

可换刀片式硬质合金钻头

**WSTAR**可换刀片式钻头系列

**TAW**

追加  
铸铁加工  
专用刀片

# 可换刀片式钻头可始终实现 稳定的孔加工



# 可换刀片式硬质合金钻头

## WSTAR可换刀片式钻头系列

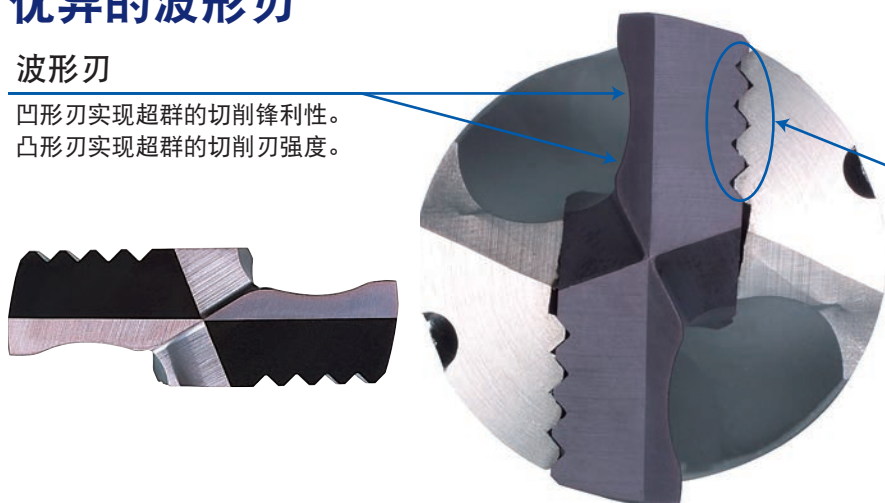
### TAW

## 追求切削锋利性、高精度的设计

### 采用切屑处理性 优异的波形刃

#### 波形刃

凹形刃实现超群的切削锋利性。  
凸形刃实现超群的切削刃强度。



### 维持高精度的 锯齿形状

#### 三菱独创的锯齿形状

三菱独创的锯齿结构可维持  
高安装精度。

切削刃形状

## 刀片材料

### 通用材料 **VP15TF**

■ 可适用于普通钢到软钢、碳钢、合金钢、不锈钢、铸铁等广泛的工件材料。



### 铸铁加工专用材料 **DP5010**

■ 铸铁加工专用高等级基体与独创结晶控制技术制造的新PVD涂层材料。



## 高耐用性刀体

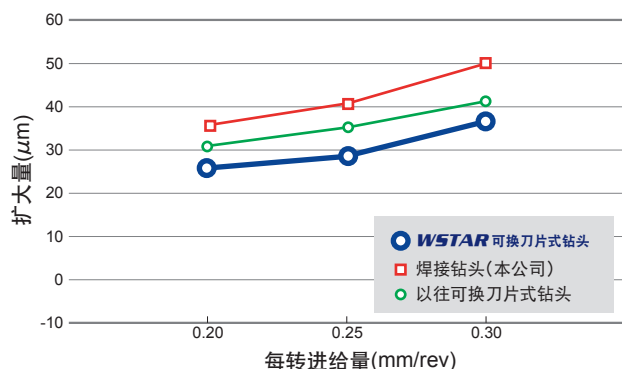
■ 刀体采用高温强度优异的特殊合金钢，且表面经过特殊处理，耐腐蚀性、耐摩擦性提高。



# 切削性能

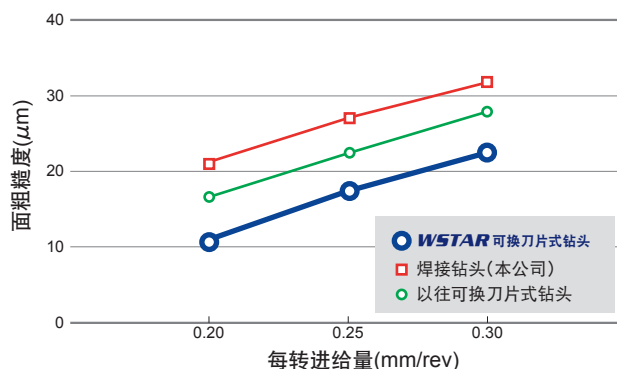
## 钢的孔加工

### ■ 扩大量



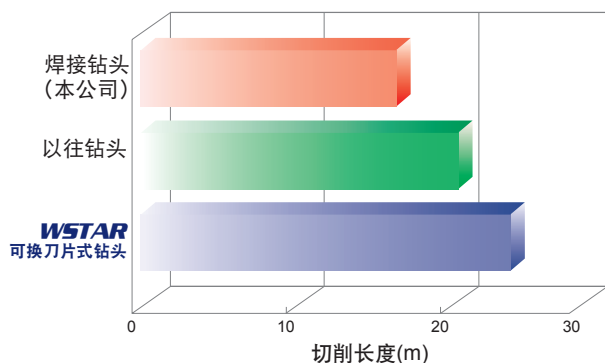
〈切削条件〉  
 工件材料：S50C(HB150—180)  
 钻头直径：φ20(L/D=5)  
 切削速度：80m/min  
 冷却液：无氯乳化液10%  
 冷却液压力：0.5MPa(内部冷却)

### ■ 面粗糙度



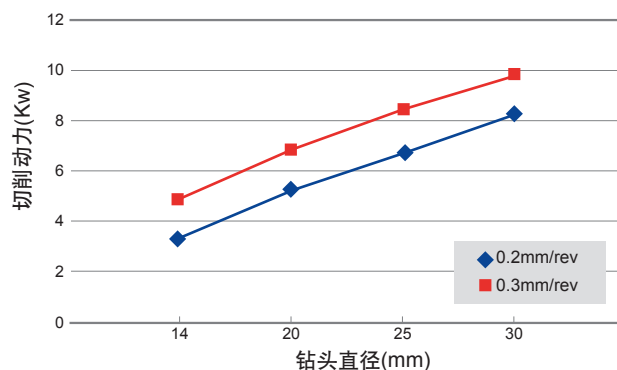
〈切削条件〉  
 工件材料：S50C(HB150—180)  
 钻头直径：φ20(L/D=5)  
 切削速度：80m/min  
 冷却液：无氯乳化液10%  
 冷却液压力：0.5MPa(内部冷却)

### ■ 刀片寿命



〈切削条件〉  
 工件材料：S50C(HB150—180) 冷却液：无氯乳化液10%  
 钻头直径：φ20(L/D=5) 冷却液压力：0.5MPa(内部冷却)  
 切削速度：100m/min  
 每转进给量：0.25mm/rev

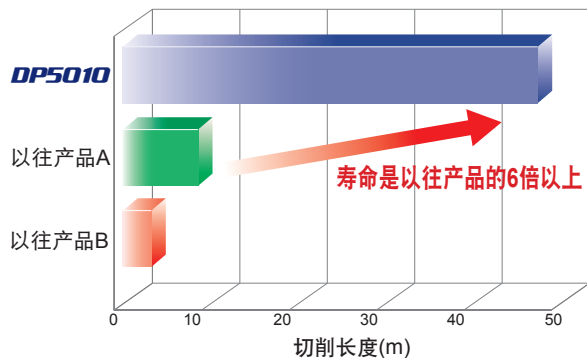
### ■ 切削动力



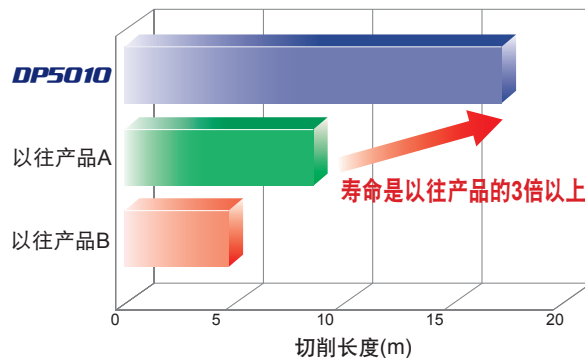
〈切削条件〉  
 工件材料：S50C(HB150—180)  
 切削速度：80m/min  
 冷却液：无氯乳化液10%  
 冷却液压力：0.5MPa(内部冷却)

## 铸铁/球墨铸铁的孔加工

### ■ 刀片寿命



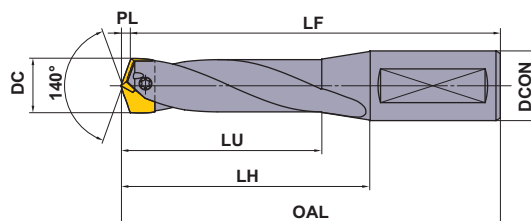
〈切削条件〉  
 工件材料：FC250 冷却液：无氯乳化液10%  
 钻头直径：φ18(L/D=3) 冷却液压力：0.5MPa(内部冷却)  
 切削速度：140m/min  
 每转进给量：0.4mm/rev







〈切削条件〉  
 工件材料：FCD450 冷却液：无氯乳化液10%  
 钻头直径：φ18(L/D=3) 冷却液压力：0.5MPa(内部冷却)  
 切削速度：100m/min  
 每转进给量：0.3mm/rev



(一般加工用)



