

股票代码: 688308

OKE 欧科亿

END MILLS

➤ OMT高效钛合金铣刀系列

OMT end mill series for high efficiency titanium alloy machining



www.oke-carbide.com

OMT 高效钛合金铣刀系列 OMT end mill series for high efficiency titanium alloy machining

01 产品优势 Product advantage

■ **不等齿距、大螺旋角和超大 U 型槽设计，高效抗振结构，超高排屑性能，金属去除率提升。**

Unequal tooth pitch, large spiral Angle and large U-shaped flute design, efficient anti-vibration structure, ultra-high chip removal performance, metal removal rate.

■ **自主研发粗晶粒基材、刃口超级抛光技术，具有超长刀具寿命。**

Self developed coarse grain size substrate combine with super polished cutting edge, which gives excellent tool life.

■ **适用于航空高强度钛合金 TC4、TA15、TC11、TC18 高效切削加工。**

Suitable for high-strength aviation titanium alloy TC4, TA15, TC11, TC18 efficient cutting.

■ **满足航空结构件大切深、大切宽的动态铣削、暴力开粗等高效加工要求，可实现粗精一体加工。**

Able to meet the high efficiency machining requirements of large cutting depth and wide cutting of aviation structural parts, such as dynamic milling and violent roughing.

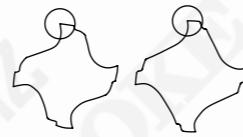


02 产品特点
Product advantage

AlCrSi 基硬度 3200(HV0.025)
最高使用温度 1200°C
摩擦系数 (钢球) 0.6

AlTiCr base coating hardness 3200 (HV0.025)
maximum working Temperature 1200°C
friction coefficient (steel ball) 0.6

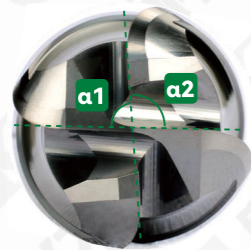
超级 U 型排屑槽, 比普通 U 槽容屑空间更大, 排屑更流畅
The Updated U shape chipping room provide bigger chipping room and smooth chipping remove



自主开发高性能棒材, 可以有效减缓切削过程中粘结磨损
Self-developed high-performance carbide rod effectively reduce adhesive wear during cutting

不等齿距的端刃抗震设计, 每个齿承受的负荷更加均匀, 有效延长铣刀的使用寿命

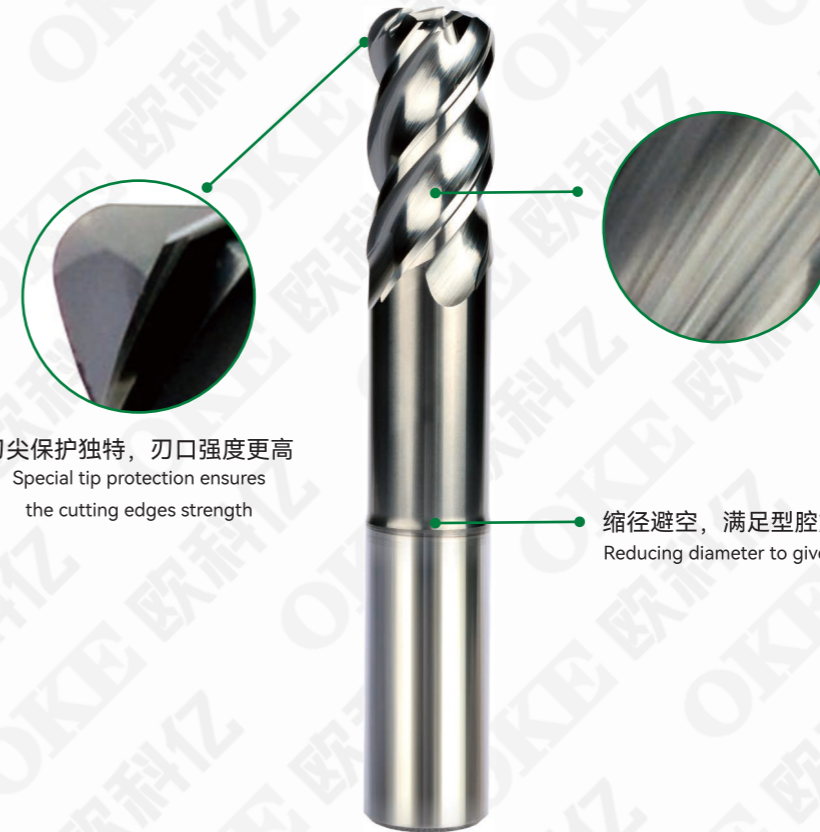
The anti-vibration cutting edge design: Differential pitch makes the load of each flute more evenly and effectively increase the tool performance.



