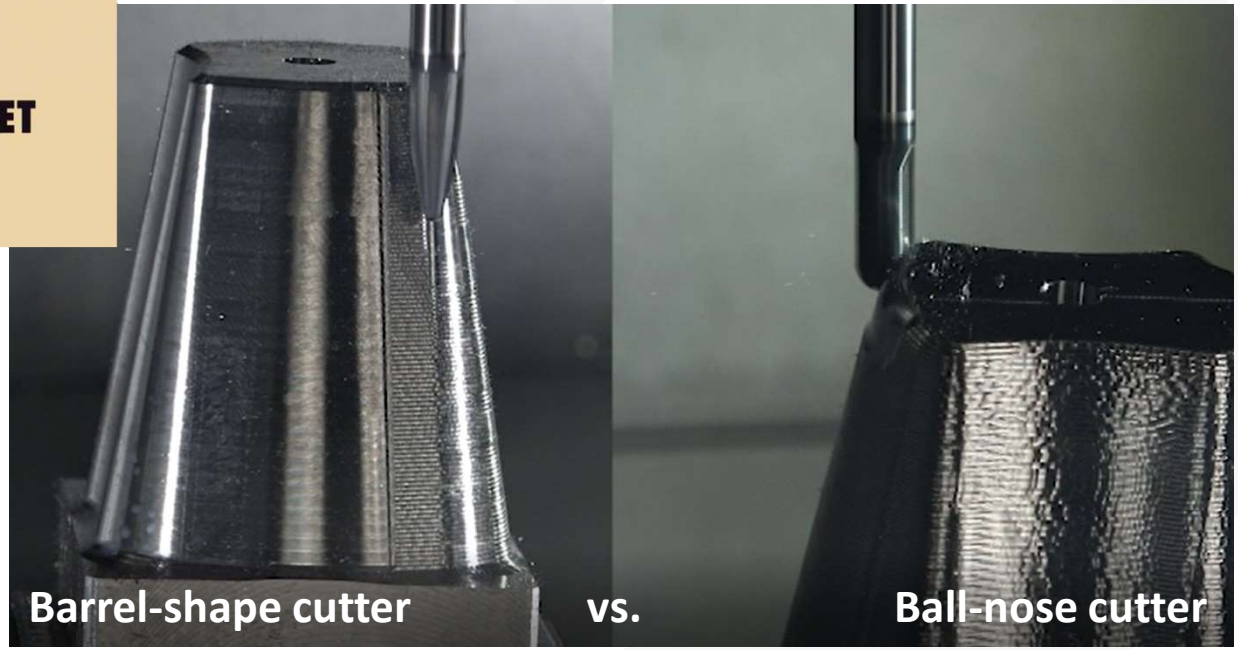
P1.1 ■161 F	P1.2 ■181 F	P1.3 ■186 F	P2.1 ■138 F	P2.2 ■121 F	P2.3 ■108 E	P3.1 ■112 F	P3.2 ■90 E	P3.3 ■76 E	P4.1 ■66 E	P4.2 ■57 E	P4.3 ◪46 E	M1.1 ■94 F	M1.2 ■79 F
M2.1 ■83 F	M2.2 ■69 E	M3.1 ◪77 E	M3.2 ◪66 E	M3.3 ◪59 E	M4.1 ◪58 E	K1.1 ■161 F	K1.2 ■119 F	K1.3 ■89 F	K2.1 ■165 F	K2.2 ■134 F	K2.3 ■107 E	K3.1 ■146 F	K3.2 ■112 F
K3.3 ■90 E	K4.1 ■136 E	K4.2 ■102 E	K4.3 ■75 E	K4.4 ■64 E	K4.5 ■54 E	K5.1 ■154 E	K5.2 ■115 E	K5.3 ■89 E	N1.1 ◪355 I	N1.2 ◪267 I	N1.3 ◪179 I	N2.1 ◪179 F	N2.2 ◪160 F
N2.3 ◪115 F	N3.1 ■187 F	N3.2 ■109 F	N3.3 ◪56 F	N4.1 ◪187 F	N4.2 ◪72 F	S1.1 ◪58 E	S1.2 ◪56 E	S2.1 ◪43 E	S3.1 ◪33 E	S4.1 ◪26 E			

