

- 正前角(多刀尖→单刀尖)



T-CBN的刀尖数

库存状态显示

关联事项的参考页

* 非10片/盒的型号另行记载。

指南篇

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3 超高压烧结体刀具 T-CBN / T-DIA

产品篇

■ T-CBN

| | | |
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■ T-DIA

| | | |
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T-CBN(CBN烧结体)TAC刀片的表示方法

超高压烧结体刀具

■多刀尖型

2 QP - CNGA120404 -L

| ① 切削刃数目代号 | |
|-----------|-----------|
| 2 | 单面 多刀尖 |
| 3 | |
| 4 | |
| 6 | 两面 多刀尖 |

| ② 型号代号 | |
|--------|----------------|
| QP | T-CBN TAC刀片 |

③ ISO代号

| ④ 补充代号 | |
|--------|--------|
| 无 | 标准钝化 |
| -L | 重视耐磨性 |
| -H | 重视抗崩刃性 |
| W | 有修光刃 |
| W□ | 有修光刃 |
| F | 锋利刃 |
| -HF | 有断屑槽 |
| -HM | 有断屑槽 |

■多刀尖型(10片/盒)

T 2 QP - CNGA120408

① 型号名称前面的T代表10片/盒。

■一般切削用

TNGA160402 - QBN

① ISO代号

② T-CBN刀片

■切槽加工用

XG R 63 10 S - QBN

① 切槽用GX型刀体

| ② 方向 | |
|------|------|
| L | 左方向用 |
| R | 右方向用 |

| ③ 槽宽 | |
|------|--------------|
| 10 | 10 → 1.0 mm |
| 15 | 15 → 1.5 mm等 |

④ 刀尖半径(r_e) = 0.2

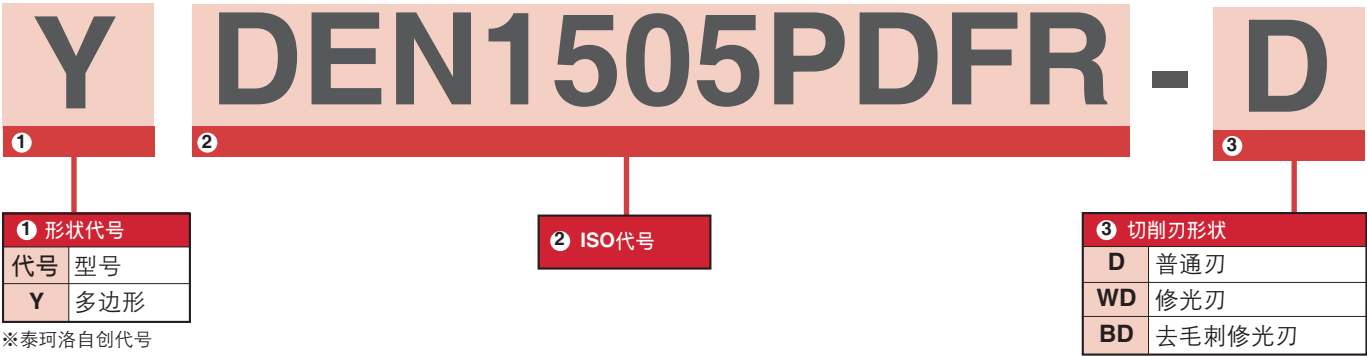
⑤ T-CBN刀片

T-DIA(金刚石烧结体)TAC刀片的表示方法

车削用TAC刀片



铣削用TAC刀片



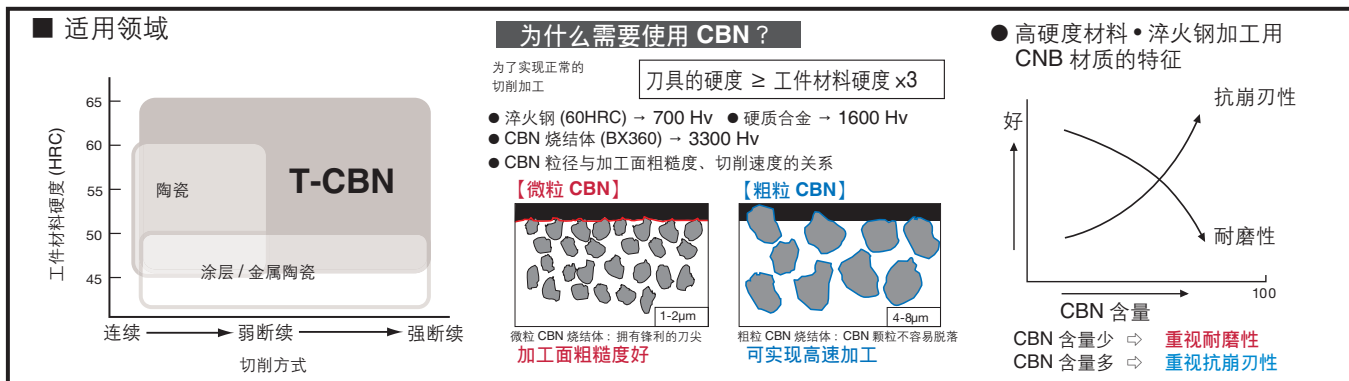
3
超高压烧结体刀具

CBN 烧结体刀具 T-CBN 系列

H 高硬度材料・淬火钢加工用 T-CBN 系列

超高压烧结体刀具

3



■ 高硬度材料・淬火钢加工用 T-CBN 的基本选择

● 涂层 T-CBN

BXM10 高速加工用

BXM20 通用材质

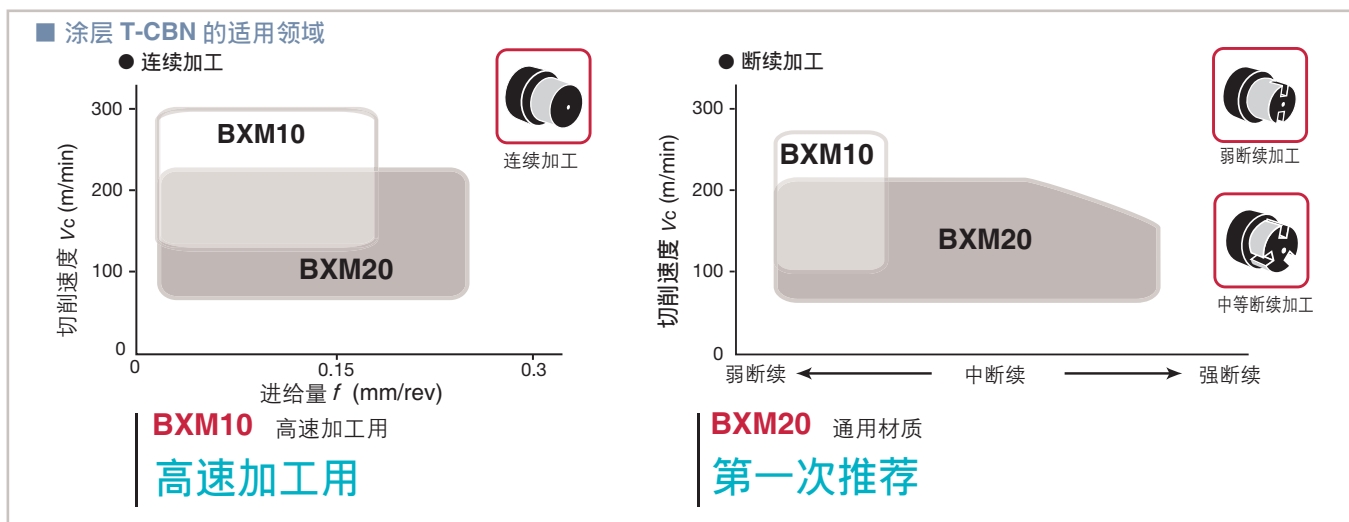
● 无涂层 T-CBN

BX310 高速领域 / 重视连续加工中的耐磨性的材质

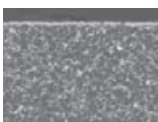
BX330 中速领域 / 重视加工面品质的材质

BX360 低 ~ 中速领域 / 抗崩刃性优秀的通用材质

BX380 低 ~ 中速领域 / 重视强断续加工中的抗崩刃性的材质



■ 涂层 T-CBN 的效果



在坚硬的 CBN 上施加涂层

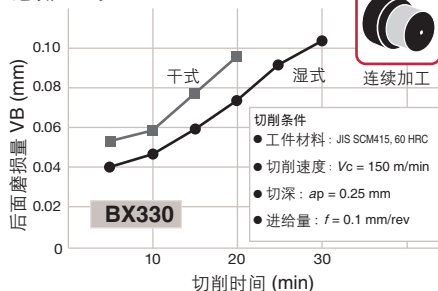
硬度 CBN > 涂层

- 防止 CBN 的氧化磨损
涂层可以隔绝空气, 抑制 CBN 的氧化磨损
- 防止涂层膜的剥落
CBN 坚硬而难以发生变形, 是良好的涂层基材

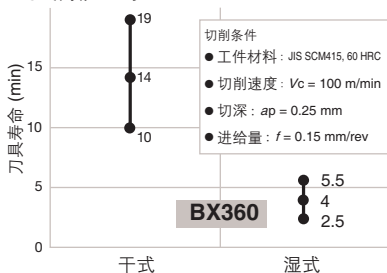
大幅改善后刀面磨损

■ 高硬度材料・淬火钢加工与切削液的关系

● 连续加工时



● 断续加工时



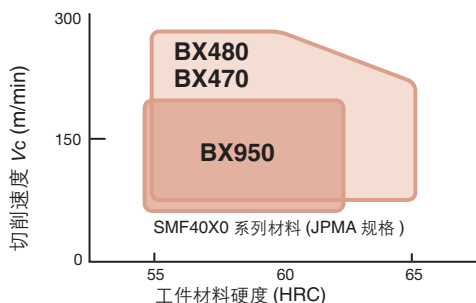
● 连续加工时使用湿式加工刀具寿命更长 (磨损寿命)

● 强断续加工时使用干式加工刀具寿命更长 (崩刃寿命)

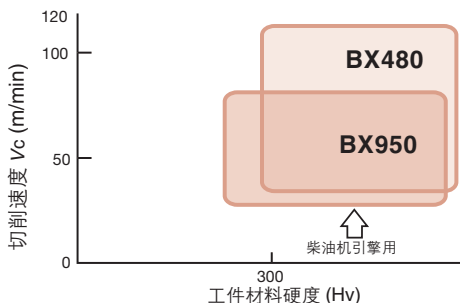
S 烧结金属加工用 T-CBN 系列

■ 适用领域

● 铁系烧结金属



● 阀座



BX470

减少毛刺 • 重视加工面

BX480

通用性 • 重视耐磨性

BX950

面向一般烧结金属零件

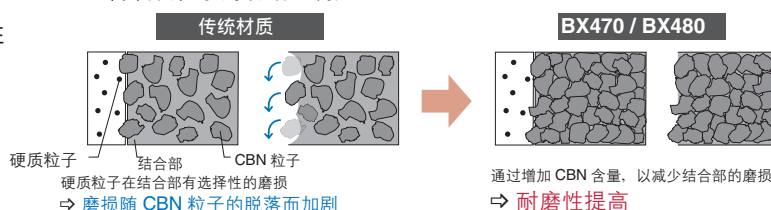


BX470/480是JCTMA2008-008
ECO-PRODUCT超硬刀具协会
(JCTMA)环保认证产品。

BX470

BX480 的特征

● 含硬质粒子的烧结金属加工



● BX470 / BX480 的材质特征

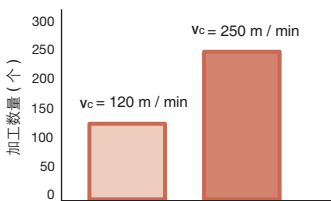
CBN 含量: 95vol%

Hv = 4100 ~ 4300

在一般市售材料中
CBN 含量世界第 1

*截止到 2010 年 7 月

■ BX480 (齿轮端面加工)



切削条件

旧产品 BX480

● 工件材料: 烧结金属 (HRA60 以上)

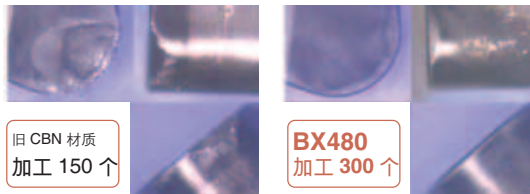
● 刀片: DCMW11T308

● 切深: $a_p = 0.2 \sim 0.5 \text{ mm}$

● 进给量: $f = 0.07 \text{ mm/rev}$ ● 水溶性切削液

● 断续加工

■ BX470 / BX480 烧结金属切削后的损伤状态



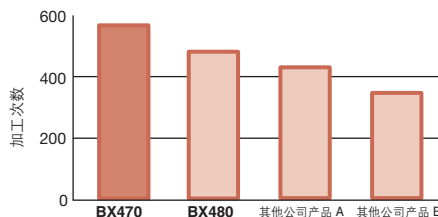
切削条件

● 工件材料: 烧结金属 (HRA60 以上) 含硬质粒子、氮化处理品

● 切削速度: $V_c = 110 \text{ m/min}$ ● 切深: $a_p = 0.15 \text{ mm}$

● 进给量: $f = 0.1 \text{ mm/rev}$ ● 水溶性切削液 ● 断续加工

■ BX470 以毛刺为寿命基准的切削



切削条件

● 工件材料: 铁系烧结金属

● 切削速度: $V_c = 100 \text{ m/min}$

● 切深: $a_p = 0.15 \sim 0.3 \text{ mm}$

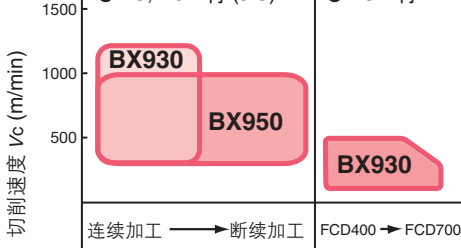
● 进给量: $f = 0.07 \sim 0.25 \text{ mm/rev}$ ● 干式

● 断续加工

K 铸铁 • 球墨铸铁加工用 T-CBN 系列

■ 适用领域

● FC, FCA 材 (JIS)



