

	P N/mm ²	N N/mm ²
125030	<850	铝-600 铜, 黄铜
vc = m/min.		
125030	8-15	14-20 15-30

HSS-Co
H7
DIN 212
Anschnittform
F/E
Linksdrill
45°
Zylinderschaft

应用:
适用于加工加长材料的通孔。
不适合加工盲孔
螺旋排屑槽利于有效排屑
≦ Ø 3,00 mm 两端带定心顶尖
≧ Ø 4,00 mm 带中心孔



125030 PRECITOOL, 钴高速钢

d ₁ (H7) mm	125030 (RG 1200)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	f mm/U
1,0	○	34	5,5	15	1,0	0,100-0,160
1,5	○	40	8	18	1,5	0,100-0,160
2,0	○	49	11	24	2,0	0,100-0,160
2,5	○	57	14	28	2,5	0,100-0,160
3,0	○	61	15	32	3,0	0,100-0,160
4,0	●	75	19	43	4,0	0,100-0,160
5,0	●	86	23	52	5,0	0,100-0,200
6,0	●	93	26	57	5,6	0,100-0,200

d ₁ (H7) mm	125030 (RG 1200)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	f mm/U
7,0	○	109	31	69	7,1	0,100-0,200
8,0	●	117	33	75	8,0	0,100-0,200
9,0	○	125	36	81	9,0	0,100-0,200
10,0	●	133	38	87	10,0	0,100-0,200
12,0	●	151	44	105	10,0	0,200-0,300
14,0	○	160	47	110	12,5	0,200-0,300
15,0	○	162	50	112	12,5	0,200-0,300
16,0	○	170	52	120	12,5	0,200-0,300

机用绞刀

	P N/mm ²	K HB	N N/mm ²
125050	<1000	<200	铜, 黄铜
vc = m/min.			
125050	8-15	10-14	15-30

HSS-Co
TiN
H7
DIN 212
Anschnittform
D
Linksdrill
Zylinderschaft



125050 PRECITOOL, 钴高速钢, TiN涂层

d ₁ (H7) mm	125050 (RG 1200)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	f mm/U
4,0	●	75	19	43	4,0	0,100-0,160
5,0	●	86	23	52	5,0	0,100-0,200
6,0	●	93	26	57	5,6	0,100-0,200
7,0	○	109	31	69	7,1	0,100-0,200
8,0	●	117	33	75	8,0	0,100-0,200
9,0	○	125	36	81	9,0	0,100-0,200
10,0	●	133	38	87	10,0	0,100-0,200

d ₁ (H7) mm	125050 (RG 1200)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	f mm/U
11,0	○	142	41	96	10,0	0,100-0,200
12,0	●	151	44	105	10,0	0,200-0,300
13,0	○	151	44	105	10,0	0,200-0,300
14,0	●	160	47	110	12,5	0,200-0,300
15,0	○	162	50	112	12,5	0,200-0,300
16,0	●	170	52	120	12,5	0,200-0,300
—	—	—	—	—	—	—

	P N/mm ²	K HB	N N/mm ²	
125100	<850	<150	铝<600	钢, 黄铜
vc = m/min.				
125100	8-15	10-14	14-20	15-30



技术说明:

- 带有平直刀柄, ≤Ø 3,75 mm 两端带中心定位顶尖
- ≥Ø3,76 mm 两端带中心孔

制造公差Ø 和 1/10 尺寸适用于绞孔公差 H 7
1/100 尺寸

公称尺寸 0,95 至 5,50 mm = +0,004/0
公称尺寸 5,51 至 12,00 mm = +0,005/0

应用:

