



LONG Life HIGH Performance

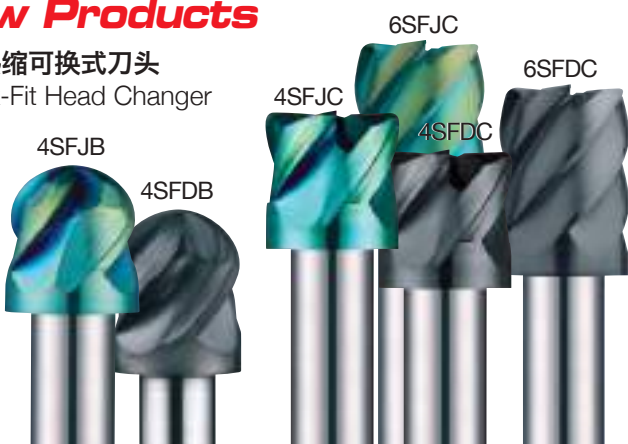
- HRC62以下多种材料加工。
- 使用TISIN-S涂层延长了产品使用寿命。
- 装夹铣刀片实现高精度，高质量精加工使用。
- 专业的技术设计，增强切削力，表面光洁度非常优秀。
- Variety cutting process for under HRC62.
- Insert coated TISIN-S provides long cutting life.
- High quality cutting surface by high precision of insert with the body.
- Special shape provides excellent performance and beautiful surface.



FINISHING 硬质合金 精加工铣刀片 INSERTS

New Products

热缩可换式刀头
Shrink-Fit Head Changer



为了多年来支持JJ铣刀的客户们，我们将降低最低成本做成最高品质来报答客户。

Thank you for JJtools partner and we repay for your favor. We are always trying to do our best for supplying better quality product and reasonable price.

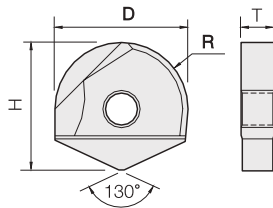
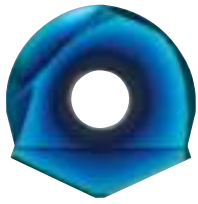
Your specials are our standards.
您的非标品会是我们的标准品



2 Flutes HH Carbide Helix Ball Inserts for Hardened Steels

New

HH系列 硬质合金 2刃 高硬度加工用 球头铣刀片



- 高硬度钢 (HRC62~) 预硬钢类、石墨类、精密加工用铣刀片
- TISIN-S涂层处理刃部, 有卓越的耐磨性。
- 专业的螺旋角设计提高了切削力能力。
- 专业的技术及刃部设计, 使刃口崩损最小化。
- 采用高抗折力、超微粒子超硬合金 (0.3 μ m) 材料, 刃部损坏最小化。

- **Ball Insert for hardened steel (HRc62~), pre-hardened and graphite materials.**
- Optimum for wear resistance by TISIN-S coating.
- Maximize cutting force by applying the new helix edge design.
- Designed for minimizing edge chipping by ball shape.
- Minimize fracturing by high TRS fine(0.3 μ m) WC grade.

2 WC TISIN-S Coating R ±0.01 5~6.5R R ±0.015 8~15R D +0~-0.01 D10~13 D +0~-0.02 D16~30 JOIN ±0.02 5~15R

单位: mm

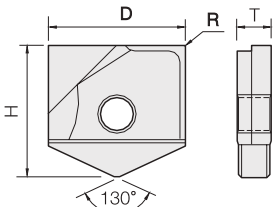
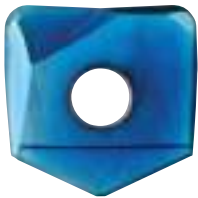
Order Number	刃径 Diameter R X D	高度 Height H	厚度 Thickness T	Order Number	刃径 Diameter R X D	高度 Height H	厚度 Thickness T
2HHINB 100	5R X 10	12.1	2.7	2HHINB 200	10R X 20	20.4	5.2
2HHINB 110	5.5R X 11	12.6	2.7	2HHINB 210	10.5R X 21	20.9	5.2
2HHINB 120	6R X 12	14.6	3.2	2HHINB 250	12.5R X 25	24.1	6.2
2HHINB 130	6.5R X 13	15.1	3.2	2HHINB 260	13R X 26	24.6	6.2
2HHINB 160	8R X 16	16.5	4.2	2HHINB 300	15R X 30	29.1	7.2
2HHINB 170	8.5R X 17	17	4.2				



2 Flutes HH Carbide Helix Corner Radius Inserts for Hardened Steels

New

HH系列 硬质合金 2刃高硬度加工用 圆鼻铣刀片



- 高硬度钢 (HRC62~) 预硬钢类、石墨类、精密加工用铣刀片
- TISIN-S涂层处理刃部, 有卓越的耐磨性。
- 专业的螺旋角设计提高了切削力能力。
- 专业的技术及刃部设计, 使刃口崩损最小化。
- 采用高抗折力、超微粒子超硬合金 (0.3 μ m) 材料, 刃部损坏最小化。

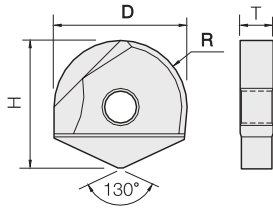
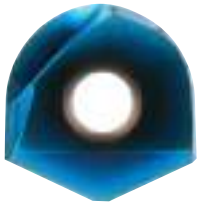
- **Ball Insert for hardened steel (HRc62~), pre-hardened and graphite materials.**
- Optimum for wear resistance by TISIN-S coating.
- Maximize cutting force by applying the new helix edge design.
- Designed for minimizing edge chipping by corner R shape.
- Minimize fracturing by high TRS fine(0.3 μ m) WC grade.