$\alpha 1 \neq \alpha 2$



$\alpha 1 \neq \alpha 2 \neq \alpha 3$

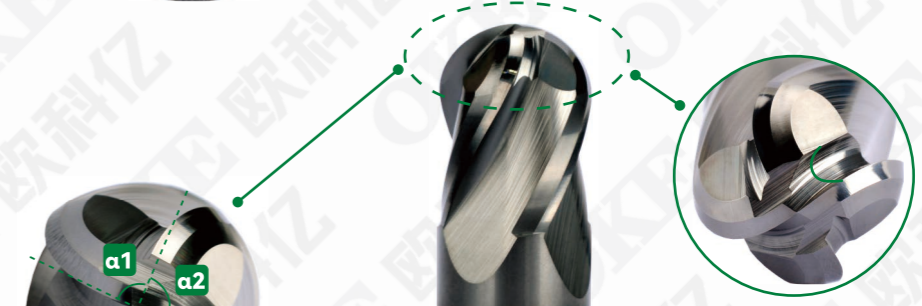


刀尖保护独特, 刃口强度更高
Special tip protection ensures the cutting edges strength

超高精细磨削抛光工艺, 获得高质量刃口质量和螺旋槽排屑能力

Ultra-high precision grinding and polishing process, to obtain high quality cutting edge quality and spiral flute chip removal capability

缩径避空, 满足型腔加工需求
Reducing diameter to give more clearance



$\alpha 1 \neq \alpha 2$

不等分刀齿球头设计, 适用于复杂曲面加工, 切削更稳定

The differential round head flute pitch design, suitable for complex surface machining with stable cutting

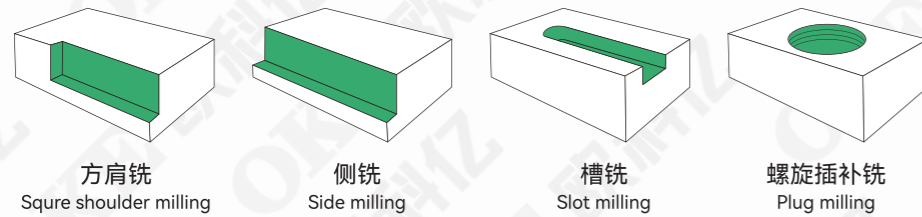
成型 gash 槽
切削效率高
切削稳定性好
结构设计合理

GASH forming geometry
High cutting efficiency
Good cutting stability
Rational structure design

03 产品应用 Product application cases

■ OMT-4E/4R/4RP

适用于加工钛合金粗、精加工
Suitable for processing titanium rough finishing



方肩铣
Square shoulder milling

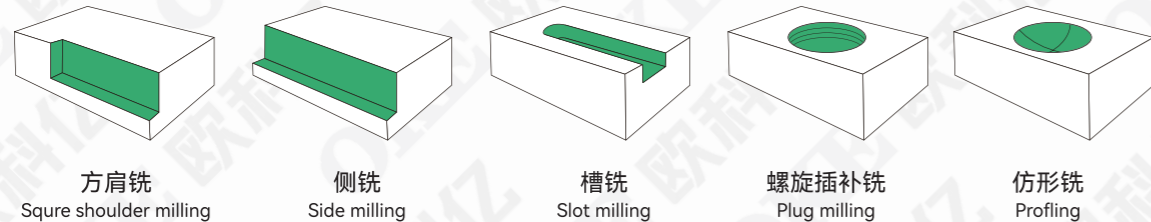
侧铣
Side milling

槽铣
Slot milling

螺旋插补铣
Plug milling

■ OMT-5R-L/X

适用于加工钛合金粗、半精、精加工
Suitable for Titanium rough, semi-finishing and finishing machining



方肩铣
Square shoulder milling

侧铣
Side milling

槽铣
Slot milling

螺旋插补铣
Plug milling

仿形铣
Profiling

■ OMT-4B

适用于加工钛合金 3D 仿形切削
Suitable for machining Titanium 3D profiling

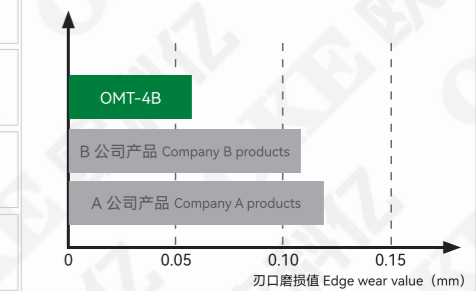
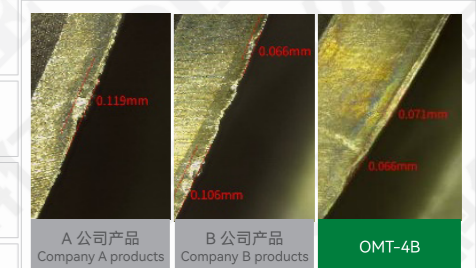


