

Yes[®] YESTOOL Co., Ltd.

韩国·京畿道安山市檀园区城谷路189
e-mail: yestool@yestool.co.kr
电话: +82-31-493-2387 / 8 (内线 #2)
传真: +82-31-494-7619
www.yestool.com

LUBRAND

大连隆邦商务发展有限公司

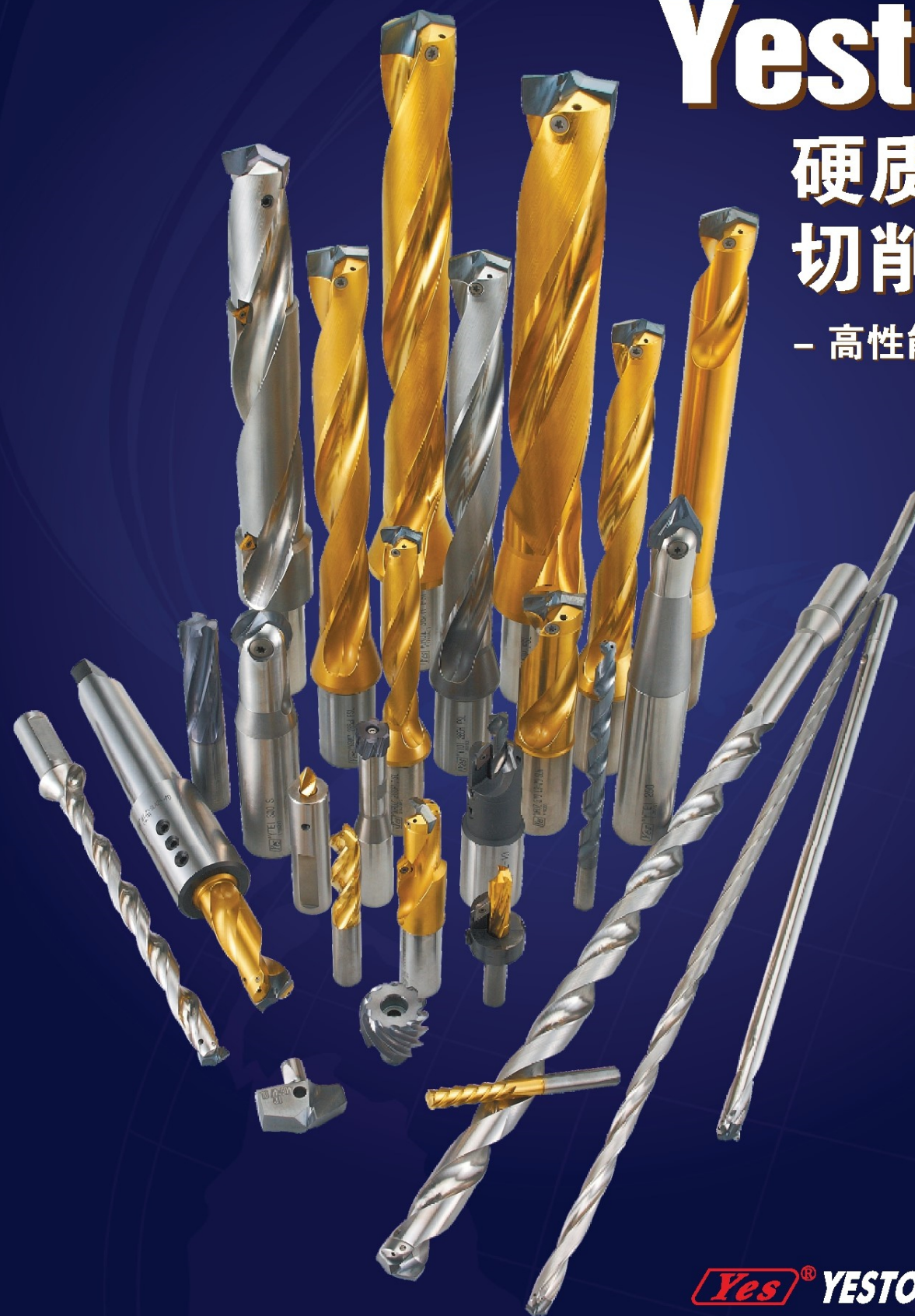
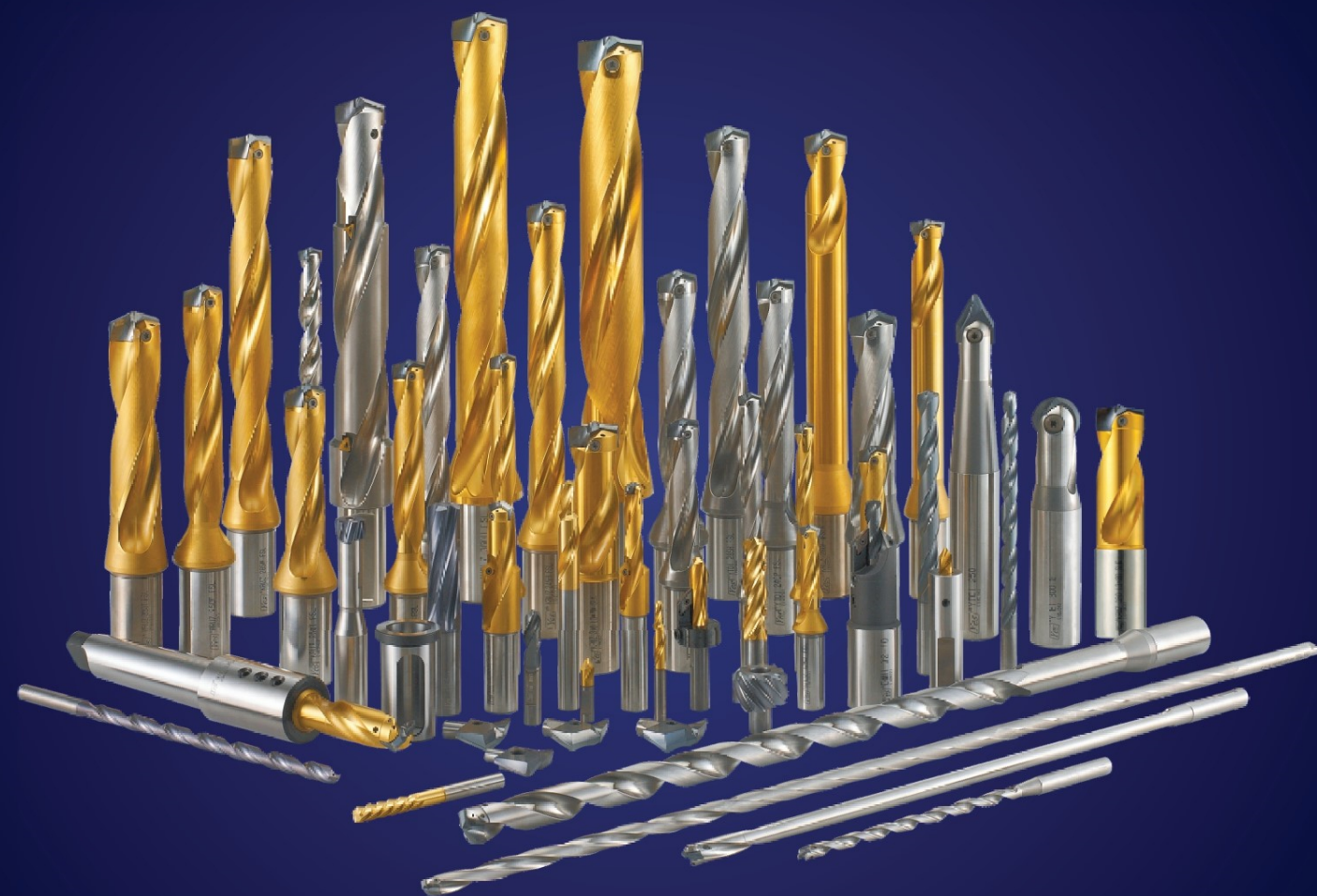
地址: 大连市西岗区高尔基路212-16号1401室
电话: 0411-39568989 传真: 0411-83785776
e-mail: libin@lubrand.com
www.lubrand.com

YC-2015/1(CN)

Yestool

硬质合金 切削刀具

— 高性能刀具系列



YESTOOL公司全球销售网络



- | | | | |
|--------|---------|---------|----------|
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Yes[®] YESTOOL Co., Ltd.



建德刀具有限公司
CUTTEC TOOLING CORPORATION
優質鋁鋼切削工具專業代理
http://www.cuttec.com.tw

台北總公司:
台北市承德路2段12號6F
TEL: 02-2555 2876
FAX: 02-2556 8046
cuttec@gmail.com

台中分公司:
台中市仁和路292號8F-5
TEL: 04-2280 9826
FAX: 04-2280 9836
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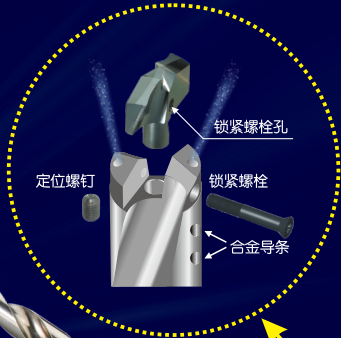
F1深孔钻刀体与硬质合金钻尖

F1DR

IDSH

可换硬质合金钻尖方式的螺旋深孔钻的又一次突破, 世界首创 !!
钻头总长, 最长可达到 1.25米
可换钻尖式刀具的专业制造商—**YESTOOL**公司的新产品

- ❖ 在枪钻专机和加工中心上, 都能使用
- ❖ 高进给, 速度比枪钻快2倍以上
- ❖ 带内冷孔, 适于安装**IDSH**硬质合金钻尖(刀片)
- ❖ 硬质合金防磨损部件 (可选择)
 - $\Phi 8.0 \sim 9.5 \Rightarrow 20 \times D$
 - $\Phi 10.0 \sim 11.5 \Rightarrow 30 \times D$
 - $\Phi 12.0 \sim 23.5 \Rightarrow 50 \times D$
 - $\Phi 24.0 \sim 25.0 \Rightarrow 45 \times D$
 - $\Phi 25.0$ 或以上直径, 最长可制造1,250mm (OAL)



※ 请访问我们的网站, 可看到测试结果
($\Phi 20.0$ 直径的钢件, 切削深度为 400mm)
www.yestool.com

切削参数	S: 2,000 rpm f: 0.25mm/转 F: 500mm/分
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KRUZ-FSL、YTDI-FSL型法兰刀体与硬质合金钻尖



KRUZ-FSL

可选刀片(3种通用)

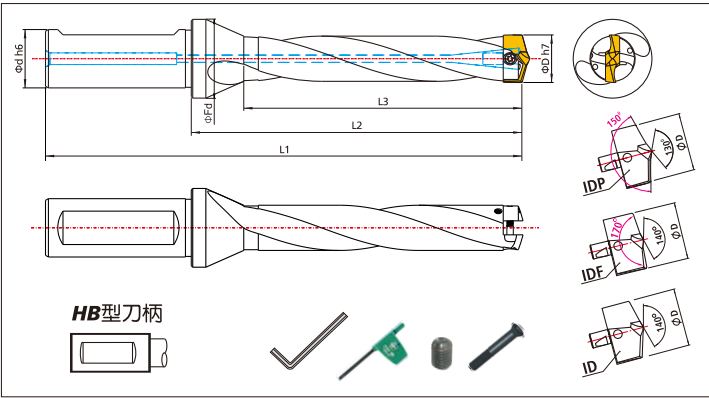
- IDP** 适于加工深孔和通用
- IDF** 适于加工薄板和浅孔
- ID** 通用刀片



KRUZ-FSL 刀体

YTDI-FSL 刀体

- 坚固的法兰式刀体, 以减少震动或抖动
- 三种可通用的<IDP>、<IDF>、<ID>型硬质合金钻尖
- 刀体采用经过特殊热处理的优质工具钢, 具有很好的刚性
- 通过减小振动, 更能提高刀具寿命
- 内冷孔设计, 可做到大进给、高速切削



订货时, 请在口内标注孔深。如: **T**(3倍孔径), **P**(5倍孔径), **H**(7倍孔径), **L**(10倍孔径----> $\Phi 11.0$ mm以上)

孔径范围	刀体型号	刀柄尺寸 (Φd)	切削深度 (倍 x 孔径)	L1	L2	L3	法兰直径 (ΦFd)	适合刀体的刀片型号	 IDP  IDF  ID	锁紧螺栓	梅花型螺批	定位螺钉	"L"型内六角扳手				
Φ8.0 ~Φ8.4	YTDI 080 □ FSL KRUZ 080 □ FSL	10.0 (HA)	T(3xD)	87	42	32	18	IDP 080, IDP 081, IDP 082, IDP 083, IDP 084 IDF 080, IDF 081, IDF 082, IDF 083, IDF 084 ID 080, ID 081, ID 082, ID 083, ID 084	CS 080 -085 SL	 T6 扭矩 0.6Nm (最大)	None	None					
Φ8.5 ~Φ8.9	YTDI 085 □ FSL KRUZ 085 □ FSL		T(3xD)	89	44	34		IDP 085, IDP 086, IDP 087, IDP 088, IDP 089 IDF 085, IDF 086, IDF 087, IDF 088, IDF 089 ID 085, ID 086, ID 087, ID 088, ID 089									
Φ9.0 ~Φ9.4	YTDI 090 □ FSL KRUZ 090 □ FSL		T(3xD)	92	47	36		IDP 090, IDP 091, IDP 092, IDP 093, IDP 094 IDF 090, IDF 091, IDF 092, IDF 093, IDF 094 ID 090, ID 091, ID 092, ID 093, ID 094									
Φ9.5 ~Φ9.9	YTDI 095 □ FSL KRUZ 095 □ FSL	12.0 (HA)	P(5xD)	110	65	54		IDP 095, IDP 096, IDP 097, IDP 098, IDP 099 IDF 095, IDF 096, IDF 097, IDF 098, IDF 099 ID 095, ID 096, ID 097, ID 098, ID 099	CS 090 -095 SL								
Φ10.0 ~Φ10.4	YTDI 100 □ FSL KRUZ 100 □ FSL		H(7xD)	128	83	72		IDP 100, IDP 101, IDP 102, IDP 103, IDP 104 IDF 100, IDF 101, IDF 102, IDF 103, IDF 104 ID 100, ID 101, ID 102, ID 103, ID 104									
Φ10.5 ~Φ10.9	YTDI 105 □ FSL KRUZ 105 □ FSL		T(3xD)	99	51	40		IDP 105, IDP 106, IDP 107, IDP 108, IDP 109 IDF 105, IDF 106, IDF 107, IDF 108, IDF 109 ID 105, ID 106, ID 107, ID 108, ID 109									
Φ11.0 ~Φ11.4	YTDI 110 □ FSL KRUZ 110 □ FSL	16.0	P(5xD)	119	71	60		IDP 110, IDP 111, IDP 112, IDP 113, IDP 114 IDF 110, IDF 111, IDF 112, IDF 113, IDF 114 ID 110, ID 111, ID 112, ID 113, ID 114	CS 100 -115 SL								
Φ11.5 ~Φ11.9	YTDI 115 □ FSL KRUZ 115 □ FSL		H(7xD)	139	91	80		IDP 115, IDP 116, IDP 117, IDP 118, IDP 119 IDF 115, IDF 116, IDF 117, IDF 118, IDF 119 ID 115, ID 116, ID 117, ID 118, ID 119									
Φ12.0 ~Φ12.4	YTDI 120 □ FSL KRUZ 120 □ FSL		T(3xD)	102	54	42		IDP 120, IDP 121, IDP 122, IDP 123, IDP 124 IDF 120, IDF 121, IDF 122, IDF 123, IDF 124 ID 120, ID 121, ID 122, ID 123, ID 124									
			P(5xD)	123	75	63											
			H(7xD)	144	96	84											
			T(3xD)	104	56	44											
			P(5xD)	126	78	66											
			H(7xD)	148	100	88											
			L(10xD)	181	133	121											
			T(3xD)	107	59	46											
			P(5xD)	130	82	69											
			H(7xD)	153	105	92											
			L(10xD)	188	140	127											
			T(3xD)	109	61	48											
			P(5xD)	133	85	72											
			H(7xD)	157	109	96											
			L(10xD)	193	145	132											

