DOHRE®

DOHRE CNC TOOL CO.,LTD

http://www.dohrecnc.com

DOHRE®

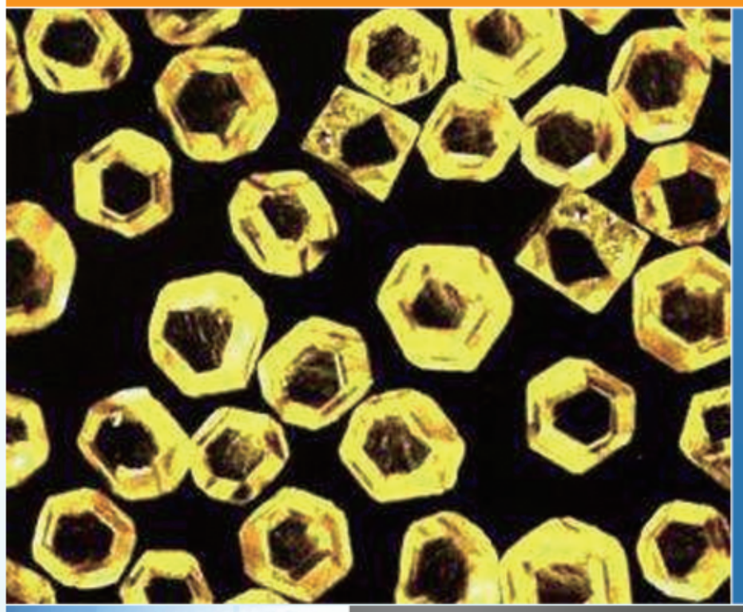
CBN milling cutter

durable high saface roughness



CBN Milling Cutters CBN铣刀





CBN Material Introduce
CBN材质简介

1957年，美国通用公司首次发现立方氮化硼晶体(CBN),由于其具有优异的超硬性、和高化学惰性而引起普遍关注。目前国内已具备量产CBN刀具的能力，并开始推广使用。CBN刀具适用于精加工、半精加工和各类淬硬铸铁，高温合金等难削材加工。

In 1975, GE found the CBN for the first time, because of its excellent superhardness and high chemical inertia, it was concerned soon widely . At present, China has the capacity to produce CBN tooling and also began to promte the useing. CBN tool is good at finishing , semi-finishing & all kinds of hardend cast iron, high temperaturer alloys & other difficut machining material.



Features of CBN CBN特性

CBN是人类已知的硬度仅次于金刚石的物质，其热稳定性和化学惰性远大于金刚石，可耐受1300-的高温，甚至在1500℃时也不发生相变，从而保持硬度。CBN与铁系金属的亲和性较低，故CBN刀具能对铁系金属进行高速切削，加工精度高，表面光洁度高。切削速度比硬质合金提高10倍，其硬度和耐磨性是硬质合金刀具的50倍，陶瓷刀具的25倍。

CBN is the only material human knows now that its hardness is second only to diamond. its thermal stability & chemical inertness is much better than diamond. can withstand 1300-1500℃, even at 1500℃,it does not happen phase change. CBN has low affinity with iron-based metal. so it can be used for the high speed cutting of iron-based metal, high precision & surface finish, cutting speed is 10 times than carbide, hardness & wear resistance is 50 times than carbide cutting tool, 25 times than ceramic tool.

Application Case 应用案例



Thin-wall Machining
薄壁加工



HSS Slice Cutting
高速钢薄片加工



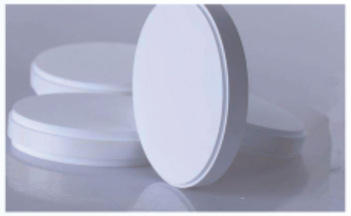
HSS Groove Cutting
高速钢沟槽切削



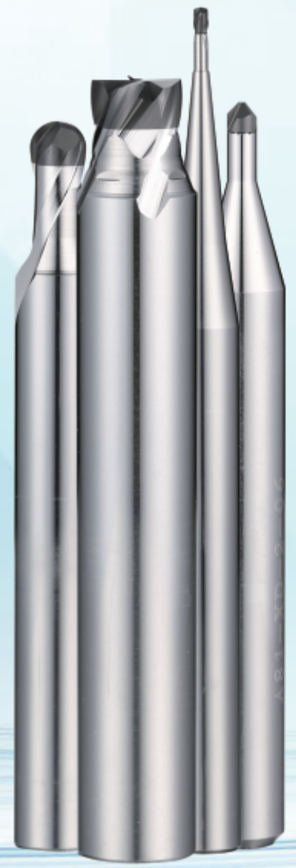
Tungsten Carbide Cutting
硬质合金切削



Mirror Finishing Cutting
镜面切削效果



Ceramics Machining
陶瓷加工



Application Range 加工范围

各类淬火钢：陶瓷、碳素工具钢、合金钢、轴承钢、高速钢等工件，工件硬度在30-70HRC.

Hardened steel, ceramic, carbon tool steel, alloy steel, bearing steel, high speed steel & HRC30~70 workpiece

热喷涂类:Ni基、Fe基两大系列产品及其他一些耐磨、耐腐、耐热喷涂材料。

Ni & Fe base & other wear-resistant, corrosion-resistant, heat-resistant spray material

耐磨铸铁类：V-Ti铸铁、高磷铸铁和冷硬铸铁等。

V-Ti cast iron, high phosphorus cast iron and chilled cast iron and other wear-resistant cast iron

钛合金类：TC4等

TC4 and other titanium alloy

耐热合金的部分工作

Some types of heat resistant alloys

YG类硬质合金工件，以及在某些场合下代替原用的金刚石刀具。

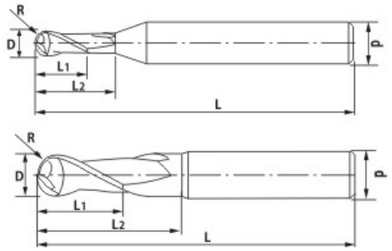
YG-type carbide workpieces, instead of the diamond tool in some cases

2刃高速球头立铣刀 2 Flutes High Speed Rib Ball End Mills

特點
- HRC50~70 淬火钢加工精度 ±5μm
- 超出寿命
- 高精度表面加工
- 多种刃长可供选择
- 推荐转速20000~50000RPM,油雾冷却
- CBN

Feature
- PCBN ENDMILL for precise finishing(± 5 μ m)of hardened steel(HRC50~70).
- Long tool life by high content PCBN.
- Excellent surface finsh.
- Various flute length for optimum performance.
- Recommend high speed(20000~50000RPM)with oil-mist.
- C.B.N(Cubic Boron Nitride)