DCON MS tolerance h6; RE ±0.01mm, PFRAD(2) ±0.01mm

S791 整硬锥鼓铣刀

DORMER PRAMET

www.dormerpramet.com



DORMER PRAMET

加工推荐

S791 锥鼓硬质合金铣刀

新图标

如何识别

基体材料

硬质合金

刀具类型

软材料槽型

HRA粗加工刃型

FS断屑槽

W –槽型 + HRA粗加工刃型

齿

齿数

齿数 + 不等齿距设计

刀具长度



切削长度

切削角度

螺旋角

前角

不等螺旋角

刀柄

标准柄

表面处理

表面光亮处理

表面抛光处理

涂层

TiSiN 涂层

冷却


内冷

刀具公差

切削直径公差

切削方向



切削方向

刀具标准

长度标准

长度标准

新图标

加工推荐

开槽工序



浅槽铣



深槽铣

键槽铣

仿形铣




仿形铣

坡走铣



坡走铣



螺旋插补铣



预钻孔螺旋插补铣

其他工序



摆线铣


车铣

方肩铣




浅方肩铣




深方肩铣

面铣


面铣

插铣



插铣


Z型铣


钻铣

切削数据

怎样识别数据?

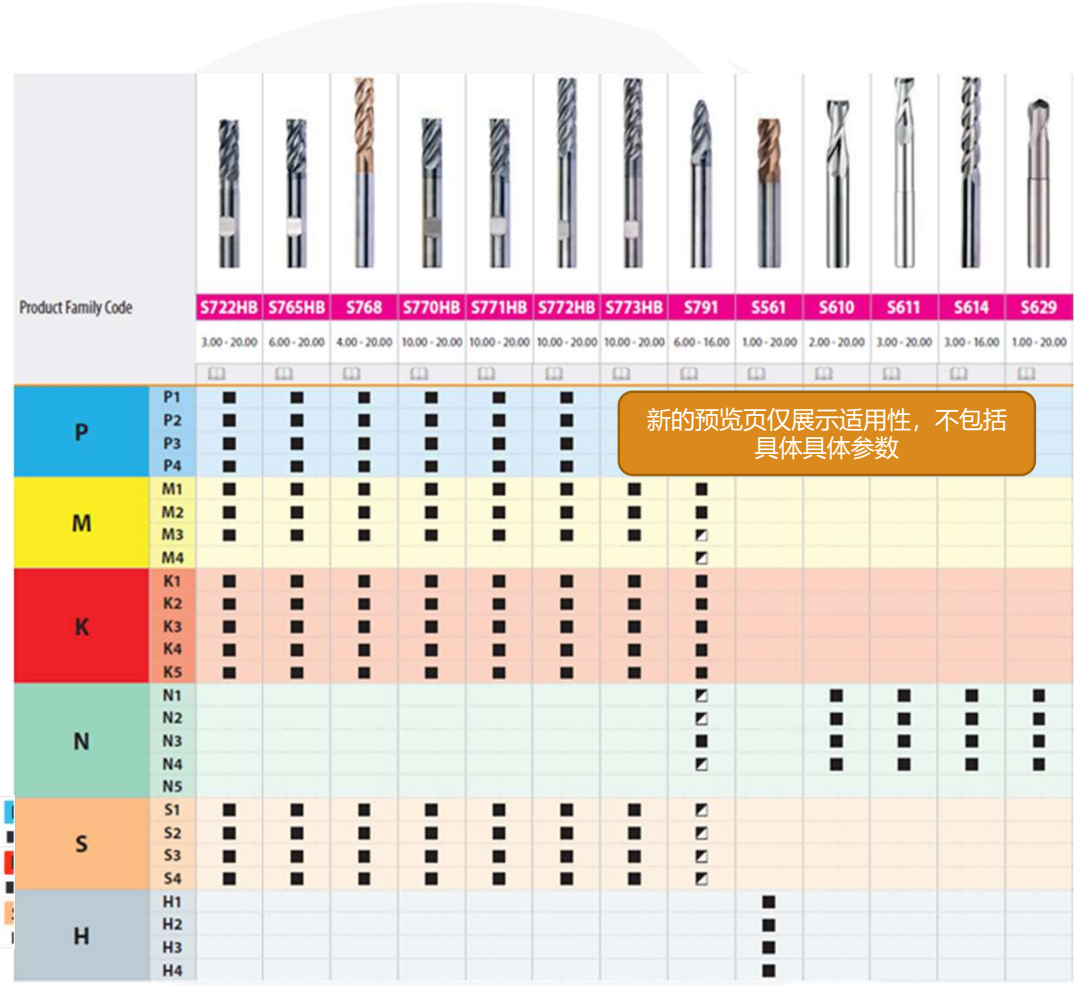
新WMG 材料组

■ 首选

◪ 次选

切削数据仅在产品页

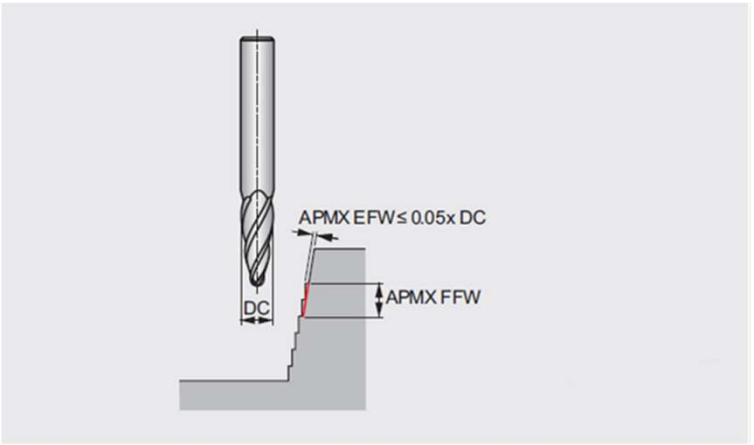
P1.1 ■ 199 J	P1.2 ■ 223 J	P1.3 ■ 230 J	P2.1 ■ 170 J	P2.2 ■ 150 J	P2.3 ■ 133 I	P3.1 ■ 138 J	
M2.2 ■ 84 I	M3.1 ■ 94 I	M3.2 ■ 81 I	K1.1 ■ 196 J	K1.2 ■ 145 J	K1.3 ■ 109 J	K2.1 ■ 202 J	
K4.3 ■ 91 I	K4.4 ■ 78 I	K4.5 ■ 65 I	K5.1 ■ 187 I	K5.2 ■ 141 I	K5.3 ■ 109 I	S1.2 ■ 69 I	



切削数据

如何计算速度和进给等参数?

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1
