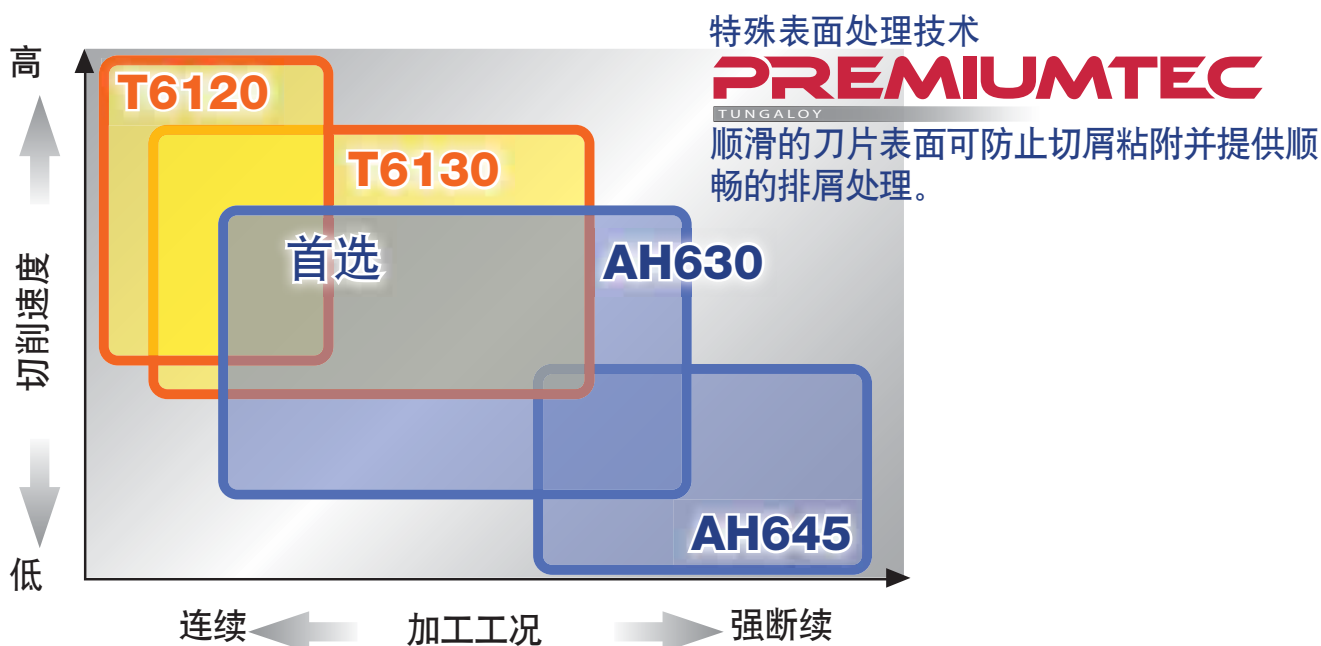


TURNLINE 不锈钢切削系列**T6100 SERIES** CVD 涂层材质**AH600 SERIES** PVD 涂层材质**PREMIUMTEC**
TUNGALOY**不锈钢车削加工的最理想材质**

超高可靠性的不锈钢切削!

■ T6100 & AH600 的应用范围



T6100 SERIES

TUNGALOY

新型 CVD 涂层材质



柱状结构稳定技术

卓越的抗崩刃性可延长刀具寿命。

附着强度更高的独特基体

高附着强度显著提高了抗剥落和抗崩刃性能。

T6120

- 适用高速切削。
- 具有出色的塑性变形抗力。
- 特别适用奥氏体和沉淀硬化的不锈钢加工。

T6130

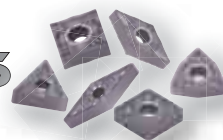
- 具有适用中高速加工的卓越耐磨性。
- 尤其适用铁素体和马氏体不锈钢加工的理想材质。
- 比 PVD 更厚的涂层带来卓越的耐磨性。

荣获 JCTMA 2012 年度技术大奖

AH600 SERIES

TUNGALOY

新型 PVD 涂层材质



卓越的耐磨性和抗崩刃性

该创新涂层可降低开裂，同时保持了较高的耐磨性，增强了抗崩刃性能。

极高的可靠性!