● FCD 材

BX930

通用性优先的第一推荐材质
球墨铸铁加工专用材质

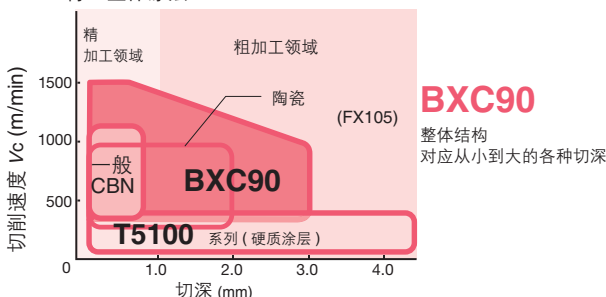
BX950

断续加工用途
重视抗崩刃性的材质

BX910

汽缸加工专用材质

● FC 材 整体涂层 T-CBN

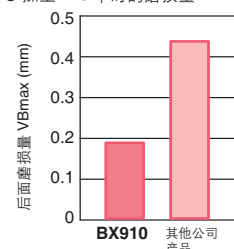


BXC90

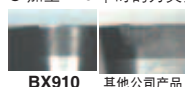
整体结构
对应从小到大的各种切深

■ 汽缸加工 使用 BX910 进行加工的实例

● 加工 120 个时的磨损量



● 加工 120 个时的刀尖损伤



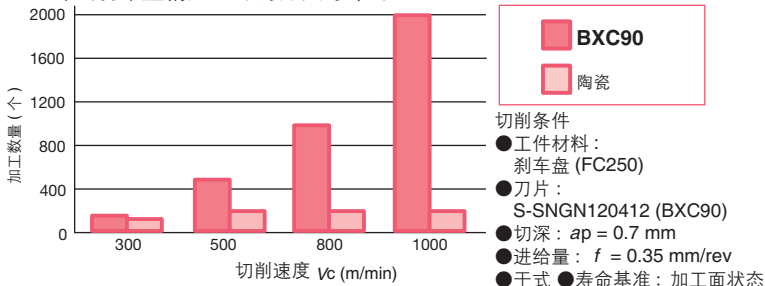
切削条件

● 工件材料: 汽缸 FC200 (离心铸造) 精镗加工

● 切削速度: $V_c = 1,000 \text{ m/min}$

● 加工机床: 专用机床 ● 水溶性切削液

■ 碟式刹车盘精加工时的刀具寿命对比



钝化规格

●钝化形状的变更为特殊对应形式，请参照下列规格。

钝化代号的表示方法

例)
钝化宽度 0.15 mm
钝化角度 -30°
带 R 钝化



形状

T...仅角度钝化
S...角度+R钝化
E...仅R钝化
F...锋利刃

钝化宽度(W) 钝化角度(α)

代号

| W | 钝化宽度 |
|-----|---------|
| 005 | 0.05 mm |
| 010 | 0.10 mm |
| 013 | 0.13 mm |
| 015 | 0.15 mm |
| 020 | 0.20 mm |

| α | 钝化角度 |
|----------|------|
| 10° | -10° |
| 15° | -15° |
| 20° | -20° |
| 25° | -25° |
| 30° | -30° |
| 35° | -35° |
| 40° | -40° |

钝化宽度 W

前面

R 钝化

后面

钝化角度 α

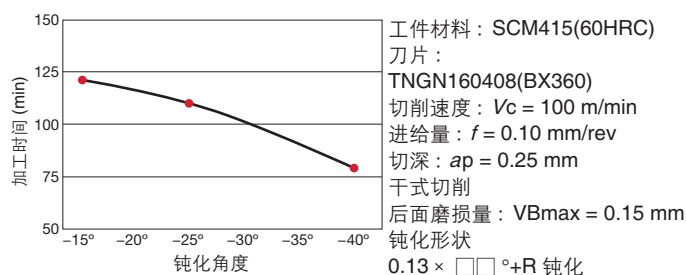
●可以通过上述条件的组合来选择刀尖规格。

●也可只设定R钝化。

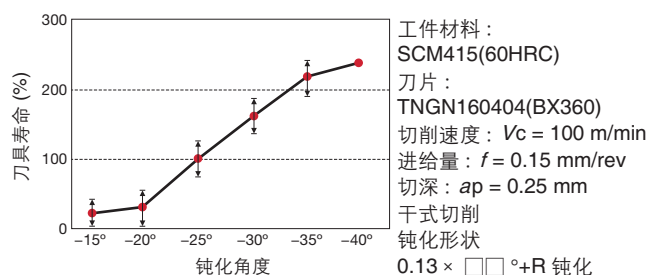
※与部分材质的组合可能出现无法对应的问题，
请向本公司营业担当人员咨询。

高硬度材料・淬火钢加工用途钝化设定
标准钝化：0.13 × 25° + R钝化
L钝化：0.13 × 15° + R钝化
H钝化：0.13 × 35° + R钝化

连续切削时的钝化角度和刀具寿命的关系



断续切削时的钝化角度和刀具寿命的关系



连续加工时较小的钝化角度可以降低磨损。

断续加工时较大的钝化角度可以减少崩刃情况的发生。

修光刃规格的T-CBN刀片

●在刀尖半径和切削刃直线部的切线部设定精切刃（修光刃）

修光刃的效果

●加工效率倍增 → 缩短加工时间

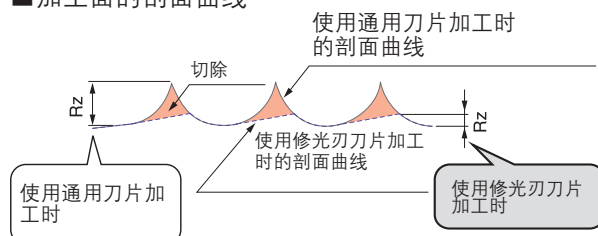
进给量倍增*，且不降低加工面粗糙度。
*f = 0.3 mm/rev 以内

●良好的加工面粗糙度

→ 通过半精加工 - 精加工的集约化以提高效率

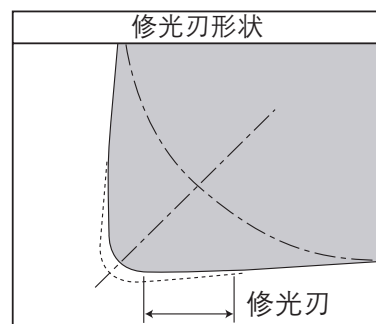
与圆弧切削刃的刀片相比，使用修光刃可以获得更佳加工面粗糙度。

加工面的剖面曲线






修光刃加工推荐刀体

| | 2QP-CNGA1204**WL | 3QP-WNGA080408WL | 2QP-DNGA1504**WJ | 3QP-TNGA1604**WG |
|---------|---------------------|---------------------|---------------------|---------------------|
| 主偏角 | 95° | | 93° | 91° |
| 外圆用推荐刀体 | ACLNR/L****12-A | AWLNR/L****08-A | ADJNR/L****15-A | ATGNR/L****16-A |
| | DCLNR/L****12 | DWLNR/L****08 | DDJNR/L****15 | DTFNR/L****16 |
| 内孔用推荐刀体 | A***-ACLNR/L12-D*** | A***-AWLNR/L08-D*** | A***-ADUNR/L15-D*** | A***-ATFNR/L16-D*** |



T-CBN 系列

负前角刀片·多刀尖型

| 规格 | 外观 | 型号 | 库存材质 | | | | | | | | | | 刀尖数 | 尺寸(mm) | | | | | 适用刀体 | |
|----------------|---|------------------|------------------|------------------|-------|-------|-------|-------|-------|-------|-------|-------|------|--------|-----------|---------|-----------|------------------|----------------------------|--------------------------|
| | | | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX930 | | BX950 | 内切圆 ød | 厚度 s | 孔径 ød1 | 刀尖圆弧 半径 rε | | CBN长度 a |
| 锋利刃 |  | 2QP-CNGA120402F | | | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.2 | 2.3 | 外圆用 TAC车刀 (4-14 ~) | |
| | | 2QP-CNGA120404F | | | | | | | | ● | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | | |
| | | 2QP-CNGA120408F | | | | | | | | ● | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| | | 2QP-CNGA120412F | | | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 通用 | | 2QP-CNGA120402 | | | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.2 | 2.3 | 内孔用 TAC车刀 (5-33 ~) | |
| | | 2QP-CNGA120404 | ● | ● | | ● | ● | ● | ● | ● | ● | ● | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | | |
| | | 2QP-CNGA120408 | ● | ● | | ● | ● | ● | ● | ● | ● | ● | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| | | 2QP-CNGA120412 | | ● | | ● | ● | ● | ● | ● | ● | ● | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 重视耐磨性 | | 2QP-CNGA120404-L | | ● | | | ● | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | 自动化切削工 具系统 (12-47 ~) | |
| | | 2QP-CNGA120408-L | | ● | | | ● | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| | | 2QP-CNGA120412-L | | ● | | | ● | | | | | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 重视抗崩刃性 | | 2QP-CNGA120404-H | | ● | | | | ● | ● | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | | |
| | | 2QP-CNGA120408-H | | ● | | | | ● | ● | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| | | 2QP-CNGA120412-H | | ● | | | | ● | ● | | | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 修光刃规格 | | 2QP-CNGA120404WL | ● | ● | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | | |
| | | 2QP-CNGA120408WL | ● | ● | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| | | 2QP-CNGA120412WL | | ● | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 修光刃规格 | | 2QP-CNMA120404W | | | | | ● | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | | |
| | | 2QP-CNMA120408W | | | | | ● | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| | | 2QP-CNMA120412W | | | | | ● | | | | | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 通用 | | T2QP-CNGA120404 | | | | | | ● | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | | |
| | | T2QP-CNGA120408 | | | | | | ● | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| 通用 |  | 4QP-CNGA120404 | | | ● | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | | |
| | | 4QP-CNGA120408 | | | ● | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| | | 4QP-CNGA120412 | | | ● | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| | | 4QP-CNGA120404-H | | | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | | |
| | | 4QP-CNGA120408-H | | | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| | | 4QP-CNGA120412-H | | | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| | | 4QP-CNMA120404W | | | ● | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | | |
| | | 4QP-CNMA120408W | | | ● | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| | | 4QP-CNMA120412W | | | ● | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 锋利刃 |  | 2QP-DNGA150402F | | | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.2 | 2.7 | 外圆用 TAC车刀 (4-21 ~) | |
| | | 2QP-DNGA150404F | | | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.5 | | |
| | | 2QP-DNGA150408F | | | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.1 | | |
| | | 2QP-DNGA150412F | | | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2 | | |
| | | 通用 | 2QP-DNGA150404 | ● | ● | | ● | ● | ● | ● | ● | ● | ● | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.5 | 内孔用 TAC车刀 (5-34 ~) |
| | | | 2QP-DNGA150408 | ● | ● | | ● | ● | ● | ● | ● | ● | ● | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.1 | |
| | | | 2QP-DNGA150412 | ● | ● | | ● | ● | ● | | ● | ● | ● | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2 | |
| | | | 2QP-DNGA150404-L | | ● | | | ● | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.5 | |
| | | 重视耐磨性 | 2QP-DNGA150408-L | | ● | | | ● | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.1 | |
| | | | 2QP-DNGA150412-L | | ● | | | ● | | | | | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2 | |
| | | | 重视抗崩刃性 | 2QP-DNGA150404-H | | ● | | | | ● | ● | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.5 |
| | | 2QP-DNGA150408-H | | | ● | | | | ● | ● | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.1 | |
| | | 2QP-DNGA150412-H | | | ● | | | | ● | ● | | | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2 | |
| | | 修光刃规格 | 2QP-DNGA150404WJ | ● | ● | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.3 | |
| | | | 2QP-DNGA150408WJ | ● | ● | | | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.1 | |
| | | 通用 | 2QP-DNGA150604 | ● | ● | | | | | | | | | 2 | 12.7 | 6.35 | 5.16 | 0.4 | 2.5 | |
| 2QP-DNGA150608 | ● | | ● | | | | | | | | | 2 | 12.7 | 6.35 | 5.16 | 0.8 | 2.1 | | | |
| 2QP-DNGA150612 | ● | | ● | | | | | | | | | 2 | 12.7 | 6.35 | 5.16 | 1.2 | 2 | | | |

※T开头的型号表示10片 / 盒。
型号名末尾带W、WL、WJ的推荐刀体请参考 [3-6](#)

产品库存 ● : 库存型号

标准钝化规格

[3-6](#)

| 材质 | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX910 | BX930 | BX950 |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 负前角刀片 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | T01315 | S01325 | S01315 | S01315 | S01325 |
| 正前角刀片 | S01325 | S01325 | — | S00515 | S00515 | S00515 | — | T01315 | — | S01315 | S00515 | S00515 |

















材 质
(1-1)

相关事项指南

外圆用车刀
(4-1)

内孔用车刀
(5-1)