KRUZ-FSL、YTDI-FSL型法兰刀体与硬质合金钻尖

孔径 范围	刀体型号	刀柄尺寸 (Φd)	切削深度 (倍×孔径)	L1	L2	L3	法兰直径 (Φfd)	适合刀体的刀片型号	  	锁紧螺栓	梅花型螺批	定位螺钉	1°型内六角扳手
Φ12.5 ~Φ12.9	YTDI 125 □ FSL KRUZ 125 □ FSL	16.0	T(3xD) P(5xD) H(7xD) L(10xD)	111 136 161 199	63 88 113 151	50 75 100 138	21	IDP 125, IDP 126, IDP 127, IDP 128, IDP 129 IDF 125, IDF 126, IDF 127, IDF 128, IDF 129 ID 125-, ID 126, ID 127, ID 128, ID 129		CS 120 -135 SL	扭矩 0.6Nm (最大)		
Φ13.0 ~Φ13.4	YTDI 130 □ FSL KRUZ 130 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	114 140 166 205	66 92 118 157	52 78 104 143		IDP 130, IDP 131, IDP 132, IDP 133, IDP 134 IDF 130, IDF 131, IDF 132, IDF 133, IDF 134 ID 130, ID 131, ID 132, ID 133, ID 134					
Φ13.5 ~Φ13.9	YTDI 135 □ FSL KRUZ 135 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	116 143 170 211	68 95 122 163	54 81 108 149		IDP 135, IDP 136, IDP 137, IDP 138, IDP 139 IDF 135, IDF 136, IDF 137, IDF 138, IDF 139 ID 135, ID 136, ID 137, ID 138, ID 139					
Φ14.0 ~Φ14.4	YTDI 140 □ FSL KRUZ 140 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	119 147 175 217	71 99 127 169	56 84 112 154		IDP 140, IDP 141, IDP 142, IDP 143, IDP 144 IDF 140, IDF 141, IDF 142, IDF 143, IDF 144 ID 140, ID 141, ID 142, ID 143, ID 144					
Φ14.5 ~Φ14.9	YTDI 145 □ FSL KRUZ 145 □ FSL	20.0	T(3xD) P(5xD) H(7xD) L(10xD)	123 152 181 225	73 102 131 175	58 87 116 160	27	IDP 145, IDP 146, IDP 147, IDP 148, IDP 149 IDF 145, IDF 146, IDF 147, IDF 148, IDF 149 ID 145, ID 146, ID 147, ID 148, ID 149		CS 140 -155 SL	扭矩 0.9Nm (最大)	M2.5x4	1.3mm
Φ15.0 ~Φ15.4	YTDI 150 □ FSL KRUZ 150 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	127 157 187 232	77 107 137 182	60 90 120 165		IDP 150, IDP 151, IDP 152, IDP 153, IDP 154 IDF 150, IDF 151, IDF 152, IDF 153, IDF 154 ID 150, ID 151, ID 152, ID 153, ID 154					
Φ15.5 ~Φ15.9	YTDI 155 □ FSL KRUZ 155 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	130 161 192 239	80 111 142 189	62 93 124 171		IDP 155, IDP 156, IDP 157, IDP 158, IDP 159 IDF 155, IDF 156, IDF 157, IDF 158, IDF 159 ID 155, ID 156, ID 157, ID 158, ID 159					
Φ16.0 ~Φ16.4	YTDI 160 □ FSL KRUZ 160 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	132 164 196 244	82 114 146 194	64 96 128 176		IDP 160, IDP 161, IDP 162, IDP 163, IDP 164 IDF 160, IDF 161, IDF 162, IDF 163, IDF 164 ID 160, ID 161, ID 162, ID 163, ID 164					
Φ16.5 ~Φ16.9	YTDI 165 □ FSL KRUZ 165 □ FSL	20.0	T(3xD) P(5xD) H(7xD) L(10xD)	135 168 201 251	85 118 151 201	66 99 132 182	27	IDP 165, IDP 166, IDP 167, IDP 168, IDP 169 IDF 165, IDF 166, IDF 167, IDF 168, IDF 169 ID 165, ID 166, ID 167, ID 168, ID 169		CS 160 -175 SL	扭矩 1.5Nm (最大)		
Φ17.0 ~Φ17.4	YTDI 170 □ FSL KRUZ 170 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	137 171 205 256	87 121 155 206	68 102 136 187		IDP 170, IDP 171, IDP 172, IDP 173, IDP 174 IDF 170, IDF 171, IDF 172, IDF 173, IDF 174 ID 170, ID 171, ID 172, ID 173, ID 174					
Φ17.5 ~Φ17.9	YTDI 175 □ FSL KRUZ 175 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	139 174 209 262	89 124 159 212	70 105 140 193		IDP 175, IDP 176, IDP 177, IDP 178, IDP 179 IDF 175, IDF 176, IDF 177, IDF 178, IDF 179 ID 175, ID 176, ID 177, ID 178, ID 179					
Φ18.0 ~Φ18.4	YTDI 180 □ FSL KRUZ 180 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	142 178 214 268	92 128 164 218	72 108 144 198		IDP 180, IDP 181, IDP 182, IDP 183, IDP 184 IDF 180, IDF 181, IDF 182, IDF 183, IDF 184 ID 180, ID 181, ID 182, ID 183, ID 184					
Φ18.5 ~Φ18.9	YTDI 185 □ FSL KRUZ 185 □ FSL	25.0	T(3xD) P(5xD) H(7xD) L(10xD)	144 181 218 274	94 131 168 224	74 111 148 204	32	IDP 185, IDP 186, IDP 187, IDP 188, IDP 189 IDF 185, IDF 186, IDF 187, IDF 188, IDF 189 ID 185, ID 186, ID 187, ID 188, ID 189		CS 180 -195 SL	扭矩 1.5Nm (最大)		
Φ19.0 ~Φ19.4	YTDI 190 □ FSL KRUZ 190 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	147 185 223 280	97 135 173 230	76 114 152 209		IDP 190, IDP 191, IDP 192, IDP 193, IDP 194 IDF 190, IDF 191, IDF 192, IDF 193, IDF 194 ID 190, ID 191, ID 192, ID 193, ID 194					
Φ19.5 ~Φ19.9	YTDI 195 □ FSL KRUZ 195 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	149 188 227 286	99 138 177 236	78 117 156 215		IDP 195, IDP 196, IDP 197, IDP 198, IDP 199 IDF 195, IDF 196, IDF 197, IDF 198, IDF 199 ID 195, ID 196, ID 197, ID 198, ID 199					
Φ20.0 ~Φ20.4	YTDI 200 □ FSL KRUZ 200 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	157 197 237 297	101 141 181 241	80 120 160 220		IDP 200, IDP 201, IDP 202, IDP 203, IDP 204 IDF 200, IDF 201, IDF 202, IDF 203, IDF 204 ID 200, ID 201, ID 202, ID 203, ID 204					

孔径 范围	刀体型号	刀柄尺寸 (Φd)	切削深度 (倍×孔径)	L1	L2	L3	法兰直径 (Φfd)	适合刀体的刀片型号	  	锁紧螺栓	梅花型螺批	定位螺钉	1°型内六角扳手
Φ20.5 ~Φ20.9	YTDI 205 □ FSL KRUZ 205 □ FSL	25.0	T(3xD) P(5xD) H(7xD) L(10xD)	160 201 242 304	104 145 186 248	82 123 164 226	32	IDP 205, IDP 206, IDP 207, IDP 208, IDP 209 IDF 205, IDF 206, IDF 207, IDF 208, IDF 209 ID 205, ID 206, ID 207, ID 208, ID 209		CS 200 -215 SL	扭矩 1.5Nm (最大)		
Φ21.0 ~Φ21.4	YTDI 210 □ FSL KRUZ 210 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	162 204 246 309	106 148 190 253	84 126 168 231		IDP 210, IDP 211, IDP 212, IDP 213, IDP 214 IDF 210, IDF 211, IDF 212, IDF 213, IDF 214 ID 210, ID 211, ID 212, ID 213, ID 214					
Φ21.5 ~Φ21.9	YTDI 215 □ FSL KRUZ 215 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	165 208 251 316	109 152 195 260	86 129 172 237		IDP 215, IDP 216, IDP 217, IDP 218, IDP 219 IDF 215, IDF 216, IDF 217, IDF 218, IDF 219 ID 215, ID 216, ID 217, ID 218, ID 219					
Φ22.0 ~Φ22.4	YTDI 220 □ FSL KRUZ 220 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	167 211 255 321	111 155 199 265	88 132 176 242		IDP 220, IDP 221, IDP 222, IDP 223, IDP 224 IDF 220, IDF 221, IDF 222, IDF 223, IDF 224 ID 220, ID 221, ID 222, ID 223, ID 224					
Φ22.5 ~Φ22.9	YTDI 225 □ FSL KRUZ 225 □ FSL	32.0	T(3xD) P(5xD) H(7xD) L(10xD)	169 214 259 327	113 158 203 271	90 135 180 248	39	IDP 225, IDP 226, IDP 227, IDP 228, IDP 229 IDF 225, IDF 226, IDF 227, IDF 228, IDF 229 ID 225, ID 226, ID 227, ID 228, ID 229		CS 220 -235 SL	扭矩 1.5Nm (最大)	M3x6	1.5mm
Φ23.0 ~Φ23.4	YTDI 230 □ FSL KRUZ 230 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	172 218 264 333	116 162 208 277	92 138 184 253		IDP 230, IDP 231, IDP 232, IDP 233, IDP 234 IDF 230, IDF 231, IDF 232, IDF 233, IDF 234 ID 230, ID 231, ID 232, ID 233, ID 234					
Φ23.5 ~Φ23.9	YTDI 235 □ FSL KRUZ 235 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	174 221 268 339	118 165 212 283	94 141 188 259		IDP 235, IDP 236, IDP 237, IDP 238, IDP 239 IDF 235, IDF 236, IDF 237, IDF 238, IDF 239 ID 235, ID 236, ID 237, ID 238, ID 239					
Φ24.0 ~Φ24.4	YTDI 240 □ FSL KRUZ 240 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	181 229 277 349	121 169 217 289	96 144 192 264		IDP 240, IDP 241, IDP 242, IDP 243, IDP244 IDF 240, IDF 241, IDF 242, IDF 243, IDF244 ID 240, ID 241, ID 242, ID 243, ID 244					
Φ24.5 ~Φ24.9	YTDI 245 □ FSL KRUZ 245 □ FSL	32.0	T(3xD) P(5xD) H(7xD) L(10xD)	183 232 281 355	123 172 221 295	98 147 196 270	39	IDP 245, IDP 246, IDP 247, IDP 248, IDP 249 IDF 245, IDF 246, IDF 247, IDF 248, IDF 249 ID 245, ID 246, ID 247, ID 248, ID 249		CS 240 -255 SL	扭矩 3.5Nm (最大)		
Φ25.0 ~Φ25.4	YTDI 250 □ FSL KRUZ 250 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	185 235 285 360	125 175 225 300	100 150 200 275		IDP 250, IDP 251, IDP 252, IDP 253, IDP 254 IDF 250, IDF 251, IDF 252, IDF 253, IDF 254 ID 250, ID 251, ID 252, ID 253, ID 254					
Φ25.5 ~Φ25.9	YTDI 255 □ FSL KRUZ 255 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	188 239 290 367	128 179 230 307	102 153 204 281		IDP 255, IDP 256, IDP 257, IDP 258, IDP 259 IDF 255, IDF 256, IDF 257, IDF 258, IDF 259 ID 255, ID 256, ID 257, ID 258, ID 259					
Φ26.0 ~Φ26.4	YTDI 260 □ FSL KRUZ 260 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	190 242 294 372	130 182 234 312	104 156 208 286		IDP 260, IDP 261, IDP 262, IDP 263, IDP 264 IDF 260, IDF 261, IDF 262, IDF 263, IDF 264 ID 260, ID 261, ID 262, ID 263, ID 264					
Φ26.5 ~Φ26.9	YTDI 265 □ FSL KRUZ 265 □ FSL	32.0	T(3xD) P(5xD) H(7xD) L(10xD)	193 246 299 379	133 186 239 319	106 159 212 292	39	IDP 265, IDP 266, IDP 267, IDP 268, IDP 269 IDF 265, IDF 266, IDF 267, IDF 268, IDF 269 ID 265, ID 266, ID 267, ID 268, ID 269		CS 260 -275 SL	扭矩 3.5Nm (最大)		
Φ27.0 ~Φ27.4	YTDI 270 □ FSL KRUZ 270 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	195 249 303 384	135 189 243 324	108 162 216 297		IDP 270, IDP 271, IDP 272, IDP 273, IDP 274 IDF 270, IDF 271, IDF 272, IDF 273, IDF 274 ID 270, ID 271, ID 272, ID 273, ID 274					
Φ27.5 ~Φ27.9	YTDI 275 □ FSL KRUZ 275 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	197 252 307 390	137 192 247 330	110 165 220 303		IDP 275, IDP 276, IDP 277, IDP 278, IDP 279 IDF 275, IDF 276, IDF 277, IDF 278, IDF 279 ID 275, ID 276, ID 277, ID 278, ID 279					
Φ28.0 ~Φ28.4	YTDI 280 □ FSL KRUZ 280 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	200 256 312 396	140 196 252 336	112 168 224 308		IDP 280, IDP 281, IDP 282, IDP 283, IDP 284 IDF 280, IDF 281, IDF 282, IDF 283, IDF 284 ID 280, ID 281, ID 282, ID 283, ID 284					

KRUZ-FSL、YTDI-FSL型法兰刀体与硬质合金钻尖

孔径 范围	刀体型号	刀柄尺寸 (Φd)	切削深度 (倍×孔径)	L1	L2	L3	法兰直径 (ΦFd)	适合刀体的刀片型号	 IDP  IDF  ID	锁紧螺栓	梅花型螺批	定位螺钉	1°型内六角扳手			
Φ28.5 ~Φ28.9	YTDI 285 □ FSL KRUZ 285 □ FSL	32.0	T(3xD) P(5xD) H(7xD) L(10xD)	202 259 316 402	142 199 256 342	114 171 228 314	39	IDP 285, IDP 286, IDP 287, IDP 288, IDP 289 IDF 285, IDF 286, IDF 287, IDF 288, IDF 289 ID 285, ID 286, ID 287, ID 288, ID 289	CS 280 ~295 SL	 T15 扭矩 3.5Nm (最大)	M4x8	2.0mm				
Φ29.0 ~Φ29.4	YTDI 290 □ FSL KRUZ 290 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	205 263 321 408	145 203 261 348	116 174 232 319		IDP 290, IDP 291, IDP 292, IDP 293, IDP 294 IDF 290, IDF 291, IDF 292, IDF 293, IDF 294 ID 290, ID 291, ID 292, ID 293, ID 294								
Φ29.5 ~Φ29.9	YTDI 295 □ FSL KRUZ 295 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	207 266 325 414	147 206 265 354	118 177 236 325		IDP 295, IDP 296, IDP 297, IDP 298, IDP 299 IDF 295, IDF 296, IDF 297, IDF 298, IDF 299 ID 295, ID 296, ID 297, ID 298, ID 299								
Φ30.0 ~Φ30.4	YTDI 300 □ FSL KRUZ 300 □ FSL		32.0	T(3xD) P(5xD) H(7xD) L(10xD)	209 269 329 419	149 209 269 359		120 180 240 330	39	IDP 300, IDP 301, IDP 302, IDP 303, IDP 304 IDF 300, IDF 301, IDF 302, IDF 303, IDF 304 ID 300, ID 301, ID 302, ID 303, ID 304	CS 300 ~315 SL	 T20 扭矩 4.0Nm (最大)	M5x10	2.5mm		
Φ30.5 ~Φ30.9	YTDI 305 □ FSL KRUZ 305 □ FSL			T(3xD) P(5xD) H(7xD) L(10xD)	212 273 334 426	152 213 274 366		122 183 244 336		IDP 305, IDP 306, IDP 307, IDP 308, IDP 309 IDF 305, IDF 306, IDF 307, IDF 308, IDF 309 ID 305, ID 306, ID 307, ID 308, ID 309						
Φ31.0 ~Φ31.4	YTDI 310 □ FSL KRUZ 310 □ FSL			T(3xD) P(5xD) H(7xD) L(10xD)	214 276 338 431	154 216 278 371		124 186 248 341		IDP 310, IDP 311, IDP 312, IDP 313, IDP 314 IDF 310, IDF 311, IDF 312, IDF 313, IDF 314 ID 310, ID 311, ID 312, ID 313, ID 314						
Φ31.5 ~Φ31.9	YTDI 315 □ FSL KRUZ 315 □ FSL			T(3xD) P(5xD) H(7xD) L(10xD)	217 280 343 438	157 220 283 378		126 189 252 347		IDP 315, IDP 316, IDP 317, IDP 318, IDP 319 IDF 315, IDF 316, IDF 317, IDF 318, IDF 319 ID 315, ID 316, ID 317, ID 318, ID 319	CS 320 ~355 SL	 T20 扭矩 4.0Nm (最大)	M5x10	2.5mm		
Φ32.0 ~Φ32.4	YTDI 320 □ FSL KRUZ 320 □ FSL			T(3xD) P(5xD) H(7xD) L(10xD)	219 283 347 443	159 223 287 383		128 192 256 352		IDP 320, IDP 321, IDP 322, IDP 323, IDP 324 IDF 320, IDF 321, IDF 322, IDF 323, IDF 324 ID 320, ID 321, ID 322, ID 323, ID 324						
Φ32.5 ~Φ32.9	YTDI 325 □ FSL KRUZ 325 □ FSL			T(3xD) P(5xD) H(7xD) L(10xD)	221 286 351 449	161 226 291 389		130 195 260 358		IDP 325, IDP 326, IDP 327, IDP 328, IDP 329 IDF 325, IDF 326, IDF 327, IDF 328, IDF 329 ID 325, ID 326, ID 327, ID 328, ID 329						
Φ33.0 ~Φ33.4	YTDI 330 □ FSL KRUZ 330 □ FSL			40.0	T(3xD) P(5xD) H(7xD) L(10xD)	224 290 356 455		164 230 296 395		132 198 264 363	55	IDP 330, IDP 331, IDP 332, IDP 333, IDP 334 IDF 330, IDF 331, IDF 332, IDF 333, IDF 334 ID 330, ID 331, ID 332, ID 333, ID 334	CS 320 ~355 SL	 T20 扭矩 4.0Nm (最大)	M5x10	2.5mm
Φ33.5 ~Φ33.9	YTDI 335 □ FSL KRUZ 335 □ FSL				T(3xD) P(5xD) H(7xD) L(10xD)	226 293 360 461		166 233 300 401		134 201 268 369		IDP 335, IDP 336, IDP 337, IDP 338, IDP 339 IDF 335, IDF 336, IDF 337, IDF 338, IDF 339 ID 335, ID 336, ID 337, ID 338, ID 339				
Φ34.0 ~Φ34.4	YTDI 340 □ FSL KRUZ 340 □ FSL				T(3xD) P(5xD) H(7xD) L(10xD)	239 307 375 477		169 237 305 407		136 204 272 374		IDP 340, IDP 341, IDP 342, IDP 343, IDP 344 IDF 340, IDF 341, IDF 342, IDF 343, IDF 344 ID 340, ID 341, ID 342, ID 343, ID 344				
Φ34.5 ~Φ34.9	YTDI 345 □ FSL KRUZ 345 □ FSL	T(3xD) P(5xD) H(7xD) L(10xD)			241 310 379 483	171 240 309 413	138 207 276 380	IDP 345, IDP 346, IDP 347, IDP 348, IDP 349 IDF 345, IDF 346, IDF 347, IDF 348, IDF 349 ID 345, ID 346, ID 347, ID 348, ID 349		CS 360 ~395 SL		 T20 扭矩 4.0Nm (最大)	M5x10	2.5mm		
Φ35.0 ~Φ35.4	YTDI 350 □ FSL KRUZ 350 □ FSL	T(3xD) P(5xD) H(7xD) L(10xD)			243 313 383 488	173 243 313 418	140 210 280 385	IDP 350, IDP 351, IDP 352, IDP 353, IDP 354 IDF 350, IDF 351, IDF 352, IDF 353, IDF 354 ID 350, ID 351, ID 352, ID 353, ID 354								
Φ35.5 ~Φ35.9	YTDI 355 □ FSL KRUZ 355 □ FSL	T(3xD) P(5xD) H(7xD) L(10xD)			246 317 388 495	176 247 318 425	142 213 284 391	IDP 355, IDP 356, IDP 357, IDP 358, IDP 359 IDF 355, IDF 356, IDF 357, IDF 358, IDF 359 ID 355, ID 356, ID 357, ID 358, ID 359								
Φ36.0 ~Φ36.4	YTDI 360 □ FSL KRUZ 360 □ FSL	40.0	T(3xD) P(5xD) H(7xD) L(10xD)		248 320 392 500	178 250 322 430	144 216 288 396	55	IDP 360, IDP 361, IDP 362, IDP 363, IDP 364 IDF 360, IDF 361, IDF 362, IDF 363, IDF 364 ID 360, ID 361, ID 362, ID 363, ID 364	CS 360 ~395 SL		 T20 扭矩 4.0Nm (最大)	M5x10	2.5mm		