液压夹头或者高精度筒夹由于朝切削方向排屑, 适用于通孔加工
左旋结构适合加工盲孔



125100 PRECITOOL, 钴高速钢, 带平直刀柄

d ₁ mm	125100 (RG 1270)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ (h ₆) mm	f mm/U	d ₁ mm	125100 (RG 1270)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ (h ₆) mm	f mm/U	d ₁ mm	125100 (RG 1270)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ (h ₆) mm	f mm/U
1	●	34	5,5	15	2,0	0,100-0,160	4,02	●	75	19	43	4,0	0,100-0,160	7,9	○	117	33	75	8,0	0,100-0,200
1,01	○	34	5,5	15	2,0	0,100-0,160	4,1	●	75	19	43	4,0	0,100-0,160	7,97	●	117	33	75	8,0	0,100-0,200
1,02	○	34	5,5	15	2,0	0,100-0,160	4,2	●	80	21	43	4,0	0,100-0,160	7,98	●	117	33	75	8,0	0,100-0,200
1,5	●	40	8	18	2,0	0,100-0,160	4,3	●	80	21	47	4,0	0,100-0,160	7,99	●	117	33	75	8,0	0,100-0,200
1,51	○	43	9	20	2,0	0,100-0,160	4,4	○	80	21	47	5,0	0,100-0,160	8	●	117	33	75	8,0	0,100-0,200
1,52	○	43	9	20	2,0	0,100-0,160	4,5	●	80	21	47	5,0	0,100-0,160	8,01	●	117	33	75	8,0	0,100-0,200
1,6	○	43	9	20	2,0	0,100-0,160	4,6	●	80	21	47	5,0	0,100-0,160	8,02	●	117	33	75	8,0	0,100-0,200
1,7	○	43	9	20	2,0	0,100-0,160	4,7	○	80	21	47	5,0	0,100-0,160	8,1	●	117	33	75	8,0	0,100-0,200
1,8	○	46	10	22	2,0	0,100-0,160	4,8	●	86	23	52	5,0	0,100-0,160	8,2	●	117	33	75	8,0	0,100-0,200
1,9	○	46	10	22	2,0	0,100-0,160	4,9	●	86	23	52	5,0	0,100-0,160	8,3	○	117	33	75	8,0	0,100-0,200
1,97	○	49	11	24	2,0	0,100-0,160	4,97	●	86	23	52	5,0	0,100-0,160	8,4	○	117	33	75	8,0	0,100-0,200
1,98	●	49	11	24	2,0	0,100-0,160	4,98	●	86	23	52	5,0	0,100-0,160	8,5	●	117	33	75	8,0	0,100-0,200
1,99	●	49	11	24	2,0	0,100-0,160	4,99	●	86	23	52	5,0	0,100-0,160	8,6	○	117	33	81	8,0	0,100-0,200
2	●	49	11	24	2,0	0,100-0,160	5	●	86	23	52	5,0	0,100-0,200	8,7	○	125	36	81	10,0	0,100-0,200
2,01	●	49	11	24	2,0	0,100-0,160	5,01	●	86	23	52	5,0	0,100-0,200	8,8	●	125	36	81	10,0	0,100-0,200
2,02	●	49	11	24	2,0	0,100-0,160	5,02	●	86	23	52	5,0	0,100-0,200	8,9	○	125	36	81	10,0	0,100-0,200
2,1	●	49	11	24	2,0	0,100-0,160	5,1	●	86	23	52	5,0	0,100-0,200	9	●	125	36	81	10,0	0,100-0,200
2,2	○	53	12	26	3,0	0,100-0,160	5,2	●	86	23	52	5,0	0,100-0,200	9,01	○	125	36	81	10,0	0,100-0,200
2,3	●	53	12	26	3,0	0,100-0,160	5,3	○	86	23	52	5,0	0,100-0,200	9,02	○	125	36	81	10,0	0,100-0,200
2,4	●	57	14	28	3,0	0,100-0,160	5,4	○	93	26	57	6,0	0,100-0,200	9,1	○	125	36	81	10,0	0,100-0,200
2,48	○	57	14	28	3,0	0,100-0,160	5,5	●	93	26	57	6,0	0,100-0,200	9,2	○	125	36	81	10,0	0,100-0,200
2,49	○	57	14	28	3,0	0,100-0,160	5,6	○	93	26	57	6,0	0,100-0,200	9,3	○	125	36	81	10,0	0,100-0,200
2,5	●	57	14	28	3,0	0,100-0,160	5,7	○	93	26	57	6,0	0,100-0,200	9,4	○	125	36	81	10,0	0,100-0,200
