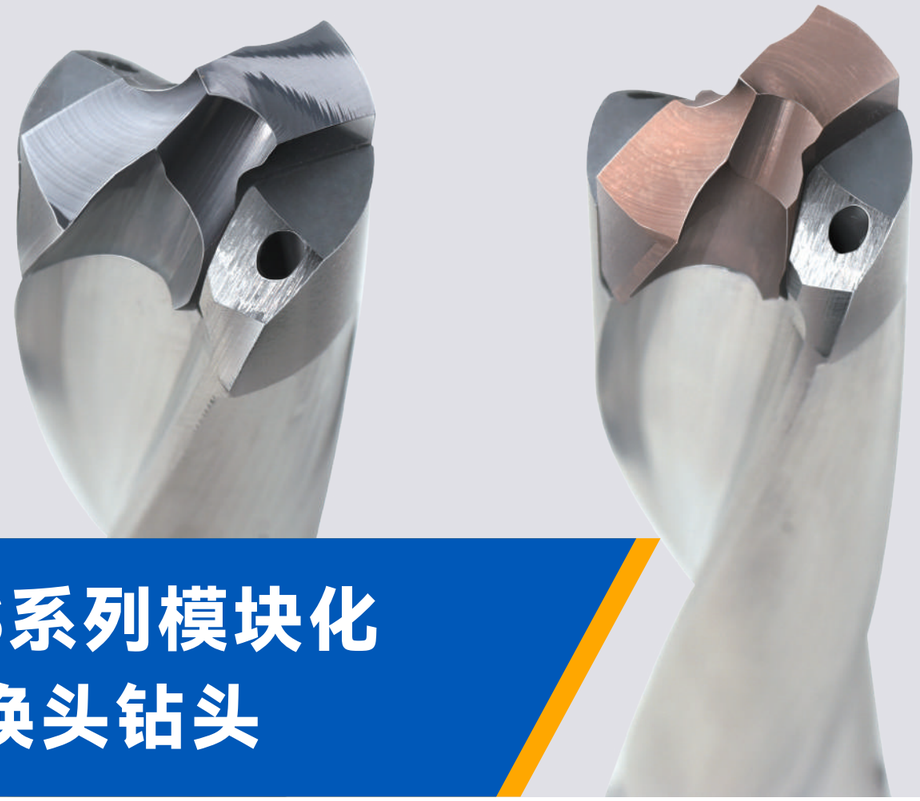
ROUND TOOLS ONE-STOP

GENERAL SERVICE PROVIDER

圆柄类刀具
一站式综合服务商



MS系列模块化可换头钻头

一站式服务　非标定制　百余年技术加持



PRODUCT INTRODUCTION

产品系列简介

5大亮点，
赋能产品质量

- 刀杆悬伸更长，可以满足更深的孔加工要求
- 钢刀杆配合硬质合金刀头的设计带来较低的刀具成本
- 稳固的刀片槽设计带来钻削应用中更高的准确性、安全性和稳定性
- 专用的刀片槽型和材质组合确保良好的切屑控制和出色的孔质量
- 钻尖设计可以保证长悬伸工况下依然保证孔位置度的要求

