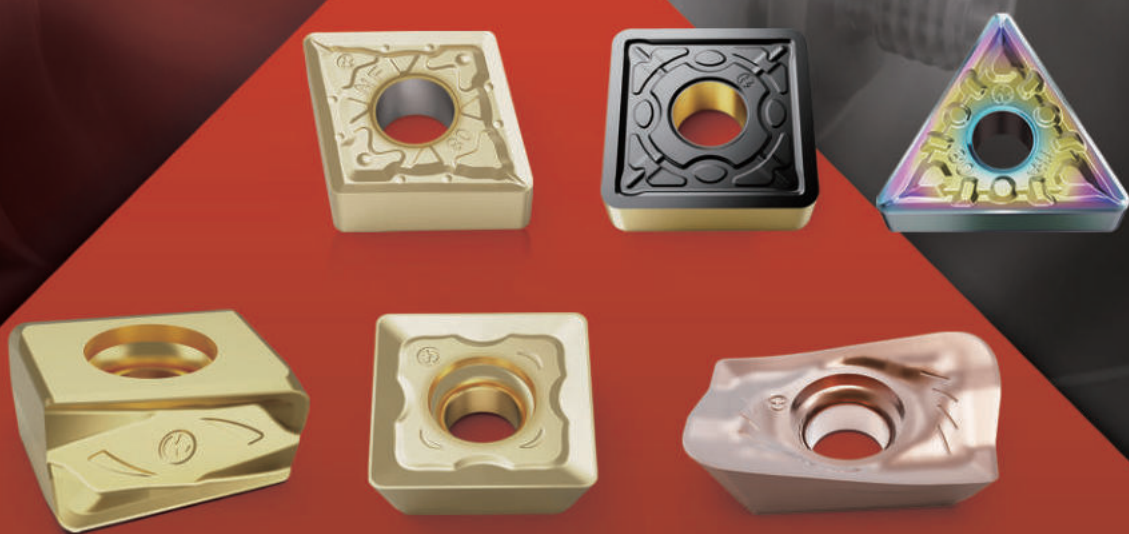
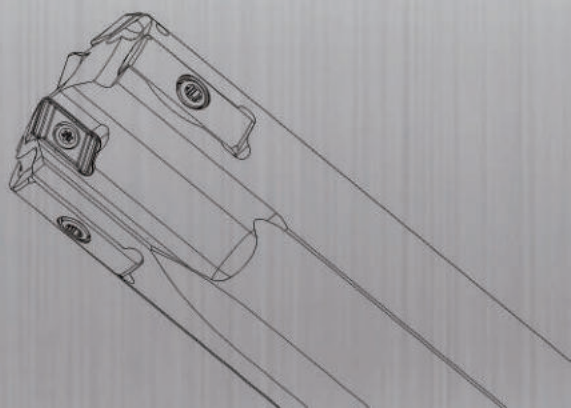


2025-2026 PRODUCTS CATALOG

综合产品目录



株洲科而诺新材料有限公司
Zhuzhou Kerno Advanced Materials Co., Ltd.





为机械加工提供完整的刀具解决方案

PROVIDE COMPLETE SOLUTION FOR MACHINING TOOLS

COMPANY PROFILE

公司简介

株洲科而诺新材料有限公司是一家成立于2005年的专业生产与研发企业，坐落于湖南省株洲市天元区，注册资本3亿元，系苏州阿诺集团全资子公司。公司前身为株洲科力特新材料有限公司，是国家级专精特新小巨人企业、国家高新技术企业。

公司技术力量雄厚，拥有专业的全流程硬质合金和金属陶瓷生产线。经营近20年间，公司始终秉承“以质量为本，以服务为宗旨”的企业理念，致力于可转位数控刀片的研发和生产，已先后获得多种奖项，成功打造了“科力特”自有品牌。现有产品体系覆盖数控车削、铣削、钻削、螺纹加工、切断切槽刀片、金属陶瓷刀片和棒材等。公司的产品广泛应用于汽车、航空、模具、军工、石油、地矿等各大行业，现已在北京、河北、东北、上海、江苏、浙江、广东、西南等各大区域设有经销处，并在欧洲、中东、南美、东南亚等国际市场建立了品牌专营销售网络，为全球20多个国家、地区提供完整的刀具解决方案，深受国内外客户的信赖与好评。

未来，科而诺将继续秉承诚信经营的理念，致力于实现高性能、高精度可转为数控刀片的国产化，不断推动技术创新和产品升级，为客户提供更优质的产品和服务，为硬质合金行业的发展贡献更多力量。



世界领先

金属加工行业巨头



实力雄厚

国家专精特新小巨人企业
高新技术企业



技术先进

为机械加工制造行业
提供完备的刀具解决方案





办公大楼 Office Building

Located in Tianyuan District, Zhuzhou City, Hunan Province, and with a registered capital of 300 million CNY, Zhuzhou Kerno Advanced Materials Co., Ltd. is a wholly-owned subsidiary of Suzhou Ahno Group. The previous company was Zhuzhou Kelite Advanced Materials Co., Ltd., which is a "National 'Little Giant' Enterprise" and a "High-tech Enterprise."

With tremendous technological strength, we have a professional full-process production line of cemented carbide and cermet. Over the past 20 years, the company has been dedicated to the R&D of indexable CNC carbide inserts. It has adhered to the corporate culture of "quality as the foundation, service as the purpose". We have received many awards and successfully created the private brand "KELITE". CNC turning, milling, drilling, threading, parting, and grooving inserts, as well as cermet inserts and bars, are all covered by the current product system. Our products are widely used in automobile, aviation, mould, military, petroleum, mining and other major industries. Sales offices have been set up in Beijing, Hebei, Shanghai, Jiangsu, Zhejiang, Guangdong, and southwest and northeast areas of China. We have also established a brand franchised sales

network in Europe, the Middle East, South America, Southeast Asia, and other international markets to provide complete tool solutions for over 20 countries and regions worldwide. We have earned the trust and appreciation of both domestic and foreign clients. In the future, true to the concept of integrity management, we will remain committed to achieving the localization of high-performance and high-precision indexable CNC carbide inserts. We will also consistently promote technological innovation and product upgrades to provide customers with the highest-quality products and services and contribute to strengthen the development of cemented carbide industry.



COMPANY DEVELOPMENT HISTORY

发展历程



2005年

科力特公司成立

In 2005:
Zhuzhou Kelite Advanced Materials Co., Ltd. was established in 2005.



2012年

搬迁至天元区中达路
汽配园

In 2012:
Our company moved to The Automobile Parts Industrial Park, Zhongda Road, Tianyuan District in 2012.

2018-2021年

完善产线布局-模具中心、
涂层中心

2018-2021:
We have built PVD coating and pressing tool divisions to improve our production-line layout from 2018 to 2021.



2009年

“科力特”自有品牌成立;
获批国家级科技项目。

In 2009:
We registered our own brand KELITE and were approved as a member of The National Science and Technology Project in 2009.

2012-2018年

引进成套进口设备, 升级产线布局

2012-2018:
We have imported complete sets of equipment to upgrade and expand our production line from 2012 to 2018.

Ingenuity Quality, Stable and Efficient.
匠心品质 稳定高效

2022年

阿诺株洲新材料产业园项目
开工建设

In 2022:
Construction of The Ahno Advanced
Materials Industrial Park in Zhuzhou
was commenced in 2022.

2024年

正式加入山特维克集团；
新产业园乔迁。

In 2024:
Zhuzhou Kerno Advanced Materials Co., Ltd.
officially incorporates into Sandvik Group
and relocates to Zhuzhou Ahno Advanced
Materials Industrial Park in 2024.

2021年

科而诺公司成立

In 2021:
Zhuzhou Kerno Advanced
Materials Co., Ltd. was esta-
blished in 2021.

2023年

山特维克集团访问科而诺

In 2023:
Managers of Sandvik Group visited
Zhuzhou Kerno Advanced Materials
Co., Ltd. in 2023.

目录 Contents

A 车削刀片 Turning Inserts

B 铣削刀片 Milling Inserts

C 铝合金系列 Aluminum Alloy Series

D 孔加工刀片 Hole Machining Inserts

E 刮管刀片 Tube Scraper Inserts

F 非标异形刀片 Special Design Inserts

G 圆棒和立铣刀 Carbide Rods and Solid Carbide End Mill

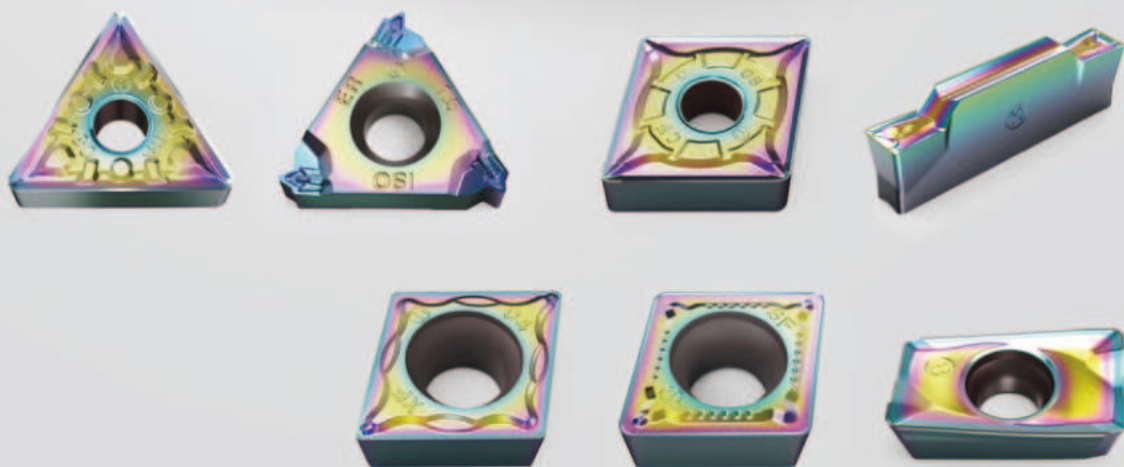
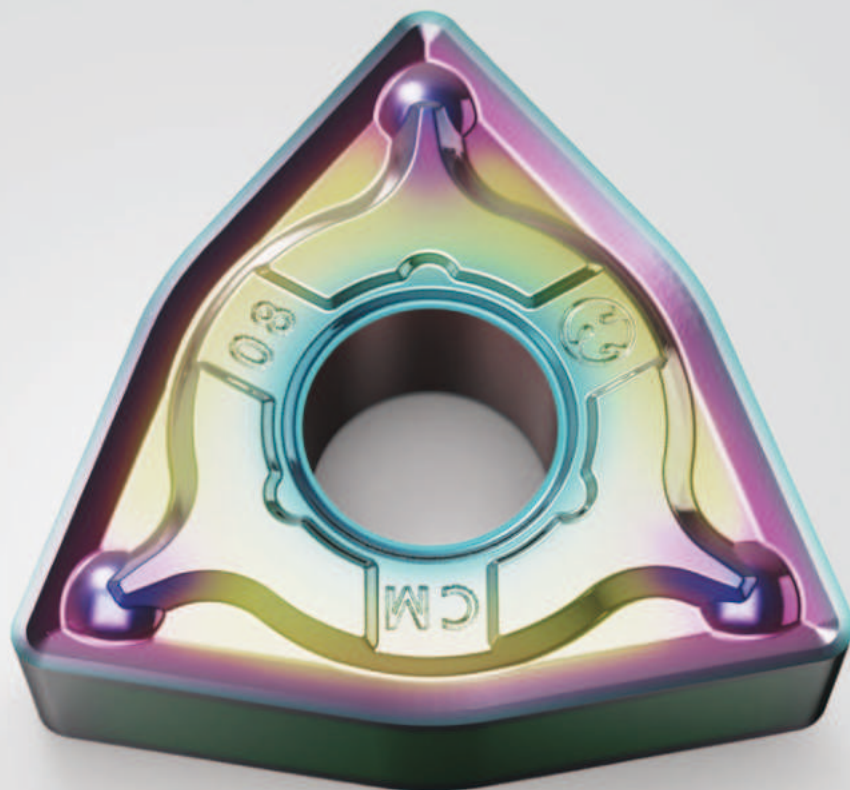
H 刀杆和刀盘 Holder and Cutter

I 加工案例 Application Cases

J 通用技术信息 General Technical Information

淬硬钢家族

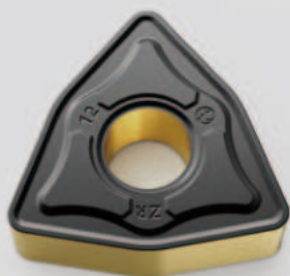
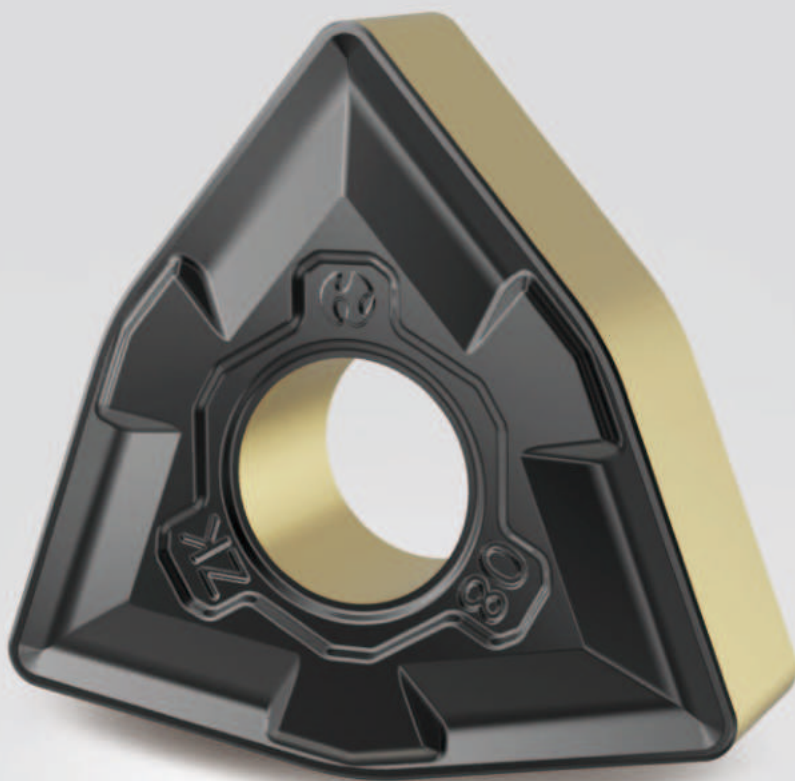
THE BIG FAMILY FOR HARDENED STEEL



全系列覆盖，包含车削、铣削、螺纹、U 钻

铸铁车削

TURNING INSERTS FOR CAST IRON



- 强化刃口专为铸铁切削而生；
- 大容量排屑槽；
- CVD 加厚涂层加持，寿命翻倍。

GM 车削槽型

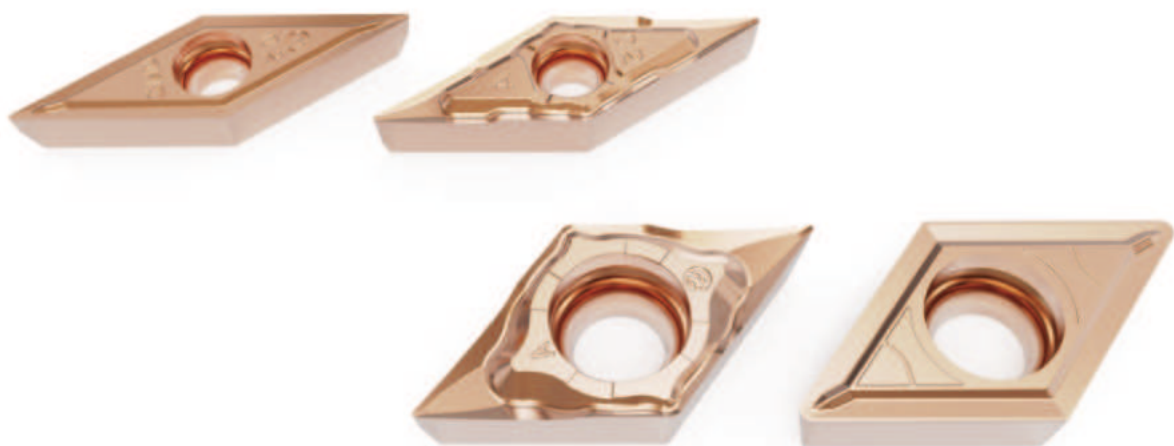
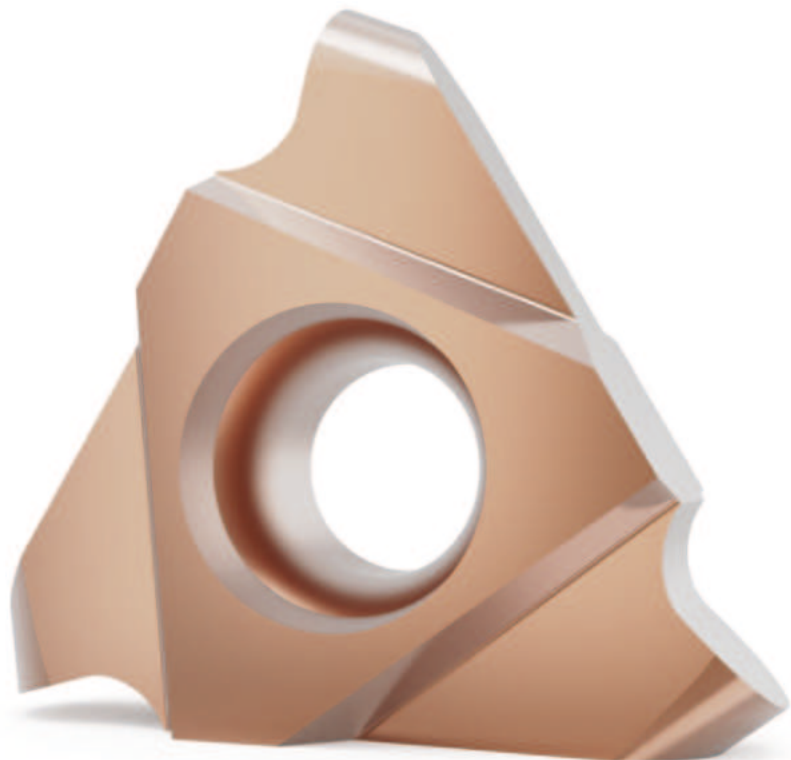
GM TURNING CHIPBREAKER



采用三维断屑槽设计，在精切削到半精切削加工中具有出众的排屑性能和低切削力优势。
低成本、M 级正前角刀片，可在广泛的应用中实现高效的镗孔加工。

小零件

MINIATURE



- 超精密刃口，可实现镜面车削；
- 0.005mm 级重复定位精度；
- 专为走心机和瑞士车床优化。

金属陶瓷刀片

CERMET INSERTS



- 金属陶瓷复合材质，硬度直逼金刚石，轻松应对高耐磨加工；
- 高温不变形，持续切削不降效，效率提升 30%+；
- 刀刃持久锋利，表面光洁度 $Ra < 0.2\mu m$ ，省去二次抛光
- 无涂层也耐用，告别锈蚀，寿命延长 50%

不锈钢车削

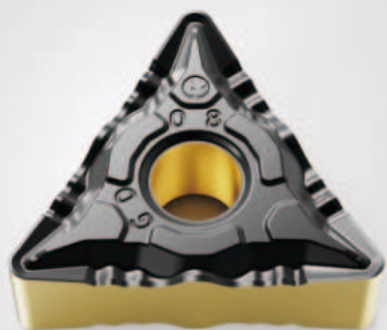
TURNING INSERTS FOR STAINLESS STEEL



不锈钢、耐热合金精加工槽型，刀尖自带刃倾角，使得切削轻快，卷屑变得更容易；变截面槽型设计，小切深下可实现良好断屑，较大切深时刀片强度好，去除黑皮时可保护刀尖。

钢件车削

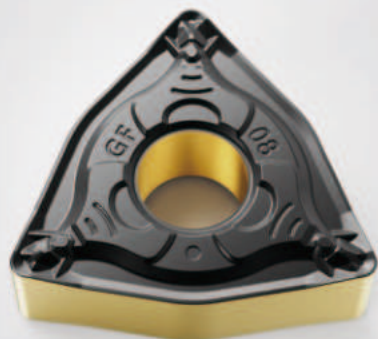
TURNING INSERTS FOR STEEL



GD 槽型



前刀面采用小平刃和大前角的组合确保了切削刀的强度与锋利度，刀尖的大刃倾角设计降低了切削阻力，波浪型的侧面设计在壁面的提拉加工时有良好的断屑能力，尤其在仿形等切深不同的加工



GF 槽型



碳钢、合金钢轻切削用第一推荐断屑槽轻切削范围，可实现稳定的切屑处理性。采用曲线切削刃，可顺畅排出切屑。



PMB 槽型



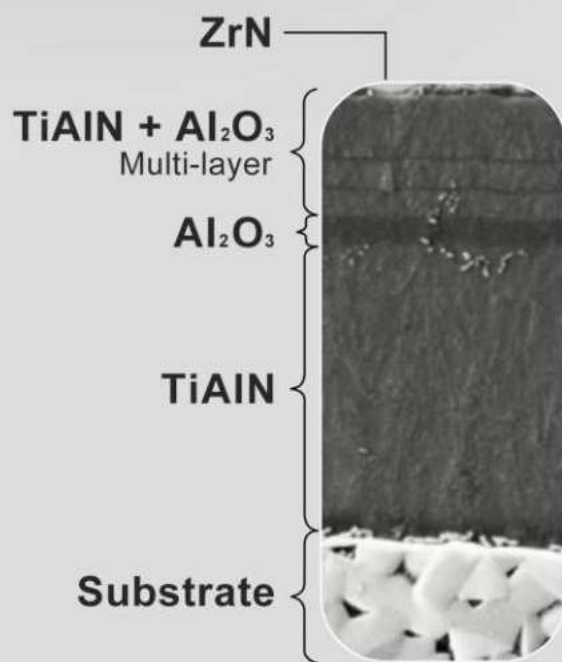
变截面槽型，独特的刃倾角刃线结构，可完美控制铁屑的流向，断屑台部位的“筋须”通过切屑模拟控制设计，可实现 0.5~3.5mm 宽广切深范围覆盖，良好刃型结构设计可实现 P、M、K 三大类材料通用加工。