2,51	○	57	14	28	3,0	0,100-0,160	5,8	○	93	26	57	6,0	0,100-0,200	9,5	○	125	36	81	10,0	0,100-0,200
2,52	●	57	14	28	3,0	0,100-0,160	5,9	○	93	26	57	6,0	0,100-0,200	9,6	●	125	36	87	10,0	0,100-0,200
2,6	●	57	14	28	3,0	0,100-0,160	5,97	●	93	26	57	6,0	0,100-0,200	9,7	○	133	38	87	10,0	0,100-0,200
2,7	●	61	15	32	3,0	0,100-0,160	5,98	●	93	26	57	6,0	0,100-0,200	9,8	○	133	38	87	10,0	0,100-0,200
2,8	●	61	15	32	3,0	0,100-0,160	5,99	●	93	26	57	6,0	0,100-0,200	9,9	○	133	38	87	10,0	0,100-0,200
2,9	○	61	15	32	3,0	0,100-0,160	6	●	93	26	57	6,0	0,100-0,200	9,97	●	133	38	87	10,0	0,100-0,200
2,97	●	61	15	32	3,0	0,100-0,160	6,01	●	93	26	63	6,0	0,100-0,200	9,98	●	133	38	87	10,0	0,100-0,200
2,98	●	61	15	32	3,0	0,100-0,160	6,02	●	93	26	63	6,0	0,100-0,200	9,99	●	133	38	87	10,0	0,100-0,200
2,99	●	61	15	32	3,0	0,100-0,160	6,1	●	93	26	63	6,0	0,100-0,200	10	●	133	38	87	10,0	0,100-0,200
3	●	61	15	32	3,0	0,100-0,160	6,2	●	101	28	63	6,0	0,100-0,200	10,01	●	133	38	87	10,0	0,100-0,200
3,01	●	65	16	35	4,0	0,100-0,160	6,3	●	101	28	63	6,0	0,100-0,200	10,02	●	133	38	87	10,0	0,100-0,200
3,02	●	65	16	35	4,0	0,100-0,160	6,4	●	101	28	63	6,0	0,100-0,200	11	○	142	41	96	10,0	0,100-0,200
3,1	●	65	16	35	4,0	0,100-0,160	6,5	●	101	28	63	6,0	0,100-0,200	11,97	○	151	44	105	10,0	0,100-0,200
3,2	●	65	16	35	4,0	0,100-0,160	6,6	●	101	28	63	6,0	0,100-0,200	11,98	●	151	44	105	10,0	0,100-0,200
3,3	○	65	16	35	4,0	0,100-0,160	6,7	○	101	28	63	6,0	0,100-0,200	11,99	●	151	44	105	10,0	0,100-0,200
3,4	●	70	18	40	4,0	0,100-0,160	6,8	○	109	31	69	8,0	0,100-0,200	12	●	151	44	105	10,0	0,200-0,300
3,5	●	70	18	40	4,0	0,100-0,160	6,9	○	109	31	69	8,0	0,100-0,200	13	●	151	44	105	10,0	0,200-0,300
3,6	○	70	18	40	4,0	0,100-0,160	7	●	109	31	69	8,0	0,100-0,200	14	●	160	47	110	14,0	0,200-0,300
3,7	●	70	18	40	4,0	0,100-0,160	7,1	○	109	31	69	8,0	0,100-0,200	15	●	162	50	112	14,0	0,200-0,300
3,8	●	75	19	43	4,0	0,100-0,160	7,2	○	109	31	69	8,0	0,100-0,200	16	●	170	52	120	14,0	0,200-0,300
3,9	○	75	19	43	4,0	0,100-0,160	7,3	○	109	31	69	8,0	0,100-0,200	17	●	175	54	123	14,0	0,200-0,300
3,97	○	75	19	43	4,0	0,100-0,160	7,4	○	109	31	69	8,0	0,100-0,200	18	●	182	56	130	14,0	0,200-0,300
3,98	●	75	19	43	4,0	0,100-0,160	7,5	●	109	31	69	8,0	0,100-0,200	19	○	189	58	131	16,0	0,200-0,300
3,99	●	75	19	43	4,0	0,100-0,160	7,6	○	109	31	75	8,0	0,100-0,200	20	●	195	60	137	16,0	0,200-0,300
4	●	75	19	43	4,0	0,100-0,160	7,7	○	117	33	75	8,0	0,100-0,200	-	-	-	-	-	-	-
4,01	●	75	19	43	4,0	0,100-0,160	7,8	○	117	33	75	8,0	0,100-0,200	-	-	-	-	-	-	-

