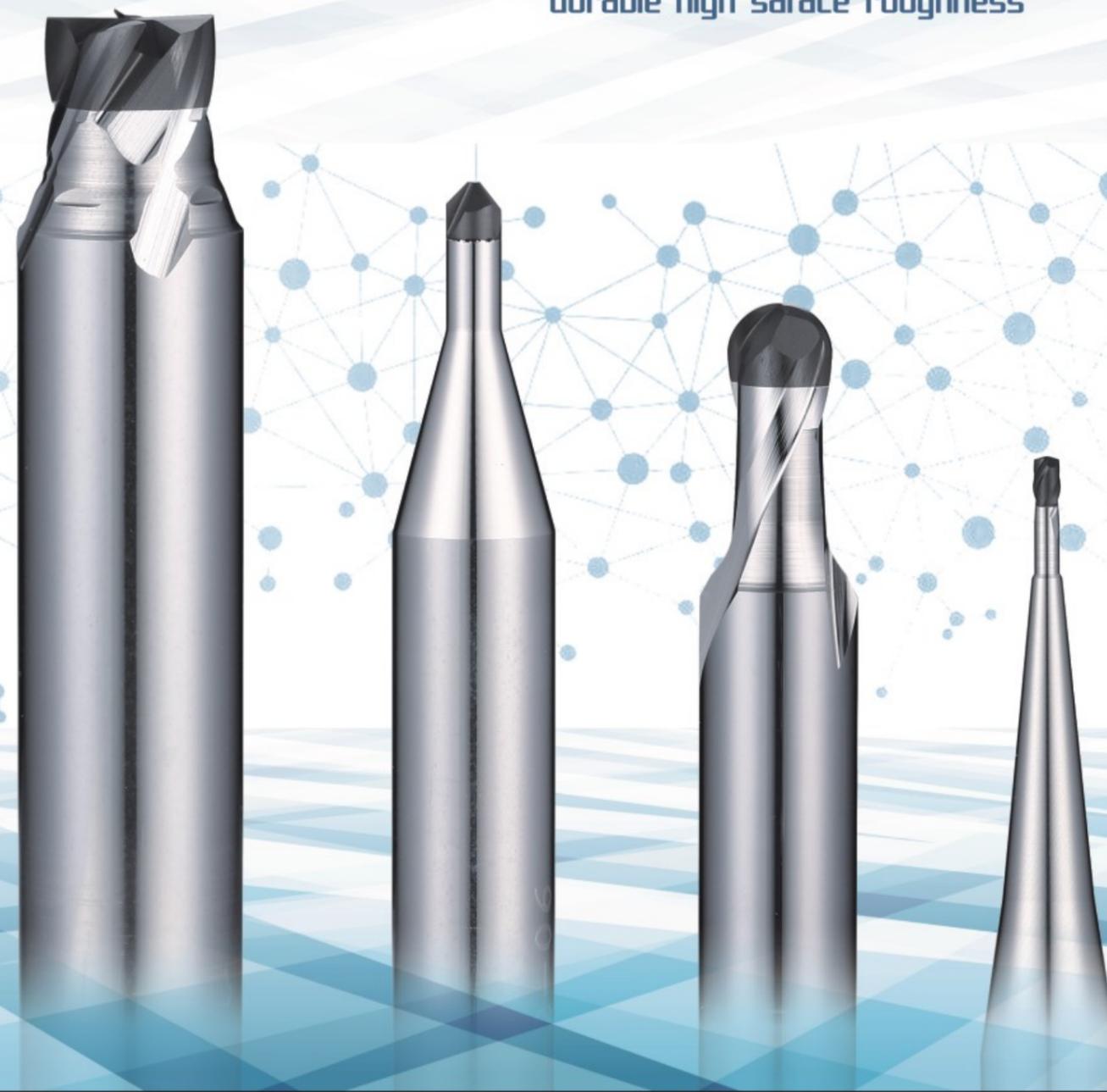


**DOHRE**<sup>®</sup>

**DOHRE**<sup>®</sup>



**CBN**  
*milling cutter*  
durable high surface roughness

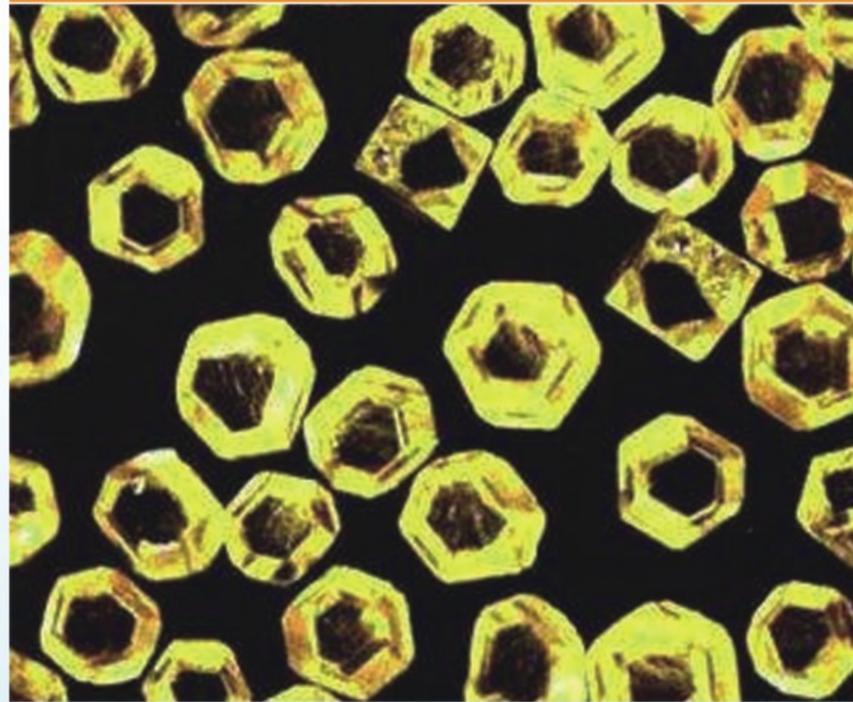
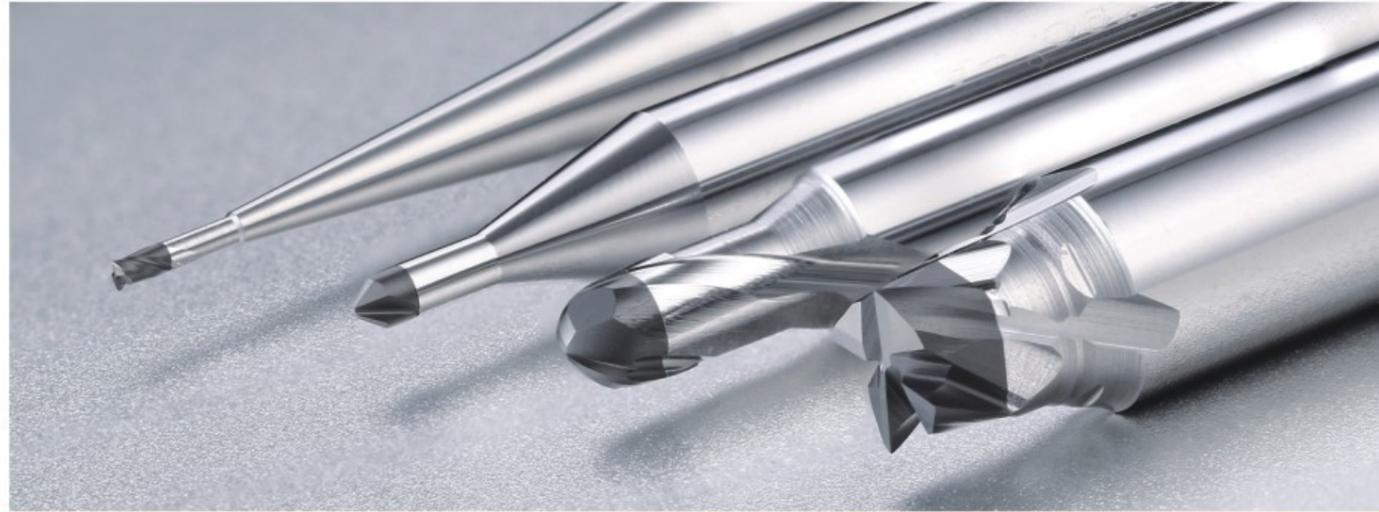


**DOHRE CNC TOOL CO.,LTD**



<http://www.dohrecnc.com>

# 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。

## 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1300-1500°C的高温，甚至在1500°C时也不发生相变，从而保持硬度。CBN与铁系金属的亲合性较低，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。