PRODUCT CODE

编号规则

MS模块化可换头钻头_刀体

MS	160	R3	B	20
1	2	3	4	5

1 MS系列模块化可换头钻头
2 最小钻头直径(mm)-D
3 最大钻深(mm)-L2
4 刀柄接口形式-侧固柄 DIN6535 HB
5 刀柄尺寸(mm)-Ds

MS模块化可换头钻头_刀片

MS	100	P	·	1600	-	A40	H
1	2	3		4		5	6

1 MS系列模块化可换头钻头
2 产品系列
3 可加工材料ISO P
4 钻头直径(mm)-D
5 钻头材质等级
6 涂层DH

SELECT GUIDE

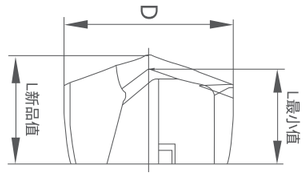
选择指南

● 首选
○ 备选

MODULAR EXCHANGEABLE TIP DRILL 模块化可换头钻头		系列	P	M	K	N	S	H	孔公差	标准范围 直径范围 D mm Min	Max	钻削深度 L/D mm	内冷	涂层 DH	涂层 DP	引导孔	盲孔	通孔	叠板	出口斜面	入口斜面	交叉孔
通用钻削系列（● 适合，○ 一般）																						
	刀片	MS150P	●	○	●			○	IT9-IT11	16.00	36.00			●		●						
		MS100P	●	○	●			○						●			●	●	○		○	
		MS356P	●	○	●			○						●		●						
		MS366P	●	○	●			○						●			●	●	○		○	
		MS356M		●			○								●	●						
		MS366M		●			○								●		●	●	○		○	
		MS356S		○			●								●	●						
		MS366S		○			●								●		●	●	○		○	
	刀体									16.00	18.00	1-10×D	●									
										18.01	19.99		●									
										20.00	22.00		●									
										22.01	24.00		●									
										24.01	26.00		●									
										26.01	28.00		●									
										28.01	30.00		●									
										30.01	32.00		●									
										32.01	36.00	1-8×D	●									

MS模块式可换头钻头_刀片

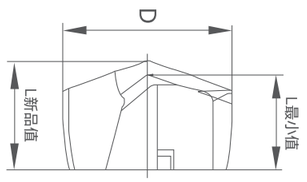




P ●
M ○
K ●
N
S
H ○

单刃带	145°	单刃带	140°	D mm		L mm		刀座尺寸
				16.00-36.00				+0.005/-0.015
MS150P系列 □□□□-D直径		MS100P系列 □□□□-D直径		MIN	MAX	新品值	最小值	
MS150P.□□□□-A46H		MS100P.□□□□-A46H		16.00	18.00	12	10.3	1
				18.01	19.99	13	11.2	2
				20.00	22.00	14	12.1	3
				22.01	24.00	15	13	4
				24.01	26.00	16	13.9	5
				26.01	28.00	17	14.8	6
				28.01	30.00	18	15.7	7
				30.01	32.00	19	16.6	8
				32.01	36.00	21	18.4	9



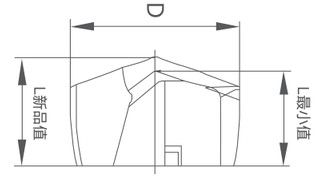


P ●
M ○
K ●
N
S
H ○

单刃带	145°	单刃带	140°	D mm		L mm		刀座尺寸
				16.00-36.00				+0.005/-0.015
MS356P系列 □□□□-D直径		MS366P系列 □□□□-D直径		MIN	MAX	新品值	最小值	
MS356P.□□□□-A46H		MS366P.□□□□-A46H		16.00	18.00	12	10.3	1
				18.01	19.99	13	11.2	2
				20.00	22.00	14	12.1	3
				22.01	24.00	15	13	4
				24.01	26.00	16	13.9	5
				26.01	28.00	17	14.8	6
				28.01	30.00	18	15.7	7
				30.01	32.00	19	16.6	8
				32.01	36.00	21	18.4	9

订货示例：D直径为19.3的MS366P刀片　订货号：MS366P.1930-A46H

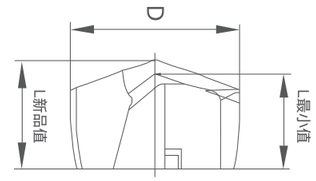




P
M ●
K
N
S ○
H

单刃带	145°	单刃带	140°	D mm		L mm		刀座尺寸
				16.00-36.00				+0.005/-0.015
MS356M系列 □□□□-D直径		MS366M系列 □□□□-D直径		MIN	MAX	新品值	最小值	
MS356M.□□□□-A46P		MS366M.□□□□-A46P		16.00	18.00	12	10.3	1
				18.01	19.99	13	11.2	2
				20.00	22.00	14	12.1	3
				22.01	24.00	15	13	4
				24.01	26.00	16	13.9	5
				26.01	28.00	17	14.8	6
				28.01	30.00	18	15.7	7
				30.01	32.00	19	16.6	8
				32.01	36.00	21	18.4	9