新开发的基体可超牢靠地附着至涂层。

AH630

- 完美平衡抗崩刃性和耐磨性，推荐用于一般加工。
- 卓越的附着强度，实现更高的抗崩刃性能

AH645

- 适用中低速切削的出色抗崩刃性
- 适用于断续和强断续不锈钢加工的材质



M 不锈钢

不锈钢

负前角型

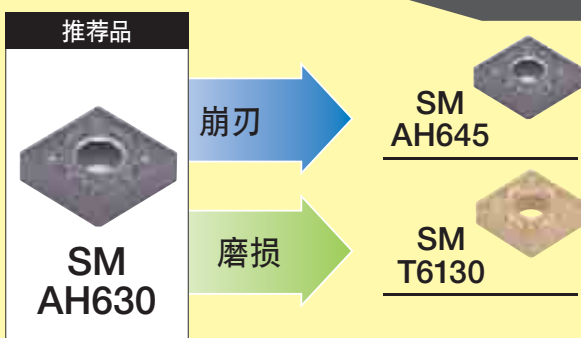
精切削

连续到弱断续



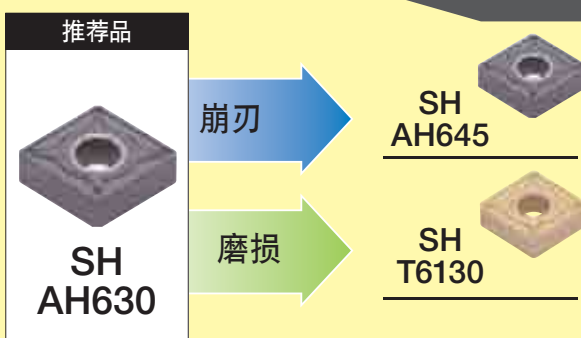
半精切削

连续到弱断续



中到重切削

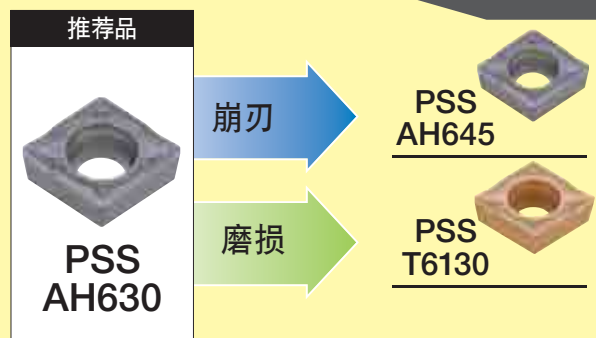
连续到弱断续



正前角型

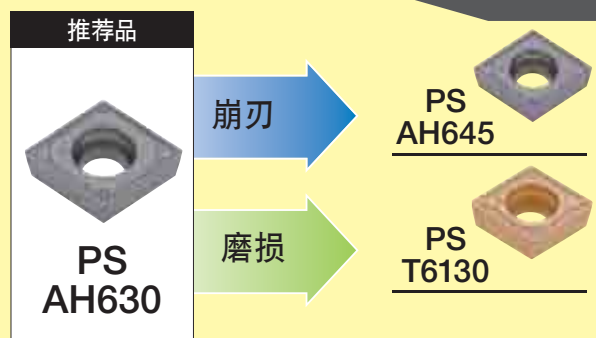
精切削

断续切削



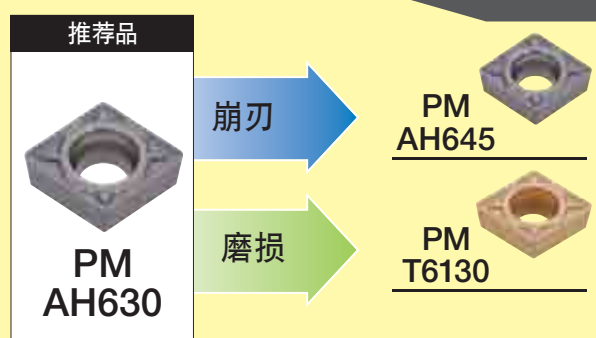
半精切削

连续到弱断续



中到重切削

连续到弱断续

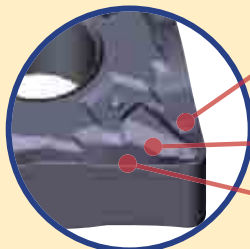


断屑槽

负前角型

用于精加工

SF 类型



- 适用精切削加工的卓越排屑性能
- 适用大进给量小切深加工的卓越排屑性能。
- 锋利刃可降低切削抗力并避免出现毛刺

低切削抗力

→ 大前角

减少切屑附着

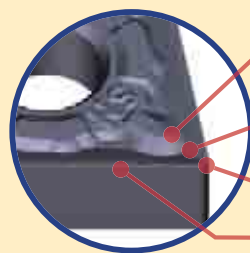
→ 沿突出结构回旋，避免接触切屑

卓越的排屑性能

→ 大倾角

用于半精加工

SM 类型



- 适用多种切削条件的多功能断屑槽。
- 切刃锋利，排屑性能出色。

出色排屑性能

→ 优良设计的突出结构，可顺畅卷集切屑

低切削抗力

→ 得益于大前角和深断屑槽

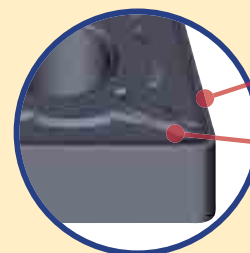
超高锋利度和抗崩性的切削刃，加工性能可靠

→ 锋利的刀尖正接触刃

→ 主切削刃接触面宽，韧性更好

用于中到重切削

SH 类型



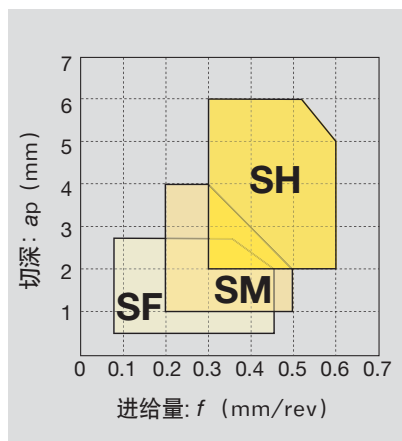
- 适用粗加工和断续加工的坚韧切削刃
- 适用多种切削条件，是切深有变化加工的理想之选
- 新设计的切削刃提高了抗崩刃性

极高的抗冲击性能

→ 源自先进的切削刃

低切削抗力和卓越的排屑性能

→ 得益于独特的断屑槽形状



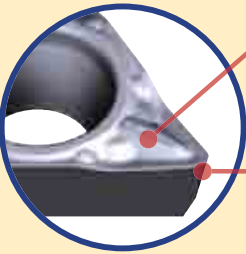
适用范围	加工工况	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)
精切削	连续	SF	T6120	0.5 ~ 2.5	0.08 ~ 0.45
	连续到弱断续		T6130		
	强断续		AH630		
半精切削	连续	SM	T6120	1.0 ~ 4.0	0.2 ~ 0.5
	连续到弱断续		T6130		
	弱断续		AH630		
	强断续		AH645		
中到重切削	连续	SH	T6130	2.0 ~ 6.0	0.3 ~ 0.6
	连续到弱断续		AH630		
	强断续		AH645		

注：上表条件适用常规尺寸刀片。

正前角型

精切削至轻型切削

PSS 类型



- 用于不锈钢精切削的最佳断屑槽
- 可在小切深加工时提供卓越的排屑性能

出色的排屑能力

➔ 拱形突出结构，即便是小切深加工时也可稳定排屑

切削抗力低，加工性能可靠

➔ 优化的倾角和前角可降低精切削加工时的切削抗力并提高排屑性能

精 ~ 半精切削

PS 类型



- 推荐用于不锈钢精 ~ 半精切削的断屑槽

切削抗力低，可靠性能高

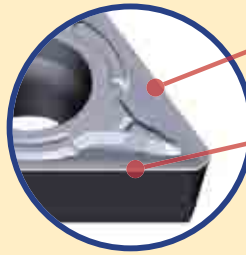
➔ 最佳前角和坚韧切削刃的理想组合

适用多种切削条件的可靠排屑性能

➔ 独特设计的突出结构，有助于顺畅排屑

重切削

PM 类型



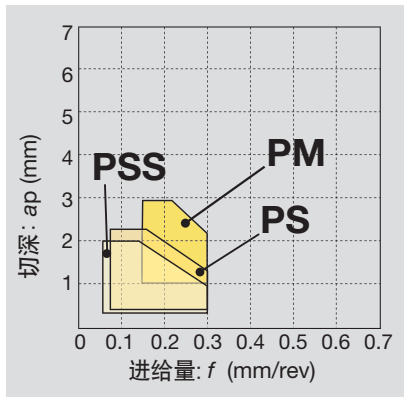
- 锋利且坚韧的切削刃，加工不锈钢时具有很高的可靠性

排屑性能出色，切削抗力低

➔ 具有最佳前角的锋利切削刃

避免咬屑和边界磨损

➔ 沿切削刃的灵活接触宽度可防止咬屑



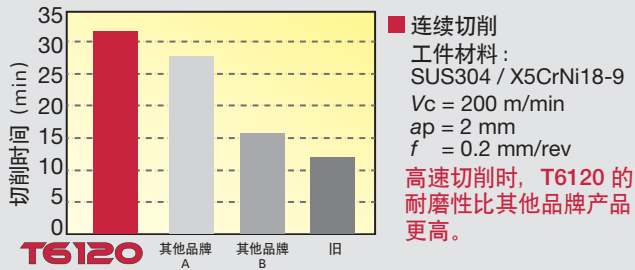
适用范围	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)
精切削至轻型切削	PSS	T6120	0.3 ~ 2.0	0.08 ~ 0.3
		T6130		
		AH630		
		AH645		
精 ~ 半精切削	PS	T6120	0.5 ~ 2.5	0.08 ~ 0.3
		T6130		
		AH630		
		AH645		
重切削	PM	T6120	1.0 ~ 3.0	0.15 ~ 0.3
		T6130		
		AH630		
		AH645		