高温合金车削

TURNING INSERTS FOR SUPERALLOY



PVD Al_2O_3 涂层技术





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Turning Inserts

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车削牌号

CVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KP010	P05~P15 K05~K20	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.新一代钢件车削牌号, KP系列中耐磨性最好的材质。 2.粘结相含量相对较低的梯度基体设计, CVD涂层提供较好的耐热性和抗机械磨损性能。 3.用于P类材料的精加工, 连续切削, 高切削速度, 有条件的断续车削加工; 还可用于球墨铸铁QT400以上的车削加工。
KP015	P10~P25 K05~K20	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.新一代钢件车削牌号, KP系列中有较强耐磨性和一定韧性的均衡型材质。 2.MT-TiCN结合耐磨的Al ₂ O ₃ 涂层, 高热稳定性, 高耐磨性, 能最大程度地保护基体。 3.优异的切削刃稳定性, 用于P类材质的精加工, 连续车削, 也可用于轻载断续车削。
KP025	P15~P35	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.新一代钢件车削牌号, KP系列中应用最广泛的材质。 2.中等含钴量基体, 搭配高耐磨性涂层。 3.可在较高切削速度下加工, 适用于连续和断续车削, 在恶劣工况下也具有高的抗机械损伤能力, 并保持出色的耐磨性。
KP035	P20~P45	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.新一代钢件车削牌号, KP系列中韧性最好的材质。 2.适用于钢件材质的粗加工、重载加工, 尤其适合采用中高进给和中等线速度的不利切削工况。
KT1153	P10~P25	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.梯度结构的高硬度专用基体, 结合中温TiCN和超细Al ₂ O ₃ 涂层, 刀片具备优异的耐磨性能。 2.适用于稳定工况下钢件的精加工, 连续车削, 追求高耐磨性场合。
KT1253	P15~P35	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.全新的纳米柱状结构MT-TiCN和厚Al ₂ O ₃ 涂层, 与韧性、强度兼备的中钴梯度硬质合金基体相结合。 2.适用于碳钢、合金钢等材料的半精加工到粗加工, 亦可用于断续加工, 是钢件车削加工的首选牌号。
KT1373	P20~P40	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.高韧性基体搭配合适厚度的MT-TiCN和Al ₂ O ₃ 涂层, 使得材质在强冲击力工况下仍能兼顾耐磨性和稳定性。 2.适用于碳钢、合金钢等材料的车削粗加工。
KT3123	K10~K25	CVD 双色	MT-TiCN+Al ₂ O ₃	1.高耐磨性细晶粒基体, 搭配细晶柱状中温TiCN和加厚Al ₂ O ₃ 涂层, 具有高的耐磨性和热稳定性。 2.适用于球墨铸铁的连续加工和高耐磨性场合, 尤其适合灰口铸铁的加工。
KT3263	K15~K35	CVD 双色	MT-TiCN+Al ₂ O ₃	1.中等晶粒的强韧性基体, 搭配全新升级的MT-TiCN和Al ₂ O ₃ 涂层工艺, 经特殊后处理工艺, 刃口强度好, 表面光滑。 2.适用于铸铁的半精加工到粗加工, 亦可用于断续切削, 是铸铁车削加工的首选牌号。
KT3253	K20~K40	CVD 双色	MT-TiCN+Al ₂ O ₃	1.高韧性基体, 优异的抗破损能力 2. QT400以上球墨铸铁加工, 可用于铸铁的强断续切削加工。

A
车削刀片B
铣削刀片C
铝合金刀片D
孔加工刀片E
刮削刀片F
非标异形刀片G
圆棒和立铣刀H
刀杆和刀盘I
加工案例J
通用技术信息

PVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KT8206	P10~P25 M10~M20	PVD 灰黑色	TiAlN	1. 采用亚微晶粒的中钴基体, 结合纳米TiAlN涂层, 具有良好的强韧性和通用性能。 2. 适用于合金钢、不锈钢、高温合金等的连续车削场合, 精加工、半精加工。
KT8284S	M15~M30 S15~S20	PVD 古铜色	TiAlSiN	1. 中钴含量的细晶粒硬质合金基体, 结合高光洁度、高耐磨性的TiAlSiN涂层, 兼具耐磨性和韧性, 且热稳定性优异。 2. 适用于不锈钢、高温合金等的半精加工、偏精加工场合, 是不锈钢车削加工的通用牌号。
KT8287N	M15~M30 S15~S20	PVD 银白色	Oxide	1. 升级的强韧性基体, 搭配高热稳定性、高耐磨性和防粘结的多层复合氧化物涂层。 2. 适用于不锈钢、钛合金等的半精车削加工, 亦可用于断续加工。
KT8286	P15~P30 M15~M30	PVD 灰黑色	TiAlN	1. 亚细晶粒高韧性硬质合金基体, 具有良好的刃口强度, 搭配TiAlN涂层, 具有良好的耐磨和通用性能。 2. 适用于合金钢、不锈钢等的半精车削加工, 可在断续加工工况下保持稳定寿命。
KS05	M05~M15 S05~S15	PVD 香槟色	Oxide	1. 结构均匀的超细晶粒基体, 提供更好的刃口保障, 搭配特殊涂层提供优异的热稳定性和抗塑性变形能力, 降低了产生凹槽磨损的风险。 2. 适用于稳定的加工条件下, 高温合金、镍基合金、不锈钢等的精加工和半精加工。
KS10	M10~M20 S10~S20	PVD 香槟色	Oxide	1. 细颗粒的硬质合金基体搭配纳米复合涂层技术结构, 防止了涂层过程中的微观裂纹的产生, 提高了抗崩性, 又不失刀片的锋利性; 2. 适用于高温合金、不锈钢的精加工和半精加工, 有着极高寿命要求和稳定性的场合。
KS10A	M10~M20 S10~S20	PVD 香槟色	Oxide	1. 添加特殊元素的增强型硬质合金基体搭配多层复合氧化物涂层, 提供了优的刃口强度和热稳定性。 2. 适用于高温合金、不锈钢的精加工和半精加工。
KT6109	H05~H25	PVD 七彩色	AlTiCrSiN	1. 采用较低钴含量的超细晶粒硬质合金基体, 搭配全新升级的多层复合纳米PVD涂层, 获得较强的涂层结合力、高耐磨性和高抗氧化性能。 2. 适用于HRC42以上淬硬钢的连续车削加工。

A
车削刀片**B**
铣削刀片**C**
铝合金刀片**D**
孔加工刀片**E**
刮管刀片**F**
非标异形刀片**G**
圆棒和立铣刀**H**
刀杆和刀盘**I**
加工案例**J**
通用技术信息

Grade Information

CVD Coated Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Applications
KP010	P05~P15 K05~K20	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. A new generation of turning grade for steel, which is the material with the best wear resistance in the KP series. 2. The design of a gradient substrate with a relatively low content of the bonding phase, and the CVD coating provides good heat resistance and resistance to mechanical wear. 3. It is designed for the finishing of P-type materials, continuous machining, high cutting speeds, and intermittent turning under certain conditions. It can also be used for the turning of nodular cast iron above QT400.
KP015	P10~P25 K05~K20	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. A new generation of turning grade for steel, which is a balanced material with strong wear resistance and a certain degree of toughness in the KP series. 2. The combination of MT-TiCN and the wear-resistant Al₂O₃ coating features high thermal stability and high wear resistance, which can protect the substrate to the greatest extent. 3. With excellent cutting edge stability, it is designed for the finishing of P-type materials, continuous turning, and can also be applied to light-duty intermittent turning.
KP025	P15~P35	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. A new generation of turning grade for steel parts, which is the most widely applied material in the KP series. 2. The substrate with a medium cobalt content is combined with a coating of high wear resistance. 3. It can be processed at relatively high cutting speeds and is suitable for both continuous and intermittent turning. It also has a high resistance to mechanical damage under harsh working conditions and maintains excellent wear resistance.
KP035	P20~P45	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. A new generation of turning grade for steel, which is the material with the best toughness in the KP series. 2. It is suitable for the roughing and heavy-duty processing of steel, especially suitable for the adverse cutting conditions with medium - high feed and medium linear speed.
KT1153	P10~P25	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. Using the special high-hardness substrate of gradient structure, combined with medium temperature TiCN and ultra-fine Al₂O₃ coating, it has excellent performance of wear resistance. 2. It is suitable for finishing processing and continuous turning of steel under stable working conditions and in pursuit of high wear-resistant occasions.
KT1253	P15~P35	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. Using new nano-columnar structure of MT-TiCN and thick Al₂O₃ coating, combined with medium cobalt gradient cemented carbide substrate with both toughness and strength. 2. It is suitable for semi-finishing to roughing processing of carbon steel, alloy steel and other materials. It can also be used for interrupted processing, and is the preferred grade for steel turning.
KT1373	P20~P40	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. High toughness substrate with suitable thickness of MT-TiCN and Al₂O₃ coating, which makes the material keep the wear resistance and stability under strong impact conditions. 2. It is suitable for roughing processing of carbon steel, alloy steel and other materials turning.
KT3123	K10~K25	CVD Bicolor	MT-TiCN+Al ₂ O ₃	1. Using high wear resistance fine crystalline substrate, combined with fine crystalline columnar medium temperature TiCN and thickened Al₂O₃ coating, it has excellent performance of wear resistance and thermal stability. 2. It is suitable for continuous processing of nodular cast iron and high wear resistance occasions, especially applicable to the processing of gray cast iron.
KT3263	K15~K35	CVD Bicolor	MT-TiCN+Al ₂ O ₃	1. The strong and tough matrix of medium grain, combined with the newly upgraded MT-TiCN and Al₂O₃ coating process. After special post-treatment process, has good cutting edge strength and smooth surface. 2. It is suitable for semi-finishing to roughing processing of cast iron, and can also be used for interrupted cutting. It is the preferred grade for cast iron turning.
KT3253	K20~K40	CVD Bicolor	MT-TiCN+Al ₂ O ₃	1. High-toughness substrate with excellent fracture resistance 2. It is designed for QT400+ nodular cast iron machining, and can be used for heavy interrupted cutting of cast iron.

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PVD Coated Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Applications
KT8206	P10~P25 M10~M20	PVD Gray-black	TiAlN	1.The submicron grain medium cobalt substrate combined with nanocrystal TiAlN coating,which makes it has good high-toughness and generality. 2.It is suitable for continuous turning of alloy steel,stainless steel superalloy,etc., finishing and semi-finishing.
KT8284S	M15~M30 S15~S20	PVD Copper	TiAlSiN	1. The fine grain cemented carbide substrate with medium cobalt combined with high surface finish and high wear resistance of TiAlSiN coating, which makes inserts have wear resistance and toughness, and excellent thermal stability. 2.It is suitable for semi-finishing and partial finishing machining of stainless steel, superalloys,etc., and is a universal grade for the turning of stainless steel.
KT8287N	M15~M30 S15~S20	PVD Silver	Oxide	1.Using upgraded substrate with high strength and toughness, combined with a multi-layer composite oxide coating featuring high thermal stability, high wear resistance, and anti-adhesion properties. 2.It is suitable for semi-finishing turning of stainless steel, titanium alloys, etc., and can also be used for interrupted machining.
KT8286	P15~P30 M15~M30	PVD Gray-black	TiAlN	1. Submicron grain and high-toughness cemented carbide substrate, which has good cutting edge strength, combined with a TiAlN coating, it has excellent wear resistance and versatility. 2. It is suitable for semi-finishing turning of alloy steel, stainless steel, etc., and can maintain a stable tool life under interrupted cutting conditions.
KS05	M05~M15 S05~S15	PVD Champagne	Oxide	1. Using an ultra-fine grain substrate with a uniform structure provides better edge protection. Combined with a special coating, it offers excellent thermal stability and resistance to plastic deformation, reducing the risk of notch wear. 2. It is suitable for the finishing and semi-finishing of superalloys, nickel-based alloys, stainless steel, etc., under stable machining conditions.
KS10	M10~M20 S10~S20	PVD Champagne	Oxide	1. The fine-grained cemented carbide substrate is combined with the nano-composite coating technology structure, which prevents the generation of micro-cracks during the coating process, and improves the chipping resistance while maintaining the sharpness of the insert. 2. It is suitable for the finishing and semi-finishing of superalloy and stainless steel in applications with extremely high requirements for tool life and stability.
KS10A	M10~M20 S10~S20	PVD Champagne	Oxide	1. The enhanced cemented carbide substrate with special elements added, combined with a multi-layer composite oxide coating, it provides excellent cutting edge strength and thermal stability. 2. It is suitable for the finishing and semi-finishing of superalloy and stainless steel.
KT6109	H05~H25	PVD Multicolor	AlTiCrSiN	1. Using ultra-fine grain cemented carbide substrate with a relatively low cobalt content, combined with a newly upgraded multi-layer composite nano PVD coating, it has strong coating adhesion, high wear resistance, and high oxidation resistance. 2. It is suitable for continuous turning of hardened steel with a hardness of HRC 42 or above.

A
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车削牌号

金属陶瓷牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KC5280	P10~P25 M10~M25 K10~K25	无涂层	\	1.TiCN基金属陶瓷牌号, 细小弥散的硬质相颗粒、粘结相强化和环形相结构控制三者结合, 使之表现出优异的耐磨性、红硬性和抗月牙洼磨损性能。 2.适用于钢件、不锈钢、铸铁等材料的精、半精加工。
KC5280L	P10~P25 M10~M25 K10~K25	无涂层	\	1.TiCN基金属陶瓷牌号, 特殊成分的添加, 在耐磨性不降低的前提下, 进一步增强了材质的抗弯强度和热稳定性能, 极大地提高了金属陶瓷牌号的使用安全性。 2.适用于钢件、不锈钢、铸铁等材料的精、半精加工。

Grade Information

Cermet Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Applications
KC5280	P10~P25 M10~M25 K10~K25	Uncoated	\	1.TiCN-based cermet grade, fine dispersion hard phase particles, bonded phase reinforcement and annular phase structure control are combined to show excellent wear resistance, hot hardness and crater wear resistance. 2.It is suitable for finishing and semi-finishing of steel, stainless steel, cast iron and other materials.
KC5280L	P10~P25 M10~M25 K10~K25	Uncoated	\	1.TiCN-based cermet grades, the addition of special components, under the premise of no reduction in wear resistance, further enhances the bending strength and thermal stability of the material, and greatly improves the safety of the use of cermet grades. 2.It is suitable for finishing and semi-finishing of steel, stainless steel, cast iron and other materials.

车削牌号一览表 Recommended Grade Table For Turning Inserts

工件材料 Workpiece materials	ISO代号 ISO Code	CVD	PVD	金属陶瓷 Cermets	硬质合金 Cemented carbide	超硬材料 Superhard materials
P	P01					
	P10	KP010		KC5280		
	P20	KP015		KC5280L		
	P30	KT1153				
	P40	KP025				
M	M01	KT1253				
	M10	KP035	KS05	KC5280		
	M20	KT1373	KT8206	KC5280L		
	M30		KT8286			
	M40		KT8287N			
K	K01		KT8284S			
	K10	KT3123		KC5280		
	K20	KT3263		KC5280L		
	K30	KT3253				
N	N01					
	N10					
	N20					
	N30					
S	S01		KS05			
	S10		KS10			
	S20		KS10A			
	S30					
H	H01					
	H10		KT6109			
	H20					
	H30					

A 车削刀片

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普通车削刀片命名规则 General Turning Inserts Naming Rules

形状代号 Shape

T N M G 16 04 08 — MB

A	B	C
D	E	H
K	L	M
O	P	R
S	T	T
V	W	Z
		其它

断屑槽及夹固形式代号 Chip Breaker and Hole

T N M G 16 04 08 — MB

代号 Symbol	有无孔 Center Hole	有无断屑槽 Chip Breaker	刀片剖面 Insert Profile	代号 Symbol	有无孔 Center Hole	有无断屑槽 Chip Breaker	刀片剖面 Insert Profile
B	有(Y)	无(N)		N	无(N)	无(N)	
H	有(Y)	单面(S)		R	无(N)	单面(S)	
C	有(Y)	无(N)		F	无(N)	双面(D)	
J	有(Y)	双面(D)		A	有(Y)	无(N)	
W	有(Y)	无(N)		M	有(Y)	单面(S)	
T	有(Y)	单面(S)		G	有(Y)	双面(D)	
Q	有(Y)	无(N)		X			
U	有(Y)	双面(D)					

后角代号 Clearance Angle

T N M G 16 04 08 — MB

A	B
C	D
E	F
G	N
P	O
	其它后角 Others

精度代号 Tolerance

T N M G 16 04 08 — MB

代号 Symbol	刀尖高度m 公差 (mm) m(mm)	内接圆I.C 公差 (mm) d=I.C. (mm)	厚度S 公差 (mm) s (mm)	(参考) M级精度详细情况 (按形状、大小分) ●刀尖高度公差 (mm) (reference) M grade tolerance detail (according to shape, size.) Tolerance of insert nose height												
				内切圆 Inscribed Circle	正三角形 Regular Triangle	正方形 Square	80°菱形 80° Rhombus	55°菱形 55° Rhombus	35°菱形 35° Rhombus	圆形 Round						
				6.35	±0.08	±0.08	±0.08	±0.11	±0.16	...						
				9.525	±0.08	±0.08	±0.08	±0.11	±0.16	...						
				12.7	±0.13	±0.13	±0.13	±0.15	...	...						
A	±0.005	±0.025	±0.025	15.875	±0.15	±0.15	±0.15	±0.18	...	...						
F	±0.005	±0.013	±0.025	19.05	±0.15	±0.15	±0.15	±0.18	...	...						
C	±0.013	±0.025	±0.025	25.4	...	±0.18	...	...	...	...						
H	±0.013	±0.013	±0.013	●内接圆I.C公差 (mm) ●Tolerance of Inscribed Circle												
E	±0.025	±0.025	±0.025	内切圆 Inscribed Circle	正三角形 Regular Triangle	正方形 Square	80°菱形 80° Rhombus	55°菱形 55° Rhombus	35°菱形 35° Rhombus	圆形 Round						
G	±0.025	±0.025	±0.13													
J	±0.005	±0.05-±0.13	±0.025								6.35	±0.05	±0.05	±0.05	±0.05	±0.05
K	±0.013	±0.05-±0.13	±0.025								9.525	±0.05	±0.05	±0.05	±0.05	±0.05
L	±0.025	±0.05-±0.13	±0.025								12.7	±0.08	±0.08	±0.08	±0.08	...
M	±0.08-±0.18	±0.05-±0.13	±0.13	15.875	±0.1	±0.1	±0.10	±0.10	...	±0.1						
N	±0.08-±0.18	±0.05-±0.13	±0.025	19.05	±0.1	±0.1	±0.10	±0.10	...	±0.1						
U	±0.13-±0.38	±0.08-±0.25	±0.13	25.4	...	...	±0.13	...	...	±0.13						

普通车削刀片命名规则 General Turning Inserts Naming Rules

切削刃长度代号 Cutting Edge Length

T N M G **16** 04 08 — MB

内切圆直径 Inscribed Circle diameter(mm)	刀片外形 Insert Shape							
	C	D	R	S	T	V	W	K
3.97					06			
5			05					
5.56					09			
6			06					
6.35	06	07			11	11		
8			08					
9.525	09	11	09	09	16	16	06	16
10			10					
12			12					
12.7	12	15	12	12	22	22	08	
15.875	16		15	15	27			
16			16	16				
19.05	19		19	19	33			
20			20					
25	25	25	25					
25.4			25	25				
31.75			31					
32			32					

刀片厚度代号 Thickness

T N M G 16 **04** 08 — MB

代号 Symbol	刀片厚度 Thickness(mm)
00	0.79
T0	0.99
01	1.59
T1	1.98
02	2.38
T2	2.58
03	3.18
T3	3.97
04	4.76
T4	4.96
05	5.56
T5	5.95
06	6.35
T6	6.75
07	7.94
09	9.52
T9	9.72
11	11.11
12	12.7

厚度指刀片底面与切削刃最高部分之间的高度
The Height Between Insert Bottom And Nose

刀片圆弧代号 Corner Radius

T N M G 16 04 **08** — MB

代号 Symbol	刀尖圆弧半径(mm) Corner Radius(mm)
00	无圆角
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2
24	2.4
32	3.2
X	其它 Special
刀片直径尺寸m0(公制) Diameter Dimension	圆形刀片 Round Insert

断屑槽型代号 Chip Breaker

T N M G 16 04 08 — **MB**

GMR	PMK	GM	PR
			
MJ	MF	GM	MM-B
			
GH	ZT	MB	
			

A 车削刀片

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D 孔加工刀片

E 刮管刀片

F 非标异形刀片

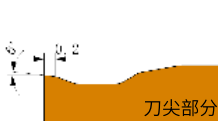
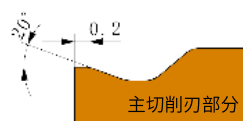
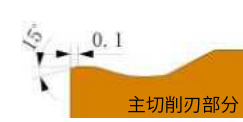
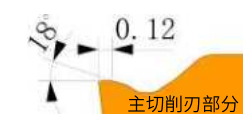
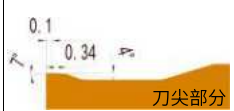
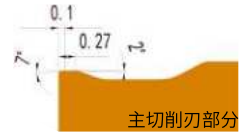
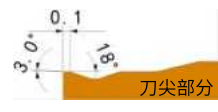
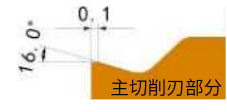
G 圆棒和立铣刀

H 刀杆和刀盘

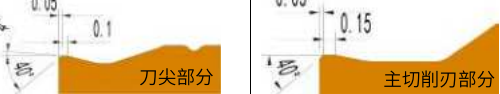
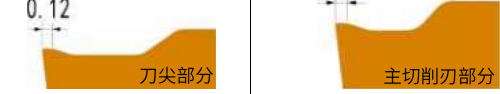
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普通车削槽型一览表

ISO 分类	槽型	刀尖、主切削部		特点
P	MB 	 刀尖部分	 主切削刃部分	科学、合理的断屑筋须设计，具有非常好的断屑效果，可用于钢件的半精到精加工。
	PMK 	 刀尖部分	 主切削刃部分	双面断屑槽，适合各种钢的内孔及外圆半精到粗加工。
	通槽 	 刀尖部分	 主切削刃部分	碳钢、合金钢中切削用第二推荐断屑槽。扁平棱边刃形，切削刃强度高。通用性高的全周断屑槽形状。
	GM 	 刀尖部分	 主切削刃部分	单面断屑槽，适用于P、M、K类通用加工。
	平板 	 刀尖部分	 主切削刃部分	刀尖刃口强度好，适合断续车削加工。
	GR 	 刀尖部分	 主切削刃部分	经济型粗车削双阶断屑槽，通过阶梯式断屑平台设计平衡加工效率与成本，特别适合机床导轨粗车、工程机械大型铸件批量加工等高金属去除率场景。
	GD 	 刀尖部分	 主切削刃部分	小平刃和大前角的组合确保了切削刃的强度与锋利度，刀尖的大刃倾角设计降低了切削阻力，波浪型的侧面设计在壁面的提拉加工时有良好的断屑能力。

普通车削槽型一览表

ISO 分类	槽型	刀尖、主切削刃部		特点
P	GMR		 刀尖部分 主切削刃部分	通用槽型，兼顾锋利性和强度，覆盖范围宽广，半精到粗加工槽型。
	PR		 刀尖部分 主切削刃部分	超强碎屑能力，主要适用于产品的粗加工。
	L/R-X		 刀尖部分 主切削刃部分	平行断屑槽。中进给量条件下，切屑处理良好。
	GF		 刀尖部分 主切削刃部分	专为碳钢/合金钢轻切削优化的曲线刃断屑槽，特殊的槽型设计实现稳定排屑，有效解决薄壁件加工中的缠屑问题，特别适用于细长轴精密车削及小切深连续加工场景。
	PMB		 刀尖部分 主切削刃部分	MB的升级槽型，新增的倒棱设计，大大增强刃口强度，有效提高刀具寿命。
	PMK		 刀尖部分 主切削刃部分	碳钢、合金钢、软钢、不锈钢、铸铁中切削用第二推荐断屑槽扁平棱边与大前角组合，同时确保刀刃强度与切削锋利性。

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮削刀片

F 非标异形刀片

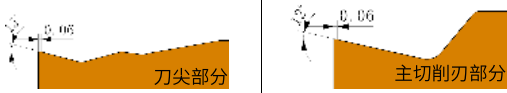
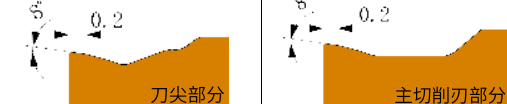
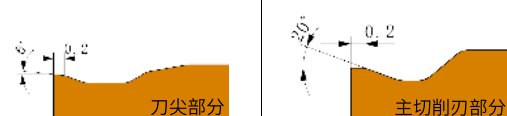
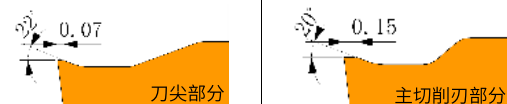
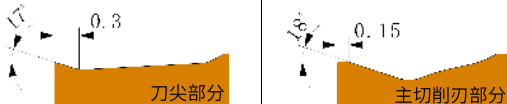
G 圆棒和立铣刀