2 WC TISIN-S Coating R ±0.015 0.5~2R D +0~-0.01 D10~13 D +0~-0.02 D16~30 JOIN ±0.02 D10~30

单位: mm

Order Number	刃径 Diameter D X R	高度 Height H	厚度 Thickness T	Order Number	刃径 Diameter D X R	高度 Height H	厚度 Thickness T
2HHINC 100 005	10 X R0.5	12.1	2.7	2HHINC 200 005	20 X R0.5	20.4	5.2
2HHINC 100 010	10 X R1	12.1	2.7	2HHINC 200 010	20 X R1	20.4	5.2
2HHINC 110 005	11 X R0.5	12.6	2.7	2HHINC 200 020	20 X R2	20.4	5.2
2HHINC 110 010	11 X R1	12.6	2.7	2HHINC 210 005	21 X R0.5	20.9	5.2
2HHINC 120 005	12 X R0.5	14.6	3.2	2HHINC 210 010	21 X R1	20.9	5.2
2HHINC 120 010	12 X R1	14.6	3.2	2HHINC 210 020	21 X R2	20.9	5.2
2HHINC 120 020	12 X R2	14.6	3.2	2HHINC 250 005	25 X R0.5	24.1	6.2
2HHINC 130 005	13 X R0.5	15.1	3.2	2HHINC 250 010	25 X R1	24.1	6.2
2HHINC 130 010	13 X R1	15.1	3.2	2HHINC 250 020	25 X R2	24.1	6.2
2HHINC 130 020	13 X R2	15.1	3.2	2HHINC 260 005	26 X R0.5	24.6	6.2
2HHINC 160 005	16 X R0.5	16.5	4.2	2HHINC 260 010	26 X R1	24.6	6.2
2HHINC 160 010	16 X R1	16.5	4.2	2HHINC 260 020	26 X R2	24.6	6.2
2HHINC 160 020	16 X R2	16.5	4.2	2HHINC 300 005	30 X R0.5	29.1	7.2
2HHINC 170 005	17 X R0.5	17	4.2	2HHINC 300 010	30 X R1	29.1	7.2
2HHINC 170 010	17 X R1	17	4.2	2HHINC 300 020	30 X R2	29.1	7.2
2HHINC 170 020	17 X R2	17	4.2				

JJ系列硬质合金 2刃 高硬度加工用球头铣刀片



- 高硬度钢 (HRC62~) 预硬钢类、石墨类精密加工用铣刀片
- TISIN-S涂层处理刃部, 有卓越的耐磨性。
- 刀口特殊设计减少崩损发生。
- 采用高抗折力、超微粒子超硬合金 (0.3 μ m) 材料, 刃部损坏最小化。

• Ball Insert for hardened steel (HRC62~), pre-hardened and graphite materials.

- Optimum for wear resistance by TISIN-S coating.
- Excellent ball design to minimize chipping.
- Minimize fracturing by high TRS fine(0.3 μ m) WC grade.

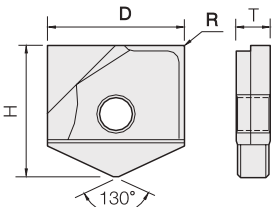
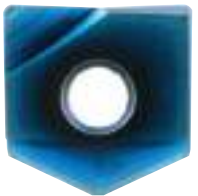


单位: mm

Order Number	刃径 Diameter R X D	高度 Height H	厚度 Thickness T
2JJINB 100	5R X 10	12.1	2.7
2JJINB 110	5.5R X 11	12.6	2.7
2JJINB 120	6R X 12	14.6	3.2
2JJINB 130	6.5R X 13	15.1	3.2
2JJINB 160	8R X 16	16.5	4.2
2JJINB 170	8.5R X 17	17	4.2

Order Number	刃径 Diameter R X D	高度 Height H	厚度 Thickness T
2JJINB 200	10R X 20	20.4	5.2
2JJINB 210	10.5R X 21	20.9	5.2
2JJINB 250	12.5R X 25	24.1	6.2
2JJINB 260	13R X 26	24.6	6.2
2JJINB 300	15R X 30	29.1	7.2

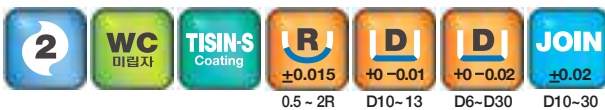
JJ系列硬质合金 2刃 高硬度加工用圆鼻铣刀片



- 高硬度钢 (HRC62~) 预硬钢类、石墨类精密加工用铣刀片
- TISIN-S涂层处理刃部, 有卓越的耐磨性。
- R角特殊设计减少崩损发生。
- 采用高抗折力、超微粒子超硬合金 (0.3 μ m) 材料, 刃部损坏最小化。

• Ball Insert for hardened steel (HRC62~), pre-hardened and graphite materials.

- Optimum for wear resistance by TISIN-S coating.
- Excellent corner radius design to minimize chipping.
- Minimize fracturing by high TRS fine(0.3 μ m) WC grade.



单位: mm

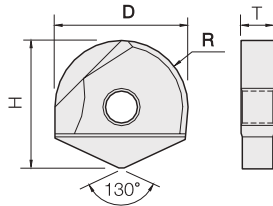
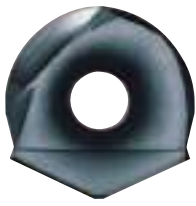
Order Number	刃径 Diameter D X R	高度 Height H	厚度 Thickness T
2JJINC 100 005	10 X R0.5	12.1	2.7
2JJINC 100 010	10 X R1	12.1	2.7
2JJINC 110 005	11 X R0.5	12.6	2.7
2JJINC 110 010	11 X R1	12.6	2.7
2JJINC 120 005	12 X R0.5	14.6	3.2
2JJINC 120 010	12 X R1	14.6	3.2
2JJINC 120 020	12 X R2	14.6	3.2
2JJINC 130 005	13 X R0.5	15.1	3.2
2JJINC 130 010	13 X R1	15.1	3.2
2JJINC 130 020	13 X R2	15.1	3.2
2JJINC 160 005	16 X R0.5	16.5	4.2
2JJINC 160 010	16 X R1	16.5	4.2
2JJINC 160 020	16 X R2	16.5	4.2
2JJINC 170 005	17 X R0.5	17	4.2
2JJINC 170 010	17 X R1	17	4.2
2JJINC 170 020	17 X R2	17	4.2

Order Number	刃径 Diameter D X R	高度 Height H	厚度 Thickness T
2JJINC 200 005	20 X R0.5	20.4	5.2
2JJINC 200 010	20 X R1	20.4	5.2
2JJINC 200 020	20 X R2	20.4	5.2
2JJINC 210 005	21 X R0.5	20.9	5.2
2JJINC 210 010	21 X R1	20.9	5.2
2JJINC 210 020	21 X R2	20.9	5.2
2JJINC 250 005	25 X R0.5	24.1	6.2
2JJINC 250 010	25 X R1	24.1	6.2
2JJINC 250 020	25 X R2	24.1	6.2
2JJINC 260 005	26 X R0.5	24.6	6.2
2JJINC 260 010	26 X R1	24.6	6.2
2JJINC 260 020	26 X R2	24.6	6.2
2JJINC 300 005	30 X R0.5	29.1	7.2
2JJINC 300 010	30 X R1	29.1	7.2
2JJINC 300 020	30 X R2	29.1	7.2



2Flutes Diamond Coated Helix Ball Insert for Graphite **New**

2刃 石墨加工用 金刚石涂层 球头铣刀片



- 石墨加工专用铣刀片
- 采用CVD纯金刚石涂层体现卓越的耐磨性。
- 专业的螺旋角设计提高了切削力。
- **Insert for graphite milling**
- Excellent wear resistance by applying qualified CVD diamond coating.
- Maximize cutting force by applying the new helix edge design.