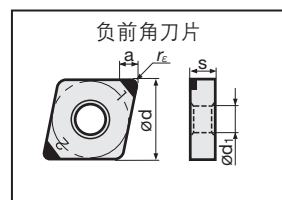
负前角刀片·多刀尖型

| 规格 | 外观 | 型 号 | 库存材质 | | | | | | | | | | | | 刀尖数 | 尺 寸(mm) | | | | | 适用 刀体 |
|------------|---|------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-----------|---------|-----------|--------------------------|--------------------------|----------|
| | | | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX910 | BX930 | BX950 | | 内切圆 ød | 厚度 s | 孔径 ød1 | 刀尖圆弧 半径 rε | CBN长度 a | |
| 通用 |  | 4QP-DNGA150404 | | | ● | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.4 | 2.5 | 外圆用 TAC车刀 (4-21 ~) | |
| | | 4QP-DNGA150408 | | | ● | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.8 | 2.1 | | |
| | | 4QP-DNGA150412 | | | ● | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 1.2 | 2 | | |
| 重视抗崩 刃性 |  | 4QP-DNGA150404-H | | | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.4 | 2.5 | 内孔用 TAC车刀 (5-34 ~) | | |
| | | 4QP-DNGA150408-H | | | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.8 | 2.1 | | | |
| | | 4QP-DNGA150412-H | | | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 1.2 | 2 | | | |
| 通用 |  | 2QP-SNGA120404 | | ● | | ● | ● | ● | ● | | ● | | ● | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.4 | 外圆用 TAC车刀 (4-25 ~) | |
| | | 2QP-SNGA120408 | | ● | | ● | ● | ● | ● | | ● | ● | ● | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.4 | | |
| | | 2QP-SNGA120412 | | ● | | ● | ● | ● | ● | | ● | ● | ● | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 重视耐磨 性 |  | 2QP-SNGA120404-L | | | | | ● | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.4 | 内孔用 TAC车刀 (5-35 ~) | |
| | | 2QP-SNGA120408-L | | ● | | | ● | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.4 | | |
| | | 2QP-SNGA120412-L | | ● | | | ● | | | | | | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 重视抗崩 刃性 |  | 2QP-SNGA120404-H | | | | | | ● | ● | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.4 | 2.4 | 切削方式 系统 (12-72 ~) | |
| | | 2QP-SNGA120408-H | | ● | | | | ● | ● | | | | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.4 | | |
| | | 2QP-SNGA120412-H | | ● | | | | ● | ● | | | | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 通用 |  | 4QP-SNGA120404 | | | ● | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.4 | 2.4 | | |
| | | 4QP-SNGA120408 | | | ● | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.8 | 2.4 | | |
| | | 4QP-SNGA120412 | | | ● | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | |
| 重视抗崩 刃性 |  | 4QP-SNGA120408-H | | | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 0.8 | 2.4 | | | |
| | | 4QP-SNGA120412-H | | | | | | | | | | | 4 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | | | |
| | | | | | | | | | | | | | | | | | | | | | |
| 通用 |  | 2QP-SNGN090308 | | | | | | | | | ● | | 2 | 9.525 | 3.18 | — | 0.8 | 2.4 | | | |
| | | 2QP-SNGN090312 | | | | | | | | | ● | | 2 | 9.525 | 3.18 | — | 1.2 | 2.4 | | | |
| | | | | | | | | | | | | | | | | | | | | | |
| 锋利刃 |  | 3QP-TNGA160402F | | | | | | | | | | | | 3 | 9.525 | 4.76 | 3.81 | 0.2 | 2.3 | 外圆用 TAC车刀 (4-24 ~) | |
| | | 3QP-TNGA160404F | | | | | | | | ● | | | | 3 | 9.525 | 4.76 | 3.81 | 0.4 | 2.2 | | |
| | | 3QP-TNGA160408F | | | | | | | | ● | | | | 3 | 9.525 | 4.76 | 3.81 | 0.8 | 1.9 | | |
| | | 3QP-TNGA160412F | | | | | | | | | | | | 3 | 9.525 | 4.76 | 3.81 | 1.2 | 2.4 | | |
| 通用 |  | 3QP-TNGA160404 | ● | ● | | ● | ● | ● | ● | ● | ● | ● | ● | 3 | 9.525 | 4.76 | 3.81 | 0.4 | 2.2 | 内孔用 TAC车刀 (5-36 ~) | |
| | | 3QP-TNGA160408 | ● | ● | | ● | ● | ● | ● | ● | ● | ● | ● | 3 | 9.525 | 4.76 | 3.81 | 0.8 | 1.9 | | |
| | | 3QP-TNGA160412 | ● | ● | | ● | ● | ● | ● | ● | ● | ● | ● | 3 | 9.525 | 4.76 | 3.81 | 1.2 | 2.4 | | |
| 重视耐磨 性 |  | 3QP-TNGA160404-L | | ● | | | ● | | | | | | | 3 | 9.525 | 4.76 | 3.81 | 0.4 | 2.2 | 切削方式 系统 (12-70 ~) | |
| | | 3QP-TNGA160408-L | | ● | | | ● | | | | | | | 3 | 9.525 | 4.76 | 3.81 | 0.8 | 1.9 | | |
| | | 3QP-TNGA160412-L | | ● | | | ● | | | | | | | 3 | 9.525 | 4.76 | 3.81 | 1.2 | 2.4 | | |
| 重视抗崩 刃性 |  | 3QP-TNGA160404-H | | ● | | | | ● | ● | | | | | 3 | 9.525 | 4.76 | 3.81 | 0.4 | 2.2 | | |
| | | 3QP-TNGA160408-H | | ● | | | | ● | ● | | | | | 3 | 9.525 | 4.76 | 3.81 | 0.8 | 1.9 | | |
| | | 3QP-TNGA160412-H | | ● | | | | ● | ● | | | | | 3 | 9.525 | 4.76 | 3.81 | 1.2 | 2.4 | | |
| 修光刃 规格 |  | 3QP-TNGA160404WG | | ● | | | | | | | | | | 3 | 9.525 | 4.76 | 3.81 | 0.4 | 2.4 | | |
| | | 3QP-TNGA160408WG | | ● | | | | | | | | | | 3 | 9.525 | 4.76 | 3.81 | 0.8 | 2.2 | | |
| 通用 |  | T3QP-TNGA160404 | | | | | | ● | | | | | | 3 | 9.525 | 4.76 | 3.81 | 0.4 | 2.2 | | |
| | | T3QP-TNGA160408 | | | | | | ● | | | | | | 3 | 9.525 | 4.76 | 3.81 | 0.8 | 1.9 | | |
| 通用 |  | 6QP-TNGA160404 | | | ● | | | | | | | | | 6 | 9.525 | 4.76 | 3.81 | 0.4 | 2.2 | | |
| | | 6QP-TNGA160408 | | | ● | | | | | | | | | 6 | 9.525 | 4.76 | 3.81 | 0.8 | 1.9 | | |
| | | 6QP-TNGA160412 | | | ● | | | | | | | | | 6 | 9.525 | 4.76 | 3.81 | 1.2 | 2.4 | | |
| 重视抗崩 刃性 |  | 6QP-TNGA160404-H | | | | | | | | | | | | 6 | 9.525 | 4.76 | 3.81 | 0.4 | 2.2 | | |
| | | 6QP-TNGA160408-H | | | | | | | | | | | | 6 | 9.525 | 4.76 | 3.81 | 0.8 | 1.9 | | |
| | | 6QP-TNGA160412-H | | | | | | | | | | | | 6 | 9.525 | 4.76 | 3.81 | 1.2 | 2.4 | | |

※T开头的型号表示10片 / 盒。

型号名末尾带WG的推荐刀体请参照 3-6

产品库存 ● : 库存型号







标准钝化规格

3-6

| 材质 | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX910 | BX930 | BX950 |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 负前角刀片 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | T01315 | S01325 | S01315 | S01315 | S01325 |
| 正前角刀片 | S01325 | S01325 | — | S00515 | S00515 | S00515 | — | T01315 | — | S01315 | S00515 | S00515 |

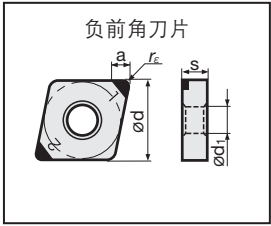
T-CBN 系列

负前角刀片•多刀尖型

| 规格 | 外观 | 型 号 | 库存材质 | | | | | | | | | | 刀尖数 | 尺 寸(mm) | | | | | 适用刀体 | |
|------------------|---|------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|---------|-----------|---------|-----------------------|------------------------------|--------------------------|--------------------------|
| | | | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX930 | | BX950 | 内切圆 ød | 厚度 s | 孔径 ød ₁ | 刀尖圆弧 半径 r _ε | | CBN长度 a |
| 通用 |  | 2QP-VNGA160402 | | | | | | | | | | | 2 | 9.525 | 4.76 | 3.81 | 0.2 | 3.5 | 外圆用 TAC车刀 (4-30 ~) | |
| | | 2QP-VNGA160404 | ● | ● | | ● | ● | ● | ● | ● | ● | ● | 2 | 9.525 | 4.76 | 3.81 | 0.4 | 3.1 | | |
| 重视耐磨性 | | 2QP-VNGA160408 | ● | ● | | ● | ● | ● | ● | ● | ● | ● | 2 | 9.525 | 4.76 | 3.81 | 0.8 | 2.2 | 内孔用 TAC车刀 (5-37 ~) | |
| | | 2QP-VNGA160412 | | ● | | | | | | | | | 2 | 9.525 | 4.76 | 3.81 | 1.2 | 3 | | |
| 重视抗崩刃性 | | 2QP-VNGA160404-L | | ● | | | ● | | | | | | 2 | 9.525 | 4.76 | 3.81 | 0.4 | 3.1 | | |
| | | 2QP-VNGA160408-L | | ● | | | ● | | | | | | 2 | 9.525 | 4.76 | 3.81 | 0.8 | 2.2 | | |
| | | 2QP-VNGA160404-H | | ● | | | | ● | ● | | | | 2 | 9.525 | 4.76 | 3.81 | 0.4 | 3.1 | | |
| | | 2QP-VNGA160408-H | | ● | | | | ● | ● | | | | 2 | 9.525 | 4.76 | 3.81 | 0.8 | 2.2 | | |
| 通用 |  | 4QP-VNGA160404 | | | ● | | | | | | | 4 | 9.525 | 4.76 | 3.81 | 0.4 | 3.1 | 内孔用 TAC车刀 (5-38 ~) | | |
| | | 4QP-VNGA160408 | | | ● | | | | | | | | 4 | 9.525 | 4.76 | 3.81 | 0.8 | | 2.2 | |
| 4QP-VNGA160412 | | | | | | | | | | | | 4 | 9.525 | 4.76 | 3.81 | 1.2 | 3 | | | |
| 刀尖强化型 | | 4QP-VNGA160404-H | | | | | | | | | | 4 | 9.525 | 4.76 | 3.81 | 0.4 | 3.1 | | | |
| 4QP-VNGA160408-H | | | | | | | | | | | | 4 | 9.525 | 4.76 | 3.81 | 0.8 | 2.2 | | | |
| 修光刀规格 |  | 3QP-WNGA080408 | ● | ● | | ● | ● | ● | ● | | ● | ● | ● | 3 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | 外圆用 TAC车刀 (4-17 ~) |
| | | | | | | | | | | | | | | | | | | | | |
| 通用 | | 3QP-WNGA080408WL | ● | ● | | | | | | | | | 3 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | 内孔用 TAC车刀 (5-38 ~) | |
| | | | | | | | | | | | | | | | | | | | | |
| 通用 |  | 6QP-WNGA080408 | | | ● | | | | | | | | 6 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | | |
| | | | | | | | | | | | | | | | | | | | | |

※型号名末尾带WL的推荐刀体请参照 [3-6](#)。












产品库存 ●: 库存型号



标准钝化规格

[3-6](#)

| 材质 | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX910 | BX930 | BX950 |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 负前角刀片 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | T01315 | S01325 | S01315 | S01315 | S01325 |
| 正前角刀片 | S01325 | S01325 | - | S00515 | S00515 | S00515 | - | T01315 | - | S01315 | S00515 | S00515 |

| 规格 | 外观 | 型号 | 库存材质 | | 刀尖数 | 尺寸(mm) | | | | | 适用刀体 |
|------|---|-------------------|------|-----|-----|-----------------|-----------|------------------|----------------------------|--------------|---|
| | | | BX | M20 | | 内切圆 ϕd | 厚度 s | 孔径 ϕd_1 | 刀尖圆弧 半径 r_ϵ | CBN长度 a | |
| 带断屑槽 |  | 2QP-CNGM120408-HF | ● | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | 外圆用 TAC车刀 (4-14 ~) 内孔用 TAC车刀 (5-33 ~) 切削方式 系统 (12-47 ~) |
| |  | 2QP-CNGM120412-HF | ● | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | |
| |  | 2QP-DNGM150408-HF | ● | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.1 | |
| |  | 2QP-DNGM150412-HF | ● | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2 | |
| |  | 3QP-TNGM160408-HF | ● | | 3 | 9.525 | 4.76 | 3.81 | 0.8 | 1.9 | |
| |  | 3QP-TNGM160412-HF | ● | | 3 | 9.525 | 4.76 | 3.81 | 1.2 | 2.4 | |
| |  | 2QP-VNGM160408-HF | ● | | 2 | 9.525 | 4.76 | 3.81 | 0.8 | 2.2 | |
| 带断屑槽 |  | 2QP-CNGM120408-HM | ● | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.2 | |
| |  | 2QP-CNGM120412-HM | ● | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2.4 | |
| |  | 2QP-DNGM150408-HM | ● | | 2 | 12.7 | 4.76 | 5.16 | 0.8 | 2.1 | |
| |  | 2QP-DNGM150412-HM | ● | | 2 | 12.7 | 4.76 | 5.16 | 1.2 | 2 | |
| |  | 3QP-TNGM160408-HM | ● | | 3 | 9.525 | 4.76 | 3.81 | 0.8 | 1.9 | |
| |  | 3QP-TNGM160412-HM | ● | | 3 | 9.525 | 4.76 | 3.81 | 1.2 | 2.2 | |
| |  | 2QP-VNGM160408-HM | ● | | 2 | 9.525 | 4.76 | 3.81 | 0.8 | 2.4 | |

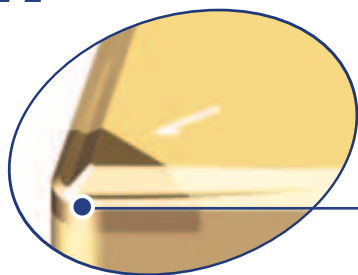
产品库存 ● : 库存型号

渗碳层去除用“硬车削断屑槽”