## 刀柄规格





DC (mm)	钻削孔深 (l/d)	刀柄		尺寸 (mm)										适用刀片					
		型 号	库 存	LU	LH	OAL	LF	PL	DCON	夹紧螺钉	扳手	刮板	防止 烧熔剂	DC (mm)	型 号	库 存			
																VP15TF	DP5010	VP10H	
18.5   19.4	3	TAWSN1900S25	●	71.4	102.4	158.4	155	3.4	25	WS304517T	TKY10T	WPT4405	MK1KS	18.5	TAWNH1850T	●		□	
															TAWKH1850TG		●		
															18.6	TAWNH1860T	●		□
															TAWKH1860TG		●		
	5	TAWMN1900S25	●	110.4	137.4	193.4	190	3.4	25	WS304517T	TKY10T	WPT4405	MK1KS	18.7	TAWNH1870T	●		□	
															TAWKH1870TG		●		
															18.8	TAWNH1880T	●		□
															TAWKH1880TG		●		
	8	TAWLN1900S25	●	165.5	188.5	244.5	241	3.5	25	WS304517T	TKY10T	WPT4405	MK1KS	18.9	TAWNH1890T	●		□	
															TAWKH1890TG		●		
															19.0	TAWNH1900T	●		□
															TAWKH1900TG		●		
19.5   20.4	3	TAWSN2000S25	●	75.5	102.5	158.5	155	3.5	25	WS304518T	TKY10T	WPT4405	MK1KS	19.1	TAWNH1910T	●		□	
															TAWKH1910TG		●		
															19.2	TAWNH1920T	●		□
															TAWKH1920TG		●		
	5	TAWMN2000S25	●	116.6	142.6	198.6	195	3.6	25	WS304518T	TKY10T	WPT4405	MK1KS	19.3	TAWNH1930T	●		□	
															TAWKH1930TG		●		
															19.4	TAWNH1940T	●		□
															TAWKH1940TG		●		
	8	TAWLN2000S25	●	173.7	196.7	252.7	249	3.7	25	WS304518T	TKY10T	WPT4405	MK1KS	19.5	TAWNH1950T	●		□	
															TAWKH1950TG		●		
															19.6	TAWNH1960T	●		□
															TAWKH1960TG		●		
8	TAWLN2000S25	●	173.7	196.7	252.7	249	3.7	25	WS304518T	TKY10T	WPT4405	MK1KS	19.7	TAWNH1970T	●		□		
														TAWKH1970TG		●			
														19.8	TAWNH1980T	●		□	
														TAWKH1980TG		●			
8	TAWLN2000S25	●	173.7	196.7	252.7	249	3.7	25	WS304518T	TKY10T	WPT4405	MK1KS	19.9	TAWNH1990T	●		□		
														TAWKH1990TG		●			
														20.0	TAWNH2000T	●		□	
														TAWKH2000TG		●			
8	TAWLN2000S25	●	173.7	196.7	252.7	249	3.7	25	WS304518T	TKY10T	WPT4405	MK1KS	20.1	TAWNH2010T	□		□		
														TAWKH2010TG		□			
														20.2	TAWNH2020T	□		□	
														TAWKH2020TG		□			
8	TAWLN2000S25	●	173.7	196.7	252.7	249	3.7	25	WS304518T	TKY10T	WPT4405	MK1KS	20.3	TAWNH2030T	□		□		
														TAWKH2030TG		□			
														20.4	TAWNH2040T	□		□	
														TAWKH2040TG		□			





注1 以上尺寸为安装TAWNH (H型) 刀片时的尺寸。

注2 标准品以外的特殊形状 (例如: 不同直径、不同长度、带倒角刃等) 若有需求敬请垂询。





注3  $\phi 14.0 - \phi 18.4$  的刀柄已于2015年3月末停产。





请使用三菱切削工具新产品快报B167中的S-TAW钻头替代。

DC (mm)	钻 削 孔 深 (l/d)	刀柄		尺寸 (mm)										适用刀片					
		型 号	库 存	LU	LH	OAL	LF	PL	DCON	夹紧螺钉	扳手	刮板	防止 烧熔剂	DC (mm)	型 号	库 存			
																VP15TF	DP5010	VP10H	
20.5   21.4	3	TAWSN2100S25	●	78.7	102.7	158.7	155.0	3.7	25	WS304518T	TKY10T	WPT4405	MK1KS	20.5	TAWNH2050T	●		□	
															TAWKH2050TG		●		
															20.6	TAWNH2060T	□		□
	5	TAWMN2100S25	●	121.8	142.8	198.8	195.0	3.8	25	WS304518T	TKY10T	WPT4405	MK1KS	20.6	TAWKH2060TG		□		
															20.7	TAWNH2070T	□		
															TAWKH2070TG		□		
	8	TAWLN2100S25	●	181.9	205.9	261.9	258.0	3.9	25	WS304518T	TKY10T	WPT4405	MK1KS	20.8	TAWNH2080T	□		□	
															TAWKH2080TG		□		
															20.9	TAWNH2090T	□		□
														TAWKH2090TG		□			
														21.0	TAWNH2100T	●		□	
														TAWKH2100TG		●			
21.1	TAWLN2100S25	●	181.9	205.9	261.9	258.0	3.9	25	WS304518T	TKY10T	WPT4405	MK1KS	21.1	TAWNH2110T	□		□		
														TAWKH2110TG		□			
														21.2	TAWNH2120T	□		□	
													TAWKH2120TG		□				
													21.3	TAWNH2130T	□		□		
													TAWKH2130TG		□				
21.4	TAWLN2100S25	●	181.9	205.9	261.9	258.0	3.9	25	WS304518T	TKY10T	WPT4405	MK1KS	21.4	TAWNH2140T	□		□		
														TAWKH2140TG		□			
														21.5	TAWNH2150T	●		□	
													TAWKH2150TG		●				
													21.6	TAWNH2160T	□		□		
													TAWKH2160TG		□				
21.5   22.4	3	TAWSN2200S25	●	83.2	108.2	164.2	160.3	3.9	25	WS355520T	TKY15T	WPT4405	MK1KS	21.7	TAWNH2170T	□		□	
															TAWKH2170TG		□		
															21.8	TAWNH2180T	□		□
	5	TAWMN2200S25	●	128.3	148.3	204.3	200.3	4.0	25	WS355520T	TKY15T	WPT4405	MK1KS	21.9	TAWKH2180TG		□		
															21.9	TAWNH2190T	□		□
															TAWKH2190TG		□		
	8	TAWLN2200S25	●	190.0	214.0	270.0	266.0	4.0	25	WS355520T	TKY15T	WPT4405	MK1KS	22.0	TAWNH2200T	●		□	
															TAWKH2200TG		●		
															22.1	TAWNH2210T	□		□
														TAWKH2210TG		□			
														22.2	TAWNH2220T	□		□	
														TAWKH2220TG		□			
22.3	TAWLN2200S25	●	190.0	214.0	270.0	266.0	4.0	25	WS355520T	TKY15T	WPT4405	MK1KS	22.3	TAWNH2230T	□		□		
														TAWKH2230TG		□			
														22.4	TAWNH2240T	□		□	
													TAWKH2240TG		□				
													22.5	TAWNH2250T	●		□		
													TAWKH2250TG		●				
22.5   23.4	3	TAWSN2300S25	●	86.4	108.4	164.4	160.3	4.1	25	WS355521T	TKY15T	WPT4405	MK1KS	22.6	TAWNH2260T	□		□	
															TAWKH2260TG		□		
															22.7	TAWNH2270T	□		□
	5	TAWMN2300S25	●	133.4	158.4	214.4	210.3	4.1	25	WS355521T	TKY15T	WPT4405	MK1KS	22.8	TAWKH2270TG		□		
															22.8	TAWNH2280T	□		□
															TAWKH2280TG		□		
	8	TAWLN2300S25	●	198.2	227.2	283.2	279.0	4.2	25	WS355521T	TKY15T	WPT4405	MK1KS	22.9	TAWNH2290T	□		□	
															TAWKH2290TG		□		
															23.0	TAWNH2300T	●		□
														TAWKH2300TG		●			
														23.1	TAWNH2310T	□		□	
														TAWKH2310TG		□			
23.2	TAWLN2300S25	●	198.2	227.2	283.2	279.0	4.2	25	WS355521T	TKY15T	WPT4405	MK1KS	23.2	TAWNH2320T	□		□		
														TAWKH2320TG		□			
														23.3	TAWNH2330T	□		□	
													TAWKH2330TG		□				
													23.4	TAWNH2340T	□		□		
													TAWKH2340TG		□				