■161 F	■181 F	■186 F	■138 F	■121 F	■108 E	■112 F
M2.1	**M2.2**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K1.1**
■83 F	■69 E	◩77 E	◩66 E	◩59 E	◩58 E	■161 F
K3.3	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**
■90 E	■136 E	■102 E	■75 E	■64 E	■54 E	■154 E
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	**S1.1**
◩115 F	■187 F	■109 F	◩56 F	◩187 F	◩72 F	◩58 E



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

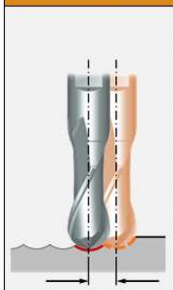
1.) Find your Alpha Code on the product page (example 121F, "F" is the Alpha Code).
2.) Find the closest diameter for your cutting application in the top row of the table.
3.) find your Alpha Code in the left column of the table.
4.) The intersection (cell) of the Diameter and Alpha Code is the feed per tooth (f_z)

仅适用于整硬铣刀

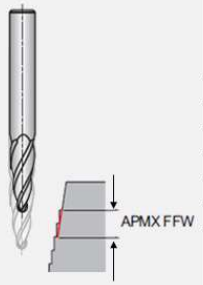
	ø DC [mm]				
	6.00	8.00	10.00	12.00	16.00
E	0.030	0.039	0.053	0.067	0.096
F	0.037	0.050	0.064	0.083	0.118
I	0.062	0.084	0.111	0.141	0.203