H 刀杆和刀盘

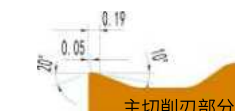
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普通车削槽型一览表

ISO 分类	槽型	刀尖、主切削刃部		特点
M	MF			M级双面断屑槽，刃口锋利，有效解决不锈钢断屑，粘刀、表面硬化等加工难点，获得高质量加工表面。
	MM-B			刀尖刃口同时兼具锋利性和强度。具有良好的排屑效果，适用于半精偏精加工。
	MB			科学、合理得断屑筋须设计，具有非常好得断屑效果，可用于钢件的半精到精加工。
	MF			M级精度，刃口锋利，适合于不锈钢、软钢等粘性材料的精加工。
	MM			M类材料半精加工推荐槽型 M级精度，刃口强度较好，可获得更高的加工效率。
	MJ			切削刃锋利，阻力小；带刃倾角设计，导屑好；断屑台前移可在小余量加工状况下实现良好断屑。
	L/R-M			双面断屑槽，抗冲击能力强，槽型设计在刃口安全性和锋利性取得了最佳平衡点，解决不锈钢粗加工等问题。

普通车削槽型一览表

ISO 分类	槽型	刀尖、主切刃部		特点
M	GM 	 刀尖部分	 主切削刃部分	单面断屑槽, 适用于P、M、K类通用加工。
	MP 	 刀尖部分	 主切削刃部分	通用型中切削正棱刃断屑槽, 凭借强化刃口处理技术平衡切削锋利度与耐用性, 是法兰盘台阶车削、轴类零件多工序加工等中等负荷钢件车削的理想选择。

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

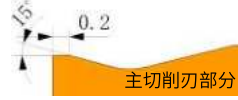
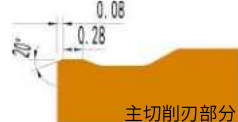
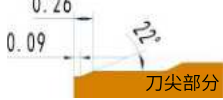
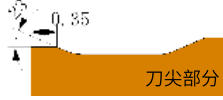
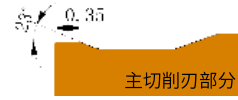
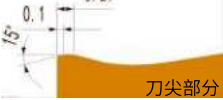
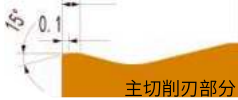
G 圆棒和立铣刀

H 刀杆和刀盘

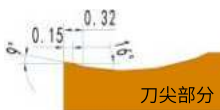
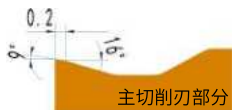
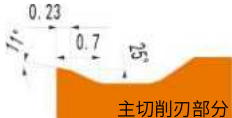
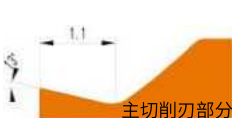
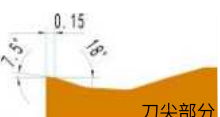
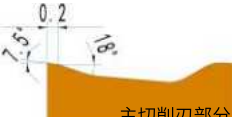
I 加工案例

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普通车削槽型一览表

ISO 分类	槽型	刀尖、主切削刃部		特点
K	 UC	 刀尖部分	 主切削刃部分	碳钢、合金钢中切削用第二推荐断屑槽。扁平棱边刀形，切削刃强度高。通用性高的全周断屑槽形状。
	 平板	 刀尖部分	 主切削刃部分	双面加工，刃口强度高，是克服铸铁加工中砂眼，夹渣等不良加工因素的刀片结构的解决方案。
	 ZR	 刀尖部分	 主切削刃部分	碳钢、合金钢、不锈钢准重切削用采用以往产品3倍以上的安装面积与宽棱边，在断续切削、黑皮切削中发挥出色的切削刃稳定性。
	 ZD	 刀尖部分	 主切削刃部分	适用于铸铁和硬材料的粗加工采用特质涂层，兼具高耐磨性与抗冲击性能，显著延长刀具寿命。支持高进给与高速切削，适合连续或轻微断续车削工况，提升生产效率。
	 GH	 刀尖部分	 主切削刃部分	宽棱边与大容量屑槽组合，实现高进给量加工。适用于断续切削、黑皮切削。
	 ZT	 刀尖部分	 主切削刃部分	宽棱边与大容量屑槽组合，实现高进给量加工。适用于断续切削、黑皮切削。
	 ZK	 刀尖部分	 主切削刃部分	碳钢/合金钢中切削专用全周断屑槽，扁平棱边强化刃口设计在保持通用性的同时提升刃口刚性，特别适用于液压杆连续车削、传动轴台阶加工等中等负荷钢件车削场景。

普通车削槽型一览表

ISO 分类	槽型	刀尖、主切削刃部		特点
S	NF	 		适用于高温合金精加工的槽型, 转位精度高, 防止加工硬化、抗磨损能力强, 更锋利的刃口设计可获得高加工精度和表面质量。双面断屑槽兼顾经济性。
	NR	 		适用于高温合金类材料大切深高效粗加工的槽型。刃口的设计兼顾了锋利和强度, 切削阻力小, 可有效减小沟槽磨损, 增加刀具寿命。
	M2	 		通用正前角槽型, 设计用于精加工高温合金以及硬质材料部分有色金属材料, 用于连续切削。
	NM	 		适用于高温合金半精加工的槽型, 转位精度高, 防止加工硬化、抗磨损能力强, 可获得比NF更高的加工效率。双面断屑槽更具经济性。

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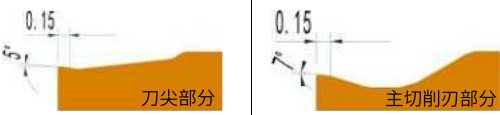
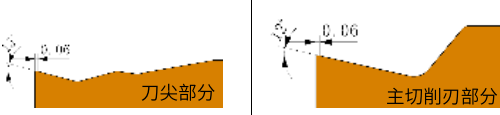
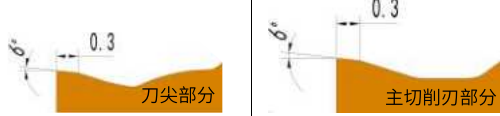
G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

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普通车削槽型一览表

ISO 分类	槽型	刀尖、主切削刃部		特点
H	CF		 刀尖部分 主切削刃部分	刃口锋利, 切削轻快; 适用于淬硬钢等难加工材料的连续精加工, 表面质量优良。
	MF		 刀尖部分 主切削刃部分	M级双面断屑槽, 刃口锋利, 有效解决不锈钢断屑, 粘刀、表面硬化等加工难点, 获得高质量加工表面。
	CM		 刀尖部分 主切削刃部分	双前角设计, 断屑范围宽; 适用于淬硬钢等难加工材料的断续半精加工及粗加工。
	TFA		 刀尖部分 主切削刃部分	大前角设计, 切削力低; 适用于淬硬钢等难加工材料的轻断续精加工, 加工表面质量好。

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I 加工案例

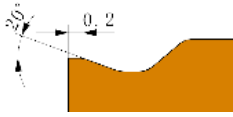
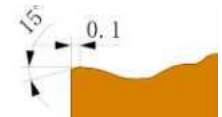
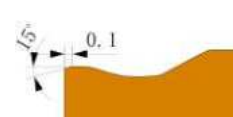
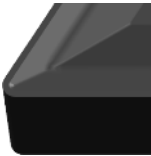
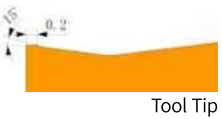
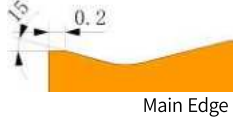
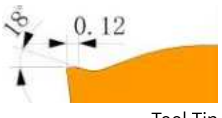
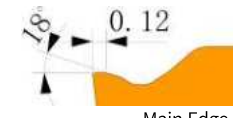
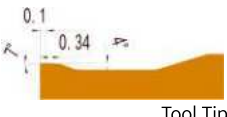
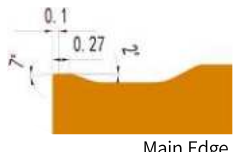
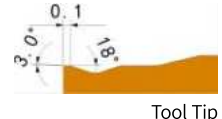
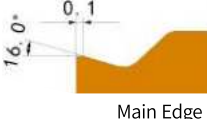
J 通用技术信息

普通车削槽型一览表

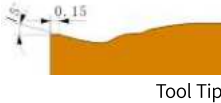
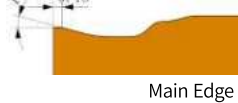
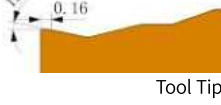
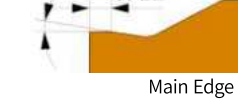
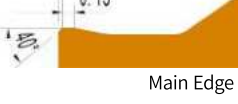
ISO 分类	槽型	刀尖、主切削部	特点
N	AK 		独特断屑台设计，使刃口更加锋利，保证刀片切削轻快并能有效断屑。

- A** 车削刀片
- B 铣削刀片
- C 铝合金刀片
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- F 非标异形刀片
- G 圆棒和立铣刀
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General Chipbreaker Table For Turning Inserts

ISO	Chipbreaker	Tool Tip	Main Edge	Features
P	MB 	 Tool Tip	 Main Edge	Versatile geometry with optimized cutting edge design to provide superior chip control in wide range of applications. It's suitable for medium cutting to finishing.
	PMK 	 Tool Tip	 Main Edge	Double-sided chipbreaker for semi-finishing to roughing processing. It's suitable for inner hole & outer circle turning machining of steel.
	STANDARD 	 Tool Tip	 Main Edge	Alternative chipbreaker for medium cutting of carbon steel and alloy steel. Flat land offers high edge strength. All-round chipbreaker offers high universality.
	GM 	 Tool Tip	 Main Edge	Single-sided chipbreaker for the universal processing in the P, M, K application range.
	FLAT TOP 	 Tool Tip	 Main Edge	Great cutting edge strength. It's suitable for interrupted processing.
	GR 	 Tool Tip	 Main Edge	An economical double-stage chipbreaker for roughing turning with a stepped chip control platform design, to optimize machining efficiency and cost-effectiveness. Ideal for high metal removal applications such as machine tool guideway roughing and batch machining of large construction machinery castings.
	GD 	 Tool Tip	 Main Edge	The combination of a small flat edge and a large rake angle ensures the strength and sharpness of the cutting edge. The design of a large edge inclination angle at the tool tip reduces cutting resistance, and the wavy side design provides excellent chip breaking ability during the pull-up machining of the wall surface.

General Chipbreaker Table For Turning Inserts

ISO	Chipbreaker	Tool Tip	Main Edge	Features
P	GMR 	 Tool Tip	 Main Edge	General-purpose chipbreaker with tough cutting edge and excellent chip control. It's suitable for semi-finishing to roughing.
	PR 	 Tool Tip	 Main Edge	Superior chip breaking capacity. It's suitable for roughing processing.
	L/R-X 	 Tool Tip	 Main Edge	Parallel chipbreaker. Good chip control for medium feed rates.
	GF 	 Tool Tip	 Main Edge	A curved edge chipbreaker specifically is optimized for light cutting of carbon steel and alloy steel. The special chipbreaker design enables stable chip evacuation, effectively solving the chip - wrapping problem in the machining of thin - walled parts. It is especially suitable for precision turning of slender shafts and continuous machining with small cutting depths.
	PMB 	 Tool Tip	 Main Edge	The upgraded chipbreaker of MB and newly added chamfer design, greatly enhance the cutting edge strength and effectively improve the tool life.
	PMK 	 Tool Tip	 Main Edge	Alternative chipbreaker for medium cutting of carbon steel, alloy steel, mild steel, stainless steel and cast iron. Balance of edge strength and sharpness due to a combination of a flat land and large rake angle.

A
车削刀片

B
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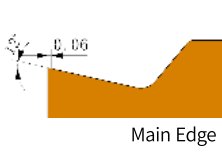
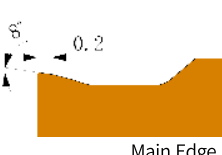
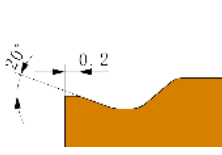
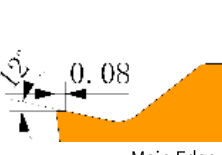
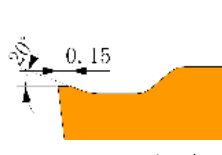
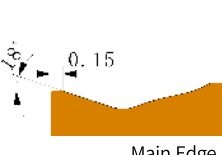
G
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刀杆和刀盘

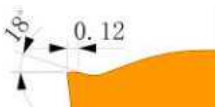
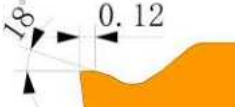
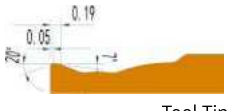
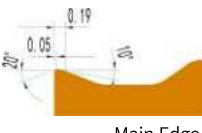
I
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General Chipbreaker Table For Turning Inserts

ISO	Chipbreaker	Tool Tip	Main Edge	Features
M	MF	 Tool Tip	 Main Edge	M-class double-sided chipbreaker with sharp cutting edge, which effectively solve the processing difficulties of stainless steel, such as chip breaking, tool sticking, and surface hardening, etc., and obtain good surface quality.
	MM-B	 Tool Tip	 Main Edge	The cutting edge balances sharpness with good chip control strength, ensuring stable chip flow in semi-finishing to finishing machining.
	MB	 Tool Tip	 Main Edge	A scientifically optimized chip breaker ensures reliable chip control, making it suitable for semi-finishing to finishing machining of stainless steel.
	MF	 Tool Tip	 Main Edge	Grade M precision, sharp cutting edge; suitable for finishing machining of stainless steel, mild steel and other sticky materials.
	MM	 Tool Tip	 Main Edge	Recommended semi-finishing chipbreaker of M-class materials with grade M precision, good edge strength, enabling higher machining efficiency.
	MJ	 Tool Tip	 Main Edge	A sharpened edge with positive rake reduces cutting resistance, while a controlled edge inclination angle directs chip flow away from the workpiece. A forwarder chipbreaker land design optimizes chip formation in finishing applications.
	L/R-M	 Main Edge	 Main Edge	A reinforced double chipbreaker design provides high resistance to impact forces while maintaining edge sharpness and safety, ensuring stable performance in roughing operations of stainless steel machining.

General Chipbreaker Table For Turning Inserts

ISO	Chipbreaker	Tool Tip	Main Edge	Features
M	GM 	 Tool Tip	 Main Edge	Single-sided chipbreaker for the universal processing in the P, M, K application range.
	MP 	 Tool Tip	 Main Edge	A universal positive rake chipbreaker that balances cutting edge sharpness and durability. Ideal for semi-finishing of steel machining such as flange and shoulder turning, multi-operation machining of shaft components, and other similar operations.

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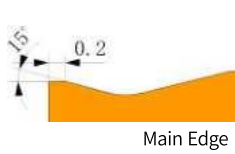
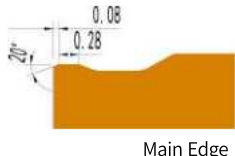
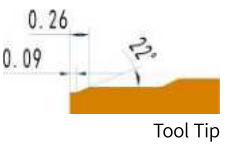
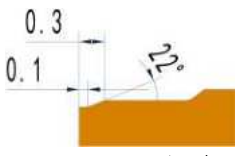
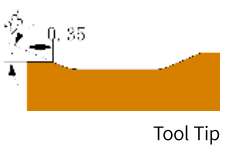
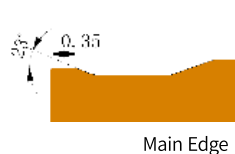
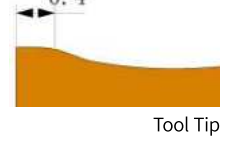
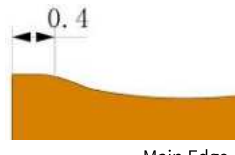
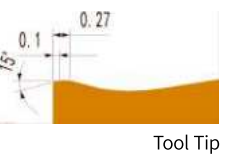
G
圆棒和立铣刀

H
刀杆和刀盘

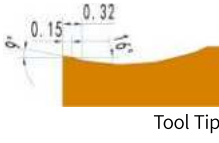
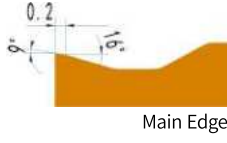
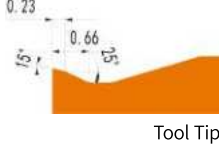
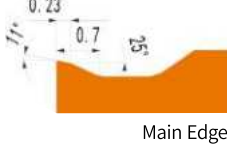
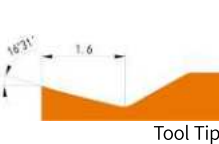
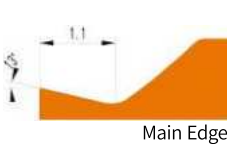
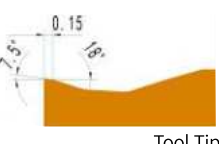
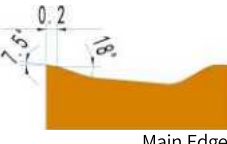
I
加工案例

J
通用技术信息

General Chipbreaker Table For Turning Inserts

ISO	Chipbreaker	Tool Tip	Main Edge	Features
K	UC	 Tool Tip	 Main Edge	Alternative chipbreaker for medium cutting of carbon steel and alloy steel. Flat land offers high edge strength. All-round chipbreaker offers high universality.
	FLAT TOP	 Tool Tip	 Main Edge	Double-sided chipbreaker with high cutting edge strength. It can overcome inferior factors such as interruption and vibration etc., when machining cast iron.
	ZR	 Tool Tip	 Main Edge	For roughing cutting of carbon steel, alloy steel and stainless steel. It uses more than three times seating surface and wide land of conventional products, providing high cutting stability for interrupted machining and scale removal.
	ZD	 Tool Tip	 Main Edge	Specially designed for roughing of cast iron and hardened materials, features a proprietary coating in high wear and impact resistance, significantly extending tool life. For high feed and high speed cutting, continuous or lightly interrupted turning conditions. It enhances production efficiency.
	GH	 Tool Tip	 Main Edge	A combination of wide land and a large chip pocket allows high feed rates, suitable for interrupted cuts and removing scale.
	ZT	 Tool Tip	 Main Edge	A combination of wide land and a large chip pocket allows high feed rates. For interrupted cuts and removing scale.
	ZK	 Tool Tip	 Main Edge	Specialized standard chipbreaker for carbon/alloy steels processing. The flat land offers high edge strength, which improves edge rigidity as well as universality. It is especially suitable for steel turning processing with medium loads such as continuous processing of hydraulic rods, step processing of drive shafts.

General Chipbreaker Table For Turning Inserts

ISO	Chipbreaker	Tool Tip	Main Edge	Features
S	NF	  Tool Tip	 Main Edge	It is suitable for finishing machining of superalloy and keeps high precision after inserts are turned, with good capacity to prevent wear and hardening. Sharp cutting edge can achieve high machining precision and good surface quality. Double-sided chipbreaker is more economical.
	NR	  Tool Tip	 Main Edge	It is suitable for high efficient roughing of superalloy with large cutting depth. The designation of the cutting edge combines sharpness and strength, with small cutting resistance, which can effectively reduce groove wear and increase insert life.
	M2	  Tool Tip	 Main Edge	Universal positive rake chipbreaker is designed for finishing machining of superalloy, hardened materials and some non - ferrous metal materials and is used for continuous machining.
	NM	  Tool Tip	 Main Edge	It is suitable for semi-finishing of superalloy and keeps high precision after inserts are turned, with good capacity to prevent wear and hardening to get higher processing efficiency than NF chipbreaker. Double-sided chipbreaker is more economical.

A
车削刀片

B
铣削刀片

C
铝合金刀片

D
孔加工刀片

E
刮管刀片

F
非标异形刀片

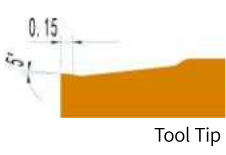
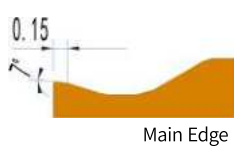
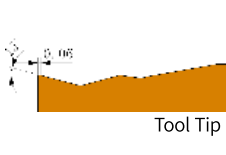
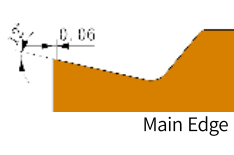
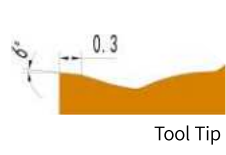
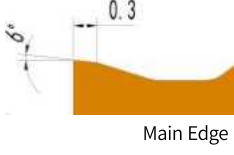
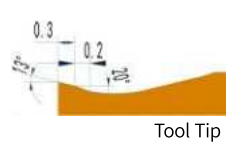
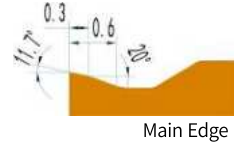
G
圆棒和立铣刀

H
刀杆和刀盘

I
加工案例

J
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General Chipbreaker Table For Turning Inserts

ISO	Chipbreaker	Tool Tip	Main Edge	Features
H	CF 	 Tool Tip	 Main Edge	Sharp cutting edge for smooth and efficient cutting; suitable for continuous finishing machining of hardened steel and other difficult-to-machine materials, providing excellent surface finish.
	MF 	 Tool Tip	 Main Edge	M-class double-sided chipbreaker with sharp cutting edge, which effectively solve the processing difficulties of stainless steel, such as chip breaking, tool sticking, and surface hardening, etc., and obtain good surface quality.
	CM 	 Tool Tip	 Main Edge	Double rake angle design with wide chip breaking range; suitable for interrupted semi-finishing and roughing of hardened steel and other difficult-to-machine materials.
	TFA 	 Tool Tip	 Main Edge	Large rake angle design with low cutting force; suitable for light interrupted finish machining of hardened steel and other difficult-to-machine materials, providing good surface finish.

General Chipbreaker Table For Turning Inserts

ISO	Chipbreaker	Tool Tip	Main Edge	Features
N	 AK		 Main Edge	The unique chipbreaker design ensures a sharper cutting edge, enabling smooth and effortless cutting performance and consistent chip control.

