

鎳基高溫合金系列

Inconel series

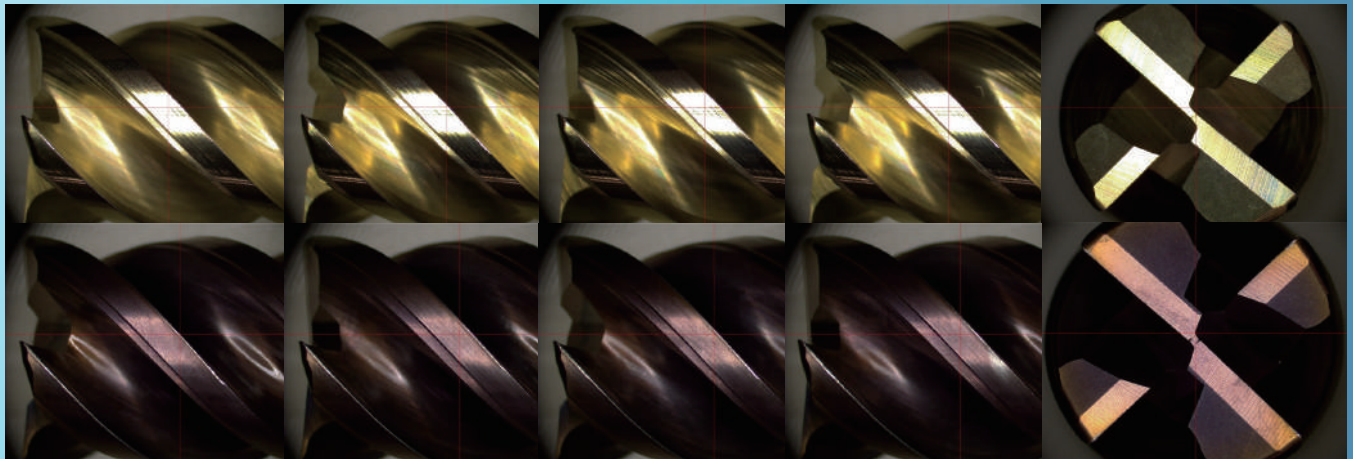
NEW

鎳基高溫合金 系列 Inconel Series

刀具測試比較報告 Tool Test Report

DHF
KSR1205E

European
brand
(S company)



型號 Type NO.	被切削材 Work Material	刀具伸長量 Extension Length	切削速度 Cutting Speed (m/min)	迴轉速度 Speed (min ⁻¹)	進給速度 Feed (mm/min)	加工深度 (Aa) Cut of depth	加工寬度 (Ap) Cut of width	加工方式 Milling Type	鍍層 Coating	冷卻方式 Coolant type	總測試 加工時間 Total test time	壽命 百分比 Tool life
DHF-KSR1205E	Inconel 718	40 mm	55	1500	250	10	0.5	側銑 Side milling	G18	濕式 Wet	120min	100%
European brand (S company)	Inconel 718	40 mm	55	1500	250	10	0.5	側銑 Side milling	X	濕式 Wet	120min	90%

特長介紹 Feature

1. 突破加工<Inconel> 鎳基高溫合金的難題，效能及刀具壽命極佳。
 2. 特殊的工藝設計，刀具剛性良好、於加工中抗震性更加良好。
 3. 複合式的G18新鍍層設計、刀具更耐磨。
 4. 系列產品針對<Inconel> <鎳基高溫合金>加工應用Vc值、可達50 (m/min)以上。
 5. 經DHF應用中心測試對比加工Inconel 718，KSR刀具壽命優於歐洲大品牌。
- I. Overcoming the challenges of machining Inconel and Nickel-based superalloy, with excellent performance and tool life.
 - II. Special geometry design with good rigidity and better vibration resistance during processing.
 - III. The new composite G18 coating design with better wear-resistant.
 - IV. Vc value can reach 50 (m/min) and above, when machining Inconel and nickel-based superalloy.
 - V. After testing Inconel 718 by DHF Application Center, the tool life of <KSR> is better than major European brands.