轴向步距(APMX FFW)

加工推荐

Ø DC	µm	2	4	8	16	32	63	125	250
2,00		0,13	0,18	0,25	0,36	0,50	0,70	0,97	1,32
3,00		0,15	0,22	0,31	0,44	0,62	0,86	1,20	1,66
4,00		0,18	0,25	0,36	0,50	0,71	1,00	1,39	1,94
5,00		0,20	0,28	0,40	0,56	0,80	1,12	1,56	2,18
6,00		0,22	0,31	0,44	0,62	0,87	1,22	1,71	2,40
8,00		0,25	0,36	0,51	0,71	1,01	1,41	1,98	2,78
10,00		0,28	0,40	0,57	0,80	1,13	1,58	2,22	3,12
12,00		0,31	0,44	0,62	0,88	1,24	1,73	2,44	3,43
14,00		0,33	0,47	0,67	0,95	1,34	1,87	2,63	3,71
16,00		0,36	0,51	0,72	1,01	1,43	2,00	2,82	3,97
18,00		0,38	0,54	0,76	1,07	1,52	2,13	2,99	4,21
20,00		0,40	0,57	0,80	1,13	1,60	2,24	3,15	4,44
22,00		0,42	0,59	0,84	1,19	1,68	2,35	3,31	4,66
25,00		0,45	0,63	0,89	1,26	1,79	2,51	3,53	4,97
28,00		0,47	0,67	0,95	1,34	1,89	2,65	3,73	5,27

APMX EFW

µm	2	4	8	16	32	63	125	250
								
	1,23	1,74	2,47	3,49	4,93	6,92	9,74	13,77
	1,20	1,70	2,40	3,39	4,80	6,73	9,48	13,41
	1,17	1,65	2,33	3,30	4,66	6,54	9,22	13,03
	1,13	1,60	2,26	3,20	4,53	6,35	8,94	12,64
	1,10	1,55	2,19	3,10	4,38	6,15	8,66	12,24