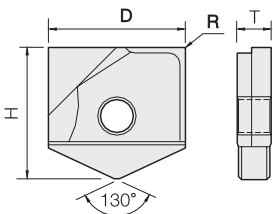
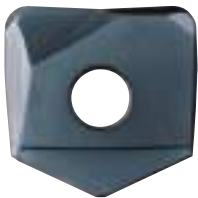
单位: mm

Order Number	刃径 Diameter R × D	高度 Height H	厚度 Thickness T	Order Number	刃径 Diameter R × D	高度 Height H	厚度 Thickness T
2DINB 100	5R X 10	12.1	2.7	2DINB 200	10R X 20	20.4	5.2
2DINB 110	5.5R X 11	12.6	2.7	2DINB 210	10.5R X 21	20.9	5.2
2DINB 120	6R X 12	14.6	3.2	2DINB 250	12.5R X 25	24.1	6.2
2DINB 130	6.5R X 13	15.1	3.2	2DINB 260	13R X 26	24.6	6.2
2DINB 160	8R X 16	16.5	4.2	2DINB 300	15R X 30	29.1	7.2
2DINB 170	8.5R X 17	17	4.2				



2Flutes Diamond Coated Helix Corner Radius Insert for Graphite **New**

2刃 石墨加工用 金刚石涂层 圆鼻铣刀片



- 石墨加工专用铣刀片
- 采用CVD纯金刚石涂层体现卓越的耐磨性。
- 专业的螺旋角设计提高了切削力。
- **Insert for graphite milling**
- Excellent wear resistance by applying qualified CVD diamond coating.
- Maximize cutting force by applying the new helix edge design.

单位: mm

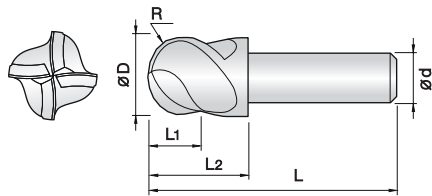
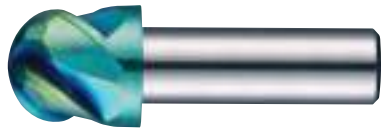
Order Number	刃径 Diameter D × R	高度 Height H	厚度 Thickness T	Order Number	刃径 Diameter D × R	高度 Height H	厚度 Thickness T
2DINC 100 005	10 X R0.5	12.1	2.7	2DINC 200 005	20 X R0.5	20.4	5.2
2DINC 100 010	10 X R1	12.1	2.7	2DINC 200 010	20 X R1	20.4	5.2
2DINC 110 005	11 X R0.5	12.6	2.7	2DINC 200 020	20 X R2	20.4	5.2
2DINC 110 010	11 X R1	12.6	2.7	2DINC 210 005	21 X R0.5	20.9	5.2
2DINC 120 005	12 X R0.5	14.6	3.2	2DINC 210 010	21 X R1	20.9	5.2
2DINC 120 010	12 X R1	14.6	3.2	2DINC 210 020	21 X R2	20.9	5.2
2DINC 120 020	12 X R2	14.6	3.2	2DINC 250 005	25 X R0.5	24.1	6.2
2DINC 130 005	13 X R0.5	15.1	3.2	2DINC 250 010	25 X R1	24.1	6.2
2DINC 130 010	13 X R1	15.1	3.2	2DINC 250 020	25 X R2	24.1	6.2
2DINC 130 020	13 X R2	15.1	3.2	2DINC 260 005	26 X R0.5	24.6	6.2
2DINC 160 005	16 X R0.5	16.5	4.2	2DINC 260 010	26 X R1	24.6	6.2
2DINC 160 010	16 X R1	16.5	4.2	2DINC 260 020	26 X R2	24.6	6.2
2DINC 160 020	16 X R2	16.5	4.2	2DINC 300 005	30 X R0.5	29.1	7.2
2DINC 170 005	17 X R0.5	17	4.2	2DINC 300 010	30 X R1	29.1	7.2
2DINC 170 010	17 X R1	17	4.2	2DINC 300 020	30 X R2	29.1	7.2
2DINC 170 020	17 X R2	17	4.2				

4SFJB

4Flutes JJ Carbide Helix Ball Shrink-fit Insert for Hardened steel

New

JJ系列硬质合金 4刃热缩可换式球头刀头



- 高硬度钢 (HRC62~) 预硬钢类、精密加工用热缩可换式刀头
- TISIN-S涂层处理刃部, 有卓越的耐磨性。
- 使用热缩刀柄时具有较高的夹持力和同心度的保障。
- 刀头使用后可修磨, 提升了产品的性价比。
- 采用高抗折力、超微粒子超硬合金 (0.4 μm) 材料, 刃部崩损最小化。

Shrink fit insert for hardened steel (HRC62~), pre-hardened and graphite materials.

- Optimum for wear resistance on the edge by TISIN-S coating.
- Excellent holding power and concentricity keeping are available by shrink fitting holder.
- Regrinding is available as new product quality and very economical after use.
- Minimize fracturing by high TRS fine (0.4 μm) WC grade.