KSE

Super
mc0.4
μm

48°

4 Flutes

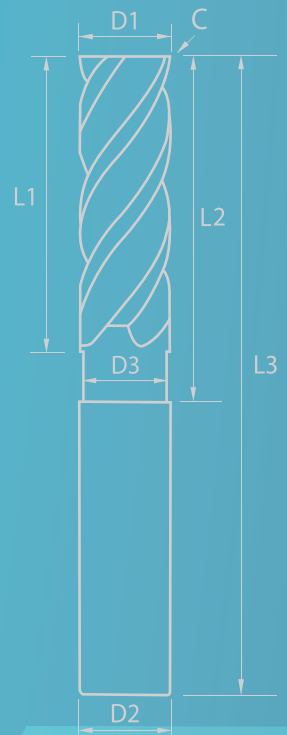
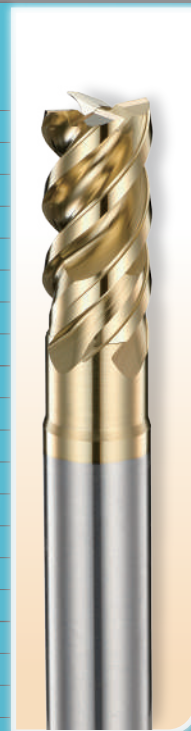
HRC
≥60

G18

Weldon

抗震高效能立銑刀 End Mills

型號 Type No.	D1 直徑 Diameter	D3 頸徑 Neck Dia.	C 倒角 Chamfer	L1 刃長 Flute Length	L2 有效長 Effective Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia	側固 Weldon
KSE0304S	3	3.05	0.035	4	6	50	6	
KSE0304	3	2.85	0.035	8	12	50	6	
KSE0304E	3	2.85	0.035	6	10	57	6	
KSE0404S	4	4.05	0.045	5	9	50	6	
KSE0404	4	3.8	0.045	11	15	50	6	
KSE0404E	4	3.8	0.045	8	13	57	6	
KSE0504S	5	5.05	0.055	7	10	50	6	
KSE0504	5	4.75	0.055	13	18	50	6	
KSE0504E	5	4.75	0.055	10	16	57	6	
KSE0604S	6	X	0.075	8	X	50	6	
KSE0604	6	5.7	0.075	16	20	50	6	
KSE0604E	6	5.7	0.075	12	18	57	6	★
KSE0604L	6	5.7	0.075	21	26	65	6	★
KSE0804S	8	X	0.1	11	X	58	8	
KSE0804	8	7.6	0.1	20	25	60	8	
KSE0804E	8	7.6	0.1	16	25	63	8	★
KSE0804L	8	7.6	0.1	32	37	75	8	★
KSE1004S	10	X	0.125	13	X	58	10	
KSE1004	10	9.5	0.125	25	32	75	10	
KSE1004E	10	9.5	0.125	20	29	72	10	★
KSE1004L	10	9.5	0.125	40	47	89	10	★
KSE1204S	12	X	0.15	15	X	67	12	
KSE1204	12	11.4	0.15	30	35	75	12	
KSE1204E	12	11.4	0.15	24	35	83	12	★
KSE1204L	12	11.4	0.15	45	53	100	12	★
KSE1604S	16	X	0.2	19	X	73	16	
KSE1604	16	15.2	0.2	40	48	100	16	
KSE1604E	16	15.2	0.2	32	42	92	16	★
KSE1604L	16	15.2	0.2	55	65	115	16	★



附註
Note

★標示為含有製作側固
The Star marks refer to be with Weldon flat design.