仿形铣
Profiling

04 产品案例 Application cases

■ 应用案例一 Application cases 1

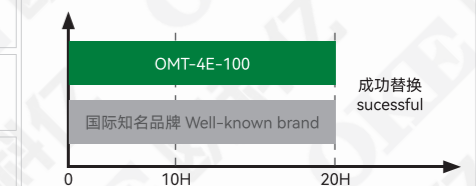
加工产品 Processed products	TC4 测试块 TC4 Test piece
刀具型号 Cutter model	OMT-4B-120R6.0
工件材料 Workpiece material	TC4
切削参数 Cutting data	Vc=45.3m/min, Fn=0.2mm/rev Ae=6mm, Ap=3.6mm
失效形式 Mode of failure	刀具磨损、粗糙度差 Tool wear, poor roughness
刀具使用部位 The part where the tool is used	端刃 + 侧刃 End edge + side edge
冷却方式 Cooling method	水溶性切削液 Water-soluble cutting fluid
加工机床 Machining machines	丽驰数控加工中心 Litz CNC machining center
加工寿命 Machining life	360min



以 45.3m/min 速度切削 360 分钟后, 相比竞品刀具, OMT-4B 球头立铣刀的刀具寿命提升了 25%。
After 360 minutes of cutting at 45.3 m/min, the OMT-4B ball nose end mill delivers a 25% increase in tool life compared to competitive tools.

■ 应用案例二 Application cases 2

加工产品 Processed products	TC4 航空结构件 TC4 Aerostructural part
刀具型号 Cutter model	OMT-4E-100
工件材料 Workpiece material	TC4
切削参数 Cutting data	S=2700r/min, F=950~2000mm/min Fn=0.35mm~0.74mm, AP=7mm AE=0.2~10mm, 动态铣削
失效形式 Mode of failure	刀具磨损、粗糙度差 Tool wear, poor roughness
刀具使用部位 The part where the tool is used	端刃 + 侧刃 End edge + side edge
冷却方式 Cooling method	水溶性切削液 Water-soluble cutting fluid
加工机床 Machining machines	数控加工中心 CNC machining center
加工寿命 Machining life	20h



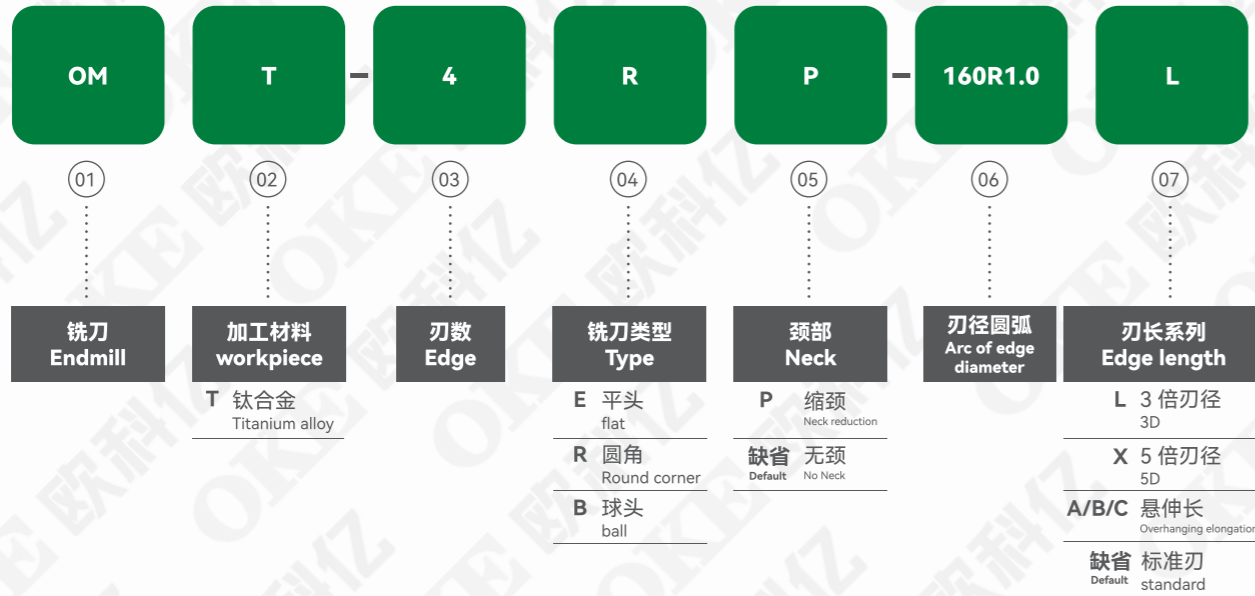
刀具连续加工 20 小时, 满足客户使用加工需求, 实现国产化刀具替换
Continuous tool processing for 20 hours, to meet customer processing needs, to achieve domestic tool replacement