APMX FFW

$$APMX\ FFW = 2 \times \sqrt{R_{th} \times (2 \times PRFRAD(2) - R_{th})^2}$$

CAM 编程

软件推荐

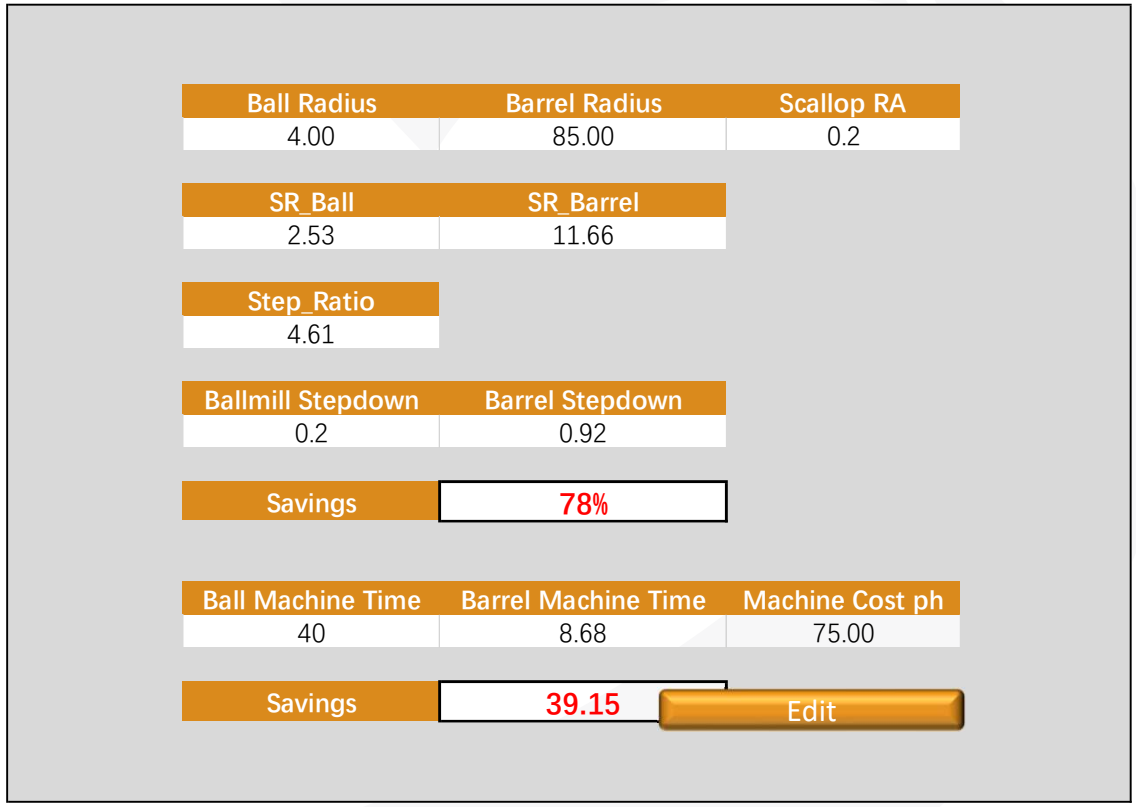
FUSION 360

hyperMILL

Mastercam

SOLIDWORKS

HEXAGON MANUFACTURING INTELLIGENCE | EDGECAM



Ball Radius	Barrel Radius	Scallop RA
4.00	85.00	0.2

SR_Ball	SR_Barrel
2.53	11.66

Step_Ratio
4.61

Ballmill Stepdown	Barrel Stepdown
0.2	0.92

Savings	78%

Ball Machine Time	Barrel Machine Time	Machine Cost ph
40	8.68	75.00

Savings	39.15

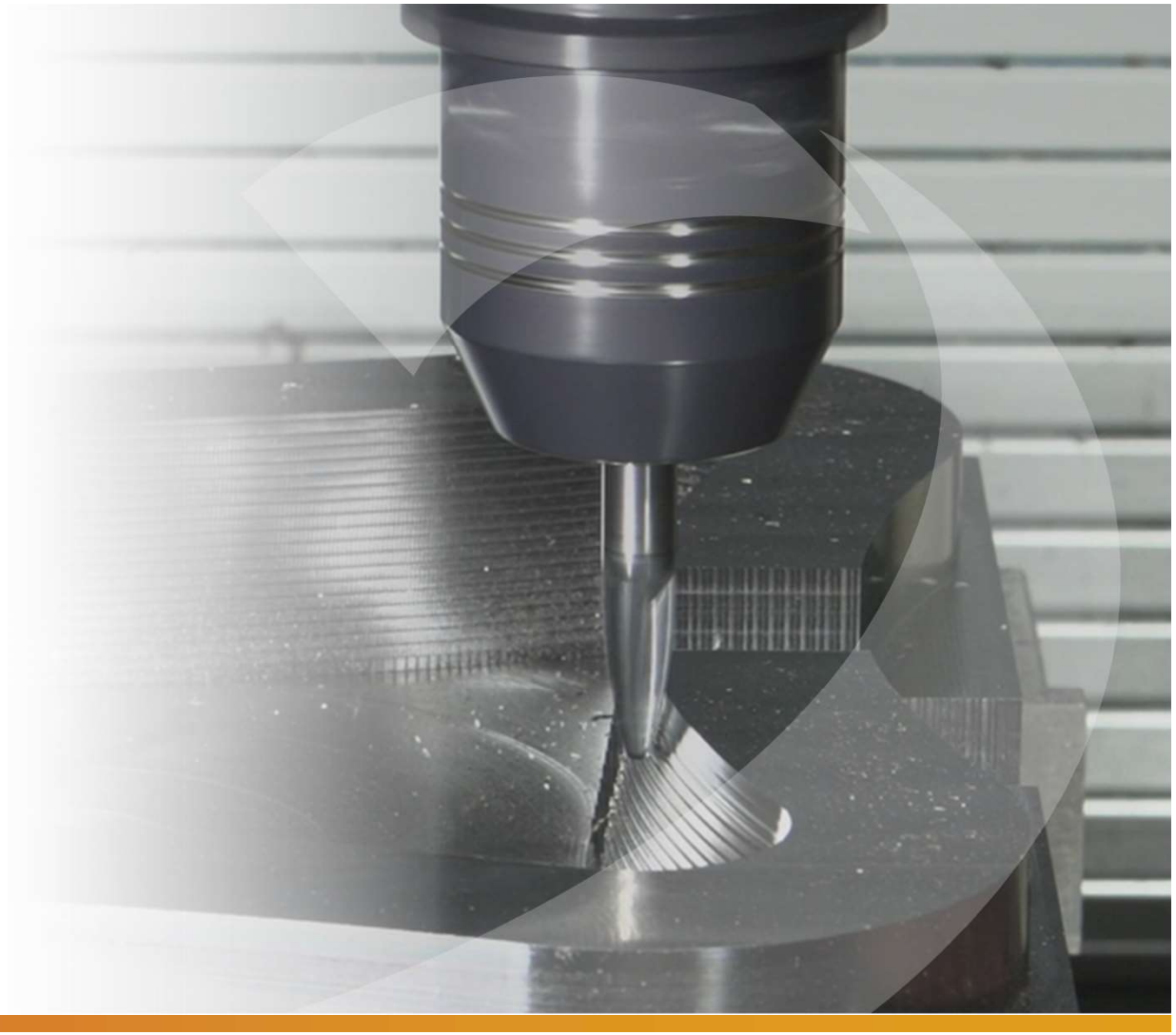