# Application Case 应用案例



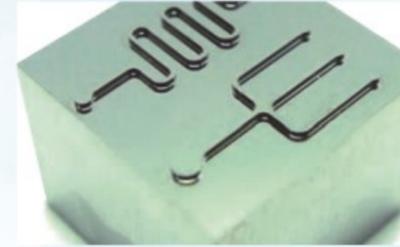
Thin-wall Machining  
薄壁加工



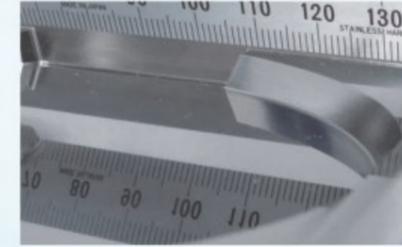
HSS Slice Cutting  
高速钢薄片加工



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。

热喷涂类：Ni基、Fe基两大系列产品及其他一些耐磨、耐腐蚀、耐热喷涂材料。

耐磨铸铁类：V-Ti铸铁、高磷铸铁和冷硬铸铁等。

钛合金类：TC4等

耐热合金的部分工作

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。

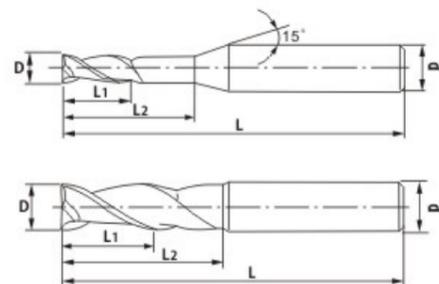


**特点** HRC50~70 淬火钢加工精度 ±5 μm  
 超出寿命  
 高精度表面加工  
 多种刃长可供选择  
 推荐转速20000~50000RPM,油雾冷却  
 CBN

**Feature** PCBN ENDMILL for precise finishing(±5 μm)of hardened steel(HRC50~70).  
 Long tool life by high content PCBN.  
 Excellent surface finish.  
 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

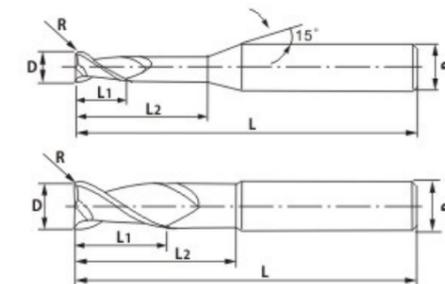
Order Number	Diameter D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2ECBN 012 060 S04	1.2	0.7	6	48	4
2ECBN 012 080 S04	1.2	0.7	8	48	4
2ECBN 012 100 S04	1.2	0.7	10	48	4
2ECBN 012 120 S04	1.2	0.7	12	48	4
2ECBN 012 160 S04	1.2	0.7	16	48	4
2ECBN 015 030 S04	1.5	0.8	3	48	4
2ECBN 015 060 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

**特点** HRC50~70 淬火钢加工精度 ±5 μm  
 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 μm)of hardened steel(HRC50~70).  
 Long tool life by high content PCBN.  
 Excellent surface finish.  
 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

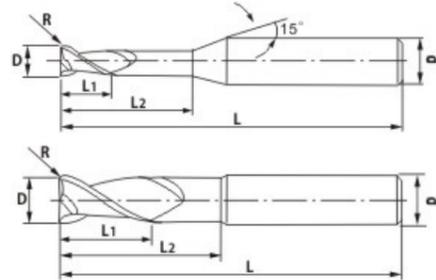
Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2CCBN 010 0002 025	1-P0.2	0.7	2.5	48	4
2CCBN 010 0002 040	1-P0.2	0.7	4	48	4
2CCBN 010 0002 060	1-P0.2	0.7	6	48	4
2CCBN 010 0002 080	1-P0.2	0.7	8	48	4
2CCBN 010 0002 100	1-P0.2	0.7	10	48	4
2CCBN 010 003 025	1-P0.3	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			

**特点** HRC50~70 淬火钢加工精度 ±5 μm  
 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 μm)of hardened steel(HRC50~70).  
 Long tool life by high content PCBN.  
 Excellent surface finish.  
 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