05 命名规则

Name rules

06 产品规格型号

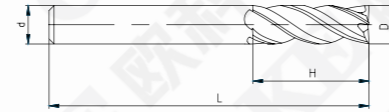
Product specifications



规格型号 Specification and model	刀具类型 Tool type	直径范围 Diameter range	刀具类型 Tool example	刃数 Tool flutes
OMT-4E	平头铣刀 Flat End Mill	4~20mm		4
OMT-4R OMT-4RP	圆角铣刀 Corner Radius End Mill	4~20mm		4
OMT-5R OMT-5R-L/X	圆角铣刀 Corner Radius End Mill	6~25mm		5
OMT-4B	球头铣刀 Ball End Mill	6~20mm		4

07 产品型号明细
Product list

■ OMT-4E 四刃直柄平头立铣刀 4 Flutes straight shank flat end mills



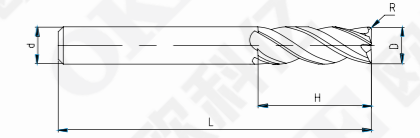
直径公差 Diameter tolerance

D4~D12	0,-0.03
D14~D20	0,-0.04

订货号 Type	基本尺寸 Main Size (mm)				齿数 Number of teeth Z	库存 Stock
	D	d	H	L		
OMT-4E-040	4	4	11	50	4	●
OMT-4E-060	6	6	16	50	4	●
OMT-4E-080	8	8	20	60	4	●
OMT-4E-100	10	10	25	75	4	●
OMT-4E-120	12	12	30	75	4	●
OMT-4E-140	14	14	32	80	4	●
OMT-4E-160	16	16	35	100	4	●
OMT-4E-200	20	20	45	100	4	●

●常备库存 In stock ▲按订单生产 Make to order

■ OMT-4R 四刃直柄圆角铣刀 4 Flutes straight shank corner radius end mills



直径公差 Diameter tolerance

D4~D12	0,-0.03
D16~D20	0,-0.04

订货号 Type	基本尺寸 Main Size (mm)					齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L		
OMT-4R-040R0.5S	4	0.5	4	11	50	4	●
OMT-4R-040R1.0S	4	1.0	4	11	50	4	●
OMT-4R-050R0.5	5	0.5	6	13	50	4	●
OMT-4R-060R0.5	6	0.5	6	16	50	4	●
OMT-4R-060R1.0	6	1.0	6	16	50	4	●
OMT-4R-080R0.5	8	0.5	8	20	60	4	●
OMT-4R-080R1.0	8	1.0	8	20	60	4	●
OMT-4R-100R0.5	10	0.5	10	25	75	4	●
OMT-4R-100R1.0	10	1.0	10	25	75	4	●
OMT-4R-100R2.0	10	2.0	10	25	75	4	●
OMT-4R-100R3.0	10	3.0	10	25	75	4	●
OMT-4R-120R0.5	12	0.5	12	30	75	4	●
OMT-4R-120R1.0	12	1.0	12	30	75	4	●

●常备库存 In stock ▲按订单生产 Make to order

被加工材料 Processed material					
碳钢、合金钢 Carbon steel, alloy steel < 48HRC	不锈钢 Stainless steel	TA α	TC α+β	TB β	高温合金 High temperature alloy
○	●	●	●	●	○

● 特别适合 Very suitable ○ 适合 Suitable

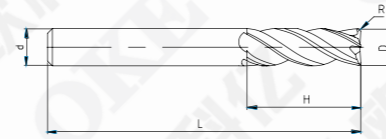
硬度单位: HRC

被加工材料 Processed material					
碳钢、合金钢 Carbon steel, alloy steel < 48HRC	不锈钢 Stainless steel	TA α	TC α+β	TB β	高温合金 High temperature alloy
○	●	●	●	●	○