以两种断屑槽应对广范围的断排屑处理！

HF 型

精切削用断屑槽

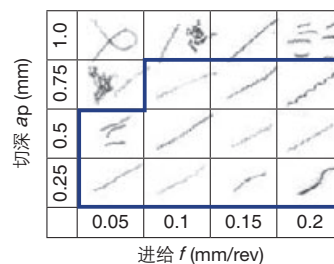


单面规格, 确保高负荷加工时的稳定性。

尖端为平面形状, 在小切深时能够获得良好的断排屑性能。适用于对表面精度有高要求的加工。

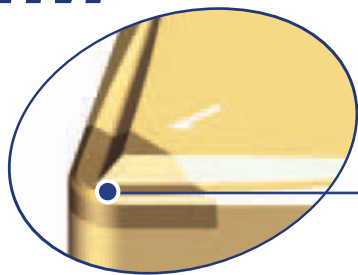
断排屑性能

● HF 断屑槽



HM 型

半精切削用断屑槽

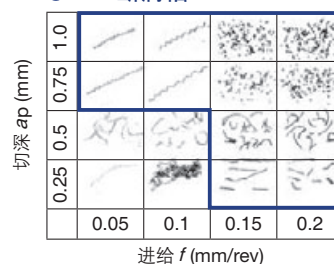


单面规格, 确保高负荷加工时的稳定性。








断屑槽形状多样, 在大切深时能够获得优良的断排屑性能。适用于半精·粗加工。

断排屑性能

● HM 断屑槽



负前角刀片•单刀尖型

| 规格 | 外观 | 型号 | 库存材质 | | 刀尖数 | 尺寸(mm) | | | | | 适用刀体 |
|-------------|---|----------------|-------|-------|-----|-----------|---------|-----------|------------------------|----------------|--|
| | | | T-CBN | BX360 | | 内切圆 ød | 厚度 s | 孔径 ød1 | 刀尖半径 r _E | CBN 长度 a | |
| 精 ~ 半精切削 |  | CNGA120402-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 0.2 | 4.1 | 外圆用TAC车刀 (4-14 ~) 内孔用TAC车刀 (5-53 ~) 自动化切削工具系统 (12-47 ~) |
| | | CNGA120404-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 0.4 | 4.0 | |
| | | CNGA120408-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 0.8 | 3.9 | |
| | | CNGA120412-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 1.2 | 3.9 | |
| |  | CNGN090404-QBN | | | 1 | 9.525 | 4.76 | — | 0.4 | 3.8 | |
| | | CNGN090408-QBN | | | 1 | 9.525 | 4.76 | — | 0.8 | 3.8 | |
| | | | | | | | | | | | |
| |  | DNGA150402-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 0.2 | 4.3 | 外圆用TAC车刀 (4-21 ~) 内孔用TAC车刀 (5-34 ~) |
| | | DNGA150404-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 0.4 | 4.1 | |
| | | DNGA150408-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 0.8 | 3.8 | |
| | | DNGA150412-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 1.2 | 3.4 | |
| 精 ~ 半精切削 |  | SNGA120402-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 0.2 | 4.1 | 外圆用TAC车刀 (4-25 ~) 内孔用TAC车刀 (5-35 ~) 自动化切削工具系统 (12-72 ~) |
| | | SNGA120404-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 0.4 | 4.1 | |
| | | SNGA120408-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 0.8 | 4.1 | |
| | | SNGA120412-QBN | ● | | 1 | 12.7 | 4.76 | 5.16 | 1.2 | 4.1 | |
| 精 ~ 半精切削 |  | SNGN120402-QBN | | | 1 | 12.7 | 4.76 | — | 0.2 | 4.1 | 外圆用TAC车刀 (4-50 ~) |
| | | SNGN120404-QBN | | | 1 | 12.7 | 4.76 | — | 0.4 | 4.1 | |
| | | SNGN120408-QBN | | | 1 | 12.7 | 4.76 | — | 0.8 | 4.1 | |
| | | SNGN120412-QBN | | | 1 | 12.7 | 4.76 | — | 1.2 | 4.1 | |
| 精 ~ 半精切削 |  | TNGA160402-QBN | ● | | 1 | 9.525 | 4.76 | 3.81 | 0.2 | 4.4 | 外圆用TAC车刀 (4-24 ~) 内孔用TAC车刀 (5-36 ~) 自动化切削工具系统 (12-70 ~) |
| | | TNGA160404-QBN | ● | | 1 | 9.525 | 4.76 | 3.81 | 0.4 | 4.2 | |
| | | TNGA160408-QBN | ● | | 1 | 9.525 | 4.76 | 3.81 | 0.8 | 4.0 | |
| | | TNGA160412-QBN | ● | | 1 | 9.525 | 4.76 | 3.81 | 1.2 | 3.7 | |
| 精 ~ 半精切削 |  | TNGN160402-QBN | | | 1 | 9.525 | 4.76 | — | 0.2 | 4.4 | 外圆用TAC车刀 (4-47 ~) |
| | | TNGN160404-QBN | | | 1 | 9.525 | 4.76 | — | 0.4 | 4.2 | |
| | | TNGN160408-QBN | | | 1 | 9.525 | 4.76 | — | 0.8 | 4.0 | |
| | | TNGN160412-QBN | | | 1 | 9.525 | 4.76 | — | 1.2 | 3.7 | |

产品库存 ●: 库存型号

标准钝化规格







3-6

| 材质 | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX910 | BX930 | BX950 |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 负前角刀片 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | T01315 | S01325 | S01315 | S01315 | S01325 |
| 正前角刀片 | S01325 | S01325 | — | S00515 | S00515 | S00515 | — | T01315 | — | S01315 | S00515 | S00515 |

正前角刀片·多刀尖型 G级

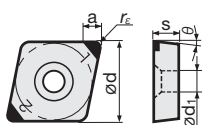
3

超高压烧结体刀具

| 规格 | 外观 | 型号 | 库存材质 | | | | 刀尖数 | 尺寸(mm) | | | | | | 适用刀体 |
|-----|---|-----------------|-------|-------|-------|-------|-----|----------------|----------------|-----------|--------------------|--------------------|------------------|------------------------|
| | | | BXM10 | BXM20 | BX470 | BX910 | | 后角 θ | 厚度 ϕd | 孔径 s | 刀尖圆弧 ϕd_1 | 内切圆 半径 r_E | CBN 长度 a | |
| 通用 |  | 2QP-CCGW060202 | ● | ● | | | 2 | 7° | 6.35 | 2.38 | 2.8 | 0.2 | 2.3 | 外圆用TAC车刀 (4-63 ~) |
| | | 2QP-CCGW060204 | ● | ● | ● | | 2 | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.3 | |
| 通用 | | 2QP-CCGW09T302 | | | | | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.2 | 2.3 | 内孔用TAC车刀 (5-12 ~) |
| | | 2QP-CCGW09T304 | ● | ● | ● | | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 2.3 | |
| | | 2QP-CCGW09T308 | ● | ● | ● | | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.8 | 2.2 | 自动化切削工具系统 (12-47 ~) |
| 通用 |  | 2QP-DCGW070202 | ● | ● | | | 2 | 7° | 6.35 | 2.38 | 2.8 | 0.2 | 2.7 | 外圆用TAC车刀 (4-63 ~) |
| | | 2QP-DCGW070204 | ● | ● | ● | | 2 | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.5 | |
| 锋利刃 | | 2QP-DCGW070208 | | | ● | | 2 | 7° | 6.35 | 2.38 | 2.8 | 0.8 | 2.5 | 内孔用TAC车刀 (5-16 ~) |
| | | 2QP-DCGW11T302F | | | ● | | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.2 | 2.7 | |
| | | 2QP-DCGW11T304F | | | ● | | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 2.5 | |
| 通用 | | 2QP-DCGW11T302 | ● | ● | | | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.2 | 2.7 | |
| | | 2QP-DCGW11T304 | ● | ● | ● | | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 2.5 | |
| | | 2QP-DCGW11T308 | ● | ● | ● | | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.8 | 2.1 | |
| 通用 |  | 2QP-SPGW09T308 | | | | ● | 2 | 11° | 9.525 | 3.97 | 4.4 | 0.8 | 2.4 | |
| | | 2QP-SPGW09T312 | | | | ● | 2 | 11° | 9.525 | 3.97 | 4.4 | 1.2 | 2.4 | |
| 通用 | | 2QP-SPGW120408 | | | | ● | 2 | 11° | 12.7 | 4.76 | 5.5 | 0.8 | 2.4 | |
| | | 2QP-SPGW120412 | | | | ● | 2 | 11° | 12.7 | 4.76 | 5.5 | 1.2 | 2.4 | |
| | | 2QP-SPGW120416 | | | | ● | 2 | 11° | 12.7 | 4.76 | 5.5 | 1.6 | 2.4 | |
| 通用 |  | 2QP-SPGN090308 | | | | ● | 2 | 11° | 9.525 | 3.18 | — | 0.8 | 2.4 | |
| | | 2QP-SPGN090312 | | | | ● | 2 | 11° | 9.525 | 3.18 | — | 1.2 | 2.4 | |
| | | | | | | | | | | | | | | |
| 通用 |  | 3QP-TPGW080202 | | | | | 3 | 11° | 4.76 | 2.38 | 2.3 | 0.2 | 2.4 | 内孔用TAC车刀 (5-20 ~) |
| | | 3QP-TPGW080204 | ● | ● | | | 3 | 11° | 4.76 | 2.38 | 2.3 | 0.4 | 2.2 | |
| 通用 | | 3QP-TPGW090202 | | ● | | | 3 | 11° | 5.56 | 2.38 | 2.5 | 0.2 | 2.3 | 自动化切削工具系统 (12-63 ~) |
| | | 3QP-TPGW090204 | ● | ● | | | 3 | 11° | 5.56 | 2.38 | 2.5 | 0.4 | 2.2 | |
| 通用 | | 3QP-TPGW110202 | | ● | | | 3 | 11° | 6.35 | 2.38 | 2.8 | 0.2 | 2.3 | |
| | | 3QP-TPGW110204 | ● | ● | ● | | 3 | 11° | 6.35 | 2.38 | 2.8 | 0.4 | 2.2 | |
| | | 3QP-TPGW110208 | | | ● | | 3 | 11° | 6.35 | 2.38 | 2.8 | 0.8 | 2.2 | |
| 锋利刃 | | 3QP-TPGW110302F | | | | | 3 | 11° | 6.35 | 3.18 | 3.4 | 0.2 | 2.3 | |
| | | 3QP-TPGW110304F | | | ● | | 3 | 11° | 6.35 | 3.18 | 3.4 | 0.4 | 2.2 | |
| | | 3QP-TPGW110308F | | | ● | | 3 | 11° | 6.35 | 3.18 | 3.4 | 0.8 | 2 | |
| 通用 | | 3QP-TPGW110302 | | ● | | | 3 | 11° | 6.35 | 3.18 | 3.4 | 0.2 | 2.3 | |
| | | 3QP-TPGW110304 | ● | ● | ● | | 3 | 11° | 6.35 | 3.18 | 3.4 | 0.4 | 2.2 | |
| | | 3QP-TPGW110308 | ● | ● | ● | ● | 3 | 11° | 6.35 | 3.18 | 3.4 | 0.8 | 1.9 | |
| 通用 | | 3QP-TPGW130302 | | ● | | | 3 | 11° | 7.94 | 3.18 | 3.4 | 0.2 | 2.3 | |
| | | 3QP-TPGW130304 | ● | ● | | | 3 | 11° | 7.94 | 3.18 | 3.4 | 0.4 | 2.2 | |
| | | 3QP-TPGW130308 | | | | | 3 | 11° | 7.94 | 3.18 | 3.4 | 0.8 | 2 | |
| 通用 | | 3QP-TPGW16T302 | | | | | 3 | 11° | 9.525 | 3.97 | 4.4 | 0.2 | 2.3 | |
| | | 3QP-TPGW16T304 | ● | ● | | | 3 | 11° | 9.525 | 3.97 | 4.4 | 0.4 | 2.2 | |
| | | 3QP-TPGW16T308 | ● | ● | | | 3 | 11° | 9.525 | 3.97 | 4.4 | 0.8 | 1.9 | |
| 锋利刃 | | 3QP-TPGW160402F | | | | | 3 | 11° | 9.525 | 4.76 | 4.4 | 0.2 | 2.3 | |
| | | 3QP-TPGW160404F | | | | | 3 | 11° | 9.525 | 4.76 | 4.4 | 0.4 | 2.2 | |
| | | 3QP-TPGW160408F | | | | | 3 | 11° | 9.525 | 4.76 | 4.4 | 0.8 | 2 | |
| 通用 | | 3QP-TPGW160404 | ● | ● | | | 3 | 11° | 9.525 | 4.76 | 4.4 | 0.4 | 2.2 | |
| | | 3QP-TPGW160408 | | ● | | | 3 | 11° | 9.525 | 4.76 | 4.4 | 0.8 | 2 | |
| 通用 |  | 3QP-TPGN110308 | | | | ● | 3 | 11° | 6.35 | 3.18 | — | 0.8 | 1.9 | |
| | | 3QP-TPGN110312 | | | | ● | 3 | 11° | 6.35 | 3.18 | — | 1.2 | 2.4 | |
| | | | | | | | | | | | | | | |

产品库存 ●: 库存型号

正前角刀片




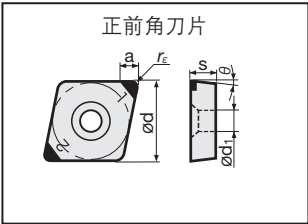
标准钝化规格

▶ 3-6

| 材质 | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX910 | BX930 | BX950 |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 负前角刀片 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | T01315 | S01325 | S01315 | S01315 | S01325 |
| 正前角刀片 | S01325 | S01325 | — | S00515 | S00515 | S00515 | — | T01315 | — | S01315 | S00515 | S00515 |

正前角刀片•多刀尖型 G级

| 规格 | 外观 | 型号 | 库存材质 | | | 刀尖数 | 尺寸(mm) | | | | | | 适用刀体 |
|----|---|----------------|-------|-------|--|-----|----------------|-----------------|-----------|------------------|----------------------------|--------------|--|
| | | | BXM10 | BXM20 | | | 后角 θ | 内切圆 ϕd | 厚度 s | 孔径 ϕd_1 | 刀尖圆弧 半径 r_ϵ | CBN长度 a | |
| 通用 |  | 2QP-VBGW110302 | | | | 2 | 5° | 6.35 | 3.18 | 2.8 | 0.2 | 3.5 | 外圆用TAC车刀 (4-83 ~) 内孔用TAC车刀 (5-22 ~) |
| | | 2QP-VBGW110304 | ● | ● | | 2 | 5° | 6.35 | 3.18 | 2.8 | 0.4 | 3.1 | |
| | | 2QP-VBGW110308 | ● | ● | | 2 | 5° | 6.35 | 3.18 | 2.8 | 0.8 | 2.2 | |
| | | 2QP-VBGW160402 | | | | 2 | 5° | 9.525 | 4.76 | 4.4 | 0.2 | 3.5 | |
| | | 2QP-VBGW160404 | ● | ● | | 2 | 5° | 9.525 | 4.76 | 4.4 | 0.4 | 3.1 | |
| | | 2QP-VBGW160408 | ● | ● | | 2 | 5° | 9.525 | 4.76 | 4.4 | 0.8 | 2.2 | |
| 通用 |  | 2QP-VCGW160402 | | | | 2 | 7° | 9.525 | 4.76 | 4.4 | 0.2 | 3.5 | 外圆用TAC车刀 (4-65 ~) 内孔用TAC车刀 (5-24 ~) |
| | | 2QP-VCGW160404 | ● | ● | | 2 | 7° | 9.525 | 4.76 | 4.4 | 0.4 | 3.1 | |
| | | 2QP-VCGW160408 | | | | 2 | 7° | 9.525 | 4.76 | 4.4 | 0.8 | 2.2 | |



产品库存 ● : 库存型号








3
超高压烧结体刀具

标准钝化规格

▶ 3-6

| 材质 | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX910 | BX930 | BX950 |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 负前角刀片 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | T01315 | S01325 | S01315 | S01315 | S01325 |
| 正前角刀片 | S01325 | S01325 | - | S00515 | S00515 | S00515 | - | T01315 | - | S01315 | S00515 | S00515 |