DC (mm)	钻削孔深 (l/d)	刀柄		尺寸 (mm)										适用刀片				
		型 号	库 存	LU	LH	OAL	LF	PL	DCON	DC (mm)	型 号	库 存						
												VP15TF	DP5010	VP10H				
23.5   24.4	3	TAWSN2400S32	●	90.6	114.6	174.6	170.3	4.3	32	WS355521T	TKY15T	WPT4405	MK1KS	23.5	TAWNH2350T	●		□
															TAWKH2350TG		●	
		TAWSN2400S32	●	90.6	114.6	174.6	170.3	4.3	32	WS355521T	TKY15T	WPT4405	MK1KS	23.6	TAWNH2360T	□		□
															TAWKH2360TG		□	
		TAWSN2400S32	●	90.6	114.6	174.6	170.3	4.3	32	WS355521T	TKY15T	WPT4405	MK1KS	23.7	TAWNH2370T	□		□
															TAWKH2370TG		□	
	5	TAWMN2400S32	●	139.6	164.6	224.6	220.3	4.3	32	WS355521T	TKY15T	WPT4405	MK1KS	23.8	TAWNH2380T	□		□
															TAWKH2380TG		□	
		TAWMN2400S32	●	139.6	164.6	224.6	220.3	4.3	32	WS355521T	TKY15T	WPT4405	MK1KS	23.9	TAWNH2390T	□		□
															TAWKH2390TG		□	
		TAWMN2400S32	●	139.6	164.6	224.6	220.3	4.3	32	WS355521T	TKY15T	WPT4405	MK1KS	24.0	TAWNH2400T	●		□
															TAWKH2400TG		●	
8	TAWLN2400S32	●	206.4	236.4	296.4	292.0	4.4	32	WS355521T	TKY15T	WPT4405	MK1KS	24.1	TAWNH2410T	□		□	
														TAWKH2410TG		□		
	TAWLN2400S32	●	206.4	236.4	296.4	292.0	4.4	32	WS355521T	TKY15T	WPT4405	MK1KS	24.2	TAWNH2420T	□		□	
														TAWKH2420TG		□		
	TAWLN2400S32	●	206.4	236.4	296.4	292.0	4.4	32	WS355521T	TKY15T	WPT4405	MK1KS	24.3	TAWNH2430T	□		□	
														TAWKH2430TG		□		
24.5   25.4	3	TAWSN2500S32	●	93.1	115.1	175.1	170.6	4.5	32	WS406023T	TKY25T	WPT4405	MK1KS	24.4	TAWNH2440T	□		□
															TAWKH2440TG		□	
		TAWSN2500S32	●	93.1	115.1	175.1	170.6	4.5	32	WS406023T	TKY25T	WPT4405	MK1KS	24.5	TAWNH2450T	●		□
															TAWKH2450TG		●	
		TAWSN2500S32	●	93.1	115.1	175.1	170.6	4.5	32	WS406023T	TKY25T	WPT4405	MK1KS	24.6	TAWNH2460T	□		□
															TAWKH2460TG		□	
	5	TAWMN2500S32	●	145.1	170.1	230.1	225.6	4.5	32	WS406023T	TKY25T	WPT4405	MK1KS	24.7	TAWNH2470T	□		□
															TAWKH2470TG		□	
		TAWMN2500S32	●	145.1	170.1	230.1	225.6	4.5	32	WS406023T	TKY25T	WPT4405	MK1KS	24.8	TAWNH2480T	□		□
															TAWKH2480TG		□	
		TAWMN2500S32	●	145.1	170.1	230.1	225.6	4.5	32	WS406023T	TKY25T	WPT4405	MK1KS	24.9	TAWNH2490T	□		□
															TAWKH2490TG		□	
8	TAWLN2500S32	●	214.6	244.6	304.6	300.0	4.6	32	WS406023T	TKY25T	WPT4405	MK1KS	25.0	TAWNH2500T	●		□	
														TAWKH2500TG		●		
	TAWLN2500S32	●	214.6	244.6	304.6	300.0	4.6	32	WS406023T	TKY25T	WPT4405	MK1KS	25.1	TAWNH2510T	□		□	
														TAWKH2510TG		□		
	TAWLN2500S32	●	214.6	244.6	304.6	300.0	4.6	32	WS406023T	TKY25T	WPT4405	MK1KS	25.2	TAWNH2520T	□		□	
														TAWKH2520TG		□		
25.5   26.4	3	TAWSN2600S32	●	97.2	120.2	180.2	175.6	4.6	32	WS406024T	TKY25T	WPT4405	MK1KS	25.3	TAWNH2530T	□		□
															TAWKH2530TG		□	
		TAWSN2600S32	●	97.2	120.2	180.2	175.6	4.6	32	WS406024T	TKY25T	WPT4405	MK1KS	25.4	TAWNH2540T	□		□
															TAWKH2540TG		□	
		TAWSN2600S32	●	97.2	120.2	180.2	175.6	4.6	32	WS406024T	TKY25T	WPT4405	MK1KS	25.5	TAWNH2550T	●		□
															TAWKH2550TG		●	
	5	TAWMN2600S32	●	151.3	175.3	235.3	230.6	4.7	32	WS406024T	TKY25T	WPT4405	MK1KS	25.6	TAWNH2560T	□		□
															TAWKH2560TG		□	
		TAWMN2600S32	●	151.3	175.3	235.3	230.6	4.7	32	WS406024T	TKY25T	WPT4405	MK1KS	25.7	TAWNH2570T	□		□
															TAWKH2570TG		□	
		TAWMN2600S32	●	151.3	175.3	235.3	230.6	4.7	32	WS406024T	TKY25T	WPT4405	MK1KS	25.8	TAWNH2580T	□		□
															TAWKH2580TG		□	
8	TAWLN2600S32	●	222.8	252.8	312.8	308.0	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	25.9	TAWNH2590T	□		□	
														TAWKH2590TG		□		
	TAWLN2600S32	●	222.8	252.8	312.8	308.0	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	26.0	TAWNH2600T	●		□	
														TAWKH2600TG		●		
	TAWLN2600S32	●	222.8	252.8	312.8	308.0	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	26.1	TAWNH2610T	□		□	
														TAWKH2610TG		□		
TAWLN2600S32	●	222.8	252.8	312.8	308.0	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	26.2	TAWNH2620T	□		□		
													TAWKH2620TG		□			
TAWLN2600S32	●	222.8	252.8	312.8	308.0	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	26.3	TAWNH2630T	□		□		
													TAWKH2630TG		□			
TAWLN2600S32	●	222.8	252.8	312.8	308.0	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	26.4	TAWNH2640T	□		□		
													TAWKH2640TG		□			



DC (mm)	钻削孔深 (l/d)	刀柄		尺寸 (mm)										适用刀片				
		型 号	库 存	LU	LH	OAL	LF	PL	DCON	夹紧螺钉	扳手	刮板	防止 烧熔剂	DC (mm)	型 号	库 存		
																VP15TF	DP5010	VP10H
26.5   27.4	3	TAWSN2700S32	●	99.4	120.4	180.4	175.6	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	26.5	TAWNH2650T	●		□
															TAWKH2650TG		●	
														26.6	TAWNH2660T	□		□
															TAWKH2660TG		□	
	26.7	TAWNH2670T	□		□													
		TAWKH2670TG		□														
	5	TAWMN2700S32	●	156.5	180.5	240.5	235.6	4.9	32	WS406024T	TKY25T	WPT4405	MK1KS	26.8	TAWNH2680T	□		□
															TAWKH2680TG		□	
														26.9	TAWNH2690T	□		□
															TAWKH2690TG		□	
	8	TAWLN2700S32	●	230.9	260.9	320.9	316.0	4.9	32	WS406024T	TKY25T	WPT4405	MK1KS	27.0	TAWNH2700T	●		□
															TAWKH2700TG		●	
27.1														TAWNH2710T	□		□	
														TAWKH2710TG		□		
27.5   28.4	3	TAWSN2800S32	●	102.2	125.2	185.2	180.2	5.0	32	WS508026T	TKY27T	WPT4405	MK1KS	27.2	TAWNH2720T	□		□
															TAWKH2720TG		□	
														27.3	TAWNH2730T	□		□
															TAWKH2730TG		□	
	5	TAWMN2800S32	●	162.3	185.3	245.3	240.2	5.1	32	WS508026T	TKY27T	WPT4405	MK1KS	27.4	TAWNH2740T	□		□
															TAWKH2740TG		□	
														27.5	TAWNH2750T	●		□
															TAWKH2750TG		●	
	8	TAWLN2800S32	●	239.1	269.1	329.1	324.0	5.1	32	WS508026T	TKY27T	WPT4405	MK1KS	27.6	TAWNH2760T	□		□
															TAWKH2760TG		□	
														27.7	TAWNH2770T	□		□
															TAWKH2770TG		□	
28.5   29.4	3	TAWSN2900S32	●	105.4	130.4	190.4	185.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	27.8	TAWNH2780T	□		□
															TAWKH2780TG		□	
														27.9	TAWNH2790T	□		□
															TAWKH2790TG		□	
	5	TAWMN2900S32	●	167.4	190.4	250.4	245.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	28.0	TAWNH2800T	●		□
															TAWKH2800TG		●	
														28.1	TAWNH2810T	□		□
															TAWKH2810TG		□	
	8	TAWLN2900S32	●	247.3	277.3	337.3	332.0	5.3	32	WS508027T	TKY27T	WPT4405	MK1KS	28.2	TAWNH2820T	□		□
															TAWKH2820TG		□	
														28.3	TAWNH2830T	□		□
															TAWKH2830TG		□	
	3	TAWSN2900S32	●	105.4	130.4	190.4	185.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	28.4	TAWNH2840T	□		□
															TAWKH2840TG		□	
														28.5	TAWNH2850T	●		□
															TAWKH2850TG		●	
	5	TAWMN2900S32	●	167.4	190.4	250.4	245.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	28.6	TAWNH2860T	□		□
															TAWKH2860TG		□	
														28.7	TAWNH2870T	□		□
															TAWKH2870TG		□	
	8	TAWLN2900S32	●	247.3	277.3	337.3	332.0	5.3	32	WS508027T	TKY27T	WPT4405	MK1KS	28.8	TAWNH2880T	□		□
															TAWKH2880TG		□	
														28.9	TAWNH2890T	□		□
															TAWKH2890TG		□	
	3	TAWSN2900S32	●	105.4	130.4	190.4	185.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	29.0	TAWNH2900T	●		□
															TAWKH2900TG		●	
														29.1	TAWNH2910T	□		□
															TAWKH2910TG		□	
	5	TAWMN2900S32	●	167.4	190.4	250.4	245.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	29.2	TAWNH2920T	□		□
															TAWKH2920TG		□	
														29.3	TAWNH2930T	□		□
															TAWKH2930TG		□	
	8	TAWLN2900S32	●	247.3	277.3	337.3	332.0	5.3	32	WS508027T	TKY27T	WPT4405	MK1KS	29.4	TAWNH2940T	□		□
															TAWKH2940TG		□	