● 特别适合 Very suitable ○ 适合 Suitable

硬度单位: HRC

■ OMT-4R 四刃直柄圆角铣刀 4 Flutes straight shank cornder radius end mills



直径公差 Diameter tolerance

D4~D12	0,-0.03
D16~D20	0,-0.04

订货号 Type	基本尺寸 Main Size (mm)					齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L		
OMT-4R-120R2.0	12	2.0	12	30	75	4	●
OMT-4R-120R3.0	12	3.0	12	30	75	4	●
OMT-4R-160R0.5	16	0.5	16	35	100	4	●
OMT-4R-160R1.0	16	1.0	16	35	100	4	●
OMT-4R-160R2.0	16	2.0	16	35	100	4	●
OMT-4R-160R3.0	16	3.0	16	35	100	4	●
OMT-4R-160R4.0	16	4.0	16	35	100	4	●
OMT-4R-200R0.5	20	0.5	20	45	100	4	●
OMT-4R-200R1.0	20	1.0	20	45	100	4	●
OMT-4R-200R2.0	20	2.0	20	45	100	4	●
OMT-4R-200R3.0	20	3.0	20	45	100	4	●
OMT-4R-200R4.0	20	4.0	20	45	100	4	●
OMT-4R-200R5.0	20	5.0	20	45	100	4	●

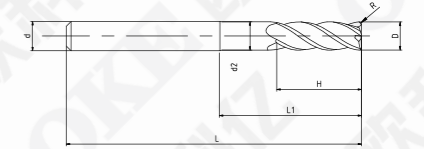
●常备库存 In stock ▲按订单生产 Make to order

被加工材料 Processed material					
碳钢、合金钢 Carbon steel, alloy steel < 48HRC	不锈钢 Stainless steel	TA α	TC α+β	TB β	高温合金 High temperature alloy
○	●	●	●	●	○

● 特别适合 Very suitable ○ 适合 Suitable

硬度单位: HRC

■ OMT-4RP 四刃直柄长颈圆角铣刀 4 Flutes straight shank long neck corner radius end mills



直径公差 Diameter tolerance

D6~D12	0,-0.03
D16~D20	0,-0.04

订货号 Type	基本尺寸 Main Size (mm)							齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L1	d2	L		
OMT-4RP-060R0.5	6	0.5	6	12	18	5.5	60	4	●
OMT-4RP-060R1.0	6	1.0	6	12	18	5.5	60	4	●
OMT-4RP-080R0.5	8	0.5	8	16	25	7.5	75	4	●
OMT-4RP-080R1.0	8	1.0	8	16	25	7.5	75	4	●
OMT-4RP-100R0.5	10	0.5	10	20	30	9.5	75	4	●
OMT-4RP-100R1.0	10	1.0	10	20	30	9.5	75	4	●
OMT-4RP-100R2.0	10	2.0	10	20	30	9.5	75	4	●
OMT-4RP-120R1.0	12	1.0	12	25	40	11.5	90	4	●
OMT-4RP-120R2.0	12	2.0	12	25	40	11.5	90	4	●
OMT-4RP-120R3.0	12	3.0	12	25	40	11.5	90	4	●
OMT-4RP-160R0.5	16	0.5	16	32	50	15.5	100	4	●
OMT-4RP-160R0.5A	16	0.5	16	32	60	15.5	110	4	▲
OMT-4RP-160R1.0	16	1.0	16	32	50	15.5	100	4	●
OMT-4RP-160R1.0A	16	1.0	16	32	60	15.5	110	4	▲
OMT-4RP-160R1.0B	16	1.0	16	32	70	15.5	120	4	▲
OMT-4RP-160R1.0C	16	1.0	16	32	80	15.5	130	4	▲
OMT-4RP-160R2.0	16	2.0	16	32	50	15.5	100	4	●
OMT-4RP-160R2.0A	16	2.0	16	32	60	15.5	110	4	▲
OMT-4RP-160R3.0A	16	3.0	16	32	60	15.5	110	4	▲
OMT-4RP-160R3.0B	16	3.0	16	35	70	15.5	120	4	▲

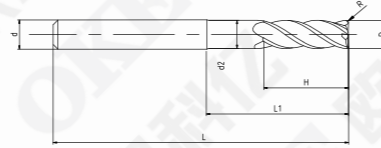
●常备库存 In stock ▲按订单生产 Make to order

被加工材料 Processed material					
碳钢、合金钢 Carbon steel, alloy steel < 48HRC	不锈钢 Stainless steel	TA α	TC α+β	TB β	高温合金 High temperature alloy
○	●	●	●	●	○