D size	D tolerance
Φ0.2~6	+0~-0.01mm



Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2BCBN 002 002 S04	0.1P×0.2	0.2	-	48	4
2BCBN 002 004 S04	0.1P×0.2	0.4	-	48	4
2BCBN 003 003 S04	0.15P×0.3	0.3	-	48	4
2BCBN 003 005 S04	0.15P×0.3	0.5	-	48	4
2BCBN 004 015 S04	0.2P×0.4	0.3	1.5	48	4
2BCBN 004 020 S04	0.2P×0.4	0.3	2	48	4
2BCBN 004 030 S04	0.2P×0.4	0.3	3	48	4
2BCBN 004 040 S04	0.2P×0.4	0.3	4	48	4
2BCBN 004 050 S04	0.2P×0.4	0.3	5	48	4
2BCBN 004 060 S04	0.2P×0.4	0.3	6	48	4
2BCBN 005 015 S04	0.25P×0.5	0.4	1.5	48	4
2BCBN 005 020 S04	0.25P×0.5	0.4	2	48	4
2BCBN 005 030 S04	0.25P×0.5	0.4	3	48	4
2BCBN 005 040 S04	0.25P×0.5	0.4	4	48	4
2BCBN 005 050 S04	0.25P×0.5	0.4	5	48	4
2BCBN 005 060 S04	0.25P×0.5	0.4	6	48	4
2BCBN 005 080 S04	0.25P×0.5	0.4	8	48	4
2BCBN 006 015 S04	0.3P×0.6	0.5	1.5	48	4
2BCBN 006 020 S04	0.3P×0.6	0.5	2	48	4
2BCBN 006 030 S04	0.3P×0.6	0.5	3	48	4
2BCBN 006 040 S04	0.3P×0.6	0.5	4	48	4
2BCBN 006 050 S04	0.3P×0.6	0.5	5	48	4
2BCBN 006 060 S04	0.3P×0.6	0.5	6	48	4
2BCBN 006 080 S04	0.3P×0.6	0.5	8	48	4
2BCBN 006 100 S04	0.3P×0.6	0.5	10	48	4
2BCBN 007 020 S04	0.35P×0.7	0.5	2	48	4
2BCBN 007 040 S04	0.35P×0.7	0.5	4	48	4
2BCBN 008 020 S04	0.4P×0.8	0.6	2	48	4
2BCBN 008 040 S04	0.4P×0.8	0.6	4	48	4
2BCBN 008 060 S04	0.4P×0.8	0.6	6	48	4
2BCBN 008 080 S04	0.4P×0.8	0.6	8	48	4
2BCBN 008 100 S04	0.4P×0.8	0.6	10	48	4
2BCBN 009 020 S04	0.45P×0.9	0.6	2	48	4
2BCBN 009 040 S04	0.45P×0.9	0.6	4	48	4
2BCBN 010 025 S04	0.5P×1	0.7	2.5	48	4
2BCBN 010 040 S04	0.5P×1	0.7	4	48	4
2BCBN 010 050 S04	0.5P×1	0.7	5	48	4
2BCBN 010 060 S04	0.5P×1	0.7	6	48	4
2BCBN 010 080 S04	0.5P×1	0.7	8	48	4
2BCBN 010 100 S04	0.5P×1	0.7	10	48	4
2BCBN 010 120 S04	0.5P×1	0.7	12	48	4
2BCBN 010 160 S04	0.5P×1	0.7	16	48	4
2BCBN 012 040 S04	0.6P×1.2	0.8	4	48	4
2BCBN 012 060 S04	0.6P×1.2	0.8	6	48	4
2BCBN 012 080 S04	0.6P×1.2	0.8	8	48	4
2BCBN 012 100 S04	0.6P×1.2	0.8	10	48	4
2BCBN 012 120 S04	0.6P×1.2	0.8	12	48	4
2BCBN 012 160 S04	0.6P×1.2	0.8	16	48	4

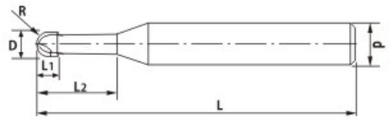
Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2BCBN 015 040 S04	0.75P×1.5	1	4	48	4
2BCBN 015 060 S04	0.75P×1.5	1	6	48	4
2BCBN 015 080 S04	0.75P×1.5	1	8	48	4
2BCBN 015 100 S04	0.75P×1.5	1	10	48	4
2BCBN 015 120 S04	0.75P×1.5	1	12	48	4
2BCBN 015 140 S04	0.75P×1.5	1	14	48	4
2BCBN 015 160 S04	0.75P×1.5	1	16	48	4
2BCBN 015 180 S04	0.75P×1.5	1	18	48	4
2BCBN 020 040 S04	1P×2	1.2	4	50	4
2BCBN 020 060 S04	1P×2	1.2	6	50	4
2BCBN 020 080 S04	1P×2	1.2	8	50	4
2BCBN 020 100 S04	1P×2	1.2	10	50	4
2BCBN 020 120 S04	1P×2	1.2	12	50	4
2BCBN 020 140 S04	1P×2	1.2	14	50	4
2BCBN 020 160 S04	1P×2	1.2	16	50	4
2BCBN 020 180 S04	1P×2	1.2	18	50	4
2BCBN 025 060 S06	1.25P×2.5	1.6	6	66	6
2BCBN 025 100 S06	1.25P×2.5	1.6	10	66	6
2BCBN 025 160 S06	1.25P×2.5	1.6	16	66	6
2BCBN 025 200 S06	1.25P×2.5	1.6	20	66	6
2BCBN 030 060 S06	1.5P×3	1.8	6	66	6
2BCBN 030 080 S06	1.5P×3	1.8	8	66	6
2BCBN 030 100 S06	1.5P×3	1.8	10	66	6
2BCBN 030 120 S06	1.5P×3	1.8	12	66	6
2BCBN 030 160 S06	1.5P×3	1.8	16	66	6
2BCBN 030 200 S06	1.5P×3	1.8	20	66	6
2BCBN 040 060 S06	2P×4	2.4	6	66	6
2BCBN 040 080 S06	2P×4	2.4	8	66	6
2BCBN 040 100 S06	2P×4	2.4	10	66	6
2BCBN 040 120 S06	2P×4	2.4	12	66	6
2BCBN 040 160 S06	2P×4	2.4	16	66	6
2BCBN 040 200 S06	2P×4	2.4	20	66	6
2BCBN 060 035 S06	3P×6	3.5	-	83	6
2BCBN 060 100 S06	3P×6	3.5	10	83	6
2BCBN 060 200 S06	3P×6	3.5	20	83	6