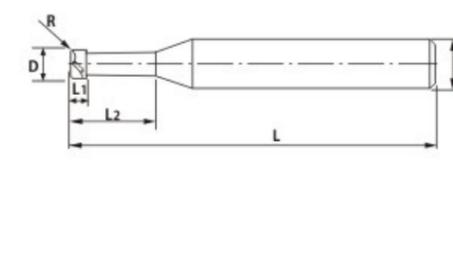
Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
2CCBN 030 010 060	3×P1	1.2	6	66	6
2CCBN 030 010 100	3×P1	1.2	10	66	6
2CCBN 030 010 160	3×P1	1.2	16	66	6
2CCBN 030 010 200	4×P0.1	1.2	20	66	6
2CCBN 040 001 060	4×P0.1	1.5	6	66	6
2CCBN 040 001 100	4×P0.1	1.5	10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

**特点** HRC50~70 淬火钢加工精度 ±5 μm  
 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 μm)of hardened steel(HRC50~70).  
 Long tool life by high content PCBN.  
 Straight type Design for Minimizing edge chipping.  
 Excellent surface finish.  
 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

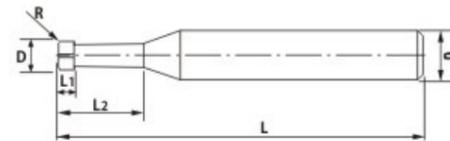


Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d
25CCBN 004 0002 015	0.4-P0.02	0.3	1.5	48	4
25CCBN 004 0005 015	0.4-P0.05	0.3	1.5	48	4
25CCBN 004 001 015	0.4-P0.1	0.3	1.5	48	4
25CCBN 005 0005 015	0.5-P0.05	0.4	1.5	48	4
25CCBN 005 001 015	0.5-P0.1	0.4	1.5	48	4
25CCBN 006 0005 020	0.6-P0.05	0.5	2	48	4
25CCBN 006 001 020	0.6-P0.1	0.5	2	48	4
25CCBN 008 001 020	0.8-P0.1	0.6	2	48	4
25CCBN 008 002 020	0.8-P0.2	0.6	2	48	4
25CCBN 010 0002 025	1-P0.02	0.7	2.5	48	4
25CCBN 010 0002 040	1-P0.02	0.7	4	48	4
25CCBN 010 0005 025	1-P0.05	0.7	2.5	48	4
25CCBN 010 0005 040	1-P0.05	0.7	4	48	4
25CCBN 010 001 025	1-P0.1	0.7	2.5	48	4
25CCBN 010 001 040	1-P0.1	0.7	4	48	4
25CCBN 010 002 025	1-P0.2	0.7	2.5	48	4
25CCBN 010 002 040	1-P0.2	0.7	4	48	4
25CCBN 010 003 025	1-P0.3	0.7	2.5	48	4
25CCBN 010 003 040	1-P0.3	0.7	4	48	4
25CCBN 015 0002 030	1.5-P0.02	0.8	3	48	4
25CCBN 015 0002 040	1.5-P0.02	0.8	4	48	4
25CCBN 015 0005 030	1.5-P0.05	0.8	3	48	4
25CCBN 015 0005 040	1.5-P0.05	0.8	4	48	4
25CCBN 015 001 030	1.5-P0.1	0.8	3	48	4
25CCBN 015 001 040	1.5-P0.1	0.8	4	48	4
25CCBN 015 002 030	1.5-P0.2	0.8	3	48	4
25CCBN 015 002 040	1.5-P0.2	0.8	4	48	4
25CCBN 015 003 030	1.5-P0.3	0.8	3	48	4
25CCBN 015 003 040	1.5-P0.3	0.8	4	48	4
25CCBN 020 0002 030	2-P0.02	0.9	3	50	4
25CCBN 020 0002 060	2-P0.02	0.9	6	50	4
25CCBN 020 0005 030	2-P0.05	0.9	3	50	4
25CCBN 020 0005 060	2-P0.05	0.9	6	50	4
25CCBN 020 001 030	2-P0.1	0.9	3	50	4
25CCBN 020 001 060	2-P0.1	0.9	6	50	4
25CCBN 020 002 030	2-P0.2	0.9	3	50	4
25CCBN 020 002 060	2-P0.2	0.9	6	50	4
25CCBN 020 003 030	2-P0.3	0.9	3	50	4
25CCBN 020 003 060	2-P0.3	0.9	6	50	4
25CCBN 020 005 030	2-P0.5	0.9	3	50	4