● 特别适合 Very suitable ○ 适合 Suitable

硬度单位: HRC

■ OMT-4RP 四刃直柄长颈圆角铣刀 4 Flutes straight shank long neck corner radius end mills



直径公差 Diameter tolerance

D6~D12	0,-0.03
D16~D20	0,-0.04

订货号 Type	基本尺寸 Main Size (mm)							齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L1	d2	L		
OMT-4RP-160R3.0C	16	3.0	16	35	80	15.5	130	4	▲
OMT-4RP-200R0.5	20	0.5	20	40	60	19.5	110	4	●
OMT-4RP-200R0.5A	20	0.5	20	40	80	19.5	130	4	▲
OMT-4RP-200R1.0	20	1.0	20	40	60	19.5	110	4	●
OMT-4RP-200R1.0A	20	1.0	20	40	70	19.5	120	4	▲
OMT-4RP-200R1.0B	20	1.0	20	40	80	19.5	130	4	▲
OMT-4RP-200R1.0C	20	1.0	20	40	100	19.5	150	4	▲
OMT-4RP-200R2.0	20	2.0	20	40	60	19.5	110	4	●
OMT-4RP-200R2.0A	20	2.0	20	40	80	19.5	130	4	▲
OMT-4RP-200R3.0	20	3.0	20	40	60	19.5	110	4	●
OMT-4RP-200R3.0A	20	3.0	20	40	70	19.5	120	4	▲
OMT-4RP-200R3.0B	20	3.0	20	40	80	19.5	130	4	▲
OMT-4RP-200R3.0C	20	3.0	20	40	100	19.5	150	4	▲
OMT-4RP-200R4.0	20	4.0	20	40	60	19.5	110	4	●
OMT-4RP-200R4.0A	20	4.0	20	40	80	19.5	130	4	▲
OMT-4RP-200R5.0	20	5.0	20	40	60	19.5	110	4	●
OMT-4RP-200R5.0A	20	5.0	20	40	70	19.5	120	4	▲
OMT-4RP-200R5.0B	20	5.0	20	40	80	19.5	130	4	▲
OMT-4RP-200R5.0C	20	5.0	20	40	100	19.5	150	4	▲

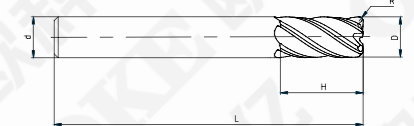
●常备库存 In stock ▲按订单生产 Make to order

被加工材料 Processed material					
碳钢、合金钢 Carbon steel, alloy steel < 48HRC	不锈钢 Stainless steel	TA α	TC α+β	TB β	高温合金 High temperature alloy
○	●	●	●	●	○

● 特别适合 Very suitable ○ 适合 Suitable

硬度单位: HRC

■ OMT-5R 五刃直柄圆角铣刀 5 Flutes straight shank corner radius end mills



直径公差 Diameter tolerance

D6~D12	0,-0.03
D16~D20	0,-0.04

订货号 Type	基本尺寸 Main Size (mm)					齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L		
OMT-5R-060R0.2	6	0.2	6	16	50	5	●
OMT-5R-060R0.3	6	0.3	6	16	50	5	●
OMT-5R-060R0.5	6	0.5	6	16	50	5	●
OMT-5R-060R0.75	6	0.75	6	16	50	5	▲
OMT-5R-060R1.0	6	1.0	6	16	50	5	●
OMT-5R-080R0.2	8	0.2	8	20	60	5	●
OMT-5R-080R0.3	8	0.3	8	20	60	5	●
OMT-5R-080R0.5	8	0.5	8	20	60	5	●
OMT-5R-080R0.75	8	0.75	8	20	60	5	▲
OMT-5R-080R1.0	8	1.0	8	20	60	5	●
OMT-5R-080R2.0	8	2.0	8	20	60	5	●
OMT-5R-100R0.2	10	0.2	10	25	75	5	●
OMT-5R-100R0.3	10	0.3	10	25	75	5	●
OMT-5R-100R0.5	10	0.5	10	25	75	5	●
OMT-5R-100R0.75	10	0.75	10	25	75	5	▲
OMT-5R-100R1.0	10	1.0	10	25	75	5	●
OMT-5R-100R1.5	10	1.5	10	25	75	5	▲
OMT-5R-100R2.0	10	2.0	10	25	75	5	●
OMT-5R-120R0.2	12	0.2	12	30	75	5	●

●常备库存 In stock ▲按订单生产 Make to order

被加工材料 Processed material					
碳钢、合金钢 Carbon steel, alloy steel < 48HRC	不锈钢 Stainless steel	TA α	TC α+β	TB β	高温合金 High temperature alloy
○	●	●	●	●	○