注：上表条件适用常规尺寸刀片。

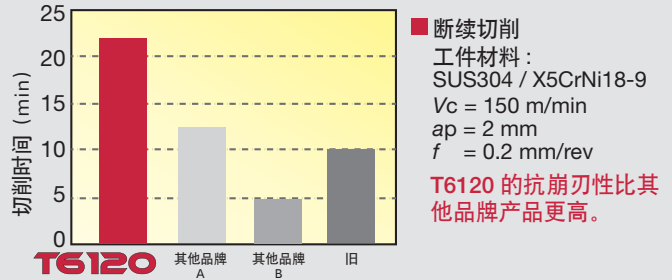
切削性能

T6120

耐磨性测试

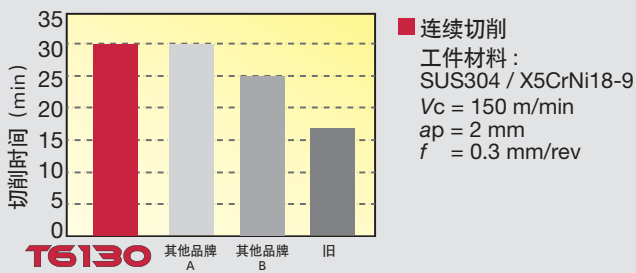


抗崩性测试

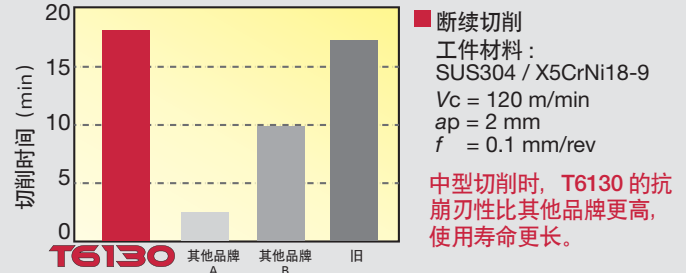


T6130

耐磨性测试

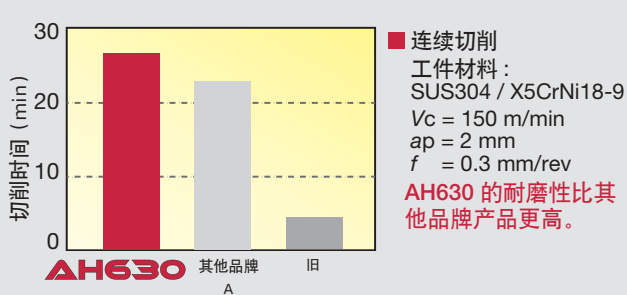


抗崩性测试

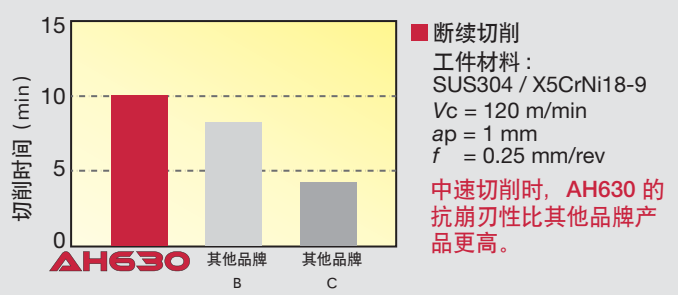


AH630

耐磨性测试

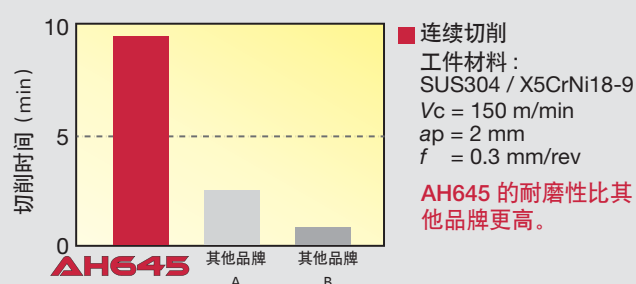


抗崩性测试

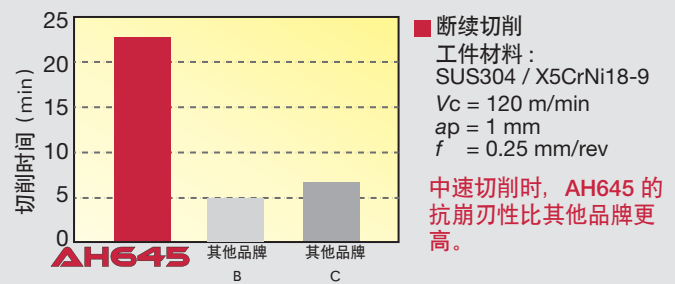


AH645

耐磨性测试



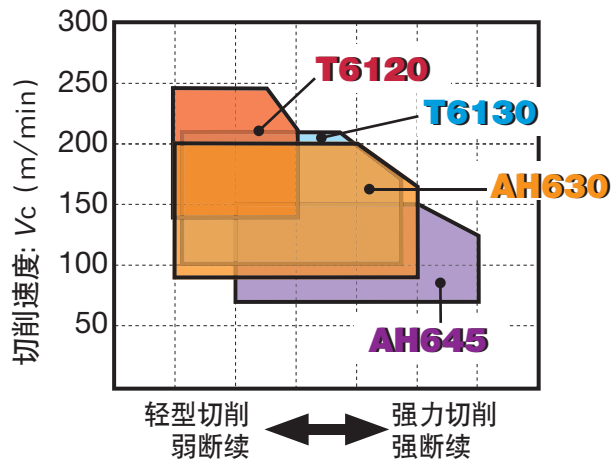
抗崩性测试



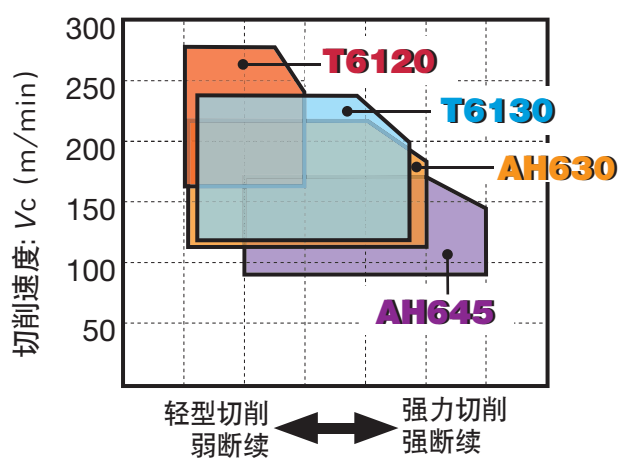
标准切削条件

标准切削条件因被加工材料而异

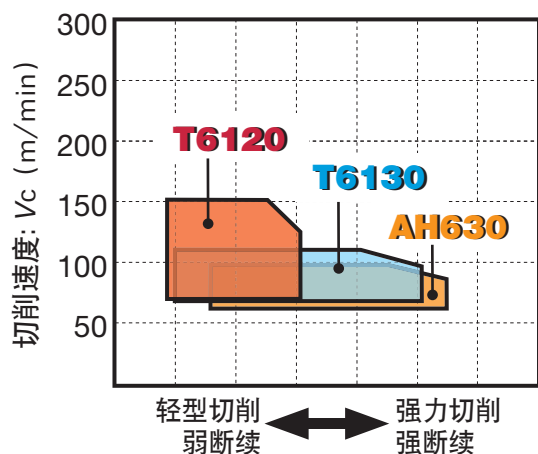
奥氏体不锈钢



铁素体 / 马氏体不锈钢



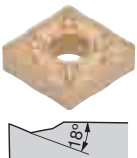
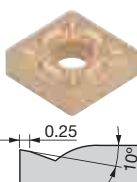
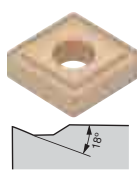
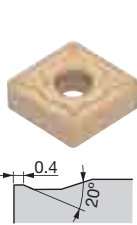
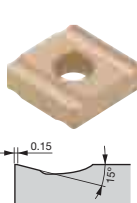
沉淀硬化不锈钢



工件材料	材质	切削速度: V_c (m/min)
奥氏体 SUS304, SUS316 等 (X5CrNi18-9, X5CrNiMo17-12-2 等) *AH630: 首选	T6120	140 - 240
	T6130	100 - 200
	AH630	90 - 190
	AH645	70 - 150
铁素体 / 马氏体 SUS430 / SUS410 等 (X6Cr17, X12Cr13 等)	T6120	160 - 280
	T6130	120 - 240
	AH630	110 - 210
	AH645	90 - 170
沉淀硬化 SUS631 等 (X7CrNiAl17-7 等)	T6120	80 - 150
	T6130	70 - 110
	AH630	60 - 90

刀片 负前角型

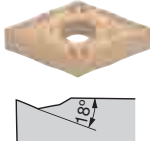
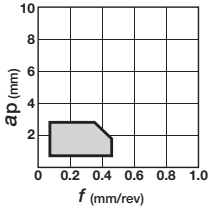
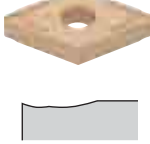
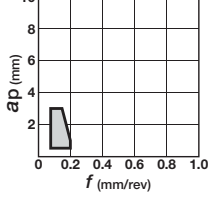
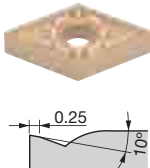
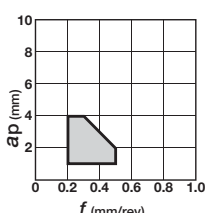
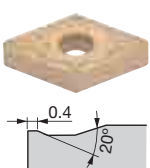
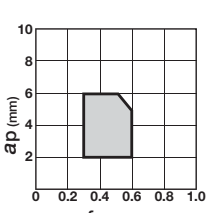
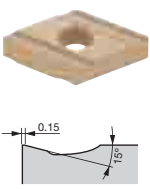
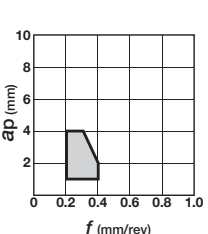
菱形, 80°

应用	断屑槽 外观 (截面图)	$f - a_p$	型号	库存材质				尺寸 (mm)			
				涂层				I.C. 直径 ϕd	厚度 s	孔径 ϕd_1	刀尖半径 r_ϵ
				T6120	T6130	AH630	AH645				
精切削	SF		CNMG090304-SF	●	●	●		9.525	3.18	3.81	0.4
			CNMG090308-SF	●	●	●					0.8
			CNMG120404-SF	●	●	●		12.7	4.76	5.16	0.4
			*CNMG120408-SF	●	●	●					0.8
			CNMG120412-SF	●	●	●					1.2
	SS		CNMG120404-SS	●	●	●	●	12.7	4.76	5.16	0.4
			*CNMG120408-SS	●	●	●	●				0.8
			CNMG120412-SS	●	●	●	●				1.2