DC (mm)	钻削孔深 (l/d)	刀柄		尺寸 (mm)										适用刀片					
		型 号	库 存	LU	LH	OAL	LF	PL	DCON	夹紧螺钉	扳手	刮板	防止 烧熔剂	DC (mm)	型 号	库 存			
																VP15TF	DP5010	VP10H	
29.5   30.4	3	TAWSN3000S32	●	109.6	130.6	190.6	185.2	5.4	32	WS508027T	TKY27T	WPT4405	MK1KS	29.5	TAWNH2950T	●		□	
															TAWKH2950TG		●		
															29.6	TAWNH2960T	□		□
															TAWKH2960TG		□		
	5	TAWMN3000S32	●	172.6	200.6	260.6	255.2	5.4	32	WS508027T	TKY27T	WPT4405	MK1KS	29.7	TAWNH2970T	□		□	
															TAWKH2970TG		□		
															29.8	TAWNH2980T	□		□
															TAWKH2980TG		□		
														29.9	TAWNH2990T	□		□	
															TAWKH2990TG		□		
															30.0	TAWNH3000T	●		□
															TAWKH3000TG		●		
	8	TAWLN3000S32	●	255.5	290.5	350.5	345.0	5.5	32	WS508027T	TKY27T	WPT4405	MK1KS	30.1	TAWNH3010T	□		□	
															TAWKH3010TG		□		
															30.2	TAWNH3020T	□		□
															TAWKH3020TG		□		
30.3														TAWNH3030T	□		□		
														TAWKH3030TG		□			
														30.4	TAWNH3040T	□		□	
														TAWKH3040TG		□			

注1 以上尺寸为安装TAWNH (H型) 刀片时的尺寸。

注2 标准品以外的特殊形状 (例如: 不同直径、不同长度、带倒角刃等) 若有需求敬请垂询。

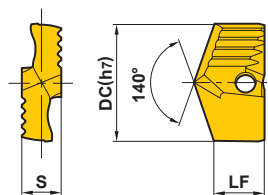
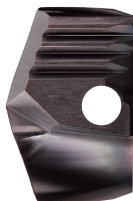
注3  $\phi 14.0 - \phi 18.4$  的刀柄已于2015年3月末停产。

请使用三菱切削工具新产品快报B167中的S-TAW钻头替代。



# 刀片

## H型



型 号	库存		尺寸 (mm)			适用刀柄
	VP15TF	VP10H	DC	LF	S	
TAWNH1400T	▲		14.0	7.6	5.0	TAWSNH 1400S16
TAWNH1410T	▲		14.1	7.6	5.0	TAWMNH 1400S16
TAWNH1420T	▲		14.2	7.6	5.0	TAWLNH 1400S16
TAWNH1430T	▲		14.3	7.6	5.0	
TAWNH1440T	▲		14.4	7.6	5.0	
TAWNH1450T	▲		14.5	7.5	5.0	
TAWNH1460T	▲		14.6	7.5	5.0	
TAWNH1470T	▲		14.7	7.5	5.0	TAWSNH 1500S20
TAWNH1480T	▲		14.8	7.5	5.0	
TAWNH1490T	▲		14.9	7.5	5.0	TAWMNH 1500S20
TAWNH1500T	▲		15.0	7.4	5.0	
TAWNH1510T	▲		15.1	7.4	5.0	TAWLNH 1500S20
TAWNH1520T	▲		15.2	7.4	5.0	
TAWNH1530T	▲		15.3	7.4	5.0	
TAWNH1540T	▲		15.4	7.4	5.0	
TAWNH1550T	▲		15.5	7.9	6.0	
TAWNH1560T	▲		15.6	7.9	6.0	
TAWNH1570T	▲		15.7	7.9	6.0	TAWSN 1600S20
TAWNH1580T	▲		15.8	7.9	6.0	
TAWNH1590T	▲		15.9	7.9	6.0	TAWMN 1600S20
TAWNH1600T	▲		16.0	7.8	6.0	
TAWNH1610T	▲		16.1	7.8	6.0	TAWLN 1600S20
TAWNH1620T	▲		16.2	7.8	6.0	
TAWNH1630T	▲		16.3	7.8	6.0	
TAWNH1640T	▲		16.4	7.8	6.0	
TAWNH1650T	▲		16.5	7.7	6.0	
TAWNH1660T	▲		16.6	7.7	6.0	
TAWNH1670T	▲		16.7	7.7	6.0	TAWSN 1700S20
TAWNH1680T	▲		16.8	7.7	6.0	
TAWNH1690T	▲		16.9	7.7	6.0	TAWMN 1700S20
TAWNH1700T	▲		17.0	7.6	6.0	
TAWNH1710T	▲		17.1	7.6	6.0	TAWLN 1700S20
TAWNH1720T	▲		17.2	7.6	6.0	
TAWNH1730T	▲		17.3	7.6	6.0	
TAWNH1740T	▲		17.4	7.6	6.0	
TAWNH1750T	▲		17.5	7.5	6.0	
TAWNH1760T	▲		17.6	7.5	6.0	
TAWNH1770T	▲		17.7	7.5	6.0	TAWSN 1800S20
TAWNH1780T	▲		17.8	7.5	6.0	
TAWNH1790T	▲		17.9	7.5	6.0	TAWMN 1800S20
TAWNH1800T	▲		18.0	7.4	6.0	
TAWNH1810T	▲		18.1	7.4	6.0	TAWLN 1800S20
TAWNH1820T	▲		18.2	7.4	6.0	
TAWNH1830T	▲		18.3	7.4	6.0	
TAWNH1840T	▲		18.4	7.4	6.0	

型 号	库存		尺寸 (mm)			适用刀柄
	VP15TF	VP10H	DC	LF	S	
TAWNH1850T	●	□	18.5	9.3	7.0	
TAWNH1860T	●	□	18.6	9.3	7.0	
TAWNH1870T	●	□	18.7	9.3	7.0	TAWSN 1900S25
TAWNH1880T	●	□	18.8	9.3	7.0	
TAWNH1890T	●	□	18.9	9.3	7.0	TAWMN 1900S25
TAWNH1900T	●	□	19.0	9.2	7.0	
TAWNH1910T	●	□	19.1	9.2	7.0	TAWLN 1900S25
TAWNH1920T	●	□	19.2	9.2	7.0	
TAWNH1930T	●	□	19.3	9.2	7.0	
TAWNH1940T	●	□	19.4	9.2	7.0	
TAWNH1950T	●	□	19.5	9.1	7.0	
TAWNH1960T	●	□	19.6	9.1	7.0	
TAWNH1970T	●	□	19.7	9.1	7.0	TAWSN 2000S25
TAWNH1980T	●	□	19.8	9.1	7.0	
TAWNH1990T	●	□	19.9	9.1	7.0	TAWMN 2000S25
TAWNH2000T	●	□	20.0	9.0	7.0	
TAWNH2010T	□	□	20.1	9.0	7.0	TAWLN 2000S25
TAWNH2020T	□	□	20.2	9.0	7.0	
TAWNH2030T	□	□	20.3	9.0	7.0	
TAWNH2040T	□	□	20.4	9.0	7.0	
TAWNH2050T	●	□	20.5	8.9	7.0	
TAWNH2060T	□	□	20.6	8.9	7.0	
TAWNH2070T	□	□	20.7	8.9	7.0	TAWSN 2100S25
TAWNH2080T	□	□	20.8	8.9	7.0	
TAWNH2090T	□	□	20.9	8.9	7.0	TAWMN 2100S25
TAWNH2100T	●	□	21.0	8.8	7.0	
TAWNH2110T	□	□	21.1	8.8	7.0	TAWLN 2100S25
TAWNH2120T	□	□	21.2	8.8	7.0	
TAWNH2130T	□	□	21.3	8.8	7.0	
TAWNH2140T	□	□	21.4	8.8	7.0	
TAWNH2150T	●	□	21.5	10.6	8.0	
TAWNH2160T	□	□	21.6	10.6	8.0	
TAWNH2170T	□	□	21.7	10.6	8.0	TAWSN 2200S25
TAWNH2180T	□	□	21.8	10.6	8.0	
TAWNH2190T	□	□	21.9	10.6	8.0	TAWMN 2200S25
TAWNH2200T	●	□	22.0	10.5	8.0	
TAWNH2210T	□	□	22.1	10.5	8.0	TAWLN 2200S25
TAWNH2220T	□	□	22.2	10.5	8.0	
TAWNH2230T	□	□	22.3	10.5	8.0	
TAWNH2240T	□	□	22.4	10.5	8.0	
TAWNH2250T	●	□	22.5	10.4	8.0	TAWSN 2300S25
TAWNH2260T	□	□	22.6	10.4	8.0	TAWMN 2300S25
TAWNH2270T	□	□	22.7	10.4	8.0	
TAWNH2280T	□	□	22.8	10.4	8.0	TAWLN 2300S25
TAWNH2290T	□	□	22.9	10.4	8.0	

