



TBB Cutting Tool

M3 Series

銑削系列

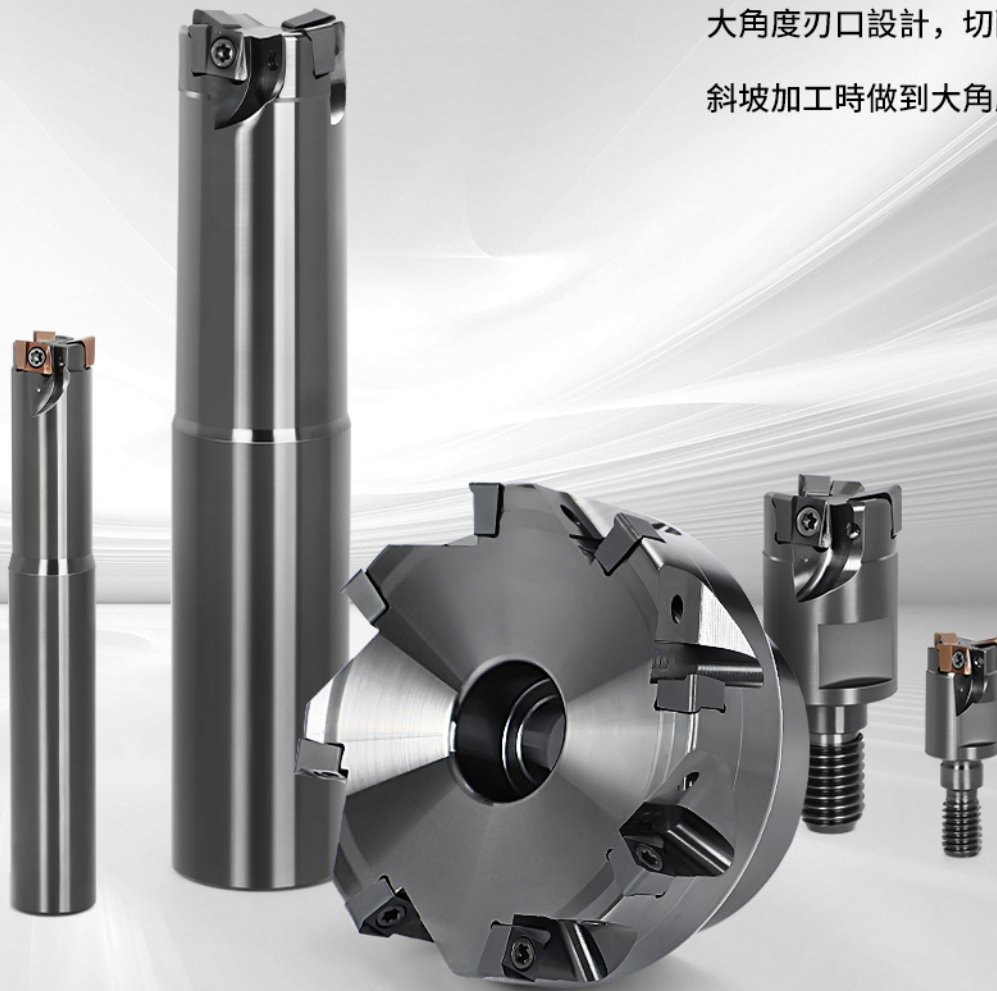
MILLING TOOLS SERIES

4NKT04 / 4NKT06
(4NKT)

真正90度的方肩加工效果

大角度刃口設計，切削阻力少

斜坡加工時做到大角度加工



團隊切削 行家優選

TEAMCUTTING EXPERT PREFERRED

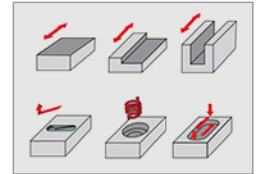
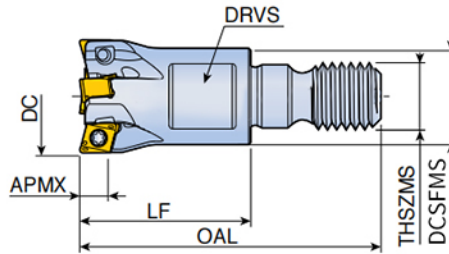
TM904N04 (4NKT)