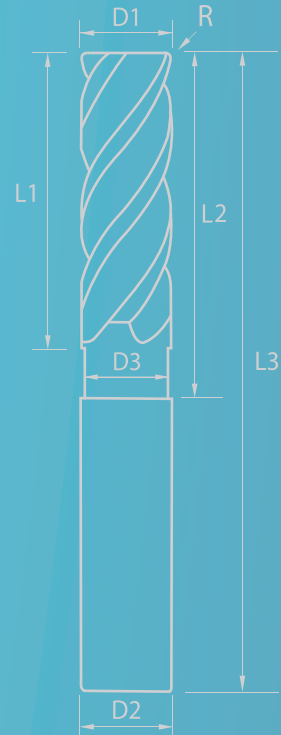
KSR



抗震高效能圓鼻角立銑刀 End Mills

Corner Radius

型號 Type No.	D1 直徑 Diameter	D3 頸徑 Neck Dia.	R R角 Corner R	L1 刃長 Flute Length	L2 有效長 Effective Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia
KSR0302S	3	3.05	0.2	4	6	50	6
KSR0302	3	2.85	0.2	8	12	50	6
KSR0302E	3	2.85	0.2	6	10	57	6
KSR0402S	4	4.05	0.2	5	9	50	6
KSR0402	4	3.8	0.2	11	15	50	6
KSR0402E	4	3.8	0.2	8	13	57	6
KSR0405S	4	4.05	0.5	5	9	50	6
KSR0405	4	3.8	0.5	11	15	50	6
KSR0405E	4	3.8	0.5	8	13	57	6
KSR0502S	5	5.05	0.2	7	10	50	6
KSR0502	5	4.75	0.2	13	18	50	6
KSR0502E	5	4.75	0.2	10	16	57	6
KSR0602S	6	X	0.2	8	X	50	6
KSR0602	6	5.7	0.2	16	20	50	6
KSR0602L	6	5.7	0.2	21	26	65	6
KSR0605S	6	X	0.5	8	X	50	6
KSR0605	6	5.7	0.5	16	20	50	6
KSR0605L	6	5.7	0.5	21	26	65	6
KSR0610	6	5.7	1	16	20	50	6
KSR0610L	6	5.7	1	21	26	65	6
KSR0805S	8	X	0.5	11	X	58	8
KSR0805	8	7.6	0.5	20	25	60	8
KSR0805L	8	7.6	0.5	32	37	75	8
KSR0810	8	7.6	1	20	25	60	8
KSR0810L	8	7.6	1	32	37	75	8
KSR1005S	10	X	0.5	13	X	58	10
KSR1005	10	9.5	0.5	25	32	75	10
KSR1005L	10	9.5	0.5	40	47	89	10
KSR1010S	10	X	1	13	X	58	10
KSR1010	10	9.5	1	25	32	75	10
KSR1010L	10	9.5	1	40	47	89	10
KSR1015	10	9.5	1.5	25	32	75	10
KSR1020	10	9.5	2	25	32	75	10
KSR1020L	10	9.5	2	40	47	89	10
KSR1030	10	9.5	3	25	32	75	10
KSR1030L	10	9.5	3	40	47	89	10
KSR1205S	12	X	0.5	15	X	67	12
KSR1205	12	11.4	0.5	30	35	75	12
KSR1205L	12	11.4	0.5	45	53	100	12
KSR1210S	12	X	1	15	X	67	12
KSR1210	12	11.4	1	30	35	75	12
KSR1210L	12	11.4	1	45	53	100	12
KSR1215	12	11.4	1.5	30	35	75	12
KSR1220	12	11.4	2	30	35	75	12
KSR1220L	12	11.4	2	45	53	100	12
KSR1230	12	11.4	3	30	35	75	12
KSR1230L	12	11.4	3	45	53	100	12
KSR1605S	16	X	0.5	19	X	73	16
KSR1605	16	15.2	0.5	40	48	100	16
KSR1605L	16	15.2	0.5	55	65	115	16
KSR1610S	16	X	1	19	X	73	16
KSR1610	16	15.2	1	40	48	100	16
KSR1610L	16	15.2	1	55	65	115	16
KSR1620	16	15.2	2	40	48	100	16
KSR1620L	16	15.2	2	55	65	115	16
KSR1630	16	15.2	3	40	48	100	16
KSR1630L	16	15.2	3	55	65	115	16



