

HSS



Being the best through innovation



REAMERS

- 高速钢手用铰刀, HSS-E 夹持式铰刀
HSS Hand Reamers, HSS-E Chucking Reamers

SELECTION GUIDE

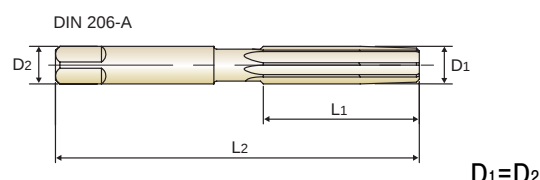
项目 ITEM	型号 MODEL	规格 DESCRIPTION	尺寸 SIZE		页 PAGE
			最小 MIN	最大 MAX	
K1143		高速钢手用铰刀-直槽 HSS HAND REAMERS - STRAIGHT FLUTES	D2.0	D60.0	1029
K1153		高速钢手用铰刀-左向螺旋槽 HSS HAND REAMERS - LH SPIRAL FLUTES	D2.0	D60.0	1031
K2101		HSS-E直柄夹持铰刀-直槽 HSS-E STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTES	D2.0	D20.0	1033
K2111		HSS-E直柄夹持铰刀-左向螺旋槽 HSS-E STRAIGHT SHANK CHUCKING REAMERS - LH SPIRAL FLUTES	D2.0	D20.0	1034
K2121		HSS-E直柄夹持铰刀-左向螺旋槽(快速螺旋) HSS-E STRAIGHT SHANK CHUCKING REAMERS - LH SPIRAL FLUTES(QUICK SPIRAL)	D4.0	D20.0	1035
K2102		HSS-E锥柄夹持铰刀-直槽 HSS-E MORSE TAPER SHANK CHUCKING REAMERS - STRAIGHT FLUTES	D10.0	D50.0	1036
K2112		HSS-E锥柄夹持铰刀-左向螺旋槽 HSS-E MORSE TAPER SHANK CHUCKING REAMERS - LH SPIRAL FLUTES	D10.0	D50.0	1037
推荐的切削条件 RECOMMENDED CUTTING CONDITIONS					1038

高速钢手用铰刀-直槽

HSS HAND REAMERS - STRAIGHT FLUTES

- ▶ 刃部公差 : DIN 1420 for H7
- ▶ 柄部直径 = 铰刀刃部直径
- ▶ 直槽/右切
- ▶ 倒角-锥形
- ▶ 中心孔类型 - $\varnothing 3.75$ 以下 : 凸出中心孔
- $\varnothing 3.75$ 超过 : 内部中心孔

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Shank Diameter $\approx$ Nominal Reamer Diameter
- ▶ Straight Flutes / Right Hand Cut
- ▶ Chamfer Angle - tapered
- ▶ Type of center - Up to $\varnothing 3.75$: external centers
- Over $\varnothing 3.75$: internal centers

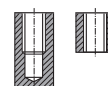


HSS

DIN
206

H7

Hole type



单位(Unit) : mm

型号	名义上的 尺寸	刃长	全长	刃数
EDP No.	Nominal SIZE	Flute Length	Overall Length	No. of Flutes
	D1	L1	L2	
K114300200	2.0	25	50	4
K114300220	2.2	27	54	4
K114300250	2.5	29	58	4
K114300280	2.8	31	62	4
K114300300	3.0	31	62	6
K114300320	3.2	33	66	6
K114300350	3.5	35	71	6
K114300400	4.0	38	76	6
K114300450	4.5	41	81	6
K114300500	5.0	44	87	6
K114300550	5.5	47	93	6
K114300600	6.0	47	93	6
K114300700	7.0	54	107	6
K114300800	8.0	58	115	6
K114300900	9.0	62	124	6
K114301000	10.0	66	133	6
K114301100	11.0	71	142	6
K114301200	12.0	76	152	6
K114301300	13.0	76	152	6
K114301400	14.0	81	163	8
K114301500	15.0	81	163	8
K114301600	16.0	87	175	8
K114301700	17.0	87	175	8
K114301800	18.0	93	188	8
K114301900	19.0	93	188	8
K114302000	20.0	100	201	8
K114302200	22.0	107	215	8
K114302400	24.0	115	231	8