半精切削	SM		CNMG120404-SM	●	●	●	●	12.7	4.76	5.16	0.4
			*CNMG120408-SM	●	●	●	●				0.8
			CNMG120412-SM	●	●	●	●				1.2
	SA		CNMG120404-SA	●	●	●	●	12.7	4.76	5.16	0.4
			*CNMG120408-SA	●	●	●	●				0.8
			CNMG120412-SA	●	●	●	●				1.2
中到重切削	SH		CNMG120408-SH		●	●	●	12.7	4.76	5.16	0.8
			CNMG120412-SH		●	●	●				1.2
			CNMG120416-SH		●	●	●				1.6
			*CNMG160612-SH		●	●	●	15.875	6.35	6.35	1.2
			CNMG160616-SH		●	●	●				1.6
			CNMG190612-SH		●	●	●	19.05	6.35	7.93	1.2
			CNMG190616-SH		●	●	●				1.6
	S		CNMG120404R-S		●	●	●	12.7	4.76	5.16	0.4
			CNMG120404L-S		●	●	●				0.4
			*CNMG120408R-S		●	●	●				0.8
			CNMG120408L-S		●	●	●				0.8

* 注: 断屑槽截面图为 * 号标记刀片的图。

●: 库存型号

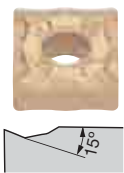
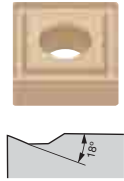
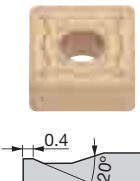
菱形, 55°

应用	断屑槽 外观 (截面图)	$f - ap$	型号	库存材质				尺寸 (mm)			
				涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精切削	SF 		DNMG150404-SF	●	●	●		12.7	4.76	5.16	0.4
			* DNMG150408-SF	●	●	●					0.8
			DNMG150604-SF	●	●	●		12.7	6.35	5.16	0.4
			DNMG150608-SF	●	●	●					0.8
	SS 		DNMG150404-SS	●	●	●	●	12.7	4.76	5.16	0.4
			DNMG150408-SS	●	●	●	●				0.8
			* DNMG150412-SS	●	●	●	●	12.7	6.35	5.16	1.2
			DNMG150604-SS	●	●	●	●				0.4
			DNMG150608-SS	●	●	●	●				0.8
			DNMG150612-SS	●	●	●	●				1.2
半精切削	SM 		DNMG150404-SM	●	●	●	●	12.7	4.76	5.16	0.4
			* DNMG150408-SM	●	●	●	●				0.8
			DNMG150412-SM	●	●	●	●	12.7	6.35	5.16	1.2
			DNMG150604-SM	●	●	●	●				0.4
			DNMG150608-SM	●	●	●	●				0.8
			DNMG150612-SM	●	●	●	●				1.2
中到重切削	SH 		DNMG150408-SH		●	●	●	12.7	4.76	5.16	0.8
			* DNMG150412-SH		●	●	●				1.2
			DNMG150416-SH		●	●	●	12.7	6.35	5.16	1.6
			DNMG150608-SH		●	●	●				0.8
			DNMG150612-SH		●	●	●				1.2
	S 		DNMG150404R-S		●	●	●	12.7	4.76	5.16	0.4
			DNMG150404L-S		●	●	●				0.4
			* DNMG150408R-S		●	●	●	12.7	6.35	5.16	0.8
			DNMG150408L-S		●	●	●				0.8
			DNMG150604R-S		●	●	●				0.4
			DNMG150604L-S		●	●	●				0.4
			DNMG150608R-S		●	●	●				0.8
			DNMG150608L-S		●	●	●				0.8