A
车削刀片

B
铣削刀片

C
铝合金刀片

D
孔加工刀片

E
刮管刀片

F
非标异形刀片

G
圆棒和立铣刀

H
刀杆和刀盘

I
加工案例

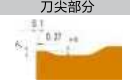
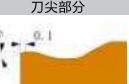
J
通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
工件材料 Workpiece Material	P	钢	√	○	×						○	×					
	M	不锈钢											√	○	○	×	
	K	铸铁				√	○	×									
	N	有色金属															
	S	耐热合金、钛合金														○	×
	H	淬硬钢														○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
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	CNMG120412-GR	12.9	12.7	4.76	5.16	1.2		▲	●					●			
	CNMG120416-GR	12.9	12.7	4.76	5.16	1.6		▲	●					●			
	CNMG160608-GR	16.1	15.875	6.35	6.35	0.8		▲	●					●			
	CNMG160612-GR	16.1	15.875	6.35	6.35	1.2		▲	●					●			
	CNMG160616-GR	16.1	15.875	6.35	6.35	1.6		▲	●					●			
	CNMG190608-GR	19.3	19.05	6.35	7.94	0.8		▲	●					●			
	CNMG190612-GR	19.3	19.05	6.35	7.94	1.2		▲	●					●			
	CNMG190616-GR	19.3	19.05	6.35	7.94	1.6		▲	●					●			
	CNMG190624-GR	19.3	19.05	6.35	7.94	2.4		▲	●					●			
	CNMG120404-PMK	12.9	12.7	4.76	5.16	0.4	●	▲	●					●			
	CNMG120408-PMK	12.9	12.7	4.76	5.16	0.8	●	▲	●					●			
	CNMG120412-PMK	12.9	12.7	4.76	5.16	1.2	●	▲	●					●			
	CNMG120416-PMK	12.9	12.7	4.76	5.16	1.6	●	▲	●					●			
	CNMG160608-PMK	16.1	15.875	6.35	6.35	0.8	●	▲	●					●			
	CNMG160612-PMK	16.1	15.875	6.35	6.35	1.2	●	▲	●					●			
	CNMG160616-PMK	16.1	15.875	6.35	6.35	1.6	●	▲	●					●			
	CNMG190608-PMK	19.3	19.05	6.35	7.94	0.8	●	▲	●					●			
	CNMG190612-PMK	19.3	19.05	6.35	7.94	1.2	●	▲	●					●			
	CNMG190616-PMK	19.3	19.05	6.35	7.94	1.6	●	▲	●					●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

GR 槽型特点

		经济型粗车削双阶断屑槽，通过阶梯式断屑平台设计平衡加工效率与成本，特别适合机床导轨粗车、工程机械大型铸件批量加工等高金属去除率场景。
		
		双面断屑槽，适合各种钢的内孔及外圆半精到粗加工。
		

适用刀具

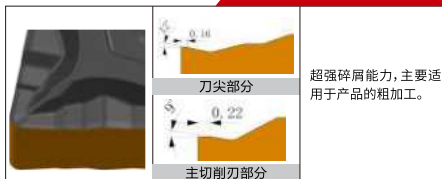
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		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																	
		工件材料 Workpiece Material	P	钢	√	○	×						○	×					
			M	不锈钢										√	○	○	×		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)						CVD涂层						PVD涂层					
		L	ØI.C	T	φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109
																			KS05
																			KS10
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	CNMG120408-MB	12.9	12.7	4.76	5.16	0.8	▲	▲	●					●		●	●		
	CNMG120412-MB	12.9	12.7	4.76	5.16	1.2	▲	▲	●					●		●	●		
	CNMG120416-MB	12.9	12.7	4.76	5.16	1.6	▲	▲	●					●		●	●		
	CNMG160608-MB	16.1	15.875	6.35	6.35	0.8	▲	▲	●					●		●	●		
	CNMG160612-MB	16.1	15.875	6.35	6.35	1.2	▲	▲	●					●		●	●		
	CNMG160616-MB	16.1	15.875	6.35	6.35	1.6	▲	▲	●					●		●	●		
	CNMG190608-MB	19.3	19.05	6.35	7.94	0.8	▲	▲	●					●		●	●		
	CNMG190612-MB	19.3	19.05	6.35	7.94	1.2	▲	▲	●					●		●	●		
	CNMG190616-MB	19.3	19.05	6.35	7.94	1.6	▲	▲	●					●		●	●		
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	CNMG120408-PR	12.9	12.7	4.76	5.16	0.8	▲	▲	●					●					
	CNMG120412-PR	12.9	12.7	4.76	5.16	1.2	▲	▲	●					●					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

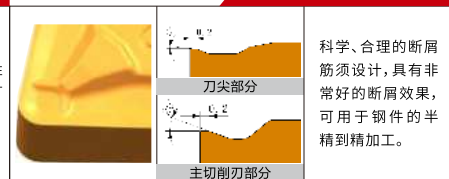
槽型特点 PR



槽型特点 GMR



槽型特点 MB



适用刀具



车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

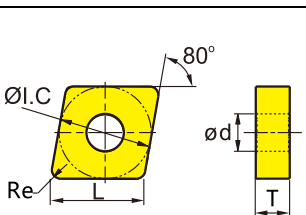
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

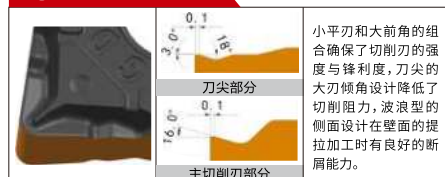
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
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	CNMG120412-GD	12.9	12.7	4.76	5.16	1.2	▲	▲	●					●							
	CNMG120404-GF	12.9	12.7	4.76	5.16	0.4	▲	▲	●					●							
	CNMG120408-GF	12.9	12.7	4.76	5.16	0.8	▲	▲	●					●							
	CNMG120412-GF	12.9	12.7	4.76	5.16	1.2	▲	▲	●					●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

GD 槽型特点



GF 槽型特点



适用刀具

DCLNR/L
KAPR:95°



PCBNR/L
KAPR:75°



PCLNR/L
KAPR:95°



MCBNR/L
KAPR:75°

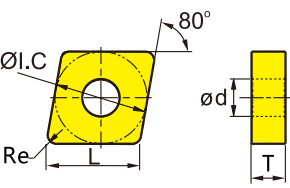


MCLNR/L
KAPR:95°



PCLNR/L
KAPR:95°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢									√	○	○	×					
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金														○	×		
			H	淬硬钢														○			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
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	CNMG120408	12.9	12.7	4.76	5.16	0.8	▲	▲	●					●		●					
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	CNMG160408	16.1	15.875	6.35	6.35	0.8	▲	▲	●					●		●					
	CNMG160412	16.1	15.875	6.35	6.35	1.2	▲	▲	●					●		●					
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	CNMG190608	19.3	19.05	6.35	7.94	0.8	▲	▲	●					●		●					
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	CNMM190608	19.3	19.05	6.35	7.94	0.8	▲	▲	●					●		●					
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▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 L/R-X

槽型特点 通槽

适用刀具
DCLNR/L
KAPR:95°

PCBNR/L
KAPR:75°

PCLNR/L
KAPR:95°

MCBNR/L
KAPR:75°

MCLNR/L
KAPR:95°

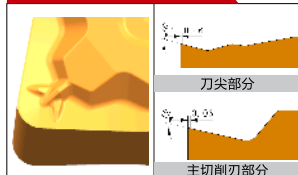
PCLNR/L
KAPR:95°


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
			M	不锈钢										√	○	○	×
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)	L	ØI.C	T	Φd	r	CVD涂层						PVD涂层			
								KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286
																KT8284S	KT8287N
																KT6109	KS05
																	KS10
	CNMG120404-MF	12.9	12.7	4.76	5.16	0.4										•	•
	CNMG120408-MF	12.9	12.7	4.76	5.16	0.8										•	•
	CNMG120412-MF	12.9	12.7	4.76	5.16	1.2										•	•
	CNMG120404-MJ	12.9	12.7	4.76	5.16	0.4										•	•
	CNMG120408-MJ	12.9	12.7	4.76	5.16	0.8										•	•
	CNMG120412-MJ	12.9	12.7	4.76	5.16	1.2										•	•
	CNMG120404-MM-B	12.9	12.7	4.76	5.16	0.4										•	•
	CNMG120408-MM-B	12.9	12.7	4.76	5.16	0.8										•	•
	CNMG120412-MM-B	12.9	12.7	4.76	5.16	1.2										•	•

▲ 为主推荐牌号 Recommended grade (Always stock available)

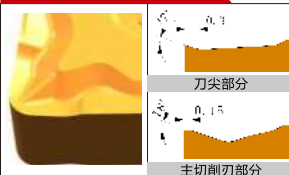
● 按订单生产可选牌号 Make-to-order

MF 槽型特点



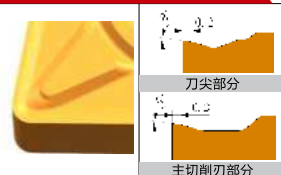
M级双面断屑槽，刃口锋利，有效解决不锈钢断屑，粘刀、表面硬化等加工难点，获得高质量加工表面。

MJ 槽型特点



切削刃锋利，阻力小；带刃倾角设计，导屑好；断屑台前移可在小余量加工状况下实现良好断屑。

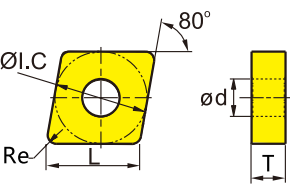
MM-B 槽型特点



刀尖刃口同时兼具锋利性和强度。具有良好的排屑效果，适用于半精偏精加工。

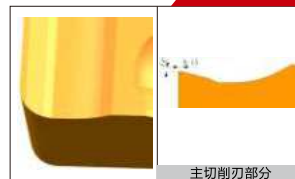
适用刀具

DCLNR/L
KAPR:95°PCBNR/L
KAPR:75°PCLNR/L
KAPR:95°MCBNR/L
KAPR:75°MCLNR/L
KAPR:95°PCLNR/L
KAPR:95°

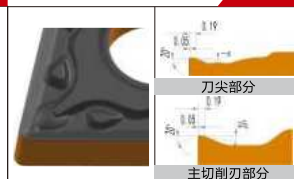
		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																				
		工件材料 Workpiece Material	P	钢		√	○	×					○	×								
			M	不锈钢											√	○	○	×				
			K	铸铁						√	○	×										
			N	有色金属																		
			S	耐热合金、钛合金																	○	×
H	淬硬钢																	○				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10	
	CNMG120404-MP	12.9	12.7	4.76	5.16	0.4										●	▲	▲	●			
	CNMG120408-MP	12.9	12.7	4.76	5.16	0.8										●	▲	▲	●			
	CNMG120412-MP	12.9	12.7	4.76	5.16	1.2										●	▲	▲	●			
	CNMG160608-MP	16.1	15.875	6.35	6.35	0.8										●	▲	▲	●			
	CNMG160612-MP	16.1	15.875	6.35	6.35	1.2										●	▲	▲	●			
	CNMG160616-MP	16.1	15.875	6.35	6.35	1.6										●	▲	▲	●			
	CNMG190608-MP	19.3	19.05	6.35	7.94	0.8										●	▲	▲	●			
	CNMG190612-MP	19.3	19.05	6.35	7.94	1.2										●	▲	▲	●			
CNMG190616-MP	19.3	19.05	6.35	7.94	1.6										●	▲	▲	●				
	CNMG120404L/R-M	12.9	12.7	4.76	5.16	0.4										●	▲	▲	●			
	CNMG120408L/R-M	12.9	12.7	4.76	5.16	0.8										●	▲	▲	●			
	CNMG120412L/R-M	12.9	12.7	4.76	5.16	1.2										●	▲	▲	●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 L/R-M


双面断屑槽，抗冲击能力强，槽型设计在刃口安全性和锋利性取得了最佳平衡点，解决不锈钢粗加工等问题。

槽型特点 MP


通用型中切削正棱刃断屑槽，凭借强化刃口处理技术平衡切削锋利度与耐用性，是法兰盘台阶车削、轴类零件多工序加工等中等负荷钢件车削的理想选择。

适用刀具
DCLNR/L
KAPR:95°

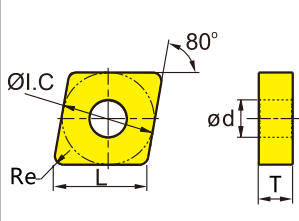
PCBNR/L
KAPR:75°

PCLNR/L
KAPR:95°

MCBNR/L
KAPR:75°

MCLNR/L
KAPR:95°

PCLNR/L
KAPR:95°


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金														○	×		
H	淬硬钢															○					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层								
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	CNMG120408-ZR	12.9	12.7	4.76	5.16	0.8					●	●	▲								
	CNMG120412-ZR	12.9	12.7	4.76	5.16	1.2					●	●	▲								
	CNMG160608-ZR	16.1	15.875	6.35	6.35	0.8					●	●	▲								
	CNMG160612-ZR	16.1	15.875	6.35	6.35	1.2					●	●	▲								
	CNMG160616-ZR	16.1	15.875	6.35	6.35	1.6					●	●	▲								
	CNMG120408-GH	12.9	12.7	4.76	5.16	0.8					●	▲	▲								
	CNMG120412-GH	12.9	12.7	4.76	5.16	1.2					●	▲	▲								
	CNMG160608-GH	16.1	15.875	6.35	6.35	0.8					●	▲	▲								
	CNMG160612-GH	16.1	15.875	6.35	6.35	1.2					●	▲	▲								
	CNMG160616-GH	16.1	15.875	6.35	6.35	1.6					●	▲	▲								
	CNMG120404-UC	12.9	12.7	4.76	5.16	0.4					●	▲	▲								
	CNMG120408-UC	12.9	12.7	4.76	5.16	0.8					●	▲	▲								
	CNMG120412-UC	12.9	12.7	4.76	5.16	1.2					●	▲	▲								
	CNMG120416-UC	12.9	12.7	4.76	5.16	1.6					●	▲	▲								
	CNMG160608-UC	16.1	15.875	6.35	6.35	0.8					●	▲	▲								
	CNMG160612-UC	16.1	15.875	6.35	6.35	1.2					●	▲	▲								
	CNMG160616-UC	16.1	15.875	6.35	6.35	1.6					●	▲	▲								

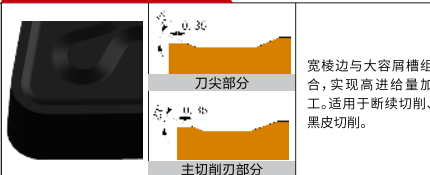
▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

ZR 槽型特点



GH 槽型特点

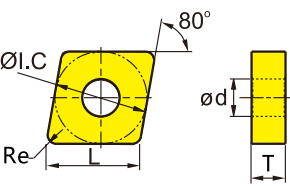


UC 槽型特点



适用刀具

DCLNR/L
KAPR:95°PCBNR/L
KAPR:75°PCLNR/L
KAPR:95°MCBNR/L
KAPR:75°MCLNR/L
KAPR:95°PCLNR/L
KAPR:95°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
		M	不锈钢										√	○	○	×					
		K	铸铁					√	○	×											
		N	有色金属																		
		S	耐热合金、钛合金															○	×		
		H	淬硬钢														○				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	CNMG120404-ZD	12.9	12.7	4.76	5.16	0.4					●	▲	▲								
	CNMG120408-ZD	12.9	12.7	4.76	5.16	0.8					●	▲	▲								
	CNMG120412-ZD	12.9	12.7	4.76	5.16	1.2					●	▲	▲								
	CNMG120416-ZD	12.9	12.7	4.76	5.16	1.6					●	▲	▲								
	CNMG160612-ZD	16.1	15.875	6.35	6.35	1.2					●	▲	▲								
	CNMG160616-ZD	16.1	15.875	6.35	6.35	1.6					●	▲	▲								
	CNMG190612-ZD	19.3	19.05	6.35	7.94	1.2					●	▲	▲								
CNMG190616-ZD	19.3	19.05	6.35	7.94	1.6					●	▲	▲									
	CNMG120404-ZK	12.9	12.7	4.76	5.16	0.4					●	▲	▲								
	CNMG120408-ZK	12.9	12.7	4.76	5.16	0.8					●	▲	▲								
	CNMG120412-ZK	12.9	12.7	4.76	5.16	1.2					●	▲	▲								
	CNMG120416-ZK	12.9	12.7	4.76	5.16	1.6					●	▲	▲								
	CNMG160608-ZK	16.1	15.875	6.35	6.35	0.8					●	▲	▲								
	CNMG160612-ZK	16.1	15.875	6.35	6.35	1.2					●	▲	▲								
	CNMG160616-ZK	16.1	15.875	6.35	6.35	1.6					●	▲	▲								

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 ZK



碳钢/合金钢中切削专用全周断屑槽，扁平棱边强化刃口设计在保持通用性的同时提升刃口刚性，特别适用于液压杆连续车削、传动轴台阶加工等中等负荷钢件车削场景。

槽型特点 ZD



适用于铸铁和硬材料的粗加工采用特质涂层，兼具高耐磨性与抗冲击性能，显著延长刀具寿命。支持高进给与高速切削，适合连续或轻微断续车削工况，提升生产效率。

适用刀具

DCLNR/L
 KAPR:95°


PCBNR/L
 KAPR:75°


PCLNR/L
 KAPR:95°


MCBNR/L
 KAPR:75°


MCLNR/L
 KAPR:95°


PCLNR/L
 KAPR:95°


A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
工件材料 Workpiece Material	P	钢	√	○	×					○	×						
	M	不锈钢										√	○	○	×		
	K	铸铁				√	○	×									
	N	有色金属															
	S	耐热合金、钛合金														○	×
	H	淬硬钢														○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	CNMA120404	12.9	12.7	4.76	5.16	0.4				•	▲	▲					
	CNMA120408	12.9	12.7	4.76	5.16	0.8				•	▲	▲					
	CNMA120412	12.9	12.7	4.76	5.16	1.2				•	▲	▲					
	CNMA120416	12.9	12.7	4.76	5.16	1.6				•	▲	▲					
	CNMA160612	16.1	15.875	6.35	6.35	1.2				•	▲	▲					
	CNMA160616	16.1	15.875	6.35	6.35	1.6				•	▲	▲					
	CNMA190612	19.3	19.05	6.35	7.94	1.2				•	▲	▲					
	CNMA190616	19.3	19.05	6.35	7.94	1.6				•	▲	▲					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

平板 槽型特点



适用刀具

DCLNR/L
KAPR:95°



PCBNR/L
KAPR:75°



PCLNR/L
KAPR:95°



MCBNR/L
KAPR:75°



MCLNR/L
KAPR:95°



PCLNR/L
KAPR:95°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
			M	不锈钢									√	○	○	×	
		K	铸铁				√	○	×								
		N	有色金属														
		S	耐热合金、钛合金													○	×
		H	淬硬钢													○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	CNMG120408-NR	12.9	12.7	4.76	5.16	0.8											● ▲
	CNMG120412-NR	12.9	12.7	4.76	5.16	1.2											● ▲
	CNMG160616-NR	16.1	15.875	6.35	6.35	1.6											● ▲
	CNMG190616-NR	19.3	19.05	6.35	7.94	1.6											● ▲
	CNMG120404-NM	12.9	12.7	4.76	5.16	0.4											● ▲
	CNMG120408-NM	12.9	12.7	4.76	5.16	0.8											● ▲
	CNMG120412-NM	12.9	12.7	4.76	5.16	1.2											● ▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 NM		槽型特点 NR	
	刀尖部分 主切削刃部分		刀尖部分 主切削刃部分
适用于高温合金半精加工的槽型，转位精度高，防止加工硬化、抗磨损能力强，可获得比NF更高的加工效率。双面断屑槽更具经济性。		适用于高温合金材料大切深高效粗加工的槽型。刃口的设计兼顾了锋利和强度，切削阻力小，可有效减小沟槽磨损，增加刀具寿命。	

适用刀具					
DCLNR/L KAPR:95° 	PCBNR/L KAPR:75° 	PCLNR/L KAPR:95° 	MCBNR/L KAPR:75° 	MCLNR/L KAPR:95° 	PCLNR/L KAPR:95°

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

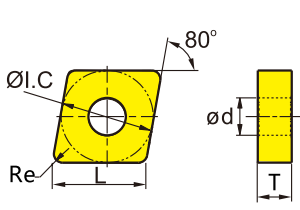
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P 钢 Steel	√	○	×					○	×					
		M 不锈钢 Stainless steel											√	○	○	×	
		K 铸铁 Cast iron				√	○	×									
		N 有色金属 Non-ferrous metal															
		S 耐热合金、钛合金 Heat-resistant alloy, Titanium alloy														○	×
		H 淬硬钢 Hardened steel														○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ØI.C	T	Ød	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	CNMG120404-NF	12.9	12.7	4.76	5.16	0.4											● ▲
	CNMG120408-NF	12.9	12.7	4.76	5.16	0.8											● ▲
	CNMG120412-NF	12.9	12.7	4.76	5.16	1.2											● ▲
	CNMG120404-M2	12.9	12.7	4.76	5.16	0.4											● ▲
	CNMG120404-M2	12.9	12.7	4.76	5.16	0.8											● ▲
	CNMG120404-M2	12.9	12.7	4.76	5.16	1.2											● ▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

NF 槽型特点



M2 槽型特点



适用刀具

DCLNR/L
KAPR:95°



PCBNR/L
KAPR:75°



PCLNR/L
KAPR:95°



MCBNR/L
KAPR:75°



MCLNR/L
KAPR:95°



PCLNR/L
KAPR:95°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	CNMG120404-TFA	12.9	12.7	4.76	5.16	0.4													▲		
	CNMG120408-TFA	12.9	12.7	4.76	5.16	0.8													▲		
	CNMG120412-TFA	12.9	12.7	4.76	5.16	1.2													▲		
	CNMG120404-CM	12.9	12.7	4.76	5.16	0.4													▲		
	CNMG120408-CM	12.9	12.7	4.76	5.16	0.8													▲		
	CNMG120412-CM	12.9	12.7	4.76	5.16	1.2													▲		
	CNMG120404-CF	12.9	12.7	4.76	5.16	0.4													▲		
	CNMG120408-CF	12.9	12.7	4.76	5.16	0.8													▲		
	CNMG120412-CF	12.9	12.7	4.76	5.16	1.2													▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 CF			槽型特点 CM			槽型特点 TFA		
	刀尖部分	0.15		刀尖部分	0.3		刀尖部分	0.3
	主切削刃部分	0.15		主切削刃部分	0.3		主切削刃部分	0.3
刃口锋利, 切削轻快; 适用于淬硬钢等难加工材料的连续精加工, 表面质量优良。			双前角设计, 断屑范围宽; 适用于淬硬钢等难加工材料的断续半精加工及粗加工。			大前角设计, 切削力低; 适用于淬硬钢等难加工材料的轻断续精加工, 加工表面质量好。		

适用刀具					
DCLNR/L KAPR:95°	PCBNR/L KAPR:75°	PCLNR/L KAPR:95°	MCBNR/L KAPR:75°	MCLNR/L KAPR:95°	PCLNR/L KAPR:95°

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

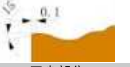
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
工件材料 Workpiece Material	P	钢	√	○	×					○	×						
	M	不锈钢										√	○	○	×		
	K	铸铁				√	○	×									
	N	有色金属															
	S	耐热合金、钛合金														○	×
	H	淬硬钢														○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	DNMG150408-GR	15.5	12.7	4.76	5.16	0.8		▲	●					●			
	DNMG150412-GR	15.5	12.7	4.76	5.16	1.2		▲	●					●			
	DNMG150416-GR	15.5	12.7	4.76	5.16	1.6		▲	●					●			
	DNMG150608-GR	15.5	12.7	6.35	5.16	0.8		▲	●					●			
	DNMG150612-GR	15.5	12.7	6.35	5.16	1.2		▲	●					●			
	DNMG150616-GR	15.5	12.7	6.35	5.16	1.6		▲	●					●			
	DNMG110404-PMK	11.6	9.525	4.76	3.81	0.4	●	▲	●					●			
	DNMG110408-PMK	11.6	9.525	4.76	3.81	0.8	●	▲	●					●			
	DNMG110412-PMK	11.6	9.525	4.76	3.81	1.2	●	▲	●					●			
	DNMG150404-PMK	15.5	12.7	4.76	5.16	0.4	●	▲	●					●			
	DNMG150408-PMK	15.5	12.7	4.76	5.16	0.8	●	▲	●					●			
	DNMG150412-PMK	15.5	12.7	4.76	5.16	1.2	●	▲	●					●			
	DNMG150604-PMK	15.5	12.7	6.35	5.16	0.4	●	▲	●					●			
	DNMG150608-PMK	15.5	12.7	6.35	5.16	0.8	●	▲	●					●			
	DNMG150612-PMK	15.5	12.7	6.35	5.16	1.2	●	▲	●					●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

GR 槽型特点

		经济型粗车削双阶断屑槽，通过阶梯式断屑平台设计平衡加工效率与成本，特别适合机床导轨粗车、工程机械大型铸件批量加工等高金属去除率场景。			双面断屑槽，适合各种钢的内孔及外圆半精到粗加工。
					

适用刀具

DDJNR/L
KAPR:93°



PDJNR/L
KAPR:93°



MDPNN
KAPR:62°30'