HSS

CARBIDE



REAMERS

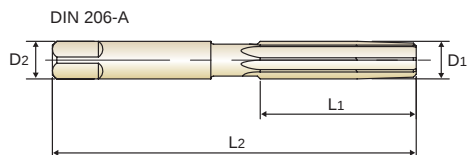
K1143 SERIES

高速钢手用铰刀-直槽

HSS HAND REAMERS - STRAIGHT FLUTES

- ▶ 刃部公差 : DIN 1420 for H7
- ▶ 柄部直径 = 铰刀刃部直径
- ▶ 直槽/右切
- ▶ 倒角-锥形
- ▶ 中心孔类型 - $\varnothing 3.75$ 以下 : 凸出中心孔
- $\varnothing 3.75$ 超过 : 内部中心孔

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Shank Diameter $\approx$ Nominal Reamer Diameter
- ▶ Straight Flutes / Right Hand Cut
- ▶ Chamfer Angle - tapered
- ▶ Type of center - Up to $\varnothing 3.75$: external centers
- Over $\varnothing 3.75$: internal centers



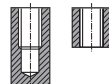
D1=D2

HSS

DIN
206

H7

Hole type



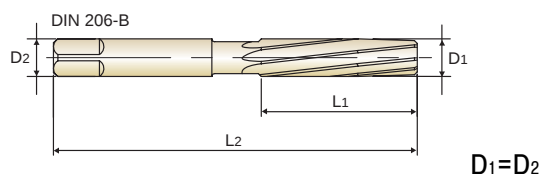
单位(Unit) : mm

型号 EDP No.	名义上的 尺寸 Nominal SIZE D1	刃长 Flute Length L1	全长 Overall Length L2	刃数 No. of Flutes
K114302500	25.0	115	231	8
K114302600	26.0	115	231	8
K114302700	27.0	124	247	10
K114302800	28.0	124	247	10
K114302900	29.0	124	247	10
K114303000	30.0	124	247	10
K114303100	31.0	133	265	10
K114303200	32.0	133	265	10
K114303300	33.0	133	265	10
K114303400	34.0	142	284	10
K114303500	35.0	142	284	10
K114303600	36.0	142	284	10
K114303700	37.0	142	284	10
K114303800	38.0	152	305	10
K114303810	38.1	152	305	10
K114303900	39.0	152	305	10
K114304000	40.0	152	305	10
K114304100	41.0	152	305	12
K114304200	42.0	152	305	12
K114304300	43.0	163	326	12
K114304400	44.0	163	326	12
K114304500	45.0	163	326	12
K114304600	46.0	163	326	12
K114304700	47.0	163	326	12
K114304800	48.0	174	347	12
K114304900	49.0	174	347	12
K114305200	52.0	174	347	12
K114306000	60.0	184	367	12

高速钢手用铰刀-左向螺旋槽 HSS HAND REAMERS - LH SPIRAL FLUTES

- ▶ 刃部公差 : DIN 1420 for H7
- ▶ 柄部直径 = 铰刀刃部直径
- ▶ 左向螺旋槽/右切
- ▶ 倒角-锥形
- ▶ 中心孔类型 - $\varnothing 3.75$ 以下 : 凸出中心孔
- $\varnothing 3.75$ 超过 : 内部中心孔

- ▶ O.D. Tolerances : DIN 1420, H7
- ▶ Shank Diameter $\approx$ Nominal Reamer Diameter
- ▶ LH Spiral Flutes / Right Hand Cut
- ▶ Chamfer Angle - tapered
- ▶ Type of center - Up to $\varnothing 3.75$: external centers
- Over $\varnothing 3.75$: internal centers