孔径 范围	刀体型号	刀柄尺寸 (Φd)	切削深度 (倍×孔径)	L1	L2	L3	法兰直径 (ΦFd)	适合刀体的刀片型号	 IDP  IDF  ID	锁紧螺栓	梅花型螺批	定位螺钉	1°型内六角扳手
Φ36.5 ~Φ36.9	YTDI 365 □ FSL KRUZ 365 □ FSL	40.0	T(3xD) P(5xD) H(7xD) L(10xD)	251 324 397 507	181 254 327 437	146 219 292 402	55	IDP 365, IDP 366, IDP 367, IDP 368, IDP 369 IDF 365, IDF 366, IDF 367, IDF 368, IDF 369 ID 365, ID 366, ID 367, ID 368, ID 369	CS 360 ~395 SL	 T20 扭矩 4.0Nm (最大)	M5x10	2.5mm	
Φ37.0 ~Φ37.4	YTDI 370 □ FSL KRUZ 370 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	253 327 401 512	183 257 331 442	148 222 296 407		IDP 370, IDP 371, IDP 372, IDP 373, IDP 374 IDF 370, IDF 371, IDF 372, IDF 373, IDF 374 ID 370, ID 371, ID 372, ID 373, ID 374					
Φ37.5 ~Φ37.9	YTDI 375 □ FSL KRUZ 375 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	255 330 405 518	185 260 335 448	150 225 300 413		IDP 375, IDP 376, IDP 377, IDP 378, IDP 379 IDF 375, IDF 376, IDF 377, IDF 378, IDF 379 ID 375, ID 376, ID 377, ID 378, ID 379					
Φ38.0 ~Φ38.4	YTDI 380 □ FSL KRUZ 380 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	258 334 410 524	188 264 340 454	152 228 304 418		IDP 380, IDP 381, IDP 382, IDP 383, IDP 384 IDF 380, IDF 381, IDF 382, IDF 383, IDF 384 ID 380, ID 381, ID 382, ID 383, ID 384					
Φ38.5 ~Φ38.9	YTDI 385 □ FSL KRUZ 385 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	260 337 414 530	196 267 344 460	154 231 308 424		IDP 385, IDP 386, IDP 387, IDP 388, IDP 389 IDF 385, IDF 386, IDF 387, IDF 388, IDF 389 ID 385, ID 386, ID 387, ID 388, ID 389					
Φ39.0 ~Φ39.4	YTDI 390 □ FSL KRUZ 390 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	263 341 419 536	193 271 349 466	156 234 312 429		IDP 390, IDP 391, IDP 392, IDP 393, IDP 394 IDF 390, IDF 391, IDF 392, IDF 393, IDF 394 ID 390, ID 391, ID 392, ID 393, ID 394					
Φ39.5 ~Φ39.9	YTDI 395 □ FSL KRUZ 395 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	265 344 423 542	195 274 353 472	158 237 316 435		IDP 395, IDP 396, IDP 397, IDP 398, IDP 399 IDF 395, IDF 396, IDF 397, IDF 398, IDF 399 ID 395, ID 396, ID 397, ID 398, ID 399					
Φ40.0 ~Φ40.4	YTDI 400 □ FSL KRUZ 400 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	267 347 427 547	197 277 357 477	160 240 320 440		IDP 400, IDP 401, IDP 402, IDP 403, IDP 404 IDF 400, IDF 401, IDF 402, IDF 403, IDF 404 ID 400, ID 401, ID 402, ID 403, ID 404					
Φ40.5 ~Φ40.9	YTDI 405 □ FSL KRUZ 405 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	270 351 432 554	200 281 362 484	162 243 324 446		IDP 405, IDP 406, IDP 407, IDP 408, IDP 409 IDF 405, IDF 406, IDF 407, IDF 408, IDF 409 ID 405, ID 406, ID 407, ID 408, ID 409					
Φ41.0 ~Φ41.4	YTDI 410 □ FSL KRUZ 410 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	272 354 436 559	202 284 366 489	164 246 328 451		IDP 410, IDP 411, IDP 412, IDP 413, IDP 414 IDF 410, IDF 411, IDF 412, IDF 413, IDF 414 ID 410, ID 411, ID 412, ID 413, ID 414					
Φ41.5 ~Φ41.9	YTDI 415 □ FSL KRUZ 415 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	275 358 441 566	205 288 371 496	166 249 332 457		IDP 415, IDP 416, IDP 417, IDP 418, IDP 419 IDF 415, IDF 416, IDF 417, IDF 418, IDF 419 ID 415, ID 416, ID 417, ID 418, ID 419					
Φ42.0 ~Φ42.4	YTDI 420 □ FSL KRUZ 420 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	277 361 445 571	207 291 375 501	168 252 336 462		IDP 420, IDP 421, IDP 422, IDP 423, IDP 424 IDF 420, IDF 421, IDF 422, IDF 423, IDF 424 ID 420, ID 421, ID 422, ID 423, ID 424					
Φ42.5 ~Φ42.9	YTDI 425 □ FSL KRUZ 425 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	279 364 449 577	209 294 379 507	170 255 340 468		IDP 425, IDP 426, IDP 427, IDP 428, IDP 429 IDF 425, IDF 426, IDF 427, IDF 428, IDF 429 ID 425, ID 426, ID 427, ID 428, ID 429					
Φ43.0 ~Φ43.4	YTDI 430 □ FSL KRUZ 430 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	282 368 454 583	212 298 384 513	172 258 344 473		IDP 430, IDP 431, IDP 432, IDP 433, IDP 434 IDF 430, IDF 431, IDF 432, IDF 433, IDF 434 ID 430, ID 431, ID 432, ID 433, ID 434					
Φ43.5 ~Φ43.9	YTDI 435 □ FSL KRUZ 435 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	284 371 458 589	214 301 388 519	174 261 348 479		IDP 435, IDP 436, IDP 437, IDP 438, IDP 439 IDF 435, IDF 436, IDF 437, IDF 438, IDF 439 ID 435, ID 436, ID 437, ID 438, ID 439					
Φ44.0 ~Φ44.4	YTDI 440 □ FSL KRUZ 440 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	287 375 463 595	217 305 393 525	176 264 352 484		IDP 440, IDP 441, IDP 442, IDP 443, IDP 444 IDF 440, IDF 441, IDF 442, IDF 443, IDF 444 ID 440, ID 441, ID 442, ID 443, ID 444					

KRUZ-FSL、YTDI-FSL型法兰刀体与硬质合金钻尖

孔径范围	刀体型号	刀柄尺寸 (Φd)	切削深度 (倍×孔径)	L1	L2	L3	法兰直径 (ΦFd)	适合刀体的刀片型号	锁紧螺栓	梅花型螺批	定位螺钉	"L"型内六角扳手
Φ44.5 ~Φ44.9	YTDI 445 □ FSL KRUZ 445 □ FSL	40.0	T(3xD) P(5xD) H(7xD) L(10xD)	289 378 467 601	219 308 397 531	178 267 356 490	55	IDP 445, IDP 446, IDP 447, IDP 448, IDP 449 IDF 445, IDF 446, IDF 447, IDF 448, IDF 449 ID 445, ID 446, ID 447, ID 448, ID 449	CS 400 ~445 SL			
Φ45.0 ~Φ45.4	YTDI 450 □ FSL KRUZ 450 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	291 381 471 606	221 311 401 536	180 270 360 495		IDP 450, IDP 451, IDP 452, IDP 453, IDP 454 IDF 450, IDF 451, IDF 452, IDF 453, IDF 454 ID 450, ID 451, ID 452, ID 453, ID 454				
Φ45.5 ~Φ45.9	YTDI 455 □ FSL KRUZ 455 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	294 385 476 613	224 315 406 543	182 273 364 501		IDP 455, IDP 456, IDP 457, IDP 458, IDP 459 IDF 455, IDF 456, IDF 457, IDF 458, IDF 459 ID 455, ID 456, ID 457, ID 458, ID 459				
Φ46.0 ~Φ46.4	YTDI 460 □ FSL KRUZ 460 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	296 388 480 618	226 318 410 548	184 276 368 506		IDP 460, IDP 461, IDP 462, IDP 463, IDP 464 IDF 460, IDF 461, IDF 462, IDF 463, IDF 464 ID 460, ID 461, ID 462, ID 463, ID 464				
Φ46.5 ~Φ46.9	YTDI 465 □ FSL KRUZ 465 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	299 392 485 625	229 322 415 555	186 279 372 512		IDP 465, IDP 466, IDP 467, IDP 468, IDP 469 IDF 465, IDF 466, IDF 467, IDF 468, IDF 469 ID 465, ID 466, ID 467, ID 468, ID 469				
Φ47.0 ~Φ47.4	YTDI 470 □ FSL KRUZ 470 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	301 395 489 630	231 325 419 560	188 282 376 517		IDP 470, IDP 471, IDP 472, IDP 473, IDP 474 IDF 470, IDF 471, IDF 472, IDF 473, IDF 474 ID 470, ID 471, ID 472, ID 473, ID 474				
Φ47.5 ~Φ47.9	YTDI 475 □ FSL KRUZ 475 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	303 398 493 636	233 328 423 566	190 285 380 523		IDP 475, IDP 476, IDP 477, IDP 478, IDP 479 IDF 475, IDF 476, IDF 477, IDF 478, IDF 479 ID 475, ID 476, ID 477, ID 478, ID 479				
Φ48.0 ~Φ48.4	YTDI 480 □ FSL KRUZ 480 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	306 402 498 642	236 332 428 572	192 288 384 528		IDP 480, IDP 481, IDP 482, IDP 483, IDP 484 IDF 480, IDF 481, IDF 482, IDF 483, IDF 484 ID 480, ID 481, ID 482, ID 483, ID 484				
Φ48.5 ~Φ48.9	YTDI 485 □ FSL KRUZ 485 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	308 405 502 648	238 335 432 578	194 291 388 534		IDP 485, IDP 486, IDP 487, IDP 488, IDP 489 IDF 485, IDF 486, IDF 487, IDF 488, IDF 489 ID 485, ID 486, ID 487, ID 488, ID 489				
Φ49.0 ~Φ49.4	YTDI 490 □ FSL KRUZ 490 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	311 409 507 654	241 339 437 584	196 294 392 539		IDP 490, IDP 491, IDP 492, IDP 493, IDP 494 IDF 490, IDF 491, IDF 492, IDF 493, IDF 494 ID 490, ID 491, ID 492, ID 493, ID 494				
Φ49.5 ~Φ49.9	YTDI 495 □ FSL KRUZ 495 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	313 412 511 660	243 342 441 590	198 297 396 545		IDP 495, IDP 496, IDP 497, IDP 498, IDP 499 IDF 495, IDF 496, IDF 497, IDF 498, IDF 499 ID 495, ID 496, ID 497, ID 498, ID 499				
Φ50.0 ~Φ50.4	YTDI 500 □ FSL KRUZ 500 □ FSL		T(3xD) P(5xD) H(7xD) L(10xD)	315 415 515 665	245 345 445 595	200 300 400 550		IDP 500, IDP 501, IDP 502, IDP 503, IDP 504 IDF 500, IDF 501, IDF 502, IDF 503, IDF 504 ID 500, ID 501, ID 502, ID 503, ID 504				

KRUZ-FSL钻头系列, 推荐切削参数

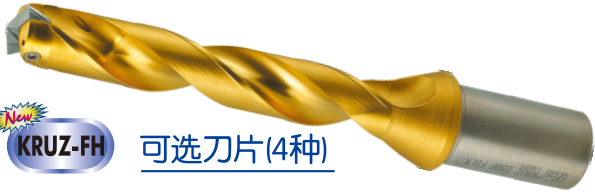
工件材质	钻头直径 切削参数	Φ8~16mm		Φ16~25mm		Φ25~32mm		Φ32~40mm		Φ40~50mm	
		线速度 (m/分钟)	进给量 (mm/转)	线速度 (m/分钟)	进给量 (mm/转)	线速度 (m/分钟)	进给量 (mm/转)	线速度 (m/分钟)	进给量 (mm/转)	线速度 (m/分钟)	进给量 (mm/转)
灰口铸铁 (FC)		80~150	0.20~0.30	80~150	0.25~0.45	80~160	0.35~0.55	90~200	0.34~0.58	90~200	0.38~0.60
球墨铸铁 (FCD)		80~140	0.15~0.25	80~140	0.22~0.45	80~150	0.32~0.52	90~160	0.35~0.62	90~200	0.38~0.60
中碳钢 (S45C)		80~140	0.15~0.30	80~140	0.16~0.40	80~150	0.20~0.40	80~150	0.22~0.48	80~160	0.25~0.54
合金钢 (SCM440)		70~140	0.15~0.30	70~140	0.15~0.40	70~140	0.18~0.40	80~140	0.25~0.47	80~140	0.27~0.52
淬硬钢 (SKD11)		40~50	0.10~0.20	40~50	0.12~0.28	40~50	0.16~0.35	40~60	0.20~0.38	40~60	0.22~0.42
不锈钢 (SUS)		30~40	0.10~0.20	35~50	0.10~0.22	35~50	0.15~0.28	40~55	0.18~0.30	40~55	0.22~0.32
铝 130HB (AL)		120~200	0.20~0.30	120~200	0.25~0.40	120~200	0.30~0.45	120~200	0.30~0.45	120~200	0.30~0.50

- ☞ 上述推荐切削参数以3xD为准。当在5xD, 7xD或10xD时, 根据工况下降15~20%切削速度。
- ☞ 上述推荐切削参数以正常工况和油污冷却(MQL)为准。
- 如果加工设备(机床)状态不好, 或工件夹具(JIG)不合理, 就会影响最佳切削速度的发挥。



KRUZ "H"系列, 法兰+大螺旋角刀体与硬质合金钻尖

注意 >> "H"系列刀体, 只专用"H"系列钻尖(刀片), 请勿失误。



可选刀片(4种)

- IDPH 适于加工深孔和通用
- IDFH 适于加工薄板和浅孔
- IDH 通用刀片
- IDSH 适于加工不锈钢, 钛或特殊材料



KRUZ-FH 刀体

YTDI-FH 刀体

订货时, 请在口内标注孔深。如: T(3倍孔径), P(5倍孔径), H(7倍孔径), L(10倍孔径---->Φ11.0mm以上)

孔径范围	刀体型号	刀柄尺寸 (Φd)	切削深度 (倍×孔径)	L1	L2	L3	法兰直径 (ΦFd)	适合刀体的刀片型号	锁紧螺栓	梅花型螺批	定位螺钉	"L"型内六角扳手
Φ12.0 ~Φ12.4	YTDI 120 □ FH KRUZ 120 □ FH	16.0	T(3xD) P(5xD) H(7xD) L(10xD)	109 133 157 193	61 85 109 145	48 72 96 132	21	IDPH 120, IDPH 121, IDPH 122, IDPH 123, IDPH 124 IDFH 120, IDFH 121, IDFH 122, IDFH 123, IDFH 124 IDH 120, IDH 121, IDH 122, IDH 123, IDH 124 IDSH 120, IDSH 121, IDSH 122, IDSH 123, IDSH 124	CS120 ~135 SL	T6 扭矩 0.6Nm (最大)		
Φ12.5 ~Φ12.9	YTDI 125 □ FH KRUZ 125 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	111 136 161 199	63 88 113 151	50 75 100 138		IDPH 125, IDPH 126, IDPH 127, IDPH 128, IDPH 129 IDFH 125, IDFH 126, IDFH 127, IDFH 128, IDFH 129 IDH 125, IDH 126, IDH 127, IDH 128, IDH 129 IDSH 125, IDSH 126, IDSH 127, IDSH 128, IDSH 129				
Φ13.0 ~Φ13.4	YTDI 130 □ FH KRUZ 130 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	114 140 166 205	66 92 118 157	52 78 104 143		IDPH 130, IDPH 131, IDPH 132, IDPH 133, IDPH 134 IDFH 130, IDFH 131, IDFH 132, IDFH 133, IDFH 134 IDH 130, IDH 131, IDH 132, IDH 133, IDH 134 IDSH 130, IDSH 131, IDSH 132, IDSH 133, IDSH 134				
Φ13.5 ~Φ13.9	YTDI 135 □ FH KRUZ 135 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	116 143 170 211	68 95 122 163	54 81 108 149		IDPH 135, IDPH 136, IDPH 137, IDPH 138, IDPH 139 IDFH 135, IDFH 136, IDFH 137, IDFH 138, IDFH 139 IDH 135, IDH 136, IDH 137, IDH 138, IDH 139 IDSH 135, IDSH 136, IDSH 137, IDSH 138, IDSH 139				
Φ14.0 ~Φ14.4	YTDI 140 □ FH KRUZ 140 □ FH	20.0	T(3xD) P(5xD) H(7xD) L(10xD)	119 147 175 217	71 99 127 169	56 84 112 154	27	IDPH 140, IDPH 141, IDPH 142, IDPH 143, IDPH 144 IDFH 140, IDFH 141, IDFH 142, IDFH 143, IDFH 144 IDH 140, IDH 141, IDH 142, IDH 143, IDH 144 IDSH 140, IDSH 141, IDSH 142, IDSH 143, IDSH 144	CS140 ~155 SL	T7 扭矩 0.9Nm (最大)	M2.5x4	1.3mm
Φ14.5 ~Φ14.9	YTDI 145 □ FH KRUZ 145 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	123 152 181 225	73 102 131 175	58 87 116 160		IDPH 145, IDPH 146, IDPH 147, IDPH 148, IDPH 149 IDFH 145, IDFH 146, IDFH 147, IDFH 148, IDFH 149 IDH 145, IDH 146, IDH 147, IDH 148, IDH 149 IDSH 145, IDSH 146, IDSH 147, IDSH 148, IDSH 149				
Φ15.0 ~Φ15.4	YTDI 150 □ FH KRUZ 150 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	127 157 187 232	77 107 137 182	60 90 120 165		IDPH 150, IDPH 151, IDPH 152, IDPH 153, IDPH 154 IDFH 150, IDFH 151, IDFH 152, IDFH 153, IDFH 154 IDH 150, IDH 151, IDH 152, IDH 153, IDH 154 IDSH 150, IDSH 151, IDSH 152, IDSH 153, IDSH 154				