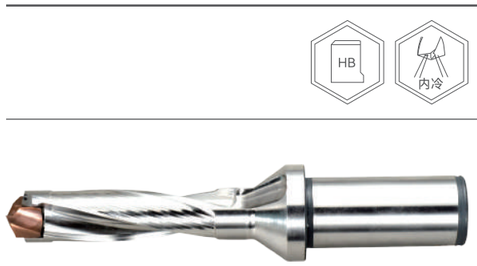
P
M ○
K
N
S ●
H

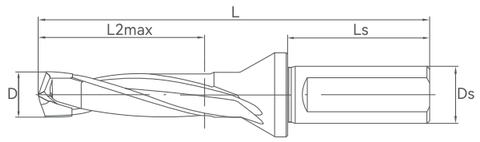
单刃带	145°	单刃带	140°	D mm		L mm		刀座尺寸
				16.00-36.00				+0.005/-0.015
MS356S系列 □□□□-D直径		MS366S系列 □□□□-D直径		MIN	MAX	新品值	最小值	
MS356S.□□□□-A46H		MS366S.□□□□-A46P		16.00	18.00	12	10.3	1
				18.01	19.99	13	11.2	2
				20.00	22.00	14	12.1	3
				22.01	24.00	15	13	4
				24.01	26.00	16	13.9	5
				26.01	28.00	17	14.8	6
				28.01	30.00	18	15.7	7
				30.01	32.00	19	16.6	8
				32.01	36.00	21	18.4	9

订货示例：D直径为19.3MM的MS366S刀片　订货号：MS366S.1930-A46P

MODULAR EXCHANGEABLE TIP DRILL · 公制

1×D刀体

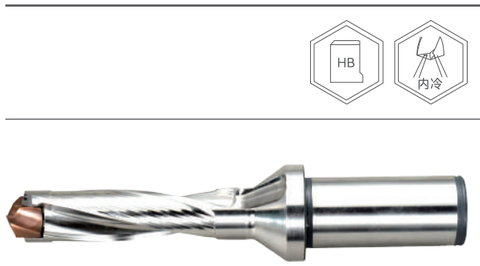


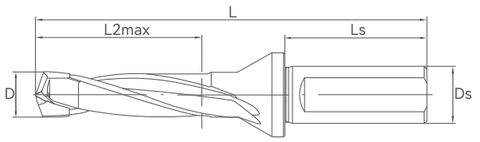


1×D	L mm	L2 mm	Ls mm	Ds mm	D mm MIN	D mm MAX	刀座尺寸	中心锁紧螺钉	扳手
MS160R1B20	104	18	50	20	16.00	18.00	1	LD-M2.5×M3.5	BS185-1,5X1,5
MS181R1B25	113	20	56	25	18.01	19.99	2	LD-M2.5×M3.5	BS185-1,5X1,5
MS200R1B25	114	22	56	25	20.00	22.00	3	LD-M3×M4	BS210-2X2
MS221R1B25	115	24	56	25	22.01	24.00	4	LD-M3×M4	BS210-2X2
MS241R1B32	124	26	60	32	24.01	26.00	5	LD-M4×M5	BS240-2.5X2.5
MS261R1B32	126	28	60	32	26.01	28.00	6	LD-M4×M5	BS240-2.5X2.5
MS281R1B32	127	30	60	32	28.01	30.00	7	LD-M5×M6	BS265-3X3
MS301R1B32	130	32	60	32	30.01	32.00	8	LD-M5×M6	BS265-3X3
MS321R1B32	150	36	70	40	32.01	36.00	9	LD-M6×M6	BS265-3X3