Hole type



单位(Unit) : mm

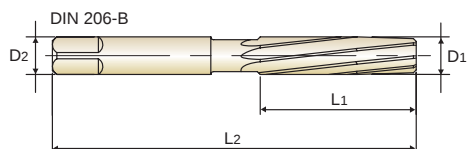
型号 EDP No.	名义上的 尺寸 Nominal SIZE	刃长 Flute Length	全长 Overall Length	刃数 No. of Flutes
	D1	L1	L2	
K115300200	2.0	25	50	4
K115300220	2.2	27	54	4
K115300250	2.5	29	58	4
K115300280	2.8	31	62	4
K115300300	3.0	31	62	6
K115300320	3.2	33	66	6
K115300350	3.5	35	71	6
K115300400	4.0	38	76	6
K115300450	4.5	41	81	6
K115300500	5.0	44	87	6
K115300550	5.5	47	93	6
K115300600	6.0	47	93	6
K115300700	7.0	54	107	6
K115300800	8.0	58	115	6
K115300900	9.0	62	124	6
K115301000	10.0	66	133	6
K115301100	11.0	71	142	6
K115301200	12.0	76	152	6
K115301300	13.0	76	152	6
K115301400	14.0	81	163	8
K115301500	15.0	81	163	8
K115301600	16.0	87	175	8
K115301700	17.0	87	175	8
K115301800	18.0	93	188	8
K115301900	19.0	93	188	8
K115302000	20.0	100	201	8
K115302200	22.0	107	215	8
K115302400	24.0	115	231	8

高速钢手用铰刀-左向螺旋槽

HSS HAND REAMERS - LH SPIRAL FLUTES

- ▶ 刃部公差 : DIN 1420 for H7
- ▶ 柄部直径 = 铰刀刃部直径
- ▶ 左向螺旋槽/右切
- ▶ 倒角-锥形
- ▶ 中心孔类型 - $\varnothing 3.75$ 以下 : 凸出中心孔
- $\varnothing 3.75$ 超过 : 内部中心孔

- ▶ O.D. Tolerances : DIN 1420, H7
- ▶ Shank Diameter $\approx$ Nominal Reamer Diameter
- ▶ LH Spiral Flutes / Right Hand Cut
- ▶ Chamfer Angle - tapered
- ▶ Type of center - Up to $\varnothing 3.75$: external centers
- Over $\varnothing 3.75$: internal centers



D1=D2

HSS

DIN
206

H7



Hole type



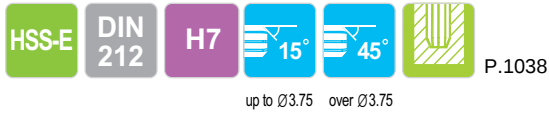
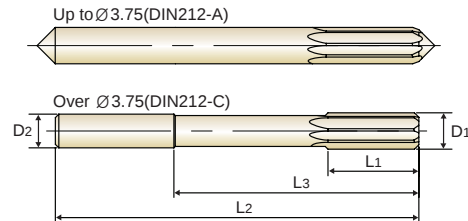
单位(Unit) : mm

型号 EDP No.	名义上的 尺寸 Nominal SIZE D1	刃长 Flute Length L1	全长 Overall Length L2	刃数 No. of Flutes
K115302500	25.0	115	231	8
K115302600	26.0	115	231	8
K115302700	27.0	124	247	10
K115302800	28.0	124	247	10
K115302900	29.0	124	247	10
K115303000	30.0	124	247	10
K115303100	31.0	133	265	10
K115303200	32.0	133	265	10
K115303300	33.0	133	265	10
K115303400	34.0	142	284	10
K115303500	35.0	142	284	10
K115303600	36.0	142	284	10
K115303700	37.0	142	284	10
K115303800	38.0	152	305	10
K115303810	38.1	152	305	10
K115303900	39.0	152	305	10
K115304000	40.0	152	305	10
K115304100	41.0	152	305	12
K115304200	42.0	152	305	12
K115304300	43.0	163	326	12
K115304400	44.0	163	326	12
K115304500	45.0	163	326	12
K115304600	46.0	163	326	12
K115304700	47.0	163	326	12
K115304800	48.0	174	347	12
K115304900	49.0	174	347	12
K115305200	52.0	174	347	12
K115306000	60.0	184	367	12

HSS-E 直柄夹持铰刀-直槽
HSS-E STRAIGHT SHANK CHUCKING REAMERS - STRAIGHT FLUTES

- ▶ 刃部公差 : DIN 1420 for H7
- ▶ 柄部直径 = h8
- ▶ 直槽/右切
- ▶ 倒角 - $\varnothing 3.75$ 以下: 15°
- $\varnothing 3.75$ 超过: 45°

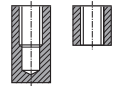
- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Shank Diameter Tolerances : h8
- ▶ Straight Flute / Right Hand Cut
- ▶ Chamfer Angle - Up to $\varnothing 3.75$: 15°
- Over $\varnothing 3.75$: 45°