●：标准库存品 □：预订生产品

▲：现在为标准库存品，将来替换为新产品（刀柄已于2015年3月停产）

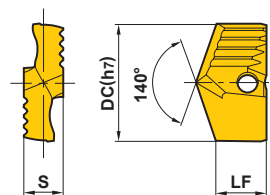
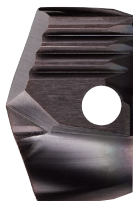
（刀片为1盒1片装）

# TAW

WSTAR可换刀片式钻头

## 刀片

### H型



型 号	库存		尺寸 (mm)			适用刀柄
	VP15TF	VP10H	DC	LF	S	
TAWNH2300T	●	□	23.0	10.3	8.0	TAWSN 2300S25
TAWNH2310T	□	□	23.1	10.3	8.0	TAWMN 2300S25
TAWNH2320T	□	□	23.2	10.3	8.0	TAWLN 2300S25
TAWNH2330T	□	□	23.3	10.3	8.0	
TAWNH2340T	□	□	23.4	10.3	8.0	
TAWNH2350T	●	□	23.5	10.2	8.0	
TAWNH2360T	□	□	23.6	10.2	8.0	
TAWNH2370T	□	□	23.7	10.2	8.0	TAWSN 2400S32
TAWNH2380T	□	□	23.8	10.2	8.0	
TAWNH2390T	□	□	23.9	10.2	8.0	TAWMN 2400S32
TAWNH2400T	●	□	24.0	10.1	8.0	TAWLN 2400S32
TAWNH2410T	□	□	24.1	10.1	8.0	
TAWNH2420T	□	□	24.2	10.1	8.0	
TAWNH2430T	□	□	24.3	10.1	8.0	
TAWNH2440T	□	□	24.4	10.1	8.0	
TAWNH2450T	●	□	24.5	11.7	9.0	
TAWNH2460T	□	□	24.6	11.7	9.0	
TAWNH2470T	□	□	24.7	11.7	9.0	TAWSN 2500S32
TAWNH2480T	□	□	24.8	11.7	9.0	
TAWNH2490T	□	□	24.9	11.7	9.0	TAWMN 2500S32
TAWNH2500T	●	□	25.0	11.6	9.0	TAWLN 2500S32
TAWNH2510T	□	□	25.1	11.6	9.0	
TAWNH2520T	□	□	25.2	11.6	9.0	
TAWNH2530T	□	□	25.3	11.6	9.0	
TAWNH2540T	□	□	25.4	11.6	9.0	
TAWNH2550T	●	□	25.5	11.5	9.0	
TAWNH2560T	□	□	25.6	11.5	9.0	
TAWNH2570T	□	□	25.7	11.5	9.0	TAWSN 2600S32
TAWNH2580T	□	□	25.8	11.5	9.0	
TAWNH2590T	□	□	25.9	11.5	9.0	TAWMN 2600S32
TAWNH2600T	●	□	26.0	11.4	9.0	TAWLN 2600S32
TAWNH2610T	□	□	26.1	11.4	9.0	
TAWNH2620T	□	□	26.2	11.4	9.0	
TAWNH2630T	□	□	26.3	11.4	9.0	
TAWNH2640T	□	□	26.4	11.4	9.0	
TAWNH2650T	●	□	26.5	11.3	9.0	
TAWNH2660T	□	□	26.6	11.3	9.0	
TAWNH2670T	□	□	26.7	11.3	9.0	TAWSN 2700S32
TAWNH2680T	□	□	26.8	11.3	9.0	
TAWNH2690T	□	□	26.9	11.3	9.0	TAWMN 2700S32
TAWNH2700T	●	□	27.0	11.2	9.0	TAWLN 2700S32
TAWNH2710T	□	□	27.1	11.2	9.0	
TAWNH2720T	□	□	27.2	11.2	9.0	
TAWNH2730T	□	□	27.3	11.2	9.0	
TAWNH2740T	□	□	27.4	11.2	9.0	

型 号	库存		尺寸 (mm)			适用刀柄
	VP15TF	VP10H	DC	LF	S	
TAWNH2750T	●	□	27.5	12.3	10.0	
TAWNH2760T	□	□	27.6	12.3	10.0	
TAWNH2770T	□	□	27.7	12.3	10.0	TAWSN 2800S32
TAWNH2780T	□	□	27.8	12.3	10.0	
TAWNH2790T	□	□	27.9	12.3	10.0	TAWMN 2800S32
TAWNH2800T	●	□	28.0	12.2	10.0	TAWLN 2800S32
TAWNH2810T	□	□	28.1	12.2	10.0	
TAWNH2820T	□	□	28.2	12.2	10.0	
TAWNH2830T	□	□	28.3	12.2	10.0	
TAWNH2840T	□	□	28.4	12.2	10.0	
TAWNH2850T	●	□	28.5	12.1	10.0	
TAWNH2860T	□	□	28.6	12.1	10.0	
TAWNH2870T	□	□	28.7	12.1	10.0	TAWSN 2900S32
TAWNH2880T	□	□	28.8	12.1	10.0	
TAWNH2890T	□	□	28.9	12.1	10.0	TAWMN 2900S32
TAWNH2900T	●	□	29.0	12.0	10.0	TAWLN 2900S32
TAWNH2910T	□	□	29.1	12.0	10.0	
TAWNH2920T	□	□	29.2	12.0	10.0	
TAWNH2930T	□	□	29.3	12.0	10.0	
TAWNH2940T	□	□	29.4	12.0	10.0	
TAWNH2950T	●	□	29.5	11.9	10.0	
TAWNH2960T	□	□	29.6	11.9	10.0	
TAWNH2970T	□	□	29.7	11.9	10.0	TAWSN 3000S32
TAWNH2980T	□	□	29.8	11.9	10.0	
TAWNH2990T	□	□	29.9	11.9	10.0	TAWMN 3000S32
TAWNH3000T	●	□	30.0	11.8	10.0	TAWLN 3000S32
TAWNH3010T	□	□	30.1	11.8	10.0	
TAWNH3020T	□	□	30.2	11.8	10.0	
TAWNH3030T	□	□	30.3	11.8	10.0	
TAWNH3040T	□	□	30.4	11.8	10.0	

●：标准库存品 □：预订生产品

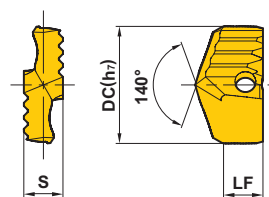
▲：现在为标准库存品，将来替换为新产品（刀柄已于2015年3月停产）

（刀片为1盒1片装）

## 刀片

### H型

(铸铁加工用)



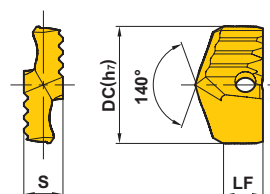
型 号	库存	尺寸 (mm)			适用刀柄
	DP5010	DC	LF	S	
TAWKH1400TG	▲	14.0	7.1	5.0	TAWSNH 1400S16
TAWKH1410TG	▲	14.1	7.1	5.0	TAWMNH 1400S16
TAWKH1420TG	▲	14.2	7.1	5.0	TAWLNH 1400S16
TAWKH1430TG	▲	14.3	7.1	5.0	
TAWKH1440TG	▲	14.4	7.1	5.0	
TAWKH1450TG	▲	14.5	7.0	5.0	
TAWKH1460TG	▲	14.6	7.0	5.0	
TAWKH1470TG	▲	14.7	7.0	5.0	TAWSNH 1500S20
TAWKH1480TG	▲	14.8	7.0	5.0	TAWMNH 1500S20
TAWKH1490TG	▲	14.9	7.0	5.0	TAWLNH 1500S20
TAWKH1500TG	▲	15.0	6.9	5.0	
TAWKH1510TG	▲	15.1	6.9	5.0	
TAWKH1520TG	▲	15.2	6.9	5.0	
TAWKH1530TG	▲	15.3	6.9	5.0	
TAWKH1540TG	▲	15.4	6.9	5.0	
TAWKH1550TG	▲	15.5	7.3	6.0	
TAWKH1560TG	▲	15.6	7.3	6.0	
TAWKH1570TG	▲	15.7	7.3	6.0	TAWSN 1600S20
TAWKH1580TG	▲	15.8	7.3	6.0	TAWMN 1600S20
TAWKH1590TG	▲	15.9	7.3	6.0	TAWLN 1600S20
TAWKH1600TG	▲	16.0	7.2	6.0	
TAWKH1610TG	▲	16.1	7.2	6.0	
TAWKH1620TG	▲	16.2	7.2	6.0	
TAWKH1630TG	▲	16.3	7.2	6.0	
TAWKH1640TG	▲	16.4	7.2	6.0	
TAWKH1650TG	▲	16.5	7.1	6.0	
TAWKH1660TG	▲	16.6	7.1	6.0	
TAWKH1670TG	▲	16.7	7.1	6.0	TAWSN 1700S20
TAWKH1680TG	▲	16.8	7.1	6.0	TAWMN 1700S20
TAWKH1690TG	▲	16.9	7.1	6.0	TAWLN 1700S20
TAWKH1700TG	▲	17.0	7.0	6.0	
TAWKH1710TG	▲	17.1	7.0	6.0	
TAWKH1720TG	▲	17.2	7.0	6.0	
TAWKH1730TG	▲	17.3	7.0	6.0	
TAWKH1740TG	▲	17.4	7.0	6.0	
TAWKH1750TG	▲	17.5	6.8	6.0	
TAWKH1760TG	▲	17.6	6.8	6.0	
TAWKH1770TG	▲	17.7	6.8	6.0	TAWSN 1800S20
TAWKH1780TG	▲	17.8	6.8	6.0	TAWMN 1800S20
TAWKH1790TG	▲	17.9	6.8	6.0	TAWLN 1800S20
TAWKH1800TG	▲	18.0	6.8	6.0	
TAWKH1810TG	▲	18.1	6.8	6.0	
TAWKH1820TG	▲	18.2	6.8	6.0	
TAWKH1830TG	▲	18.3	6.8	6.0	
TAWKH1840TG	▲	18.4	6.8	6.0	