4刃雙面刀片大切深清角鎖牙銑刀頭

High Ramping Modular Heads

4NKT04系列

4NKT04 Series



Designation 型號	CIC 齒數	Dimension (mm)/尺寸							THSZMS 螺紋規格	INSERT 刀片
		APMX	DCX	DC	DCSFMS	OAL	LF	DRVS		
TM904N04-108-M04	1	3.5	8	8	7.8	28	17	7	M4xP0.7	4NKT04...
TM904N04-109-M04	1	3.5	9	9	7.8	28	17	7	M4xP0.7	4NKT04...
TM904N04-210-M05	2	3.5	10	10	9	29	17	7	M5xP0.8	4NKT04...
TM904N04-211-M05	2	3.5	11	11	9	29	17	7	M5xP0.8	4NKT04...
TM904N04-312-M06	3	3.5	12	12	11	32	17	9	M6xP1.0	4NKT04...
TM904N04-313-M06	3	3.5	13	13	11	32	17	9	M6xP1.0	4NKT04...
TM904N04-314-M06	3	3.5	14	14	13	32	17	10	M6xP1.0	4NKT04...
TM904N04-315-M06	3	3.5	15	15	13	32	17	10	M6xP1.0	4NKT04...
TM904N04-314-M08	3	3.5	14	14	13	34.5	17	10	M8xP1.25	4NKT04... *
TM904N04-315-M08	3	3.5	15	15	13	34.5	17	10	M8xP1.25	4NKT04... *
TM904N04-416-M08	4	3.5	16	16	15	43	25	12	M8xP1.25	4NKT04...
TM904N04-417-M08	4	3.5	17	17	15	43	25	12	M8xP1.25	4NKT04...

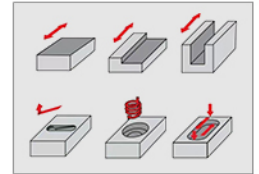
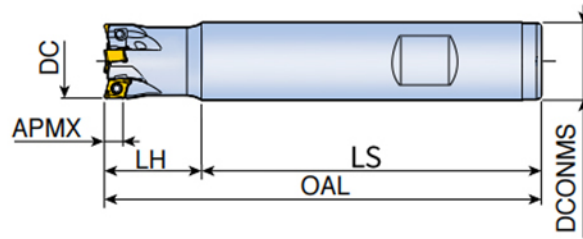
TE904N04 (4NKT)