P.1038

up to $\varnothing 3.75$ over $\varnothing 3.75$

Hole type



单位(Unit) : mm

型号	名义上的 尺寸	柄部直径	切削长度	颈部长度	全长	刃数
EDP No.	Nominal SIZE	Shank Diameter	Cutting Length	Neck Length	Overall Length	No. of Flutes
	D1	D2	L1	L3	L2	
K210100200	2.0	2	11	-	49	4
K210100220	2.2	2.2	12	-	53	4
K210100250	2.5	2.5	14	-	57	4
K210100260	2.6	2.6	14	-	57	4
K210100280	2.8	2.8	15	-	61	4
K210100300	3.0	3	15	-	61	6
K210100310	3.1	3.1	16	-	65	6
K210100320	3.2	3.2	16	-	65	6
K210100350	3.5	3.5	18	-	70	6
K210100360	3.6	3.6	18	-	70	6
K210100370	3.7	3.7	18	-	70	6
K210100400	4.0	4	19	42	75	6
K210100430	4.3	4.5	21	46	80	6
K210100450	4.5	4.5	21	46	80	6
K210100460	4.6	4.5	21	46	80	6
K210100500	5.0	5	23	51	86	6
K210100550	5.5	5.6	26	56	93	6
K210100560	5.6	5.6	26	56	93	6
K210100600	6.0	5.6	26	56	93	6
K210100650	6.5	6.3	28	62	101	6
K210100700	7.0	7.1	31	68	109	6
K210100720	7.2	7.1	31	68	109	6
K210100800	8.0	8	33	74	117	6
K210100830	8.3	8	33	74	117	6
K210100850	8.5	8	33	74	117	6
K210100900	9.0	9	36	80	125	6
K210100950	9.5	9	36	80	125	6
K210101000	10.0	10	38	86	133	6
K210101050	10.5	10	38	86	133	6
K210101100	11.0	10	41	95	142	6
K210101200	12.0	10	44	104	151	6
K210101300	13.0	10	44	104	151	6
K210101400	14.0	12.5	47	108	160	8
K210101500	15.0	12.5	50	110	162	8
K210101600	16.0	12.5	52	118	170	8
K210101700	17.0	14	54	121	175	8
K210101800	18.0	14	56	128	182	8
K210101900	19.0	16	58	129	189	8
K210102000	20.0	16	60	135	195	8

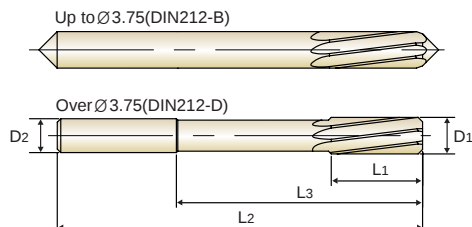


HSS-E 直柄夹持铰刀-左向螺旋槽

HSS-E STRAIGHT SHANK CHUCKING REAMERS - LH SPIRAL FLUTES

- ▶ 刃部公差 : DIN 1420 for H7
- ▶ 柄部直径 = h8
- ▶ 左向螺旋槽 / 右切
- ▶ 倒角 - $\varnothing 3.75$ 以下 : 15°
- $\varnothing 3.75$ 超过 : 45°

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Shank Diameter Tolerances : h8
- ▶ LH Spiral Flutes / Right Hand Cut
- ▶ Chamfer Angle - Up to $\varnothing 3.75$: 15°
- Over $\varnothing 3.75$: 45°



