

	P N/mm <sup>2</sup>	K HB	N N/mm <sup>2</sup>	
121000	<850	<150	铝 <600	钢, 黄铜
vc = m/min.				
121000	8-12	10-14	14-20	15-30

HSS-Co

H7

DIN 219 B

Anschnittform  
B

Aufnahmebohrung  
1:30

Linksdrill  
7°

技术说明:  
内孔锥度1:30, 与121050夹具匹配

应用:  
用于绞通孔, 短切削刃也可用于加工盲孔



121000 PRECITOOL, 钴高速钢

d <sub>1</sub> (H7) mm	121000 (RG 1200)	l <sub>1</sub> mm	l <sub>2</sub> mm	Z	d <sub>2</sub> mm	f mm/U	d <sub>1</sub> (H7) mm	121000 (RG 1200)	l <sub>1</sub> mm	l <sub>2</sub> mm	Z	d <sub>2</sub> mm	f mm/U
25,0	○	45	32	8	13,0	0,200-0,300	40,0	●	56	40	10	19,0	0,300-0,500
26,0	○	45	32	8	13,0	0,200-0,300	42,0	○	56	40	10	19,0	0,300-0,500
28,0	○	45	32	8	13,0	0,200-0,300	44,0	●	63	45	12	22,0	0,300-0,500
30,0	●	45	32	8	13,0	0,300-0,500	45,0	○	63	45	12	22,0	0,300-0,500
32,0	○	50	36	10	16,0	0,300-0,500	50,0	●	63	45	12	22,0	0,300-0,500
34,0	○	50	36	10	16,0	0,300-0,500	52,0	●	71	50	12	27,0	0,300-0,500
35,0	●	50	36	10	16,0	0,300-0,500	55,0	●	71	50	12	27,0	0,300-0,500
36,0	○	56	40	10	19,0	0,300-0,500	60,0	●	71	50	12	27,0	0,300-0,500
38,0	○	56	40	10	19,0	0,300-0,500	—	—	—	—	—	—	—

套式刀杆和配件

技术说明:  
- 锥度1:30 短锥形夹具  
- 带夹持柄和配套螺母  
- 淬火刀杆, 稳定性高

应用:  
匹配套式绞刀 121000

DIN 217

Aufnahme-  
dorn  
1:30

MK-  
Schaft



121050 PRECITOOL, 短型

d <sub>1</sub> mm	121050 (RG 1201)	l <sub>1</sub> mm	l <sub>2</sub> mm	MK
13	●	250	45	3
16	●	261	50	3
19	●	298	56	4
22	●	312	63	4
27	●	359	71	5

121060 PRECITOOL, 夹持柄

121065 PRECITOOL, 配套螺母

121070 PRECITOOL, 垫片弹簧

d <sub>1</sub> mm	121060 (RG 1200)	121065 (RG 1200)	121070 (RG 1200)
13	○	○	○
16	○	○	○
19	○	○	○
22	○	○	○
27	○	○	○

	P N/mm <sup>2</sup>	K HB	N N/mm <sup>2</sup>	
122500	<850	<150	铝 <600	铜, 黄铜
122550				



技术说明:  
 - 高速钢材料  
 - 可调范围大  
 - 利用环规或者千分尺进行微调  
 - 带有锥形截面, 切削刃经过铲磨处理并且进行周边磨。

应用:  
 特别适合修磨, 公差范围灵活, 适合临时测量。122550 备用刀, 使用之前, 需小心清洗刀槽。



122500 BECK, 可调节  
 122550 BECK, 备用刀套装

d <sub>1</sub> mm	122500 (RG 1270)	122550 (RG 1270)	l <sub>1</sub> mm	l <sub>2</sub> mm	a mm
6,4-7,2	●	○	110	32	3,0
7,2-8,0	●	○	110	32	3,4
8-9	●	○	115	34	3,8
9-10	●	○	115	34	4,3
10-11	●	○	115	34	4,9
11-12	●	○	125	35	4,9
12-13,5	●	○	135	41	6,2
13,5-15,5	●	○	146	50	7,0

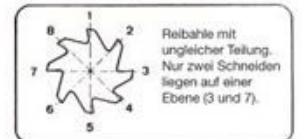
d <sub>1</sub> mm	122500 (RG 1270)	122550 (RG 1270)	l <sub>1</sub> mm	l <sub>2</sub> mm	a mm
15,5-18	●	○	166	60	8,0
18-21	●	○	178	65	9,0
21-24	●	○	195	76	11,0
24-27,5	●	○	218	82	12,0
27,5-31,5	●	○	245	86	14,5
31,5-37	●	○	280	98	18,0
37-45	●	○	325	108	20,0
45-55	●	○	370	118	26,0

	P N/mm <sup>2</sup>	K HB	N N/mm <sup>2</sup>	
123000	<850	<150	铝 <600	铜, 黄铜



技术说明:  
 - 带有左向7° 螺旋和长的切削刃  
 - 带有不等刃距的偶数切削刃, 确保孔的圆度且不会产生振刀纹。

应用:  
 适用于手用或者机床用绞通孔加工。加工受力小, 适合断续加工。



123000 PRECITOOL, 高速钢

d <sub>1</sub> (H7) mm	123000 (RG 1201)	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>4</sub> mm	a mm
2,0	●	50	25	—	1,6
2,5	●	58	29	—	2
3,0	●	62	31	—	2,2
3,5	○	71	35	47	2,8
4,0	●	76	38	50	3,1
4,5	●	81	41	53	3,5
5,0	●	87	44	56	4
5,5	●	93	47	59	4,5
6,0	●	93	47	59	4,6
7,0	●	107	54	66	5,6
8,0	●	115	58	70	6,3
9,0	●	124	62	75	7,1
10,0	●	133	66	80	8
11,0	●	142	71	86	9
12,0	●	152	76	91	10
13,0	●	152	76	91	10
14,0	●	163	81	97	11,2

d <sub>1</sub> (H7) mm	123000 (RG 1201)	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>4</sub> mm	a mm
15,0	●	163	81	97	11,2
16,0	●	175	87	105	12,5
17,0	●	175	87	105	12,5
18,0	●	188	93	112	14
19,0	●	188	93	112	14
20,0	●	201	100	119	16
22,0	●	215	107	129	18
24,0	●	231	115	137	20
25,0	●	231	115	137	20
26,0	○	231	115	137	20
28,0	●	247	124	149	22,4
30,0	●	247	124	149	22,4
32,0	○	265	133	160	25
35,0	○	284	142	169	28
38,0	○	305	152	183	31,5
40,0	●	305	152	183	31,5
—	—	—	—	—	—