* 注: 断屑槽截面图为 * 号标记刀具的图。

●: 库存型号

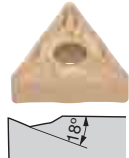
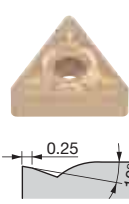
方形, 90°

应用	断屑槽 外观 (截面图)	$f - a_p$	型号	库存材质				尺寸 (mm)			
				涂层				I.C. 直径 ϕd	厚度 s	孔径 ϕd_1	刀尖半径 r_ϵ
				T6120	T6130	AH630	AH645				
精切削	SF		SNMG120404-SF	●	●	●		12.7	4.76	5.16	0.4
			* SNMG120408-SF	●	●	●					0.8
	SS		SNMG120404-SS	●	●	●	●	12.7	4.76	5.16	0.4
			* SNMG120408-SS	●	●	●	●				0.8
			SNMG120412-SS	●	●	●	●				1.2
半精切削	SM		* SNMG120408-SM	●	●	●	●	12.7	4.76	5.16	0.8
			SNMG120412-SM	●	●	●	●				1.2
	SA		* SNMG120404-SA	●	●	●	●	12.7	4.76	5.16	0.4
			SNMG120408-SA	●	●	●	●				0.8
			SNMG120412-SA	●	●	●	●				1.2
中到重切削	SH		SNMG120408-SH		●	●	●	12.7	4.76	5.16	0.8
			SNMG120412-SH		●	●	●				1.2
			* SNMG150612-SH		●	●	●	15.875	6.35	6.35	1.2
			SNMG150616-SH		●	●	●				1.6
			SNMG190612-SH		●	●	●	19.05	6.35	7.93	1.2
			SNMG190616-SH		●	●	●				1.6
	S		SNMG120404R-S		●	●	●	12.7	4.76	5.16	0.4
			SNMG120404L-S		●	●	●				0.4
			* SNMG120408R-S		●	●	●				0.8
			SNMG120408L-S		●	●	●				0.8

* 注: 断屑槽截面图为 * 号标记刀具的图。

●: 库存型号

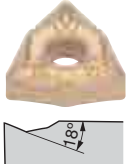
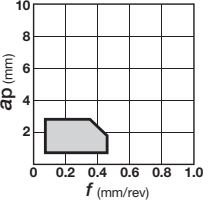
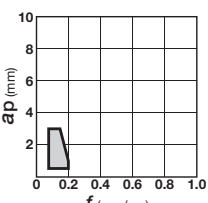
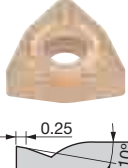
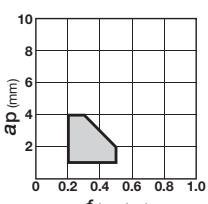
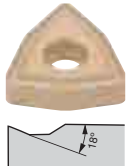
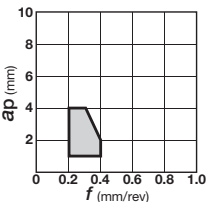
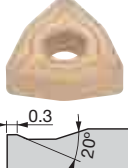
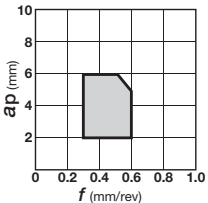
三角形, 60°

应用	断屑槽	$f - ap$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ød	厚度 s	孔径 ød1	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精切削	SF		TNMG160404-SF	●	●	●		9.525	4.76	3.81	0.4
		* TNMG160408-SF	●	●	●		0.8				
		TNMG160412-SF	●	●	●		1.2				
	SS		TNMG160404-SS	●	●	●	●	9.525	4.76	3.81	0.4
		TNMG160408-SS	●	●	●	●	0.8				
		TNMG160412-SS	●	●	●	●	1.2				
		* TNMG220404-SS	●	●	●	●	12.7	4.76	5.16	0.4	
		TNMG220408-SS	●	●	●	●				0.8	
		TNMG220412-SS	●	●	●	●				1.2	
半精切削	SM		TNMG160404-SM	●	●	●	●	9.525	4.76	3.81	0.4
		* TNMG160408-SM	●	●	●	●	0.8				
		TNMG160412-SM	●	●	●	●	1.2				
		TNMG220408-SM	●	●	●	●	12.7	5.16		0.8	
		TNMG220412-SM	●	●	●	●				1.2	
	SA		TNMG160404-SA	●	●	●	●	9.525	4.76	3.81	0.4
		* TNMG160408-SA	●	●	●	●	0.8				
		TNMG160412-SA	●	●	●	●	1.2				
		TNMG220408-SA	●	●	●	●	12.7	5.16		0.8	
		TNMG220412-SA	●	●	●	●				1.2	
	S		TNMG160404R-S		●	●	●	9.525	4.76	3.81	0.4
		TNMG160404L-S		●	●	●	0.4				
		* TNMG160408R-S		●	●	●	0.8				
		TNMG160408L-S		●	●	●	0.8				
		TNMG220404R-S		●	●	●	12.7	4.76	5.16	0.4	
		TNMG220404L-S		●	●	●				0.4	
		TNMG220408R-S		●	●	●				0.8	
		TNMG220408L-S		●	●	●				0.8	

* 注: 断屑槽截面图为 * 号标记刀具的图。

●: 库存型号

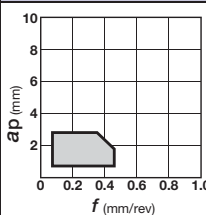
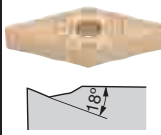
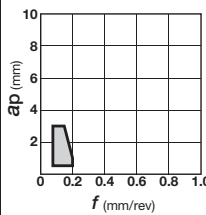
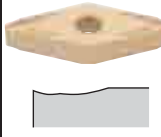
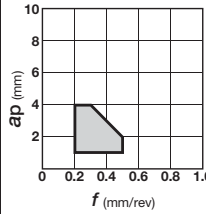
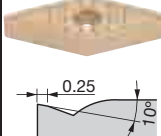
六边形, 80°