MODULAR EXCHANGEABLE TIP DRILL · 公制

3×D刀体

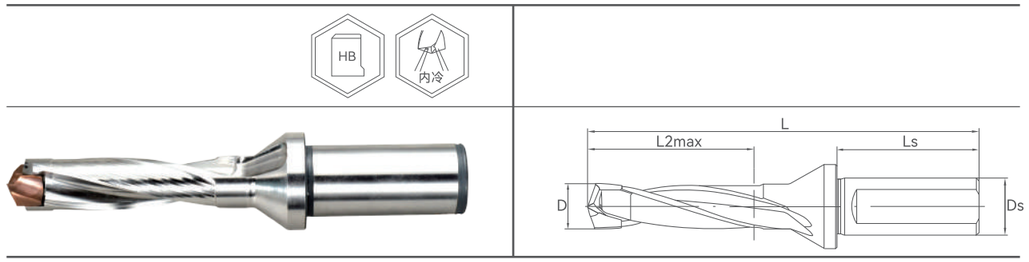




3×D	L mm	L2 mm	Ls mm	Ds mm	D mm MIN	D mm MAX	刀座尺寸	中心锁紧螺钉	扳手
MS160R3B20	128	48	50	20	16.00	17.00	1	LD-M2.5×M3.5	BS185-1,5X1,5
MS170R3B20	131	51	50	20	17.00	18.00	1	LD-M2.5×M3.5	BS185-1,5X1,5
MS180R3B20	135	54	50	20	18.00	18.00	1	LD-M2.5×M3.5	BS185-1,5X1,5
MS181R3B25	146	55	56	25	18.01	19.00	2	LD-M2.5×M3.5	BS185-1,5X1,5
MS190R3B25	149	57	56	25	19.00	19.99	2	LD-M2.5×M3.5	BS185-1,5X1,5
MS200R3B25	152	60	56	25	20.00	21.00	3	LD-M3×M4	BS210-2X2
MS210R3B25	156	63	56	25	21.00	22.00	3	LD-M3×M4	BS210-2X2
MS220R3B25	159	66	56	25	22.00	22.00	3	LD-M3×M4	BS210-2X2
MS221R3B25	159	67	56	25	22.01	23.00	4	LD-M3×M4	BS210-2X2
MS230R3B25	162	69	56	25	23.01	24.00	4	LD-M3×M4	BS210-2X2
MS240R3B25	165	72	56	25	24.00	24.00	4	LD-M3×M4	BS210-2X2
MS241R3B32	175	73	60	32	24.01	25.00	5	LD-M4×M5	BS240-2.5X2.5
MS250R3B32	179	75	60	32	25.00	26.00	5	LD-M4×M5	BS240-2.5X2.5
MS260R3B32	182	78	60	32	26.00	26.00	5	LD-M4×M5	BS240-2.5X2.5
MS261R3B32	182	79	60	32	26.01	27.00	6	LD-M4×M5	BS240-2.5X2.5
MS270R3B32	185	81	60	32	27.00	28.00	6	LD-M4×M5	BS240-2.5X2.5
MS280R3B32	188	84	60	32	28.00	28.00	6	LD-M4×M5	BS240-2.5X2.5
MS281R3B32	188	85	60	32	28.01	29.00	7	LD-M5×M6	BS267-3X3
MS290R3B32	192	87	60	32	29.00	30.00	7	LD-M5×M6	BS267-3X3
MS300R3B32	195	90	60	32	30.00	30.00	7	LD-M5×M6	BS267-3X3
MS301R3B32	195	91	60	32	30.01	31.00	8	LD-M5×M6	BS267-3X3
MS310R3B32	198	93	60	32	31.00	32.00	8	LD-M5×M6	BS267-3X3
MS320R3B32	202	96	60	32	32.00	32.00	8	LD-M5×M6	BS267-3X3
MS321R3B40	220	97	70	40	32.01	33.00	9	LD-M6×M6	BS267-3X3
MS330R3B40	223	99	70	40	33.00	34.00	9	LD-M6×M6	BS267-3X3
MS340R3B40	226	102	70	40	34.00	35.00	9	LD-M6×M6	BS267-3X3
MS350R3B40	229	105	70	40	35.00	36.00	9	LD-M6×M6	BS267-3X3
MS360R3B40	232	108	70	40	36.00	36.00	9	LD-M6×M6	BS267-3X3