Edit

INTERNAL USE ONLY FOR

MET

销售信息

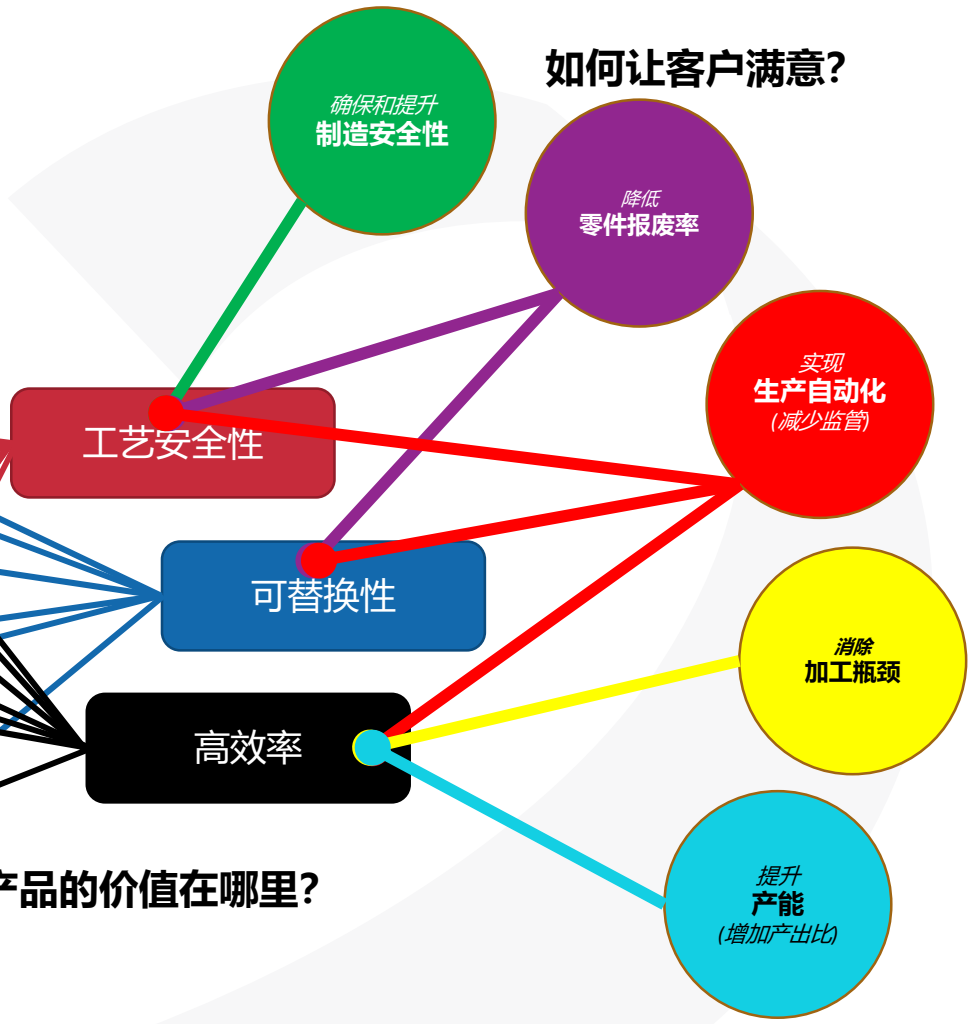
S791 锥鼓硬质合金铣刀



销售信息

产品的卖点在哪里?

产品特点	产品优势
特殊基体材料	*可实现更高线速度*
AlCrN coating	*增强耐磨性，提升刀具寿命*
	提升热冲击稳定性
	增加线速度
	降低摩擦提升加工的光顺性
更大相切刃	*更大的步距可节约加工时间*
	增加表面质量
球头设计	*1把刀具实现两种工序(侧壁和根部圆角)*
正前角槽型	*加工高强度材料时提升刃口强度*
	确保光顺切削
	降低加工硬化的风险
3- 和 4-齿	*增加加工效率*
30° 螺旋角	*平衡切削力*

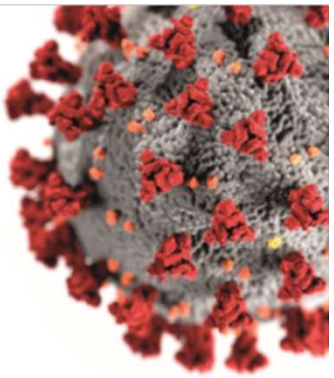


DORMER PRAMET

SIMPLY RELIABLE

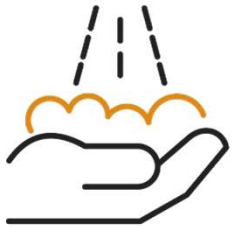
/DormerPrametSocial	Dormer Pramet	@DormerPramet	Dormer Pramet	dormerpramet.com