● = 德国中央仓库库存
○ = 德国工厂仓库供货

技术说明:

- 套装包含10把NC绞刀 125100
左旋螺旋槽 Ø 1,5 | 2,0 | 3,0 | 4,0 | 5,0 | 6,0 | 7,0 | 8,0 | 10,0 | 12,0 mm H7

应用:

液压夹头或者高精度筒夹
由于朝切削方向排屑, 适用于通孔加工
左旋结构适合加工盲孔

供货:

塑料工具箱

HSS-Co	H7	类似 DIN 212	Anschlitt- form B	Linksdrill 	Zylinder- schaft 
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125130 PRECITOOL, 钴高速钢

Ø-范围mm	125130 (RG 1270)
1,5-12,0	●

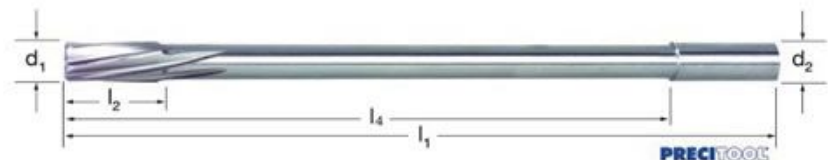
机用绞刀

	P N/mm ²	K HB	N N/mm ²	
125200	<850	<150	铝 <600	铝 <600
vc = m/min.				
125200	8-15	10-14	14-20	14-20

HSS-Co	H7	DIN 212	Anschlitt- form B	Linksdrill 10' 	Zylinder- schaft 
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应用:

尤其适合施工用, 绞深孔或者难加工孔



125200 PRECITOOL, 钴高速钢, 长型

d ₁ (H7) mm	125200 (RG 1203)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ (h8) mm	f mm/U	d ₁ (H7) mm	125200 (RG 1203)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ (h8) mm	f mm/U
1,5	○	55	12	35	1,5	0,100-0,160	6,5	●	130	16	100	6	0,100-0,200
2,0	●	65	14	45	2	0,100-0,160	7,0	●	140	18	110	7	0,100-0,200
2,5	●	75	14	55	2,5	0,100-0,160	8,0	●	160	18	130	8	0,100-0,200
3,0	●	90	14	70	3	0,100-0,160	9,0	○	175	18	140	9	0,100-0,200
4,0	●	105	16	80	4	0,100-0,160	10,0	●	175	20	150	10	0,100-0,200
5,0	●	115	16	90	5	0,100-0,200	12,0	●	210	20	160	12	0,100-0,200
6,0	●	130	16	100	6	0,100-0,200	-	-	-	-	-	-	-

机用绞刀

	P N/mm ²	K HB	N N/mm ²	
125300	<850	<500	铝 <600	钢, 黄铜
vc = m/min.				
125300	8-15	Auf Anfrage	14-20	15-30

HSS-Co	H7	DIN 212	Anschlitt- form B	Linksdrill 10' 	Zylinder- schaft 
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应用:

尤其适合施工用, 绞深孔或者难加工孔.



125300 PRECITOOL, 钴高速钢, 超长型

d ₁ (H7) mm	125300 (RG 1203)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ (h8) mm	f mm/U	d ₁ (H7) mm	125300 (RG 1203)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ (h8) mm	f mm/U
3,0	○	120	30	100	3	0,100-0,160	6,0	●	250	35	220	6	0,100-0,200
4,0	○	160	30	135	4	0,100-0,160	8,0	●	250	35	220	8	0,100-0,200
5,0	○	200	30	175	5	0,100-0,200	10,0	●	250	35	220	10	0,100-0,200

	P N/mm ²	K HB	N N/mm ²	
125500	<850	<150	铝 <600	钢, 黄铜
vc = m/min.				
125500	8-15	10-14	14-20	15-30