4刃雙面刀片大切深清角銑刀桿

High Ramping End Mills

4NKT04系列

4NKT04 Series



Designation 型號	CICT 齒數	Dimension (mm)/尺寸							INSERT 刀片	
		APMX	DCX	DC	DCONMS	OAL	LH	LS		
TE904N04-107-10-80	1	3.5	7	7	10	80	15	65	4NKT04...	
TE904N04-107-10-100	-	-	-	-	-	-	-	-	-	**
TE904N04-107-10-120	-	-	-	-	-	-	-	-	-	**
TE904N04-108-10-80	1	3.5	8	8	10	80	17	63	4NKT04...	
TE904N04-108-10-100	-	-	-	-	-	-	-	-	-	**
TE904N04-108-10-120	-	-	-	-	-	-	-	-	-	**
TE904N04-109-10-80	1	3.5	9	9	10	80	19	61	4NKT04...	
TE904N04-109-10-100	-	-	-	-	-	-	-	-	-	**
TE904N04-109-10-120	-	-	-	-	-	-	-	-	-	**
TE904N04-210-10-80	2	3.5	10	10	10	80	22	58	4NKT04...	
TE904N04-210-10-100	-	-	-	-	-	-	-	-	-	**
TE904N04-210-10-120	-	-	-	-	-	-	-	-	-	**
TE904N04-211-10-80	2	3.5	11	11	10	80	11	69	4NKT04...	
TE904N04-211-10-100	-	-	-	-	-	-	-	-	-	**
TE904N04-211-10-120	-	-	-	-	-	-	-	-	-	**
TE904N04-312-12-80	3	3.5	12	12	12	80	26	54	4NKT04...	
TE904N04-312-12-100	-	-	-	-	-	-	-	-	-	**
TE904N04-312-12-120	-	-	-	-	-	-	-	-	-	**
TE904N04-313-12-80	3	3.5	13	13	12	80	13	67	4NKT04...	
TE904N04-313-12-100	-	-	-	-	-	-	-	-	-	**
TE904N04-313-12-120	-	-	-	-	-	-	-	-	-	**
TE904N04-314-14-100	3	3.5	14	14	14	100	30	70	4NKT04...	
TE904N04-314-14-120	-	-	-	-	-	-	-	-	-	**
TE904N04-314-14-160	-	-	-	-	-	-	-	-	-	**
TE904N04-315-14-100	3	3.5	15	15	14	100	15	85	4NKT04...	
TE904N04-315-14-120	-	-	-	-	-	-	-	-	-	**
TE904N04-315-14-160	-	-	-	-	-	-	-	-	-	**
TE904N04-416-16-120	4	3.5	16	16	16	120	35	85	4NKT04...	
TE904N04-416-16-160	-	-	-	-	-	-	-	-	-	**
TE904N04-416-16-200	-	-	-	-	-	-	-	-	-	**
TE904N04-417-16-120	4	3.5	17	17	16	120	17	103	4NKT04...	
TE904N04-417-16-160	-	-	-	-	-	-	-	-	-	**
TE904N04-417-16-200	-	-	-	-	-	-	-	-	-	**

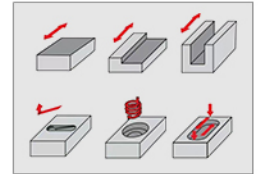
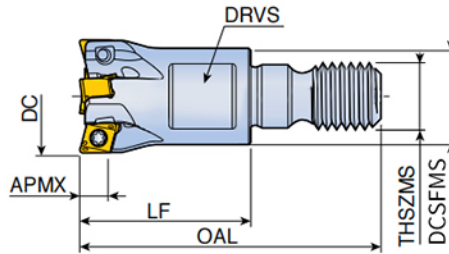
TM904N06 (4NKT)

4刃雙面刀片大切深清角鎖牙銑刀頭

High Ramping Modular Heads

4NKT06系列

4NKT06 Series



Designation 型號	CIC 齒數	Dimension (mm)/尺寸							THSZMS 螺紋規格	INSERT 刀片
		APMX	DCX	DC	DCSFMS	OAL	LF	DRVS		
TM904N06-216-M08	2	6	16	16	15	43	25.5	12	M8xP1.25	4NKT06...
TM904N06-217-M08	2	6	17	17	15	43	25.5	12	M8xP1.25	4NKT06...
TM904N06-320-M10	3	6	20	20	19	49	29	15	M10xP1.5	4NKT06...
TM904N06-321-M10	3	6	21	21	19	49	29	15	M10xP1.5	4NKT06...
TM904N06-425-M12	4	6	25	25	24	57	35	19	M12xP1.75	4NKT06...
TM904N06-426-M12	4	6	26	26	24	57	35	19	M12xP1.75	4NKT06...
TM904N06-532-M16	5	6	32	32	31	63	38	24	M16xP2.0	4NKT06...
TM904N06-533-M16	5	6	33	33	31	63	37	24	M16xP2.0	4NKT06...