P.1038

Hole type

up to $\varnothing 3.75$ over $\varnothing 3.75$

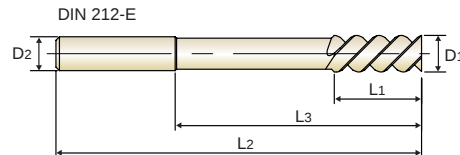
单位(Unit) : mm

型号 EDP No.	名义上的 尺寸 Nominal SIZE	柄部直径 Shank Diameter	切削长度 Cutting Length	颈部长度 Neck Length	全长 Overall Length	刃数 No. of Flutes
	D1	D2	L1	L3	L2	
K211100200	2.0	2	11	-	49	4
K211100220	2.2	2.2	12	-	53	4
K211100250	2.5	2.5	14	-	57	4
K211100260	2.6	2.6	14	-	57	4
K211100280	2.8	2.8	15	-	61	4
K211100300	3.0	3	15	-	61	6
K211100310	3.1	3.1	16	-	65	6
K211100320	3.2	3.2	16	-	65	6
K211100350	3.5	3.5	18	-	70	6
K211100360	3.6	3.6	18	-	70	6
K211100370	3.7	3.7	18	-	70	6
K211100400	4.0	4	19	42	75	6
K211100430	4.3	4.5	21	46	80	6
K211100450	4.5	4.5	21	46	80	6
K211100460	4.6	4.5	21	46	80	6
K211100500	5.0	5	23	51	86	6
K211100550	5.5	5.6	26	56	93	6
K211100560	5.6	5.6	26	56	93	6
K211100600	6.0	5.6	26	56	93	6
K211100650	6.5	6.3	28	62	101	6
K211100700	7.0	7.1	31	68	109	6
K211100720	7.2	7.1	31	68	109	6
K211100800	8.0	8	33	74	117	6
K211100830	8.3	8	33	74	117	6
K211100850	8.5	8	33	74	117	6
K211100900	9.0	9	36	80	125	6
K211100950	9.5	9	36	80	125	6
K211101000	10.0	10	38	86	133	6
K211101050	10.5	10	38	86	133	6
K211101100	11.0	10	41	95	142	6
K211101200	12.0	10	44	104	151	6
K211101300	13.0	10	44	104	151	6
K211101400	14.0	12.5	47	108	160	8
K211101500	15.0	12.5	50	110	162	8
K211101600	16.0	12.5	52	118	170	8
K211101700	17.0	14	54	121	175	8
K211101800	18.0	14	56	128	182	8
K211101900	19.0	16	58	129	189	8
K211102000	20.0	16	60	135	195	8

HSS-E直柄夹持铰刀-左向螺旋槽(快速螺旋)
HSS-E STRAIGHT SHANK CHUCKING REAMERS - LH SPIRAL FLUTES(QUICK SPIRAL)

- ▶ 刃部公差 : DIN 1420 for H7
- ▶ 柄部直径 = h8
- ▶ 倒角-锥形
- ▶ 左向高螺旋槽/右切

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Shank Diameter Tolerances : h8
- ▶ Chamfer Angle - tapered
- ▶ LH High Spiral Flutes / Right Hand Cut



HSS-E **DIN 212** **H7** **LH45°** **FORM E**  P.1038

Hole type


单位(Unit) : mm

型号	名义上的 尺寸	柄部直径	切削长度	颈部长度	全长	刃数
EDP No.	Nominal SIZE	Shank Diameter	Cutting Length	Neck Length	Overall Length	No. of Flutes
	D1	D2	L1	L3	L2	
K212100400	4.0	4	19	42	75	3
K212100450	4.5	4.5	21	46	80	3
K212100500	5.0	5	23	51	86	3
K212100550	5.5	5.6	26	56	93	3
K212100600	6.0	5.6	26	56	93	3
K212100650	6.5	6.3	28	62	101	3
K212100700	7.0	7.1	31	68	109	3
K212100800	8.0	8	33	74	117	3
K212100850	8.5	8	33	74	117	3
K212100900	9.0	9	36	80	125	3
K212100950	9.5	9	36	80	125	3
K212101000	10.0	10	38	86	133	3
K212101100	11.0	10	41	95	142	3
K212101200	12.0	10	44	104	151	3
K212101300	13.0	10	44	104	151	3
K212101400	14.0	12.5	47	108	160	4
K212101500	15.0	12.5	50	110	162	4
K212101600	16.0	12.5	52	118	170	4
K212101700	17.0	14	54	121	175	4
K212101800	18.0	14	56	128	182	4
K212101900	19.0	16	58	129	189	4
K212102000	20.0	16	60	135	195	4

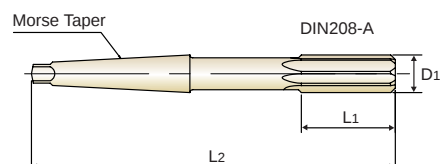


HSS-E 锥柄夹持铰刀-直槽

HSS-E MORSE TAPER SHANK CHUCKING REAMERS - STRAIGHT FLUTES

- ▶ 刃部公差 : DIN 1420 for H7
- ▶ 直槽/右切
- ▶ 倒角 - 45°

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ Straight Flute / Right Hand Cut
- ▶ Chamfer Angle : 45°