应用:
绞装配孔, 公差在H7之外
Ø ≤ 3,75 mm 两端中心定位顶尖
Ø ≥ 3,76 mm 带中心孔和夹持柄

制造公差:
Ø 0,95- 5,50 +0,004/0
Ø 5,51-12,05 +0,005/0



125500 PRECITOOL, 钴高速钢, 1/100 上升

d ₁ mm (0,01 stgd.)	125500 (RG 1200)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	f mm/U
0,95 - 1,06	○	34	5,5	15	1,0	0,100-0,160
1,07 - 1,18	○	36	6,5	15,5	1,1	0,100-0,160
1,19 - 1,32	○	38	7,5	16,5	1,2	0,100-0,160
1,33 - 1,39	○	40	8	18	1,4	0,100-0,160
1,40 - 1,41	●	40	8	18	1,4	0,100-0,160
1,42 - 1,49	○	40	8	18	1,5	0,100-0,160
1,50 - 1,70	●	40	8	18	1,5	0,100-0,160
1,71 - 1,90	○	46	10	22	1,8	0,100-0,160
1,91 - 1,99	○	49	11	24	2,0	0,100-0,160
2,00 - 2,09	●	49	11	24	2,0	0,100-0,160
2,10 - 2,12	●	49	11	24	2,0	0,100-0,160
2,13 - 2,36	○	53	12	26	2,2	0,100-0,160
2,37 - 2,49	○	57	14	28	2,5	0,100-0,160
2,50 - 2,59	●	57	14	28	2,5	0,100-0,160
2,60 - 2,65	●	57	14	28	2,5	0,100-0,160
2,66 - 2,80	○	61	15	32	2,8	0,100-0,160
2,81 - 2,99	●	61	15	32	3,0	0,100-0,160
3,00 - 3,09	●	61	15	32	3,0	0,100-0,160
3,10 - 3,35	○	65	16	35	3,2	0,100-0,160
3,36 - 3,49	○	70	18	40	3,5	0,100-0,160
3,50 - 3,59	●	70	18	40	3,5	0,100-0,160
3,60 - 3,75	●	70	18	40	3,5	0,100-0,160

d ₁ mm (0,01 stgd.)	125500 (RG 1200)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	f mm/U
3,76 - 3,81	○	75	19	43	4,0	0,100-0,160
3,82 - 4,20	○	75	19	43	4,0	0,100-0,160
4,21 - 4,25	○	75	19	43	4,0	0,100-0,160
4,26 - 4,75	○	80	21	47	4,5	0,100-0,160
4,76 - 5,20	○	86	23	52	5,0	0,100-0,160
5,21 - 5,30	○	86	23	52	5,0	0,100-0,200
5,31 - 5,50	○	93	26	57	5,6	0,100-0,200
5,51 - 5,60	○	93	26	57	5,6	0,100-0,200
5,61 - 6,00	○	93	26	57	5,6	0,100-0,200
6,01 - 6,11	●	101	28	63	6,3	0,100-0,200
6,12 - 6,70	○	101	28	63	6,3	0,100-0,200
6,71 - 7,20	○	109	31	69	7,1	0,100-0,200
7,21 - 7,50	○	109	31	69	7,1	0,100-0,200
7,51 - 8,20	○	117	33	75	8,0	0,100-0,200
8,21 - 8,50	○	117	33	75	8,0	0,100-0,200
8,51 - 9,20	○	125	36	81	9,0	0,100-0,200
9,21 - 9,50	○	125	36	81	9,0	0,100-0,200
9,52 - 10,20	●	133	38	87	10,0	0,100-0,200
10,21 - 10,60	○	133	38	87	10,0	0,100-0,200
10,61 - 11,20	○	142	41	96	10,0	0,100-0,200
11,21 - 11,80	○	142	41	96	10,0	0,100-0,200
11,81 - 12,05	○	151	44	105	10,0	0,100-0,200

	P N/mm ²	K HB	N N/mm ²	
128000	<850	<150	铝 <600	钢, 黄铜
vc = m/min.				
128000	8-15	10-14	14-20	15-30