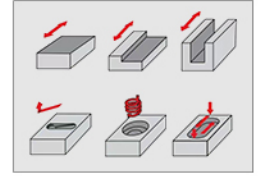
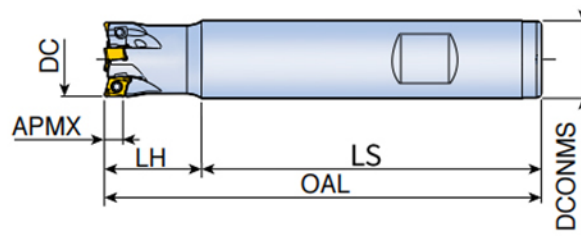
TE904N06 (4NKT)

4刃雙面刀片大切深清角銑刀桿

High Ramping End Mills

4NKT06系列

4NKT06 Series



Designation 型號	CICT 齒數	Dimension (mm)/尺寸							INSERT 刀片	
		APMX	DCX	DC	DCONMS	OAL	LH	LS		
TE904N06-110-10-80	-	-	-	-	-	-	-	-	-	**
TE904N06-111-10-80	-	-	-	-	-	-	-	-	-	**
TE904N06-112-12-100	-	-	-	-	-	-	-	-	-	**
TE904N06-113-12-100	-	-	-	-	-	-	-	-	-	**
TE904N06-114-14-120	-	-	-	-	-	-	-	-	-	**
TE904N06-215-14-120	-	-	-	-	-	-	-	-	-	**
TE904N06-215.6-16-150	-	-	-	-	-	-	-	-	-	**
TE904N06-216-16-120	2	6	16	16	16	120	35	85	4NKT06...	
TE904N06-216-16-160	2	6	16	16	16	160	35	125	4NKT06...	
TE904N06-217-16-160	2	6	17	17	16	160	17	143	4NKT06...	
TE904N06-217-16-200	2	6	17	17	16	200	17	183	4NKT06...	
TE904N06-218-16-160	-	-	-	-	-	-	-	-	-	**
TE904N06-320-19-120	-	-	-	-	-	-	-	-	-	**
TE904N06-320-19-160	-	-	-	-	-	-	-	-	-	**
TE904N06-320-20-120	3	6	20	20	20	120	44	79	4NKT06...	
TE904N06-320-20-160	3	6	20	20	20	160	44	116	4NKT06...	
TE904N06-321-20-160	3	6	21	21	20	160	21	139	4NKT06...	
TE904N06-321-20-200	3	6	21	21	20	200	21	179	4NKT06...	
TE904N06-322-20-160	-	-	-	-	-	-	-	-	-	**
TE904N06-323-20-160	-	-	-	-	-	-	-	-	-	**
TE904N06-324-20-160	-	-	-	-	-	-	-	-	-	**
TE904N06-425-24-160	-	-	-	-	-	-	-	-	-	**
TE904N06-425-25-120	4	6	25	25	25	120	55	65	4NKT06...	
TE904N06-425-25-160	4	6	25	25	25	160	55	105	4NKT06...	
TE904N06-425-25-200	4	6	25	25	25	200	55	145	4NKT06...	
TE904N06-426-25-160	4	6	26	26	25	160	26	134	4NKT06...	
TE904N06-426-25-200	4	6	26	26	25	200	26	174	4NKT06...	
TE904N06-427-25-160	-	-	-	-	-	-	-	-	-	**
TE904N06-428-25-160	-	-	-	-	-	-	-	-	-	**
TE904N06-430-25-160	-	-	-	-	-	-	-	-	-	**
TE904N06-532-32-160	5	6	32	32	32	160	70	90	4NKT06...	
TE904N06-532-32-200	5	6	32	32	32	200	70	130	4NKT06...	
TE904N06-533-32-160	5	6	33	33	32	160	33	127	4NKT06...	
TE904N06-533-32-200	5	6	33	33	32	200	33	167	4NKT06...	