MDJNR/L
KAPR:93°



PDUNR/L
KAPR:93°

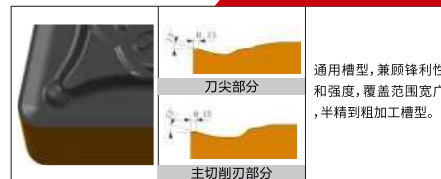


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢									√	○	○	×					
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
H	淬硬钢															○					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	DNMG110404-MB	11.6	9.525	4.76	3.81	0.4	▲	▲	●					●		●	●				
	DNMG110408-MB	11.6	9.525	4.76	3.81	0.8	▲	▲	●					●		●	●				
	DNMG110412-MB	11.6	9.525	4.76	3.81	1.2	▲	▲	●					●		●	●				
	DNMG150404-MB	15.5	12.7	4.76	5.16	0.4	▲	▲	●					●		●	●				
	DNMG150408-MB	15.5	12.7	4.76	5.16	0.8	▲	▲	●					●		●	●				
	DNMG150412-MB	15.5	12.7	4.76	5.16	1.2	▲	▲	●					●		●	●				
	DNMG150604-MB	15.5	12.7	6.35	5.16	0.4	▲	▲	●					●		●	●				
	DNMG150608-MB	15.5	12.7	6.35	5.16	0.8	▲	▲	●					●		●	●				
	DNMG150612-MB	15.5	12.7	6.35	5.16	1.2	▲	▲	●					●		●	●				
	DNMG150404-GMR	15.5	12.7	4.76	5.16	0.4	▲	▲	●					●							
	DNMG150408-GMR	15.5	12.7	4.76	5.16	0.8	▲	▲	●					●							
	DNMG150412-GMR	15.5	12.7	4.76	5.16	1.2	▲	▲	●					●							
	DNMG150604-GMR	15.5	12.7	6.35	5.16	0.4	▲	▲	●					●							
	DNMG150608-GMR	15.5	12.7	6.35	5.16	0.8	▲	▲	●					●							
	DNMG150612-GMR	15.5	12.7	6.35	5.16	1.2	▲	▲	●					●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

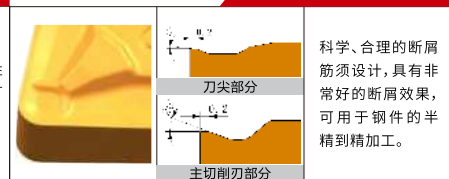
● 按订单生产可选牌号 Make-to-order

槽型特点 GMR



通用槽型，兼顾锋利性和强度，覆盖范围宽广，半精到粗加工槽型。

槽型特点 MB



科学、合理的断屑筋须设计，具有非常好的断屑效果，可用于钢件的半精到精加工。

适用刀具

DDJNR/L
KAPR:93°



PDJNR/L
KAPR:93°



MDPNN
KAPR:62°30'



MDJNR/L
KAPR:93°



PDUNR/L
KAPR:93°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
工件材料 Workpiece Material	P	钢	√	○	×							○	×				
	M	不锈钢												√	○	○	×
	K	铸铁					√	○	×								
	N	有色金属															
	S	耐热合金、钛合金															○
	H	淬硬钢															○
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	DNMG110404-GF	11.6	9.525	4.76	3.81	0.4	▲	▲	●					●			
	DNMG110408-GF	11.6	9.525	4.76	3.81	0.8	▲	▲	●					●			
	DNMG150404-GF	15.5	12.7	4.76	5.16	0.4	▲	▲	●					●			
	DNMG150408-GF	15.5	12.7	4.76	5.16	0.8	▲	▲	●					●			
	DNMG150412-GF	15.5	12.7	4.76	5.16	1.2	▲	▲	●					●			
	DNMG150604-GF	15.5	12.7	6.35	5.16	0.4	▲	▲	●					●			
	DNMG150608-GF	15.5	12.7	6.35	5.16	0.8	▲	▲	●					●			
	DNMG150612-GF	15.5	12.7	6.35	5.16	1.2	▲	▲	●					●			
	DNMG150604	15.5	12.7	6.35	5.16	0.4	▲	▲	●					●		●	
	DNMG150608	15.5	12.7	6.35	5.16	0.8	▲	▲	●					●		●	
	DNMG150612	15.5	12.7	6.35	5.16	1.2	▲	▲	●					●		●	
	DNMG150616	15.5	12.7	6.35	5.16	1.6	▲	▲	●					●		●	
	DNMG150604L/R-X	15.5	12.7	6.35	5.16	0.4	▲	▲	●					●			
	DNMG150608L/R-X	15.5	12.7	6.35	5.16	0.8	▲	▲	●					●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

GF 槽型特点



通槽 槽型特点

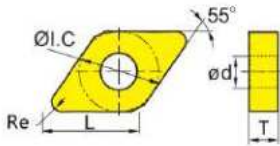


L/R-X 槽型特点



适用刀具

DDJNR/L
KAPR:93°PDJNR/L
KAPR:93°MDPNN
KAPR:62°30'MDJNR/L
KAPR:93°PDUNR/L
KAPR:93°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																				
		工件材料 Workpiece Material	P	钢	√	○	×					○	×									
			M	不锈钢									√	○	○	×						
			K	铸铁				√	○	×												
			N	有色金属																		
			S	耐热合金、钛合金														○	×			
			H	淬硬钢														○				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10	
	DNMG150404-MF	15.5	12.7	4.76	5.16	0.4										●	●	▲	●			
	DNMG150408-MF	15.5	12.7	4.76	5.16	0.8										●	●	▲	●			
	DNMG150412-MF	15.5	12.7	4.76	5.16	1.2										●	●	▲	●			
	DNMG150604-MF	15.5	12.7	6.35	5.16	0.4										●	●	▲	●			
	DNMG150608-MF	15.5	12.7	6.35	5.16	0.8										●	●	▲	●			
	DNMG150612-MF	15.5	12.7	6.35	5.16	1.2										●	●	▲	●			
	DNMG150404-MJ	15.5	12.7	4.76	5.16	0.4										●	●	▲	●			
	DNMG150408-MJ	15.5	12.7	4.76	5.16	0.8										●	●	▲	●			
	DNMG150412-MJ	15.5	12.7	4.76	5.16	1.2										●	●	▲	●			
	DNMG150604-MJ	15.5	12.7	6.35	5.16	0.4										●	●	▲	●			
	DNMG150608-MJ	15.5	12.7	6.35	5.16	0.8										●	●	▲	●			
	DNMG150612-MJ	15.5	12.7	6.35	5.16	1.2										●	●	▲	●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 MJ		槽型特点 MF	
	刀尖部分		刀尖部分
	主切削刃部分		主切削刃部分
切削刃锋利，阻力小；带刃倾角设计，导屑好；断屑台前移可在小余量加工状况下实现良好断屑。		M级双面断屑槽，刃口锋利，有效解决不锈钢断屑，粘刀、表面硬化等加工难点，获得高质量加工表面。	

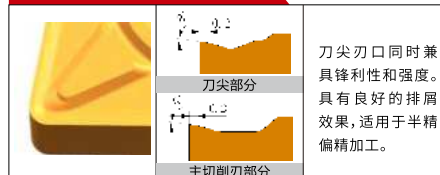
适用刀具				
DDJNR/L KAPR:93° 	PDJNR/L KAPR:93° 	MDPNN KAPR:62°30' 	MDJNR/L KAPR:93° 	PDUNR/L KAPR:93° 

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
工件材料 Workpiece Material	P	钢	√	○	×						○	×					
	M	不锈钢											√	○	○	×	
	K	铸铁				√	○	×									
	N	有色金属															
	S	耐热合金、钛合金														○	×
	H	淬硬钢														○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	DNMG150404-MM-B	15.5	12.7	4.76	5.16	0.4									•	•	▲
	DNMG150408-MM-B	15.5	12.7	4.76	5.16	0.8									•	•	▲
	DNMG150412-MM-B	15.5	12.7	4.76	5.16	1.2									•	•	▲
	DNMG150604-MM-B	15.5	12.7	6.35	5.16	0.4									•	•	▲
	DNMG150608-MM-B	15.5	12.7	6.35	5.16	0.8									•	•	▲
	DNMG150612-MM-B	15.5	12.7	6.35	5.16	1.2									•	•	▲
	DNMG110404-MP	11.6	9.525	4.76	3.81	0.4									•	▲	▲
	DNMG110408-MP	11.6	9.525	4.76	3.81	0.8									•	▲	▲
	DNMG110412-MP	11.6	9.525	4.76	3.81	1.2									•	▲	▲
	DNMG150404-MP	15.5	12.7	4.76	5.16	0.4									•	▲	▲
	DNMG150408-MP	15.5	12.7	4.76	5.16	0.8									•	▲	▲
	DNMG150412-MP	15.5	12.7	4.76	5.16	1.2									•	▲	▲
	DNMG150604-MP	15.5	12.7	6.35	5.16	0.4									•	▲	▲
	DNMG150608-MP	15.5	12.7	6.35	5.16	0.8									•	▲	▲
	DNMG150612-MP	15.5	12.7	6.35	5.16	1.2									•	▲	▲
	DNMG150604L/R-M	15.5	12.7	6.35	5.16	0.4									•	▲	▲
	DNMG150608L/R-M	15.5	12.7	6.35	5.16	0.8									•	▲	▲

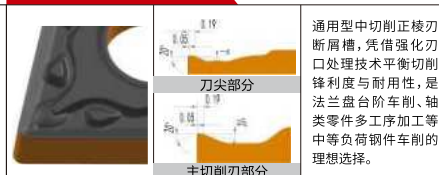
▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

MM-B 槽型特点



MP 槽型特点

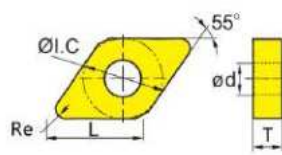


L/R-M 槽型特点



适用刀具

DDJNR/L
KAPR:93°PDJNR/L
KAPR:93°MDPNN
KAPR:62°30'MDJNR/L
KAPR:93°PDUNR/L
KAPR:93°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢									√	○	○	×					
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金														○	×		
H	淬硬钢														○						
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层								
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	DNMG150408-ZR	15.5	12.7	4.76	5.16	0.8					●	●	▲								
	DNMG150412-ZR	15.5	12.7	4.76	5.16	1.2					●	●	▲								
	DNMG150608-ZR	15.5	12.7	6.35	5.16	0.8					●	●	▲								
	DNMG150612-ZR	15.5	12.7	6.35	5.16	1.2					●	●	▲								
	DNMG150404-UC	15.5	12.7	4.76	5.16	0.4					●	●	▲								
	DNMG150408-UC	15.5	12.7	4.76	5.16	0.8					●	●	▲								
	DNMG150412-UC	15.5	12.7	4.76	5.16	1.2					●	●	▲								
	DNMG150416-UC	15.5	12.7	4.76	5.16	1.6					●	●	▲								
	DNMG150604-UC	15.5	12.7	6.35	5.16	0.4					●	●	▲								
	DNMG150608-UC	15.5	12.7	6.35	5.16	0.8					●	●	▲								
	DNMG150612-UC	15.5	12.7	6.35	5.16	1.2					●	●	▲								
	DNMG150616-UC	15.5	12.7	6.35	5.16	1.6					●	●	▲								

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 UC		槽型特点 ZR	
			
	刀尖部分		刀尖部分
	主切削刃部分		主切削刃部分
碳钢、合金钢中切削用第二推荐断屑槽。扁平棱边刃形，切削刃强度高。通用性高的全周断屑槽形状。		碳钢、合金钢、不锈钢准重切削用采用以往产品3倍以上的安装面积与宽棱边，在断续切削、黑皮切削中发挥出色的切削刃稳定性。	

适用刀具				
DDJNR/L KAPR:93° 	PDJNR/L KAPR:93° 	MDPNN KAPR:62°30' 	MDJNR/L KAPR:93° 	PDUNR/L KAPR:93° 

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

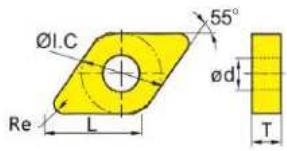
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	DNMG150408-GH	15.5	12.7	4.76	5.16	0.8					●	▲	▲								
	DNMG150412-GH	15.5	12.7	4.76	5.16	1.2					●	▲	▲								
	DNMG150608-GH	15.5	12.7	6.35	5.16	0.8					●	▲	▲								
	DNMG150612-GH	15.5	12.7	6.35	5.16	1.2					●	▲	▲								
	DNMG150404-ZD	15.5	12.7	4.76	5.16	0.4					●	▲	▲								
	DNMG150408-ZD	15.5	12.7	4.76	5.16	0.8					●	▲	▲								
	DNMG150412-ZD	15.5	12.7	4.76	5.16	1.2					●	▲	▲								
	DNMG150604-ZD	15.5	12.7	6.35	5.16	0.4					●	▲	▲								
	DNMG150608-ZD	15.5	12.7	6.35	5.16	0.8					●	▲	▲								
	DNMG150612-ZD	15.5	12.7	6.35	5.16	1.2					●	▲	▲								

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

GH 槽型特点



宽棱边与大容量槽组合，实现高进给量加工。适用于断续切削、黑皮切削。

ZD 槽型特点



适用于铸铁和硬材料的粗加工采用特质涂层，兼具高耐磨性与抗冲击性能，显著延长刀具寿命。支持高进给与高速切削，适合连续或轻微断续车削工况，提升生产效率。

适用刀具

DDJNR/L
KAPR:93°



PDJNR/L
KAPR:93°



MDPNN
KAPR:62°30'

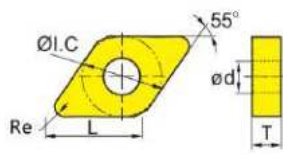


MDJNR/L
KAPR:93°



PDUNR/L
KAPR:93°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢										√	○	○	×	
		K	铸铁					√	○	×							
		N	有色金属														
		S	耐热合金、钛合金													○	×
		H	淬硬钢													○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	DNMG150404-ZK	15.5	12.7	4.76	5.16	0.4				•	▲	▲					
	DNMG150408-ZK	15.5	12.7	4.76	5.16	0.8				•	▲	▲					
	DNMG150412-ZK	15.5	12.7	4.76	5.16	1.2				•	▲	▲					
	DNMG150416-ZK	15.5	12.7	4.76	5.16	1.6				•	▲	▲					
	DNMG150604-ZK	15.5	12.7	6.35	5.16	0.4				•	▲	▲					
	DNMG150608-ZK	15.5	12.7	6.35	5.16	0.8				•	▲	▲					
	DNMG150612-ZK	15.5	12.7	6.35	5.16	1.2				•	▲	▲					
	DNMA150404	15.5	12.7	4.76	5.16	0.4				•	▲	▲					
	DNMA150408	15.5	12.7	4.76	5.16	0.8				•	▲	▲					
	DNMA150412	15.5	12.7	4.76	5.16	1.2				•	▲	▲					
	DNMA150604	15.5	12.7	6.35	5.16	0.4				•	▲	▲					
	DNMA150608	15.5	12.7	6.35	5.16	0.8				•	▲	▲					
	DNMA150612	15.5	12.7	6.35	5.16	1.2				•	▲	▲					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 平板		槽型特点 ZK	
	刀尖部分		刀尖部分
	主切削刃部分		主切削刃部分
双面加工，刃口强度高，是克服铸铁加工中砂眼、夹渣等不良加工因素的刀片结构的解决方案。		碳钢/合金钢中切削专用全周断屑槽，扁平棱边强化刃口设计在保持通用性的同时提升刃口刚性，特别适用于液压杆连续车削、传动轴台阶加工等中等负荷钢件车削场景。	

适用刀具				
DDJNR/L KAPR:93° 	PDJNR/L KAPR:93° 	MDPNN KAPR:62°30' 	MDJNR/L KAPR:93° 	PDUNR/L KAPR:93° 

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

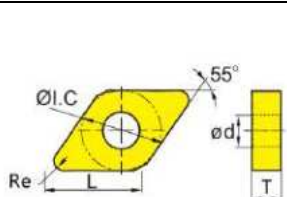
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

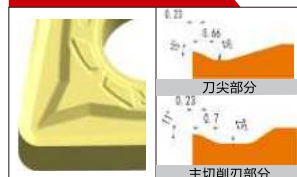
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	DNMG150608-NR	15.5	12.7	6.35	5.16	0.8														●	▲
	DNMG150612-NR	15.5	12.7	6.35	5.16	1.2														●	▲
																					▲
	DNMG150412-NM	15.5	12.7	4.76	5.16	1.2														●	▲
	DNMG150612-NM	15.5	12.7	6.35	5.16	1.2														●	▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

NR 槽型特点



适用于高温合金类材料大切深高效粗加工的槽型。刃口的设计兼顾了锋利和强度，切削阻力小，可有效减小沟槽磨损，增加刀具寿命。

NM 槽型特点



适用于高温合金半精加工的槽型，转位精度高，防止加工硬化、抗磨损能力强，可获得比NF更高的加工效率。双面断屑槽更具经济性。

适用刀具

DDJNR/L
KAPR:93°



PDJNR/L
KAPR:93°



MDPNN
KAPR:62°30'



MDJNR/L
KAPR:93°



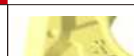
PDUNR/L
KAPR:93°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢									√	○	○	×					
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金														○	×		
			H	淬硬钢														○			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	DNMG150404-NF	15.5	12.7	4.76	5.16	0.4														●	▲
	DNMG150408-NF	15.5	12.7	4.76	5.16	0.8														●	▲
	DNMG150604-NF	15.5	12.7	6.35	5.16	0.4														●	▲
	DNMG150608-NF	15.5	12.7	6.35	5.16	0.8														●	▲
	DNMG150404-M2	15.5	12.7	4.76	5.16	0.4														●	▲
	DNMG150408-M2	15.5	12.7	4.76	5.16	0.8														●	▲
	DNMG150604-M2	15.5	12.7	6.35	5.16	0.4														●	▲
	DNMG150608-M2	15.5	12.7	6.35	5.16	0.8														●	▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 M2			槽型特点 NF		
	刀尖部分			刀尖部分	
	主切削刃部分			主切削刃部分	
	通用正前角槽型，设计用于精加工高温合金以及硬质材料部分有色金属材料，用于连续切削。			适用于高温合金精加工的槽型，转位精度高，防止加工硬化、抗磨损能力强，更锋利的刃口设计可获得高加工精度和表面质量。双面断屑槽兼顾经济性。	

适用刀具				
DDJNR/L KAPR:93° 	PDJNR/L KAPR:93° 	MDPNN KAPR:62°30' 	MDJNR/L KAPR:93° 	PDUNR/L KAPR:93°

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

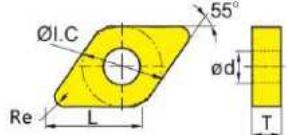
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

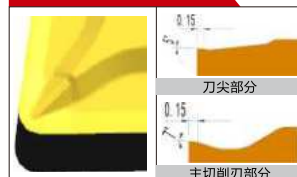
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢		√	○	×					○	×							
			M	不锈钢											√	○	○	×			
			K	铸铁						√	○	×									
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层							PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	DNMG150404-TFA	15.5	12.7	4.76	5.16	0.4													▲		
	DNMG150408-TFA	15.5	12.7	4.76	5.16	0.8													▲		
	DNMG150412-TFA	15.5	12.7	4.76	5.16	1.2													▲		
	DNMG150404-CM	15.5	12.7	4.76	5.16	0.4													▲		
	DNMG150408-CM	15.5	12.7	4.76	5.16	0.8													▲		
	DNMG150412-CM	15.5	12.7	4.76	5.16	1.2													▲		
	DNMG150404-CF	15.5	12.7	4.76	5.16	0.4													▲		
	DNMG150408-CF	15.5	12.7	4.76	5.16	0.8													▲		
	DNMG150412-CF	15.5	12.7	4.76	5.16	1.2													▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

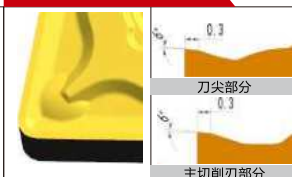
● 按订单生产可选牌号 Make-to-order

CF 槽型特点



刃口锋利, 切削轻快;
适用于淬硬钢等难加工材料的连续精加工, 表面质量优良。

CM 槽型特点



双前角设计, 断屑范围宽; 适用于淬硬钢等难加工材料的断续半精加工及粗加工。

TFA 槽型特点



大前角设计, 切削力低; 适用于淬硬钢等难加工材料的轻断续精加工, 加工表面质量好。

适用刀具

DDJNR/L
KAPR:93°



PDJNR/L
KAPR:93°



MDPNN
KAPR:62°30'

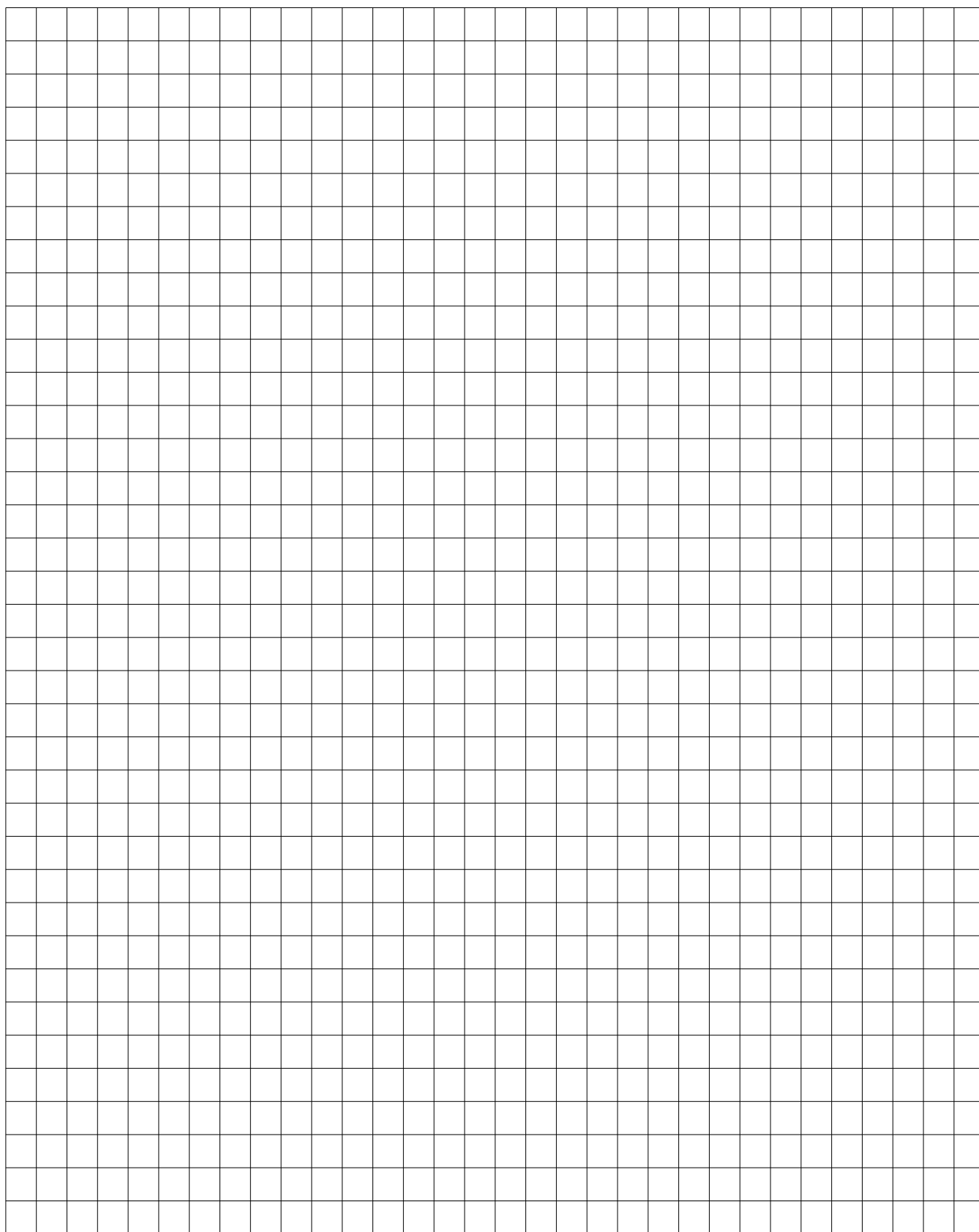


MDJNR/L
KAPR:93°



PDUNR/L
KAPR:93°




A
 车削刀片

B
 铣削刀片

C
 铝合金刀片

D
 孔加工刀片

E
 刮管刀片

F
 非标异形刀片

G
 圆棒和立铣刀

H
 刀杆和刀盘

I
 加工案例

J
 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
工件材料 Workpiece Material	P	钢	√	○	×						○	×					
	M	不锈钢											√	○	○	×	
	K	铸铁				√	○	×									
	N	有色金属															
	S	耐热合金、钛合金														○	×
	H	淬硬钢														○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	SNMG120408-GR	12.7	12.7	4.76	5.16	0.8		▲	●					●			
	SNMG120412-GR	12.7	12.7	4.76	5.16	1.2		▲	●					●			
	SNMG120416-GR	12.7	12.7	4.76	5.16	1.6		▲	●					●			
	SNMG150608-GR	15.875	15.875	6.35	6.35	0.8		▲	●					●			
	SNMG150612-GR	15.875	15.875	6.35	6.35	1.2		▲	●					●			
	SNMG150616-GR	15.875	15.875	6.35	6.35	1.6		▲	●					●			
	SNMG150624-GR	15.875	15.875	6.35	6.35	2.4		▲	●					●			
	SNMG190612-GR	19.05	19.05	6.35	7.94	1.2		▲	●					●			
	SNMG190616-GR	19.05	19.05	6.35	7.94	1.6		▲	●					●			
	SNMG190624-GR	19.05	19.05	6.35	7.94	2.4		▲	●					●			
	SNMG120404-PMK	12.7	12.7	4.76	5.16	0.4	●	▲	●					●			
	SNMG120408-PMK	12.7	12.7	4.76	5.16	0.8	●	▲	●					●			
	SNMG120412-PMK	12.7	12.7	4.76	5.16	1.2	●	▲	●					●			
	SNMG150608-PMK	15.875	15.875	6.35	6.35	0.8	●	▲	●					●			
	SNMG150612-PMK	15.875	15.875	6.35	6.35	1.2	●	▲	●					●			
	SNMG150616-PMK	15.875	15.875	6.35	6.35	1.6	●	▲	●					●			
	SNMG190612-PMK	19.05	19.05	6.35	7.94	1.2	●	▲	●					●			
	SNMG190616-PMK	19.05	19.05	6.35	7.94	1.6	●	▲	●					●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