10
Yes®

1'
Yes



KRUZ "H"系列， 法兰+大螺旋角刀体与硬质合金钻尖

孔径 范围	刀体型号	刀柄尺寸 (Φd)	切削深度 (倍 x 孔径)	L1	L2	L3	法兰直径 (Φfd)	适合刀体的刀片型号	IDPHIDFHIDHIDSH	锁紧螺栓	梅花型螺批	定位螺钉	1°型内六角扳手
Φ30.5 ~Φ30.9	YTDI 305 □ FH KRUZ 305 □ FH	32.0	T(3xD) P(5xD) H(7xD) L(10xD)	212 273 334 426	152 213 274 366	122 183 244 336	39	IDPH 305, IDPH 306, IDPH 307, IDPH 308, IDPH 309 IDFH 305, IDFH 306, IDFH 307, IDFH 308, IDFH 309 IDH 305, IDH 306, IDH 307, IDH 308, IDH 309 IDSH 305, IDSH 306, IDSH 307, IDSH 308, IDSH 309	   			M4x8	2.0mm
Φ31.0 ~Φ31.4	YTDI 310 □ FH KRUZ 310 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	214 276 338 431	154 216 278 371	124 186 248 341		IDPH 310, IDPH 311, IDPH 312, IDPH 313, IDPH 314 IDFH 310, IDFH 311, IDFH 312, IDFH 313, IDFH 314 IDH 310, IDH 311, IDH 312, IDH 313, IDH 314 IDSH 310, IDSH 311, IDSH 312, IDSH 313, IDSH 314					
Φ31.5 ~Φ31.9	YTDI 315 □ FH KRUZ 315 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	217 280 343 438	157 220 283 378	126 189 252 347		IDPH 315, IDPH 316, IDPH 317, IDPH 318, IDPH 319 IDFH 315, IDFH 316, IDFH 317, IDFH 318, IDFH 319 IDH 315, IDH 316, IDH 317, IDH 318, IDH 319 IDSH 315, IDSH 316, IDSH 317, IDSH 318, IDSH 319					
Φ32.0 ~Φ32.4	YTDI 320 □ FH KRUZ 320 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	219 283 347 443	159 223 287 383	128 192 256 352		IDPH 320, IDPH 321, IDPH 322, IDPH 323, IDPH 324 IDFH 320, IDFH 321, IDFH 322, IDFH 323, IDFH 324 IDH 320, IDH 321, IDH 322, IDH 323, IDH 324 IDSH 320, IDSH 321, IDSH 322, IDSH 323, IDSH 324					
Φ32.5 ~Φ32.9	YTDI 325 □ FH KRUZ 325 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	221 286 351 449	161 226 291 389	130 195 260 358		IDPH 325, IDPH 326, IDPH 327, IDPH 328, IDPH 329 IDFH 325, IDFH 326, IDFH 327, IDFH 328, IDFH 329 IDH 325, IDH 326, IDH 327, IDH 328, IDH 329 IDSH 325, IDSH 326, IDSH 327, IDSH 328, IDSH 329					
Φ33.0 ~Φ33.4	YTDI 330 □ FH KRUZ 330 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	224 290 356 455	164 230 296 395	132 198 264 363		IDPH 330, IDPH 331, IDPH 332, IDPH 333, IDPH 334 IDFH 330, IDFH 331, IDFH 332, IDFH 333, IDFH 334 IDH 330, IDH 331, IDH 332, IDH 333, IDH 334 IDSH 330, IDSH 331, IDSH 332, IDSH 333, IDSH 334					
Φ33.5 ~Φ33.9	YTDI 335 □ FH KRUZ 335 □ FH	40.0	T(3xD) P(5xD) H(7xD) L(10xD)	226 293 360 461	166 233 300 401	134 201 268 369	55	IDPH 335, IDPH 336, IDPH 337, IDPH 338, IDPH 339 IDFH 335, IDFH 336, IDFH 337, IDFH 338, IDFH 339 IDH 335, IDH 336, IDH 337, IDH 338, IDH 339 IDSH 335, IDSH 336, IDSH 337, IDSH 338, IDSH 339	   			M5x10	2.5mm
Φ34.0 ~Φ34.4	YTDI 340 □ FH KRUZ 340 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	239 307 375 477	169 237 305 407	136 204 272 374		IDPH 340, IDPH 341, IDPH 342, IDPH 343, IDPH 344 IDFH 340, IDFH 341, IDFH 342, IDFH 343, IDFH 344 IDH 340, IDH 341, IDH 342, IDH 343, IDH 344 IDSH 340, IDSH 341, IDSH 342, IDSH 343, IDSH 344					
Φ34.5 ~Φ34.9	YTDI 345 □ FH KRUZ 345 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	241 310 379 483	171 240 309 413	138 207 276 380		IDPH 345, IDPH 346, IDPH 347, IDPH 348, IDPH 349 IDFH 345, IDFH 346, IDFH 347, IDFH 348, IDFH 349 IDH 345, IDH 346, IDH 347, IDH 348, IDH 349 IDSH 345, IDSH 346, IDSH 347, IDSH 348, IDSH 349					
Φ35.0 ~Φ35.4	YTDI 350 □ FH KRUZ 350 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	243 313 383 488	173 243 313 418	140 210 280 385		IDPH 350, IDPH 351, IDPH 352, IDPH 353, IDPH 354 IDFH 350, IDFH 351, IDFH 352, IDFH 353, IDFH 354 IDH 350, IDH 351, IDH 352, IDH 353, IDH 354 IDSH 350, IDSH 351, IDSH 352, IDSH 353, IDSH 354					
Φ35.5 ~Φ35.9	YTDI 355 □ FH KRUZ 355 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	246 317 388 495	176 247 318 425	142 213 284 391		IDPH 355, IDPH 356, IDPH 357, IDPH 358, IDPH 359 IDFH 355, IDFH 356, IDFH 357, IDFH 358, IDFH 359 IDH 355, IDH 356, IDH 357, IDH 358, IDH 359 IDSH 355, IDSH 356, IDSH 357, IDSH 358, IDSH 359					
Φ36.0 ~Φ36.4	YTDI 360 □ FH KRUZ 360 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	248 320 392 500	178 250 322 430	144 216 288 396		IDPH 360, IDPH 361, IDPH 362, IDPH 363, IDPH 364 IDFH 360, IDFH 361, IDFH 362, IDFH 363, IDFH 364 IDH 360, IDH 361, IDH 362, IDH 363, IDH 364 IDSH 360, IDSH 361, IDSH 362, IDSH 363, IDSH 364					
Φ36.5 ~Φ36.9	YTDI 365 □ FH KRUZ 365 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	251 324 397 507	181 254 327 437	146 219 292 402		IDPH 365, IDPH 366, IDPH 367, IDPH 368, IDPH 369 IDFH 365, IDFH 366, IDFH 367, IDFH 368, IDFH 369 IDH 365, IDH 366, IDH 367, IDH 368, IDH 369 IDSH 365, IDSH 366, IDSH 367, IDSH 368, IDSH 369					
Φ37.0 ~Φ37.4	YTDI 370 □ FH KRUZ 370 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	253 327 401 512	183 257 331 442	148 222 296 407		IDPH 370, IDPH 371, IDPH 372, IDPH 373, IDPH 374 IDFH 370, IDFH 371, IDFH 372, IDFH 373, IDFH 374 IDH 370, IDH 371, IDH 372, IDH 373, IDH 374 IDSH 370, IDSH 371, IDSH 372, IDSH 373, IDSH 374					
Φ37.5 ~Φ37.9	YTDI 375 □ FH KRUZ 375 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	255 330 405 518	185 260 335 448	150 225 300 413		IDPH 375, IDPH 376, IDPH 377, IDPH 378, IDPH 379 IDFH 375, IDFH 376, IDFH 377, IDFH 378, IDFH 379 IDH 375, IDH 376, IDH 377, IDH 378, IDH 379 IDSH 375, IDSH 376, IDSH 377, IDSH 378, IDSH 379					

孔径 范围	刀体型号	刀柄尺寸 (Φd)	切削深度 (倍 x 孔径)	L1	L2	L3	法兰直径 (Φfd)	适合刀体的刀片型号	IDPHIDFHIDHIDSH	锁紧螺栓	梅花型螺批	定位螺钉	1°型内六角扳手
Φ38.0 ~Φ38.4	YTDI 380 □ FH KRUZ 380 □ FH	40.0	T(3xD) P(5xD) H(7xD) L(10xD)	258 334 410 524	188 264 340 454	152 228 304 418	55	IDPH 380, IDPH 381, IDPH 382, IDPH 383, IDPH 384 IDFH 380, IDFH 381, IDFH 382, IDFH 383, IDFH 384 IDH 380, IDH 381, IDH 382, IDH 383, IDH 384 IDSH 380, IDSH 381, IDSH 382, IDSH 383, IDSH 384	   			M5x10	2.5mm
Φ38.5 ~Φ38.9	YTDI 385 □ FH KRUZ 385 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	260 337 414 530	196 267 344 460	154 231 308 424		IDPH 385, IDPH 386, IDPH 387, IDPH 388, IDPH 389 IDFH 385, IDFH 386, IDFH 387, IDFH 388, IDFH 389 IDH 385, IDH 386, IDH 387, IDH 388, IDH 389 IDSH 385, IDSH 386, IDSH 387, IDSH 388, IDSH 389					
Φ39.0 ~Φ39.4	YTDI 390 □ FH KRUZ 390 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	263 341 419 536	193 271 349 466	156 234 312 429		IDPH 390, IDPH 391, IDPH 392, IDPH 393, IDPH 394 IDFH 390, IDFH 391, IDFH 392, IDFH 393, IDFH 394 IDH 390, IDH 391, IDH 392, IDH 393, IDH 394 IDSH 390, IDSH 391, IDSH 392, IDSH 393, IDSH 394					
Φ39.5 ~Φ39.9	YTDI 395 □ FH KRUZ 395 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	265 344 423 542	195 274 353 472	158 237 316 435		IDPH 395, IDPH 396, IDPH 397, IDPH 398, IDPH 399 IDFH 395, IDFH 396, IDFH 397, IDFH 398, IDFH 399 IDH 395, IDH 396, IDH 397, IDH 398, IDH 399 IDSH 395, IDSH 396, IDSH 397, IDSH 398, IDSH 399					
Φ40.0 ~Φ40.4	YTDI 400 □ FH KRUZ 400 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	267 347 427 547	197 277 357 477	160 240 320 440		IDPH 400, IDPH 401, IDPH 402, IDPH 403, IDPH 404 IDFH 400, IDFH 401, IDFH 402, IDFH 403, IDFH 404 IDH 400, IDH 401, IDH 402, IDH 403, IDH 404 IDSH 400, IDSH 401, IDSH 402, IDSH 403, IDSH 404					
Φ40.5 ~Φ40.9	YTDI 405 □ FH KRUZ 405 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	270 351 432 554	200 281 362 484	162 243 324 446		IDPH 405, IDPH 406, IDPH 407, IDPH 408, IDPH 409 IDFH 405, IDFH 406, IDFH 407, IDFH 408, IDFH 409 IDH 405, IDH 406, IDH 407, IDH 408, IDH 409 IDSH 405, IDSH 406, IDSH 407, IDSH 408, IDSH 409					
Φ41.0 ~Φ41.4	YTDI 410 □ FH KRUZ 410 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	272 354 436 559	202 284 366 489	164 246 328 451		IDPH 410, IDPH 411, IDPH 412, IDPH 413, IDPH 414 IDFH 410, IDFH 411, IDFH 412, IDFH 413, IDFH 414 IDH 410, IDH 411, IDH 412, IDH 413, IDH 414 IDSH 410, IDSH 411, IDSH 412, IDSH 413, IDSH 414					
Φ41.5 ~Φ41.9	YTDI 415 □ FH KRUZ 415 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	275 358 441 566	205 288 371 496	166 249 332 457		IDPH 415, IDPH 416, IDPH 417, IDPH 418, IDPH 419 IDFH 415, IDFH 416, IDFH 417, IDFH 418, IDFH 419 IDH 415, IDH 416, IDH 417, IDH 418, IDH 419 IDSH 415, IDSH 416, IDSH 417, IDSH 418, IDSH 419					
Φ42.0 ~Φ42.4	YTDI 420 □ FH KRUZ 420 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	277 361 445 571	207 291 375 501	168 252 336 462		IDPH 420, IDPH 421, IDPH 422, IDPH 423, IDPH 424 IDFH 420, IDFH 421, IDFH 422, IDFH 423, IDFH 424 IDH 420, IDH 421, IDH 422, IDH 423, IDH 424 IDSH 420, IDSH 421, IDSH 422, IDSH 423, IDSH 424					
Φ42.5 ~Φ42.9	YTDI 425 □ FH KRUZ 425 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	279 364 449 577	209 294 379 507	170 255 340 468		IDPH 425, IDPH 426, IDPH 427, IDPH 428, IDPH 429 IDFH 425, IDFH 426, IDFH 427, IDFH 428, IDFH 429 IDH 425, IDH 426, IDH 427, IDH 428, IDH 429 IDSH 425, IDSH 426, IDSH 427, IDSH 428, IDSH 429					
Φ43.0 ~Φ43.4	YTDI 430 □ FH KRUZ 430 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	282 368 454 583	212 298 384 513	172 258 344 473		IDPH 430, IDPH 431, IDPH 432, IDPH 433, IDPH 434 IDFH 430, IDFH 431, IDFH 432, IDFH 433, IDFH 434 IDH 430, IDH 431, IDH 432, IDH 433, IDH 434 IDSH 430, IDSH 431, IDSH 432, IDSH 433, IDSH 434					
Φ43.5 ~Φ43.9	YTDI 435 □ FH KRUZ 435 □ FH	40.0	T(3xD) P(5xD) H(7xD) L(10xD)	284 371 458 589	214 301 388 519	174 261 348 479	55	IDPH 435, IDPH 436, IDPH 437, IDPH 438, IDPH 439 IDFH 435, IDFH 436, IDFH 437, IDFH 438, IDFH 439 IDH 435, IDH 436, IDH 437, IDH 438, IDH 439 IDSH 435, IDSH 436, IDSH 437, IDSH 438, IDSH 439	   			M6x12	3.0mm
Φ44.0 ~Φ44.4	YTDI 440 □ FH KRUZ 440 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	287 375 463 595	217 305 393 525	176 264 352 484		IDPH 440, IDPH 441, IDPH 442, IDPH 443, IDPH 444 IDFH 440, IDFH 441, IDFH 442, IDFH 443, IDFH 444 IDH 440, IDH 441, IDH 442, IDH 443, IDH 444 IDSH 440, IDSH 441, IDSH 442, IDSH 443, IDSH 444					
Φ44.5 ~Φ44.9	YTDI 445 □ FH KRUZ 445 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	289 378 467 601	219 308 397 531	178 267 356 490		IDPH 445, IDPH 446, IDPH 447, IDPH 448, IDPH 449 IDFH 445, IDFH 446, IDFH 447, IDFH 448, IDFH 449 IDH 445, IDH 446, IDH 447, IDH 448, IDH 449 IDSH 445, IDSH 446, IDSH 447, IDSH 448, IDSH 449					
Φ45.0 ~Φ45.4	YTDI 450 □ FH KRUZ 450 □ FH		T(3xD) P(5xD) H(7xD) L(10xD)	291 381 471 606	221 311 401 536	180 270 360 495		IDPH 450, IDPH 451, IDPH 452, IDPH 453, IDPH 454 IDFH 450, IDFH 451, IDFH 452, IDFH 453, IDFH 454 IDH 450, IDH 451, IDH 452, IDH 453, IDH 454 IDSH 450, IDSH 451, IDSH 452, IDSH 453, IDSH 454					

New

KRUZ "H"系列， 法兰+大螺旋角刀体与硬质合金钻尖

孔径 范围	刀体型号	刀柄尺寸 (Φd)	切削深度 (倍×孔径)	L1	L2	L3	法兰直径 (Φd)	适合刀体的刀片型号	IDPH	IDFH	IDH	IDSH	锁紧螺栓	梅花型螺栓	定位螺钉	1°型内六角扳手
Φ45.5 ~Φ45.9	YTDI 455 □ FH KRUZ 455 □ FH	40.0	T(3xD)	294	224	182	55	IDPH 455, IDPH 456, IDPH 457, IDPH 458, IDPH 459 IDFH 455, IDFH 456, IDFH 457, IDFH 458, IDFH 459 IDH 455, IDH 456, IDH 457, IDH 458, IDH 459 IDSH 455, IDSH 456, IDSH 457, IDSH 458, IDSH 459								
			P(5xD)	385	315	273										
			H(7xD)	476	406	364										
			L(10xD)	613	543	501										
Φ46.0 ~Φ46.4	YTDI 460 □ FH KRUZ 460 □ FH		T(3xD)	296	226	184		IDPH 460, IDPH 461, IDPH 462, IDPH 463, IDPH 464 IDFH 460, IDFH 461, IDFH 462, IDFH 463, IDFH 464 IDH 460, IDH 461, IDH 462, IDH 463, IDH 464 IDSH 460, IDSH 461, IDSH 462, IDSH 463, IDSH 464								
			P(5xD)	388	318	276										
			H(7xD)	480	410	368										
			L(10xD)	618	548	506										
Φ46.5 ~Φ46.9	YTDI 465 □ FH KRUZ 465 □ FH		T(3xD)	299	229	186		IDPH 465, IDPH 466, IDPH 467, IDPH 468, IDPH 469 IDFH 465, IDFH 466, IDFH 467, IDFH 468, IDFH 469 IDH 465, IDH 466, IDH 467, IDH 468, IDH 469 IDSH 465, IDSH 466, IDSH 467, IDSH 468, IDSH 469								
			P(5xD)	392	322	279										
			H(7xD)	485	415	372										
			L(10xD)	625	555	512										
Φ47.0 ~Φ47.4	YTDI 470 □ FH KRUZ 470 □ FH		T(3xD)	301	231	188		IDPH 470, IDPH 471, IDPH 472, IDPH 473, IDPH 474 IDFH 470, IDFH 471, IDFH 472, IDFH 473, IDFH 474 IDH 470, IDH 471, IDH 472, IDH 473, IDH 474 IDSH 470, IDSH 471, IDSH 472, IDSH 473, IDSH 474								
			P(5xD)	395	325	282										
			H(7xD)	489	419	376										
			L(10xD)	630	560	517										
Φ47.5 ~Φ47.9	YTDI 475 □ FH KRUZ 475 □ FH		T(3xD)	303	233	190		IDPH 475, IDPH 476, IDPH 477, IDPH 478, IDPH 479 IDFH 475, IDFH 476, IDFH 477, IDFH 478, IDFH 479 IDH 475, IDH 476, IDH 477, IDH 478, IDH 479 IDSH 475, IDSH 476, IDSH 477, IDSH 478, IDSH 479								
			P(5xD)	398	328	285										
			H(7xD)	493	423	380										
			L(10xD)	636	566	523										
Φ48.0 ~Φ48.4	YTDI 480 □ FH KRUZ 480 □ FH		T(3xD)	306	236	192		IDPH 480, IDPH 481, IDPH 482, IDPH 483, IDPH 484 IDFH 480, IDFH 481, IDFH 482, IDFH 483, IDFH 484 IDH 480, IDH 481, IDH 482, IDH 483, IDH 484 IDSH 480, IDSH 481, IDSH 482, IDSH 483, IDSH 484								
			P(5xD)	402	332	288										
			H(7xD)	498	428	384										
			L(10xD)	642	572	528										
Φ48.5 ~Φ48.9	YTDI 485 □ FH KRUZ 485 □ FH		T(3xD)	308	238	194		IDPH 485, IDPH 486, IDPH 487, IDPH 488, IDPH 489 IDFH 485, IDFH 486, IDFH 487, IDFH 488, IDFH 489 IDH 485, IDH 486, IDH 487, IDH 488, IDH 489 IDSH 485, IDSH 486, IDSH 487, IDSH 488, IDSH 489								
			P(5xD)	405	335	291										
			H(7xD)	502	432	388										
			L(10xD)	648	578	534										
Φ49.0 ~Φ49.4	YTDI 490 □ FH KRUZ 490 □ FH		T(3xD)	311	241	196		IDPH 490, IDPH 491, IDPH 492, IDPH 493, IDPH 494 IDFH 490, IDFH 491, IDFH 492, IDFH 493, IDFH 494 IDH 490, IDH 491, IDH 492, IDH 493, IDH 494 IDSH 490, IDSH 491, IDSH 492, IDSH 493, IDSH 494								
			P(5xD)	409	339	294										
			H(7xD)	507	437	392										
			L(10xD)	654	584	539										
Φ49.5 ~Φ49.9	YTDI 495 □ FH KRUZ 495 □ FH		T(3xD)	313	243	198		IDPH 495, IDPH 496, IDPH 497, IDPH 498, IDPH 499 IDFH 495, IDFH 496, IDFH 497, IDFH 498, IDFH 499 IDH 495, IDH 496, IDH 497, IDH 498, IDH 499 IDSH 495, IDSH 496, IDSH 497, IDSH 498, IDSH 499								
			P(5xD)	412	342	297										
			H(7xD)	511	441	396										
			L(10xD)	660	590	545										
Φ50.0 ~Φ50.4	YTDI 500 □ FH KRUZ 500 □ FH		T(3xD)	315	245	200		IDPH 500, IDPH 501, IDPH 502, IDPH 503, IDPH 504 IDFH 500, IDFH 501, IDFH 502, IDFH 503, IDFH 504 IDH 500, IDH 501, IDH 502, IDH 503, IDH 504 IDSH 500, IDSH 501, IDSH 502, IDSH 503, IDSH 504								
			P(5xD)	415	345	300										
			H(7xD)	515	445	400										
			L(10xD)	665	595	550										

KRUZ-FH钻头系列, 推荐切削参数

工件材质	钻头直径 切削参数	Φ8~16mm		Φ16~25mm		Φ25~32mm		Φ32~40mm		Φ40~50mm	
		线速度 (m/分钟)	进给量 (mm/转)	线速度 (m/分钟)	进给量 (mm/转)	线速度 (m/分钟)	进给量 (mm/转)	线速度 (m/分钟)	进给量 (mm/转)	线速度 (m/分钟)	进给量 (mm/转)
灰口铸铁 (FC)		80~150	0.20~0.30	80~150	0.25~0.45	80~160	0.35~0.55	90~200	0.34~0.58	90~200	0.38~0.60
球墨铸铁 (FCD)		80~140	0.15~0.25	80~140	0.22~0.45	80~150	0.32~0.52	90~160	0.35~0.62	90~200	0.38~0.60
中碳钢 (S45C)		80~140	0.15~0.30	80~140	0.16~0.40	80~150	0.20~0.40	80~150	0.22~0.48	80~160	0.25~0.54
合金钢 (SCM440)		70~140	0.15~0.30	70~140	0.15~0.40	70~140	0.18~0.40	80~140	0.25~0.47	80~140	0.27~0.52
淬硬钢 (SKD11)		40~50	0.10~0.20	40~50	0.12~0.28	40~50	0.16~0.35	40~60	0.20~0.38	40~60	0.22~0.42
不锈钢 (SUS)		30~40	0.10~0.20	35~50	0.10~0.22	35~50	0.15~0.28	40~55	0.18~0.30	40~55	0.22~0.32
铝 130HB (AL)		120~200	0.20~0.30	120~200	0.25~0.40	120~200	0.30~0.45	120~200	0.30~0.45	120~200	0.30~0.50

☞ 上述推荐切削参数以3xD为准。当在5xD, 7xD或10xD时, 根据工况下降15~20%切削速度。
☞ 上述推荐切削参数以正常工况和油污冷却(MQL)为准。
如果加工设备(机床)状态不好, 或工件夹具(JIG)不合理, 就会影响最佳切削速度的发挥。

New

KRUZ "K"系列刀体与硬质合金钻尖

注意 !!!