2刃球头立铣刀 2 Flutes High Speed Straight Rib Ball End Mills

特點
- HRC50~70 淬火钢加工精度 ±5μm
- 超出寿命
- 直柄设计
- 高精度表面加工
- 多种刃长可供选择
- 推荐转速20000~50000RPM,油雾冷去
- CBN

Feature
- PCBN ENDMILL for precise finishing(± 5 μ m)of hardened steel(HRC50~70).
- Long tool life by high content PCBN.
- Straight type Design for Minimizing edge chipping.
- Excellent surface finsh.
- Various flute length for optimum performance.
- Recommend high speed(20000~50000RPM)with oil-mist.
- C.B.N(Cubic Boron Nitride)





D size	D tolerance
Φ0.2~6	+0~-0.01mm



Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2SBCBN 002 002 S04	0.1P×0.2	0.2	–	48	4
2SBCBN 002 004 S04	0.1P×0.2	0.4	–	48	4
2SBCBN 003 003 S04	0.15P×0.3	0.3	–	48	4
2SBCBN 003 005 S04	0.15P×0.3	0.5	–	48	4
2SBCBN 004 015 S04	0.2P×0.4	0.3	1.5	48	4
2SBCBN 005 015 S04	0.25P×0.5	0.4	1.5	48	4
2SBCBN 005 020 S04	0.25P×0.5	0.4	2	48	4
2SBCBN 006 015 S04	0.3P×0.6	0.5	1.5	48	4
2SBCBN 006 020 S04	0.3P×0.6	0.5	2	48	4
2SBCBN 006 030 S04	0.3P×0.6	0.5	3	48	4
2SBCBN 006 040 S04	0.3P×0.6	0.5	4	48	4
2SBCBN 007 020 S04	0.35P×0.7	0.5	2	48	4
2SBCBN 008 020 S04	0.4P×0.8	0.6	2	48	4
2SBCBN 008 030 S04	0.4P×0.8	0.6	3	48	4
2SBCBN 008 040 S04	0.4P×0.8	0.6	4	48	4
2SBCBN 009 020 S04	0.45P×0.9	0.6	2	48	4
2SBCBN 010 025 S04	0.5P×1	0.7	2.5	48	4
2SBCBN 010 040 S04	0.5P×1	0.7	4	48	4
2SBCBN 010 050 S04	0.5P×1	0.7	5	48	4
2SBCBN 010 060 S04	0.5P×1	0.7	6	48	4
2SBCBN 012 040 S04	0.6P×1.2	0.8	4	48	4
2SBCBN 015 040 S04	0.75P×1.5	1	4	48	4
2SBCBN 015 060 S04	0.75P×1.5	1	6	48	4
2SBCBN 015 080 S04	0.75P×1.5	1	8	48	4
2SBCBN 015 100 S04	0.75P×1.5	1	10	48	4
2SBCBN 020 040 S04	1P×2	1.2	4	50	4
2SBCBN 020 060 S04	1P×2	1.2	6	50	4
2SBCBN 020 080 S04	1P×2	1.2	8	50	4
2SBCBN 020 100 S04	1P×2	1.2	10	50	4
2SBCBN 020 120 S04	1P×2	1.2	12	50	4
2SBCBN 025 060 S06	1.25P×2.5	1.6	6	66	6
2SBCBN 030 060 S06	1.5P×3	1.8	6	66	6
2SBCBN 030 080 S06	1.5P×3	1.8	8	66	6
2SBCBN 030 100 S06	1.5P×3	1.8	10	66	6
2SBCBN 030 120 S06	1.5P×3	1.8	12	66	6
2SBCBN 030 160 S06	1.5P×3	1.8	16	66	6
2SBCBN 030 200 S06	1.5P×3	1.8	20	66	6
2SBCBN 040 060 S06	2P×4	2.4	6	66	6
2SBCBN 040 080 S06	2P×4	2.4	8	66	6
2SBCBN 040 100 S06	2P×4	2.4	10	66	6
2SBCBN 040 120 S06	2P×4	2.4	12	66	6
2SBCBN 040 160 S06	2P×4	2.4	16	66	6
2SBCBN 040 200 S06	2P×4	2.4	20	66	6
2SBCBN 060 035 S06	3P×6	3.5	–	83	6
2SBCBN 060 100 S06	3P×6	3.5	10	83	6

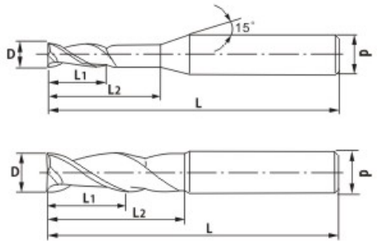
Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d

2刃立铣刀 2 Flutes High Speed Rib Ball End Mills

特點
HRC50~70 淬火钢加工精度 ±5μm
超出寿命
高精度表面加工
多种刃长可供选择
推荐转速20000~50000RPM,油雾冷却
CBN

Feature
PCBN ENDMILL for precise finishing(± 5 μ m)of hardened steel(HRC50~70).
Long tool life by high content PCBN.
Excellent surface finsh.
Various flute length for optimum performance.
Recommend high speed(20000~50000RPM)with oil-mist.
C.B.N(Cubic Boron Nitride)