D Size	D Tolerance
ø10 ~ 12	-0.005 ~ -0.015mm
ø13 ~ 21	-0.01 ~ -0.02mm

单位: mm

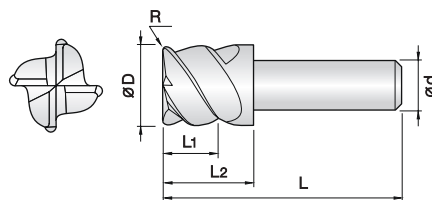
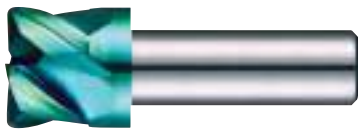
Order Number	刃径 Diameter R x D	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d	Order Number	刃径 Diameter R x D	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d
4SFJB 100 085 S06	5R X 10	8.5	12	37	6	4SFJB 160 120 S10	8R X 16	12	17	48	10
4SFJB 110 085 S06	5.5R X 11	8.5	12	37	6	4SFJB 170 120 S10	8.5R X 17	12	17	48	10
4SFJB 120 090 S06	6R X 12	9	13	38	6	4SFJB 200 150 S12	10R X 20	15	21	54	12
4SFJB 130 090 S06	6.5R X 13	9	13	38	6	4SFJB 210 150 S12	10.5R X 21	15	21	54	12

4SFJJC

4Flutes JJ Carbide Helix Corner Radius Shrink-fit Insert for Hardened steel

New

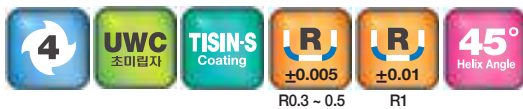
JJ系列硬质合金 4刃热缩可换式圆鼻刀头



- 高硬度钢 (HRC62~) 预硬钢类、精密加工用热缩可换式刀头
- TISIN-S涂层处理刃部, 有卓越的耐磨性。
- 使用热缩刀柄时具有较高的夹持力和同心度的保障。
- 刀头使用后可修磨, 提升了产品的性价比。
- 采用高抗折力、超微粒子超硬合金 (0.4 μm) 材料, 刃部崩损最小化。

Shrink fit insert for hardened steel (HRC62~), pre-hardened and graphite materials.

- Optimum for wear resistance on the edge by TISIN-S coating.
- Excellent holding power and concentricity keeping are available by shrink fitting holder.
- Regrinding is available as new product quality and very economical after use.
- Minimize fracturing by high TRS fine (0.4 μm) WC grade.



D Size	D Tolerance
ø10 ~ 12	0 ~ -0.01mm
ø13 ~ 21	-0.01 ~ -0.02mm

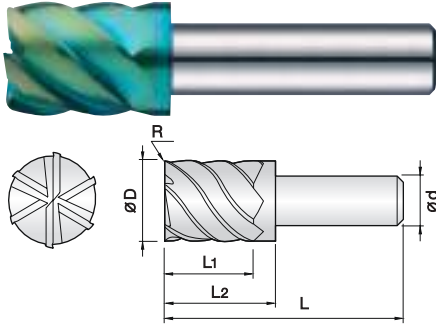
单位: mm

Order Number	刃径 Diameter D x R	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d	Order Number	刃径 Diameter D x R	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d
4SFJJC 100 003 085	10 X R0.3	8.5	12	37	6	4SFJJC 130 005 090	13 X R0.5	9	13	38	6
4SFJJC 100 005 085	10 X R0.5	8.5	12	37	6	4SFJJC 130 010 090	13 X R1	9	13	38	6
4SFJJC 100 010 085	10 X R1	8.5	12	37	6	4SFJJC 160 005 120	16 X R0.5	12	17	48	10
4SFJJC 110 003 085	11 X R0.3	8.5	12	37	6	4SFJJC 160 010 120	16 X R1	12	17	48	10
4SFJJC 110 005 085	11 X R0.5	8.5	12	37	6	4SFJJC 170 005 120	17 X R0.5	12	17	48	10
4SFJJC 110 010 085	11 X R1	8.5	12	37	6	4SFJJC 170 010 120	17 X R1	12	17	48	10
4SFJJC 120 003 090	12 X R0.3	9	13	38	6	4SFJJC 200 005 150	20 X R0.5	15	21	54	12
4SFJJC 120 005 090	12 X R0.5	9	13	38	6	4SFJJC 200 010 150	20 X R1	15	21	54	12
4SFJJC 120 010 090	12 X R1	9	13	38	6	4SFJJC 210 005 150	21 X R0.5	15	21	54	12
4SFJJC 130 003 090	13 X R0.3	9	13	38	6	4SFJJC 210 010 150	21 X R1	15	21	54	12

6-12SFJC

6~12Flutes JJ Carbide Helix Corner Radius Shrink-fit Insert for Hardened steel New

JJ系列硬质合金 6~12 刃热缩可换式R角刀头



- 高硬度钢 (HRC62~) 预硬钢类、精密加工用热缩可换式刀头
- TISIN-S涂层处理刃部, 有卓越的耐磨性。
- 6~12多刃更利于高速加工。
- 使用热缩刀柄时具有较高的夹持力和同心度的保障。
- 刀头使用后 可修磨, 提升了产品的性价比。
- 采用高抗折力、超微粒子超硬合金 (0.4 μ m) 材料, 刃部崩损最小化。

• Shrink fit insert for hardened steel (HRC62~), pre-hardened and graphite materials.

- Optimum for wear resistance on the edge by TISIN-S coating.
- High speed milling process is available with multiple 6-12 flutes.
- Excellent holding power and concentricity keeping are available by shrink fitting holder.
- Regrinding is available as new product quality and very economical after use.
- Minimize fracturing by high TRS fine (0.4 μ m) WC grade.



D Size	D Tolerance
ϕ 10 ~ 12	0 ~ -0.01mm
ϕ 13 ~ 21	-0.01 ~ -0.02mm

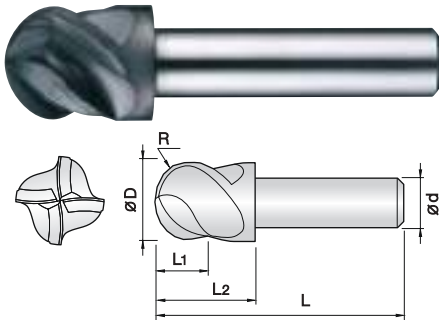
单位: mm

Order Number	刃径 Diameter D x R	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d	Order Number	刃径 Diameter D x R	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d
6SFJC 100 003 085	10 X R0.3	8.5	12	37	6	8SFJC 130 005 090	13 X R0.5	9	13	38	6
6SFJC 100 005 085	10 X R0.5	8.5	12	37	6	8SFJC 130 010 090	13 X R1	9	13	38	6
6SFJC 100 010 085	10 X R1	8.5	12	37	6	10SFJC 160 005 120	16 X R0.5	12	17	48	10
6SFJC 110 003 085	11 X R0.3	8.5	12	37	6	10SFJC 160 010 120	16 X R1	12	17	48	10
6SFJC 110 005 085	11 X R0.5	8.5	12	37	6	10SFJC 170 005 120	17 X R0.5	12	17	48	10
6SFJC 110 010 085	11 X R1	8.5	12	37	6	10SFJC 170 010 120	17 X R1	12	17	48	10
8SFJC 120 003 090	12 X R0.3	9	13	38	6	12SFJC 200 005 150	20 X R0.5	15	21	54	12
8SFJC 120 005 090	12 X R0.5	9	13	38	6	12SFJC 200 010 150	20 X R1	15	21	54	12
8SFJC 120 010 090	12 X R1	9	13	38	6	12SFJC 210 005 150	21 X R0.5	15	21	54	12
8SFJC 130 003 090	13 X R0.3	9	13	38	6	12SFJC 210 010 150	21 X R1	15	21	54	12

4SFDB

4Flutes Diamond Coated Helix Ball Shink-fit Insert for Graphite New

硬质合金 4刃 石墨加工用 金刚石涂层 热缩可换式球头刀头



- 石墨加工用热缩可换式刀头
- 采用CVD纯金刚石涂层体现卓越的耐磨性。
- 专业的螺旋角设计提高了切削能力。
- 使用热缩刀柄时具有较高的夹持力和同心度的保障。

• Shrink fit insert for graphite materials.