"K"系列钻尖(IDFK或IDPK),
只专用"K"系列刀体(KRUZ-SLK或FSLK), 请勿失误。

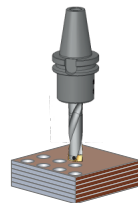
IDFK 硬质合金钻尖(刀片)

- 硬质合金刀片, 全部由CNC磨削程序来完成
- 140°+170°双角度结合平底钻尖, 是我公司的专利品
- TiAlN涂层钻尖, 具有优秀耐磨性和高进给加工性能
- 该系列是对型钢、角钢或薄板的钻孔, 针对性地设计的产物



IDPK 硬质合金钻尖(刀片)

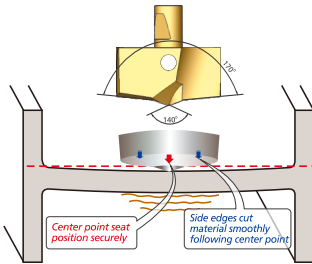
- 硬质合金刀片, 全部由CNC磨削程序来完成
- 130°+150°双角度结合钻尖角, 是我公司的专利品
- TiAlN涂层钻尖, 具有优秀耐磨性和高进给加工性能
- 优化的合理设计结构, 适于多层叠加薄板的孔加工



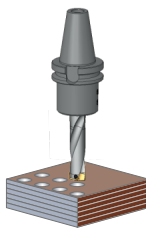
(多层叠加的钢板)

KRUZ-SLK 钻头刀体

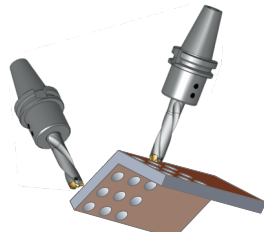
- 刀体采用经过特殊热处理的优质工具钢, 具有很好的刚性
- TiN涂层的刀体, 保证更长的刀具寿命和更好的润滑性能
- 经特殊设计的螺旋角和容屑槽, 增加排屑性能, 使屑更快地向外弹出
- 在0.5mm范围内, 可通用IDFK与IDPK钻尖(刀片)
- 短而粗的刀体结构, 对结构钢可最大发挥钻孔能力
- 内冷设计, 提高效率、延长刀具寿命



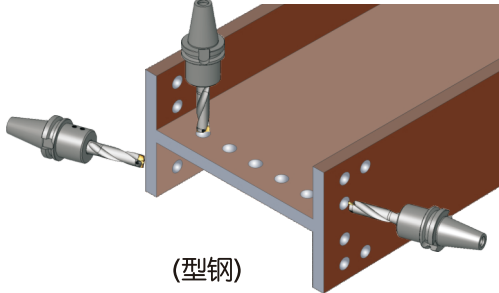
(加工案例)



(钢板)



(角钢)



(型钢)



(专用钻床A)



(专用钻床B)



(专用钻床C)



(专用钻床D)



公制



专为结构钢加工设备而设计的钴尖(刀片)

孔径(Φ) mm	刀体型号	刀柄 (Φd)	尺寸			钻头IDFK	钻头IDPK	钻头IDPK	锁紧螺栓	梅花型螺栓	定位螺钉	L型内角扳手	
			L1	L2	L3								
14.0~14.4	KRUZ 140 L3=50 SLK	16	110	62		IDFK 140, IDFK 141, IDFK 142, IDFK 143, IDFK 144 IDPK 140, IDPK 141, IDPK 142, IDPK 143, IDPK 144			CS 140 -155 SL	T7	Torque 0.9Nm (Max)	M2.5x4	1.3mm
14.5~14.9	KRUZ 145 L3=50 SLK					IDFK 145, IDFK 146, IDFK 147, IDFK 148, IDFK 149 IDPK 145, IDPK 146, IDPK 147, IDPK 148, IDPK 149							
15.0~15.4	KRUZ 150 L3=50 SLK		115	65		IDFK 150, IDFK 151, IDFK 152, IDFK 153, IDFK 154 IDPK 150, IDPK 151, IDPK 152, IDPK 153, IDPK 154			CS 160 -175 SL				
15.5~15.9	KRUZ 155 L3=50 SLK					IDFK 155, IDFK 156, IDFK 157, IDFK 158, IDFK 159 IDPK 155, IDPK 156, IDPK 157, IDPK 158, IDPK 159							
16.0~16.4	KRUZ 160 L3=50 SLK					IDFK 160, IDFK 161, IDFK 162, IDFK 163, IDFK 164 IDPK 160, IDPK 161, IDPK 162, IDPK 163, IDPK 164							
16.5~16.9	KRUZ 165 L3=50 SLK					IDFK 165, IDFK 166, IDFK 167, IDFK 168, IDFK 169 IDPK 165, IDPK 166, IDPK 167, IDPK 168, IDPK 169							
17.0~17.4	KRUZ 170 L3=50 SLK	20				IDFK 170, IDFK 171, IDFK 172, IDFK 173, IDFK 174 IDPK 170, IDPK 171, IDPK 172, IDPK 173, IDPK 174							
17.5~17.9	KRUZ 175 L3=50 SLK					IDFK 175, IDFK 176, IDFK 177, IDFK 178, IDFK 179 IDPK 175, IDPK 176, IDPK 177, IDPK 178, IDPK 179							
18.0~18.4	KRUZ 180 L3=50 SLK		118	68		IDFK 180, IDFK 181, IDFK 182, IDFK 183, IDFK 184 IDPK 180, IDPK 181, IDPK 182, IDPK 183, IDPK 184			CS 180 -195 SL				
18.5~18.9	KRUZ 185 L3=50 SLK					IDFK 185, IDFK 186, IDFK 187, IDFK 188, IDFK 189 IDPK 185, IDPK 186, IDPK 187, IDPK 188, IDPK 189							
19.0~19.4	KRUZ 190 L3=50 SLK					IDFK 190, IDFK 191, IDFK 192, IDFK 193, IDFK 194 IDPK 190, IDPK 191, IDPK 192, IDPK 193, IDPK 194							
19.5~19.9	KRUZ 195 L3=50 SLK					IDFK 195, IDFK 196, IDFK 197, IDFK 198, IDFK 199 IDPK 195, IDPK 196, IDPK 197, IDPK 198, IDPK 199							
20.0~20.4	KRUZ 200 L3=50 SLK					IDFK 200, IDFK 201, IDFK 202, IDFK 203, IDFK 204 IDPK 200, IDPK 201, IDPK 202, IDPK 203, IDPK 204			CS 200 -215 SL	T8	Torque 1.5Nm (Max)		
20.5~20.9	KRUZ 205 L3=50 SLK					IDFK 205, IDFK 206, IDFK 207, IDFK 208, IDFK 209 IDPK 205, IDPK 206, IDPK 207, IDPK 208, IDPK 209							
21.0~21.4	KRUZ 210 L3=50 SLK	25	130	74	50	IDFK 210, IDFK 211, IDFK 212, IDFK 213, IDFK 214 IDPK 210, IDPK 211, IDPK 212, IDPK 213, IDPK 214							
21.5~21.9	KRUZ 215 L3=50 SLK					IDFK 215, IDFK 216, IDFK 217, IDFK 218, IDFK 219 IDPK 215, IDPK 216, IDPK 217, IDPK 218, IDPK 219							
22.0~22.4	KRUZ 220 L3=50 SLK					IDFK 220, IDFK 221, IDFK 222, IDFK 223, IDFK 224 IDPK 220, IDPK 221, IDPK 222, IDPK 223, IDPK 224			CS 220 -235 SL				
22.5~22.9	KRUZ 225 L3=50 SLK					IDFK 225, IDFK 226, IDFK 227, IDFK 228, IDFK 229 IDPK 225, IDPK 226, IDPK 227, IDPK 228, IDPK 229							
23.0~23.4	KRUZ 230 L3=50 SLK					IDFK 230, IDFK 231, IDFK 232, IDFK 233, IDFK 234 IDPK 230, IDPK 231, IDPK 232, IDPK 233, IDPK 234							
23.5~23.9	KRUZ 235 L3=50 SLK					IDFK 235, IDFK 236, IDFK 237, IDFK 238, IDFK 239 IDPK 235, IDPK 236, IDPK 237, IDPK 238, IDPK 239							
24.0~24.4	KRUZ 240 L3=50 SLK		136	76		IDFK 240, IDFK 241, IDFK 242, IDFK 243, IDFK 244 IDPK 240, IDPK 241, IDPK 242, IDPK 243, IDPK 244			CS 240 -255 SL				
24.5~24.9	KRUZ 245 L3=50 SLK					IDFK 245, IDFK 246, IDFK 247, IDFK 248, IDFK 249 IDPK 245, IDPK 246, IDPK 247, IDPK 248, IDPK 249							
25.0~25.4	KRUZ 250 L3=50 SLK					IDFK 250, IDFK 251, IDFK 252, IDFK 253, IDFK 254 IDPK 250, IDPK 251, IDPK 252, IDPK 253, IDPK 254							
25.5~25.9	KRUZ 255 L3=50 SLK					IDFK 255, IDFK 256, IDFK 257, IDFK 258, IDFK 259 IDPK 255, IDPK 256, IDPK 257, IDPK 258, IDPK 259							
26.0~26.4	KRUZ 260 L3=50 SLK	32				IDFK 260, IDFK 261, IDFK 262, IDFK 263, IDFK 264 IDPK 260, IDPK 261, IDPK 262, IDPK 263, IDPK 264			CS 260 -275 SL	T15	Torque 3.5Nm (Max)		
26.5~26.9	KRUZ 265 L3=50 SLK					IDFK 265, IDFK 266, IDFK 267, IDFK 268, IDFK 269 IDPK 265, IDPK 266, IDPK 267, IDPK 268, IDPK 269							
27.0~27.4	KRUZ 270 L3=50 SLK					IDFK 270, IDFK 271, IDFK 272, IDFK 273, IDFK 274 IDPK 270, IDPK 271, IDPK 272, IDPK 273, IDPK 274							
27.5~27.9	KRUZ 275 L3=50 SLK					IDFK 275, IDFK 276, IDFK 277, IDFK 278, IDFK 279 IDPK 275, IDPK 276, IDPK 277, IDPK 278, IDPK 279							
28.0~28.4	KRUZ 280 L3=50 SLK		140	80		IDFK 280, IDFK 281, IDFK 282, IDFK 283, IDFK 284 IDPK 280, IDPK 281, IDPK 282, IDPK 283, IDPK 284							
28.5~28.9	KRUZ 285 L3=50 SLK					IDFK 285, IDFK 286, IDFK 287, IDFK 288, IDFK 289 IDPK 285, IDPK 286, IDPK 287, IDPK 288, IDPK 289							
29.0~29.4	KRUZ 290 L3=50 SLK					IDFK 290, IDFK 291, IDFK 292, IDFK 293, IDFK 294 IDPK 290, IDPK 291, IDPK 292, IDPK 293, IDPK 294			CS 280 -295 SL				
29.5~29.9	KRUZ 295 L3=50 SLK					IDFK 295, IDFK 296, IDFK 297, IDFK 298, IDFK 299 IDPK 295, IDPK 296, IDPK 297, IDPK 298, IDPK 299							

☞ 上述未标出的尺寸，可根据需求定制。



公制

专为结构钢加工设备而设计的钻尖(刀片)

孔径(Φ) mm	刀体型号	刀柄 (Φd)	尺寸			钻头IDFK 	钻头IDPK 													
			L1	L2	L3															
30.0~30.4	KRUZ 300 L3=70 SLK	32	155	95	70	IDFK 300, IDFK 301, IDFK 302, IDFK 303, IDFK 304 IDPK 300, IDPK 301, IDPK 302, IDPK 303, IDPK 304	CS 300 -315 SL			M4x8	2.0mm									
30.5~30.9	KRUZ 305 L3=70 SLK					IDFK 305, IDFK 306, IDFK 307, IDFK 308, IDFK 309 IDPK 305, IDPK 306, IDPK 307, IDPK 308, IDPK 309														
31.0~31.4	KRUZ 310 L3=70 SLK					IDFK 310, IDFK 311, IDFK 312, IDFK 313, IDFK 314 IDPK 310, IDPK 311, IDPK 312, IDPK 313, IDPK 314														
31.5~31.9	KRUZ 315 L3=70 SLK					IDFK 315, IDFK 316, IDFK 317, IDFK 318, IDFK 319 IDPK 315, IDPK 316, IDPK 317, IDPK 318, IDPK 319														
32.0~32.4	KRUZ 320 L3=70 SLK					IDFK 320, IDFK 321, IDFK 322, IDFK 323, IDFK 324 IDPK 320, IDPK 321, IDPK 322, IDPK 323, IDPK 324														
32.5~32.9	KRUZ 325 L3=70 SLK					IDFK 325, IDFK 326, IDFK 327, IDFK 328, IDFK 329 IDPK 325, IDPK 326, IDPK 327, IDPK 328, IDPK 329														
33.0~33.4	KRUZ 330 L3=70 SLK					IDFK 330, IDFK 331, IDFK 332, IDFK 333, IDFK 334 IDPK 330, IDPK 331, IDPK 332, IDPK 333, IDPK 334														
33.5~33.9	KRUZ 335 L3=70 SLK					IDFK 335, IDFK 336, IDFK 337, IDFK 338, IDFK 339 IDPK 335, IDPK 336, IDPK 337, IDPK 338, IDPK 339														
34.0~34.4	KRUZ 340 L3=80 SLK	180	110	80	IDFK 340, IDFK 341, IDFK 342, IDFK 343, IDFK 344 IDPK 340, IDPK 341, IDPK 342, IDPK 343, IDPK 344	CS 320 -355 SL			M5x10	2.5mm										
34.5~34.9	KRUZ 345 L3=80 SLK				IDFK 345, IDFK 346, IDFK 347, IDFK 348, IDFK 349 IDPK 345, IDPK 346, IDPK 347, IDPK 348, IDPK 349															
35.0~35.4	KRUZ 350 L3=80 SLK				IDFK 350, IDFK 351, IDFK 352, IDFK 353, IDFK 354 IDPK 350, IDPK 351, IDPK 352, IDPK 353, IDPK 354															
35.5~35.9	KRUZ 355 L3=80 SLK				IDFK 355, IDFK 356, IDFK 357, IDFK 358, IDFK 359 IDPK 355, IDPK 356, IDPK 357, IDPK 358, IDPK 359															
36.0~36.4	KRUZ 360 L3=80 SLK				IDFK 360, IDFK 361, IDFK 362, IDFK 363, IDFK 364 IDPK 360, IDPK 361, IDPK 362, IDPK 363, IDPK 364															
36.5~36.9	KRUZ 365 L3=80 SLK				IDFK 365, IDFK 366, IDFK 367, IDFK 368, IDFK 369 IDPK 365, IDPK 366, IDPK 367, IDPK 368, IDPK 369															
37.0~37.4	KRUZ 370 L3=80 SLK				IDFK 370, IDFK 371, IDFK 372, IDFK 373, IDFK 374 IDPK 370, IDPK 371, IDPK 372, IDPK 373, IDPK 374															
37.5~37.9	KRUZ 375 L3=80 SLK				IDFK 375, IDFK 376, IDFK 377, IDFK 378, IDFK 379 IDPK 375, IDPK 376, IDPK 377, IDPK 378, IDPK 379															
38.0~38.4	KRUZ 380 L3=80 SLK				IDFK 380, IDFK 381, IDFK 382, IDFK 383, IDFK 384 IDPK 380, IDPK 381, IDPK 382, IDPK 383, IDPK 384															
38.5~38.9	KRUZ 385 L3=80 SLK				IDFK 385, IDFK 386, IDFK 387, IDFK 388, IDFK 389 IDPK 385, IDPK 386, IDPK 387, IDPK 388, IDPK 389															
39.0~39.4	KRUZ 390 L3=80 SLK				IDFK 390, IDFK 391, IDFK 392, IDFK 393, IDFK 394 IDPK 390, IDPK 391, IDPK 392, IDPK 393, IDPK 394															
39.5~39.9	KRUZ 395 L3=80 SLK				IDFK 395, IDFK 396, IDFK 397, IDFK 398, IDFK 399 IDPK 395, IDPK 396, IDPK 397, IDPK 398, IDPK 399															
40.0~40.4	KRUZ 400 L3=80 SLK				IDFK 400, IDFK 401, IDFK 402, IDFK 403, IDFK 404 IDPK 400, IDPK 401, IDPK 402, IDPK 403, IDPK 404															
40.5~40.9	KRUZ 405 L3=80 SLK				IDFK 405, IDFK 406, IDFK 407, IDFK 408, IDFK 409 IDPK 405, IDPK 406, IDPK 407, IDPK 408, IDPK 409															
41.0~41.4	KRUZ 410 L3=80 SLK				IDFK 410, IDFK 411, IDFK 412, IDFK 413, IDFK 414 IDPK 410, IDPK 411, IDPK 412, IDPK 413, IDPK 414															
41.5~41.9	KRUZ 415 L3=80 SLK				IDFK 415, IDFK 416, IDFK 417, IDFK 418, IDFK 419 IDPK 415, IDPK 416, IDPK 417, IDPK 418, IDPK 419															
42.0~42.4	KRUZ 420 L3=80 SLK	185	115	80	IDFK 420, IDFK 421, IDFK 422, IDFK 423, IDFK 424 IDPK 420, IDPK 421, IDPK 422, IDPK 423, IDPK 424	CS 400 -445 SL	Torque 4.0Nm (Max)			M6x12	3.0mm									
42.5~42.9	KRUZ 425 L3=80 SLK				IDFK 425, IDFK 426, IDFK 427, IDFK 428, IDFK 429 IDPK 425, IDPK 426, IDPK 427, IDPK 428, IDPK 429															
43.0~43.4	KRUZ 430 L3=80 SLK				IDFK 430, IDFK 431, IDFK 432, IDFK 433, IDFK 434 IDPK 430, IDPK 431, IDPK 432, IDPK 433, IDPK 434															
43.5~43.9	KRUZ 435 L3=80 SLK				IDFK 435, IDFK 436, IDFK 437, IDFK 438, IDFK 439 IDPK 435, IDPK 436, IDPK 437, IDPK 438, IDPK 439															
44.0~44.4	KRUZ 440 L3=80 SLK				IDFK 440, IDFK 441, IDFK 442, IDFK 443, IDFK 444 IDPK 440, IDPK 441, IDPK 442, IDPK 443, IDPK 444															
44.5~44.9	KRUZ 445 L3=80 SLK				IDFK 445, IDFK 446, IDFK 447, IDFK 448, IDFK 449 IDPK 445, IDPK 446, IDPK 447, IDPK 448, IDPK 449															
45.0~45.4	KRUZ 450 L3=80 SLK				IDFK 450, IDFK 451, IDFK 452, IDFK 453, IDFK 454 IDPK 450, IDPK 451, IDPK 452, IDPK 453, IDPK 454															
45.5~45.9	KRUZ 455 L3=80 SLK				IDFK 455, IDFK 456, IDFK 457, IDFK 458, IDFK 459 IDPK 455, IDPK 456, IDPK 457, IDPK 458, IDPK 459															
46.0~46.4	KRUZ 460 L3=80 SLK				IDFK 460, IDFK 461, IDFK 462, IDFK 463, IDFK 464 IDPK 460, IDPK 461, IDPK 462, IDPK 463, IDPK 464															
46.5~46.9	KRUZ 465 L3=80 SLK				IDFK 465, IDFK 466, IDFK 467, IDFK 468, IDFK 469 IDPK 465, IDPK 466, IDPK 467, IDPK 468, IDPK 469															
47.0~47.4	KRUZ 470 L3=80 SLK				IDFK 470, IDFK 471, IDFK 472, IDFK 473, IDFK 474 IDPK 470, IDPK 471, IDPK 472, IDPK 473, IDPK 474															
47.5~47.9	KRUZ 475 L3=80 SLK				IDFK 475, IDFK 476, IDFK 477, IDFK 478, IDFK 479 IDPK 475, IDPK 476, IDPK 477, IDPK 478, IDPK 479															
48.0~48.4	KRUZ 480 L3=90 SLK				IDFK 480, IDFK 481, IDFK 482, IDFK 483, IDFK 484 IDPK 480, IDPK 481, IDPK 482, IDPK 483, IDPK 484															
48.5~48.9	KRUZ 485 L3=90 SLK				IDFK 485, IDFK 486, IDFK 487, IDFK 488, IDFK 489 IDPK 485, IDPK 486, IDPK 487, IDPK 488, IDPK 489															
49.0~49.4	KRUZ 490 L3=90 SLK				200							130	90	IDFK 490, IDFK 491, IDFK 492, IDFK 493, IDFK 494 IDPK 490, IDPK 491, IDPK 492, IDPK 493, IDPK 494	CS 450 -500 SL					
49.5~49.9	KRUZ 495 L3=90 SLK													IDFK 495, IDFK 496, IDFK 497, IDFK 498, IDFK 499 IDPK 495, IDPK 496, IDPK 497, IDPK 498, IDPK 499						
50.0~50.4	KRUZ 500 L3=90 SLK	IDFK 500, IDFK 501, IDFK 502, IDFK 503, IDFK 504 IDPK 500, IDPK 501, IDPK 502, IDPK 503, IDPK 504																		