正前角刀片·多刀尖型

| 规格 | 外观 | 型号 | 库存材质 | | | | | 刀尖数 | 尺寸(mm) | | | | | | 适用刀体 |
|-------------------|---|----------------|-------|-------|-------|-------|-------|-----|----------------|-----------------|-----------|------------------|----------------------------|------------------|--|
| | | | BX310 | BX330 | BX360 | BX930 | BX950 | | 后角 θ | 内切圆 ϕd | 厚度 s | 孔径 ϕd_1 | 刀尖圆弧 半径 r_ϵ | CBN 长度 a | |
| 精切削 通用 |  | 2QP-CCMW060202 | ● | ● | ● | ● | ● | 2 | 7° | 6.35 | 2.38 | 2.8 | 0.2 | 2.3 | 外圆用TAC车刀 (4-63 ~) 内孔用TAC车刀 (5-12 ~) 自动化切削工具系统 (12-47 ~) |
| | | 2QP-CCMW060204 | ● | ● | ● | ● | ● | 2 | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.3 | |
| | | 2QP-CCMW09T304 | ● | ● | ● | ● | ● | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 2.3 | |
| | | 2QP-CCMW09T308 | ● | ● | ● | ● | ● | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.8 | 2.2 | |
| 精切削 通用 |  | 2QP-DCMW070202 | ● | ● | ● | ● | ● | 2 | 7° | 6.35 | 2.38 | 2.8 | 0.2 | 2.7 | 外圆用TAC车刀 (4-63 ~) 内孔用TAC车刀 (5-16 ~) |
| | | 2QP-DCMW070204 | ● | ● | ● | ● | ● | 2 | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.5 | |
| | | 2QP-DCMW11T302 | ● | ● | ● | ● | ● | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.2 | 2.7 | |
| | | 2QP-DCMW11T304 | ● | ● | ● | ● | ● | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 2.5 | |
| | | 2QP-DCMW11T308 | ● | ● | ● | ● | ● | 2 | 7° | 9.525 | 3.97 | 4.4 | 0.8 | 2.1 | |
| |  | 2QP-SPMN090304 | ● | ● | ● | ● | ● | 2 | 11° | 9.525 | 3.18 | — | 0.4 | 2.4 | 外圆用TAC车刀 (4-73) 内孔用TAC车刀 (5-61) 自动化切削工具系统 (12-72 ~) |
| | | 2QP-SPMN090308 | ● | ● | ● | ● | ● | 2 | 11° | 9.525 | 3.18 | — | 0.8 | 2.4 | |
| | | | | | | | | | | | | | | | |
| 精切削 通用 |  | 3QP-TPMW080204 | ● | ● | ● | ● | ● | 3 | 11° | 4.76 | 2.38 | 2.3 | 0.4 | 2.2 | 内孔用TAC车刀 (5-20 ~) 自动化切削工具系统 (12-63 ~) |
| | | | | | | | | | | | | | | | |
| | | 3QP-TPMW090202 | ● | ● | ● | ● | ● | 3 | 11° | 5.56 | 2.38 | 2.5 | 0.2 | 2.3 | |
| | | 3QP-TPMW090204 | ● | ● | ● | ● | ● | 3 | 11° | 5.56 | 2.38 | 2.5 | 0.4 | 2.2 | |
| | | 3QP-TPMW110202 | ● | ● | ● | ● | ● | 3 | 11° | 6.35 | 2.38 | 2.8 | 0.2 | 2.3 | |
| | | 3QP-TPMW110204 | ● | ● | ● | ● | ● | 3 | 11° | 6.35 | 2.38 | 2.8 | 0.4 | 2.2 | |
| | | 3QP-TPMW110302 | ● | ● | ● | ● | ● | 3 | 11° | 6.35 | 3.18 | 3.4 | 0.2 | 2.4 | |
| | | 3QP-TPMW110304 | ● | ● | ● | ● | ● | 3 | 11° | 6.35 | 3.18 | 3.4 | 0.4 | 2.2 | |
| | | 3QP-TPMW110308 | ● | ● | ● | ● | ● | 3 | 11° | 6.35 | 3.18 | 3.4 | 0.8 | 1.9 | |
| | | 3QP-TPMW130302 | ● | ● | ● | ● | ● | 3 | 11° | 7.94 | 3.18 | 3.4 | 0.2 | 2.4 | |
| | | 3QP-TPMW130304 | ● | ● | ● | ● | ● | 3 | 11° | 7.94 | 3.18 | 3.4 | 0.4 | 2.2 | |
| | | 3QP-TPMW16T304 | ● | ● | ● | ● | ● | 3 | 11° | 9.525 | 3.97 | 4.4 | 0.4 | 2.2 | |
| | | 3QP-TPMW16T308 | ● | ● | ● | ● | ● | 3 | 11° | 9.525 | 3.97 | 4.4 | 0.8 | 1.9 | |
| | | 3QP-TPMW160404 | ● | ● | ● | ● | ● | 3 | 11° | 9.525 | 4.76 | 4.4 | 0.4 | 2.2 | |
| | | 3QP-TPMW160408 | ● | ● | ● | ● | ● | 3 | 11° | 9.525 | 4.76 | 4.4 | 0.8 | 1.9 | |
| 精 ~ 半精切削 通用 |  | 3QP-TPMN110302 | ● | ● | ● | ● | ● | 3 | 11° | 6.35 | 3.18 | — | 0.2 | 2.3 | 外圆用TAC车刀 (4-73) 内孔用TAC车刀 (5-50) 自动化切削工具系统 (12-70) |
| | | 3QP-TPMN110304 | ● | ● | ● | ● | ● | 3 | 11° | 6.35 | 3.18 | — | 0.4 | 2.2 | |
| | | 3QP-TPMN110308 | ● | ● | ● | ● | ● | 3 | 11° | 6.35 | 3.18 | — | 0.8 | 1.9 | |
| | | 3QP-TPMN160304 | ● | ● | ● | ● | ● | 3 | 11° | 9.525 | 3.18 | — | 0.4 | 2.2 | |
| | | 3QP-TPMN160308 | ● | ● | ● | ● | ● | 3 | 11° | 9.525 | 3.18 | — | 0.8 | 1.9 | |
| 精切削 通用 |  | 2QP-VBMW110304 | ● | ● | ● | ● | ● | 2 | 5° | 6.35 | 3.18 | 2.8 | 0.4 | 3.1 | 外圆用TAC车刀 (4-83 ~) 内孔用TAC车刀 (5-22 ~) |
| | | 2QP-VBMW110308 | ● | ● | ● | ● | ● | 2 | 5° | 6.35 | 3.18 | 2.8 | 0.8 | 2.2 | |
| | | 2QP-VBMW160404 | ● | ● | ● | ● | ● | 2 | 5° | 9.525 | 4.76 | 4.4 | 0.4 | 2.2 | |
| | | 2QP-VBMW160408 | ● | ● | ● | ● | ● | 2 | 5° | 9.525 | 4.76 | 4.4 | 0.8 | 2.2 | |
| 精切削 通用 |  | 2QP-VCMW160404 | ● | ● | ● | ● | ● | 2 | 5° | 9.525 | 4.76 | 4.4 | 0.4 | 2.2 | 外圆用TAC车刀 (4-65 ~) 内孔用TAC车刀 (5-24 ~) |
| | | | | | | | | | | | | | | | |






● : 库存型号

标准钝化规格

3-6

| 材质 | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX910 | BX930 | BX950 |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 负前角刀片 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | T01315 | S01325 | S01315 | S01315 | S01325 |
| 正前角刀片 | S01325 | S01325 | — | S00515 | S00515 | S00515 | — | T01315 | — | S01315 | S00515 | S00515 |

正前角刀片•专用单刀尖型

| 规格 | 外观 | 型号 | 库存材质 | | 刀尖数 | 尺寸(mm) | | | | | | 适用刀体 |
|---------------|---|--------------|-------|-------|-----|----------------|-----------------|-----------|------------------|-----------------|--------------|--|
| | | | T-CBN | BX330 | | 后角 θ | 内切圆 ϕd | 厚度 s | 孔径 ϕd_1 | 刀尖圆弧半径 r_E | CBN长度 a | |
| 精切削通用 2片/盒 |  | Q-CCMW060204 | ● | | 1 | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.5 | 外圆用TAC车刀 (4-63 ~) 内孔用TAC车刀 (5-12 ~) 自动化切削工具系统 (12-47 ~) |
| | | Q-CCMW09T304 | ● | | 1 | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 2.5 | |
| | | | | | | | | | | | | |
| |  | Q-DCMW070204 | ● | | 1 | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.1 | 外圆用TAC车刀 (4-63 ~) 内孔用TAC车刀 (5-16 ~) |
| | | Q-DCMW11T304 | ● | | 1 | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 2.1 | |
| | | | | | | | | | | | | |
| |  | Q-SPGN090304 | ● | | 1 | 11° | 9.525 | 3.18 | — | 0.4 | 2.8 | 外圆用TAC车刀 (4-73) 内孔用TAC车刀 (5-61) 自动化切削工具系统 (12-72 ~) |
| | | Q-SPGN090308 | ● | | 1 | 11° | 9.525 | 3.18 | — | 0.8 | 2.8 | |
| | | | | | | | | | | | | |
| |  | Q-TPMW080204 | ● | | 1 | 11° | 4.76 | 2.38 | 2.3 | 0.4 | 2.2 | 内孔用TAC车刀 (5-20 ~) 自动化切削工具系统 (12-63 ~) |
| | | Q-TPMW090202 | ● | | 1 | 11° | 5.56 | 2.38 | 2.5 | 0.2 | 2.4 | |
| | | Q-TPMW090204 | ● | | 1 | 11° | 5.56 | 2.38 | 2.5 | 0.4 | 2.3 | |
| | | Q-TPMW110202 | ● | | 1 | 11° | 6.35 | 2.38 | 2.8 | 0.2 | 2.4 | |
| | | Q-TPMW110204 | ● | | 1 | 11° | 6.35 | 2.38 | 2.8 | 0.4 | 2.2 | |
| | | Q-TPMW110304 | ● | | 1 | 11° | 6.35 | 3.18 | 3.4 | 0.4 | 2.2 | |
| | | Q-TPMW110308 | ● | | 1 | 11° | 6.35 | 3.18 | 3.4 | 0.8 | 1.9 | |
| | | Q-TPMW130302 | ● | | 1 | 11° | 7.94 | 3.18 | 3.4 | 0.2 | 2.4 | |
| | | Q-TPMW130304 | ● | | 1 | 11° | 7.94 | 3.18 | 3.4 | 0.4 | 2.3 | |
| | | Q-TPMW16T304 | ● | | 1 | 11° | 9.525 | 3.97 | 4.4 | 0.4 | 2.3 | |
| | | Q-TPMW160404 | ● | | 1 | 11° | 9.525 | 4.76 | 4.4 | 0.4 | 2.3 | |
| | | Q-TPMW160408 | ● | | 1 | 11° | 9.525 | 4.76 | 4.4 | 0.8 | 1.9 | |
| |  | Q-TPGN110304 | ● | | 1 | 11° | 6.35 | 3.18 | — | 0.4 | 2.2 | 外圆用TAC车刀 (4-73) 内孔用TAC车刀 (5-50) 自动化切削工具系统 (12-70) |
| | | Q-TPGN110308 | ● | | 1 | 11° | 6.35 | 3.18 | — | 0.8 | 2.2 | |
| | | Q-TPGN160304 | ● | | 1 | 11° | 9.525 | 3.18 | — | 0.4 | 2.3 | |
| | | Q-TPGN160308 | ● | | 1 | 11° | 9.525 | 3.18 | — | 0.8 | 1.9 | |

MINI T-CBN

正前角刀片•Mini

●：库存型号

| 规格 | 外观 | 型号 | 库存材质 | | 刀尖数 | 尺寸(mm) | | | | | | 适用刀体 |
|-------------|---|----------------|-------|-------|-----|----------------|-----------------|-----------|------------------|-----------------|--------------|--|
| | | | T-CBN | BX310 | | 后角 θ | 内切圆 ϕd | 厚度 s | 孔径 ϕd_1 | 刀尖圆弧半径 r_E | CBN长度 a | |
| 精 ~ 半精切削 |  | 1QP-CCGW03X102 | ● | | 1 | 7° | 3.57 | 1.39 | 1.9 | 0.2 | 1.4 | 内孔用TAC车刀 (5-12) 自动化切削工具系统 (12-63 ~) |
| | | 1QP-CCGW03X104 | ● | | 1 | 7° | 3.57 | 1.39 | 1.9 | 0.4 | 1.3 | |
| | | 1QP-CCGW04T102 | ● | | 1 | 7° | 4.37 | 1.79 | 2.3 | 0.2 | 1.9 | |
| | | 1QP-CCGW04T104 | ● | | 1 | 7° | 4.37 | 1.79 | 2.3 | 0.4 | 1.8 | |
| |  | 1QP-EPGW03X102 | ● | | 1 | 11° | 3.57 | 1.39 | 1.9 | 0.2 | 1.4 | 内孔用TAC车刀 (5-28) 自动化切削工具系统 (12-63 ~) |
| | | 1QP-EPGW03X104 | ● | | 1 | 11° | 3.57 | 1.39 | 1.9 | 0.4 | 1.3 | |
| | | 1QP-EPGW040102 | ● | | 1 | 11° | 3.97 | 1.59 | 2.3 | 0.2 | 1.7 | |
| | | 1QP-EPGW040104 | ● | | 1 | 11° | 3.97 | 1.59 | 2.3 | 0.4 | 1.6 | |

●：库存型号

标准钝化规格

3-6







| 材质 | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX910 | BX930 | BX950 |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 负前角刀片 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | T01315 | S01325 | S01315 | S01315 | S01325 |
| 正前角刀片 | S01325 | S01325 | — | S00515 | S00515 | S00515 | — | T01315 | — | S01315 | S00515 | S00515 |

材质
(1-1)

相关事项指南

外圆用车刀
(4-1)内孔用车刀
(5-1)