MODULAR EXCHANGEABLE TIP DRILL·公制

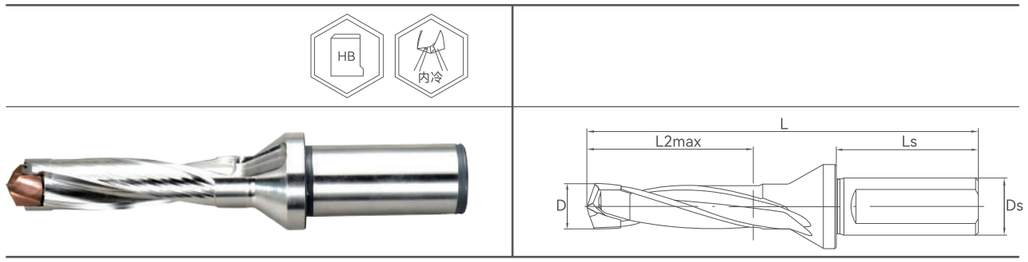
5×D刀体



5×D	L mm	L2 mm	Ls mm	Ds mm	D mm MIN	D mm MAX	刀座尺寸	中心锁紧螺钉	扳手
MS160R5B20	160	80	50	20	16.00	17.00	1	LD-M2.5×M3.5	BS185-1,5X1,5
MS170R5B20	165	85	50	20	17.00	18.00	1	LD-M2.5×M3.5	BS185-1,5X1,5
MS180R5B20	171	90	50	20	18.00	18.00	1	LD-M2.5×M3.5	BS185-1,5X1,5
MS181R5B25	182	91	56	25	18.01	19.00	2	LD-M2.5×M3.5	BS185-1,5X1,5
MS190R5B25	187	95	56	25	19.00	19.99	2	LD-M2.5×M3.5	BS185-1,5X1,5
MS200R5B25	192	100	56	25	20.00	21.00	3	LD-M3×M4	BS210-2X2
MS210R5B25	198	105	56	25	21.00	22.00	3	LD-M3×M4	BS210-2X2
MS220R5B25	203	110	56	25	22.00	22.00	3	LD-M3×M4	BS210-2X2
MS221R5B25	203	111	56	25	22.01	23.00	4	LD-M3×M4	BS210-2X2
MS230R5B25	208	115	56	25	23.01	24.00	4	LD-M3×M4	BS210-2X2
MS240R5B25	213	120	56	25	24.00	24.00	4	LD-M3×M4	BS210-2X2
MS241R5B32	224	121	60	32	24.01	25.00	5	LD-M4×M5	BS240-2.5X2.5
MS250R5B32	229	125	60	32	25.00	26.00	5	LD-M4×M5	BS240-2.5X2.5
MS260R5B32	234	130	60	32	26.00	26.00	5	LD-M4×M5	BS240-2.5X2.5
MS261R5B32	234	131	60	32	26.01	27.00	6	LD-M4×M5	BS240-2.5X2.5
MS270R5B32	239	135	60	32	27.00	28.00	6	LD-M4×M5	BS240-2.5X2.5
MS280R5B32	244	140	60	32	28.00	28.00	6	LD-M4×M5	BS240-2.5X2.5
MS281R5B32	245	141	60	32	28.01	29.00	7	LD-M5×M6	BS267-3X3
MS290R5B32	250	145	60	32	29.00	30.00	7	LD-M5×M6	BS267-3X3
MS300R5B32	255	150	60	32	30.00	30.00	7	LD-M5×M6	BS267-3X3
MS301R5B32	256	151	60	32	30.01	31.00	8	LD-M5×M6	BS267-3X3
MS310R5B32	260	155	60	32	31.00	32.00	8	LD-M5×M6	BS267-3X3
MS320R5B32	266	160	60	32	32.00	32.00	8	LD-M5×M6	BS267-3X3
MS321R5B40	284	161	70	40	32.01	33.00	9	LD-M6×M6	BS284-3X3
MS330R5B40	289	165	70	40	33.00	34.00	9	LD-M6×M6	BS284-3X3
MS340R5B40	294	170	70	40	34.00	35.00	9	LD-M6×M6	BS330-3X3
MS350R5B40	299	175	70	40	35.00	36.00	9	LD-M6×M6	BS330-3X3
MS360R5B40	304	180	70	40	36.00	36.00	9	LD-M6×M6	BS330-3X3