- Excellent wear resistance by applying the CVD pure diamond coating.
- Advanced helix edge design to maximize cutting force.
- Excellent holding power and concentricity keeping are available by shrink fitting holder.



D Size	D Tolerance
ϕ 10 ~ 12	-0.005 ~ -0.02mm
ϕ 13 ~ 21	-0.01 ~ -0.02mm

单位: mm

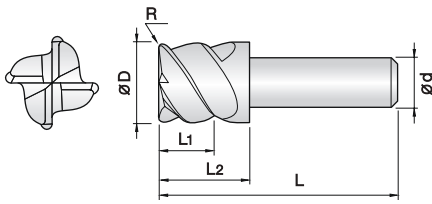
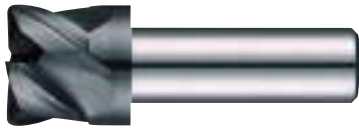
Order Number	刃径 Diameter R x D	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d	Order Number	刃径 Diameter R x D	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d
4SFDB 100 085 S06	5R X 10	8.5	12	37	6	4SFDB 160 120 S10	8R X 16	12	17	48	10
4SFDB 110 085 S06	5.5R X 11	8.5	12	37	6	4SFDB 170 120 S10	8.5R X 17	12	17	48	10
4SFDB 120 090 S06	6R X 6	9	13	38	6	4SFDB 200 150 S12	10R X 20	15	21	54	12
4SFDB 130 090 S06	6.5R X 13	9	13	38	6	4SFDB 210 150 S12	10.5R X 21	15	21	54	12

4SFDC

4Flutes Diamond Coated Helix Corner Radius Shrink-fit Insert for Graphite

New

硬质合金 4刃 石墨加工用 金刚石涂层 热缩可换式 圆鼻刀头



- 石墨加工专用热缩可换式刀头
- 采用CVD纯金刚石涂层体现卓越的耐磨性。
- 专业的螺旋角设计提高了切削能力。
- 使用热缩刀柄时具有较高的夹持力和同心度的保障。

• **Shrink fit insert for graphite materials.**

- Excellent wear resistance by applying the CVD pure diamond coating.
- Advanced helix edge design to maximize cutting force.
- Excellent holding power and concentricity keeping are available by shrink fitting holder.



D Size	D Tolerance
ø10 ~ 12	0 ~ -0.01mm
ø13 ~ 21	-0.01 ~ -0.02mm

单位: mm

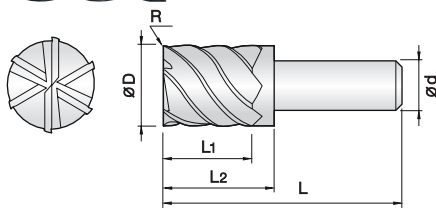
Order Number	刃径 Diameter D × R	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d	Order Number	刃径 Diameter D × R	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d
4SFDC 100 003 085	10 X R0.3	8.5	12	37	6	4SFDC 130 005 090	13 X R0.5	9	13	38	6
4SFDC 100 005 085	10 X R0.5	8.5	12	37	6	4SFDC 130 010 090	13 X R1	9	13	38	6
4SFDC 100 010 085	10 X R1	8.5	12	37	6	4SFDC 160 005 120	16 X R0.5	12	17	48	10
4SFDC 110 003 085	11 X R0.3	8.5	12	37	6	4SFDC 160 010 120	16 X R1	12	17	48	10
4SFDC 110 005 085	11 X R0.5	8.5	12	37	6	4SFDC 170 005 120	17 X R0.5	12	17	48	10
4SFDC 110 010 085	11 X R1	8.5	12	37	6	4SFDC 170 010 120	17 X R1	12	17	48	10
4SFDC 120 003 090	12 X R0.3	9	13	38	6	4SFDC 200 005 150	20 X R0.5	15	21	54	12
4SFDC 120 005 090	12 X R0.5	9	13	38	6	4SFDC 200 010 150	20 X R1	15	21	54	12
4SFDC 120 010 090	12 X R1	9	13	38	6	4SFDC 210 005 150	21 X R0.5	15	21	54	12
4SFDC 130 003 090	13 X R0.3	9	13	38	6	4SFDC 210 010 150	21 X R1	15	21	54	12

6-12SFDC

6~12Flutes Diamond Coated Helix Ball Shrink-fit Insert for Graphite

New

6~12刃 石墨加工用 金刚石涂层 热缩可换式 圆鼻刀头



- 石墨加工专用热缩可换式刀头
- 采用CVD纯金刚石涂层体现卓越的耐磨性。
- 6~12多刃更利于高速加工。
- 使用热缩刀柄时具有较高的夹持力和同心度的保障。

• **Shrink fit insert for graphite materials.**

- Excellent wear resistance by applying the CVD pure diamond coating.
- High speed milling process is available with multiple 6-12 flutes.
- Excellent holding power and concentricity keeping are available by shrink fitting holder.