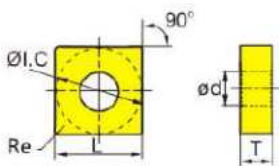
GR 槽型特点



PMK 槽型特点

适用刀具

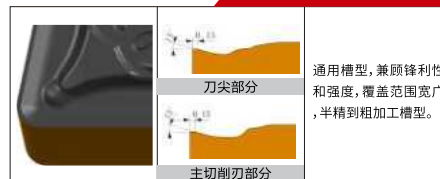
DSBNR/L
KAPR:75°MSBNR/L
KAPR:75°MSRNR/L
KAPR:75°MSKNR/L
KAPR:75°MSDNN
KAPR:45°PSKNR/L
KAPR:75°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢									√	○	○	×					
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金														○	×		
			H	淬硬钢														○			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层							PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	SNMG120404-MB	12.7	12.7	4.76	5.16	0.4	▲	▲	●					●		●	●				
	SNMG120408-MB	12.7	12.7	4.76	5.16	0.8	▲	▲	●					●		●	●				
	SNMG120412-MB	12.7	12.7	4.76	5.16	1.6	▲	▲	●					●		●	●				
	SNMG120416-MB	12.7	12.7	4.76	5.16	1.6	▲	▲	●					●		●	●				
	SNMG150608-MB	15.875	15.875	6.35	6.35	0.8	▲	▲	●					●		●	●				
	SNMG150612-MB	15.875	15.875	6.35	6.35	1.2	▲	▲	●					●		●	●				
	SNMG120404-GMR	12.7	12.7	4.76	5.16	0.4	▲	▲	●					●							
	SNMG120408-GMR	12.7	12.7	4.76	5.16	0.8	▲	▲	●					●							
	SNMG120412-GMR	12.7	12.7	4.76	5.16	1.2	▲	▲	●					●							

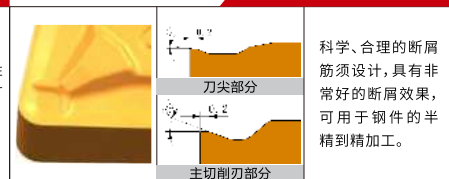
▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 GMR



槽型特点 MB



适用刀具

DSBNR/L
KAPR:75°



MSBNR/L
KAPR:75°



MSRNR/L
KAPR:75°



MSKNR/L
KAPR:75°



MSDNN
KAPR:45°



PSKNR/L
KAPR:75°

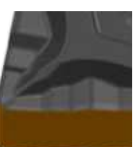


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
工件材料 Workpiece Material	P	钢	√	○	×						○	×					
	M	不锈钢											√	○	○	×	
	K	铸铁					√	○	×								
	N	有色金属															
	S	耐热合金、钛合金														○	×
	H	淬硬钢														○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	SNMG120404-GD	12.7	12.7	4.76	5.16	0.4	▲	▲	●					●			
	SNMG120408-GD	12.7	12.7	4.76	5.16	0.8	▲	▲	●					●			
	SNMG120412-GD	12.7	12.7	4.76	5.16	1.2	▲	▲	●					●			
	SNMG120404-PR	12.7	12.7	4.76	5.16	0.4	▲	▲	●					●			
	SNMG120408-PR	12.7	12.7	4.76	5.16	0.8	▲	▲	●					●			
	SNMG120412-PR	12.7	12.7	4.76	5.16	1.2	▲	▲	●					●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

GD 槽型特点

		小平刃和大前角的组合确保了切削刃的强度与锋利度，刀尖的大刃倾角设计降低了切削阻力，波浪型的侧面设计在壁面的提拉加工时有良好的断屑能力。			超强碎屑能力，主要适用于产品的粗加工。
					

适用刀具

DSBNR/L
KAPR:75°



MSBNR/L
KAPR:75°



MSRNR/L
KAPR:75°



MSKNR/L
KAPR:75°



MSDNN
KAPR:45°



PSKNR/L
KAPR:75°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢									√	○	○	×					
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
H	淬硬钢															○					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	SNMG120404-GF	12.7	12.7	4.76	5.16	0.4	▲	▲	●						●		●				
	SNMG120408-GF	12.7	12.7	4.76	5.16	0.8	▲	▲	●						●		●				
	SNMG120412-GF	12.7	12.7	4.76	5.16	1.2	▲	▲	●						●		●				
	SNMG090304	9.525	9.525	3.18	3.81	0.4	▲	▲	●						●		●				
	SNMG090308	9.525	9.525	3.18	3.81	0.8	▲	▲	●						●		●				
	SNMG120404	12.7	12.7	4.76	5.16	0.4	▲	▲	●						●		●				
	SNMG120408	12.7	12.7	4.76	5.16	0.8	▲	▲	●						●		●				
	SNMG120412	12.7	12.7	4.76	5.16	1.2	▲	▲	●						●		●				
	SNMG150608	15.875	15.875	6.35	6.35	0.8	▲	▲	●						●		●				
	SNMG150612	15.875	15.875	6.35	6.35	1.2	▲	▲	●						●		●				
	SNMG190612	19.05	19.05	6.35	7.94	1.2	▲	▲	●						●		●				
	SNMG190616	19.05	19.05	6.35	7.94	1.6	▲	▲	●						●		●				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 通槽		槽型特点 GF		
				
	刀尖部分			刀尖部分
	主切削刃部分			主切削刃部分
碳钢、合金钢中切削用第二推荐断屑槽。扁平棱边刃形，切削刃强度高。通用性高的全周断屑槽形状。		专为碳钢/合金钢轻切削优化的曲线刃断屑槽，特殊的槽型设计实现稳定排屑，有效解决薄壁件加工中的缠屑问题，特别适用于细长轴精密车削及小切深连续加工场景。		

适用刀具					
DSBNR/L KAPR:75°	MSBNR/L KAPR:75°	MSRNR/L KAPR:75°	MSKNR/L KAPR:75°	MSDNN KAPR:45°	PSKNR/L KAPR:75°

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

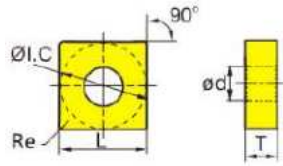
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

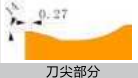
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
H	淬硬钢															○					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层							PVD涂层							
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	SNMM120408	12.7	12.7	4.76	5.16	0.8	▲	▲	●					●		●					
	SNMM120412	12.7	12.7	4.76	5.16	1.2	▲	▲	●					●		●					
	SNMM120416	12.7	12.7	4.76	5.16	1.6	▲	▲	●					●		●					
	SNMM190608	19.05	19.05	6.35	7.94	0.8	▲	▲	●					●		●					
	SNMM190612	19.05	19.05	6.35	7.94	1.2	▲	▲	●					●		●					
	SNMM190616	19.05	19.05	6.35	7.94	1.6	▲	▲	●					●		●					
	SNMG120404L/R-X	12.7	12.7	4.76	5.16	0.4	▲	▲	●					●							
	SNMG120408L/R-X	12.7	12.7	4.76	5.16	0.8	▲	▲	●					●							
	SNMG120412L/R-X	12.7	12.7	4.76	5.16	1.2	▲	▲	●					●							
	SNMG150608L/R-X	15.875	15.875	6.35	6.35	0.8	▲	▲	●					●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

通槽 槽型特点

		碳钢、合金钢中切削 用第二推荐断屑槽。 扁平棱边刃形，切削 刃强度高。通用性高 的全周断屑槽形状。			平行断屑槽。中进给量 条件下，切屑处理良好。
					

L/R-X 槽型特点

适用刀具

DSBNR/L
KAPR:75°



MSBNR/L
KAPR:75°



MSRNR/L
KAPR:75°



MSKNR/L
KAPR:75°

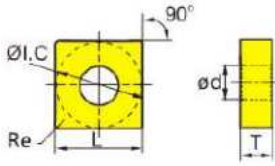


MSDNN
KAPR:45°



PSKNR/L
KAPR:75°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢										√	○	○	×	
		K	铸铁				√	○	×								
		N	有色金属														
		S	耐热合金、钛合金													○	×
		H	淬硬钢													○	

产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)						CVD涂层						PVD涂层					
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109
	SNMG120404-MF	12.7	12.7	4.76	5.16	0.4									•	•	▲	•	
	SNMG120408-MF	12.7	12.7	4.76	5.16	0.8									•	•	▲	•	
	SNMG120412-MF	12.7	12.7	4.76	5.16	1.2									•	•	▲	•	
	SNMG120404-MJ	12.7	12.7	4.76	5.16	0.4									•	•	▲	•	
	SNMG120408-MJ	12.7	12.7	4.76	5.16	0.8									•	•	▲	•	
	SNMG120412-MJ	12.7	12.7	4.76	5.16	1.2									•	•	▲	•	
	SNMG120404-MM-B	12.7	12.7	4.76	5.16	0.4									•	▲	▲	•	
	SNMG120408-MM-B	12.7	12.7	4.76	5.16	0.8									•	▲	▲	•	
	SNMG120412-MM-B	12.7	12.7	4.76	5.16	1.2									•	▲	▲	•	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 MM-B			槽型特点 MJ			槽型特点 MF		
								
	刀尖部分			刀尖部分			刀尖部分	
								
主切削刃部分			主切削刃部分			主切削刃部分		
刀尖刃口同时兼具锋利性和强度。具有良好的排屑效果，适用于半精偏精加工。			切削刃锋利，阻力小；带刃倾角设计，导屑好；断屑台前移可在小余量加工状况下实现良好断屑。			M级双面断屑槽，刃口锋利，有效解决不锈钢断屑，粘刀、表面硬化等加工难点，获得高质量加工表面。		

适用刀具					
DSBNR/L KAPR:75°	MSBNR/L KAPR:75°	MSRNR/L KAPR:75°	MSKNR/L KAPR:75°	MSDNN KAPR:45°	PSKNR/L KAPR:75°
					

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

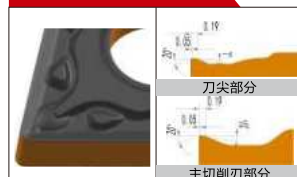
		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢											√	○	○	×
		K	铸铁					√	○	×							
		N	有色金属														
		S	耐热合金、钛合金													○	×
		H	淬硬钢													○	

产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层					
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N
	SNMG090304-MP	9.525	9.525	3.18	3.81	0.4									•	▲	▲	•
	SNMG090308-MP	9.525	9.525	3.18	3.81	0.8									•	▲	▲	•
	SNMG120404-MP	12.7	12.7	4.76	5.16	0.4									•	▲	▲	•
	SNMG120408-MP	12.7	12.7	4.76	5.16	0.8									•	▲	▲	•
	SNMG120412-MP	12.7	12.7	4.76	5.16	1.2									•	▲	▲	•
	SNMG120404L/R-M	12.7	12.7	4.76	5.16	0.4									•	▲	▲	•
	SNMG120408L/R-M	12.7	12.7	4.76	5.16	0.8									•	▲	▲	•
	SNMG120412L/R-M	12.7	12.7	4.76	5.16	1.2									•	▲	▲	•
	SNMG150608L/R-M	15.875	15.875	6.35	6.35	0.8									•	▲	▲	•

▲ 为主推荐牌号 Recommended grade (Always stock available)

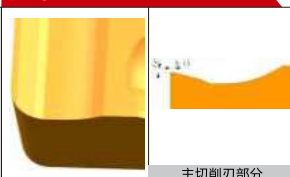
● 按订单生产可选牌号 Make-to-order

MP 槽型特点



通用型中切削正棱刃断屑槽，凭借强化刃口处理技术平衡切削锋利度与耐用性，是法兰盘台阶车削、轴类零件多工序加工等中等负荷钢件车削的理想选择。

L/R-M 槽型特点



双面断屑槽，抗冲击能力强，槽型设计在刃口安全性和锋利性取得了最佳平衡点，解决不锈钢粗加工等问题。

适用刀具

DSBNR/L
KAPR:75°



MSBNR/L
KAPR:75°



MSRNR/L
KAPR:75°



MSKNR/L
KAPR:75°

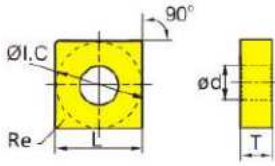


MSDNN
KAPR:45°



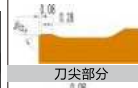
PSKNR/L
KAPR:75°



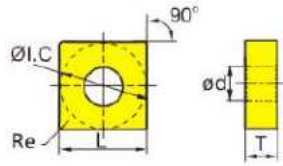
		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢										√	○	○	×	
		K	铸铁				√	○	×								
		N	有色金属														
		S	耐热合金、钛合金													○	×
		H	淬硬钢													○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ØI.C	T	φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	SNMG120408-ZR	12.7	12.7	4.76	5.16	0.8				•	•	▲					
	SNMG120412-ZR	12.7	12.7	4.76	5.16	1.2				•	•	▲					
	SNMG120416-ZR	12.7	12.7	4.76	5.16	1.6				•	•	▲					
	SNMG150612-ZR	15.875	15.875	6.35	6.35	1.2				•	•	▲					
	SNMG150616-ZR	15.875	15.875	6.35	6.35	1.6				•	•	▲					
	SNMG120404-UC	12.7	12.7	4.76	5.16	0.4				•	•	▲					
	SNMG120408-UC	12.7	12.7	4.76	5.16	0.8				•	•	▲					
	SNMG120412-UC	12.7	12.7	4.76	5.16	1.2				•	•	▲					
	SNMG120416-UC	12.7	12.7	4.76	5.16	1.6				•	•	▲					
	SNMG150608-UC	15.875	15.875	6.35	6.35	0.8				•	•	▲					
	SNMG150612-UC	15.875	15.875	6.35	6.35	1.2				•	•	▲					
	SNMG190612-UC	19.05	19.05	6.35	7.94	1.2				•	•	▲					
	SNMG190616-UC	19.05	19.05	6.35	7.94	1.6				•	•	▲					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 UC		槽型特点 ZR	
			
	刀尖部分		刀尖部分
	主切削刃部分		主切削刃部分
碳钢、合金钢中切削用第二推荐断屑槽。扁平棱边刃形，切削刃强度高。通用性高的全周断屑槽形状。		碳钢、合金钢、不锈钢准重切削用采用以往产品3倍以上的安装面积与宽棱边，在断续切削、黑皮切削中发挥出色的切削刃稳定性。	

适用刀具					
DSBNR/L KAPR:75°	MSBNR/L KAPR:75°	MSRNR/L KAPR:75°	MSKNR/L KAPR:75°	MSDNN KAPR:45°	PSKNR/L KAPR:75°
					

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
		K	铸铁					√	○	×											
		N	有色金属																		
		S	耐热合金、钛合金															○	×		
		H	淬硬钢															○			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层								
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	SNMG120408-ZD	12.7	12.7	4.76	5.16	0.8				●	▲	▲									
	SNMG120412-ZD	12.7	12.7	4.76	5.16	1.2				●	▲	▲									
	SNMG120416-ZD	12.7	12.7	4.76	5.16	1.6				●	▲	▲									
	SNMG150612-ZD	15.875	15.875	6.35	6.35	1.2				●	▲	▲									
	SNMG150616-ZD	15.875	15.875	6.35	6.35	1.6				●	▲	▲									
	SNMG190612-ZD	19.05	19.05	6.35	7.94	1.2				●	▲	▲									
	SNMG190616-ZD	19.05	19.05	6.35	7.94	1.6				●	▲	▲									
	SNMG120404-ZK	12.7	12.7	4.76	5.16	0.4				●	▲	▲									
	SNMG120408-ZK	12.7	12.7	4.76	5.16	0.8				●	▲	▲									
	SNMG120412-ZK	12.7	12.7	4.76	5.16	1.2				●	▲	▲									
	SNMG120416-ZK	12.7	12.7	4.76	5.16	1.6				●	▲	▲									
	SNMG150608-ZK	15.875	15.875	6.35	6.35	0.8				●	▲	▲									
	SNMG150612-ZK	15.875	15.875	6.35	6.35	1.2				●	▲	▲									
	SNMG190612-ZK	19.05	19.05	6.35	7.94	1.2				●	▲	▲									
	SNMG190616-ZK	19.05	19.05	6.35	7.94	1.6				●	▲	▲									

▲ 为主推荐牌号 Recommended grade (Always stock available)

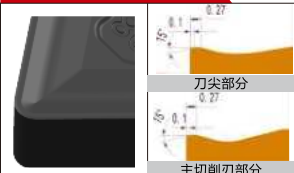
● 按订单生产可选牌号 Make-to-order

ZD 槽型特点



适用于铸铁和硬材料的粗加工采用特质涂层，兼具高耐磨性与抗冲击性能，显著延长刀具寿命。支持高进给与高速切削，适合连续或轻微断续车削工况，提升生产效率。

ZK 槽型特点



碳钢/合金钢中切削专用全周断屑槽，扁平棱边强化刃口设计在保持通用性的同时提升刃口刚性，特别适用于液压杆连续车削、传动轴台阶加工等中等负荷钢件车削场景。

适用刀具

DSBNR/L
KAPR:75°MSBNR/L
KAPR:75°MSRNR/L
KAPR:75°MSKNR/L
KAPR:75°MSDNN
KAPR:45°PSKNR/L
KAPR:75°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
	型号 Type	M	不锈钢										√	○	○	×	
		K	铸铁				√	○	×								
		N	有色金属														
		S	耐热合金、钛合金													○	×
		H	淬硬钢													○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ØI.C	T	φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	SNMG120408-GH	12.7	12.7	4.76	5.16	0.8				•	▲	▲					
	SNMG120412-GH	12.7	12.7	4.76	5.16	1.2				•	▲	▲					
	SNMG120416-GH	12.7	12.7	4.76	5.16	1.6				•	▲	▲					
	SNMG150612-GH	15.875	15.875	6.35	6.35	1.2				•	▲	▲					
	SNMG150616-GH	15.875	15.875	6.35	6.35	1.6				•	▲	▲					
	SNMG120404-ZT	12.7	12.7	4.76	5.16	0.4				•	•	▲					
	SNMG120408-ZT	12.7	12.7	4.76	5.16	0.8				•	•	▲					
	SNMG120412-ZT	12.7	12.7	4.76	5.16	1.2				•	•	▲					
	SNMA120408	12.7	12.7	4.76	5.16	0.8				•	▲	▲					
	SNMA120412	12.7	12.7	4.76	5.16	1.2				•	▲	▲					
	SNMA120416	12.7	12.7	4.76	5.16	1.6				•	▲	▲					
	SNMA150612	15.875	15.875	6.35	6.35	1.2				•	▲	▲					
	SNMA150616	15.875	15.875	6.35	6.35	1.6				•	▲	▲					
	SNMA190612	19.05	19.05	6.35	7.94	1.2				•	▲	▲					
	SNMA190616	19.05	19.05	6.35	7.94	1.6				•	▲	▲					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 平板		槽型特点 ZT		槽型特点 GH	
	刀尖部分		刀尖部分		刀尖部分
	主切削刃部分		主切削刃部分		主切削刃部分
双面加工，刃口强度高，是克服铸铁加工中砂眼、夹渣等不良加工因素的刀片结构的解决方案。		宽棱边与大容量槽组合，实现高进给量加工。适用于断续切削、黑皮切削。		宽棱边与大容量槽组合，实现高进给量加工。适用于断续切削、黑皮切削。	

适用刀具					
DSBNR/L KAPR:75°	MSBNR/L KAPR:75°	MSRNR/L KAPR:75°	MSKNR/L KAPR:75°	MSDNN KAPR:45°	PSKNR/L KAPR:75°

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

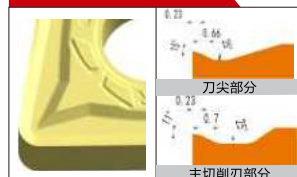
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
工件材料 Workpiece Material	P	钢	√	○	×						○	×					
	M	不锈钢											√	○	○	×	
	K	铸铁				√	○	×									
	N	有色金属															
	S	耐热合金、钛合金														○	×
	H	淬硬钢														○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	SNMG120408-NR	12.7	12.7	4.76	5.16	0.8											
	SNMG120408-NM	12.7	12.7	4.76	5.16	0.8											
	SNMG120412-NM	12.7	12.7	4.76	5.16	1.6											
	SNMG120408-M2	12.7	12.7	4.76	5.16	0.8											
	SNMG120412-M2	12.7	12.7	4.76	5.16	1.6											

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

NR 槽型特点



适用于高温合金类材料大切深高效粗加工的槽型。刃口的设计兼顾了锋利和强度，切削阻力小，可有效减小沟槽磨损，增加刀具寿命。

NM 槽型特点



适用于高温合金半精加工的槽型，转位精度高，防止加工硬化、抗磨损能力强，可获得比NF更高的加工效率。双面断屑槽更具经济性。

M2 槽型特点



通用正前角槽型，设计用于精加工高温合金以及硬质材料部分有色金属材料，用于连续切削。

适用刀具

DSBNR/L
KAPR:75°



MSBNR/L
KAPR:75°



MSRNR/L
KAPR:75°



MSKNR/L
KAPR:75°



MSDNN
KAPR:45°



PSKNR/L
KAPR:75°



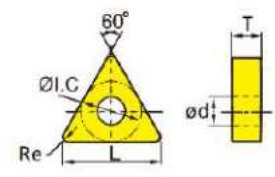
		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢										√	○	○	×	
		K	铸铁				√	○	×								
		N	有色金属														
		S	耐热合金、钛合金													○	×
		H	淬硬钢													○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ØI.C	T	φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	SNMG120408-TFA	12.7	12.7	4.76	5.16	0.8											▲
	SNMG120412-TFA	12.7	12.7	4.76	5.16	1.2											▲
	SNMG120408-CM	12.7	12.7	4.76	5.16	0.8											▲
	SNMG120412-CM	12.7	12.7	4.76	5.16	1.2											▲
	SNMG120408-CF	12.7	12.7	4.76	5.16	0.8											▲
	SNMG120412-CF	12.7	12.7	4.76	5.16	1.2											▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 CF		槽型特点 CM		槽型特点 TFA	
	刀尖部分 主切削刃部分		刀尖部分 主切削刃部分		刀尖部分 主切削刃部分
刃口锋利, 切削轻快; 适用于淬硬钢等难加工材料的连续精加工, 表面质量优良。		双前角设计, 断屑范围宽; 适用于淬硬钢等难加工材料的断续半精加工及粗加工。		大前角设计, 切削力低; 适用于淬硬钢等难加工材料的轻断续精加工, 加工表面质量好。	