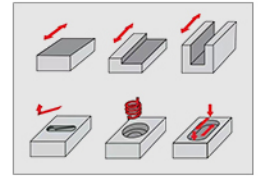
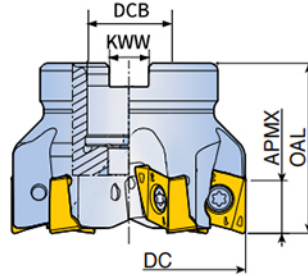
TF904N06 (4NKT)

4刃雙面刀片大切深清角銑刀盤

High Ramping Face Mills

4NKT06系列

4NKT06 Series



Designation 型號	CICT 齒數	Dimension (mm)/尺寸							INSERT 刀片
		APMX	DCX	DC	DCB	OAL	KWW	Type	
TF904N06-535-16	5	6	35	35	16	40	8.4	A	4NKT06...
TF904N06-640-16	6	6	40	40	16	40	8.4	A	4NKT06...
TF904N06-650-22	6	6	50	50	22	40	10.4	A	4NKT06...
TF904N06-863-22	8	6	63	63	22	40	10.4	A	4NKT06...
TF904N06-1080-27	10	6	80	80	27	50	12.4	A	4NKT06...
TF904N06-12100-32	-	-	-	-	-	-	-	-	-

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4NKT040204 (4NKT)

4刃雙面清角銑刀片

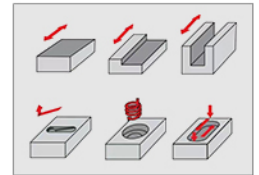
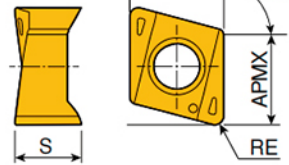
High Ramping Mill Inserts

4NKT04系列

4NKT04 Series



P 鋼
M 不鏽鋼
S 鈦、鎳



Designation 型號	Dimension (mm)/尺寸							Grade 材質	Use 用途
	IC/大小	S/厚度	RE/圓角	APMX/最大切深	Angle/角度	Screw/螺絲	Wrench/扳手		
4NKT040204R-M	4.0	3.1	0.4	3.5	90°	TSA-18040-1	TWA-T6	TC3320 TC5520	P M S

4NKT060308 (4NKT)

4刃雙面清角銑刀片

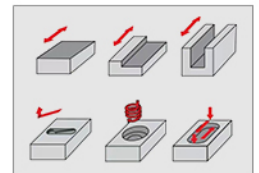
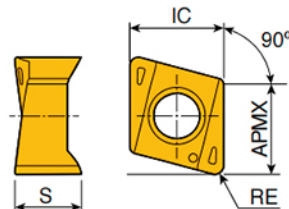
High Ramping Mill Inserts

4NKT06系列

4NKT06 Series



P 鋼
M 不鏽鋼
S 鈦、鎳



Designation 型號	Dimension (mm)/尺寸							Grade 材質	Use 用途
	IC/大小	S/厚度	RE/圓角	APMX/最大切深	Angle/角度	Screw/螺絲	Wrench/扳手		
4NKT060308R-M	6.6	4.67	0.8	6	90°	TSA-30070-1	TWA-T8	TC3320 TC5520	P M S

刀盤相關資訊請參照第M3-05頁

鎖牙銑刀頭、銑刀桿相關資訊請參照第M3-01, M3-02, M3-03, M3-04頁

4NKT040204/4NKT060308 (4NKT)