应用:
绞通孔



128000 PRECITOOL, 钴高速钢, 带莫氏刀杆

d ₁ (H7) mm	128000 (RG 1200)	l ₁ mm	l ₂ mm	l ₄ mm	MK	f mm/U
5,0	●	133	23	67,5	1	0,100-0,200
6,0	●	138	26	72,5	1	0,100-0,200
7,0	○	150	31	84,5	1	0,100-0,200
8,0	●	156	33	90,5	1	0,100-0,200
9,0	○	162	36	96,5	1	0,100-0,200
10,0	●	168	38	102,5	1	0,100-0,200
11,0	●	175	41	109,5	1	0,100-0,200
12,0	●	182	44	116,5	1	0,200-0,300
13,0	●	182	44	116,5	1	0,200-0,300
14,0	●	189	47	123,5	1	0,200-0,300
15,0	●	204	50	124	2	0,200-0,300
16,0	●	210	52	130	2	0,200-0,300
17,0	●	214	54	134	2	0,200-0,300
18,0	●	219	56	139	2	0,200-0,300
19,0	●	223	58	143	2	0,200-0,300
20,0	●	228	60	148	2	0,200-0,300
21,0	●	232	62	152	2	0,200-0,300
22,0	●	237	64	157	2	0,200-0,300

d ₁ (H7) mm	128000 (RG 1200)	l ₁ mm	l ₂ mm	l ₄ mm	MK	f mm/U
23,0	●	241	66	161	2	0,200-0,300
24,0	●	368	68	169	3	0,200-0,300
25,0	●	268	68	169	3	0,200-0,300
26,0	●	273	70	174	3	0,200-0,300
27,0	●	277	71	178	3	0,200-0,300
28,0	●	277	71	178	3	0,200-0,300
29,0	○	281	73	182	3	0,200-0,300
30,0	●	281	73	182	3	0,300-0,500
32,0	●	317	77	193	4	0,300-0,500
34,0	●	321	78	197	4	0,300-0,500
35,0	●	321	78	197	4	0,300-0,500
36,0	●	325	79	201	4	0,300-0,500
38,0	●	329	81	205	4	0,300-0,500
40,0	●	329	81	205	4	0,300-0,500
42,0	●	333	82	209	4	0,300-0,500
45,0	●	336	83	212	4	0,300-0,500
48,0	○	344	86	220	4	0,300-0,500
50,0	●	344	86	220	4	0,300-0,500

● = 德国中央仓库库存
○ = 德国工厂仓库供货

	P N/mm ²	K HB	N N/mm ²	
128200	<850	<150	铝 <600	铜, 黄铜
vc = m/min.				
128200	8-15	10-14	14-20	15-30



应用:
尤其适合刀具和施工用, 绞深孔或者难加工孔。



128200 PRECITOOL, 钴高速钢, 长型, 带莫氏锥形刀杆

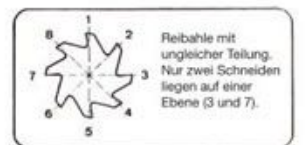
d ₁ (H7) mm	128200 (RG 1203)	l ₁ mm	l ₂ mm	l ₄ mm	MK	f mm/U
13,0	○	245	22	180	1	0,200-0,350
14,0	●	245	22	180	1	0,200-0,350
15,0	●	260	22	180	2	0,200-0,350
16,0	●	260	25	180	2	0,200-0,350
18,0	○	260	25	180	2	0,200-0,350
20,0	●	270	28	190	2	0,200-0,350
22,0	○	280	28	200	2	0,200-0,350
24,0	○	300	32	200	3	0,200-0,350
25,0	●	320	32	200	3	0,200-0,350
26,0	○	330	32	200	3	0,200-0,350

d ₁ (H7) mm	128200 (RG 1203)	l ₁ mm	l ₂ mm	l ₄ mm	MK	f mm/U
28,0	○	340	32	240	3	0,200-0,350
30,0	○	350	36	250	3	0,300-0,500
32,0	○	375	36	250	4	0,300-0,500
34,0	○	375	36	250	4	0,300-0,500
36,0	○	375	40	250	4	0,300-0,500
38,0	○	395	40	270	4	0,300-0,500
40,0	○	395	40	270	4	0,300-0,500
42,0	○	405	40	280	4	0,300-0,500
45,0	○	405	45	280	4	0,300-0,500
50,0	○	415	45	290	4	0,300-0,500