适用刀具					
DSBNR/L KAPR:75°	MSBNR/L KAPR:75°	MSRNR/L KAPR:75°	MSKNR/L KAPR:75°	MSDNN KAPR:45°	PSKNR/L KAPR:75°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																				
		工件材料 Workpiece Material	P	钢	√	○	×					○	×									
			M	不锈钢										√	○	○	×					
			K	铸铁					√	○	×											
			N	有色金属																		
			S	耐热合金、钛合金															○	×		
H	淬硬钢																○					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层							
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10	
	TNMG160404-GR	16.5	9.525	4.76	3.81	0.4		▲	●					●								
	TNMG160408-GR	16.5	9.525	4.76	3.81	0.8		▲	●					●								
	TNMG160412-GR	16.5	9.525	4.76	3.81	1.2		▲	●					●								
	TNMG220408-GR	22	12.7	4.76	5.16	0.8		▲	●					●								
	TNMG220412-GR	22	12.7	4.76	5.16	1.2		▲	●					●								
	TNMG220416-GR	22	12.7	4.76	5.16	1.6		▲	●					●								
	TNMG270608-GR	27.5	15.875	6.35	6.35	0.8		▲	●					●								
	TNMG270612-GR	27.5	15.875	6.35	6.35	1.2		▲	●					●								
	TNMG270616-GR	27.5	15.875	6.35	6.35	1.6		▲	●					●								
	TNMG160404-PMK	16.5	9.525	4.76	3.81	0.4	●	▲	●					●								
	TNMG160408-PMK	16.5	9.525	4.76	3.81	0.8	●	▲	●					●								
	TNMG160412-PMK	16.5	9.525	4.76	3.81	1.2	●	▲	●					●								
	TNMG220408-PMK	22	12.7	4.76	5.16	0.8	●	▲	●					●								
	TNMG220412-PMK	22	12.7	4.76	5.16	1.2	●	▲	●					●								
	TNMG220416-PMK	22	12.7	4.76	5.16	1.6	●	▲	●					●								

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

GR 槽型特点

		经济型粗车削双阶断屑槽，通过阶梯式断屑平台设计平衡加工效率与成本，特别适合机床导轨粗车、工程机械大型铸件批量加工等有色金属去除率场景。		刀尖部分
				
		双面断屑槽，适合各种钢的内孔及外圆半精到粗加工。		刀尖部分
				

适用刀具

DTG NR/L KAPR:91° 	PTT NR/L KAPR:60° 	PTG NR/L KAPR:90° 	MTG NR/L KAPR:90° 	MTJ NR/L KAPR:93° 	MTF NR/L KAPR:90° 
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		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																	
		工件材料 Workpiece Material	P	钢	√	○	×					○	×						
		M	不锈钢											√	○	○	×		
		K	铸铁					√	○	×									
		N	有色金属																
		S	耐热合金、钛合金															○	×
		H	淬硬钢															○	

产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	TNMG160404-MB	16.5	9.525	4.76	3.81	0.4	▲	▲	●					●		●	●				
	TNMG160408-MB	16.5	9.525	4.76	3.81	0.8	▲	▲	●					●		●	●				
	TNMG160412-MB	16.5	9.525	4.76	3.81	1.2	▲	▲	●					●		●	●				
	TNMG220408-MB	22	12.7	4.76	5.16	0.8	▲	▲	●					●		●	●				
	TNMG220412-MB	22	12.7	4.76	5.16	1.2	▲	▲	●					●		●	●				
	TNMG220416-MB	22	12.7	4.76	5.16	1.6	▲	▲	●					●		●	●				
	TNMG160404-GMR	16.5	9.525	4.76	3.81	0.4	▲	▲	●					●							
	TNMG160408-GMR	16.5	9.525	4.76	3.81	0.8	▲	▲	●					●							
	TNMG160412-GMR	16.5	9.525	4.76	3.81	1.2	▲	▲	●					●							

▲ 为主推荐牌号 Recommended grade (Always stock available) ● 按订单生产可选牌号 Make-to-order

槽型特点 GMR			槽型特点 MP		
	 刀尖部分			 刀尖部分	
	 主切削刃部分			 主切削刃部分	
	通用槽型，兼顾锋利性和强度，覆盖范围宽广，半精到粗加工槽型。			通用型中切正棱刃断屑槽，凭借强化刃口处理技术平衡切削锋利度与耐用性，是法兰盘台阶车削、轴类零件多工序加工等中等负荷钢件车削的理想选择。	

适用刀具					
DTG NR/L KAPR:91°	PTT NR/L KAPR:60°	PTG NR/L KAPR:90°	MTG NR/L KAPR:90°	MTJ NR/L KAPR:93°	MTF NR/L KAPR:90°

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

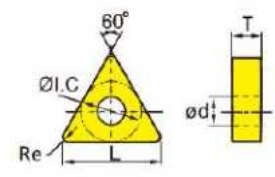
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

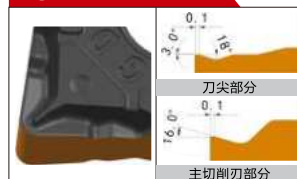
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金														○	×		
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层							PVD涂层							
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	TNMG160404-GD	16.5	9.525	4.76	3.81	0.4	▲	▲	●					●							
	TNMG160408-GD	16.5	9.525	4.76	3.81	0.8	▲	▲	●					●							
	TNMG160412-GD	16.5	9.525	4.76	3.81	1.2	▲	▲	●					●							
	TNMG160404-PR	16.5	9.525	4.76	3.81	0.4	▲	▲	●					●							
	TNMG160408-PR	16.5	9.525	4.76	3.81	0.8	▲	▲	●					●							
	TNMG160412-PR	16.5	9.525	4.76	3.81	1.2	▲	▲	●					●							
	TNMG160404-GF	16.5	9.525	4.76	3.81	0.4	▲	▲	●					●							
	TNMG160408-GF	16.5	9.525	4.76	3.81	0.8	▲	▲	●					●							
	TNMG160412-GF	16.5	9.525	4.76	3.81	1.2	▲	▲	●					●							
	TNMG220408-GF	22	12.7	4.76	5.16	0.8	▲	▲	●					●							
	TNMG220412-GF	22	12.7	4.76	5.16	1.2	▲	▲	●					●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

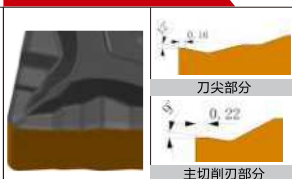
● 按订单生产可选牌号 Make-to-order

GD 槽型特点



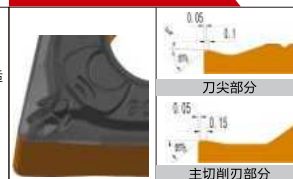
小平刃和大前角的组合确保了切削刃的强度与锋利度，刀尖的大刃倾角设计降低了切削阻力，波浪型的侧面设计在壁面的提拉加工时有良好的断屑能力。

PR 槽型特点



超强碎屑能力，主要适用于产品的粗加工。

GF 槽型特点



专为碳钢/合金钢轻切削优化的曲线刀断屑槽，特殊的槽型设计实现稳定排屑，有效解决薄壁件加工中的缠屑问题，特别适用于细长轴精密车削及小切深连续加工场景。

适用刀具

DTG NR/L
KAPR:91°



PTT NR/L
KAPR:60°



PTG NR/L
KAPR:90°



MTG NR/L
KAPR:90°

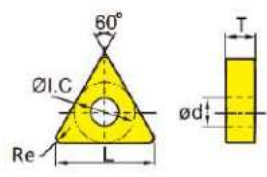


MTJ NR/L
KAPR:93°



MTF NR/L
KAPR:90°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金														○	×		
			H	淬硬钢														○			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	TNMG160404	16.5	9.525	4.76	3.81	0.4	▲	▲	●					●		●					
	TNMG160408	16.5	9.525	4.76	3.81	0.8	▲	▲	●					●		●					
	TNMG160412	16.5	9.525	4.76	3.81	1.2	▲	▲	●					●		●					
	TNMG220404	22	12.7	4.76	5.16	0.4	▲	▲	●					●		●					
	TNMG220408	22	12.7	4.76	5.16	0.8	▲	▲	●					●		●					
	TNMG220412	22	12.7	4.76	5.16	1.2	▲	▲	●					●		●					
	TNMG220416	22	12.7	4.76	5.16	1.6	▲	▲	●					●		●					
	TNMG270612	27.5	15.875	6.35	6.35	1.2	▲	▲	●					●		●					
	TNMG270616	27.5	15.875	6.35	6.35	1.6	▲	▲	●					●		●					
	TNMG330916	33	19.05	9.525	7.94	1.6	▲	▲	●					●		●					
TNMG330924	33	19.05	9.525	7.94	2.4	▲	▲	●					●		●						
	TNMM160404	16.5	9.525	4.76	3.81	0.4	▲	▲	●					●		●					
	TNMM160408	16.5	9.525	4.76	3.81	0.8	▲	▲	●					●		●					
	TNMM160412	16.5	9.525	4.76	3.81	1.2	▲	▲	●					●		●					
	TNMM220408	22	12.7	4.76	5.16	0.8	▲	▲	●					●		●					
	TNMM220412	22	12.7	4.76	5.16	1.2	▲	▲	●					●		●					
	TNMM220416	22	12.7	4.76	5.16	1.6	▲	▲	●					●		●					
	TNMM270612	27.5	15.875	6.35	6.35	1.2	▲	▲	●					●		●					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 通槽

适用刀具
DTG NR/L
 KAPR:91°

PTT NR/L
 KAPR:60°

PTG NR/L
 KAPR:90°

MTG NR/L
 KAPR:90°

MTJ NR/L
 KAPR:93°

MTF NR/L
 KAPR:90°


车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

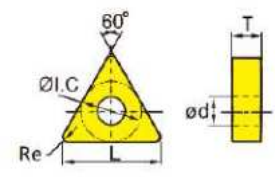
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

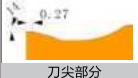
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层								
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	TNMG160404L/R-X	16.5	9.525	4.76	3.81	0.4	▲	▲	●					●							
	TNMG160408L/R-X	16.5	9.525	4.76	3.81	0.8	▲	▲	●					●							
	TNMG160412L/R-X	16.5	9.525	4.76	3.81	1.2	▲	▲	●					●							
	TNMG160404-PMB	16.5	9.525	4.76	3.81	0.4	▲	▲	●					●		●	●				
	TNMG160408-PMB	16.5	9.525	4.76	3.81	0.8	▲	▲	●					●		●	●				
	TNMG160412-PMB	16.5	9.525	4.76	3.81	1.2	▲	▲	●					●		●	●				

▲ 为主推荐牌号 Recommended grade (Always stock available)

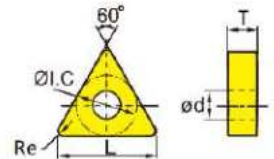
● 按订单生产可选牌号 Make-to-order

L/R-X 槽型特点

	 刀尖部分	平行断屑槽。中进给量条件下,切屑处理良好。		 刀尖部分	MB的升级槽型,新增的倒棱设计,大大增强刃口强度,有效提高刀具寿命。
	 主切削刃部分			 主切削刃部分	

适用刀具

DTG NR/L KAPR:91° 	PTT NR/L KAPR:60° 	PTG NR/L KAPR:90° 	MTG NR/L KAPR:90° 	MTJ NR/L KAPR:93° 	MTF NR/L KAPR:90° 
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		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																						
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				○	×						
		M	不锈钢												√	○	○	×						
		K	铸铁					√	○	×														
		N	有色金属																					
		S	耐热合金、钛合金																		○		×	
		H	淬硬钢																	○				

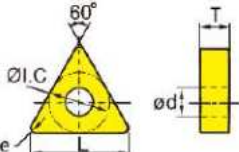
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层								
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10		
	TNMG160404-MF	16.5	9.525	4.76	3.81	0.4										●	●	▲	●				
	TNMG160408-MF	16.5	9.525	4.76	3.81	0.8										●	●	▲	●				
	TNMG160412-MF	16.5	9.525	4.76	3.81	1.2										●	●	▲	●				
	TNMG220404-MF	22	12.7	4.76	5.16	0.4										●	●	▲	●				
	TNMG220408-MF	22	12.7	4.76	5.16	0.8										●	●	▲	●				
	TNMG220412-MF	22	12.7	4.76	5.16	1.2										●	●	▲	●				
	TNMG160404-MJ	16.5	9.525	4.76	3.81	0.4										●	●	▲	●				
	TNMG160408-MJ	16.5	9.525	4.76	3.81	0.8										●	●	▲	●				
	TNMG160412-MJ	16.5	9.525	4.76	3.81	1.2										●	●	▲	●				
	TNMG220404-MJ	22	12.7	4.76	5.16	0.4										●	●	▲	●				
	TNMG220408-MJ	22	12.7	4.76	5.16	0.8										●	●	▲	●				
	TNMG220412-MJ	22	12.7	4.76	5.16	1.2										●	●	▲	●				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 MJ			槽型特点 MF		
		切削刃锋利，阻力小；带刃倾角设计，导屑好；断屑台前移可在小余量加工状况下实现良好断屑。			M级双面断屑槽，刃口锋利，有效解决不锈钢断屑，粘刀、表面硬化等加工难点，获得高质量加工表面。
	刀尖部分			刀尖部分	
		主切削刃部分			

适用刀具					
DTG NR/L KAPR:91°	PTT NR/L KAPR:60°	PTG NR/L KAPR:90°	MTG NR/L KAPR:90°	MTJ NR/L KAPR:93°	MTF NR/L KAPR:90°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
H	淬硬钢																○				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	TNMG110304-MP	11	6.35	3.18	2.26	0.4									●	▲	▲	●			
	TNMG110308-MP	11	6.35	3.18	2.26	0.8									●	▲	▲	●			
	TNMG160404-MP	16.5	9.525	4.76	3.81	0.4									●	▲	▲	●			
	TNMG160408-MP	16.5	9.525	4.76	3.81	0.8									●	▲	▲	●			
	TNMG160412-MP	16.5	9.525	4.76	3.81	1.2									●	▲	▲	●			
	TNMG220404-MP	22	12.7	4.76	5.16	0.4									●	▲	▲	●			
	TNMG220408-MP	22	12.7	4.76	5.16	0.8									●	▲	▲	●			
TNMG220412-MP	22	12.7	4.76	5.16	1.2									●	▲	▲	●				
	TNMG160404-MM-B	16.5	9.525	4.76	3.81	0.4									●	▲	▲	●			
	TNMG160408-MM-B	16.5	9.525	4.76	3.81	0.8									●	▲	▲	●			
	TNMG160412-MM-B	16.5	9.525	4.76	3.81	1.2									●	▲	▲	●			
	TNMG220404-MM-B	22	12.7	4.76	5.16	0.4									●	▲	▲	●			
	TNMG220408-MM-B	22	12.7	4.76	5.16	0.8									●	▲	▲	●			
	TNMG220412-MM-B	22	12.7	4.76	5.16	1.2									●	▲	▲	●			
	TNMG160404L/R-M	16.5	9.525	4.76	3.81	0.4									●	▲	▲	●			
	TNMG160408L/R-M	16.5	9.525	4.76	3.81	0.8									●	▲	▲	●			
	TNMG160412L/R-M	16.5	9.525	4.76	3.81	1.2									●	▲	▲	●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

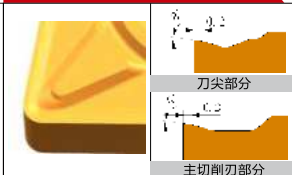
● 按订单生产可选牌号 Make-to-order

MP 槽型特点



通用型中切削正棱刃断屑槽，凭借强化刃口处理技术平衡切削锋利度与耐用性，是法兰盘台阶车削、轴类零件多工序加工等中等负荷钢件车削的理想选择。

MM-B 槽型特点



刀尖刃口同时兼具锋利性和强度。具有良好的排屑效果，适用于半精偏精加工。

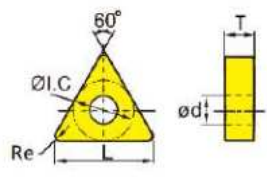
L/R-M 槽型特点



双面断屑槽，抗冲击能力强，槽型设计在刃口安全性和锋利性取得了最佳平衡点，解决不锈钢粗加工等问题。

适用刀具

DTG NR/L
KAPR:91°PTT NR/L
KAPR:60°PTG NR/L
KAPR:90°MTG NR/L
KAPR:90°MTJ NR/L
KAPR:93°MTF NR/L
KAPR:90°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢										√	○	○	×	
		K	铸铁					√	○	×							
		N	有色金属														
		S	耐热合金、钛合金													○	×
		H	淬硬钢													○	

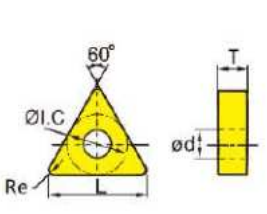
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层					
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N
	TNMG160408-ZR	16.5	9.525	4.76	3.81	0.8				●	●	▲						
	TNMG160412-ZR	16.5	9.525	4.76	3.81	1.2				●	●	▲						
	TNMG220408-ZR	22	12.7	4.76	5.16	0.8				●	●	▲						
	TNMG220412-ZR	22	12.7	4.76	5.16	1.2				●	●	▲						
	TNMG220416-ZR	22	12.7	4.76	5.16	1.6				●	●	▲						
	TNMG270612-ZR	27.5	15.875	6.35	6.35	1.2				●	●	▲						
	TNMG270616-ZR	27.5	15.875	6.35	6.35	1.6				●	●	▲						
	TNMG160408-GH	16.5	9.525	4.76	3.81	0.8				●	●	▲						
	TNMG160412-GH	16.5	9.525	4.76	3.81	1.2				●	●	▲						
	TNMG220408-GH	22	12.7	4.76	5.16	0.8				●	●	▲						
	TNMG220412-GH	22	12.7	4.76	5.16	1.2				●	●	▲						
	TNMG220416-GH	22	12.7	4.76	5.16	1.6				●	●	▲						
	TNMG270612-GH	27.5	15.875	6.35	6.35	1.2				●	●	▲						
	TNMG270616-GH	27.5	15.875	6.35	6.35	1.6				●	●	▲						

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 GH		槽型特点 ZR	
	刀尖部分		刀尖部分
	主切削刃部分		主切削刃部分
	宽棱边与大容量槽组合, 实现高进给量加工。适用于断续切削、黑皮切削。		碳钢、合金钢、不锈钢准重切削用采用以往产品3倍以上的安装面积与宽棱边, 在断续切削、黑皮切削中发挥出色的切削刃稳定性。

适用刀具					
DTG NR/L KAPR:91°	PTT NR/L KAPR:60°	PTG NR/L KAPR:90°	MTG NR/L KAPR:90°	MTJ NR/L KAPR:93°	MTF NR/L KAPR:90°
					

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
H	淬硬钢																○				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	TNMG160304-UC	16.5	9.525	3.18	3.81	0.4					●	▲	▲								
	TNMG160308-UC	16.5	9.525	3.18	3.81	0.8					●	▲	▲								
	TNMG160404-UC	16.5	9.525	4.76	3.81	0.4					●	▲	▲								
	TNMG160408-UC	16.5	9.525	4.76	3.81	0.8					●	▲	▲								
	TNMG160412-UC	16.5	9.525	4.76	3.81	1.2					●	▲	▲								
	TNMG160416-UC	16.5	9.525	4.76	3.81	1.6					●	▲	▲								
	TNMG220404-UC	22	12.7	4.76	5.16	0.4					●	▲	▲								
	TNMG220408-UC	22	12.7	4.76	5.16	0.8					●	▲	▲								
	TNMG220412-UC	22	12.7	4.76	5.16	1.2					●	▲	▲								
	TNMG220416-UC	22	12.7	4.76	5.16	1.6					●	▲	▲								
	TNMG270608-UC	27.5	15.875	6.35	6.35	0.8					●	▲	▲								
	TNMG270612-UC	27.5	15.875	6.35	6.35	1.2					●	▲	▲								
	TNMG270616-UC	27.5	15.875	6.35	6.35	1.6					●	▲	▲								
	TNMG160404-ZD	16.5	9.525	4.76	3.81	0.4					●	▲	▲								
	TNMG160408-ZD	16.5	9.525	4.76	3.81	0.8					●	▲	▲								
	TNMG160412-ZD	16.5	9.525	4.76	3.81	1.2					●	▲	▲								
	TNMG160416-ZD	16.5	9.525	4.76	3.81	1.6					●	▲	▲								
	TNMG220404-ZD	22	12.7	4.76	5.16	0.4					●	▲	▲								
	TNMG220408-ZD	22	12.7	4.76	5.16	0.8					●	▲	▲								
	TNMG220412-ZD	22	12.7	4.76	5.16	1.2					●	▲	▲								
	TNMG220416-ZD	22	12.7	4.76	5.16	1.6					●	▲	▲								

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

UC 槽型特点

		碳钢、合金钢中切削用第二推荐断屑槽。扁平棱边刃形，切削刃强度高。通用性高的全周断屑槽形状。
刀尖部分	刀尖部分	
主切削刃部分	主切削刃部分	

ZD 槽型特点

		适用于铸铁和硬材料的粗加工采用特质涂层，兼具高耐磨性与抗冲击性能，显著延长刀具寿命。支持高进给与高速切削，适合连续或轻微断续车削工况，提升生产效率。
刀尖部分	刀尖部分	
主切削刃部分	主切削刃部分	

适用刀具

DTG NR/L KAPR:91° 	PTT NR/L KAPR:60° 	PTG NR/L KAPR:90° 	MTG NR/L KAPR:90° 	MTJ NR/L KAPR:93° 	MTF NR/L KAPR:90°
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		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	TNMG160304-ZK	16.5	9.525	3.18	3.81	0.4					●	▲	▲								
	TNMG160308-ZK	16.5	9.525	3.18	3.81	0.8					●	▲	▲								
	TNMG160404-ZK	16.5	9.525	4.76	3.81	0.4					●	▲	▲								
	TNMG160408-ZK	16.5	9.525	4.76	3.81	0.8					●	▲	▲								
	TNMG160412-ZK	16.5	9.525	4.76	3.81	1.2					●	▲	▲								
	TNMG160416-ZK	16.5	9.525	4.76	3.81	1.6					●	▲	▲								
	TNMG220404-ZK	22	12.7	4.76	5.16	0.4					●	▲	▲								
	TNMG220408-ZK	22	12.7	4.76	5.16	0.8					●	▲	▲								
	TNMG220412-ZK	22	12.7	4.76	5.16	1.2					●	▲	▲								
	TNMG220416-ZK	22	12.7	4.76	5.16	1.6					●	▲	▲								
	TNMG270608-ZK	27.5	15.875	6.35	6.35	0.8					●	▲	▲								
	TNMG270612-ZK	27.5	15.875	6.35	6.35	1.2					●	▲	▲								
TNMG270616-ZK	27.5	15.875	6.35	6.35	1.6					●	▲	▲									
	TNMA160404	16.5	9.525	4.76	3.81	0.4					●	▲	▲								
	TNMA160408	16.5	9.525	4.76	3.81	0.8					●	▲	▲								
	TNMA160412	16.5	9.525	4.76	3.81	1.2					●	▲	▲								
	TNMA160416	16.5	9.525	4.76	3.81	1.6					●	▲	▲								
	TNMA220404	22	12.7	4.76	5.16	0.4					●	▲	▲								
	TNMA220408	22	12.7	4.76	5.16	0.8					●	▲	▲								
	TNMA220412	22	12.7	4.76	5.16	1.2					●	▲	▲								
TNMA220416	22	12.7	4.76	5.16	1.6					●	▲	▲									