正前角刀片·单刀尖型

| 规格 | 外观 | 型号 | 库存材质 | | 刀尖数 | 尺寸(mm) | | | | | | 适用刀体 |
|-------------|---|-------------------|-------|-------|-----|----------------|-----------------|-----------|------------------|---------------------|--------------|--|
| | | | T-CBN | BX360 | | 后角 θ | 内切圆 ϕd | 厚度 s | 孔径 ϕd_1 | 刀尖圆弧 半径 r_E | CBN长度 a | |
| 精 ~ 半精切削 |  | SPGN090304-QBN | ● | | 1 | 11° | 9.525 | 3.18 | — | 0.4 | 4.1 | 外圆用TAC车刀 (4-73) 内孔用TAC车刀 (5-61) 自动化切削工具系统 (12-72 ~) |
| | | SPGN090308-QBN | ● | | 1 | 11° | 9.525 | 3.18 | — | 0.8 | 4.1 | |
| | | SPGN090312-QBN | ● | | 1 | 11° | 9.525 | 3.18 | — | 1.2 | 4.1 | |
| | | SPGN120308-QBN | ● | | 1 | 11° | 12.7 | 3.18 | — | 0.8 | 4.1 | |
| | | SPGN120312-QBN | ● | | 1 | 11° | 12.7 | 3.18 | — | 1.2 | 4.1 | |
| 精 ~ 半精切削 |  | TPGW090202-QBN | ● | | 1 | 11° | 5.56 | 2.38 | 2.5 | 0.2 | 3.3 | 内孔用TAC车刀 (5-20 ~) 自动化切削工具系统 (12-63 ~) |
| | | TPGW090204-QBN | ● | | 1 | 11° | 5.56 | 2.38 | 2.5 | 0.4 | 3.2 | |
| | | TPGW110202-QBN | ● | | 1 | 11° | 6.35 | 2.38 | 2.8 | 0.2 | 3.9 | |
| | | TPGW110204-QBN | ● | | 1 | 11° | 6.35 | 2.38 | 2.8 | 0.4 | 3.7 | |
| | | TPGW130302-QBN | ● | | 1 | 11° | 7.94 | 3.18 | 3.4 | 0.2 | 3.9 | |
| | | TPGW130304-QBN | ● | | 1 | 11° | 7.94 | 3.18 | 3.4 | 0.4 | 3.7 | |
| | | TPGW16T302-QBN | ● | | 1 | 11° | 9.525 | 3.97 | 4.4 | 0.2 | 4.4 | |
| | | TPGW16T304-QBN | ● | | 1 | 11° | 9.525 | 3.97 | 4.4 | 0.4 | 4.2 | |
| |  | TPGW16T308-QBN | ● | | 1 | 11° | 9.525 | 3.97 | 4.4 | 0.8 | 4 | 外圆用TAC车刀 (4-73) 内孔用TAC车刀 (5-50) 自动化切削工具系统 (12-70) |
| | | TPGN110304-QBN | ● | | 1 | 11° | 6.35 | 3.18 | — | 0.4 | 3.7 | |
| | | TPGN110308-QBN | ● | | 1 | 11° | 6.35 | 3.18 | — | 0.8 | 3.5 | |
| | | TPGN160304-QBN | ● | | 1 | 11° | 9.525 | 3.18 | — | 0.4 | 4.2 | |
| | | TPGN160308-QBN | ● | | 1 | 11° | 9.525 | 3.18 | — | 0.8 | 4 | |
| | | | | | | | | | | | | |
| 精切削 |  | TBGN060104-15-QBN | ● | | 3 | 5° | 3.97 | 1.59 | — | 0.4 | 6.4 | |
| | | TBGN060108-15-QBN | ● | | 3 | 5° | 3.97 | 1.59 | — | 0.8 | 6 | |
| 精 ~ 半精切削 |  | CPGA090204-QBN | ● | | 1 | 11° | 9.525 | 2.38 | 4 | 0.4 | 4 | 泰珂洛旧式规格 (非ISO标准) |
| | | CPGA090208-QBN | ● | | 1 | 11° | 9.525 | 2.38 | 4 | 0.8 | 3.8 | |
| 精 ~ 半精切削 |  | TPGA090202-QBN | ● | | 1 | 11° | 5.56 | 2.38 | 3.2 | 0.2 | 3.1 | 泰珂洛旧式规格 (非ISO标准) |
| | | TPGA090204-QBN | ● | | 1 | 11° | 5.56 | 2.38 | 3.2 | 0.4 | 2.9 | |
| | | TPGA110202-QBN | ● | | 1 | 11° | 6.35 | 2.38 | 3 | 0.2 | 3.9 | |
| | | TPGA110204-QBN | ● | | 1 | 11° | 6.35 | 2.38 | 3 | 0.4 | 3.7 | |
| | | TPGA110302-QBN | ● | | 1 | 11° | 6.35 | 3.18 | 3 | 0.2 | 3.9 | |
| | | TPGA110304-QBN | ● | | 1 | 11° | 6.35 | 3.18 | 3 | 0.4 | 3.7 | |
| | | TPGA160302-QBN | ● | | 1 | 11° | 9.525 | 3.18 | 4 | 0.2 | 4.4 | |
| | | TPGA160304-QBN | ● | | 1 | 11° | 9.525 | 3.18 | 4 | 0.4 | 4.2 | |
| | | TPGA160308-QBN | ● | | 1 | 11° | 9.525 | 3.18 | 4 | 0.8 | 4 | |





●: 库存型号

标准钝化规格

▶ 3-6

| 材质 | BXM10 | BXM20 | BXC50 | BX310 | BX330 | BX360 | BX380 | BX470 | BX480 | BX910 | BX930 | BX950 |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 负前角刀片 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | S01325 | T01315 | S01325 | S01315 | S01315 | S01325 |
| 正前角刀片 | S01325 | S01325 | — | S00515 | S00515 | S00515 | — | T01315 | — | S01315 | S00515 | S00515 |

涂层整体T-CBN

| 规格 | 外观 | 型号 | 库存材质 | 尺寸(mm) | | |
|-----------|---|--------------|------------------------|--------------|--------|--------------|
| | | | 涂层 整体T-CBN BXC90 | 内切圆 ϕd | 厚度 s | 刀尖圆弧半径 r_E |
| 精~ 粗切削 |  | S-CNGN090308 | ● | 9.525 | 3.18 | 0.8 |
| | | S-CNGN090312 | ● | 9.525 | 3.18 | 1.2 |
| | | S-CNGN120408 | ● | 12.7 | 4.76 | 0.8 |
| | | S-CNGN120412 | ● | 12.7 | 4.76 | 1.2 |
| |  | S-RNGN090300 | ● | 9.525 | 3.18 | — |
| | | S-RNGN120400 | ● | 12.7 | 4.76 | — |
| | | | | | | |
| | | | | | | |
| |  | S-SNGN090308 | ● | 9.525 | 3.18 | 0.8 |
| | | S-SNGN090312 | ● | 9.525 | 3.18 | 1.2 |
| | | S-SNGN120308 | ● | 12.7 | 3.18 | 0.8 |
| | | S-SNGN120312 | ● | 12.7 | 3.18 | 1.2 |
| | | S-SNGN120408 | ● | 12.7 | 4.76 | 0.8 |
| | | S-SNGN120412 | ● | 12.7 | 4.76 | 1.2 |
| |  | S-TNGN110308 | ● | 6.35 | 3.18 | 0.8 |
| | | S-TNGN110312 | ● | 6.35 | 3.18 | 1.2 |
| | | S-TNGN160408 | ● | 9.525 | 4.76 | 0.8 |
| | | S-TNGN160412 | ● | 9.525 | 4.76 | 1.2 |

3

超高压烧结体刀具

T-CBN 系列

整体 T-CBN (BX90S)

● : 库存型号

| 规格 | 外观 | 型号 | 库存材质 | 尺寸(mm) | | |
|-----------|---|--------------|------------------|--------------|--------|-------|
| | | | 整体T-CBN BX90S | 内切圆 ϕd | 厚度 s | r_E |
| 精~ 粗切削 |  | S-CNMN090308 | | 9.25 | 3.18 | 0.8 |
| | | S-CNMN090312 | | 9.525 | 3.18 | 1.2 |
| | | S-CNMN120408 | | 12.7 | 4.76 | 0.8 |
| | | S-CNMN120412 | | 12.7 | 4.76 | 1.2 |
| |  | S-RNMN090300 | | 9.525 | 3.18 | — |
| | | S-RNMN120400 | | 12.7 | 4.76 | — |
| | | | | | | |
| | | | | | | |
| |  | S-SNMN090308 | | 9.525 | 3.18 | 0.8 |
| | | S-SNMN090312 | | 9.525 | 3.18 | 1.2 |
| | | S-SNMN120308 | | 12.7 | 3.18 | 0.8 |
| | | S-SNMN120312 | | 12.7 | 3.18 | 1.2 |
| | | S-SNMN120408 | | 12.7 | 4.76 | 0.8 |
| | | S-SNMN120412 | | 12.7 | 4.76 | 1.2 |
| |  | S-TNMN110308 | | 6.35 | 3.18 | 0.8 |
| | | S-TNMN110312 | | 6.35 | 3.18 | 1.2 |
| | | S-TNMN160408 | | 9.525 | 4.76 | 0.8 |
| | | S-TNMN160412 | | 9.525 | 4.76 | 1.2 |

T-CBN 系列

CBN槽刀

| 规格 | 外观 | 型 号 | 库存材质 | | 刀尖数 | 尺 寸(mm) | | | 适用刀体 |
|------|---|----------------|-------|---|-----|-------------|-------|-----------------|--|
| | | | T-CBN | | | 槽宽 ±0.05 | 可加工槽深 | 刀尖圆弧半径 r_E | |
| | | | BX360 | | | | | | |
| | | | R | L | | | | | |
| 切槽加工 |  | XGR/L6310S-QBN | | | 1 | 1.0 | 1.5 | 0.2 | 外圆刀体 :GX-□□□□R/LE (6-43) 内孔刀体 :GX-□□□□L/RI (最小加工直径 ø55) (6-82) |
| | | XGR/L6315S-QBN | ● | | 1 | 1.5 | 2.3 | 0.2 | |
| | | XGR/L6320S-QBN | ● | | 1 | 2.0 | 3 | 0.2 | |
| | | XGR/L6325S-QBN | ● | | 1 | 2.5 | 3.8 | 0.2 | |
| | | XGR/L6330S-QBN | ● | | 1 | 3.0 | 4.5 | 0.2 | |
| | | XGR/L6335S-QBN | ● | | 1 | 3.5 | 5.3 | 0.2 | |
| | | XGR/L6340S-QBN | ● | | 1 | 4.0 | 6 | 0.2 | |
| | | XGR/L6345S-QBN | ● | | 1 | 4.5 | 6 | 0.2 | |

● : 库存型号

材 质
(1-1)

相关事项指南

外圆用车刀
(4-1)内孔用车刀
(5-1)

T-CBN球头立铣刀

BBB2000



高硬度材料

2
刀齿数

0°
螺旋角

T-CBN球头立铣刀

| 型 号 | 库 存 | | 尺 寸 (mm) | | | | | 刀齿数 |
|---------|-------|-----|----------|-----|--------|-----|------|-----|
| | T-CBN | R | 刃部直径 | 刃 长 | 颈部直径全长 | 全 长 | 柄部直径 | |
| BBB2006 | ● | 0.3 | 0.6 | 0.5 | 1.2 | 50 | 6.0 | 2 |
| BBB2008 | ● | 0.4 | 0.8 | 0.6 | 1.6 | 50 | 6.0 | |
| BBB2010 | ● | 0.5 | 1.0 | 0.7 | 2.0 | 50 | 6.0 | |
| BBB2020 | ● | 1.0 | 2.0 | 1.5 | 4.0 | 50 | 6.0 | |

公差(BBB2000)

| R | R公差 | 柄部直径公差 |
|-----------|---------|--------|
| 0.3 ~ 1.0 | ± 0.005 | h6 |

●BBB2000(T-CBN球头立铣刀)

| 工件材料 | | 淬火钢 NAK80•SKD61 | | | 淬火钢 SKD11•DRM1,2 | | | 淬火钢 SKH•DRM3 | | | 工件脱模锥度(θ 1)/有效颈部直径全长(Z) | | | |
|-------------|------------------------------|--------------------|----------------------------|------------------------------|---------------------|----------------------------|------------------------------|------------------|----------------------------|---|-------------------------|--|--|--|
| 硬度 | | 52HRC | | | 62HRC以下 | | | 70HRC以下 | | | | | | |
| 刃部半径 (R) | 切深量 $a_p \times p_t$ (mm) | 进给速度 (mm/min) | 转数 (min ⁻¹) | 切深量 $a_p \times p_t$ (mm) | 进给速度 (mm/min) | 转数 (min ⁻¹) | 切深量 $a_p \times p_t$ (mm) | 进给速度 (mm/min) | 转数 (min ⁻¹) | | | | | |
| 0.3 | 0.02 × 0.03 | 2,000 | 50,000 | 0.01 × 0.02 | 2,000 | 50,000 | 0.01 × 0.02 | 1,500 | 50,000 | 0°30′/1.25 1°/1.30 2°/1.35 3°/1.45 | | | | |
| 0.4 | 0.03 × 0.05 | 2,000 | | 0.02 × 0.03 | 2,000 | | 0.01 × 0.03 | 1,500 | | 0°30′/1.65 1°/1.70 2°/1.80 3°/1.90 | | | | |
| 0.5 | 0.05 × 0.05 | 3,000 | | 0.03 × 0.05 | 3,000 | | 0.02 × 0.03 | 2,000 | | 0°30′/2.05 1°/2.10 2°/2.25 3°/2.40 | | | | |
| 1.0 | 0.10 × 0.10 | 5,000 | | 0.05 × 0.05 | 5,000 | | 0.03 × 0.05 | 3,000 | | 0°30′/4.15 1°/4.25 2°/4.50 3°/4.80 | | | | |

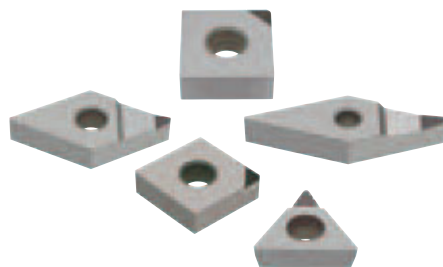
※切深用(a_p)表示为最大值。
※推荐使用油雾以及鼓风装置。
※所用机床的转速低于50,000 min⁻¹时, 请以相同的比率调整转数和进给速度。
※刀具悬伸量请选用所需要的最小限度。

●: 库存型号

超高压烧结体刀具

多晶体人造金刚石烧结体

T-DIA系列



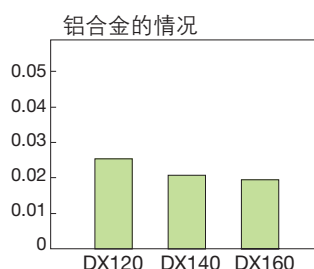
T-DIA刀具系列更加丰富。
支持广范的工件材料和切削条件。

3

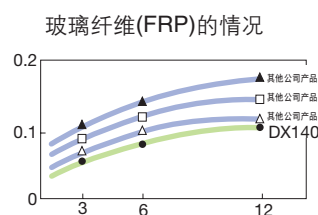
■ 特征和用途(物理特性•机械特性)

| | DX110 | DX120 | DX140 | DX160 | DX180 |
|--------------|--------------|------------|-------|-------------|-------------|
| 材质 | | | | | |
| 特性 | 重视加工面用超细微粒材质 | 重视加工面用微粒材质 | 通用材质 | 高硬度材料用高纯度材质 | 特殊用途用高耐磨性材质 |
| 人造金刚石主粒度(μm) | < 1 | 4.5 | 12.5 | 28 | 45 |
| 硬度(Hv) | 6000 | | | | 12000(硬) |
| 耐磨性 | | | | | 好 |
| 被研磨性(刀尖锋利性) | 好 | | | | |

■ 切削性能•耐磨性

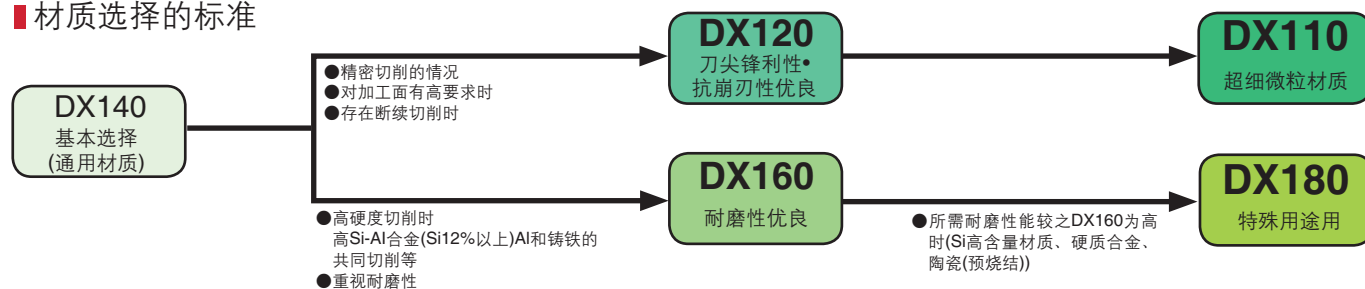


外圆纵向连续车削
 ●工件材料: 10%Si-Al合金
 ●刀片: SPGN120308-DIA
 ●刀杆: CSBPR2525M4
 ●切削速度: $V_c = 500$ m/min
 ●进给量: $f = 0.1$ mm/rev
 ●切深: $a_p = 0.5$ mm
 ●切削液: 干式切削
 ●切削时间: 30 min