	P N/mm ²	K HB	N N/mm ²	
128540	<1200	<300	铜, 黄铜, 铝<600	塑料
vc = m/min.				
128540	8-20	10-20	20-60	10-50



应用:
带硬质合金K10刀片, 用于加工高磨损性材料, 例如: 灰口铸铁, 硬铸铁, 有色金属, 塑料等等, 硬质合金绞刀保证尺寸精度前提条件: 稳定, 主轴精密的机床



128540 PRECITOOL, 整体硬质合金, 带莫氏锥形刀杆

d ₁ (H7) mm	128540 (RG 1230)	l ₁ mm	l ₂ mm	l ₄ mm	MK	f mm/U
10,0	●	168	38	102,5	1	0,150-0,200
12,0	●	182	44	116,5	1	0,200-0,300
14,0	●	189	47	123,5	1	0,200-0,300
15,0	●	204	50	124	2	0,200-0,300
16,0	●	210	52	130	2	0,200-0,400
17,0	○	214	54	134	2	0,200-0,400
18,0	●	219	56	139	2	0,200-0,400
19,0	○	223	58	143	2	0,200-0,400

d ₁ (H7) mm	128540 (RG 1230)	l ₁ mm	l ₂ mm	l ₄ mm	MK	f mm/U
20,0	●	228	60	148	2	0,200-0,400
22,0	●	237	64	157	2	0,200-0,400
24,0	●	268	68	169	3	0,200-0,400
25,0	●	268	68	169	3	0,200-0,400
26,0	●	273	70	174	3	0,200-0,400
30,0	●	281	73	182	3	0,200-0,400
40,0	○	329	81	205	4	0,5
-	-	-	-	-	-	-

	P N/mm ²	K HB	N N/mm ²	
125600	<1200	<300	铝 <600	铜, 黄铜
vc = m/min.				
125600	8-20	10-20	20-60	25-50



技术说明/应用:

- 硬质合金高精度绞刀, 直径d1分度尺寸0.01mm
- ≥ Ø 7,56 mm 带焊接硬质合金刀头
- 表面光亮
- 左旋, 右向
- 加工通孔
- d2 适用于 Ø 0,95-3,75 mm = d1 - 0,05 mm

制造公差:

- ≤ Ø 3,00: 0/+0,003
- Ø 3 < 且 ≤ Ø 6,00: 0/+0,004
- ≥ Ø 6,01: 0/+0,005



125600 PRECITOOL, 整体硬质合金, 1/100 分度尺寸

d ₁ mm (0,01 stgd.)	125600 (RG 1203)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	f mm/U
0,95 - 1,05	○	33	7	10	—	0,100-0,160
1,06 - 1,44	○	40	10	24	—	0,100-0,160
1,45 - 1,55	○	40	10	24	—	0,100-0,160
1,56 - 1,94	○	50	11	31	—	0,100-0,160
1,95 - 2,05	○	50	11	31	—	0,100-0,160
2,06 - 2,38	○	50	11	31	—	0,100-0,160
2,37 - 2,94	○	57	15	38	—	0,100-0,160
2,95 - 3,05	○	57	15	38	—	0,100-0,160
3,06 - 3,35	●	57	15	38	—	0,100-0,160
3,36 - 3,75	○	57	15	38	—	0,100-0,160
3,76 - 4,25	○	75	19	49	4,0	0,100-0,160
4,26 - 4,75	○	80	21	51	4,0	0,100-0,160
4,76 - 5,30	○	86	23	59	5,0	0,100-0,160
5,31 - 5,80	○	93	26	65	5,0	0,100-0,200
5,81 - 5,94	○	101	28	71	6,0	0,100-0,200
5,95 - 6,05	○	101	28	71	6,0	0,100-0,200
6,06 - 6,70	●	101	28	71	6,0	0,100-0,200