MODULAR EXCHANGEABLE TIP DRILL·公制

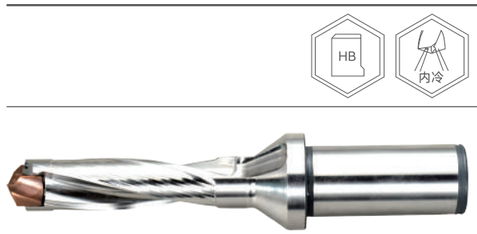
7×D刀体

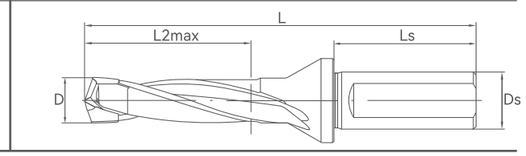


7×D	L mm	L2 mm	Ls mm	Ds mm	D mm MIN	D mm MAX	刀座尺寸	中心锁紧螺钉	扳手
MS160R7B20	192	112	50	20	16.00	17.00	1	LD-M2.5×M3.5	BS225-1,5X1,5
MS170R7B20	199	119	50	20	17.00	18.00	1	LD-M2.5×M3.5	BS225-1,5X1,5
MS180R7B20	207	126	50	20	18.00	18.00	1	LD-M2.5×M3.5	BS225-1,5X1,5
MS181R7B25	218	127	56	25	18.01	19.00	2	LD-M2.5×M3.5	BS225-1,5X1,5
MS190R7B25	225	133	56	25	19.00	19.99	2	LD-M2.5×M3.5	BS225-1,5X1,5
MS200R7B25	232	140	56	25	20.00	21.00	3	LD-M3×M4	BS260-2X2
MS210R7B25	240	147	56	25	21.00	22.00	3	LD-M3×M4	BS260-2X2
MS220R7B25	247	154	56	25	22.00	22.00	3	LD-M3×M4	BS260-2X2
MS221R7B25	247	155	56	25	22.01	23.00	4	LD-M3×M4	BS260-2X2
MS230R7B25	254	161	56	25	23.01	24.00	4	LD-M3×M4	BS260-2X2
MS240R7B25	261	168	56	25	24.00	24.00	4	LD-M3×M4	BS260-2X2
MS241R7B32	272	169	60	32	24.01	25.00	5	LD-M4×M5	BS295-2.5X2.5
MS250R7B32	279	175	60	32	25.00	26.00	5	LD-M4×M5	BS295-2.5X2.5
MS260R7B32	286	182	60	32	26.00	26.00	5	LD-M4×M5	BS295-2.5X2.5
MS261R7B32	287	183	60	32	26.01	27.00	6	LD-M4×M5	BS295-2.5X2.5
MS270R7B32	293	189	60	32	27.00	28.00	6	LD-M4×M5	BS295-2.5X2.5
MS280R7B32	300	196	60	32	28.00	28.00	6	LD-M4×M5	BS295-2.5X2.5
MS281R7B32	301	197	60	32	28.01	29.00	7	LD-M5×M6	BS330-3X3
MS290R7B32	308	203	60	32	29.00	30.00	7	LD-M5×M6	BS330-3X3
MS300R7B32	315	210	60	32	30.00	30.00	7	LD-M5×M6	BS330-3X3
MS301R7B32	316	211	60	32	30.01	31.00	8	LD-M5×M6	BS330-3X3
MS310R7B32	322	217	60	32	31.00	32.00	8	LD-M5×M6	BS330-3X3
MS320R7B32	330	224	60	32	32.00	32.00	8	LD-M5×M6	BS330-3X3
MS321R7B40	348	225	70	40	32.01	33.00	9	LD-M6×M6	BS440-3X3
MS330R7B40	355	231	70	40	33.00	34.00	9	LD-M6×M6	BS440-3X3
MS340R7B40	362	238	70	40	34.00	35.00	9	LD-M6×M6	BS40-3X3
MS350R7B40	369	245	70	40	35.00	36.00	9	LD-M6×M6	BS440-3X3
MS360R7B40	376	252	70	40	36.00	36.00	9	LD-M6×M6	BS440-3X3