HSS-E

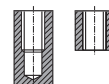
DIN
208

H7



P.1038

Hole type



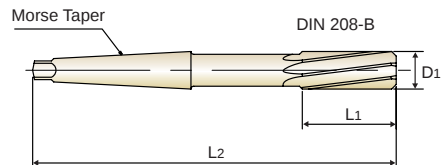
单位(Unit) : mm

型号 EDP No.	名义上的 尺寸 Nominal SIZE D1	锥度型号 No. of Morse Taper	切削长度 Cutting Length L1	全长 Overall Length L2	刃数 No. of Flutes
K210201000	10.0	1	38	168	6
K210201100	11.0	1	41	175	6
K210201200	12.0	1	44	182	6
K210201300	13.0	1	44	182	6
K210201400	14.0	1	47	189	8
K210201500	15.0	2	50	204	8
K210201600	16.0	2	52	210	8
K210201700	17.0	2	54	214	8
K210201800	18.0	2	56	219	8
K210201900	19.0	2	58	223	8
K210202000	20.0	2	60	228	8
K210202100	21.0	2	62	232	8
K210202200	22.0	2	64	237	8
K210202300	23.0	2	66	241	8
K210202400	24.0	3	68	268	8
K210202500	25.0	3	68	268	8
K210202600	26.0	3	70	273	8
K210202700	27.0	3	71	277	10
K210202800	28.0	3	71	277	10
K210202900	29.0	3	73	281	10
K210203000	30.0	3	73	281	10
K210203100	31.0	3	75	285	10
K210203200	32.0	4	77	317	10
K210203400	34.0	4	78	321	10
K210203500	35.0	4	78	321	10
K210203600	36.0	4	79	325	10
K210203800	38.0	4	81	329	10
K210204000	40.0	4	81	329	10
K210204100	41.0	4	82	333	12
K210204200	42.0	4	82	333	12
K210204300	43.0	4	83	336	12
K210204400	44.0	4	83	336	12
K210204500	45.0	4	83	336	12
K210204600	46.0	4	84	340	12
K210204700	47.0	4	84	340	12
K210204800	48.0	4	86	344	12
K210205000	50.0	4	86	344	12

HSS-E 锥柄夹持铰刀-左向螺旋槽
HSS-E MORSE TAPER SHANK CHUCKING REAMERS - LH SPIRAL FLUTES

- ▶ 刃部公差 : DIN 1420 for H7
- ▶ 左向螺旋槽/右切
- ▶ 倒角 - 45°

- ▶ O.D. Tolerances : DIN 1420 for H7
- ▶ LH Spiral Flutes / Right Hand Cut
- ▶ Chamfer Angle : 45°



HSS-E

DIN
208

H7



P.1038

Hole type



单位(Unit) : mm

型号 EDP No.	名义上的 尺寸 Nominal SIZE D1	锥度型号 No. of Morse Taper	切削长度 Cutting Length L1	全长 Overall Length L2	刃数 No. of Flutes
K211201000	10.0	1	38	168	6
K211201100	11.0	1	41	175	6
K211201200	12.0	1	44	182	6
K211201300	13.0	1	44	182	6
K211201400	14.0	1	47	189	8
K211201500	15.0	2	50	204	8
K211201600	16.0	2	52	210	8
K211201700	17.0	2	54	214	8
K211201800	18.0	2	56	219	8
K211201900	19.0	2	58	223	8
K211202000	20.0	2	60	228	8
K211202100	21.0	2	62	232	8
K211202200	22.0	2	64	237	8
K211202300	23.0	2	66	241	8
K211202400	24.0	3	68	268	8
K211202500	25.0	3	68	268	8
K211202600	26.0	3	70	273	8
K211202700	27.0	3	71	277	10
K211202800	28.0	3	71	277	10
K211202900	29.0	3	73	281	10
K211203000	30.0	3	73	281	10
K211203100	31.0	3	75	285	10
K211203200	32.0	4	77	317	10
K211203400	34.0	4	78	321	10
K211203500	35.0	4	78	321	10
K211203600	36.0	4	79	325	10
K211203800	38.0	4	81	329	10
K211204000	40.0	4	81	329	10
K211204100	41.0	4	82	333	12
K211204200	42.0	4	82	333	12
K211204300	43.0	4	83	336	12
K211204400	44.0	4	83	336	12
K211204500	45.0	4	83	336	12
K211204600	46.0	4	84	340	12
K211204700	47.0	4	84	340	12
K211204800	48.0	4	86	344	12
K211205000	50.0	4	86	344	12