D size	D tolerance
Φ0.2~6	+0~-0.01mm



Order Number	Diameter D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2ECBN 002 002 S04	0.2	0.2	–	48	4
2ECBN 002 004 S04	0.2	0.4	–	48	4
2ECBN 003 003 S04	0.3	0.3	–	48	4
2ECBN 003 005 S04	0.3	0.5	–	48	4
2ECBN 004 015 S04	0.4	0.3	1.5	48	4
2ECBN 004 020 S04	0.4	0.3	2	48	4
2ECBN 004 030 S04	0.4	0.3	3	48	4
2ECBN 004 040 S04	0.4	0.3	4	48	4
2ECBN 004 050 S04	0.4	0.3	5	48	4
2ECBN 004 060 S04	0.4	0.3	6	48	4
2ECBN 005 015 S04	0.5	0.4	1.5	48	4
2ECBN 005 020 S04	0.5	0.4	2	48	4
2ECBN 005 030 S04	0.5	0.4	3	48	4
2ECBN 005 040 S04	0.5	0.4	4	48	4
2ECBN 005 050 S04	0.5	0.4	5	48	4
2ECBN 005 060 S04	0.5	0.4	6	48	4
2ECBN 005 080 S04	0.5	0.4	8	48	4
2ECBN 006 015 S04	0.6	0.5	1.5	48	4
2ECBN 006 020 S04	0.6	0.5	2	48	4
2ECBN 006 030 S04	0.6	0.5	3	48	4
2ECBN 006 040 S04	0.6	0.5	4	48	4
2ECBN 006 060 S04	0.6	0.5	6	48	4
2ECBN 006 080 S04	0.6	0.5	8	48	4
2ECBN 006 100 S04	0.6	0.5	10	48	4
2ECBN 007 025 S04	0.7	0.5	2.5	48	4
2ECBN 007 040 S04	0.7	0.5	4	48	4
2ECBN 007 060 S04	0.7	0.5	6	48	4
2ECBN 008 025 S04	0.8	0.6	2.5	48	4
2ECBN 008 040 S04	0.8	0.6	4	48	4
2ECBN 008 060 S04	0.8	0.6	6	48	4
2ECBN 008 080 S04	0.8	0.6	8	48	4
2ECBN 008 100 S04	0.8	0.6	10	48	4
2ECBN 009 025 S04	0.9	0.6	2.5	48	4
2ECBN 009 040 S04	0.9	0.6	4	48	4
2ECBN 009 060 S04	0.9	0.6	6	48	4
2ECBN 009 080 S04	0.9	0.6	8	48	4
2ECBN 009 100 S04	0.9	0.6	10	48	4
2ECBN 010 025 S04	1	0.7	2.5	48	4
2ECBN 010 040 S04	1	0.7	4	48	4
2ECBN 010 050 S04	1	0.7	5	48	4
2ECBN 010 060 S04	1	0.7	6	48	4
2ECBN 010 080 S04	1	0.7	8	48	4
2ECBN 010 100 S04	1	0.7	10	48	4
2ECBN 010 120 S04	1	0.7	12	48	4
2ECBN 010 140 S04	1	0.7	14	48	4
2ECBN 010 160 S04	1	0.7	16	48	4
2ECBN 012 030 S04	1.2	0.7	3	48	4
2ECBN 012 040 S04	1.2	0.7	4	48	4

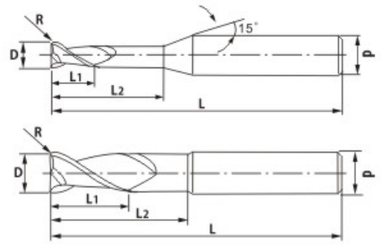
Order Number	Diameter D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2ECBN 012 060 S04	1.2	0.7	6	48	4
2ECBN 012 080 S04	1.2	0.7	8	48	4
2ECBN 012 100 S04	1.2	0.7	10	48	4
2ECBN 012 120 S04	1.2	0.7	12	48	4
2ECBN 012 160 S04	1.2	0.7	16	48	4
2ECBN 015 030 S04	1.5	0.8	3	48	4
2ECBN 015 060 S04	1.5	0.8	6	48	4
2ECBN 015 080 S04	1.5	0.8	8	48	4
2ECBN 015 100 S04	1.5	0.8	10	48	4
2ECBN 015 120 S04	1.5	0.8	12	48	4
2ECBN 015 140 S04	1.5	0.8	14	48	4
2ECBN 015 160 S04	1.5	0.8	16	48	4
2ECBN 015 180 S04	1.5	0.8	18	48	4
2ECBN 020 030 S04	2	0.9	3	50	4
2ECBN 020 060 S04	2	0.9	6	50	4
2ECBN 020 080 S04	2	0.9	8	50	4
2ECBN 020 100 S04	2	0.9	10	50	4
2ECBN 020 120 S04	2	0.9	12	50	4
2ECBN 020 140 S04	2	0.9	14	50	4
2ECBN 020 160 S04	2	0.9	16	50	4
2ECBN 020 180 S04	2	0.9	18	50	4
2ECBN 025 060 S06	2.5	1.2	6	66	6
2ECBN 025 100 S06	2.5	1.2	10	66	6
2ECBN 025 160 S06	2.5	1.2	16	66	6
2ECBN 025 200 S06	2.5	1.2	20	66	6
2ECBN 030 060 S06	3	1.2	6	66	6
2ECBN 030 080 S06	3	1.2	8	66	6
2ECBN 030 100 S06	3	1.2	10	66	6
2ECBN 030 120 S06	3	1.2	12	66	6
2ECBN 030 160 S06	3	1.2	16	66	6
2ECBN 030 200 S06	3	1.2	20	66	6
2ECBN 040 060 S06	4	1.5	6	66	6
2ECBN 040 080 S06	4	1.5	8	66	6
2ECBN 040 100 S06	4	1.5	10	66	6
2ECBN 040 120 S06	4	1.5	12	66	6
2ECBN 040 160 S06	4	1.5	16	66	6
2ECBN 040 200 S06	4	1.5	20	66	6
2ECBN 060 030 S06	6	3	–	66	6
2ECBN 060 100 S06	6	3	10	66	6
2ECBN 060 200 S06	6	3	20	66	6

2刃高速圆鼻立铣刀 2 Flutes High Speed Rib Corner Radius End Mills

特點
HRC50~70 淬火钢加工精度 ±5μm
超出寿命
高精度表面加工
多种刃长可供选择
推荐转速20000~50000RPM,油雾冷却
CBN

Feature
PCBN ENDMILL for precise finishing(± 5 μ m)of hardened steel(HRC50~70).
Long tool life by high content PCBN.
Excellent surface finsh.
Various flute length for optimum performance.
Recommend high speed(20000~50000RPM)with oil-mist.
C.B.N(Cubic Boron Nitride)