型 号	库存	尺寸 (mm)			适用刀柄
	DP5010	DC	LF	S	
TAWKH1850TG	●	18.5	8.6	7.0	
TAWKH1860TG	●	18.6	8.6	7.0	
TAWKH1870TG	●	18.7	8.6	7.0	TAWSN 1900S25
TAWKH1880TG	●	18.8	8.6	7.0	TAWMN 1900S25
TAWKH1890TG	●	18.9	8.6	7.0	TAWLN 1900S25
TAWKH1900TG	●	19.0	8.5	7.0	
TAWKH1910TG	●	19.1	8.5	7.0	
TAWKH1920TG	●	19.2	8.5	7.0	
TAWKH1930TG	●	19.3	8.5	7.0	
TAWKH1940TG	●	19.4	8.5	7.0	
TAWKH1950TG	●	19.5	8.4	7.0	
TAWKH1960TG	●	19.6	8.4	7.0	
TAWKH1970TG	●	19.7	8.4	7.0	TAWSN 2000S25
TAWKH1980TG	●	19.8	8.4	7.0	TAWMN 2000S25
TAWKH1990TG	●	19.9	8.4	7.0	TAWLN 2000S25
TAWKH2000TG	●	20.0	8.3	7.0	
TAWKH2010TG	□	20.1	8.3	7.0	
TAWKH2020TG	□	20.2	8.3	7.0	
TAWKH2030TG	□	20.3	8.3	7.0	
TAWKH2040TG	□	20.4	8.3	7.0	
TAWKH2050TG	●	20.5	8.2	7.0	
TAWKH2060TG	□	20.6	8.2	7.0	
TAWKH2070TG	□	20.7	8.2	7.0	TAWSN 2100S25
TAWKH2080TG	□	20.8	8.2	7.0	TAWMN 2100S25
TAWKH2090TG	□	20.9	8.2	7.0	TAWLN 2100S25
TAWKH2100TG	●	21.0	8.1	7.0	
TAWKH2110TG	□	21.1	8.1	7.0	
TAWKH2120TG	□	21.2	8.1	7.0	
TAWKH2130TG	□	21.3	8.1	7.0	
TAWKH2140TG	□	21.4	8.1	7.0	
TAWKH2150TG	●	21.5	9.8	8.0	
TAWKH2160TG	□	21.6	9.8	8.0	
TAWKH2170TG	□	21.7	9.8	8.0	TAWSN 2200S25
TAWKH2180TG	□	21.8	9.8	8.0	TAWMN 2200S25
TAWKH2190TG	□	21.9	9.8	8.0	TAWLN 2200S25
TAWKH2200TG	●	22.0	9.7	8.0	
TAWKH2210TG	□	22.1	9.7	8.0	
TAWKH2220TG	□	22.2	9.7	8.0	
TAWKH2230TG	□	22.3	9.7	8.0	
TAWKH2240TG	□	22.4	9.7	8.0	
TAWKH2250TG	●	22.5	9.6	8.0	TAWSN 2300S25
TAWKH2260TG	□	22.6	9.6	8.0	TAWMN 2300S25
TAWKH2270TG	□	22.7	9.6	8.0	TAWLN 2300S25
TAWKH2280TG	□	22.8	9.6	8.0	
TAWKH2290TG	□	22.9	9.6	8.0	

## 刀片

### H型

(铸铁加工用)



型 号	库存	尺寸 (mm)			适用刀柄
	DP5010	DC	LF	S	
TAWKH2300TG	●	23.0	9.5	8.0	TAWSN 2300S25
TAWKH2310TG	□	23.1	9.5	8.0	TAWMN 2300S25
TAWKH2320TG	□	23.2	9.5	8.0	TAWLN 2300S25
TAWKH2330TG	□	23.3	9.5	8.0	
TAWKH2340TG	□	23.4	9.5	8.0	
TAWKH2350TG	●	23.5	9.4	8.0	
TAWKH2360TG	□	23.6	9.4	8.0	
TAWKH2370TG	□	23.7	9.4	8.0	TAWSN 2400S32
TAWKH2380TG	□	23.8	9.4	8.0	
TAWKH2390TG	□	23.9	9.4	8.0	TAWMN 2400S32
TAWKH2400TG	●	24.0	9.3	8.0	TAWLN 2400S32
TAWKH2410TG	□	24.1	9.3	8.0	
TAWKH2420TG	□	24.2	9.3	8.0	
TAWKH2430TG	□	24.3	9.3	8.0	
TAWKH2440TG	□	24.4	9.3	8.0	
TAWKH2450TG	●	24.5	10.8	9.0	
TAWKH2460TG	□	24.6	10.8	9.0	
TAWKH2470TG	□	24.7	10.8	9.0	TAWSN 2500S32
TAWKH2480TG	□	24.8	10.8	9.0	
TAWKH2490TG	□	24.9	10.8	9.0	TAWMN 2500S32
TAWKH2500TG	●	25.0	10.7	9.0	TAWLN 2500S32
TAWKH2510TG	□	25.1	10.7	9.0	
TAWKH2520TG	□	25.2	10.7	9.0	
TAWKH2530TG	□	25.3	10.7	9.0	
TAWKH2540TG	□	25.4	10.7	9.0	
TAWKH2550TG	●	25.5	10.6	9.0	
TAWKH2560TG	□	25.6	10.6	9.0	
TAWKH2570TG	□	25.7	10.6	9.0	TAWSN 2600S32
TAWKH2580TG	□	25.8	10.6	9.0	
TAWKH2590TG	□	25.9	10.6	9.0	TAWMN 2600S32
TAWKH2600TG	●	26.0	10.5	9.0	TAWLN 2600S32
TAWKH2610TG	□	26.1	10.5	9.0	
TAWKH2620TG	□	26.2	10.5	9.0	
TAWKH2630TG	□	26.3	10.5	9.0	
TAWKH2640TG	□	26.4	10.5	9.0	
TAWKH2650TG	●	26.5	10.4	9.0	
TAWKH2660TG	□	26.6	10.4	9.0	
TAWKH2670TG	□	26.7	10.4	9.0	TAWSN 2700S32
TAWKH2680TG	□	26.8	10.4	9.0	
TAWKH2690TG	□	26.9	10.4	9.0	TAWMN 2700S32
TAWKH2700TG	●	27.0	10.3	9.0	TAWLN 2700S32
TAWKH2710TG	□	27.1	10.3	9.0	
TAWKH2720TG	□	27.2	10.3	9.0	
TAWKH2730TG	□	27.3	10.3	9.0	
TAWKH2740TG	□	27.4	10.3	9.0	

型 号	库存	尺寸 (mm)			适用刀柄
	DP5010	DC	LF	S	
TAWKH2750TG	●	27.5	11.3	10.0	
TAWKH2760TG	□	27.6	11.3	10.0	
TAWKH2770TG	□	27.7	11.3	10.0	TAWSN 2800S32
TAWKH2780TG	□	27.8	11.3	10.0	
TAWKH2790TG	□	27.9	11.3	10.0	TAWMN 2800S32
TAWKH2800TG	●	28.0	11.2	10.0	TAWLN 2800S32
TAWKH2810TG	□	28.1	11.2	10.0	
TAWKH2820TG	□	28.2	11.2	10.0	
TAWKH2830TG	□	28.3	11.2	10.0	
TAWKH2840TG	□	28.4	11.2	10.0	
TAWKH2850TG	●	28.5	11.1	10.0	
TAWKH2860TG	□	28.6	11.1	10.0	
TAWKH2870TG	□	28.7	11.1	10.0	TAWSN 2900S32
TAWKH2880TG	□	28.8	11.1	10.0	
TAWKH2890TG	□	28.9	11.1	10.0	TAWMN 2900S32
TAWKH2900TG	●	29.0	11.0	10.0	TAWLN 2900S32
TAWKH2910TG	□	29.1	11.0	10.0	
TAWKH2920TG	□	29.2	11.0	10.0	
TAWKH2930TG	□	29.3	11.0	10.0	
TAWKH2940TG	□	29.4	11.0	10.0	
TAWKH2950TG	●	29.5	10.9	10.0	
TAWKH2960TG	□	29.6	10.9	10.0	
TAWKH2970TG	□	29.7	10.9	10.0	TAWSN 3000S32
TAWKH2980TG	□	29.8	10.9	10.0	
TAWKH2990TG	□	29.9	10.9	10.0	TAWMN 3000S32
TAWKH3000TG	●	30.0	10.8	10.0	TAWLN 3000S32
TAWKH3010TG	□	30.1	10.8	10.0	
TAWKH3020TG	□	30.2	10.8	10.0	
TAWKH3030TG	□	30.3	10.8	10.0	
TAWKH3040TG	□	30.4	10.8	10.0	