直槽夹持式铰刀, 螺旋槽夹持式铰刀

STRAIGHT FLUTE CHUCKING REAMER, SPIRAL FLUTE CHUCKING REAMER

REAMERS

COUNTER
SINKSCOUNTER
BORESROTARY
BURRS

材质 Material	切削速度 Cutting Speed (m/min.)	每转进给 Feed(mm/rev.)					
		Ø2 ~ Ø4	Ø4 ~ Ø8	Ø8 ~ Ø13	Ø13 ~ Ø20	Ø20 ~ Ø30	> Ø30
钢 <500N/mm ² Steels < 500N/mm ²	12 ~ 16	0.05~0.15	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50
钢 500-700N/mm ² Steels 500-700N/mm ²	10 ~ 12	0.05~0.15	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50
钢 700-800N/mm ² Steels 700-800N/mm ²	6 ~ 8	0.05~0.10	0.08~0.16	0.10~0.20	0.15~0.25	0.20~0.30	0.30~0.40
合金钢或碳钢铸件 <500N/mm ² Alloy Steel or Carbon Steel castings < 500N/mm ²	6 ~ 10	0.05~0.10	0.08~0.16	0.10~0.20	0.15~0.25	0.20~0.30	0.30~0.40
合金钢或碳钢铸件 >500N/mm ² Alloy Steel or Carbon Steel castings > 500N/mm ²	4 ~ 6	0.05~0.10	0.08~0.16	0.10~0.20	0.15~0.25	0.20~0.30	0.30~0.40
合金钢或碳钢锻件 Alloy Steel or Carbon Steel forgings	4 ~ 6	0.03~0.08	0.06~0.10	0.08~0.15	0.10~0.20	0.15~0.25	0.20~0.30
铸铁 <200HB Cast Iron < 200HB	12 ~ 14	0.05~0.15	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50
铸铁 >200HB Cast Iron > 200HB	10 ~ 12	0.05~0.10	0.08~0.16	0.10~0.20	0.15~0.25	0.20~0.30	0.30~0.40
铝或铝合金 Aluminum or Aluminum Alloy	16 ~ 20	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50	0.40~0.60
镁或镁合金 Magnesium or Magnesium Alloy	10 ~ 16	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50	0.40~0.60
铜, 黄铜 Copper, Brass	16 ~ 18	0.10~0.20	0.15~0.25	0.20~0.30	0.25~0.40	0.35~0.50	0.40~0.60
不锈钢 Stainless Steels	4 ~ 6	0.03~0.08	0.06~0.10	0.08~0.15	0.10~0.20	0.15~0.25	0.20~0.30
塑料 Plastics	8 ~ 12	0.10~0.20	0.20~0.30	0.30~0.40	0.40~0.50	0.50~0.60	0.60~0.80

夹持式铰刀-大螺旋

CHUCKING REAMER-QUICK SPIRAL

材质 Material	切削速度 Cutting Speed (m/min.)	每转进给 Feed(mm/rev.)			
		Ø2 ~ Ø4	Ø4 ~ Ø8	Ø8 ~ Ø13	Ø13 ~ Ø20
钢 <500N/mm ² Steels < 500N/mm ²	16 ~ 18	0.08~0.16	0.16~0.25	0.20~0.30	0.30~0.40
钢 <500-700N/mm ² Steels 500-700N/mm ²	14 ~ 16	0.08~0.16	0.16~0.25	0.20~0.30	0.30~0.40
铝或铝合金 Aluminum or Aluminum Alloy	18 ~ 22	0.10~0.20	0.20~0.30	0.30~0.40	0.40~0.60
镁或镁合金 Magnesium or Magnesium Alloy	10 ~ 16	0.08~0.16	0.16~0.25	0.20~0.30	0.30~0.40
铜, 黄铜 Copper, Brass	16 ~ 20	0.08~0.16	0.16~0.25	0.20~0.30	0.30~0.40
塑料 Plastics	12 ~ 14	0.10~0.20	0.20~0.30	0.30~0.40	0.40~0.60