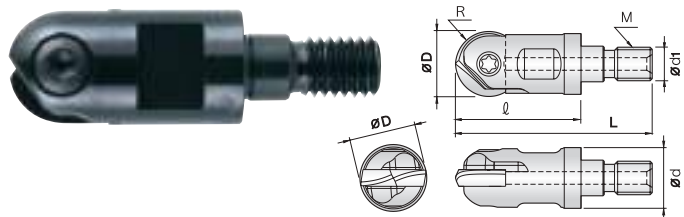
D Size	D Tolerance
ø10 ~ 12	0 ~ -0.01mm
ø13 ~ 21	-0.01 ~ -0.02mm

单位: mm

Order Number	刃径 Diameter D × R	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d	Order Number	刃径 Diameter D × R	刃长 Length of cut L1	有效长 Effective Length L2	全长 Overall Length L	柄径 Shank Dia d
6SFDC 100 003 085	10 X R0.3	8.5	12	37	6	8SFDC 130 005 090	13 X R0.5	9	13	38	6
6SFDC 100 005 085	10 X R0.5	8.5	12	37	6	8SFDC 130 010 090	13 X R1	9	13	38	6
6SFDC 100 010 085	10 X R1	8.5	12	37	6	10SFDC 160 005 120	16 X R0.5	12	17	48	10
6SFDC 110 003 085	11 X R0.3	8.5	12	37	6	10SFDC 160 010 120	16 X R1	12	17	48	10
6SFDC 110 005 085	11 X R0.5	8.5	12	37	6	10SFDC 170 005 120	17 X R0.5	12	17	48	10
6SFDC 110 010 085	11 X R1	8.5	12	37	6	10SFDC 170 010 120	17 X R1	12	17	48	10
8SFDC 120 003 090	12 X R0.3	9	13	38	6	12SFDC 200 005 150	20 X R0.5	15	21	54	12
8SFDC 120 005 090	12 X R0.5	9	13	38	6	12SFDC 200 010 150	20 X R1	15	21	54	12
8SFDC 120 010 090	12 X R1	9	13	38	6	12SFDC 210 005 150	21 X R0.5	15	21	54	12
8SFDC 130 003 090	13 X R0.3	9	13	38	6	12SFDC 210 010 150	21 X R1	15	21	54	12

MHE Modular Head

可换式刀头



- 可装夹球头刀片和圆鼻刀片。
- 用一个刀杆可替换不同的刀头使用，大幅度降低了成本。
- 加工中心或在机床上不用卸下刀杆，可直接更换刀头。节省了时间和便利性。
- Can be used for both of ball and corner radius inserts.
- Possible to exchange variety heads for one modular adopter and helps save your purchasing cost.
- Installed modular adopter can change only head without uninstallation, it gives more convenience and it helps save your time.

单位: mm

Order Number	Dimensions (mm)						Insert	Parts	
	M	D	L	l	d	d1		Screw	Wrench
MHE 100 250 M06	M06	10	40	25	9.5	6.5	2JJIN □ 100 / 2JJIN □ 110	SC 100 581142	T10
MHE 120 250 M06	M06	12	40	25	11	6.5	2JJIN □ 120 / 2JJIN □ 130	SC 120 581143	T20
MHE 160 290 M08	M08	16	45	29	14.5	8.5	2JJIN □ 160 / 2JJIN □ 170	SC 160 581144	T20
MHE 200 330 M10	M10	20	55	33	18	10.5	2JJIN □ 200 / 2JJIN □ 210	SC 200 581145	T25
MHE 250 390 M12	M12	25	60	39	22.5	12.5	2JJIN □ 250 / 2JJIN □ 260	SC 250 581146	T30
MHE 300 430 M16	M16	30	70	43	28	17	2JJIN □ 300	SC 300 581147	T30

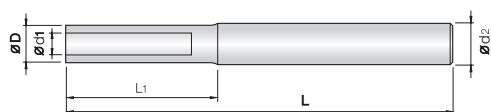


Bolt Order Number	Screw	Bolt Order Number	Screw
SC 100 581142	T10	SC 250 581146	T30
SC 120 581143	T20	SC 300 581147	T30
SC 160 581144	T20		
SC 200 581145	T25		

SFMA Carbide Shrink-fit Insert Modular Adopter

可换式刀头

New



- 硬质合金热缩刀杆
- 多种规格和有效长适合加工深沟、槽型工况。
- 使用热缩刀柄时具有较高的夹持力和同心度的保障。
- Adopter for shrink fit insert
- Deep cavity milling is available with a variety of effective lengths.
- Excellent holding power and concentricity keeping are available by shrink fitting holder.

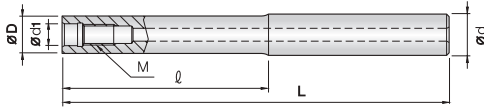
单位: mm

Order Number	Dimensions (mm)					Insert
	D	d1	d2	L1	L	
SFMA 100 028 108	9.8	6	10	28	108	4SF □ □ 100
SFMA 100 028 123	9.8	6	10	28	148	4SF □ □ 100
SFMA 100 048 163	9.8	6	10	48	188	4SF □ □ 100
SFMA 120 027 107	11.8	6	12	27	107	4SF □ □ 120
SFMA 120 027 122	11.8	6	12	27	147	4SF □ □ 120
SFMA 120 047 162	11.8	6	12	47	187	4SF □ □ 120
SFMA 160 033 143	15.8	16	10	33	143	4SF □ □ 160
SFMA 160 053 183	15.8	16	10	53	183	4SF □ □ 160
SFMA 200 039 139	19.8	20	12	39	139	4SF □ □ 200
SFMA 200 059 179	19.8	20	12	59	179	4SF □ □ 200
SFMA 200 079 229	19.8	20	12	79	229	4SF □ □ 200



Carbide Modular Adopter

硬质合金可换式刀杆



- 螺纹刀头专用刀杆
- 多种规格和有效长适合加工深沟、槽型工况。
- 便于装夹螺纹刀头。

• Adopter for the spiral modular head (MHE)

- Deep cavity milling is available with a variety of effective lengths.
- Convenient clamping with the modular head (MHE).

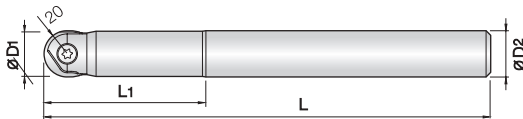
单位: mm

Order Number	Dimensions (mm)					
	M	D	d	d1	l	L
CMA100 240 114	M06	9.7	10	6.5	24	114
CMA120 240 129	M06	11	12	6.5	24	129
CMA160 300 130	M08	14.5	16	8.5	30	130
CMA160 300 160	M08	14.5	16	8.5	30	160
CMA160 300 200	M08	14.5	16	8.5	30	200
CMA160 300 250	M08	14.5	16	8.5	30	250
CMA200 500 170	M10	18.5	20	10.5	50	170
CMA200 500 220	M10	18.5	20	10.5	50	220
CMA200 500 270	M10	18.5	20	10.5	50	270
CMA250 650 265	M12	23	25	12.5	65	265
CMA250 650 315	M12	23	25	12.5	65	315
CMA300 800 260	M16	28	32	17	80	260
CMA300 800 360	M16	28	32	17	80	360