## 倒角加工模块用刀片

外形	型 号	库存	形 状
		VP15TF	
	TAWC12T301-45GM	●	

## 推荐切削条件

工件材料	钻头直径	条件	$\phi 18.5-\phi 21.4$		$\phi 21.5-\phi 24.4$	
			切削速度 (m/min)	每转进给量 (mm/rev)	切削速度 (m/min)	每转进给量 (mm/rev)
P	软钢	$\leq \text{HB180}$	90 (70—110)	0.25 (0.20—0.30)	100 (80—120)	0.30 (0.25—0.35)
	碳钢 合金钢	HB180—280	80 (60—100)	0.25 (0.20—0.30)	90 (70—110)	0.30 (0.25—0.35)
		HB280—350	70 (50—90)	0.20 (0.15—0.25)	80 (60—100)	0.25 (0.20—0.30)
M	不锈钢	$\leq \text{HB200}$	60 (50—70)	0.20 (0.15—0.22)	60 (50—70)	0.20 (0.15—0.22)
K	灰铸铁	抗拉强度 $\leq 350\text{MPa}$	120 (60—140)	0.25 (0.20—0.30)	130 (80—150)	0.35 (0.25—0.40)
	球墨铸铁	抗拉强度 $\leq 450\text{MPa}$	80 (60—90)	0.25 (0.20—0.30)	90 (60—100)	0.30 (0.25—0.35)

工件材料	钻头直径	条件	$\phi 24.5-\phi 27.4$		$\phi 27.5-\phi 30.4$	
			切削速度 (m/min)	每转进给量 (mm/rev)	切削速度 (m/min)	每转进给量 (mm/rev)
P	软钢	$\leq \text{HB180}$	110 (80—120)	0.30 (0.25—0.35)	110 (80—120)	0.30 (0.25—0.35)
	碳钢 合金钢	HB180—280	100 (80—120)	0.30 (0.25—0.35)	100 (80—120)	0.30 (0.25—0.35)
		HB280—350	90 (70—110)	0.25 (0.20—0.30)	90 (70—110)	0.25 (0.20—0.30)
M	不锈钢	$\leq \text{HB200}$	70 (60—80)	0.25 (0.20—0.28)	70 (60—80)	0.25 (0.20—0.28)
K	灰铸铁	抗拉强度 $\leq 350\text{MPa}$	140 (90—160)	0.35 (0.25—0.40)	140 (90—160)	0.40 (0.30—0.45)
	球墨铸铁	抗拉强度 $\leq 450\text{MPa}$	100 (80—110)	0.30 (0.25—0.35)	100 (80—110)	0.30 (0.25—0.35)

注1 使用钻削孔深8D用钻头时，请将切削速度降低20%左右。

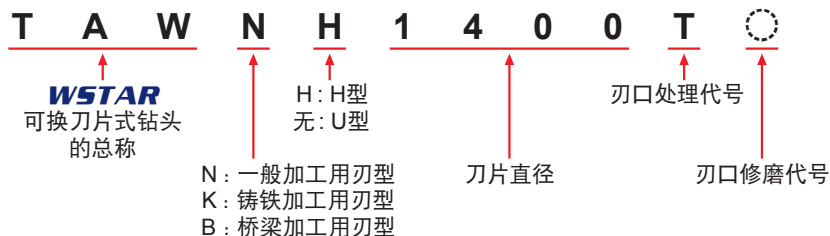
注2 使用钻削孔深8D用钻头时，推荐预先进行同尺寸的导孔加工。

注3 软钢、不锈钢加工推荐使用H型刃口修磨刀片。

## 刃口修磨量的选择

若希望订购非标准刃口修磨的刀片，请在型号后标注下图所示的刃口修磨代号。

(刀片型号)



(刃口修磨规定)

刃口修磨代号	刃口修磨量 (mm)
F	无
G	0.02—0.05
H	0.05—0.10
无标记(标准品)	0.10—0.15
K	0.15—0.20
S	0.20—0.25
M	0.25—0.30

## 使用注意事项

### 刀片的安装方法

- 安装刀片前，请松开刀柄的夹紧螺钉。
- 请将刀片与刀柄的锯齿相对应插入槽内。
- 用手指轻按刀片顶端部的同时，用附带的扳手或市面销售的六角星形扳手拧紧夹紧螺钉。(图1)
- 确保刀片底面与刀柄槽底部完全密合无缝。(图2)

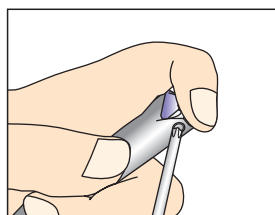


图1

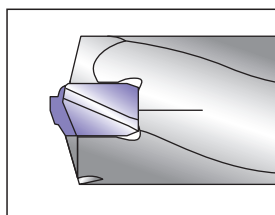
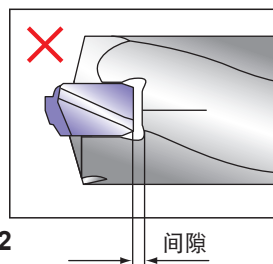


图2



间隙

### 更换刀片时的注意事项

- 插入新刀片前，请使用气枪等将使用后的刀柄的刀片槽吹干净。
- 若刀柄的锯齿部分及槽部分的污垢较多，请使用附带的刮板(WPT4405)去除。



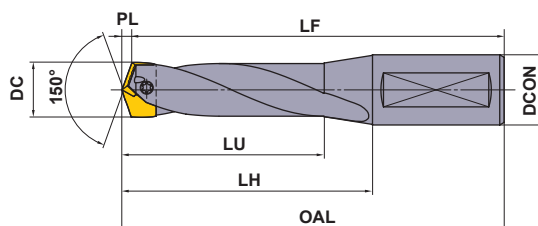
# TAW

WSTAR可换刀片式钻头

P M K N S H

钢

(桥梁加工用)



## 刀柄规格


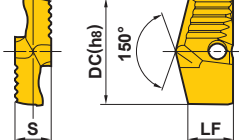
DC (mm)	钻削孔深 (l/d)	刀柄		适用刀片			尺寸 (mm)						夹紧螺钉	扳手	刮板	防止 烧熔剂
		型 号	库存	DC (mm)	型 号	库存 VP15TF	LU	LH	OAL	LF	PL	DCON				
24.5	3	TAWSB2500S32	●	24.5	TAWBH2450T	●	91.9	113.9	173.9	170.6	3.3	32	WS406023T	TKY25T	WPT4405	MK1KS
24.6	5	TAWMB2500S32	□	24.6	TAWBH2460T	□	143.9	168.9	228.9	225.6	3.3	32	WS406023T	TKY25T	WPT4405	MK1KS
24.7				24.7	TAWBH2470T	●										
26.5	3	TAWSB2700S32	●	26.5	TAWBH2650T	□	98.2	119.2	179.2	175.6	3.6	32	WS406024T	TKY25T	WPT4405	MK1KS
26.7	5	TAWMB2700S32	□	26.7	TAWBH2670T	●	155.2	179.2	239.2	235.6	3.6	32	WS406024T	TKY25T	WPT4405	MK1KS
					TAWBH2670T	●										

注1 以上尺寸为安装TAWBH (H型) 刀片时的尺寸。

注2 标准品以外的特殊形状 (例如: 不同直径、不同长度、带倒角刃等) 若有需求敬请垂询。

●: 标准库存品 □: 预订生产品

## 刀片

外形	型 号	库存	尺寸 (mm)			适用刀柄	刃口修磨量 (mm)	形 状
		VP15TF	DC	LF	S			
	TAWBH2450T	●	24.5	11.7	9.0	TAWSB2500S32 TAWMB2500S32	0.20—0.25	
	TAWBH2460T	□	24.6	11.7	9.0			
	TAWBH2470T	●	24.7	11.7	9.0			
	TAWBH2650T	□	26.5	11.3	9.0	TAWSB2700S32 TAWMB2700S32		
	TAWBH2670T	●	26.7	11.3	9.0			

●: 标准库存品 □: 预订生产品

(1盒1片装)

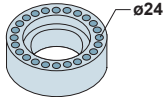
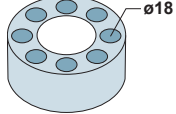
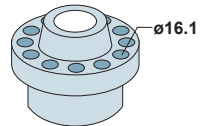
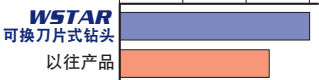
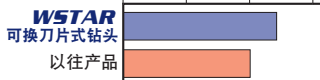
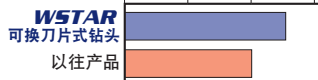
## 推荐切削条件