17



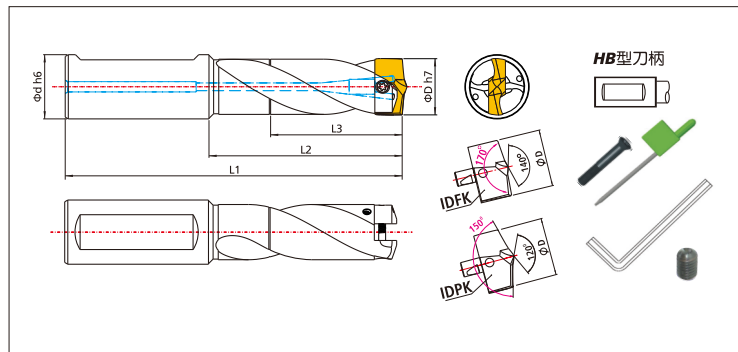
英制



适于加工多层叠加板



专为结构钢加工设备而设计的钻尖(刀片)



孔径(Φ) 十进制	刀体型号	刀柄 (Φd)	尺寸			钻尖IDFK 	钻尖IDPK 	可替代的公制刀体
			L1	L2	L3			
.5512~.5705	KRUZ .5512 SLK	5/8 (15.875mm)	4.3307 (70mm)	2.4409 (62mm)	1.9685 (50mm)	IDFK 9/16"(14.29mm)	IDPK 9/16"(14.29mm)	KRUZ 140 L3=50 SLK
.5709~.5902	KRUZ .5709 SLK					IDFK 37/64"(14.68mm)	IDPK 37/64"(14.68mm)	KRUZ 145 L3=50 SLK
.5906~.6098	KRUZ .5906 SLK	4.5276 (115mm)	2.5591 (65mm)	IDFK 19/32"(15.08mm), IDFK 39/64"(15.48mm)		IDPK 19/32"(15.08mm), IDPK 39/64"(15.48mm)	KRUZ 150 L3=50 SLK	
.6102~.6295	KRUZ .6102 SLK			IDFK 5/8"(15.88mm)		IDPK 5/8"(15.88mm)	KRUZ 155 L3=50 SLK	
.6299~.6492	KRUZ .6299 SLK	4.6457 (118mm)	2.6772 (68mm)	IDFK 41/64"(16.27mm)		IDPK 41/64"(16.27mm)	KRUZ 160 L3=50 SLK	
.6496~.6689	KRUZ .6496 SLK			IDFK 21/32"(16.67mm)		IDPK 21/32"(16.67mm)	KRUZ 165 L3=50 SLK	
.6693~.6886	KRUZ .6693 SLK	5.1181 (130mm)	2.9134 (74mm)	IDFK 43/64"(17.07mm), IDFK 11/16"(17.46mm)		IDPK 43/64"(17.07mm), IDPK 11/16"(17.46mm)	KRUZ 170 L3=50 SLK	
.6890~.7083	KRUZ .6890 SLK			IDFK 45/64"(17.86mm)		IDPK 45/64"(17.86mm)	KRUZ 175 L3=50 SLK	
.7087~.7280	KRUZ .7087 SLK	5.3543 (136mm)	2.9921 (76mm)	IDFK 23/32"(18.26mm)		IDPK 23/32"(18.26mm)	KRUZ 180 L3=50 SLK	
.7283~.7476	KRUZ .7283 SLK			IDFK 47/64"(18.65mm)		IDPK 47/64"(18.65mm)	KRUZ 185 L3=50 SLK	
.7480~.7673	KRUZ .7480 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 3/4(19.05mm), IDFK 49/64"(19.45mm)		IDPK 3/4(19.05mm), IDPK 49/64"(19.45mm)	KRUZ 190 L3=50 SLK	
.7677~.7870	KRUZ .7677 SLK			IDFK 25/32"(19.84mm)		IDPK 25/32"(19.84mm)	KRUZ 195 L3=50 SLK	
.7874~.8067	KRUZ .7874 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 51/64"(20.24mm)		IDPK 51/64"(20.24mm)	KRUZ 200 L3=50 SLK	
.8071~.8264	KRUZ .8071 SLK			IDFK 13/16"(20.64mm)		IDPK 13/16"(20.64mm)	KRUZ 205 L3=50 SLK	
.8268~.8461	KRUZ .8268 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 27/32"(21.43mm)		IDPK 27/32"(21.43mm)	KRUZ 210 L3=50 SLK	
.8465~.8657	KRUZ .8465 SLK			IDFK 55/64"(21.83mm)		IDPK 55/64"(21.83mm)	KRUZ 215 L3=50 SLK	
.8661~.8854	KRUZ .8661 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 7/8"(22.23mm)	IDPK 7/8"(22.23mm)	KRUZ 220 L3=50 SLK		
.8858~.9051	KRUZ .8858 SLK			IDFK 57/64"(22.62mm)	IDPK 57/64"(22.62mm)	KRUZ 225 L3=50 SLK		
.9055~.9248	KRUZ .9055 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 29/32"(23.02mm), IDFK 59/64"(23.42mm)	IDPK 29/32"(23.02mm), IDPK 59/64"(23.42mm)	KRUZ 230 L3=50 SLK		
.9252~.9445	KRUZ .9252 SLK			IDFK 15/16"(23.81mm)	IDPK 15/16"(23.81mm)	KRUZ 235 L3=50 SLK		
.9646~.9839	KRUZ .9646 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 31/32"(24.61mm)	IDPK 31/32"(24.61mm)	KRUZ 245 L3=50 SLK		
.9843~1.0035	KRUZ .9843 SLK			IDFK 63/64"(25.00mm), IDFK 1"(25.4mm)	IDPK 63/64"(25.00mm), IDPK 1"(25.4mm)	KRUZ 250 L3=50 SLK		
1.0039~1.0232	KRUZ 1.0039 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 1-1/64"(25.80mm)	IDPK 1-1/64"(25.80mm)	KRUZ 255 L3=50 SLK		
1.0236~1.0429	KRUZ 1.0236 SLK			IDFK 1-1/32"(26.19mm)	IDPK 1-1/32"(26.19mm)	KRUZ 260 L3=50 SLK		
1.0433~1.0626	KRUZ 1.0433 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 1-3/64"(26.59mm), IDFK 1-1/16"(26.99mm)	IDPK 1-3/64"(26.59mm), IDPK 1-1/16"(26.99mm)	KRUZ 265 L3=50 SLK		
1.0827~1.1020	KRUZ 1.0827 SLK			IDFK 1-3/32"(27.78mm)	IDPK 1-3/32"(27.78mm)	KRUZ 275 L3=50 SLK		
1.1024~1.1217	KRUZ 1.1024 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 1-7/64"(28.18mm)	IDPK 1-7/64"(28.18mm)	KRUZ 280 L3=50 SLK		
1.1220~1.1413	KRUZ 1.1220 SLK			IDFK 1-1/8"(28.58mm)	IDPK 1-1/8"(28.58mm)	KRUZ 285 L3=50 SLK		
1.1417~1.1610	KRUZ 1.1417 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 1-5/32"(29.37mm)	IDPK 1-5/32"(29.37mm)	KRUZ 290 L3=50 SLK		
1.1811~1.2004	KRUZ 1.1811 SLK			IDFK 1-3/16"(30.16mm)	IDPK 1-3/16"(30.16mm)	KRUZ 300 L3=70 SLK		
1.2008~1.2201	KRUZ 1.2008 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 1-7/32"(30.96mm)	IDPK 1-7/32"(30.96mm)	KRUZ 305 L3=70 SLK		
1.2402~1.2594	KRUZ 1.2402 SLK			IDFK 1-1/4"(31.75mm)	IDPK 1-1/4"(31.75mm)	KRUZ 315 L3=70 SLK		
1.2795~1.2988	KRUZ 1.2795 SLK	5.5118 (140mm)	3.1496 (80mm)	IDFK 1-9/32"(32.54mm)	IDPK 1-9/32"(32.54mm)	KRUZ 325 L3=70 SLK		
1.2992~1.3185	KRUZ 1.2992 SLK			IDFK 1-5/16"(33.34mm)	IDPK 1-5/16"(33.34mm)	KRUZ 330 L3=70 SLK		
1.3386~1.3579	KRUZ 1.3386 SLK	7.0866 (180mm)	4.3307 (110mm)	3.1496 (80mm)	IDFK 1-11/32"(34.13mm)	IDPK 1-11/32"(34.13mm)	KRUZ 340 L3=80 SLK	
1.3583~1.3776	KRUZ 1.3583 SLK				IDFK 1-3/8"(34.93mm)	IDPK 1-3/8"(34.93mm)	KRUZ 345 L3=80 SLK	



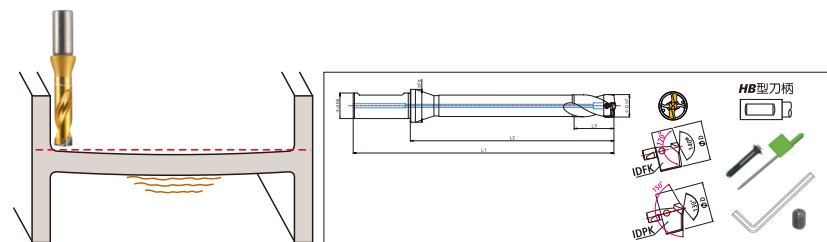
(7xD) 与IDFK & IDPK 钻头



适于加工多层叠加板



适于加工多层叠加板



- ▶ 如存在干涉等情况，需较长的悬长时，最为理想的刀体
- ▶ 孔深可加工到接近法兰部分(7倍径)
- ▶ 最小化的螺旋槽和更长的圆柱形颈部设计
- ▶ 比普通的7xD钻头刚度更好
- ▶ 内冷设计
- ▶ 法兰刀柄更能减少抖动或振动

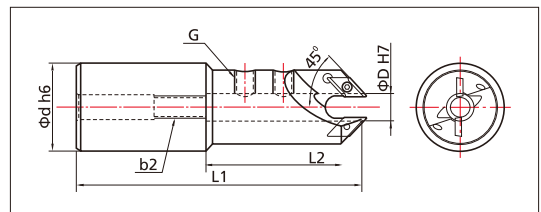
专为结构钢加工设备而设计的钴尖(刀片)

孔径(Φ) mm	刀体型号	刀柄 (Φd)	尺 寸			法兰直径 (ΦFd)	钻尖IDFK  钻尖IDPK 		锁紧螺栓 	梅花型螺批 	定位螺钉 	1°型内角手 
			L1	L2	L3							
14.0~14.4	KRUZ 140H FL50 FSLK	16	175	127	21	IDFK 140, IDFK 141, IDFK 142, IDFK 143, IDFK 144 IDPK 140, IDPK 141, IDPK 142, IDPK 143, IDPK 144	CS 140 -155 SL	T7	M2.5x4	1.3mm		
14.5~14.9	KRUZ 145H FL50 FSLK		181	131		IDFK 145, IDFK 146, IDFK 147, IDFK 148, IDFK 149 IDPK 145, IDPK 146, IDPK 147, IDPK 148, IDPK 149						
15.0~15.4	KRUZ 150H FL50 FSLK		187	137		IDFK 150, IDFK 151, IDFK 152, IDFK 153, IDFK 154 IDPK 150, IDPK 151, IDPK 152, IDPK 153, IDPK 154						
15.5~15.9	KRUZ 155H FL50 FSLK		192	142		IDFK 155, IDFK 156, IDFK 157, IDFK 158, IDFK 159 IDPK 155, IDPK 156, IDPK 157, IDPK 158, IDPK 159						
16.0~16.4	KRUZ 160H FL50 FSLK	20	196	146		IDFK 160, IDFK 161, IDFK 162, IDFK 163, IDFK 164 IDPK 160, IDPK 161, IDPK 162, IDPK 163, IDPK 164						
16.5~16.9	KRUZ 165H FL50 FSLK		201	151		IDFK 165, IDFK 166, IDFK 167, IDFK 168, IDFK 169 IDPK 165, IDPK 166, IDPK 167, IDPK 168, IDPK 169						
17.0~17.4	KRUZ 170H FL50 FSLK		205	155		IDFK 170, IDFK 171, IDFK 172, IDFK 173, IDFK 174 IDPK 170, IDPK 171, IDPK 172, IDPK 173, IDPK 174						
17.5~17.9	KRUZ 175H FL50 FSLK		209	159		IDFK 175, IDFK 176, IDFK 177, IDFK 178, IDFK 179 IDPK 175, IDPK 176, IDPK 177, IDPK 178, IDPK 179						
18.0~18.4	KRUZ 180H FL50 FSLK		214	164		IDFK 180, IDFK 181, IDFK 182, IDFK 183, IDFK 184 IDPK 180, IDPK 181, IDPK 182, IDPK 183, IDPK 184						
18.5~18.9	KRUZ 185H FL50 FSLK	218	168	IDFK 185, IDFK 186, IDFK 187, IDFK 188, IDFK 189 IDPK 185, IDPK 186, IDPK 187, IDPK 188, IDPK 189								
19.0~19.4	KRUZ 190H FL50 FSLK	223	173	IDFK 190, IDFK 191, IDFK 192, IDFK 193, IDFK 194 IDPK 190, IDPK 191, IDPK 192, IDPK 193, IDPK 194								
19.5~19.9	KRUZ 195H FL50 FSLK	227	177	IDFK 195, IDFK 196, IDFK 197, IDFK 198, IDFK 199 IDPK 195, IDPK 196, IDPK 197, IDPK 198, IDPK 199								
20.0~20.4	KRUZ 200H FL50 FSLK	25	237	181	32	IDFK 200, IDFK 201, IDFK 202, IDFK 203, IDFK 204 IDPK 200, IDPK 201, IDPK 202, IDPK 203, IDPK 204	CS 200 -215 SL	T8	M3x6	1.5mm		
20.5~20.9	KRUZ 205H FL50 FSLK		242	186		IDFK 205, IDFK 206, IDFK 207, IDFK 208, IDFK 209 IDPK 205, IDPK 206, IDPK 207, IDPK 208, IDPK 209						
21.0~21.4	KRUZ 210H FL50 FSLK		246	190		IDFK 210, IDFK 211, IDFK 212, IDFK 213, IDFK 214 IDPK 210, IDPK 211, IDPK 212, IDPK 213, IDPK 214						
21.5~21.9	KRUZ 215H FL50 FSLK		251	195		IDFK 215, IDFK 216, IDFK 217, IDFK 218, IDFK 219 IDPK 215, IDPK 216, IDPK 217, IDPK 218, IDPK 219						
22.0~22.4	KRUZ 220H FL50 FSLK		255	199		IDFK 220, IDFK 221, IDFK 222, IDFK 223, IDFK 224 IDPK 220, IDPK 221, IDPK 222, IDPK 223, IDPK 224						
22.5~22.9	KRUZ 225H FL50 FSLK		259	203		IDFK 225, IDFK 226, IDFK 227, IDFK 228, IDFK 229 IDPK 225, IDPK 226, IDPK 227, IDPK 228, IDPK 229						
23.0~23.4	KRUZ 230H FL50 FSLK		264	208		IDFK 230, IDFK 231, IDFK 232, IDFK 233, IDFK 234 IDPK 230, IDPK 231, IDPK 232, IDPK 233, IDPK 234						
23.5~23.9	KRUZ 235H FL50 FSLK		268	212		IDFK 235, IDFK 236, IDFK 237, IDFK 238, IDFK 239 IDPK 235, IDPK 236, IDPK 237, IDPK 238, IDPK 239						
24.0~24.4	KRUZ 240H FL50 FSLK		277	217		IDFK 240, IDFK 241, IDFK 242, IDFK 243, IDFK 244 IDPK 240, IDPK 241, IDPK 242, IDPK 243, IDPK 244						
24.5~24.9	KRUZ 245H FL50 FSLK		281	221		IDFK 245, IDFK 246, IDFK 247, IDFK 248, IDFK 249 IDPK 245, IDPK 246, IDPK 247, IDPK 248, IDPK 249						
25.0~25.4	KRUZ 250H FL50 FSLK	32	285	225	39	IDFK 250, IDFK 251, IDFK 252, IDFK 253, IDFK 254 IDPK 250, IDPK 251, IDPK 252, IDPK 253, IDPK 254	CS 240 -255 SL	T15	M4x8	2.0mm		
25.5~25.9	KRUZ 255H FL50 FSLK		290	230		IDFK 255, IDFK 256, IDFK 257, IDFK 258, IDFK 259 IDPK 255, IDPK 256, IDPK 257, IDPK 258, IDPK 259						
26.0~26.4	KRUZ 260H FL50 FSLK		294	234		IDFK 260, IDFK 261, IDFK 262, IDFK 263, IDFK 264 IDPK 260, IDPK 261, IDPK 262, IDPK 263, IDPK 264						
26.5~26.9	KRUZ 265H FL50 FSLK		299	239		IDFK 265, IDFK 266, IDFK 267, IDFK 268, IDFK 269 IDPK 265, IDPK 266, IDPK 267, IDPK 268, IDPK 269						
27.0~27.4	KRUZ 270H FL50 FSLK		303	243		IDFK 270, IDFK 271, IDFK 272, IDFK 273, IDFK 274 IDPK 270, IDPK 271, IDPK 272, IDPK 273, IDPK 274						
27.5~27.9	KRUZ 275H FL50 FSLK		307	247		IDFK 275, IDFK 276, IDFK 277, IDFK 278, IDFK 279 IDPK 275, IDPK 276, IDPK 277, IDPK 278, IDPK 279						
28.0~28.4	KRUZ 280H FL50 FSLK		312	252		IDFK 280, IDFK 281, IDFK 282, IDFK 283, IDFK 284 IDPK 280, IDPK 281, IDPK 282, IDPK 283, IDPK 284						
28.5~28.9	KRUZ 285H FL50 FSLK		316	256		IDFK 285, IDFK 286, IDFK 287, IDFK 288, IDFK 289 IDPK 285, IDPK 286, IDPK 287, IDPK 288, IDPK 289						
29.0~29.4	KRUZ 290H FL50 FSLK		321	261		IDFK 290, IDFK 291, IDFK 292, IDFK 293, IDFK 294 IDPK 290, IDPK 291, IDPK 292, IDPK 293, IDPK 294						
29.5~29.9	KRUZ 295H FL50 FSLK		325	265		IDFK 295, IDFK 296, IDFK 297, IDFK 298, IDFK 299 IDPK 295, IDPK 296, IDPK 297, IDPK 298, IDPK 299						
30.0~30.4	KRUZ 300H FL70 FSLK	70	329	269	IDFK 300, IDFK 301, IDFK 302, IDFK 303, IDFK 304 IDPK 300, IDPK 301, IDPK 302, IDPK 303, IDPK 304	CS 300 -315 SL	T20	M5x10	2.5mm			
30.5~30.9	KRUZ 305H FL70 FSLK		334	274	IDFK 305, IDFK 306, IDFK 307, IDFK 308, IDFK 309 IDPK 305, IDPK 306, IDPK 307, IDPK 308, IDPK 309							
31.0~31.4	KRUZ 310H FL70 FSLK		338	278	IDFK 310, IDFK 311, IDFK 312, IDFK 313, IDFK 314 IDPK 310, IDPK 311, IDPK 312, IDPK 313, IDPK 314							
31.5~31.9	KRUZ 315H FL70 FSLK		343	283	IDFK 315, IDFK 316, IDFK 317, IDFK 318, IDFK 319 IDPK 315, IDPK 316, IDPK 317, IDPK 318, IDPK 319							
32.0~32.4	KRUZ 320H FL70 FSLK		347	287	IDFK 320, IDFK 321, IDFK 322, IDFK 323, IDFK 324 IDPK 320, IDPK 321, IDPK 322, IDPK 323, IDPK 324							