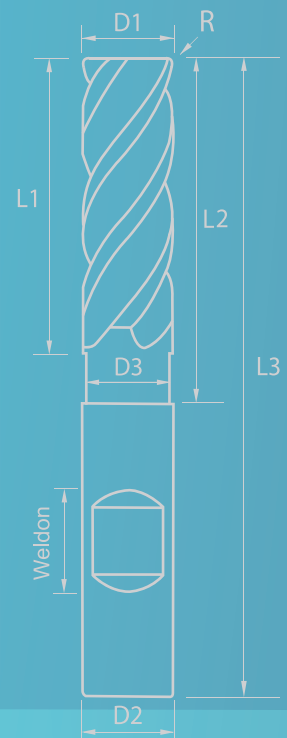
KSR



抗震高效能圓鼻角立銼刀 End Mills

Corner Radius

型號 Type No.	D1 直徑 Diameter	D3 頸徑 Neck Dia.	R R角 Corner R	L1 刃長 Flute Length	L2 有效長 Effective Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia	側固 Weldon
KSR0602E	6	5.7	0.2	12	18	57	6	★
KSR0605E	6	5.7	0.5	12	18	57	6	★
KSR0610E	6	5.7	1	12	18	57	6	★
KSR0805E	8	7.6	0.5	16	25	63	8	★
KSR0810E	8	7.6	1	16	25	63	8	★
KSR1005E	10	9.5	0.5	20	29	72	10	★
KSR1010E	10	9.5	1	20	29	72	10	★
KSR1015E	10	9.5	1.5	20	29	72	10	★
KSR1020E	10	9.5	2	20	29	72	10	★
KSR1030E	10	9.5	3	20	29	72	10	★
KSR1205E	12	11.4	0.5	24	35	83	12	★
KSR1210E	12	11.4	1	24	35	83	12	★
KSR1215E	12	11.4	1.5	24	35	83	12	★
KSR1220E	12	11.4	2	24	35	83	12	★
KSR1230E	12	11.4	3	24	35	83	12	★
KSR1605E	16	15.2	0.5	32	42	92	16	★
KSR1610E	16	15.2	1	32	42	92	16	★
KSR1620E	16	15.2	2	32	42	92	16	★
KSR1630E	16	15.2	3	32	42	92	16	★



附註
Note

★標示為含有製作側固
The Star marks refer to be with Weldon flat design.

X-KSE

Super
MG0.4
μm

48°

4 Flutes

HRC
▶60

G18

抗震高效能立銑刀頭 End Mills

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	C 倒角 Chamfer	D2 頸徑 Neck Dia.	L2 全長 O.A.L.	M 螺牙 Thread Size	鎖固扳手型號 Spanner Type No.
X-KSE0804	8	8	0.1	7.8	12.1	M5-3P	K08
X-KSE1004	10	10	0.125	9.8	16.1	M7-3P	K10
X-KSE1204	12	12	0.15	11.7	20.3	M8-3P	K12
X-KSE1604	16	16	0.2	15.6	25.7	M10-3P	K16
X-KSE2004	20	20	0.25	19.5	31.1	M12-3P	K20
X-KSE2504	25	25	0.3	24.4	39.3	M16-3P	K25