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直径公差 Diameter tolerance

D6~D12	0,-0.03
D16~D20	0,-0.04

订货号 Type	基本尺寸 Main Size (mm)					齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L		
OMT-5R-120R0.3	12	0.3	12	30	75	5	●
OMT-5R-120R0.5	12	0.5	12	30	75	5	●
OMT-5R-120R0.75	12	0.75	12	30	75	5	▲
OMT-5R-120R1.0	12	1.0	12	30	75	5	●
OMT-5R-120R1.5	12	1.5	12	30	75	5	▲
OMT-5R-120R2.0	12	2.0	12	30	75	5	●
OMT-5R-120R2.5	12	2.5	12	30	75	5	▲
OMT-5R-120R3.0	12	3.0	12	30	75	5	▲
OMT-5R-160R0.2	16	0.2	16	35	100	5	▲
OMT-5R-160R0.3	16	0.3	16	35	100	5	▲
OMT-5R-160R0.5	16	0.5	16	35	100	5	●
OMT-5R-160R0.75	16	0.75	16	35	100	5	▲
OMT-5R-160R1.0	16	1.0	16	35	100	5	●
OMT-5R-160R1.5	16	1.5	16	35	100	5	▲
OMT-5R-160R2.0	16	2.0	16	35	100	5	●
OMT-5R-160R2.5	16	2.5	16	35	100	5	▲
OMT-5R-160R3.0	16	3.0	16	35	100	5	●
OMT-5R-160R4.0	16	4.0	16	35	100	5	●
OMT-5R-200R0.2	20	0.2	20	45	100	5	▲

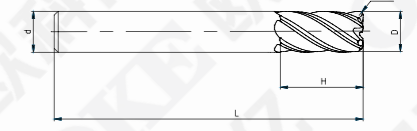
●常备库存 In stock ▲按订单生产 Make to order

被加工材料 Processed material					
碳钢、合金钢 Carbon steel, alloy steel < 48HRC	不锈钢 Stainless steel	TA α	TC α+β	TB β	高温合金 High temperature alloy
○	●	●	●	●	○

● 特别适合 Very suitable ○ 适合 Suitable

硬度单位: HRC

■ OMT-5R 五刃直柄圆角铣刀 5 Flutes straight shank cornder radius end mills



直径公差 Diameter tolerance

D6~D12	0,-0.03
D16~D20	0,-0.04

订货号 Type	基本尺寸 Main Size (mm)					齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L		
OMT-5R-200R0.3	20	0.3	20	45	100	5	▲
OMT-5R-200R0.5	20	0.5	20	45	100	5	▲
OMT-5R-200R0.75	20	0.75	20	45	100	5	▲
OMT-5R-200R1.0	20	1.0	20	45	100	5	●
OMT-5R-200R1.5	20	1.5	20	45	100	5	▲
OMT-5R-200R2.0	20	2.0	20	45	100	5	●
OMT-5R-200R2.5	20	2.5	20	45	100	5	▲
OMT-5R-200R3.0	20	3.0	20	45	100	5	●
OMT-5R-200R4.0	20	4.0	20	45	100	5	▲
OMT-5R-250R1.0	25	1.0	25	50	110	5	▲
OMT-5R-250R2.0	25	2.0	25	50	110	5	▲
OMT-5R-250R3.0	25	3.0	25	50	110	5	▲
OMT-5R-250R4.0	25	4.0	25	50	110	5	▲
OMT-5R-250R5.0	25	5.0	25	50	110	5	▲

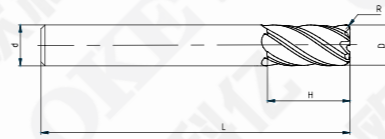
●常备库存 In stock ▲按订单生产 Make to order

被加工材料 Processed material					
碳钢、合金钢 Carbon steel, alloy steel < 48HRC	不锈钢 Stainless steel	TA α	TC α+β	TB β	高温合金 High temperature alloy
○	●	●	●	●	○

● 特别适合 Very suitable ○ 适合 Suitable

硬度单位: HRC

■ OMT-5R-L/X 五刃长刃圆角铣刀 5 Long Flutes corner radius end mills



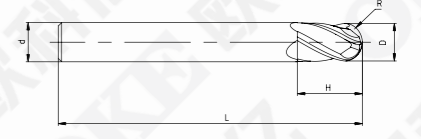
直径公差 Diameter tolerance

D16~D25	0,-0.04
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订货号 Type	基本尺寸 Main Size (mm)					齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L		
OMT-5R-160R0.5L	16	0.5	16	48	100	5	●
OMT-5R-160R0.5X	16	0.5	16	80	130	5	▲
OMT-5R-200R0.5L	20	0.5	20	60	110	5	●
OMT-5R-200R0.5X	20	0.5	20	100	150	5	▲
OMT-5R-250R0.5L	25	0.5	25	75	155	5	▲
OMT-5RL-250R0.5X	25	0.5	25	125	205	5	▲