D size	D tolerance
Φ0.4~6	+0~-0.01mm



Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2CCBN 004 0002 015	0.4×P0.02	0.3	1.5	48	4
2CCBN 004 0002 020	0.4×P0.02	0.3	2	48	4
2CCBN 004 0005 015	0.4×P0.05	0.3	1.5	48	4
2CCBN 004 0005 020	0.4×P0.05	0.3	2	48	4
2CCBN 004 001 015	0.4×P0.1	0.3	1.5	48	4
2CCBN 004 001 020	0.4×P0.1	0.3	2	48	4
2CCBN 005 0005 015	0.5×P0.05	0.4	1.5	48	4
2CCBN 005 0005 020	0.5×P0.05	0.4	2	48	4
2CCBN 005 0005 030	0.5×P0.05	0.4	3	48	4
2CCBN 005 0005 040	0.5×P0.05	0.4	4	48	4
2CCBN 005 0005 050	0.5×P0.05	0.4	5	48	4
2CCBN 005 001 015	0.5×P0.1	0.4	1.5	48	4
2CCBN 005 001 020	0.5×P0.1	0.4	2	48	4
2CCBN 005 001 030	0.5×P0.1	0.4	3	48	4
2CCBN 005 001 040	0.5×P0.1	0.4	4	48	4
2CCBN 005 001 050	0.5×P0.1	0.4	5	48	4
2CCBN 006 0005 020	0.6×P0.05	0.5	2	48	4
2CCBN 006 0005 030	0.6×P0.05	0.5	3	48	4
2CCBN 006 0005 040	0.6×P0.05	0.5	4	48	4
2CCBN 006 0005 060	0.6×P0.05	0.5	6	48	4
2CCBN 006 001 020	0.6×P0.1	0.5	2	48	4
2CCBN 006 001 030	0.6×P0.1	0.5	3	48	4
2CCBN 006 001 040	0.6×P0.1	0.5	4	48	4
2CCBN 006 001 060	0.6×P0.1	0.5	6	48	4
2CCBN 007 001 025	0.7×P0.1	0.5	2.5	48	4
2CCBN 007 001 040	0.7×P0.1	0.5	4	48	4
2CCBN 007 001 060	0.7×P0.1	0.5	6	48	4
2CCBN 008 001 025	0.8×P0.1	0.6	2.5	48	4
2CCBN 008 001 040	0.8×P0.1	0.6	4	48	4
2CCBN 008 001 060	0.8×P0.1	0.6	6	48	4
2CCBN 008 002 025	0.8×P0.2	0.6	2.5	48	4
2CCBN 008 002 040	0.8×P0.2	0.6	4	48	4
2CCBN 008 002 060	0.8×P0.2	0.6	6	48	4
2CCBN 010 0002 025	1×P0.02	0.7	2.5	48	4
2CCBN 010 0002 040	1×P0.02	0.7	4	48	4
2CCBN 010 0002 060	1×P0.02	0.7	6	48	4
2CCBN 010 0002 080	1×P0.02	0.7	8	48	4
2CCBN 010 0002 100	1×P0.02	0.7	10	48	4
2CCBN 010 0005 025	1×P0.02	0.7	2.5	48	4
2CCBN 010 0005 040	1×P0.02	0.7	4	48	4
2CCBN 010 0005 060	1×P0.02	0.7	6	48	4
2CCBN 010 0005 080	1×P0.02	0.7	8	48	4
2CCBN 010 0005 100	1×P0.02	0.7	10	48	4
2CCBN 010 001 025	1×P0.1	0.7	2.5	48	4
2CCBN 010 001 040	1×P0.1	0.7	4	48	4
2CCBN 010 001 060	1×P0.1	0.7	6	48	4
2CCBN 010 001 080	1×P0.1	0.7	8	48	4
2CCBN 010 001 100	1×P0.1	0.7	10	48	4

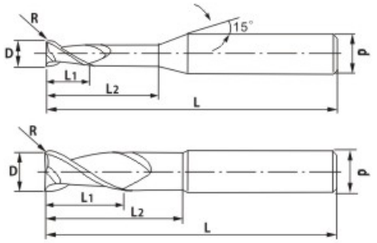
Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2CCBN 010 002 025	1×P0.2	0.7	2.5	48	4
2CCBN 010 002 040	1×P0.2	0.7	4	48	4
2CCBN 010 002 060	1×P0.2	0.7	6	48	4
2CCBN 010 002 080	1×P0.2	0.7	8	48	4
2CCBN 010 002 100	1×P0.2	0.7	10	48	4
2CCBN 010 003 025	1×P0.3	0.7	2.5	48	4
2CCBN 010 003 040	1×P0.3	0.7	4	48	4
2CCBN 010 003 060	1×P0.3	0.7	6	48	4
2CCBN 010 003 080	1×P0.3	0.7	8	48	4
2CCBN 010 003 100	1×P0.3	0.7	10	48	4
2CCBN 012 001 030	1.2×P0.1	0.7	3	48	4
2CCBN 012 001 040	1.2×P0.1	0.7	4	48	4
2CCBN 012 001 060	1.2×P0.1	0.7	6	48	4
2CCBN 012 001 080	1.2×P0.1	0.7	8	48	4
2CCBN 012 001 100	1.2×P0.1	0.7	10	48	4
2CCBN 012 002 030	1.2×P0.2	0.7	3	48	4
2CCBN 012 002 040	1.2×P0.2	0.7	4	48	4
2CCBN 012 002 060	1.2×P0.2	0.7	6	48	4
2CCBN 012 002 080	1.2×P0.2	0.7	8	48	4
2CCBN 012 002 100	1.2×P0.2	0.7	10	48	4
2CCBN 012 003 030	1.2×P0.3	0.7	3	48	4
2CCBN 012 003 040	1.2×P0.3	0.7	4	48	4
2CCBN 012 003 060	1.2×P0.3	0.7	6	48	4
2CCBN 012 003 080	1.2×P0.3	0.7	8	48	4
2CCBN 012 003 100	1.2×P0.3	0.7	10	48	4
2CCBN 015 0002 030	1.5×P0.02	0.8	3	48	4
2CCBN 015 0002 040	1.5×P0.02	0.8	4	48	4
2CCBN 015 0002 060	1.5×P0.02	0.8	6	48	4
2CCBN 015 0002 080	1.5×P0.02	0.8	8	48	4
2CCBN 015 0002 100	1.5×P0.02	0.8	10	48	4
2CCBN 015 0005 030	1.5×P0.05	0.8	3	48	4
2CCBN 015 0005 040	1.5×P0.05	0.8	4	48	4
2CCBN 015 0005 060	1.5×P0.05	0.8	6	48	4
2CCBN 015 0005 080	1.5×P0.05	0.8	8	48	4
2CCBN 015 0005 100	1.5×P0.05	0.8	10	48	4
2CCBN 015 001 030	1.5×P0.1	0.8	3	48	4
2CCBN 015 001 040	1.5×P0.1	0.8	4	48	4
2CCBN 015 001 060	1.5×P0.1	0.8	6	48	4
2CCBN 015 001 080	1.5×P0.1	0.8	8	48	4
2CCBN 015 001 100	1.5×P0.1	0.8	10	48	4
2CCBN 015 002 030	1.5×P0.2	0.8	3	48	4
2CCBN 015 002 040	1.5×P0.2	0.8	4	48	4
2CCBN 015 002 060	1.5×P0.2	0.8	6	48	4
2CCBN 015 002 080	1.5×P0.2	0.8	8	48	4
2CCBN 015 002 100	1.5×P0.2	0.8	10	48	4
2CCBN 015 003 030	1.5×P0.3	0.8	3	48	4
2CCBN 015 003 040	1.5×P0.3	0.8	4	48	4
2CCBN 015 003 060	1.5×P0.3	0.8	6	48	4