25CCBN 020 005 060	2-P0.5	0.9	6	50	4
25CCBN 025 001 060	2.5-P0.1	1.2	6	50	6
25CCBN 025 002 060	2.5-P0.2	1.2	6	50	6
25CCBN 025 003 060	2.5-P0.3	1.2	6	50	6
25CCBN 030 001 060	3-P0.1	1.2	6	66	6
25CCBN 030 001 100	3-P0.1	1.2	10	66	6
25CCBN 030 001 160	3-P0.1	1.2	16	66	6
25CCBN 030 001 200	3-P0.1	1.2	20	66	6
25CCBN 030 002 060	3-P0.2	1.2	6	66	6
25CCBN 030 002 100	3-P0.2	1.2	10	66	6
25CCBN 030 002 160	3-P0.2	1.2	16	66	6
25CCBN 030 002 200	3-P0.2	1.2	20	66	6
25CCBN 030 003 060	3-P0.3	1.2	6	66	6
25CCBN 030 003 100	3-P0.3	1.2	10	66	6
25CCBN 030 003 160	3-P0.3	1.2	16	66	6
25CCBN 030 003 200	3-P0.3	1.2	20	66	6
25CCBN 030 005 060	3-P0.5	1.2	6	66	6
25CCBN 030 005 100	3-P0.5	1.2	10	66	6
25CCBN 030 005 160	3-P0.5	1.2	16	66	6
25CCBN 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
25CCBN 030 002 060	3-P0.2	1.2	6	66	6
25CCBN 030 002 100	3-P0.2	1.2	10	66	6
25CCBN 030 003 060	3-P0.3	1.2	6	66	6
25CCBN 030 003 100	3-P0.3	1.2	10	66	6
25CCBN 030 005 060	3-P0.5	1.2	6	66	6
25CCBN 030 005 100	3-P0.5	1.2	10	66	6
25CCBN 030 005 160	3-P0.5	1.2	16	66	6
25CCBN 030 010 060	3-P1	1.2	6	66	6
25CCBN 030 010 100	3-P1	1.2	10	66	6
25CCBN 040 001 060	4-P0.1	1.5	6	66	6
25CCBN 040 001 100	4-P0.1	1.5	10	66	6
25CCBN 040 001 160	4-P0.1	1.5	16	66	6
25CCBN 040 002 060	4-P0.2	1.5	6	66	6
25CCBN 040 002 100	4-P0.2	1.5	10	66	6
25CCBN 040 002 160	4-P0.2	1.5	16	66	6
25CCBN 040 003 060	4-P0.3	1.5	6	66	6
25CCBN 040 003 100	4-P0.3	1.5	10	66	6
25CCBN 040 003 160	4-P0.3	1.5	16	66	6
25CCBN 040 005 060	4-P0.5	1.5	6	66	6
25CCBN 040 005 100	4-P0.5	1.5	10	66	6
25CCBN 040 005 160	4-P0.5	1.5	16	66	6
25CCBN 040 010 060	4-P1	1.5	6	66	6
25CCBN 040 010 100	4-P1	1.5	10	66	6
25CCBN 040 010 160	4-P1	1.5	16	66	6
25CCBN 060 003 030	6-P0.3	3	-	83	6
25CCBN 060 003 150	6-P0.3	3	15	83	6
25CCBN 060 005 030	6-P0.5	3	-	83	6
25CCBN 060 005 150	6-P0.5	3	15	83	6
25CCBN 060 010 030	6-P1	3	-	83	6
25CCBN 060 010 150	6-P1	3	15	83	6

**特点** HRC50~70 淬火钢加工精度  $\pm 5 \mu m$   
 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 ( $\pm 5 \mu m$ ) of hardened steel (HRC50~70).  
 Long tool life by high content PCBN.  
 Straight type Design for Minimizing edge chipping.  
 Excellent surface finish.  
 Various flute length for optimum performance.  
 Recommend high speed (20000~50000RPM) with oil-mist.  
 C.B.N (Cubic Boron Nitride)