●常备库存 In stock ▲按订单生产 Make to order

■ OMT-4B 四刃球头铣刀 4 Flutes ball end mills



直径公差 Diameter tolerance

D6~D12	0,-0.03
D16~D20	0,-0.04

订货号 Type	基本尺寸 Main Size (mm)					齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L		
OMT-4B-060R3.0	6	3.0	6	12	50	4	●
OMT-4B-080R4.0	8	4.0	8	14	60	4	●
OMT-4B-100R5.0	10	5.0	10	18	75	4	●
OMT-4B-120R6.0	12	6.0	12	22	75	4	●
OMT-4B-160R8.0	16	8.0	16	30	100	4	▲
OMT-4B-200R10.0	20	10.0	20	38	100	4	▲

●常备库存 In stock ▲按订单生产 Make to order

被加工材料 Processed material					
碳钢、合金钢 Carbon steel, alloy steel < 48HRC	不锈钢 Stainless steel	TA α	TC α+β	TB β	高温合金 High temperature alloy
○	●	●	●	●	○

● 特别适合 Very suitable ○ 适合 Suitable

硬度单位: HRC

被加工材料 Processed material					
碳钢、合金钢 Carbon steel, alloy steel < 48HRC	不锈钢 Stainless steel	TA α	TC α+β	TB β	高温合金 High temperature alloy
○	●	●	●	●	○

● 特别适合 Very suitable ○ 适合 Suitable

硬度单位: HRC

08 切削参数推荐表
Cutting parameters recommended table

OMT-4E/4R/5R 切削参数推荐——侧铣 Cutting parameter recommendation—Side Milling

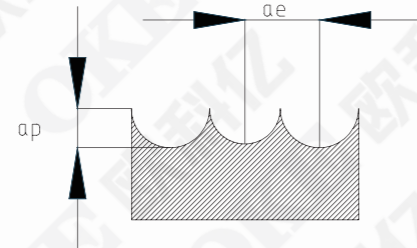
工件材料 Workpiece Material		切深量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	12	16	20
钛合金 Titanium Alloy	TA	$ap \leq 1.5D$	100 (80~120)	转速 Speed (min^{-1})	2650	1990	1590
		$ae \leq 0.2D$		进给速度 Feed Rate (mm/min)	740	635	605
	TC	$ap \leq 1.5D$	100 (80~120)	转速 Speed (min^{-1})	2650	1990	1590
		$ae \leq 0.2D$		进给速度 Feed Rate (mm/min)	690	635	570
	TB	$ap \leq 1.5D$	80 (60~100)	转速 Speed (min^{-1})	2120	1590	1270
		$ae \leq 0.2D$		进给速度 Feed Rate (mm/min)	550	510	460

OMT-4E/4R/5R 切削参数推荐——槽铣 Cutting parameter recommendation—Slotting

工件材料 Workpiece Material		切深量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	12	16	20
钛合金 Titanium Alloy	TA	$ap \leq 1D$	80 (60~100)	转速 Speed (min^{-1})	2120	1590	1275
		$ae=1D$		进给速度 Feed Rate (mm/min)	595	510	485
	TC	$ap \leq 1D$	80 (60~100)	转速 Speed (min^{-1})	2120	1590	1275
		$ae=1D$		进给速度 Feed Rate (mm/min)	550	510	460
	TB	$ap \leq 1D$	50 (40~60)	转速 Speed (min^{-1})	1460	1095	875
		$ae=1D$		进给速度 Feed Rate (mm/min)	380	350	315

■ OMT-4B 切削参数推荐——仿形铣 Cutting parameter recommendation—Profiling

工件材料 Workpiece Material	切深量 Cutting Depth (mm)	切削速度 Cutting Speed (m/min)	刃径 Tool Diameter (mm)	6	8	10	12	16
钛合金 Titanium Alloy	$ap \leq 0.2D$	70 (60~80)	转速 Speed (min^{-1})	3715	2785	2230	1860	1390
	$ae \leq 0.3D$		进给速度 Feed Rate (mm/min)	670	610	535	480	445



09 客户支持服务
Customer Support

■ 定制化解决方案
Customized solutions

■ 技术培训与指导
Technical training and guidance

■ 售后服务与维护
After-sales service and maintenance



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Working Add: #588, Jinlong Area, Majiahe Rd, Tianyuan District, Zhuzhou, Hunan, China.

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Domestic Sales Hotline

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0731-2267 3988 (锯齿) (Saw Tips)

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International Sales Hotline

0086-731-2757 7393