COVID-19 PRECAUTIONS

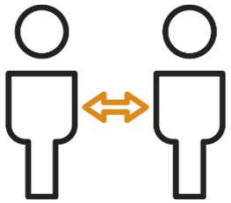


FOLLOW LOCAL GUIDELINES

STAY HOME WHEN FEELING SICK



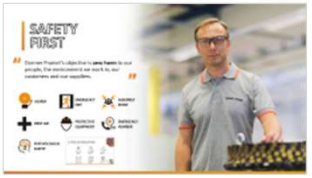
WASH YOUR HANDS CAREFULLY



OBSERVE PHYSICAL DISTANCING GUIDELINES

COUGH AND SNEEZE CORRECTLY

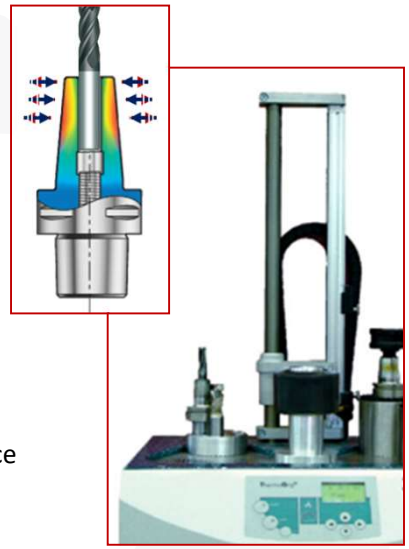
AVOID TOUCHING YOUR FACE



SC SHRINK FIT HOLDERS

Tooling systems

Description	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
Hydraulic Chuck	3 - 20	●	●	●		●	●	●			●	●
	25 – 32		●	●			●	●			●	●