平面铣削
 ●工件材料: 玻璃纤维(FRP)
 ●刀片: SPCN42ZFR-DIA
 ●铣刀: TPG4208R-A
 ●切削速度: $V_c = 942$ m/min
 ●进给量: $f = 0.1$ mm/rev
 ●切深: $a_p = 1.5$ mm
 ●切削液: 干式切削

■ 材质选择的标准







● 标准切削条件

| 工件材料 | 切削速度 V_c (m/min) | 切深 a_p (mm) | 进给量 f (mm/rev) | 适用材质 | | | | |
|-----------------|-----------------------|------------------|---------------------|-------|-------|-------|-------|-------|
| | | | | DX110 | DX120 | DX140 | DX160 | DX180 |
| Al合金(Si12%以下) | 1500 (1000-2500) | 0.5 (0.05-2.0) | 0.1 (0.05-0.2) | ○ | ○ | ◎ | | |
| Al合金(Si12%以上) | 600 (400-800) | 0.5 (0.05-2.0) | 0.1 (0.05-0.2) | | | ○ | ◎ | |
| 铜•黄铜 | 800 (500-1500) | 0.5 (0.05-2.0) | 0.1 (0.05-0.2) | ○ | ○ | ◎ | | |
| 磷青铜 | 400 (300-500) | 0.5 (0.05-2.0) | 0.1 (0.05-0.2) | ○ | ○ | ◎ | | |
| 碳•石墨 | 400 (300-500) | 0.5 (0.05-2.0) | 0.1 (0.05-0.2) | | | ◎ | | |
| 纤维强化塑料 | 700 (500-1000) | 0.2 (0.05-0.5) | 0.05 (0.03-0.1) | ○ | ◎ | ○ | | |
| 塑料 | 700 (500-1000) | 0.2 (0.05-0.5) | 0.03 (0.01-0.05) | ○ | ◎ | ○ | | |
| 硬质合金(D40 ~ D60) | 15 (10-20) | 0.1 (0.05-0.2) | 0.03 (0.01-0.05) | | | | ○ | ◎ |
| 陶瓷(预烧结) | 130 (100-150) | 0.5 (0.05-2.0) | 0.05 (0.03-0.1) | | | | ○ | ◎ |

(注) ◎: 首要推荐 ○: 次要推荐






T-DIA TAC刀片

带负前角

| 规格 | 外观 | 型号 | 库 存 材 质 | | | 尺 寸(mm) | | | | | 适用刀体 |
|--------------|---|----------------|-----------------|-------|-------|---------|------|------|------------|------|------------------------|
| | | | 刀尖锋利性(好) 耐磨性(好) | | | 内切圆 | 厚度 | 孔径 | 刀尖圆 弧半径 | DIA长 | |
| | | | DX120 | DX140 | DX180 | | | | | | |
| 精切削 低切削抗力 |  | CNMM120402-DIA | ● | | | 12.7 | 4.76 | 5.16 | 0.2 | 3.5 | 外圆用TAC车刀 (4-14 ~) |
| | | CNMM120404-DIA | ● | | | 12.7 | 4.76 | 5.16 | 0.4 | 3.5 | 内孔用TAC车刀 (5-33 ~) |
| | | | | | | | | | | | 自动化切削工具系统 (12-47 ~) |
| |  | DNMM150402-DIA | ● | | | 12.7 | 4.76 | 5.16 | 0.2 | 3.3 | 外圆用TAC车刀 (4-21 ~) |
| | | DNMM150404-DIA | ● | | | 12.7 | 4.76 | 5.16 | 0.4 | 3.1 | |
| | | | | | | | | | | | 内孔用TAC车刀 (5-34 ~) |
| |  | TNMM160402-DIA | ● | | | 9.525 | 4.76 | 3.81 | 0.2 | 3.3 | 外圆用TAC车刀 (4-24 ~) |
| | | TNMM160404-DIA | ● | | | 9.525 | 4.76 | 3.81 | 0.4 | 3.2 | 内孔用TAC车刀 (5-36 ~) |
| | | | | | | | | | | | 自动化切削工具系统 (12-70 ~) |
| |  | VNMM160402-DIA | ● | | | 9.525 | 4.76 | 3.81 | 0.2 | 4.8 | 外圆用TAC车刀 (4-30 ~) |
| | | VNMM160404-DIA | ● | | | 9.525 | 4.76 | 3.81 | 0.4 | 4.4 | |
| | | VNMM160408-DIA | ● | | | 9.525 | 4.76 | 3.81 | 0.8 | 3.6 | 内孔用TAC车刀 (5-37 ~) |
| | | | | | | | | | | | |

3
超高压烧结体刀具





负前角刀片

| 规格 | 外观 | 型 号 | 库 存 材 质 | | | 尺 寸(mm) | | | | | 适用刀体 |
|---|---|----------------|-----------------|-------|-------|---------|------|------|------------|----------------------|------------------------|
| | | | 刀尖锋利性(好) 耐磨性(好) | | | 内切圆 | 厚度 | 孔径 | 刀尖圆 弧半径 | DIA长 | |
| | | | DX120 | DX140 | DX160 | | | | | | |
| 精 ~ 半精切削 |  | CNGA120404-DIA | | ● | | 12.7 | 4.76 | 5.16 | 0.4 | 3.5 | 外圆用TAC车刀 (4-14 ~) |
| | | CNGA120408-DIA | | | | 12.7 | 4.76 | 5.16 | 0.8 | 3.4 | 内孔用TAC车刀 (5-33 ~) |
| | | | | | | | | | | | 自动化切削工具系统 (12-47 ~) |
| | | | | | | | | | | | |
| |  | DNGA150404-DIA | | ● | ● | 12.7 | 4.76 | 5.16 | 0.4 | 3.1 | 外圆用TAC车刀 (4-21 ~) |
| | | DNGA150408-DIA | | ● | | 12.7 | 4.76 | 5.16 | 0.8 | 2.8 | 内孔用TAC车刀 (5-34 ~) |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| |  | TNGA160304-DIA | | | | 9.525 | 3.18 | 3.81 | 0.4 | 3.2 | 外圆用TAC车刀 (4-24 ~) |
| | | TNGA160308-DIA | | | | 9.525 | 3.18 | 3.81 | 0.8 | 2.9 | 内孔用TAC车刀 (5-36 ~) |
| | | TNGA160404-DIA | | ● | ● | 9.525 | 4.76 | 3.81 | 0.4 | 3.2 | 自动化切削工具系统 (12-70 ~) |
| | | TNGA160408-DIA | | ● | ● | 9.525 | 4.76 | 3.81 | 0.8 | 2.9 | |
| | | | | | | | | | | | |
| |  | SNGA120404-DIA | | ● | ▲ | 12.7 | 4.76 | 5.16 | 0.4 | 3.6 | 外圆用TAC车刀 (4-25 ~) |
| | | SNGA120408-DIA | | ● | ▲ | 12.7 | 4.76 | 5.16 | 0.8 | 3.6 | 内孔用TAC车刀 (5-35 ~) |
| | | | | | | | | | | | 自动化切削工具系统 (12-72 ~) |
| | | | | | | | | | | | |
|  | SNGN090308-DIA | | | | 9.525 | 3.18 | | 0.8 | 3.6 | 外圆用TAC车刀 (4-50 ~) | |
| | SNGN120408-DIA | | ● | | 12.7 | 4.76 | | 0.8 | 3.6 | | |
| | | | | | | | | | | | |






产品库存 ● : 库存型号
▲ : 计划停止生产的产品

T-DIA TAC刀片

带正前角

| 规格 | 外观 | 型 号 | 库 存 材 质 | | | 尺 寸(mm) | | | | | | 适用刀体 |
|--------------|---|----------------|-----------------|-------|-------|----------------|-----------------|-----------|------------------|------------------------|-------------|--|
| | | | 刀尖锋利性(好) 耐磨性(好) | | | 后角 θ | 内切圆 ϕd | 厚度 s | 孔径 ϕd_1 | 刀尖圆弧半径 r_ϵ | DIA长 a | |
| | | | DX120 | DX140 | DX160 | | | | | | | |
| 精切削 低切削抗力 |  | CCMT060202-DIA | ● | | | 7° | 6.35 | 2.38 | 2.8 | 0.2 | 2.4 | 外圆用TAC车刀 (4-63 ~) 内孔用TAC车刀 (5-12 ~) 自动化切削工具系统 (12-47 ~) |
| | | CCMT060204-DIA | ● | | | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.4 | |
| | | CCMT09T302-DIA | ● | | | 7° | 9.525 | 3.97 | 4.4 | 0.2 | 2.4 | |
| | | CCMT09T304-DIA | ● | | | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 2.4 | |
| |  | DCMT070202-DIA | ● | | | 7° | 6.35 | 2.38 | 2.8 | 0.2 | 2.3 | 外圆用TAC车刀 (4-63 ~) 内孔用TAC车刀 (5-16 ~) |
| | | DCMT070204-DIA | ● | | | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.1 | |
| | | DCMT11T302-DIA | ● | | | 7° | 9.525 | 3.97 | 4.4 | 0.2 | 3.2 | |
| | | DCMT11T304-DIA | ● | | | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 3.0 | |
| |  | TCMT080202-DIA | ● | | | 7° | 4.76 | 2.38 | 2.7 | 0.2 | 2.2 | 外圆用TAC车刀 (4-65) 内孔用TAC车刀 (5-19) 自动化切削工具系统 (12-47 ~) |
| | | TCMT080204-DIA | ● | | | 7° | 4.76 | 2.38 | 2.7 | 0.4 | 2.0 | |
| | | TCMT110202-DIA | ● | | | 7° | 6.35 | 2.38 | 2.8 | 0.2 | 2.4 | |
| | | TCMT110204-DIA | ● | | | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.2 | |
| | | TCMT110302-DIA | ● | | | 7° | 6.35 | 3.18 | 2.8 | 0.2 | 2.4 | |
| | | TCMT110304-DIA | ● | | | 7° | 6.35 | 3.18 | 2.8 | 0.4 | 2.2 | |
| |  | VCMT160402-DIA | ● | | | 7° | 9.525 | 4.76 | 4.4 | 0.2 | 4.8 | 外圆用TAC车刀 (4-65 ~) 内孔用TAC车刀 (5-24 ~) |
| | | VCMT160404-DIA | ● | | | 7° | 9.525 | 4.76 | 4.4 | 0.4 | 4.4 | |
| | | | | | | | | | | | | |






正前角刀片

| 规格 | 外观 | 型 号 | 库 存 材 质 | | | 尺 寸(mm) | | | | | | 适用刀体 |
|------------|---|----------------|-----------------|-------|-------|----------------|-----------------|-----------|------------------|------------------------|-------------|--|
| | | | 刀尖锋利性(好) 耐磨性(好) | | | 后角 θ | 内切圆 ϕd | 厚度 s | 孔径 ϕd_1 | 刀尖圆弧半径 r_ϵ | DIA长 a | |
| | | | DX120 | DX140 | DX160 | | | | | | | |
| 精~ 半精切削 |  | CCGW060200-DIA | | ● | | 7° | 6.35 | 2.38 | 2.8 | 0.03 | 2.4 | 外圆用TAC车刀 (4-63 ~) 内孔用TAC车刀 (5-12 ~) 自动化切削工具系统 (12-47 ~) |
| | | CCGW060202-DIA | | ● | | 7° | 6.35 | 2.38 | 2.8 | 0.2 | 2.4 | |
| | | CCGW060204-DIA | | ● | | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.4 | |
| | | CCGW09T302-DIA | | ● | | 7° | 9.525 | 3.97 | 4.4 | 0.2 | 3.5 | |
| | | CCGW09T304-DIA | | ● | ● | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 3.5 | |
| | | CCGW09T308-DIA | | ● | ▲ | 7° | 9.525 | 3.97 | 4.4 | 0.8 | 3.4 | |
| |  | DCGW070200-DIA | | ● | | 7° | 6.35 | 2.38 | 2.8 | 0.05 | 2.4 | 外圆用TAC车刀 (4-63 ~) 内孔用TAC车刀 (5-16 ~) |
| | | DCGW070202-DIA | ● | ● | | 7° | 6.35 | 2.38 | 2.8 | 0.2 | 2.3 | |
| | | DCGW070204-DIA | | ● | | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.1 | |
| | | DCGW11T302-DIA | | ● | | 7° | 9.525 | 3.97 | 4.4 | 0.2 | 3.2 | |
| | | DCGW11T304-DIA | | ● | | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 3.0 | |
| | | DCGW11T308-DIA | | ● | | 7° | 9.525 | 3.97 | 4.4 | 0.8 | 2.7 | |
| |  | SPGN090302-DIA | | | | 11° | 9.525 | 3.18 | — | 0.2 | 3.6 | 外圆用TAC车刀 (4-73) 内孔用TAC车刀 (5-61) 自动化切削工具系统 (12-72 ~) |
| | | SPGN090304-DIA | | | ▲ | 11° | 9.525 | 3.18 | — | 0.4 | 3.6 | |
| | | SPGN090308-DIA | | ● | | 11° | 9.525 | 3.18 | — | 0.8 | 3.6 | |
| | | SPGN120302-DIA | | ● | | 11° | 12.7 | 3.18 | — | 0.2 | 3.6 | |
| | | SPGN120304-DIA | | ● | ▲ | 11° | 12.7 | 3.18 | — | 0.4 | 3.6 | |
| | | SPGN120308-DIA | | ● | ● | 11° | 12.7 | 3.18 | — | 0.8 | 3.6 | |
| |  | SPGN120312-DIA | | | | 11° | 12.7 | 3.18 | — | 1.2 | 3.6 | 外圆用TAC车刀 (4-65) 内孔用TAC车刀 (5-19) 自动化切削工具系统 (12-47 ~) |
| | | TCGW110202-DIA | | | | 7° | 6.35 | 2.38 | 2.8 | 0.2 | 2.4 | |
| | | TCGW110204-DIA | | | | 7° | 6.35 | 2.38 | 2.8 | 0.4 | 2.2 | |
| | | TCGW16T302-DIA | | | | 7° | 9.525 | 3.97 | 4.4 | 0.2 | 3.3 | |
| | | TCGW16T304-DIA | | | | 7° | 9.525 | 3.97 | 4.4 | 0.4 | 3.2 | |
| |  | TCGW16T308-DIA | | | | 7° | 9.525 | 3.97 | 4.4 | 0.8 | 2.9 | 内孔用TAC车刀 (5-20 ~) 自动化切削工具系统 (12-63 ~) |
| | | TPGW080202-DIA | | ● | | 11° | 4.76 | 2.38 | 2.3 | 0.2 | 2.4 | |
| | | TPGW080204-DIA | | ● | | 11° | 4.76 | 2.38 | 2.3 | 0.4 | 2.3 | |
| | | TPGW090202-DIA | ● | ● | | 11° | 5.56 | 2.38 | 2.5 | 0.2 | 2.4 | |
| | | TPGW090204-DIA | | ● | | 11° | 5.56 | 2.38 | 2.5 | 0.4 | 2.2 | |
| | | TPGW110202-DIA | ● | ● | | 11° | 6.35 | 2.38 | 2.8 | 0.2 | 2.4 | |
| | | TPGW110204-DIA | | ● | | 11° | 6.35 | 2.38 | 2.8 | 0.4 | 2.2 | |
| | | TPGW130302-DIA | ● | ● | | 11° | 7.94 | 3.18 | 3.4 | 0.2 | 3.3 | |
| | | TPGW130304-DIA | | ● | | 11° | 7.94 | 3.18 | 3.4 | 0.4 | 3.2 | |
| | | TPGW16T302-DIA | | ● | | 11° | 9.525 | 3.97 | 4.4 | 0.2 | 3.3 | |
| | | TPGW16T304-DIA | | ● | | 11° | 9.525 | 3.97 | 4.4 | 0.4 | 3.2 | |
| | | TPGW16T308-DIA | | ● | | 11° | 9.525 | 3.97 | 4.4 | 0.8 | 2.9 | |