D size	D tolerance
$\phi 0.8-6$	$+0/-0.01mm$



Order Number	Diameter R×D	Length of Cut L1	Effective Length L2	Overall Length L	Shank Dia d	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 030 003 060	3×P0.3	1.2	6	66	6
4SCCBN 008 002 025	0.8-P0.2	0.6	2.5	48	4	4SCCBN 030 003 100	3×P0.5	1.2	10	66	6
4SCCBN 010 0002 025	1-P0.02	0.7	2.5	48	4	4SCCBN 030 005 060	3×P0.5	1.2	6	66	6
4SCCBN 010 0002 040	1-P0.02	0.7	4	48	4	4SCCBN 030 005 100	3×P0.5	1.2	10	66	6
4SCCBN 010 0005 025	1-P0.05	0.7	2.5	48	4	4SCCBN 030 005 160	3×P1	1.2	16	66	6
4SCCBN 010 0005 040	1-P0.05	0.7	4	48	4	4SCCBN 030 010 060	3×P1	1.2	6	66	6
4SCCBN 010 001 025	1-P0.1	0.7	2.5	48	4	4SCCBN 030 010 100	3×P1	1.2	10	66	6
4SCCBN 010 001 040	1-P0.1	0.7	4	48	4	4SCCBN 030 010 160	4×P0.1	1.2	16	66	6
4SCCBN 010 002 025	1-P0.2	0.7	2.5	48	4	4SCCBN 040 001 060	4×P0.1	1.5	6	66	6
4SCCBN 010 002 040	1-P0.2	0.7	4	48	4	4SCCBN 040 001 100	4×P0.1	1.5	10	66	6
4SCCBN 010 003 025	1-P0.3	0.7	2.5	48	4	4SCCBN 040 001 160	4×P0.2	1.5	16	66	6
4SCCBN 010 003 040	1-P0.3	0.7	4	48	4	4SCCBN 040 002 060	4×P0.2	1.5	6	66	6
4SCCBN 015 0002 030	1.5-P0.02	0.8	3	48	4	4SCCBN 040 002 100	4×P0.2	1.5	10	66	6
4SCCBN 015 0002 040	1.5-P0.02	0.8	4	48	4	4SCCBN 040 002 160	4×P0.2	1.5	16	66	6
4SCCBN 015 0005 030	1.5-P0.05	0.8	3	48	4	4SCCBN 040 003 060	4×P0.3	1.5	6	66	6
4SCCBN 015 0005 040	1.5-P0.05	0.8	4	48	4	4SCCBN 040 003 100	4×P0.3	1.5	10	66	6
4SCCBN 015 001 030	1.5-P0.1	0.8	3	48	4	4SCCBN 040 003 160	4×P0.3	1.5	16	66	6
4SCCBN 015 001 040	1.5-P0.1	0.8	4	48	4	4SCCBN 040 005 060	4×P0.5	1.5	6	66	6
4SCCBN 015 002 030	1.5-P0.2	0.8	3	48	4	4SCCBN 040 005 100	4×P0.5	1.5	10	66	6
4SCCBN 015 002 040	1.5-P0.2	0.8	4	48	4	4SCCBN 040 005 160	4×P0.5	1.5	16	66	6
4SCCBN 015 003 030	1.5-P0.3	0.8	3	48	4	4SCCBN 040 010 060	4×P1	1.5	6	66	6
4SCCBN 015 003 040	1.5-P0.3	0.8	4	48	4	4SCCBN 040 010 100	4×P1	1.5	10	66	6
4SCCBN 020 0002 030	2-P0.02	0.9	3	48	4	4SCCBN 040 010 160	4×P1	1.5	16	66	6
4SCCBN 020 0002 040	2-P0.02	0.9	4	50	4	4SCCBN 060 003 030	6×P0.3	3	-	83	6
4SCCBN 020 0002 060	2-P0.02	0.9	6	50	4	4SCCBN 060 003 150	6×P0.3	3	15	83	6
4SCCBN 020 0005 030	2-P0.05	0.9	3	50	4	4SCCBN 060 005 030	6×P0.5	3	-	83	6
4SCCBN 020 0005 040	2-P0.05	0.9	4	50	4	4SCCBN 060 005 150	6×P0.5	3	15	83	6
4SCCBN 020 0005 060	2-P0.05	0.9	6	50	4	4SCCBN 060 010 030	6×P1	3	-	83	6
4SCCBN 020 001 030	2-P0.1	0.9	3	50	4	4SCCBN 060 010 150	6×P1	3	15	83	6
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 020 005 040	2-P0.5	0.9	4	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						

**MEMO**