☞ 上述未标出的尺寸，可根据需求定制。

钻铣刀具

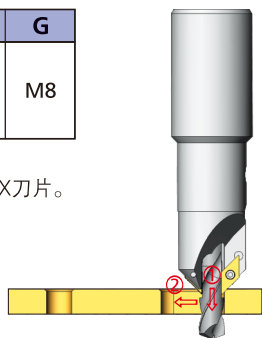
DMH



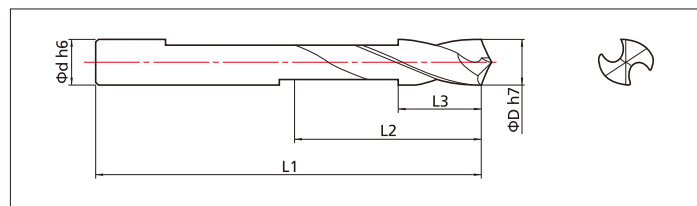
- ▶ 在该刀体上安装使用，可换式硬质合金钻铣刀与XCGX刀片
- ▶ 特殊设计的硬质合金钻铣刀(TiAlN)，具有很好铣削功能的螺旋槽
- ▶ 硬质合金倒角刀片XCGX 1102，可用两个边角
- ▶ 采用侧固系统并经特殊热处理的工具钢刀体，具有很好的刚性
- ▶ 钻、铣、倒角功能集于一体，又经济又省事
- ▶ 加上倒角功能的立铣刀，边铣边倒角

CODE No.	D(mm)	d(mm)	L1	L2	G
DMH 32-8	8	32	110	40	M8
DMH 32-10	10				
DMH 32-12	12				

☞ 其他特殊尺寸，可根据需求定制。
☞ 注：安装DM钻铣刀之前，首先在DMH架上装好XCGX刀片。



DM



CODE No.	D(mm)	d(mm)	L1	L2	L3
DM 080 TiAlN	8.0	8.0	70	30	14.6
DM 100 TiAlN	10.0	10.0			
DM 120 TiAlN	12.0	12.0			

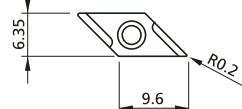
☞ DM 钻可加工最大14mm孔深。如需加工更深的孔，需分别注明各尺寸。

- ▶ 整体硬质合金材料，TiAlN涂层
- ▶ 该产品是YESTOOL公司自主设计的钻铣刀
- ▶ 采用平磨工艺，适合安装两个XCGX刀片
- ▶ 该刀头必须安装在DMH刀架上使用
- ▶ 采用TiAlN涂层，寿命更长

XCGX



- ▶ 采用磨边的硬质合金刀片
- ▶ 使用两个边角
- ▶ 可应用与孔倒角



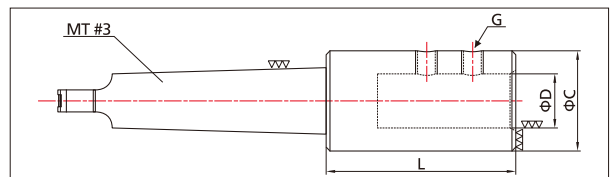
XCGX1102

侧固式莫式锥柄

MT



MTC



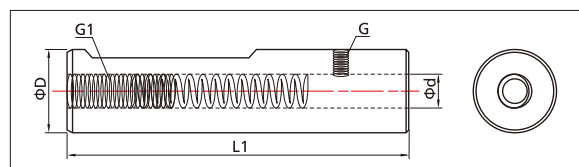
- ▶ 适合安装KRUZ刀体的特殊莫氏锥柄
- ▶ 通过螺钉把KRUZ刀体，安装在侧固式莫式锥柄上面
- ▶ 是加长HSS MT刀柄钻头的替代品
- ▶ 对老设备、不稳定的机床、工件装夹不稳定，是理想的刀具

CODE No.	MT#	D(mm)	L(mm)	C(mm)	G
MT3S-SLA16-95	#3	16	95	33	M12
MT3S-SLA20-70		20	70	37	
MT3S-SLA25-70		25		40	
MT3S-SLA32-70		32		42	
MT3S-SLA40-80		40	80	52	

☞ 针对MT#2, MT#4莫式锥柄，可根据要求定制。

划线刀具

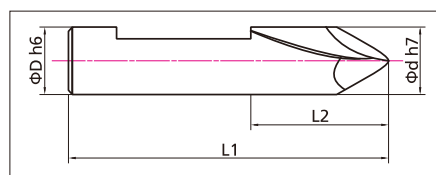
STH



- ▶ 安装在侧固式刀柄的可换式硬质合金划线钻
- ▶ 经热处理的工具钢刀体
- ▶ 特殊设计的弹簧系统，加工不平表面时，可回收钻头阻力
- ▶ 另外还有：对倒角孔铣边的功能

CODE No.	D(mm)	d(mm)	L1	G	G1
STH 080	20	8	120	M4x6	M8x20
STH-Spring	6		40		

SD

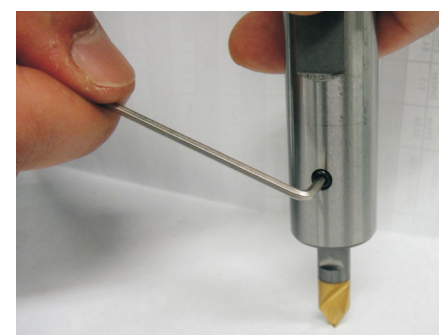
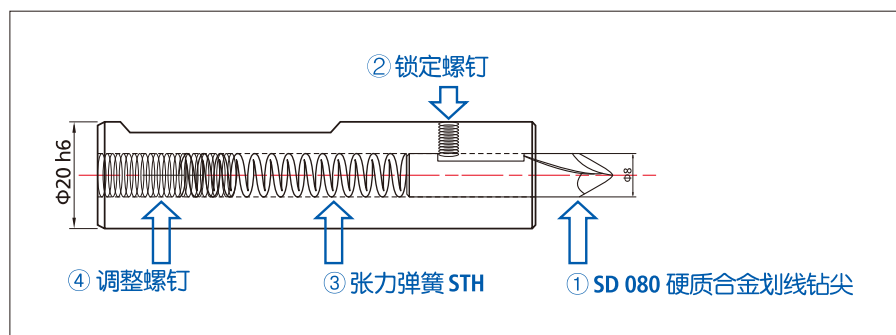


- ▶ TiN涂层的90°钻尖，保证了划线时的双角稳定性
- ▶ 适合STH刀架的硬质合金扁柄钻头
- ▶ 双重角钻尖，有效防止尖部的崩刃
- ▶ 以侧固螺钉来锁定
- ▶ 以侧面螺栓可调张力

CODE No.	D(mm)	d(mm)	L1	L2
SD 080 TiN	8	8	37	13

装配划线刀具的方法

- 推入①SD 080划线钻尖，直到削平的刀柄完全隐藏到刀体内
- 完全锁紧螺钉②
- 向刀体内，插入③STH张力弹簧
- 把调整螺钉④，向右推到边端
- 最后，把锁定螺钉②，向左松动45°(约1/8转)，弹簧的弹力进入执行状态

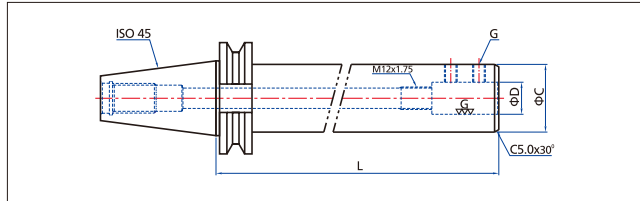


拆除划线刀具的方法

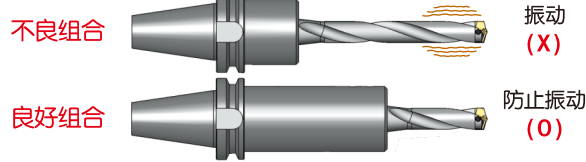
- 向左旋转调整螺钉④，取出该螺钉
- 从刀体上取出张力弹簧③
- 松开锁定螺钉②
- 从刀体上取下①SD 080划线刀具

注意!：请务必留意拆卸划线钻头时的安全，从刀体上端开始操作（参见上图）。

ISO 45与HSK加长强化刀柄(加工型钢设备专用)



- ISO 45(HSK)刀柄, 可增强钻削刚性
- 采用了内冷结构
- 采用了两个螺钉侧固式夹紧方式
- 优化的KRUIZ-SLK刀体与IDFK钻头(刀片)组合
- HSK刀柄, 可根据要求定制



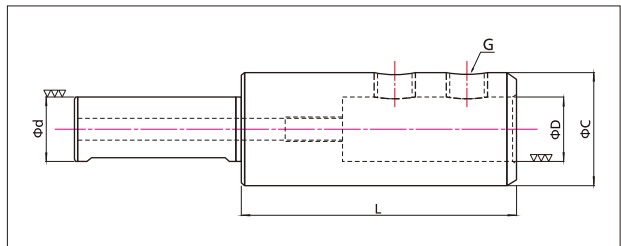
型号	D	L	C	G	型号	D	L	C	G	型号	D	L	C	G
ISO45(HSK)-SLA16-80	16	80	56	M10	ISO45(HSK)-SLA20-400	20	400	56	M12	ISO45(HSK)-SLA32-270	32	270	56	M14
ISO45(HSK)-SLA16-160	16	160	56	M10	ISO45(HSK)-SLA20-450	20	450	56	M12	ISO45(HSK)-SLA32-300	32	300	56	M14
ISO45(HSK)-SLA16-210	16	210	56	M10	ISO45(HSK)-SLA20-500	20	500	56	M12	ISO45(HSK)-SLA32-350	32	350	56	M14
ISO45(HSK)-SLA16-240	16	240	56	M10	ISO45(HSK)-SLA25-80	25	80	56	M12	ISO45(HSK)-SLA32-400	32	400	56	M14
ISO45(HSK)-SLA16-270	16	270	56	M10	ISO45(HSK)-SLA25-160	25	160	56	M12	ISO45(HSK)-SLA32-450	32	450	56	M14
ISO45(HSK)-SLA16-300	16	300	56	M10	ISO45(HSK)-SLA25-210	25	210	56	M12	ISO45(HSK)-SLA32-500	32	500	56	M14
ISO45(HSK)-SLA16-350	16	350	56	M10	ISO45(HSK)-SLA25-240	25	240	56	M12	ISO45(HSK)-SLA40-90	40	90	60	M14
ISO45(HSK)-SLA16-400	16	400	56	M10	ISO45(HSK)-SLA25-270	25	270	56	M12	ISO45(HSK)-SLA40-160	40	160	60	M14
ISO45(HSK)-SLA16-450	16	450	56	M10	ISO45(HSK)-SLA25-300	25	300	56	M12	ISO45(HSK)-SLA40-210	40	210	60	M14
ISO45(HSK)-SLA16-500	16	500	56	M10	ISO45(HSK)-SLA25-350	25	350	56	M12	ISO45(HSK)-SLA40-240	40	240	60	M14
ISO45(HSK)-SLA20-80	20	80	56	M12	ISO45(HSK)-SLA25-400	25	400	56	M12	ISO45(HSK)-SLA40-270	40	270	60	M14
ISO45(HSK)-SLA20-160	20	160	56	M12	ISO45(HSK)-SLA25-450	25	450	56	M12	ISO45(HSK)-SLA40-300	40	300	60	M14
ISO45(HSK)-SLA20-210	20	210	56	M12	ISO45(HSK)-SLA25-500	25	500	56	M12	ISO45(HSK)-SLA40-350	40	350	60	M14
ISO45(HSK)-SLA20-240	20	240	56	M12	ISO45(HSK)-SLA32-80	32	80	56	M14	ISO45(HSK)-SLA40-400	40	400	60	M14
ISO45(HSK)-SLA20-270	20	270	56	M12	ISO45(HSK)-SLA32-160	32	160	56	M14	ISO45(HSK)-SLA40-450	40	450	60	M14
ISO45(HSK)-SLA20-300	20	300	56	M12	ISO45(HSK)-SLA32-210	32	210	56	M14	ISO45(HSK)-SLA40-500	40	500	60	M14
ISO45(HSK)-SLA20-350	20	350	56	M12	ISO45(HSK)-SLA32-240	32	240	56	M14					

不包括拉钉
ISO40刀柄可根据需求定制

加长套筒



- 该加长套筒, 便于使用短钻头
- 侧固式锁紧方式
- 钻头刀柄直径, 仍保持一致



型号	d(mm)	D(mm)	L(mm)	C(mm)	G
EXT16-SLA16-80	16	16	80	50	M10
EXT16-SLA16-125	16	16	125	50	M10
EXT16-SLA16-150	16	16	150	50	M10
EXT16-SLA16-200	16	16	200	50	M10
EXT16-SLA16-250	16	16	250	50	M10
EXT20-SLA20-80	20	20	80	50	M12
EXT20-SLA20-125	20	20	125	50	M12
EXT20-SLA20-150	20	20	150	50	M12
EXT20-SLA20-200	20	20	200	50	M12
EXT20-SLA20-250	20	20	250	50	M12
EXT25-SLA25-80	25	25	80	50	M12
EXT25-SLA25-125	25	25	125	50	M12
EXT25-SLA25-150	25	25	150	50	M12
EXT25-SLA25-200	25	25	200	50	M12
EXT25-SLA25-250	25	25	250	50	M12
EXT32-SLA32-80	32	32	80	50	M14
EXT32-SLA32-125	32	32	125	50	M14
EXT32-SLA32-150	32	32	150	50	M14
EXT32-SLA32-200	32	32	200	50	M14
EXT32-SLA32-250	32	32	250	50	M14
EXT40-SLA40-80	40	40	80	60	M14
EXT40-SLA40-125	40	40	125	60	M14
EXT40-SLA40-150	40	40	150	60	M14
EXT40-SLA40-200	40	40	200	60	M14
EXT40-SLA40-250	40	40	250	60	M14

推荐切削参数(型钢)

针对KRUIZ SLK刀体 + 硬质合金IDFK钻头(刀片)