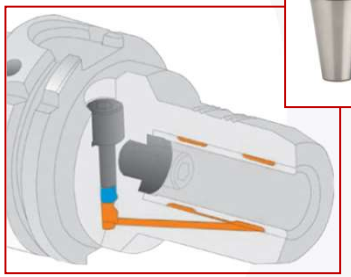
SC

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

HC HYDRAULIC CHUCK

Tooling systems

Description	Diameter range	DIN 69871				JIS B 6339			DIN 2080		DIN 69893-A	
		SK30	SK40	SK50	SK60	BT30	BT40	BT50	SK40	SK50	HSK63	HSK100
Hydraulic Chuck	6 – 20	●	●	●		●	●	●			●	●
	25 – 32		●	●			●	●			●	●
	40			●								



HC

HC-C

HC-C-S

Sealed for though coolant

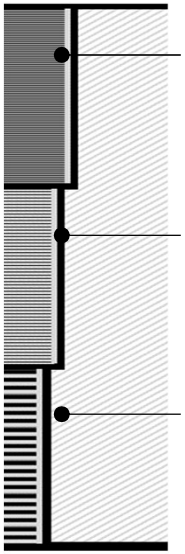
Torque

Clamping-Ø 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

SURFACE ROUGHNESS

What is surface roughness and how to meassure it?



Ra 0.8

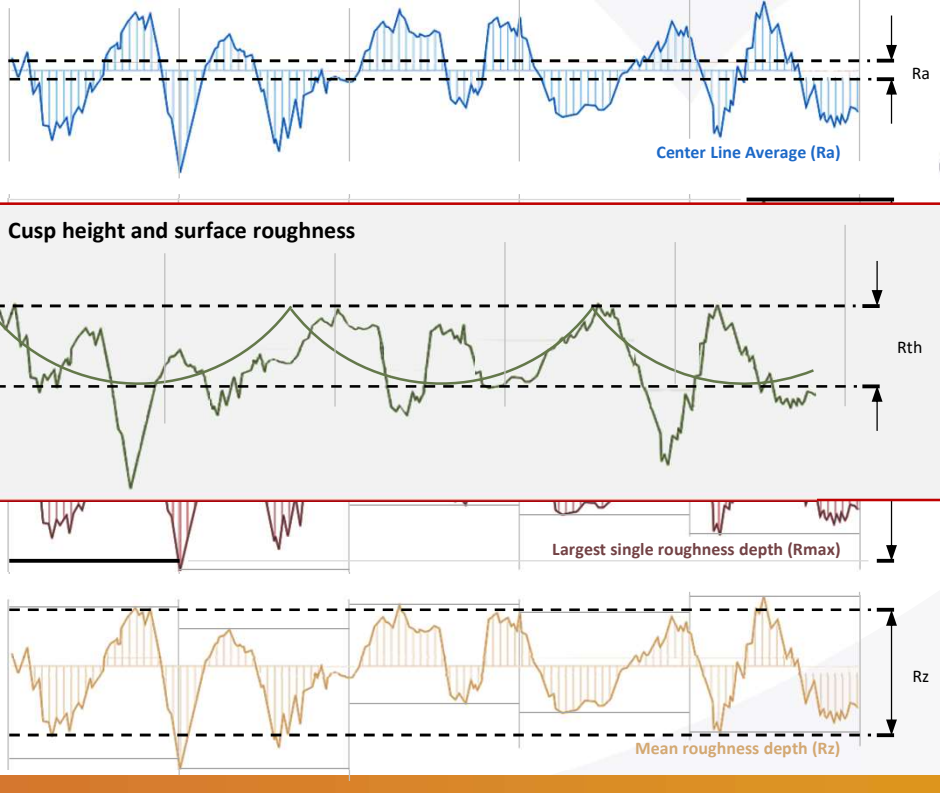
Finishing

Ra 3.2

Semi Finishing

Ra 12.5

Roughin



Ra µ m	Ra µ in	Roughness Grade Number
50	2000	N12
25	1000	N11
12.5	500	N10
6.3	250	N9
3.2	125	N8
1.6	63	N7
0.8	32	N6
0.4	16	N5
0.2	8	N4
0.1	4	N3
0.05	2	N2
0.025	1	N1

Surface may be produced by any method

Machining required to specified parameter

Machining prohibited