产品库存 ● : 库存型号
▲ : 计划停止生产的产品

T-DIA TAC刀片

正前角刀片

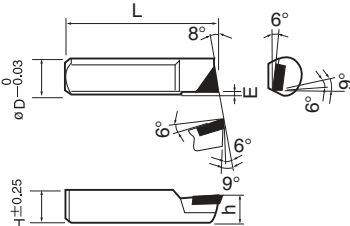
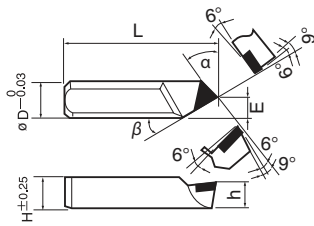
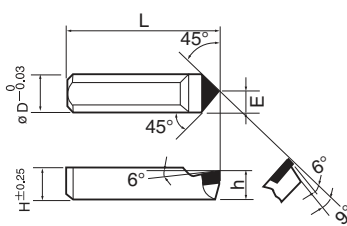
| 规格 | 外观 | 型 号 | 库 存 材 质 | | | 尺 寸(mm) | | | | | | 适用刀体 |
|----------------|---|----------------|-----------------|-------|-------|----------------|-----------------|-----------|------------------|------------------------|-------------|--|
| | | | 刀尖锋利性(好) 耐磨性(好) | | | 后角 θ | 内切圆 ϕd | 厚度 s | 孔径 ϕd_1 | 刀尖圆弧半径 r_ϵ | DIA长 a | |
| | | | DX120 | DX140 | DX160 | | | | | | | |
| 精~ 半精切削 |  | TPGN090204-DIA | | ● | | 11° | 5.56 | 2.38 | — | 0.4 | 2.2 | 内孔用TAC车刀 (5-20 ~) 自动化切削工具系统 (12-63 ~) |
| | | TPGN090208-DIA | | | | 11° | 5.56 | 2.38 | — | 0.8 | 2.0 | |
| | | TPGN110301-DIA | | | | 11° | 6.35 | 3.18 | — | 0.1 | 3.4 | |
| | | TPGN110302-DIA | | | | 11° | 6.35 | 3.18 | — | 0.2 | 3.3 | |
| | | TPGN110304-DIA | ● | ● | | 11° | 6.35 | 3.18 | — | 0.4 | 3.2 | |
| | | TPGN110308-DIA | | ● | | 11° | 6.35 | 3.18 | — | 0.8 | 2.9 | |
| | | TPGN160301-DIA | | | | 11° | 9.525 | 3.18 | — | 0.1 | 3.4 | |
| | | TPGN160302-DIA | | ● | | 11° | 9.525 | 3.18 | — | 0.2 | 3.3 | |
| | | TPGN160304-DIA | ● | ● | ▲ | 11° | 9.525 | 3.18 | — | 0.4 | 3.2 | |
| | | TPGN160308-DIA | | ● | | 11° | 9.525 | 3.18 | — | 0.8 | 2.9 | |
| | | TPGN160312-DIA | | | | 11° | 9.525 | 3.18 | — | 1.2 | 2.6 | |
| |  | VCGW160402-DIA | | ● | | 7° | 9.525 | 4.76 | 4.4 | 0.2 | 4.8 | 外圆用TAC车刀 (4-65 ~) 内孔用TAC车刀 (5-24 ~) |
| | | VCGW160404-DIA | | ● | | 7° | 9.525 | 4.76 | 4.4 | 0.4 | 4.4 | |
| | | VCGW160408-DIA | | | | 7° | 9.525 | 4.76 | 4.4 | 0.8 | 3.6 | |
| | | VCGW160412-DIA | | | | 7° | 9.525 | 4.76 | 4.4 | 1.2 | 2.7 | |
| | | VCGW220530-DIA | | | | 7° | 12.7 | 5.56 | 5.5 | 3.0 | 5.0 | |
| 精切削 |  | EPGW040102-DIA | | ● | | 11° | 3.97 | 1.59 | 2.3 | 0.2 | 2.0 | 内孔用TAC车刀 (5-28 ~) 自动化切削工具系统 (12-63 ~) |
| | | EPGW040104-DIA | | ● | | 11° | 3.97 | 1.59 | 2.3 | 0.4 | 1.9 | |
| | | | | | | | | | | | | |
| 精~ 半精切削 |  | CPGA090202-DIA | | ● | | 11° | 9.525 | 2.38 | 4.0 | 0.2 | 2.4 | 泰珂洛旧式规格 (非ISO标准) |
| | | CPGA090204-DIA | | ● | | 11° | 9.525 | 2.38 | 4.0 | 0.4 | 2.4 | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| |  | TPGA090202-DIA | | ● | | 11° | 5.556 | 2.38 | 3.2 | 0.2 | 2.4 | 泰珂洛旧式规格 (非ISO标准) |
| | | TPGA090204-DIA | | ● | | 11° | 5.556 | 2.38 | 3.2 | 0.4 | 2.2 | |
| | | TPGA110202-DIA | | ● | | 11° | 6.35 | 3.18 | 3.0 | 0.2 | 2.4 | |
| | | TPGA110204-DIA | | ● | | 11° | 6.35 | 3.18 | 3.0 | 0.4 | 2.2 | |
| | | TPGA110302-DIA | | ● | | 11° | 6.35 | 3.18 | 3.0 | 0.2 | 2.4 | |
| | | TPGA110304-DIA | | ● | | 11° | 6.35 | 3.18 | 3.0 | 0.4 | 2.2 | |
| | | TPGA110308-DIA | | ● | | 11° | 6.35 | 3.18 | 3.0 | 0.8 | 2.0 | |
| | | TPGA160302-DIA | | ● | | 11° | 9.525 | 3.18 | 4.0 | 0.2 | 3.3 | |
| | | TPGA160304-DIA | | ● | | 11° | 9.525 | 3.18 | 4.0 | 0.4 | 3.2 | |
| TPGA160308-DIA | | ● | | 11° | 9.525 | 3.18 | 4.0 | 0.8 | 2.9 | | | |

产品库存 ●：库存型号
▲：计划停止生产的产品

T-DIA镗刀[圆刀杆]

3

超高压烧结体刀具

| 形 状 | 型 号 | 库 存 | 尺 寸(mm) | | | | | | | | | | | | | | | | |
|---|---|---------|---------|----------|-----|-----|----------|-----|-----|----------|-----|-----|---------|--|---|---|-----|----|---|
| | | | øD | h | H | L | E | | | | | | | | | | | | |
|  | DBR-104 | | 4 | 3 | 3.5 | 16 | 0.2 | | | | | | | | | | | | |
| | DBR-105 | | 5 | 3.5 | 4 | 20 | | | | | | | | | | | | | |
| | DBR-106 | | 6 | 4 | 5 | 25 | | | | | | | | | | | | | |
| | DBR-108 | | 8 | 6 | 7 | 35 | 0.5 | | | | | | | | | | | | |
| | DBR-110 | | 10 | 7 | 9 | 50 | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | |
|  <table data-bbox="151 896 529 1046"><tr><th>型 号</th><th>α</th><th>β</th></tr><tr><td>BS-200系列</td><td>15°</td><td>15°</td></tr><tr><td>BS-300系列</td><td>38°</td><td>30°</td></tr><tr><td>BS-400系列</td><td>53°</td><td>45°</td></tr></table> | 型 号 | α | β | BS-200系列 | 15° | 15° | BS-300系列 | 38° | 30° | BS-400系列 | 53° | 45° | DBR-204 | | 4 | 3 | 3.5 | 16 | 1 |
| | 型 号 | α | β | | | | | | | | | | | | | | | | |
| | BS-200系列 | 15° | 15° | | | | | | | | | | | | | | | | |
| | BS-300系列 | 38° | 30° | | | | | | | | | | | | | | | | |
| | BS-400系列 | 53° | 45° | | | | | | | | | | | | | | | | |
| | DBR-205 | | 5 | 3.5 | 4 | 20 | 1.5 | | | | | | | | | | | | |
| | DBR-206 | | 6 | 4 | 5 | 25 | | | | | | | | | | | | | |
| | DBR-208 | | 8 | 6 | 7 | 35 | 2 | | | | | | | | | | | | |
| | DBR-210 | | 10 | 7 | 9 | 50 | 3 | | | | | | | | | | | | |
| | DBR-304 | | 4 | 3 | 3.5 | 16 | 2 | | | | | | | | | | | | |
| | DBR-305 | | 5 | 3.5 | 4 | 20 | 2.5 | | | | | | | | | | | | |
| | DBR-306 | | 6 | 4 | 5 | 25 | 3 | | | | | | | | | | | | |
| | DBR-308 | | 8 | 6 | 7 | 35 | 4 | | | | | | | | | | | | |
| | DBR-310 | | 10 | 7 | 9 | 50 | 5 | | | | | | | | | | | | |
| | DBR-404 | | 4 | 3 | 3.5 | 16 | 2.5 | | | | | | | | | | | | |
| | DBR-405 | | 5 | 3.5 | 4 | 20 | 3 | | | | | | | | | | | | |
| | DBR-406 | | 6 | 4 | 5 | 25 | 4 | | | | | | | | | | | | |
| | DBR-408 | | 8 | 6 | 7 | 35 | 5 | | | | | | | | | | | | |
| | DBR-410 | | 10 | 7 | 9 | 50 | 6 | | | | | | | | | | | | |
| |  | DBR-504 | | 4 | 3 | 3.5 | 16 | 2 | | | | | | | | | | | |
| DBR-505 | | | 5 | 3.5 | 4 | 20 | 2.5 | | | | | | | | | | | | |
| DBR-506 | | | 6 | 4 | 5 | 25 | 3 | | | | | | | | | | | | |
| DBR-508 | | | 8 | 6 | 7 | 35 | 4 | | | | | | | | | | | | |
| DBR-510 | | | 10 | 7 | 9 | 50 | 5 | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | |

(注) øD = 4 ~ 5 … 硬质合金刀杆 øD = 6 ~ 10 … 钢刀杆

T-DIA立铣刀

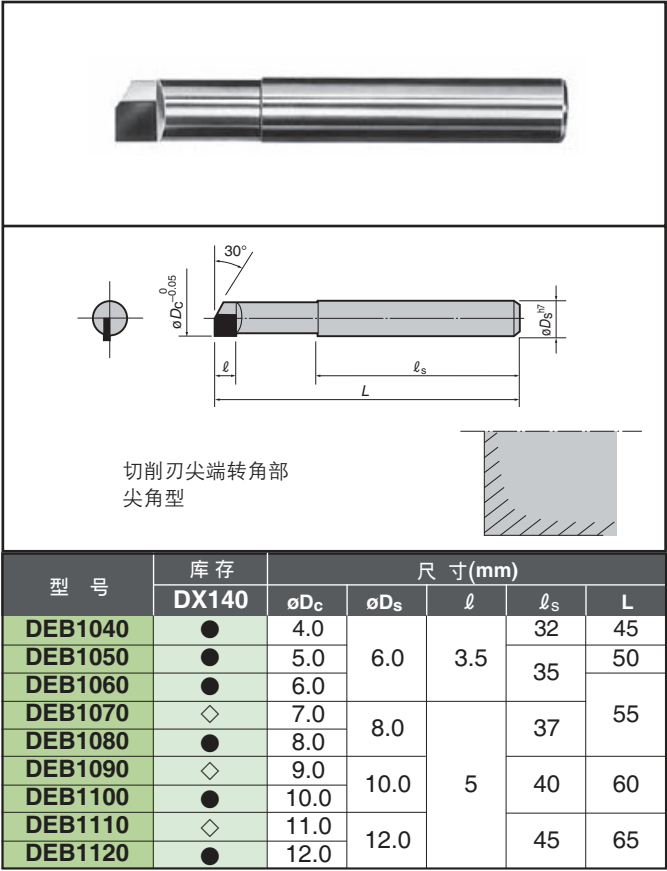
DEB1000

N
非铁金属

1
刀齿数

0°
螺旋角

铝用高速铣削(带金刚石烧结体)



■ 使用注意事项

- 刀尖非常锋利, 请小心使用。(使用千分尺等进行直接测量会产生崩刃, 请勿采用此类测量方法。)
- 立铣刀悬伸出铣削夹具的长度要尽可能地减短。
- 所使用的机床要尽可能选择高刚性机床。

3

超高压烧结体刀具

■ T-DIA立铣刀的标准切削条件

DEB1000

侧面铣削 $a_p = 3\text{ mm}$ 以下 $a_e = 0.1\text{ mm}$

| | | |
|-------------|---------------------------------|----------------------------|
| 工件材料 | 铝合金•铜合金 | |
| 切削速度(m/min) | 120 ~ 180 | |
| 条件 | 转数 $n\text{ (min}^{-1}\text{)}$ | 进给速度 $V_f\text{ (mm/min)}$ |
| 刃部直径(mm) | | |
| $\phi 4$ | 12,000 | 120 |
| $\phi 5$ | 9,600 | |
| $\phi 6$ | 8,000 | |
| $\phi 8$ | 6,000 | |
| $\phi 10$ | 4,800 | |
| $\phi 12$ | 4,000 | 100 |

※请将刀具悬伸量长度设置为所需最小限度。悬伸量长时容易产生振动, 请在使用时降低转数和进给量。

※所使用的机床要尽可能选择高刚性机床。

※根据切深量、机床刚性等使用的情况, 合理调整转数和进给速度。

产品库存 ◇: 专卖店
●: 库存产品