2刃高速圆鼻立铣刀 2 Flutes High Speed Rib Corner Radius End Mills

特點
- HRC50~70 淬火钢加工精度 ±5μm
- 超出寿命
- 高精度表面加工
- 多种刃长可供选择
- 推荐转速20000~50000RPM,油雾冷却
- CBN

Feature
- PCBN ENDMILL for precise finishing(± 5 μ m)of hardened steel(HRC50~70).
- Long tool life by high content PCBN.
- Excellent surface finsh.
- Various flute length for optimum performance.
- Recommend high speed(20000~50000RPM)with oil-mist.
- C.B.N(Cubic Boron Nitride)





D size	D tolerance
Φ0.4~6	+0~-0.01mm



Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2CCBN 015 003 080	1.5-P0.3	0.8	8	48	4
2CCBN 015 003 100	1.5-P0.3	0.8	10	48	4
2CCBN 020 0002 030	2-P0.02	0.9	3	50	4
2CCBN 020 0002 060	2-P0.02	0.9	6	50	4
2CCBN 020 0002 080	2-P0.02	0.9	8	50	4
2CCBN 020 0002 100	2-P0.02	0.9	10	50	4
2CCBN 020 0005 030	2-P0.05	0.9	3	50	4
2CCBN 020 0005 060	2-P0.05	0.9	6	50	4
2CCBN 020 0005 080	2-P0.05	0.9	8	50	4
2CCBN 020 0005 100	2-P0.05	0.9	10	50	4
2CCBN 020 001 030	2-P0.1	0.9	3	50	4
2CCBN 020 001 060	2-P0.1	0.9	6	50	4
2CCBN 020 001 080	2-P0.1	0.9	8	50	4
2CCBN 020 001 100	2-P0.1	0.9	10	50	4
2CCBN 020 002 030	2-P0.2	0.9	3	50	4
2CCBN 020 002 060	2-P0.2	0.9	6	50	4
2CCBN 020 002 080	2-P0.2	0.9	8	50	4
2CCBN 020 002 100	2-P0.2	0.9	10	50	4
2CCBN 020 003 030	2-P0.3	0.9	3	50	4
2CCBN 020 003 060	2-P0.3	0.9	6	50	4
2CCBN 020 003 080	2-P0.3	0.9	8	50	4
2CCBN 020 003 100	2-P0.3	0.9	10	50	4
2CCBN 020 005 030	2-P0.5	0.9	3	50	4
2CCBN 020 005 060	2-P0.5	0.9	6	50	4
2CCBN 020 005 080	2-P0.5	0.9	8	50	4
2CCBN 020 005 100	2-P0.5	0.9	10	50	4
2CCBN 025 001 060	2.5-P0.1	1.2	6	66	6
2CCBN 025 001 100	2.5-P0.1	1.2	10	66	6
2CCBN 025 002 060	2.5-P0.2	1.2	6	66	6
2CCBN 025 002 100	2.5-P0.2	1.2	10	66	6
2CCBN 025 003 060	2.5-P0.3	1.2	6	66	6
2CCBN 025 003 100	2.5-P0.3	1.2	10	66	6
2CCBN 030 001 060	3-P0.1	1.2	6	66	6
2CCBN 030 001 100	3-P0.1	1.2	10	66	6
2CCBN 030 001 160	3-P0.1	1.2	16	66	6
2CCBN 030 001 200	3-P0.1	1.2	20	66	6
2CCBN 030 002 060	3-P0.2	1.2	6	66	6
2CCBN 030 002 100	3-P0.2	1.2	10	66	6
2CCBN 030 002 160	3-P0.2	1.2	16	66	6
2CCBN 030 002 200	3-P0.2	1.2	20	66	6
2CCBN 030 003 060	3-P0.3	1.2	6	66	6
2CCBN 030 003 100	3-P0.3	1.2	10	66	6
2CCBN 030 003 160	3-P0.3	1.2	16	66	6
2CCBN 030 003 200	3-P0.3	1.2	20	66	6
2CCBN 030 005 060	3-P0.5	1.2	6	66	6
2CCBN 030 005 100	3-P0.5	1.2	10	66	6
2CCBN 030 005 160	3-P0.5	1.2	16	66	6
2CCBN 030 005 200	3-P0.5	1.2	20	66	6

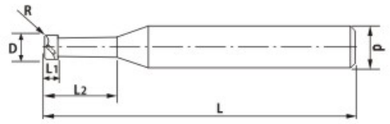
Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2CCBN 030 010 060	3×P1	1.2	6	66	6
2CCBN 030 010 100	3×P1	1.2	10	66	6
2CCBN 030 010 160	3×P1	1.2	16	66	6
2CCBN 030 010 200	4×P0.1	1.2	20	66	6
2CCBN 040 001 060	4×P0.1	1.5	6	66	6
2CCBN 040 001 100	4×P0.1	1.5	10	66	6
2CCBN 040 001 160	4×P0.2	1.5	16	66	6
2CCBN 040 002 060	4×P0.2	1.5	6	66	6
2CCBN 040 002 100	4×P0.2	1.5	10	66	6
2CCBN 040 002 160	4×P0.3	1.5	16	66	6
2CCBN 040 003 060	4×P0.3	1.5	6	66	6
2CCBN 040 003 100	4×P0.3	1.5	10	66	6
2CCBN 040 003 160	4×P0.5	1.5	16	66	6
2CCBN 040 005 060	4×P0.5	1.5	6	66	6
2CCBN 040 005 100	4×P0.5	1.5	10	66	6
2CCBN 040 005 160	4×P0.5	1.5	16	66	6
2CCBN 040 010 060	4×P1	1.5	6	66	6
2CCBN 040 010 100	4×P1	1.5	10	66	6
2CCBN 040 010 160	4×P1	1.5	16	66	6
2CCBN 060 003 030	6×P0.3	3	-	83	6
2CCBN 060 003 150	6×P0.3	3	15	83	6
2CCBN 060 005 030	6×P0.5	3	-	83	6
2CCBN 060 005 150	6×P0.5	3	15	83	6
2CCBN 060 010 030	6×P1	3	-	83	6
2CCBN 060 010 150	6×P1	3	15	83	6

2刃高速圆鼻立铣刀 2 Flutes High Speed Rib Corner Radius End Mills

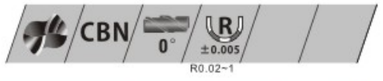
特點
- HRC50~70 淬火钢加工精度 ±5μm
- 超出寿命
- 直柄设计
- 高精度表面加工
- 多种刃长可供选择
- 推荐转速20000~50000RPM,油雾冷却
- CBN