应用	断屑槽 外观 (截面图)	$f - ap$	型号	库存材质				尺寸 (mm)			
				涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精切削	SF 		WNMG060404-SF	●	●	●		9.525	4.76	3.81	0.4
			WNMG060408-SF	●	●	●					0.8
			WNMG080404-SF	●	●	●		12.7	4.76	5.16	0.4
			*WNMG080408-SF	●	●	●					0.8
半精切削	SS 		WNMG080404-SS	●	●	●	●	12.7	4.76	5.16	0.4
			*WNMG080408-SS	●	●	●	●				0.8
			WNMG080412-SS	●	●	●	●				1.2
	SM 		WNMG080404-SM	●	●	●	●	12.7	4.76	5.16	0.4
			*WNMG080408-SM	●	●	●	●				0.8
			WNMG080412-SM	●	●	●	●				1.2
中到重切削	SA 		*WNMG080408-SA	●	●	●	●	12.7	4.76	5.16	0.8
			WNMG080412-SA	●	●	●	●				1.2
	SH 		WNMG080408-SH		●	●	●	12.7	4.76	5.16	0.8
			*WNMG080412-SH		●	●	●				1.2

* 注: 断屑槽截面图为 * 号标记刀具的图。

●: 库存型号

菱形, 35°

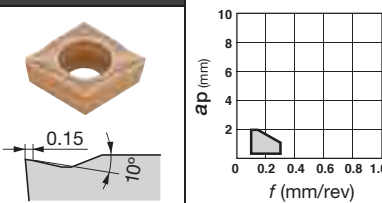
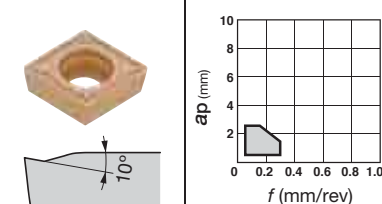
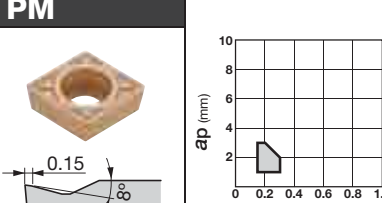
应用	断屑槽	$f - a_p$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精切削	SF		VNMG160404-SF	●	●	●		9.525	4.76	3.81	0.4
		* VNMG160408-SF	●	●	●		0.8				
	SS		* VNMG160404-SS	●	●	●	●	9.525	4.76	3.81	0.4
		VNMG160408-SS	●	●	●	●	0.8				
		VNMG160412-SS	●	●	●	●	1.2				
负前角型	SM		VNMG160404-SM	●	●	●	●	9.525	4.76	3.81	0.4
		* VNMG160408-SM	●	●	●	●	0.8				
		VNMG160412-SM	●	●	●	●	1.2				

* 注：断屑槽截面图为 * 号标记刀具的图。

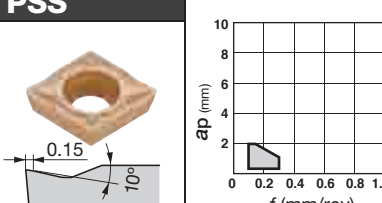
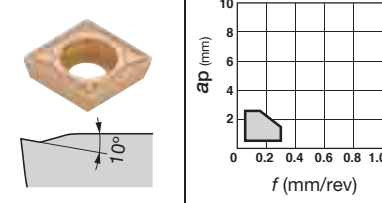
●：库存型号

刀片 正前角型

菱形, 80° (7°)

应用	断屑槽	f - ap	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ød	厚度 s	孔径 ød1	刀尖 半径 rε
				T6120	T6130	AH630	AH645				
精切削至 轻型切削	PSS		CCMT060204-PSS	●	●	●	●	6.35	2.38	2.8	0.4
			CCMT060208-PSS	●	●	●	●				0.8
			*CCMT09T304-PSS	●	●	●	●	9.525	3.97	4.4	0.4
			CCMT09T308-PSS	●	●	●	●				0.8
			CCMT120404-PSS	●	●	●	●	12.7	4.76	5.5	0.4
			CCMT120408-PSS	●	●	●	●				0.8
			CCMT120412-PSS	●	●	●	●				1.2
精 ~ 半精 切削	PS		CCMT060202-PS	●	●	●	●	6.35	2.38	2.8	0.2
			CCMT060204-PS	●	●	●	●				0.4
			*CCMT060208-PS	●	●	●	●	9.525	3.97	4.4	0.8
			CCMT09T302-PS	●	●	●	●				0.2
			CCMT09T304-PS	●	●	●	●	12.7	4.76	5.5	0.4
			CCMT09T308-PS	●	●	●	●				0.8
			CCMT120404-PS	●	●	●	●				0.4
			CCMT120408-PS	●	●	●	●				0.8
中型切削	PM		CCMT060204-PM	●	●	●	●	6.35	2.38	2.8	0.4
			CCMT060208-PM	●	●	●	●				0.8
			CCMT09T304-PM	●	●	●	●	9.525	3.97	4.4	0.4
			*CCMT09T308-PM	●	●	●	●				0.8
			CCMT09T312-PM	●	●	●	●	12.7	4.76	5.5	1.2
			CCMT120408-PM	●	●	●	●				0.8
			CCMT120412-PM	●	●	●	●				1.2

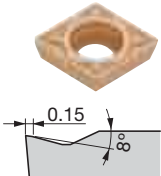
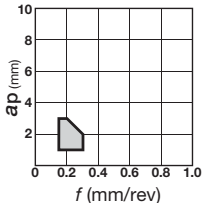
菱形, 80° (11°)

应用	断屑槽	f - ap	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ød	厚度 s	孔径 ød1	刀尖 半径 rε
				T6120	T6130	AH630	AH645				
精切削至 轻型切削	PSS		CPMT080204-PSS	●	●	●	●	7.94	2.38	3.4	0.4
			CPMT080208-PSS	●	●	●	●				0.8
			*CPMT090304-PSS	●	●	●	●	9.525	3.18	4.4	0.4
			CPMT090308-PSS	●	●	●	●				0.8
精 ~ 半精 切削	PS		CPMT080202-PS	●	●	●	●	7.94	2.38	3.4	0.2
			CPMT080204-PS	●	●	●	●				0.4
			CPMT080208-PS	●	●	●	●				0.8
			*CPMT090304-PS	●	●	●	●	9.525	3.18	4.4	0.4
			CPMT090308-PS	●	●	●	●				0.8

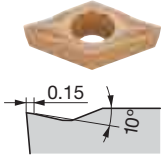
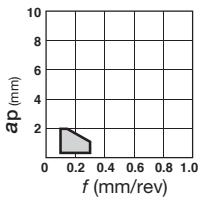
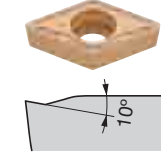
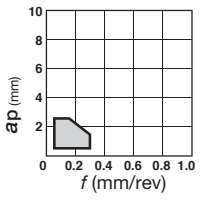
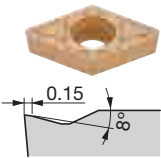
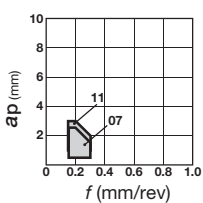
* 注: 断屑槽截面图为 * 号标记刀片的图。