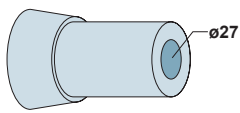
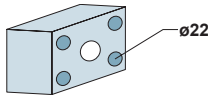
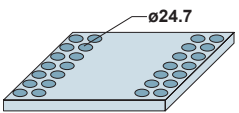
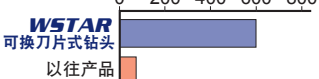
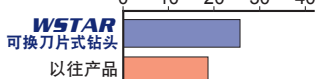
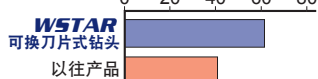
工件材料		钻头直径	φ24.5, φ24.6, φ24.7		φ26.5, φ26.7	
		条件	切削速度 (m/min)	每转进给量 (mm/rev)	切削速度 (m/min)	每转进给量 (mm/rev)
P	结构钢	SS400 抗拉强度 ≤400—500MPa	70 (60—80)	0.30 (0.25—0.35)	70 (60—80)	0.30 (0.25—0.35)
		SM490 抗拉强度 ≤490—610MPa	65 (55—75)	0.30 (0.25—0.35)	65 (55—75)	0.30 (0.25—0.35)
		SM570 抗拉强度 ≤570—720MPa	60 (50—70)	0.30 (0.25—0.35)	60 (50—70)	0.30 (0.25—0.35)

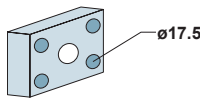
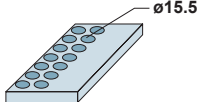
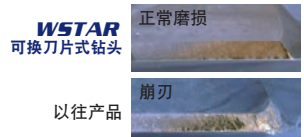
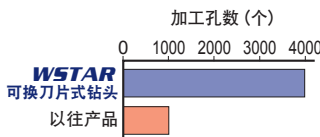
●: 标准库存品 □: 预订生产品

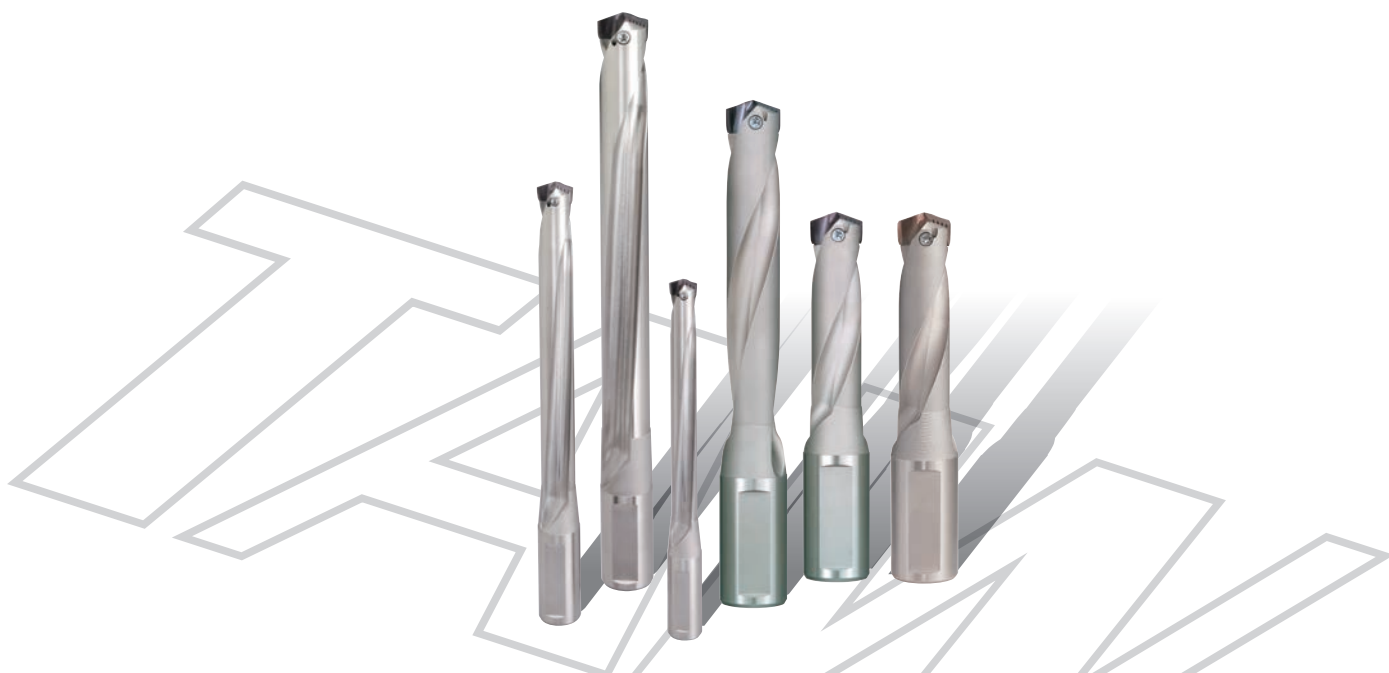


## 使用实例

刀 柄	TAWSN2400S32	TAWMN1800S20	TAWSN1600S20
刀 片(材 料)	TAWNH2400T (VP15TF)	TAWN1800T (VP15TF)	TAWN1610T (VP15TF)
工 件 材 料	S50C 	S48C(HB200) 	SF390A 
零 部 件 名 称	机床零部件环	齿圈	机床零部件
切 削 条 件			
切 削 速 度(m/min)	90	70	80
每 转 进 给 量(mm/rev)	0.3	0.3	0.3
转 速(min <sup>-1</sup> )	1194	1238	1582
进 给 速 度(mm/min)	358	371	475
冷 却 方 式	W.S.O	水溶性(内部冷却)	水溶性(内部冷却)
使 用 机 床	立式加工中心	卧式加工中心	卧式加工中心
结 果	切削长度 (m) 0 10 20 30 	加工孔数 (个) 0 100 200 300 	加工孔数 (个) 0 200 400 600 

刀 柄	TAWSN2700S32	TAWLN2200S25	TAWSB2500S32
刀 片(材 料)	TAWN2700T (VP15TF)	TAWN2200T (VP15TF)	TAWB2470T (VP15TF)
工 件 材 料	相当于SCM 	FCD400 	SM490 (1张板) 
零 部 件 名 称	钻头体	液压阀	桥梁用钢板
切 削 条 件			
切 削 速 度(m/min)	80	70	60
每 转 进 给 量(mm/rev)	0.3	0.2	0.3
转 速(min <sup>-1</sup> )	943	1013	773
进 给 速 度(mm/min)	283	203	232
冷 却 方 式	水溶性(内部冷却)	水溶性(内部冷却)	W.S.O
使 用 机 床	NC车床	卧式加工中心	炮身钻床
结 果	加工孔数 (个) 0 200 400 600 800 	切削长度 (m) 0 10 20 30 40 	切削长度 (m) 0 20 40 60 80 

刀 柄	TAWSN1800S20	TAWSN1600S20
刀 片(材 料)	TAWKH1750TG (DP5010)	TAWKH1550TG (DP5010)
工 件 材 料	FC250 	FC250 
零 部 件 名 称	机床零部件	机床零部件
切 削 条 件		
切 削 速 度(m/min)	120	73
每 转 进 给 量(mm/rev)	0.25	0.2
转 速(min <sup>-1</sup> )	2183	1500
进 给 速 度(mm/min)	546	300
冷 却 方 式	水溶性(内部冷却)	水溶性(内部冷却)
使 用 机 床	立式加工中心	立式加工中心
结 果		加工孔数 (个) 0 1000 2000 3000 4000 



# 可换刀片式硬质合金钻头 **WSTAR**可换刀片式钻头系列 **TAW**

## 关于安全

●请勿用手直接触摸切削刃、切屑。●请在推荐条件范围内使用,及早更换刀具。●有时会有高温的切屑飞出,伸长的切屑排出,请使用防护罩、防护镜等防护用具。●使用非水溶性切削液时,务必采取防火措施。  
●使用旋转刀具时,务必进行试运转,确认有无振摆、振动、异常声音。●研磨或加热切削工具会产生粉尘、烟雾。大量吸入、吸入、与眼睛、皮肤接触,会对人体有害。

**三菱综合材料株式会社**

**MITSUBISHI MATERIALS CORPORATION**

**三菱综合材料管理(上海)有限公司**

E-mail: [mmscinfo@mmc.sh.cn](mailto:mmscinfo@mmc.sh.cn)

<http://www.mmsc-carbide.com.cn>

●刀具技术服务热线

三 菱 三 菱

**400-001-3030**

上海总公司

地址: 中国上海市静安区南京西路1468号中欣大厦3911室 邮编: 200040  
电话: 021-6289-0022 传真: 021-6279-1180

天津分公司

电话: 022-2311-9298

重庆分公司

电话: 023-6372-9572

广州分公司

电话: 020-8755-5462

沈阳分公司

电话: 024-3128-1230



微信公众号 MMC-TOOLS

(规格若有更改, 恕不事先通知)

EXP-10-E042  
####.##.AK(##)