MODULAR EXCHANGEABLE TIP DRILL·公制

8×D刀体

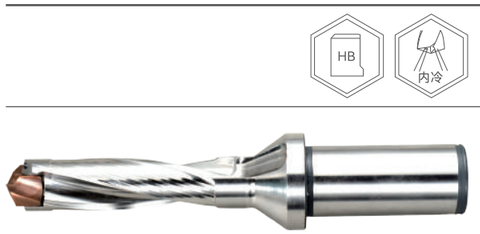


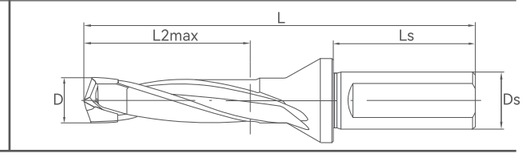


8×D	L mm	L2 mm	Ls mm	Ds mm	D mm MIN	D mm MAX	刀座尺寸	中心锁紧螺钉	扳手
MS160R8B20	208	128	50	20	16.00	17.00	1	LD-M2.5×M3.5	BS225-1,5X1,5
MS170R8B20	216	136	50	20	17.00	18.00	1	LD-M2.5×M3.5	BS225-1,5X1,5
MS180R8B20	225	144	50	20	18.00	18.00	1	LD-M2.5×M3.5	BS225-1,5X1,5
MS181R8B25	236	145	56	25	18.01	19.00	2	LD-M2.5×M3.5	BS270-1,5X1,5
MS190R8B25	244	152	56	25	19.00	19.99	2	LD-M2.5×M3.5	BS270-1,5X1,5
MS200R8B25	252	160	56	25	20.00	21.00	3	LD-M3×M4	BS260-2X2
MS210R8B25	261	168	56	25	21.00	22.00	3	LD-M3×M4	BS260-2X2
MS220R8B25	269	176	56	25	22.00	22.00	3	LD-M3×M4	BS273-2X2
MS221R8B25	270	177	56	25	22.01	23.00	4	LD-M3×M4	BS273-2X2
MS230R8B25	277	184	56	25	23.01	24.00	4	LD-M3×M4	BS273-2X2
MS240R8B25	285	192	56	25	24.00	24.00	4	LD-M3×M4	BS282-2X2
MS241R8B32	296	193	60	32	24.01	25.00	5	LD-M4×M5	BS295-2.5X2.5
MS250R8B32	304	200	60	32	25.00	26.00	5	LD-M4×M5	BS393-2.5X2.5
MS260R8B32	312	208	60	32	26.00	26.00	5	LD-M4×M5	BS393-2.5X2.5
MS261R8B32	313	209	60	32	26.01	27.00	6	LD-M4×M5	BS393-2.5X2.5
MS270R8B32	320	216	60	32	27.00	28.00	6	LD-M4×M5	BS393-2.5X2.5
MS280R8B32	328	224	60	32	28.00	28.00	6	LD-M4×M5	BS393-2.5X2.5
MS281R8B32	329	225	60	32	28.01	29.00	7	LD-M5×M6	BS330-3X3
MS290R8B32	337	232	60	32	29.00	30.00	7	LD-M5×M6	BS440-3X3
MS300R8B32	345	240	60	32	30.00	30.00	7	LD-M5×M6	BS440-3X3
MS301R8B32	346	241	60	32	30.01	31.00	8	LD-M5×M6	BS440-3X3
MS310R8B32	353	248	60	32	31.00	32.00	8	LD-M5×M6	BS440-3X3
MS320R8B32	362	256	60	32	32.00	32.00	8	LD-M5×M6	BS440-3X3
MS321R8B40	380	257	70	40	32.01	33.00	9	LD-M6×M6	BS440-3X3
MS330R8B40	388	264	70	40	33.00	34.00	9	LD-M6×M6	BS440-3X3
MS340R8B40	396	272	70	40	34.00	35.00	9	LD-M6×M6	BS40-3X3
MS350R8B40	404	280	70	40	35.00	36.00	9	LD-M6×M6	BS440-3X3
MS360R8B40	412	288	70	40	36.00	36.00	9	LD-M6×M6	BS440-3X3

MODULAR EXCHANGEABLE TIP DRILL·公制

10×D刀体





10×D	L mm	L2 mm	Ls mm	Ds mm	D mm MIN	D mm MAX	刀座尺寸	中心锁紧螺钉	扳手
MS160R10B20	240	160	50	20	16.00	17.00	1	LD-M2.5×M3.5	BS270-1,5X1,5
MS170R10B20	250	170	50	20	17.00	18.00	1	LD-M2.5×M3.5	BS270-1,5X1,5
MS180R10B20	261	180	50	20	18.00	18.00	1	LD-M2.5×M3.5	BS270-1,5X1,5
MS181R10B25	273	181	56	25	18.01	19.00	2	LD-M2.5×M3.5	BS270-1,5X1,5
MS190R10B25	282	190	56	25	19.00	19.99	2	LD-M2.5×M3.5	BS281-1,5X1,5
MS200R10B25	292	200	56	25	20.00	21.00	3	LD-M3×M4	BS343-2X2
MS210R10B25	303	210	56	25	21.00	22.00	3	LD-M3×M4	BS343-2X2
MS220R10B25	313	220	56	25	22.00	22.00	3	LD-M3×M4	BS343-2X2
MS221R10B25	313	221	56	25	22.01	23.00	4	LD-M3×M4	BS343-2X2
MS230R10B25	323	230	56	25	23.01	24.00	4	LD-M3×M4	BS343-2X2
MS240R10B25	333	240	56	25	24.00	24.00	4	LD-M3×M4	BS343-2X2
MS241R10B32	344	241	60	32	24.01	25.00	5	LD-M4×M5	BS393-2.5X2.5
MS250R10B32	354	250	60	32	25.00	26.00	5	LD-M4×M5	BS393-2.5X2.5
MS260R10B32	364	260	60	32	26.00	26.00	5	LD-M4×M5	BS393-2.5X2.5
MS261R10B32	365	261	60	32	26.01	27.00	6	LD-M4×M5	BS393-2.5X2.5
MS270R10B32	374	270	60	32	27.00	28.00	6	LD-M4×M5	BS393-2.5X2.5
MS280R10B32	384	280	60	32	28.00	28.00	6	LD-M4×M5	BS393-2.5X2.5
MS281R10B32	385	281	60	32	28.01	29.00	7	LD-M5×M6	BS440-3X3
MS290R10B32	395	290	60	32	29.00	30.00	7	LD-M5×M6	BS440-3X3
MS300R10B32	405	300	60	32	30.00	30.00	7	LD-M5×M6	BS440-3X3
MS301R10B32	406	301	60	32	30.01	31.00	8	LD-M5×M6	BS440-3X3
MS310R10B32	415	310	60	32	31.00	32.00	8	LD-M5×M6	BS440-3X3
MS320R10B32	443	320	60	32	32.00	32.00	8	LD-M5×M6	BS440-3X3