d ₁ mm (0,01 stgd.)	125600 (RG 1203)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	f mm/U
6,71 - 7,55	○	109	31	78	7,0	0,100-0,200
7,56 - 7,94	○	117	33	84	8,0	0,100-0,200
7,95 - 8,05	○	117	33	84	8,0	0,100-0,200
8,06 - 8,55	●	117	33	84	8,0	0,100-0,300
8,56 - 9,55	○	125	36	88	9,0	0,100-0,300
9,56 - 9,94	○	133	38	97	10,0	0,100-0,300
9,95 - 10,05	○	133	38	97	10,0	0,100-0,300
10,06 - 11,05	○	133	38	97	10,0	0,100-0,300
11,06 - 11,30	○	151	44	110	12,0	0,100-0,300
11,31 - 11,94	○	151	44	110	12,0	0,100-0,300
11,95 - 12,05	○	151	44	110	12,0	0,100-0,300
12,06 - 13,05	○	151	44	110	12,0	0,200-0,350
13,97 - 14,05	○	160	47	110	14,0	0,200-0,350
14,97 - 15,05	○	162	50	112	14,0	0,200-0,350
15,97 - 16,05	○	170	52	117	16,0	0,200-0,350
17,97 - 18,05	○	182	56	129	16,0	0,200-0,400
19,97 - 20,00	○	195	60	142	16,0	0,200-0,400

	P N/mm ²	K HB	N N/mm ²	
126360	<1200	<300	铝 <600	铜, 黄铜
vc = m/min.				
126360	8-20	10-20	20-60	25-50



应用:

直径至 6,00 mm, 由整体硬质合金构成, 从 7,00 mm 至 16,00 mm 使用整体硬质合金刀头, 大直径带刀片K10. 加工强磨损性材料, 例如: 灰口铸铁, 退火铸, 黄铜, 高强度钢等等. 整体硬质合金具有高切削速度, 硬质合金绞刀能保证尺寸精度.
前提条件: 稳定, 高精度主轴机床



126360 PRECITOOL, 整体硬质合金

d ₁ (H7) mm	126360 (RG 1230)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	Z	f mm/U
1,00	●	34	6	15	1,0	3	0,100-0,160
1,20	●	40	8	16,5	1,2	3	0,100-0,160
1,40	○	40	8	18	1,4	3	0,100-0,160
1,50	●	40	8	18	1,5	3	0,100-0,160
1,80	●	49	11	26	1,6	3	0,100-0,160
2,00	●	49	11	24	2,0	4	0,10-0,160
2,20	○	53	12	30	2,2	4	0,10-0,160
2,50	●	57	14	28	2,5	4	0,10-0,160
2,80	○	61	15	32	2,8	4	0,10-0,160
3,00	●	61	15	30	3,0	6	0,100-0,160
3,20	○	65	16	33	3,2	6	0,100-0,160
3,50	●	70	18	33	3,5	6	0,100-0,160
4,00	●	75	19	44	4,0	6	0,100-0,160
4,50	●	80	21	46	4,5	6	0,100-0,160

d ₁ (H7) mm	126360 (RG 1230)	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	Z	f mm/U
5,00	●	86	23	53	5,0	6	0,100-0,200
6,00	●	93	26	56	5,6	6	0,100-0,200
7,00	●	109	31	69	7,1	6	0,100-0,200
8,00	●	117	33	75	8,0	6	0,100-0,300
9,00	●	125	36	81	9,0	6	0,100-0,300
10,00	●	133	38	87	10,0	6	0,100-0,300
11,00	●	142	41	96	10,0	6	0,100-0,300
12,00	●	151	44	105	10,0	6	0,200-0,350
13,00	●	151	44	105	10,0	6	0,200-0,350
14,00	●	160	47	110	12,5	6	0,200-0,350
15,00	●	162	50	112	12,5	6	0,200-0,350
16,00	●	170	52	120	12,5	6	0,200-0,400
20,00	●	195	60	137	16,0	6	0,200-0,400
—	—	—	—	—	—	—	—

● = 德国中央仓库库存
○ = 德国工厂仓库供货