●: 库存型号

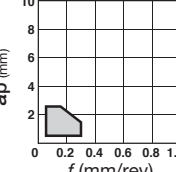
菱形, 80° (11°)

应用	断屑槽	$f - ap$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 $\varnothing d$	厚度 s	孔径 $\varnothing d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
中型切削	PM 		CPMT060204-PM	●	●	●	●	6.35	2.38	2.8	0.4
			CPMT060208-PM	●	●	●	●				0.8
			*CPMT090304-PM	●	●	●	●	9.525	3.18	4.4	0.4
			CPMT090308-PM	●	●	●	●				0.8

菱形, 55° (7°)

应用	断屑槽	$f - ap$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精切削至 轻型切削	PSS 		DCMT070204-PSS	●	●	●	●	6.35	2.38	2.8	0.4
	DCMT070208-PSS		●	●	●	●	0.8				
	*DCMT11T304-PSS		●	●	●	●	9.525	3.97	4.4	0.4	
	DCMT11T308-PSS		●	●	●	●				0.8	
	DCMT11T312-PSS		●	●	●	●				1.2	
精 ~ 半精 切削	PS 		DCMT070202-PS	●	●	●	●	6.35	2.38	2.8	0.2
	*DCMT070204-PS		●	●	●	●	0.4				
	DCMT11T302-PS		●	●	●	●	9.525	3.97	4.4	0.2	
	*DCMT11T304-PS		●	●	●	●				0.4	
	DCMT11T308-PS		●	●	●	●				0.8	
	DCMT11T312-PS		●	●	●	●	1.2				
中型切削	PM 		DCMT070204-PM	●	●	●	●	6.35	2.38	2.8	0.4
	DCMT070208-PM		●	●	●	●	0.8				
	DCMT11T304-PM		●	●	●	●	9.525	3.97	4.4	0.4	
	*DCMT11T308-PM		●	●	●	●				0.8	
	DCMT11T312-PM		●	●	●	●				1.2	

方形, 90° (7°)

应用	断屑槽	$f - ap$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精 ~ 半精 切削	PS		*SCMT09T304-PS	●	●	●	●	9.525	3.97	4.4	0.4
	SCMT09T308-PS		●	●	●	●	0.8				
	SCMT120404-PS		●	●	●	●	12.7	4.76	5.5	0.4	
	SCMT120408-PS		●	●	●	●				0.8	

* 注: 断屑槽截面图为 * 号标记刀片的图。

●: 库存型号

方形, 90° (7°)

应用	断屑槽	$f - ap$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
中型切削	PM		*SCMT09T304-PM	●	●	●	●	9.525	3.97	4.4	0.4
			SCMT09T308-PM	●	●	●	●				0.8
			SCMT120408-PM	●	●	●	●	12.7	4.76	5.5	0.8
			SCMT120412-PM	●	●	●	●				1.2

方形, 90° (11°)

应用	断屑槽	$f - ap$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精~半精 切削	PS		SPMT090304-PS	●	●	●	●	9.525	3.97	4.4	0.4
			SPMT090308-PS	●	●	●	●				0.8
			SPMT120404-PS	●	●	●	●	12.7	4.76	5.5	0.4
			*SPMT120408-PS	●	●	●	●				0.8

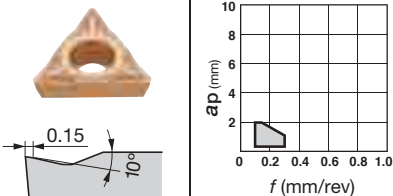
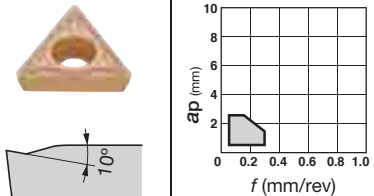
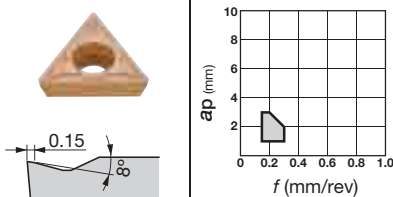
三角形, 60° (7°)

应用	断屑槽	$f - ap$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精~半精 切削	PS		TCMT110202-PS	●	●	●	●	6.35	2.38	2.8	0.2
			*TCMT110204-PS	●	●	●	●				0.4
			TCMT110208-PS	●	●	●	●				0.8
			TCMT110302-PS	●	●	●	●	6.35	3.18	2.8	0.2
			TCMT110304-PS	●	●	●	●				0.4
			TCMT110308-PS	●	●	●	●				0.8
			TCMT16T302-PS	●	●	●	●	9.525	3.97	4.4	0.2
			TCMT16T304-PS	●	●	●	●				0.4
			TCMT16T308-PS	●	●	●	●				0.8
中型切削	PM		TCMT110202-PM	●	●	●	●	6.35	2.38	2.8	0.2
			TCMT110204-PM	●	●	●	●				0.4
			TCMT110208-PM	●	●	●	●				0.8
			TCMT110302-PM	●	●	●	●	6.35	3.18	2.8	0.2
			TCMT110304-PM	●	●	●	●				0.4
			TCMT110308-PM	●	●	●	●				0.8
			*TCMT16T304-PM	●	●	●	●	9.525	3.97	4.4	0.4
			TCMT16T308-PM	●	●	●	●				0.8
			TCMT16T312-PM	●	●	●	●				1.2

* 注: 断屑槽截面图为 * 号标记刀具的图。

●: 库存型号

三角形, 60° (11°)

应用	断屑槽	$f - ap$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精切削至 轻型切削	PSS		TPMT090204-PSS	●	●	●	●	5.56	2.38	2.5	0.4
	TPMT090208-PSS		●	●	●	●	0.8				
	*TPMT110204-PSS		●	●	●	●	6.35	2.38	2.8	0.4	
	TPMT110208-PSS		●	●	●	●				0.8	
	TPMT110304-PSS		●	●	●	●	6.35	3.18	3.4	0.4	
	TPMT110308-PSS		●	●	●	●				0.8	
	TPMT130304-PSS		●	●	●	●	7.94	3.18	3.4	0.4	
	TPMT130308-PSS		●	●	●	●				0.8	
	TPMT16T304-PSS		●	●	●	●	9.525	3.97	4.4	0.4	
	TPMT16T308-PSS		●	●	●	●				0.8	
精 ~ 半精 切削	PS		TPMT090202-PS	●	●	●	●	5.56	2.38	2.5	0.2
	TPMT090204-PS		●	●	●	●	0.4				
	TPMT090208-PS		●	●	●	●	0.8				
	TPMT110202-PS		●	●	●	●	6.35	2.38	2.8	0.2	
	*TPMT110204-PS		●	●	●	●				0.4	
	TPMT110208-PS		●	●	●	●				0.8	
	TPMT110304-PS		●	●	●	●	6.35	3.18	3.4	0.4	
	TPMT110308-PS		●	●	●	●				0.8	
	TPMT130304-PS		●	●	●	●	7.94	3.18	3.4	0.4	
	TPMT130308-PS		●	●	●	●				0.8	
	TPMT16T304-PS		●	●	●	●	9.525	3.97	4.4	0.4	
	TPMT16T308-PS		●	●	●	●				0.8	
中型切削	PM		TPMT090204-PM	●	●	●	●	5.56	2.38	2.5	0.4
	TPMT090208-PM		●	●	●	●	0.8				
	TPMT110204-PM		●	●	●	●	6.35	2.38	2.8	0.4	
	TPMT110208-PM		●	●	●	●				0.8	
	TPMT110304-PM		●	●	●	●	6.35	3.18	3.4	0.4	
	TPMT110308-PM		●	●	●	●				0.8	
	TPMT130304-PM		●	●	●	●	7.94	3.18	3.4	0.4	
	TPMT130308-PM		●	●	●	●				0.8	
	*TPMT16T304-PM		●	●	●	●	9.525	3.97	4.4	0.4	
	TPMT16T308-PM		●	●	●	●				0.8	
	TPMT16T312-PM		●	●	●	●				1.2	