Carbide Indexable Cutter for Finishing

硬质合金抗震刀杆-精加工用



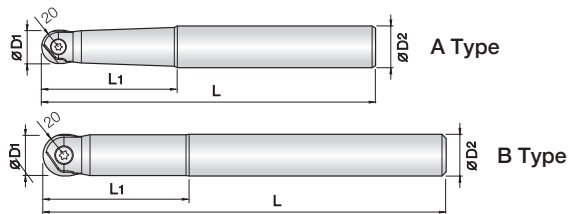
- 可装夹球头刀片和圆鼻刀片。
- 可达到整理硬质合金铣刀的强度，适用于高速、高精加工。
- 可修磨刀杆
- 比普通刀杆减少了震动，增强了稳定性。
- Can be used for both of ball and corner radius inserts.
- Suitable for high speed cutting and high precise cutting due to same toughness as solid tools.
- Available repairing tool holders at JJ TOOLS co., ltd when broken problem.
- Available stable machining due to minimized vibration on carbide holders.

单位: mm

Order Number	Dimensions (mm)				Insert	Parts	
	D1	D2	L1	L		Screw	Wrench
CICF100 350 150	10	10	35	150	2JJIN□ 100 / 2JJIN□ 110	SC 100 581142	T10
CICF120 450 160	12	12	45	160	2JJIN□ 120 / 2JJIN□ 130	SC 120 581143	T20
CICF160 600 200	16	16	60	200	2JJIN□ 160 / 2JJIN□ 170	SC 160 581144	T20
CICF160 600 230	16	16	60	230	2JJIN□ 160 / 2JJIN□ 170	SC 160 581144	T20
CICF200 700 220	20	20	70	220	2JJIN□ 200 / 2JJIN□ 210	SC 200 581145	T25
CICF250 800 250	25	25	80	250	2JJIN□ 250 / 2JJIN□ 260	SC 250 581146	T30
CICF250 800 300	25	25	80	300	2JJIN□ 250 / 2JJIN□ 260	SC 250 581146	T30



- 可装夹球头刀片和圆鼻刀片。
- 锥度有效设计将震动最小化。
- 多种规格，选择性多。
- Can be used for both of ball and corner radius inserts.
- Effective length design by taper type to minimize vibration (A-Type).
- Wide tool range option is available with a variety of overall lengths.



单位: mm

Order Number	Dimensions (mm)					Insert	Parts	
	D1	D2	L1	L	Type		Screw	Wrench
ICF100 250 100 S12	10	12	25	100	A	2JJIN □ 100 / 2JJIN □ 110	SC 100 581142	T10
ICF100 500 150 S16	10	16	50	150	A	2JJIN □ 100 / 2JJIN □ 110	SC 100 581142	T10
ICF120 300 110 S12	12	12	30	110	B	2JJIN □ 120 / 2JJIN □ 130	SC 120 581143	T20
ICF120 600 160 S16	12	16	60	160	A	2JJIN □ 120 / 2JJIN □ 130	SC 120 581143	T20
ICF160 500 130 S20	16	20	50	130	A	2JJIN □ 160 / 2JJIN □ 170	SC 160 581144	T20
ICF160 600 220 S16	16	16	60	220	B	2JJIN □ 160 / 2JJIN □ 170	SC 160 581144	T20
ICF160 650 160 S20	16	20	65	160	A	2JJIN □ 160 / 2JJIN □ 170	SC 160 581144	T20
ICF200 700 220 S20	20	20	70	220	B	2JJIN □ 200 / 2JJIN □ 210	SC 200 581145	T25
ICF200 700 250 S20	20	20	70	250	B	2JJIN □ 200 / 2JJIN □ 210	SC 200 581145	T25
ICF200 800 180 S25	20	25	80	180	A	2JJIN □ 200 / 2JJIN □ 210	SC 200 581145	T25
ICF250 700 220 S25	25	25	70	220	B	2JJIN □ 250 / 2JJIN □ 260	SC 250 581146	T30
ICF250 800 250 S25	25	25	80	250	B	2JJIN □ 250 / 2JJIN □ 260	SC 250 581146	T30
ICF250 800 300 S25	25	25	80	300	B	2JJIN □ 250 / 2JJIN □ 260	SC 250 581146	T30
ICF300 1000 250 S32	30	32	100	250	A	2JJIN □ 300	SC 300 581147	T30
ICF300 1000 300 S32	30	32	100	300	A	2JJIN □ 300	SC 300 581147	T30
ICF300 1000 350 S32	30	32	100	350	A	2JJIN □ 300	SC 300 581147	T30

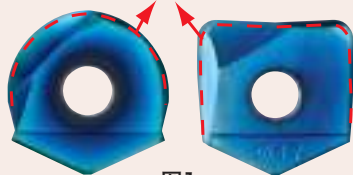
 修磨刃线
 Regrind processing line


图1



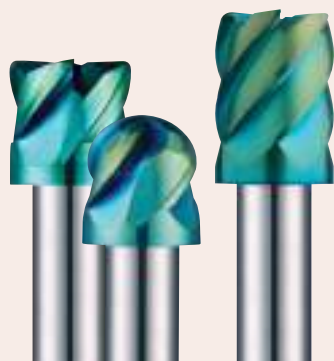
图2

刀片修磨注意事项 Note for regrinding insert

- 如图1，如果磨损或崩损超过图中轮廓线时，无法修磨。
- 修磨后刀尖部分会变小0.3~0.5mm 会产生干涉，加工时请留意。
- If the insert is damaged deeper than the regrind processing line, regrinding is not available.
- When the regrinding process, the height of the insert (H) will be shortened by 0.3mm to 0.5mm, so insert holder (figure 2) may cause interference your machining process. Please note for your work.
- 金刚石涂层的石墨加工刀片无法修磨。
- Regrinding DIA coated insert for graphite material is not available.

热缩可换式刀头修磨 Regrinding shrink-fit insert

- 可修磨2~3次超高性价比。
- 修磨后能达到正常性能。
- 2 to 3 times regrinding is available, so it is economical.
- Regrinding performs the same as new product quality.
- 金刚石涂层的石墨加工刀片无法修磨。
- Regrinding DIA coated insert for graphite material is not available.