X-KSR

Super
MG0.4
μm

48°

R

4 Flutes

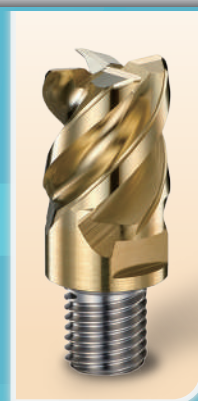
HRC
▶60

G18

抗震高效能圓鼻角立銑刀頭 End Mills

Corner Radius

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	R 圓角 Corner R	D2 頸徑 Neck Dia.	L2 全長 O.A.L.	M 螺牙 Thread Size	鎖固扳手型號 Spanner Type No.
X-KSR0805	8	8	0.5	7.8	12.1	M5-3P	K08
X-KSR0810	8	8	1	7.8	12.1	M5-3P	K08
X-KSR1005	10	10	0.5	9.8	16.1	M7-3P	K10
X-KSR1010	10	10	1	9.8	16.1	M7-3P	K10
X-KSR1015	10	10	1.5	9.8	16.1	M7-3P	K10
X-KSR1020	10	10	2	9.8	16.1	M7-3P	K10
X-KSR1030	10	10	3	9.8	16.1	M7-3P	K10
X-KSR1205	12	12	0.5	11.7	20.3	M8-3P	K12
X-KSR1210	12	12	1	11.7	20.3	M8-3P	K12
X-KSR1220	12	12	2	11.7	20.3	M8-3P	K12
X-KSR1230	12	12	3	11.7	20.3	M8-3P	K12
X-KSR1605	16	16	0.5	15.6	25.7	M10-3P	K16
X-KSR1610	16	16	1	15.6	25.7	M10-3P	K16
X-KSR1620	16	16	2	15.6	25.7	M10-3P	K16
X-KSR1630	16	16	3	15.6	25.7	M10-3P	K16
X-KSR1640	16	16	4	15.6	25.7	M10-3P	K16
X-KSR2005	20	20	0.5	19.5	31.1	M12-3P	K20
X-KSR2010	20	20	1	19.5	31.1	M12-3P	K20
X-KSR2020	20	20	2	19.5	31.1	M12-3P	K20
X-KSR2030	20	20	3	19.5	31.1	M12-3P	K20
X-KSR2040	20	20	4	19.5	31.1	M12-3P	K20

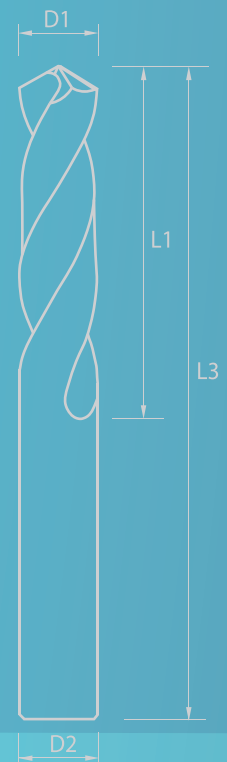


DAN



鎢鋼鑽頭 Carbide Drills

型號 Type No.	D1 直徑 Diameter	L1 刃長 Flute Length	L3 全長 O.A.L.	D2 柄徑 Shank Dia.	公制螺牙鑽孔 尺寸備註
DAN025	2.5	14.3	62	6	O
DAN030	3.0	17.1	62	6	
DAN033	3.3	18.8	62	6	O
DAN035	3.5	20	62	6	
DAN040	4.0	22.8	66	6	
DAN042	4.2	24	66	6	O
DAN045	4.5	25.7	66	6	
DAN050	5.0	28.6	66	6	O
DAN055	5.5	31.4	66	6	
DAN060	6.0	34.3	66	6	
DAN065	6.5	37.1	79	8	
DAN068	6.8	38.8	79	8	O
DAN070	7.0	40	79	8	
DAN080	8.0	45.7	79	8	
DAN085	8.5	48.5	103	10	O
DAN087	8.7	49.7	103	10	
DAN090	9.0	51.4	103	10	
DAN100	10.0	57.1	103	10	
DAN102	10.2	58.2	118	12	O
DAN110	11.0	62.8	118	12	
DAN120	12.0	68.5	118	12	O



註記: O者為公制螺牙鑽孔尺寸
Remark: O refers to metric thread drill size



德信發企業股份有限公司

DHF Precision Tool Co., Ltd.

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鎳基高溫合金系列

Inconel series