Feature
- PCBN ENDMILL for precise finishing(± 5 μ m)of hardened steel(HRC50~70).
- Long tool life by high content PCBN.
- Straight type Design for Minimizing edge chipping.
- Excellent surface finsh.
- Various flute length for optimum performance.
- Recommend high speed(20000~50000RPM)with oil-mist.
- C.B.N(Cubic Boron Nitride)





D size	D tolerance
Φ0.4~6	+0~-0.01mm



Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2SCCBN 004 0002 015	0.4-P0.02	0.3	1.5	48	4
2SCCBN 004 0005 015	0.4-P0.05	0.3	1.5	48	4
2SCCBN 004 001 015	0.4-P0.1	0.3	1.5	48	4
2SCCBN 005 0005 015	0.5-P0.05	0.4	1.5	48	4
2SCCBN 005 001 015	0.5-P0.1	0.4	1.5	48	4
2SCCBN 006 0005 020	0.6-P0.05	0.5	2	48	4
2SCCBN 006 001 020	0.6-P0.1	0.5	2	48	4
2SCCBN 008 001 020	0.8-P0.1	0.6	2	48	4
2SCCBN 008 002 020	0.8-P0.2	0.6	2	48	4
2SCCBN 010 0002 025	1-P0.02	0.7	2.5	48	4
2SCCBN 010 0002 040	1-P0.02	0.7	4	48	4
2SCCBN 010 0005 025	1-P0.05	0.7	2.5	48	4
2SCCBN 010 0005 040	1-P0.05	0.7	4	48	4
2SCCBN 010 001 025	1-P0.1	0.7	2.5	48	4
2SCCBN 010 001 040	1-P0.1	0.7	4	48	4
2SCCBN 010 002 025	1-P0.2	0.7	2.5	48	4
2SCCBN 010 002 040	1-P0.2	0.7	4	48	4
2SCCBN 010 003 025	1-P0.3	0.7	2.5	48	4
2SCCBN 010 003 040	1-P0.3	0.7	4	48	4
2SCCBN 015 0002 030	1.5-P0.02	0.8	3	48	4
2SCCBN 015 0002 040	1.5-P0.02	0.8	4	48	4
2SCCBN 015 0005 030	1.5-P0.05	0.8	3	48	4
2SCCBN 015 0005 040	1.5-P0.05	0.8	4	48	4
2SCCBN 015 001 030	1.5-P0.1	0.8	3	48	4
2SCCBN 015 001 040	1.5-P0.1	0.8	4	48	4
2SCCBN 015 002 030	1.5-P0.2	0.8	3	48	4
2SCCBN 015 002 040	1.5-P0.2	0.8	4	48	4
2SCCBN 015 003 030	1.5-P0.3	0.8	3	48	4
2SCCBN 015 003 040	1.5-P0.3	0.8	4	48	4
2SCCBN 020 0002 030	2-P0.02	0.9	3	50	4
2SCCBN 020 0002 060	2-P0.02	0.9	6	50	4
2SCCBN 020 0005 030	2-P0.05	0.9	3	50	4
2SCCBN 020 0005 060	2-P0.05	0.9	6	50	4
2SCCBN 020 001 030	2-P0.1	0.9	3	50	4
2SCCBN 020 001 060	2-P0.1	0.9	6	50	4
2SCCBN 020 002 030	2-P0.2	0.9	3	50	4
2SCCBN 020 002 060	2-P0.2	0.9	6	50	4
2SCCBN 020 003 030	2-P0.3	0.9	3	50	4
2SCCBN 020 003 060	2-P0.3	0.9	6	50	4
2SCCBN 020 005 030	2-P0.5	0.9	3	50	4
2SCCBN 020 005 060	2-P0.5	0.9	6	50	4
2SCCBN 025 001 060	2.5-P0.1	1.2	6	50	6
2SCCBN 025 002 060	2.5-P0.2	1.2	6	50	6
2SCCBN 025 003 060	2.5-P0.3	1.2	6	50	6
2SCCBN 030 001 060	3-P0.1	1.2	6	50	6
2SCCBN 030 001 100	3-P0.1	1.2	10	50	6

Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2SCCBN 030 002 060	3-P0.2	1.2	6	66	6
2SCCBN 030 002 100	3-P0.2	1.2	10	66	6
2SCCBN 030 003 060	3-P0.3	1.2	6	66	6
2SCCBN 030 003 100	3-P0.3	1.2	10	66	6
2SCCBN 030 005 060	3-P0.5	1.2	6	66	6
2SCCBN 030 005 100	3-P0.5	1.2	10	66	6
2SCCBN 030 005 160	3-P0.5	1.2	16	66	6
2SCCBN 030 010 060	3-P1	1.2	6	66	6
2SCCBN 030 010 100	3-P1	1.2	10	66	6
2SCCBN 030 010 160	3-P1	1.2	16	66	6
2SCCBN 040 001 060	4-P0.1	1.5	6	66	6
2SCCBN 040 001 100	4-P0.1	1.5	10	66	6
2SCCBN 040 001 160	4-P0.1	1.5	16	66	6
2SCCBN 040 002 060	4-P0.2	1.5	6	66	6
2SCCBN 040 002 100	4-P0.2	1.5	10	66	6
2SCCBN 040 002 160	4-P0.2	1.5	16	66	6
2SCCBN 040 003 060	4-P0.3	1.5	6	66	6
2SCCBN 040 003 100	4-P0.3	1.5	10	66	6
2SCCBN 040 003 160	4-P0.3	1.5	16	66	6
2SCCBN 040 005 060	4-P0.5	1.5	6	66	6
2SCCBN 040 005 100	4-P0.5	1.5	10	66	6
2SCCBN 040 005 160	4-P0.5	1.5	16	66	6
2SCCBN 040 010 060	4-P1	1.5	6	66	6
2SCCBN 040 010 100	4-P1	1.5	10	66	6
2SCCBN 040 010 160	4-P1	1.5	16	66	6
2SCCBN 060 003 030	6-P0.3	3	–	83	6
2SCCBN 060 003 150	6-P0.3	3	15	83	6
2SCCBN 060 005 030	6-P0.5	3	–	83	6
2SCCBN 060 005 150	6-P0.5	3	15	83	6
2SCCBN 060 010 030	6-P1	3	–	83	6
2SCCBN 060 010 150	6-P1	3	15	83	6