4刃雙面清角銑刀片

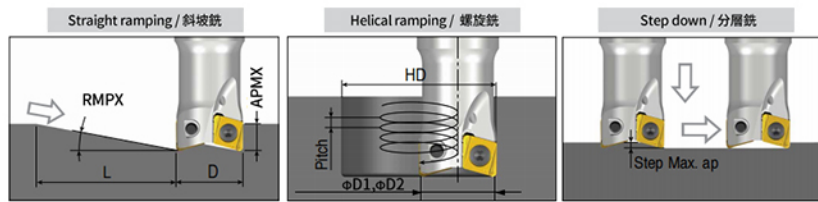
High Ramping Mill Inserts

4NKT04/06系列

4NKT04/06 Series

切削參數 / Cutting Conditions

ISO	Material/工件材料	Hardness/硬度	Vc (m/min)/切削速度	fz (mm/t)/每齒進給量
P	碳鋼 S45C, S55C ... C45, C55 ...	-300HB	120-250	0.07-0.15
	合金鋼 SCM440, SCr415 ... 42CrMo4 ...	-300HB	100-220	0.07-0.15
	預硬化鋼 NAK80, PX5 ...	30-40HRC	80-180	0.07-0.15
M	不銹鋼 SUS304, SUS316 ... X5CrNi18-9 X5CrNiMo17-12-2 ...	-200HB	100-250	0.07-0.15
K	灰鑄鐵 FC250, FC300 ... 250, 300 ...	150-250HB	120-300	0.07-0.15
	球墨鑄鐵 FCD400 ... 400-15, 600-3 ...	150-250HB	100-200	0.07-0.15
S	鈦合金 Ti-6Al-4V ...	-40HRC	40-80	0.05-0.1
	耐熱合金 Inconel, Hastelloy...	-40HRC	30-70	0.05-0.1
H	淬火鋼	SKD61 ... X40CrMoV5-1 ...	40-50HRC	40-80
		SKD11 ... X153CrMoV12...	50-60HRC	30-60



● 4NKT040204

型號	DCX	APMX	RMPX	Step Max.ap	D1(HD)	D2(HD)	MAX Pich/rev
		最大切深	最大斜坡銑角度	最大分層銑深度	最小加工孔徑	最大加工孔徑	最大軸向切深
TE904N04-107-10...	7	3.5	3.5°	0.4	7.9	14	0.2/2.5
TE904N04-108-10...	8	3.5	3.7°	0.4	9.9	16	0.3/2.8
TE904N04-109-10...	9	3.5	3.9°	0.4	11.9	18	0.5/2.0
TE904N04-210-10...	10	3.5	4.2°	0.5	13.9	20	0.8/2.0
TE904N04-211-10...	11	3.5	4.8°	0.6	15.9	22	1.1/2.5
TE904N04-312-12...	12	3.5	4.5°	0.7	17.9	24	1.2/2.5
TE904N04-313-12...	13	3.5	4.7°	0.8	19.9	26	1.5/2.9
TE904N04-314-14...	14	3.5	4.5°	0.9	21.9	28	1.6/3.0
TE904N04-415-14...	15	3.5	4.3°	0.9	23.9	30	1.8/3.1
TE904N04-416-16...	16	3.5	4.1°	0.9	25.9	32	1.9/3.1
TE904N04-417-16...	17	3.5	3.9°	0.9	27.9	34	1.8/3.0

● 4NKT060308

型號	DCX	APMX	RMPX	Step Max.ap	D1(HD)	D2(HD)	MAX Pich/rev
		最大切深	最大斜坡銑角度	最大分層銑深度	最小加工孔徑	最大加工孔徑	最大軸向切深
TE904N06-216-16...	16	6	3.5°	0.7	21.5	32.0	0.8/2.5
TE904N06-218-16...	18	6	4.0°	0.9	25.5	36.0	1.3/3.2
TE904N06-320-20...	20	6	4.2°	1.0	29.5	40.0	1.8/3.7
TE904N06-425-25...	25	6	4.9°	1.5	39.5	50.0	3.1/5.4
TE904N06-532-32...	32	6	3.5°	1.5	53.5	64.0	3.3/4.9
TF904N06-640...	40	6	2.6°	1.5	69.5	80.0	3.4/4.6
TF904N06-650...	50	6	2.0°	1.5	89.5	100.0	3.5/4.4
TF904N06-863...	63	6	1.5°	1.5	115.5	126.0	3.5/4.1
TF904N06-1080...	80	6	1.0°	1.5	149.5	160.0	3.0/3.5

產品的特點: 1. 斜坡加工時可以做大角度加工。2. 大角度刃口設計, 切削阻力減少, 加工輕快
3. 真正90度的方肩加工效果, 也適用於多場景加工