步骤	钻头直径		转数	每转进给		线速		每分钟进给		功率 (KW)	进给力 (KGF)	稳定性	刀具寿命	速度
	公制	英制		f(mm/rev.)	IPR(inch/rev.)	V(m/min.)	SFM(feet/min.)	F(mm)	IPM(inch)					
步骤 1	14.0	9/16"	760	0.20	0.008	33	110	152	6.0	1.7	331	稳定	长	慢
	16.0	41/64"	740	0.21	0.008	37	122	155	6.1	2.2	387			
	17.5	45/64"	720	0.22	0.009	40	130	158	6.3	2.6	434			
	18.0	23/32"	700	0.22	0.009	40	130	154	6.1	2.6	445			
	21.5	55/64"	620	0.24	0.009	42	137	149	5.8	3.3	556			
	22.0	7/8"	600	0.24	0.009	41	136	144	5.6	3.3	568			
	24.0	15/16"	570	0.26	0.010	43	141	148	5.8	3.9	648			
	24.5	31/32"	550	0.26	0.010	42	139	143	5.6	3.9	661			
	26.0	1-1/32"	520	0.28	0.011	42	139	146	5.7	4.2	732			
	26.5	1-3/64"	510	0.28	0.011	42	139	143	5.6	4.3	745			
	27.0	1-1/16"	500	0.28	0.011	42	139	140	5.5	4.3	758			
	30.0	1-3/16"	400	0.29	0.011	38	124	116	4.6	4.1	856			
	40.0	1-37/64"	300	0.29	0.011	38	124	87	3.4	5.0	1126			
	14.0	9/16"	970	0.21	0.008	43	140	204	8.1	2.3	341			
	16.0	41/64"	950	0.22	0.009	48	157	209	8.3	3.0	398			
步骤 2	17.5	45/64"	930	0.24	0.009	51	168	223	8.7	3.7	457			
	18.0	23/32"	900	0.24	0.009	51	167	216	8.5	3.8	470			
	21.5	55/64"	800	0.26	0.010	54	177	208	8.2	4.8	584			
	22.0	7/8"	780	0.26	0.010	54	177	203	8.0	4.9	597			
	24.0	15/16"	710	0.28	0.011	54	175	199	7.8	5.3	678			
	24.5	31/32"	690	0.28	0.011	53	174	193	7.6	5.4	692			
	26.0	1-1/32"	640	0.30	0.012	52	171	192	7.6	5.7	763			
	26.5	1-3/64"	630	0.30	0.012	52	172	189	7.4	5.8	777			
	27.0	1-1/16"	610	0.30	0.012	52	170	183	7.2	5.8	791			
	30.0	1-3/16"	500	0.30	0.012	47	154	150	5.9	5.5	874			
	40.0	1-37/64"	350	0.31	0.012	44	144	109	4.3	6.3	1172			
	14.0	9/16"	1,180	0.22	0.009	52	170	260	10.3	3.1	351			
	16.0	41/64"	1,160	0.23	0.009	58	191	267	10.6	4.0	409			
	17.5	45/64"	1,140	0.26	0.010	63	205	296	11.6	5.0	480			
	18.0	23/32"	1,100	0.26	0.010	62	204	286	11.2	5.1	493			
步骤 3	21.5	55/64"	980	0.28	0.011	66	217	274	10.8	6.5	611			
	22.0	7/8"	960	0.28	0.011	66	218	269	10.6	6.6	624			
	24.0	15/16"	850	0.30	0.012	64	210	255	10.0	7.0	707			
	24.5	31/32"	830	0.30	0.012	64	209	249	9.8	7.1	721			
	26.0	1-1/32"	760	0.32	0.013	62	204	243	9.6	7.4	794			
	26.5	1-3/64"	750	0.32	0.013	62	205	240	9.5	7.5	808			
	27.0	1-1/16"	720	0.32	0.013	61	200	230	9.1	7.4	823			
	30.0	1-3/16"	600	0.32	0.013	57	185	192	7.6	7.2	909			
	40.0	1-37/64"	400	0.32	0.013	50	165	128	5.0	7.6	1195			
	14.0	9/16"	1,330	0.23	0.009	58	192	306	12.1	3.7	360			
	16.0	41/64"	1,310	0.24	0.009	66	216	314	12.3	4.8	420			
	17.5	45/64"	1,290	0.28	0.011	71	233	361	14.2	6.2	502			
	18.0	23/32"	1,240	0.28	0.011	70	230	347	13.6	6.2	516			
	21.5	55/64"	1,100	0.30	0.012	74	244	330	13.0	7.8	637			
	22.0	7/8"	1,080	0.30	0.012	75	245	324	12.7	8.0	651			
步骤 4	24.0	15/16"	930	0.32	0.013	70	230	298	11.7	8.2	736			
	24.5	31/32"	910	0.32	0.013	70	230	291	11.5	8.3	750			
	26.0	1-1/32"	850	0.34	0.013	69	228	289	11.4	8.8	824			
	26.5	1-3/64"	810	0.34	0.013	67	221	275	10.9	8.6	839			
	27.0	1-1/16"	800	0.34	0.013	68	222	272	10.7	8.8	854			
	30.0	1-3/16"	700	0.34	0.013	66	216	238	9.4	9.1	944			
	40.0	1-37/64"	450	0.34	0.013	57	185	153	6.0	9.1	1240			
	14.0	9/16"	1,800	0.24	0.009	79	260	432	16.9	5.6	370			
	16.0	41/64"	1,780	0.25	0.010	89	293	445	17.4	7.3	431			
	17.5	45/64"	1,760	0.30	0.012	97	317	528	20.8	9.5	524			
	18.0	23/32"	1,660	0.30	0.012	94	308	498	19.6	9.3	538			

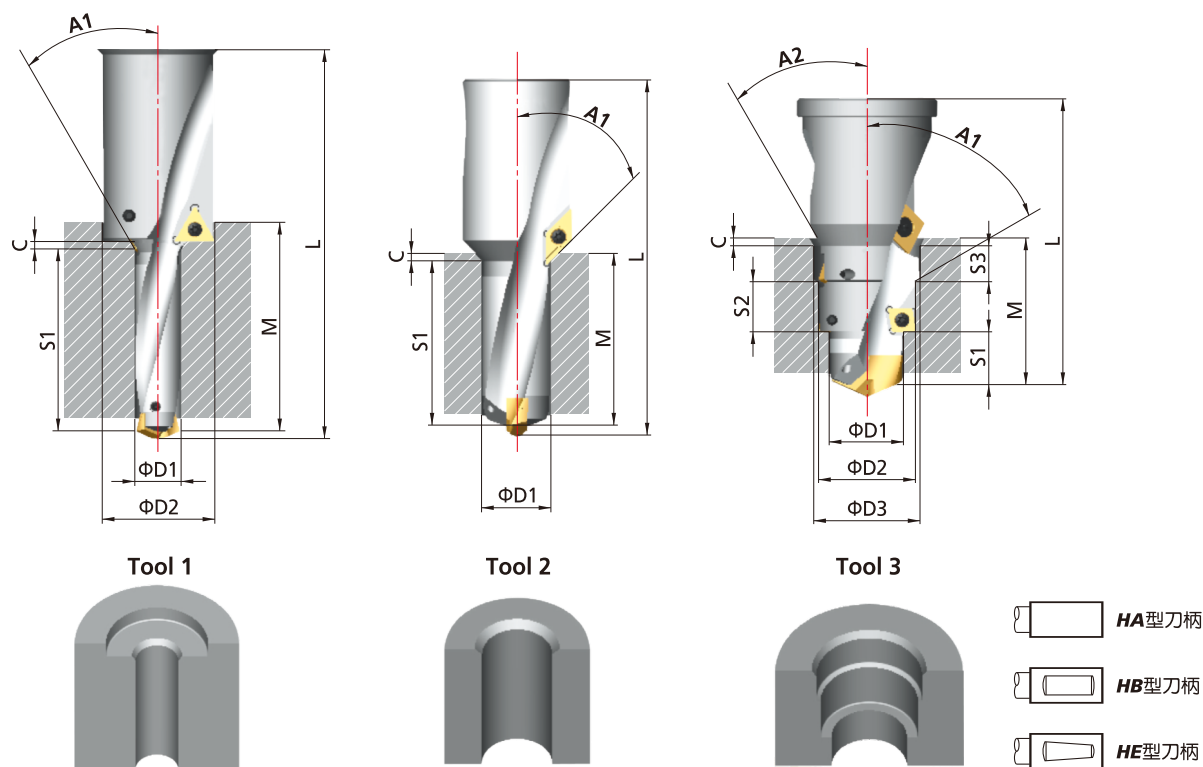
KRUZ非标阶梯组合钻的刀体

这种组合钻，一次就能同时加工2~3种不同直径的孔和倒角。精度高、效率高、降成本。



- ▶ 螺旋槽钻头刀体，更容易排屑对主轴冷却有帮助
- ▶ 采用我公司的标准钻尖(ID、IDP、IDF)以及ISO标准倒角刀片
- ▶ 所有的装换刀片，不需拆下刀体可直接换刀
- ▶ 缩短周期，提高生产效率、降低成本

定制时请参考以下形状与尺寸标注方法，标明各部分尺寸，并提供图纸

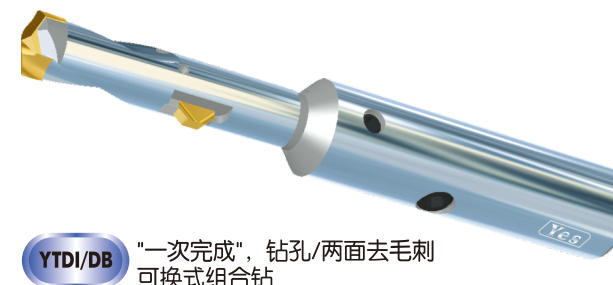


定制时提供以下信息，便有助于设计刀具

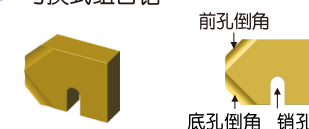
- ① 工件材质 (请注明)
- ② 刀柄型式 (HA型, HB型, HE型或其他非标)
- ③ 倒角刀片、阶梯刀片的种类 (限于ISO标准)
- ④ 是否要求带内冷
- ⑤ 提供工件图纸

“一次完成”钻孔/去毛刺，可换式组合钻

这种组合钻，不停止旋转连续完成钻孔与两面去毛刺，效率惊人。



YTDI/DB “一次完成”，钻孔/两面去毛刺可换式组合钻



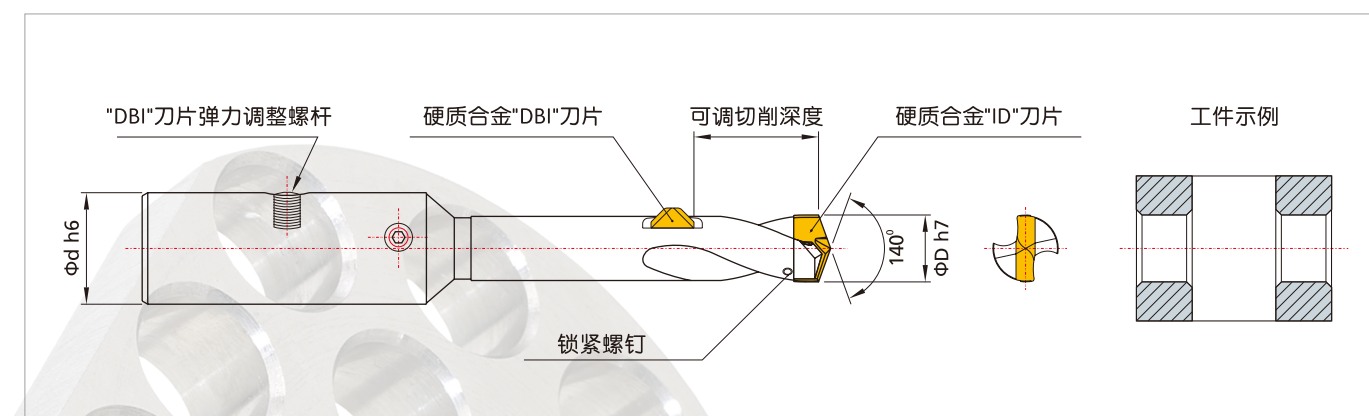
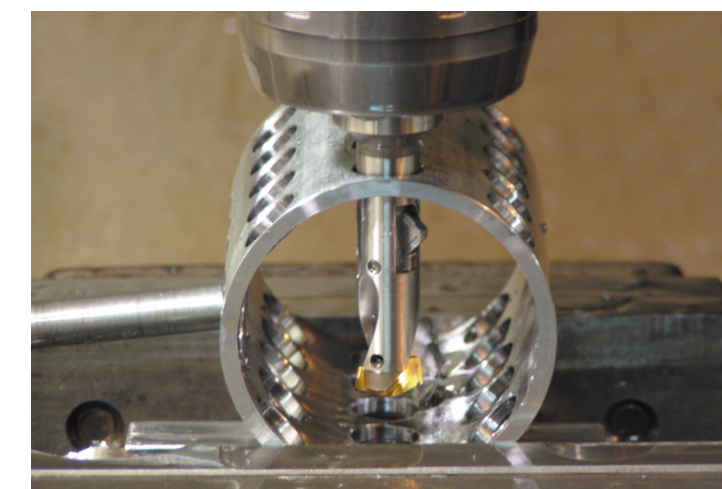
DBI 硬质合金去毛刺刀片 45° (有TiN, TiAlN涂层)



IDP 标准硬质合金刀片 (有TiN, TiAlN涂层)

*注：如需要准确的倒角尺寸(如C=1.0)时，不能使用这种刀具

- ▶ 连续不断地完成：钻孔以及清理前/后两面毛刺
- ▶ 前端钻孔刀片，采用了我公司的标准刀片
- ▶ 去毛刺“DBI”刀片，可简便更换，并且通过刀片弹力调整螺杆来调整其侧向力
- ▶ 当钻头穿过孔时，“DBI”刀片自动回缩进去，不刮伤孔的加工表面。
- ▶ 不需从机床卸下刀体，可简便更换两种刀片
- ▶ 可设计各种深度和去毛刺角度(倒角)
- ▶ 不需另外调整去毛刺与钻孔的各别速度，所有加工始终可维持相同速度

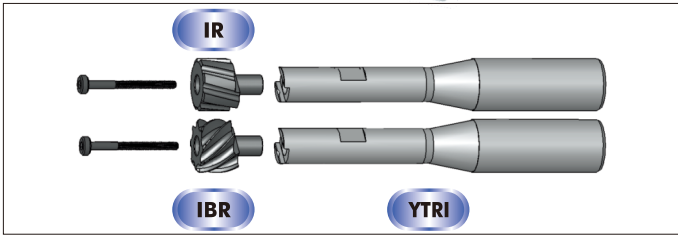


YesTool公司的“一次完成”组合钻实现了惊人的“高效率、低成本”

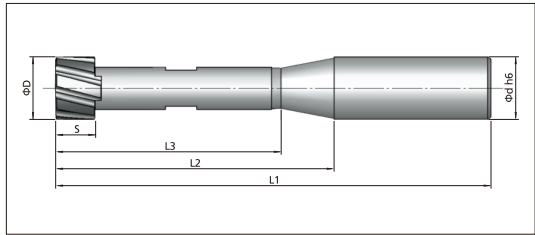


“DBI”刀片，在进刀/退刀时，可以一次清除前/后孔的毛刺。当钻头穿过孔时，这种特殊刀片自动回缩进去，不刮伤孔的加工表面。

YTRI可换式铰刀刀体与硬质合金刀头



- ▶ 可换式硬质合金铰刀刀头
- ▶ 大幅度降低大直径(15mm以上)铰削加工的成本
- ▶ 用螺栓从中心孔锁定刀头
- ▶ IR: 右螺旋多刃铰刀刀头
- ▶ IBR: 左螺旋拉铰刀刀头
- ▶ 快速铰削, 满足H7精度

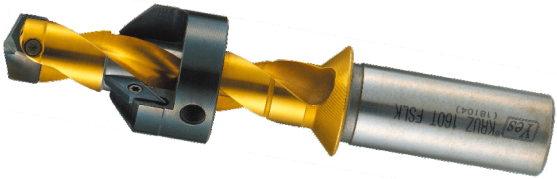


订货时, 请在口内标明孔深。如: T(3倍孔径), P(5倍孔径)

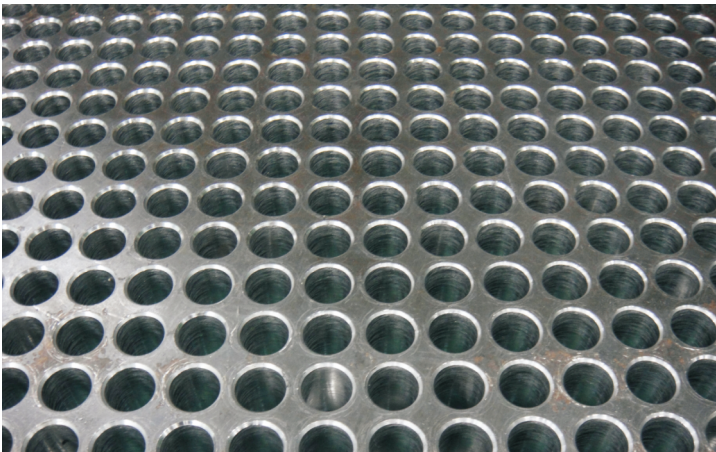
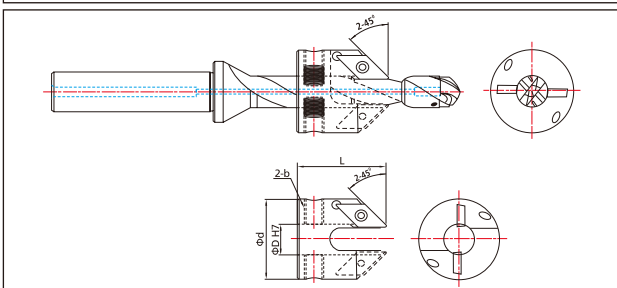
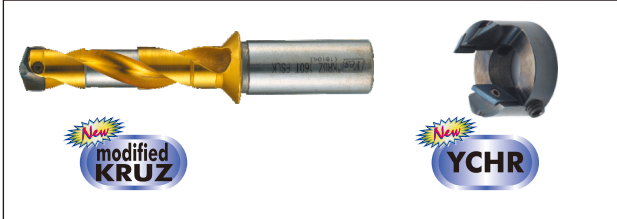
刀体型号	柄径 d	S	T(3 x Dia.)			P(5 x Dia.)			适用的 IR, IBR规格	锁定螺栓 M	刃数
			L1	L2	L3	L1	L2	L3			
YTRI 150-174 □	20	7.4	114	64	53	148	98	87	IR 150~174, IBR 150~174	M2.5x30	6
YTRI 175-199 □		9.4	125	75	61	165	115	101	IR 175~199, IBR 175~199	M2.5x30	
YTRI 200-224 □		9.3	136	86	69	180	130	113	IR 200~224, IBR 200~224	M3x35	
YTRI 225-249 □	25	10.6	153	97	75	203	147	125	IR 225~249, IBR 225~249	M4x40	8
YTRI 250-274 □		10.4	158	102	82	213	157	137	IR 250~274, IBR 250~274	M5x45	
YTRI 275-299 □	32	12.2	177	117	90	237	177	150	IR 275~299, IBR 275~299	M5x45	10
YTRI 300-324 □		13.1	183	123	96	248	188	161	IR 300~324, IBR 300~324	M6x40	
YTRI 325-349 □		13.8	190	130	103	260	200	173	IR 325~349, IBR 325~349	M6x45	
YTRI 350-374 □	40	14.6	215	145	110	290	220	185	IR 350~374, IBR 350~374	M8x50	12
YTRI 375-400 □		15.4	222	152	117	302	232	197	IR 375~400, IBR 375~400	M8x50	

* 注: 加工盲孔, 底部带刃的铰刀可定制

KRUZ可换式倒角组合刀具



- ▶ 适当修改标准KRUZ刀体, 就能组合倒角刀架
- ▶ YCHR倒角刀架, 安装两个XCGX 1102倒角刀片
- ▶ 在KRUZ刀体部分, 设计了两个螺钉支撑面
- ▶ 使用范围为: KRUZ刀体直径8 ~ 50.0mm
- ▶ 特殊深度, 根据需求定制



测试报告表

Yes[®] YESTOOL Co., Ltd.

❖ 韩国·京畿道安山市檀园区城谷路189
❖ 电话: +82-31-493-2387 / 8 (内线 #2) ❖ 传真: +82-31-494-7619
❖ e-mail: yestool@yestool.co.kr ❖ www.yestool.com

公司(工厂)名:	电 话:	日 期:	操作员 / 操作的情况:	
代销商名:	电 话:	工件材质与特性:		硬 度 RC BRN
产品名称:	内 冷 ☐	外 冷 ☐	卧式机床 ☐	立式机床 ☐
机床名称:	切削油(油性 / 水溶性) 品 牌		切削油压力 (理论 / 实际) Mpa or Bar	切削油流量 (实际) GPM
机床状态:	主轴功率(HP)		钻孔理由 螺纹底孔 ☐ 精加工孔 ☐ 粗加工孔 ☐	
机床的工作情况描述:				

项 目	YesTool公司产品	其他公司产品(目前使用的产品)
目前使用的钻头生产厂家(品牌)		
钻头的种类(高速钢或超硬) / 直径		
工件(被削件)的夹持方法		
可更换刀片式还是整体型?		
刀片种类及其生产厂家(品牌)		
粗加工? 孔径与公差?		
精加工? 孔径与公差?		
孔深(盲孔还是通孔)		
转速(rpm)		
线速 Vc (m/分钟)		
进给量 f (mm/每转)		
每分钟进给量 F(mm/分钟)		
每孔的加工时间(秒)		
排屑状态(屑的模样)		
孔的精度要求		
每一个钻头的可加工孔数		
每一个钻头的可加工总长(钻头寿命)		
换钻头品牌的理由		
每一个钻头刀体可用到替换多少个刀片?		
目前使用的是否为刀片更换方式?		
刀片价格		
再磨计划		
再磨、钝化、再涂层费用		
机床的每小时生产率(费用)		
每一工件的孔数		
产品年生产量		