2JJINB/2HHINB 加工条件表 Cutting Condition

加工材料 Material		高硬度钢 Hardened Steels 45~55HRc					高硬度钢 Hardened Steels 55~62HRc				
半径 Radius	加工模式 Process Type	n min ⁻¹	Vc m/mm	Vf mm/mim	ap mm	ae mm	n min ⁻¹	Vc m/mm	Vf mm/mim	ap mm	ae mm
5R, 5.5R	半径 General pupose	3180	100	640	0.25	1	2550	80	510	0.25	1
	高速加工 High-speed cutting	6690	210	2680	0.15	0.8	5410	170	2160	0.15	0.8
	精铣 Finishing	8280	260	3310	0.1	0.25	6370	200	2550	0.1	0.25
6R, 6.5R	半径 General pupose	2650	100	530	0.3	1.2	2120	80	420	0.3	1.2
	高速加工 High-speed cutting	5310	200	2120	0.2	0.9	4250	160	1700	0.2	0.9
	精铣 Finishing	7700	290	3080	0.1	0.3	6100	230	2440	0.1	0.3
8R, 8.5R	半径 General pupose	1990	100	480	0.8	1.6	1590	80	380	0.8	1.6
	高速加工 High-speed cutting	2990	150	1440	0.6	1.1	2390	120	1150	0.6	1.1
	精铣 Finishing	6970	350	4180	0.1	0.3	5570	280	3340	0.1	0.3
10R, 10.5R	半径 General pupose	1590	100	380	1	2	1270	80	300	1	2
	高速加工 High-speed cutting	2390	150	1150	0.7	1.5	1910	120	920	0.7	1.5
	精铣 Finishing	6370	400	5100	0.1	0.4	5100	320	4080	0.1	0.4
12.5R, 13R	半径 General pupose	1270	100	310	1.25	2.5	1020	80	240	1.25	2.5
	高速加工 High-speed cutting	1910	150	920	0.9	1.8	1530	120	730	0.9	1.8
	精铣 Finishing	5730	450	5730	0.1	0.5	4590	360	4590	0.1	0.5
15R	半径 General pupose	1060	100	250	1.6	3.2	850	80	200	1.6	3.2
	高速加工 High-speed cutting	1590	150	760	1.1	2.4	1270	120	610	1.1	2.4
	精铣 Finishing	5310	500	6370	0.1	0.6	4240	400	5090	0.1	0.6

2JJINC/2HHINC 加工条件表 Cutting Condition

加工材料 Material		高硬度钢 Hardened Steels 45~55HRc					高硬度钢 Hardened Steels 55~62HRc				
半径 Outside Diameter	加工模式 Process Type	n min ⁻¹	Vc m/mm	Vf mm/mim	ap mm	ae mm	n min ⁻¹	Vc m/mm	Vf mm/mim	ap mm	ae mm
10~11mm	半径 General pupose	3180	100	640	0.25	1	2550	80	510	0.25	1
	高速加工 High-speed cutting	8920	280	890	0.25	0.25	7000	220	700	0.25	0.25
	精铣 Finishing	8920	280	890	0.1	0.2	7000	220	700	0.1	0.2
12~13mm	半径 General pupose	2650	100	530	0.3	1.2	2120	80	420	0.3	1.2
	高速加工 High-speed cutting	7430	280	740	0.3	0.3	5840	220	580	0.3	0.3
	精铣 Finishing	7430	280	740	0.1	0.2	5840	220	580	0.1	0.2
16~17m m	半径 General pupose	1990	100	480	0.8	1.6	1590	80	380	0.8	1.6
	高速加工 High-speed cutting	5570	280	670	0.8	0.8	4380	220	530	0.8	0.8
	精铣 Finishing	5570	280	670	0.2	0.2	4380	220	530	0.2	0.2
10~11mm	半径 General pupose	1590	100	380	1	2	1270	80	300	1	2
	高速加工 High-speed cutting	4460	280	530	1	1	3500	220	420	1	1
	精铣 Finishing	4460	280	530	0.2	0.2	3500	220	420	0.2	0.2
25~26m m	半径 General pupose	1270	100	310	1.25	2.5	1020	80	240	1.25	2.5
	高速加工 High-speed cutting	3570	280	430	1.25	1.25	2800	220	340	1.25	1.25
	精铣 Finishing	3570	280	430	0.2	0.2	2800	220	340	0.2	0.2
30mm	半径 General pupose	1060	100	250	1.6	3.2	850	80	200	1.6	3.2
	高速加工 High-speed cutting	2970	280	360	1.6	1.6	2330	220	280	1.6	1.6
	精铣 Finishing	2970	280	360	0.2	0.2	2330	220	280	0.2	0.2

悬垂比率 Overhang	切削速度 Vc	移动速度 Feed
< 3D	100%	100%
3~5D	70%	70%
5~8D	60%	60%
8~10D	50%	50%

- 如果超长为3D或更大，请根据表格参数上进行调整。
- If the overlength is 3D or more, make adjustments according to the table at right.
- 为工件材料和加工形状条件使用合适的冷却液。
- 以上为参考数据，根据实际机器和工件条件调整参数。
- 请务必遵守安全说明和注意事项，以免产品破损造成伤害。
- Use the appropriate coolant for the work material and machining shape.
- These conditions are for general guidance; in actual machining conditions adjust the parameters according to your actual machine and work-piece conditions.
- Be sure to practice safety instructions and precautions such as wearing glasses and safety shoes, and placing safety covers when you use this tool. Because this tool can be broken during machining so failure to follow these instructions may cause personal injury.

4~12SFJC 加工条件表 Cutting Condition

加工材料 Material		高硬度钢 Hardened Steels 45~55HRc				高硬度钢 Hardened Steels 55~62HRc			
半径 Outside Diameter	加工模式 Process Type	n min ⁻¹	Vf mm/mim	ap mm	ae mm	n min ⁻¹	Vf mm/mim	ap mm	ae mm
10~11mm	半径 General pupose	3340	830	0.25	1	2680	660	0.25	1
	精铣 Finishing	9660	1150	0.1	0.2	7350	910	0.1	0.2
12~13mm	半径 General pupose	2780	670	0.3	1.2	2220	540	0.3	1.2
	精铣 Finishing	7800	960	0.1	0.2	6130	750	0.1	0.2
16~17m m	半径 General pupose	2090	620	0.8	1.6	1670	490	0.8	1.6
	精铣 Finishing	5850	870	0.2	0.2	4600	690	0.2	0.2
20~21mm	半径 General pupose	1670	490	1	2	1330	390	1	2
	精铣 Finishing	4680	690	0.2	0.2	3670	540	0.2	0.2

- 以上是4刃标准的参数，多刃时调整相应参数。
- 建议使用切削油。

Your specials are our standards.
您的非标品会是我们的标准品。

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