Corner Radius End Mills

4刃高速圆鼻立铣刀 4 Flutes High Speed Rib Corner Radius End Mills

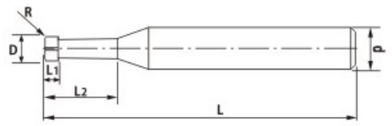
特點

HRC50~70 淬火钢加工精度 ±5μm
超出寿命
直柄设计
高精度表面加工
多种刃长可供选择
推荐转速20000~50000RPM,油雾冷却
CBN

Feature

PCBN ENDMILL for precise finishing(± 5 μ m)of hardened steel(HRC50~70).
Long tool life by high content PCBN.
Straight type Design for Minimizing edge chipping.
Excellent surface finsh.
Various flute length for optimum performance.
Recommend high speed(20000~50000RPM)with oil-mist.
C.B.N(Cubic Boron Nitride)





D size	D tolerance
ф0.8~6	+0~-0.01mm



Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
4SCCBN 008 001 025	0.8×P0.1	0.6	2.5	48	4
4SCCBN 008 002 025	0.8×P0.2	0.6	2.5	48	4
4SCCBN 010 0002 025	1×P0.02	0.7	2.5	48	4
4SCCBN 010 0002 040	1×P0.02	0.7	4	48	4
4SCCBN 010 0005 025	1×P0.05	0.7	2.5	48	4
4SCCBN 010 0005 040	1×P0.05	0.7	4	48	4
4SCCBN 010 001 025	1×P0.1	0.7	2.5	48	4
4SCCBN 010 001 040	1×P0.1	0.7	4	48	4
4SCCBN 010 002 025	1×P0.2	0.7	2.5	48	4
4SCCBN 010 002 040	1×P0.2	0.7	4	48	4
4SCCBN 010 003 025	1×P0.3	0.7	2.5	48	4
4SCCBN 010 003 040	1×P0.3	0.7	4	48	4
4SCCBN 015 0002 030	1.5×P0.02	0.8	3	48	4
4SCCBN 015 0002 040	1.5×P0.02	0.8	4	48	4
4SCCBN 015 0005 030	1.5×P0.05	0.8	3	48	4
4SCCBN 015 0005 040	1.5×P0.05	0.8	4	48	4
4SCCBN 015 001 030	1.5×P0.1	0.8	3	48	4
4SCCBN 015 001 040	1.5×P0.1	0.8	4	48	4
4SCCBN 015 002 030	1.5×P0.2	0.8	3	48	4
4SCCBN 015 002 040	1.5×P0.2	0.8	4	48	4
4SCCBN 015 003 030	1.5×P0.3	0.8	3	48	4
4SCCBN 015 003 040	1.5×P0.3	0.8	4	48	4
4SCCBN 020 0002 030	2×P0.02	0.9	3	48	4
4SCCBN 020 0002 040	2×P0.02	0.9	4	50	4
4SCCBN 020 0002 060	2×P0.02	0.9	6	50	4
4SCCBN 020 0005 030	2×P0.05	0.9	3	50	4
4SCCBN 020 0005 040	2×P0.05	0.9	4	50	4
4SCCBN 020 0005 060	2×P0.05	0.9	6	50	4
4SCCBN 020 001 030	2×P0.1	0.9	3	50	4
4SCCBN 020 001 040	2×P0.1	0.9	4	50	4
4SCCBN 020 001 060	2×P0.1	0.9	6	50	4
4SCCBN 020 002 030	2×P0.2	0.9	3	50	4
4SCCBN 020 002 040	2×P0.2	0.9	4	50	4
4SCCBN 020 002 060	2×P0.2	0.9	6	50	4
4SCCBN 020 003 030	2×P0.3	0.9	3	50	4
4SCCBN 020 003 040	2×P0.3	0.9	4	50	4
4SCCBN 020 003 060	2×P0.3	0.9	6	50	4
4SCCBN 020 005 030	2×P0.5	0.9	3	50	4
4SCCBN 020 005 030	2×P0.5	0.9	4	50	4
4SCCBN 020 005 040	2×P0.5	0.9	6	50	4
4SCCBN 020 005 060	2×P0.5	0.9	6	50	4
4SCCBN 025 001 060	2.5×P0.1	1.2	6	66	6
4SCCBN 025 002 060	2.5×P0.2	1.2	6	66	6
4SCCBN 025 003 060	2.5×P0.3	1.2	6	66	6
4SCCBN 030 001 060	3×P0.1	1.2	6	66	6
4SCCBN 030 001 100	3×P0.1	1.2	10	66	6
4SCCBN 030 002 060	3×P0.2	1.2	6	66	6
4SCCBN 030 002 100	3×P0.2	1.2	10	66	6

Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
4SCCBN 030 003 060	3×P0.3	1.2	6	66	6
4SCCBN 030 003 100	3×P0.5	1.2	10	66	6
4SCCBN 030 005 060	3×P0.5	1.2	6	66	6
4SCCBN 030 005 100	3×P0.5	1.2	10	66	6
4SCCBN 030 005 160	3×P1	1.2	16	66	6
4SCCBN 030 010 060	3×P1	1.2	6	66	6
4SCCBN 030 010 100	3×P1	1.2	10	66	6
4SCCBN 030 010 160	4×P0.1	1.2	16	66	6
4SCCBN 040 001 060	4×P0.1	1.5	6	66	6
4SCCBN 040 001 100	4×P0.1	1.5	10	66	6
4SCCBN 040 001 160	4×P0.2	1.5	16	66	6
4SCCBN 040 002 060	4×P0.2	1.5	6	66	6
4SCCBN 040 002 100	4×P0.2	1.5	10	66	6
4SCCBN 040 002 160	4×P0.3	1.5	16	66	6
4SCCBN 040 003 060	4×P0.3	1.5	6	66	6
4SCCBN 040 003 100	4×P0.3	1.5	10	66	6
4SCCBN 040 003 160	4×P0.5	1.5	16	66	6
4SCCBN 040 005 060	4×P0.5	1.5	6	66	6
4SCCBN 040 005 100	4×P0.5	1.5	10	66	6
4SCCBN 040 005 160	4×P1	1.5	16	66	6
4SCCBN 040 010 060	4×P1	1.5	6	66	6
4SCCBN 040 010 100	4×P1	1.5	10	66	6
4SCCBN 040 010 160	4×P1	1.5	16	66	6
4SCCBN 060 003 030	6×P0.3	3	–	83	6
4SCCBN 060 003 150	6×P0.3	3	15	83	6
4SCCBN 060 005 030	6×P0.5	3	–	83	6
4SCCBN 060 005 150	6×P0.5	3	15	83	6
4SCCBN 060 010 030	6×P1	3	–	83	6
4SCCBN 060 010 150	6×P1	3	15	83	6

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