安装方式

❶ 安装中心锁紧螺钉

- Φ32MM以下的刀片，锁紧螺钉与刀体表面齐平
- Φ32MM以上的刀片，锁紧螺钉低于刀体表面2MM

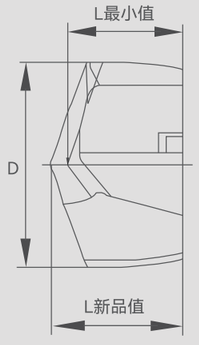


❷ 安装刀片

- 用扳手锁紧刀片，使其完全贴合刀体
- 如需更换刀片，逆时针旋转扳手，直至刀片脱落刀体



刀片尺寸表



刀座尺寸	直径范围 D mm	L 新品值	L 最小值（最短修磨长度）
1	15.88-18.00	12	10.3
2	18.01-19.99	13	11.2
3	20.00-22.00	14	12.1
4	22.01-24.00	15	13
5	24.01-26.00	16	13.9
6	26.01-28.00	17	14.8
7	28.01-30.00	18	15.7
8	31.01-32.00	19	16.6
9	32.01-36.00	21	18.4

切削参数

材料分组		工件材质	切削速度-vc 范围-m/min 最小值	初始值	最大值	根据直径推荐进给(Fn) mm/r 16	20	25.4	32	36
P	1	非合金钢	80	100	120	0.17-0.36	0.19-0.41	0.25-0.53	0.29-0.6	0.33-0.69
	2	低合金钢	80	90	100	0.17-0.36	0.19-0.41	0.25-0.53	0.29-0.6	0.33-0.69
	3	高合金钢	60	70	80	0.17-0.31	0.19-0.36	0.25-0.46	0.23-0.53	0.33-0.6
	4	铁素体、马氏体不锈钢	60	70	80	0.14-0.31	0.16-0.36	0.2-0.46	0.23-0.53	0.3-0.6
K	1	可锻铸铁	100	110	120	0.21-0.42	0.25-0.48	0.31-0.59	0.37-0.7	0.43-0.81
	2	灰口铸铁	90	100	110	0.21-0.41	0.25-0.48	0.31-0.59	0.37-0.7	0.43-0.81
	3	球墨铸铁	80	90	100	0.20-0.41	0.21-0.44	0.23-0.48	0.25-0.53	0.27-0.57
M	1	奥氏体不锈钢	50	60	70	0.11-0.17	0.13-0.20	0.16-0.25	0.18-0.28	0.21-0.31
	2	超级奥氏体(镍≥20%)不锈钢	20	40	60	0.11-0.17	0.13-0.20	0.16-0.25	0.18-0.28	0.21-0.31
	3	双相(奥氏体/铁素体)不锈钢	40	55	70	0.11-0.17	0.13-0.20	0.16-0.25	0.18-0.28	0.21-0.31
S		高温合金	20	40	60	0.11-0.17	0.13-0.20	0.16-0.25	0.18-0.28	0.21-0.31

推荐冷却液压力	
钻孔深度	冷却压力
3XD	8巴
4XD	10巴
5XD	12巴
7XD	20巴
8XD	25巴
10XD	30巴