* 注: 断屑槽截面图为 * 号标记刀片的图。

●: 库存型号

菱形, 35° (5°)

应用	断屑槽	$f - ap$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精切削至 轻型切削	PSS		VBMT110304-PSS	●	●	●	●	6.35	3.18	2.8	0.4
			VBMT110308-PSS	●	●	●	●				0.8
			*VBMT160404-PSS	●	●	●	●	9.525	4.76	4.4	0.4
			VBMT160408-PSS	●	●	●	●				0.8
精 ~ 半精 切削	PS		*VBMT110302-PS	●	●	●	●	6.35	3.18	2.8	0.2
			VBMT110304-PS	●	●	●	●				0.4
			VBMT110308-PS	●	●	●	●				0.8
			VBMT160402-PS	●	●	●	●	9.525	4.76	4.4	0.2
			VBMT160404-PS	●	●	●	●				0.4
			VBMT160408-PS	●	●	●	●				0.8

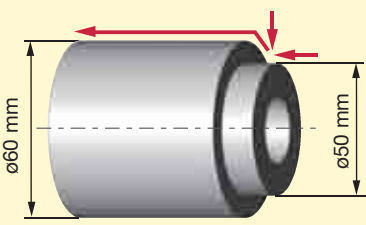
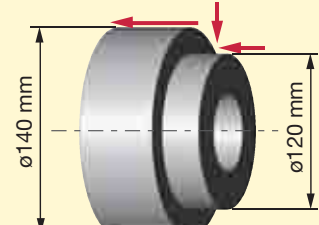
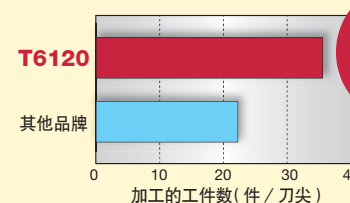
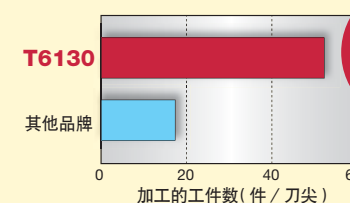
菱形, 35° (7°)

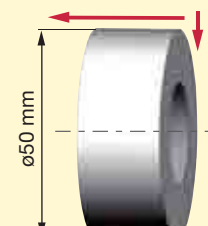
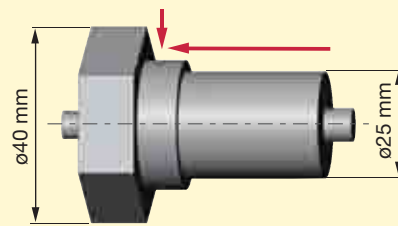
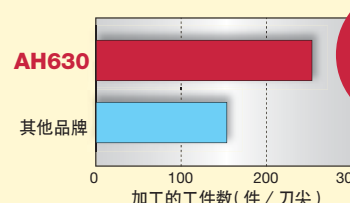
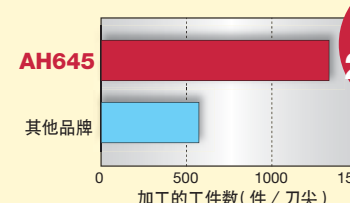
应用	断屑槽	$f - ap$	型号	库存材质				尺寸 (mm)			
	外观 (截面图)			涂层				I.C. 直径 ϕd	厚度 s	孔径 $\phi d1$	刀尖半径 $r\epsilon$
				T6120	T6130	AH630	AH645				
精切削至 轻型切削	PSS		VCMT110304-PSS	●	●	●	●	6.35	3.18	2.8	0.4
			VCMT110308-PSS	●	●	●	●				0.8
			*VCMT160404-PSS	●	●	●	●	9.525	4.76	4.4	0.4
			VCMT160408-PSS	●	●	●	●				0.8
精 ~ 半精 切削	PS		VCMT110302-PS	●	●	●	●	6.35	3.18	2.8	0.2
			VCMT110304-PS	●	●	●	●				0.4
			*VCMT110308-PS	●	●	●	●				0.8
			VCMT160404-PS	●	●	●	●	9.525	4.76	4.4	0.4
			VCMT160408-PS	●	●	●	●				0.8

* 注: 断屑槽截面图为 * 号标记刀具的图。

●: 库存型号

实际加工示例

工件类型		轴	机械零件
刀片		CNMG120408-SM	WNMG080412-SM
材质		T6120	T6130
工件材料		SUS304 / X5CrNi18-9	SUS303 / X10CrNiS18-9
			
切削条件	切削速度: V_c (m/min)	120	125
	进给量: f (mm/rev)	0.5	0.3
	切深: a_p (mm)	1.5	1.3
	加工方式	连续	连续
		冷却液	湿式
结果		 刀具寿命提高 1.5 倍! T6120 具有卓越的耐磨性, 刀具寿命是其他品牌 CVD 材质的 1.5 倍。	 刀具寿命提高 3 倍! T6130 可加工出良好的工件表面和比其他品牌手长 3 倍的刀具寿命, 这些得益于其优秀的耐磨性和抗崩刃性能。

工件类型		轴	机械零件
刀片		CNMG120408-SM	CNMG120404-SM
材质		AH630	AH645
工件材料		SUS304 / X5CrNi18-9	SUS304 / X5CrNi18-9
			
切削条件	切削速度: V_c (m/min)	150	100
	进给量: f (mm/rev)	0.3	0.15
	切深: a_p (mm)	2	1 ~ 2.5
	加工方式	连续	断续
		冷却液	湿式
结果		 刀具寿命提高 1.6 倍! AH630 完美兼顾了耐磨性和抗崩刃性, 刀具寿命是其他品牌材质的 1.6 倍。	 刀具寿命提高 2 倍以上! AH645 具有卓越的抗崩刃性, 刀具寿命是其他品牌材质的 2 倍。



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