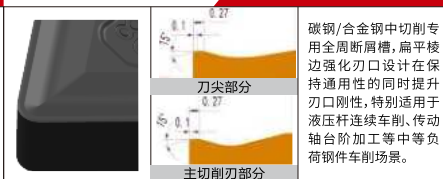
▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 平板



槽型特点 ZK



适用刀具

DTG NR/L
KAPR:91°



PTT NR/L
KAPR:60°



PTG NR/L
KAPR:90°



MTG NR/L
KAPR:90°



MTJ NR/L
KAPR:93°



MTF NR/L
KAPR:90°



车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

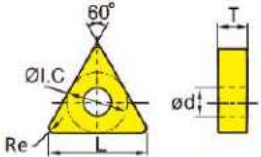
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	TNMG160408-NR	16.5	9.525	4.76	3.81	0.8														●	▲
	TNMG160404-M2	16.5	9.525	4.76	3.81	0.4														●	▲
	TNMG160408-M2	16.5	9.525	4.76	3.81	0.8														●	▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

NR 槽型特点

		适用于高温合金类材料大切深高效粗加工的槽型。刃口的设计兼顾了锋利和强度，切削阻力小，可有效减小沟槽磨损，增加刀具寿命。		通用正前角槽型，设计用于精加工高温合金以及硬质材料部分有色金属材料，用于连续切削。
	主切削刃部分			

M2 槽型特点

		适用于高温合金类材料大切深高效粗加工的槽型。刃口的设计兼顾了锋利和强度，切削阻力小，可有效减小沟槽磨损，增加刀具寿命。		通用正前角槽型，设计用于精加工高温合金以及硬质材料部分有色金属材料，用于连续切削。
	主切削刃部分			

适用刀具

DTG NR/L KAPR:91° 	PTT NR/L KAPR:60° 	PTG NR/L KAPR:90° 	MTG NR/L KAPR:90° 	MTJ NR/L KAPR:93° 	MTF NR/L KAPR:90°
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		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
产品 Inserts Shape	型号 Type	M	不锈钢											√	○	○	×				
		K	铸铁				√	○	×												
		N	有色金属																		
		S	耐热合金、钛合金															○	×		
		H	淬硬钢															○			
		尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	TNMG160308-TFA	16.5	9.525	3.18	3.81	0.8													▲		
	TNMG160404-TFA	16.5	9.525	4.76	3.81	0.4													▲		
	TNMG160408-TFA	16.5	9.525	4.76	3.81	0.8													▲		
	TNMG160412-TFA	16.5	9.525	4.76	3.81	1.2													▲		
	TNMG160308-CM	16.5	9.525	3.18	3.81	0.8													▲		
	TNMG160404-CM	16.5	9.525	4.76	3.81	0.4													▲		
	TNMG160408-CM	16.5	9.525	4.76	3.81	0.8													▲		
	TNMG160412-CM	16.5	9.525	4.76	3.81	1.2													▲		
	TNMG160308-CF	16.5	9.525	3.18	3.81	0.8													▲		
	TNMG160404-CF	16.5	9.525	4.76	3.81	0.4													▲		
	TNMG160408-CF	16.5	9.525	4.76	3.81	0.8													▲		
	TNMG160412-CF	16.5	9.525	4.76	3.81	1.2													▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 CF		槽型特点 CM		槽型特点 TFA	
	刀尖部分 主切削刃部分		刀尖部分 主切削刃部分		刀尖部分 主切削刃部分
刃口锋利, 切削轻快; 适用于淬硬钢等难加工材料的连续精加工, 表面质量优良。		双前角设计, 断屑范围宽; 适用于淬硬钢等难加工材料的断续半精加工及粗加工。		大前角设计, 切削力低; 适用于淬硬钢等难加工材料的轻断续精加工, 加工表面质量好。	

适用刀具					
DTGNR/L KAPR:91°	PTTNR/L KAPR:60°	PTGNR/L KAPR:90°	MTGNR/L KAPR:90°	MTJNR/L KAPR:93°	MTFNR/L KAPR:90°

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

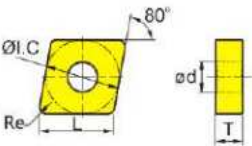
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

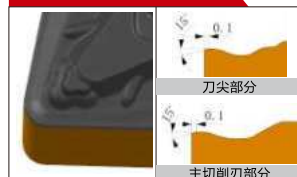
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	VNMG160404-PMK	16.6	9.525	4.76	3.81	0.4	●	▲	●					●							
	VNMG160408-PMK	16.6	9.525	4.76	3.81	0.8	●	▲	●					●							
	VNMG160412-PMK	16.6	9.525	4.76	3.81	1.2	●	▲	●					●							
	VNMG160404-MB	16.6	9.525	4.76	3.81	0.4	▲	▲	●					●		●	●				
	VNMG160408-MB	16.6	9.525	4.76	3.81	0.8	▲	▲	●					●		●	●				
	VNMG160412-MB	16.6	9.525	4.76	3.81	1.2	▲	▲	●					●		●	●				

▲ 为主推荐牌号 Recommended grade (Always stock available)

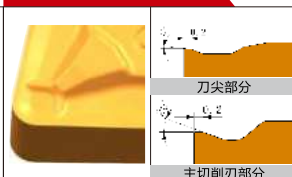
● 按订单生产可选牌号 Make-to-order

PMK 槽型特点



双面断屑槽, 适合各种钢的内孔及外圆半精到粗加工。

MB 槽型特点



科学、合理的断屑筋须设计, 具有非常好的断屑效果, 可用于钢件的半精到精加工。

适用刀具

DVVNN
KAPR:72°30'



DVJNR/L
KAPR:93°



MVVNN
KAPR:72°30'



MVJNR/L
KAPR:93°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢										√	○	○	×	
		K	铸铁				√	○	×								
		N	有色金属														
		S	耐热合金、钛合金													○	×
		H	淬硬钢													○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ØI.C	T	Ød	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	VNMG160404-PR	16.6	9.525	4.76	3.81	0.4	▲	▲	●					●			
	VNMG160408-PR	16.6	9.525	4.76	3.81	0.8	▲	▲	●					●			
	VNMG160412-PR	16.6	9.525	4.76	3.81	1.2	▲	▲	●					●			
	VNMG160404-GMR	16.6	9.525	4.76	3.81	0.4	▲	▲	●					●			
	VNMG160408-GMR	16.6	9.525	4.76	3.81	0.8	▲	▲	●					●			
	VNMG160412-GMR	16.6	9.525	4.76	3.81	1.2	▲	▲	●					●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 GMR

		通用槽型，兼顾锋利性和强度，覆盖范围宽广，半精到粗加工槽型。			超强碎屑能力，主要适用于产品的粗加工。
	刀尖部分			刀尖部分	
	主切削刃部分			主切削刃部分	

适用刀具

DVVNN
KAPR:72°30'



DVJNR/L
KAPR:93°



MVVNN
KAPR:72°30'



MVJNR/L
KAPR:93°



A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

- 按订单生产可选牌号 Make-to-order

专为碳钢/合金钢轻切削优化的曲线刀断屑槽,特殊的槽型设计实现稳定排屑,有效解决薄壁件加工中的缠屑问题,特别适用于细长轴精密车削及小切深连续加工场景。

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢											√	○	○	×			
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	VNMG160404-MF	16.6	9.525	4.76	3.81	0.4									●	●	▲	●			
	VNMG160408-MF	16.6	9.525	4.76	3.81	0.8									●	●	▲	●			
	VNMG160412-MF	16.6	9.525	4.76	3.81	1.2									●	●	▲	●			
	VNMG160404-MJ	16.6	9.525	4.76	3.81	0.4									●	●	▲	●			
	VNMG160408-MJ	16.6	9.525	4.76	3.81	0.8									●	●	▲	●			
	VNMG160412-MJ	16.6	9.525	4.76	3.81	1.2									●	●	▲	●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 MJ		槽型特点 MF	
	刀尖部分 主切削刃部分		刀尖部分 主切削刃部分
切削刃锋利，阻力小；带刃倾角设计，导屑好；断屑台前移可在小余量加工状况下实现良好断屑。		M级双面断屑槽，刃口锋利，有效解决不锈钢断屑，粘刀、表面硬化等加工难点，获得高质量加工表面。	

适用刀具			
DVVNN KAPR:72°30'	DVJNR/L KAPR:93°	MVVNN KAPR:72°30'	MVJNR/L KAPR:93°

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

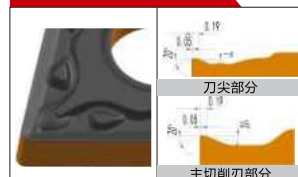
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢											√	○	○	×
		K	铸铁					√	○	×							
		N	有色金属														
		S	耐热合金、钛合金													○	×
		H	淬硬钢													○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦL.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	VNMG160404-MP	16.6	9.525	4.76	3.81	0.4									•	▲	▲
	VNMG160408-MP	16.6	9.525	4.76	3.81	0.8									•	▲	▲
	VNMG160412-MP	16.6	9.525	4.76	3.81	1.2									•	▲	▲
	VNMG160404-MM-B	16.6	9.525	4.76	3.81	0.4									•	▲	▲
	VNMG160408-MM-B	16.6	9.525	4.76	3.81	0.8									•	▲	▲
	VNMG160412-MM-B	16.6	9.525	4.76	3.81	1.2									•	▲	▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

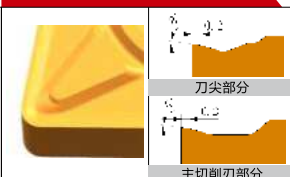
● 按订单生产可选牌号 Make-to-order

MP 槽型特点



通用型中切削正棱刃断屑槽，凭借强化刃口处理技术平衡切削锋利度与耐用性，是法兰盘台阶车削、轴类零件多工序加工等中等负荷钢件车削的理想选择。

MM-B 槽型特点



刀尖刃口同时兼具锋利性和强度。具有良好的排屑效果，适用于半精偏精加工。

适用刀具

DVVNN
KAPR:72°30'



DVJNR/L
KAPR:93°

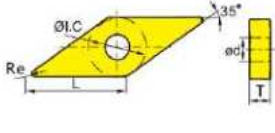


MVVNN
KAPR:72°30'



MVJNR/L
KAPR:93°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢										√	○	○	×	
		K	铸铁				√	○	×								
		N	有色金属														
		S	耐热合金、钛合金														○
		H	淬硬钢													○	×
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	VNMG160404-UC	16.6	9.525	4.76	3.81	0.4				●	▲	▲					
	VNMG160408-UC	16.6	9.525	4.76	3.81	0.8				●	▲	▲					
	VNMG160412-UC	16.6	9.525	4.76	3.81	1.2				●	▲	▲					
	VNMG160404-ZD	16.6	9.525	4.76	3.81	0.4				●	▲	▲					
	VNMG160408-ZD	16.6	9.525	4.76	3.81	0.8				●	▲	▲					
	VNMG160412-ZD	16.6	9.525	4.76	3.81	1.2				●	▲	▲					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 ZD		槽型特点 UC	
	 刀尖部分		 刀尖部分
	主切削刃部分		
	适用于铸铁和硬材料的粗加工采用特质涂层，兼具高耐磨性与抗冲击性能，显著延长刀具寿命。支持高进给与高速切削，适合连续或轻微断续车削工况，提升生产效率。		
		碳钢、合金钢中切削用第二推荐断屑槽。扁平棱边刃形，切削刃强度高。通用性高的全周断屑槽形状。	

适用刀具

DVVNN
 KAPR:72°30'

DVJNR/L
 KAPR:93°

MVVNN
 KAPR:72°30'

MVJNR/L
 KAPR:93°


车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

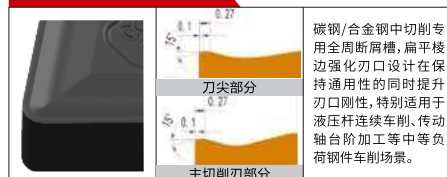
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢											√	○	○	×
		K	铸铁					√	○	×							
		N	有色金属														
		S	耐热合金、钛合金														○
		H	淬硬钢													○	×
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦL.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	VNMG160404-ZK	16.6	9.525	4.76	3.81	0.4				•	▲	▲					
	VNMG160408-ZK	16.6	9.525	4.76	3.81	0.8				•	▲	▲					
	VNMG160412-ZK	16.6	9.525	4.76	3.81	1.2				•	▲	▲					
	VNMA160404	16.6	9.525	4.76	3.81	0.4				•	▲	▲					
	VNMA160408	16.6	9.525	4.76	3.81	0.8				•	▲	▲					
	VNMA160412	16.6	9.525	4.76	3.81	1.2				•	▲	▲					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

ZK 槽型特点



平板 槽型特点



适用刀具

DVVNN
KAPR:72°30'



DVJNR/L
KAPR:93°

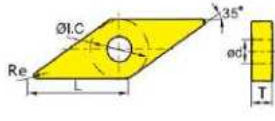


MVVNN
KAPR:72°30'



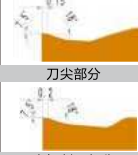
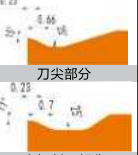
MVJNR/L
KAPR:93°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层							PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	VNMG160408-NR	16.6	9.525	4.76	3.81	0.8														●	▲
	VNMG160412-NR	16.6	9.525	4.76	3.81	1.2														●	▲
	VNMG160412-NM	16.6	9.525	4.76	3.81	1.2														●	▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 NM		槽型特点 NR	
	刀尖部分  主切削刃部分		刀尖部分  主切削刃部分
适用于高温合金半精加工的槽型，转位精度高，防止加工硬化、抗磨损能力强，可获得比NF更高的加工效率。双面断屑槽更具经济性。		适用于高温合金材料大切深高效粗加工的槽型。刃口的设计兼顾了锋利和强度，切削阻力小，可有效减小沟槽磨损，增加刀具寿命。	

适用刀具

DVVNN
 KAPR:72°30'

DVJNR/L
 KAPR:93°

MVVNN
 KAPR:72°30'

MVJNR/L
 KAPR:93°


A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

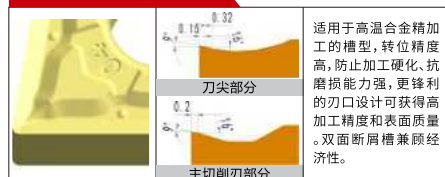
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material		P	钢	√	○	×					○	×			
				M	不锈钢										√	○	×
				K	铸铁				√	○	×						
				N	有色金属												
				S	耐热合金、钛合金												○
				H	淬硬钢											○	×
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	VNMG160404-NF	16.6	9.525	4.76	3.81	0.4											
	VNMG160408-NF	16.6	9.525	4.76	3.81	0.8											
	VNMG160404-M2	16.6	9.525	4.76	3.81	0.4											
	VNMG160408-M2	16.6	9.525	4.76	3.81	0.8											
	VNMG160412-M2	16.6	9.525	4.76	3.81	1.2											

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

NF 槽型特点



M2 槽型特点



适用刀具

DVVNN
KAPR:72°30'



DVJNR/L
KAPR:93°

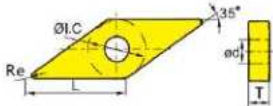


MVVNN
KAPR:72°30'



MVJNR/L
KAPR:93°

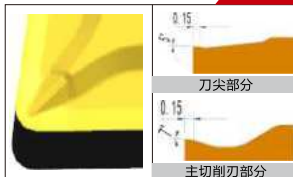


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金														○	×		
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	VNMG160408-TFA	16.6	9.525	4.76	3.81	0.8													▲		
	VNMG160412-TFA	16.6	9.525	4.76	3.81	1.2													▲		
	VNMG160408-CM	16.6	9.525	4.76	3.81	0.8													▲		
	VNMG160412-CM	16.6	9.525	4.76	3.81	1.2													▲		
	VNMG160408-CF	16.6	9.525	4.76	3.81	0.8													▲		
	VNMG160412-CF	16.6	9.525	4.76	3.81	1.2													▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

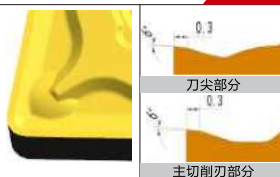
● 按订单生产可选牌号 Make-to-order

槽型特点 CF



刃口锋利, 切削轻快;
适用于淬硬钢等难加工材料的连续精加工, 表面质量优良。

槽型特点 CM



双前角设计, 断屑范围宽; 适用于淬硬钢等难加工材料的断续半精加工及粗加工。

槽型特点 TFA



大前角设计, 切削力低; 适用于淬硬钢等难加工材料的轻断续精加工, 加工表面质量好。

适用刀具

DVVNN
KAPR:72°30'



DVJNR/L
KAPR:93°



MVVNN
KAPR:72°30'



MVJNR/L
KAPR:93°



A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

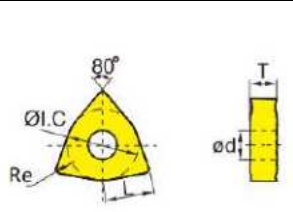
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

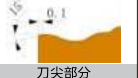
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢																	
			M	不锈钢																	
			K	铸铁																	
			N	有色金属																	
			S	耐热合金、钛合金																	
			H	淬硬钢																	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	WNMG060408-GR	6.5	9.525	9.525	3.81	0.8		▲	●					●							
	WNMG060412-GR	6.5	9.525	9.525	3.81	1.2		▲	●					●							
	WNMG080408-GR	8.7	12.7	12.7	5.16	0.8		▲	●					●							
	WNMG080412-GR	8.7	12.7	12.7	5.16	1.2		▲	●					●							
	WNMG080416-GR	8.7	12.7	12.7	5.16	1.6		▲	●					●							
	WNMG060408-PMK	6.5	9.525	9.525	3.81	0.8	●	▲	●					●							
	WNMG060412-PMK	6.5	9.525	9.525	3.81	1.2	●	▲	●					●							
	WNMG080404-PMK	8.7	12.7	12.7	5.16	0.4	●	▲	●					●							
	WNMG080408-PMK	8.7	12.7	12.7	5.16	0.8	●	▲	●					●							
	WNMG080412-PMK	8.7	12.7	12.7	5.16	1.2	●	▲	●					●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

GR 槽型特点

		经济型粗车削双阶断屑槽，通过阶梯式断屑平台设计平衡加工效率与成本，特别适合机床导轨粗车、工程机械大型铸件批量加工等高金属去除率场景。			双面断屑槽，适合各种钢的内孔及外圆半精到粗加工。
	刀尖部分			刀尖部分	
	主切削刃部分			主切削刃部分	

适用刀具

DWLNRL
KAPR:95°



PWLNRL
KAPR:95°



MWLNRL
KAPR:95°



PWLNRL
KAPR:95°

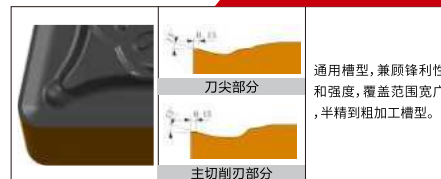


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
			M	不锈钢									√	○	○	×	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)	L	ØI.C	T	Φd	r	CVD涂层						PVD涂层			
								KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286
	WNMG060408-MB	6.5	9.525	4.76	3.81	0.8		▲	▲	●					●	●	●
	WNMG060412-MB	6.5	9.525	4.76	3.81	1.2		▲	▲	●					●	●	●
	WNMG080404-MB	8.7	12.7	4.76	5.16	0.4		▲	▲	●					●	●	●
	WNMG080408-MB	8.7	12.7	4.76	5.16	0.8		▲	▲	●					●	●	●
	WNMG080412-MB	8.7	12.7	4.76	5.16	1.2		▲	▲	●					●	●	●
	WNMG080416-MB	8.7	12.7	4.76	5.16	1.6		▲	▲	●					●	●	●
	WNMG080608-MB	8.7	12.7	6.35	5.16	0.8		▲	▲	●					●	●	●
	WNMG080404-GMR	8.7	12.7	4.76	5.16	0.4		▲	▲	●					●	●	●
	WNMG080408-GMR	8.7	12.7	4.76	5.16	0.8		▲	▲	●					●	●	●
	WNMG080412-GMR	8.7	12.7	4.76	5.16	1.2		▲	▲	●					●	●	●
	WNMG080416-GMR	8.7	12.7	4.76	5.16	1.6		▲	▲	●					●	●	●

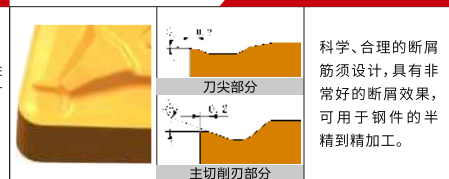
▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 GMR



槽型特点 MB



适用刀具

DWLNLR/L
KAPR:95°



PWLNLR/L
KAPR:95°

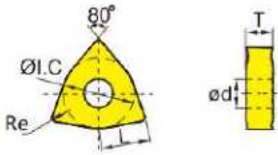


MWLNLR/L
KAPR:95°



PWLNLR/L
KAPR:95°

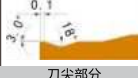
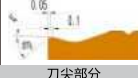
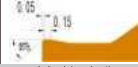


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
H	淬硬钢															○					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层							PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	WNUMG060408-GD	6.5	9.525	4.76	3.81	0.8	▲	▲	●					●							
	WNUMG060412-GD	6.5	9.525	4.76	3.81	1.2	▲	▲	●					●							
	WNUMG080404-GD	8.7	12.7	4.76	5.16	0.4	▲	▲	●					●							
	WNUMG080408-GD	8.7	12.7	4.76	5.16	0.8	▲	▲	●					●							
	WNUMG080412-GD	8.7	12.7	4.76	5.16	1.2	▲	▲	●					●							
	WNUMG080416-GD	8.7	12.7	4.76	5.16	1.6	▲	▲	●					●							
	WNUMG06T304-GF	6.5	9.525	3.97	3.81	0.4	▲	▲	●					●							
	WNUMG06T308-GF	6.5	9.525	3.97	3.81	0.8	▲	▲	●					●							
	WNUMG060404-GF	6.5	9.525	4.76	3.81	0.4	▲	▲	●					●							
	WNUMG060408-GF	6.5	9.525	4.76	3.81	0.8	▲	▲	●					●							
	WNUMG080408-GF	8.7	12.7	4.76	5.16	0.8	▲	▲	●					●							
	WNUMG080412-GF	8.7	12.7	4.76	5.16	1.2	▲	▲	●					●							
	WNUMG080416-GF	8.7	12.7	4.76	5.16	1.6	▲	▲	●					●							
	WNUMG080408-W	8.7	12.7	4.76	5.16	0.8	▲	▲	●					●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

GD 槽型特点

		小平刃和大前角的组合确保了切削刃的强度与锋利度，刀尖的大刀倾角设计降低了切削阻力，波浪型的侧面设计在壁面的提拉加工时有良好的断屑能力。
		
		专为碳钢/合金钢轻切削优化的曲线刀断屑槽，特殊的槽型设计实现稳定排屑，有效解决薄壁件加工中的缠屑问题，特别适用于细长轴精密车削及小切深连续加工场景。
		

适用刀具

DWLNR/L
KAPR:95°PWLNR/L
KAPR:95°MWLNR/L
KAPR:95°PWLNR/L
KAPR:95°

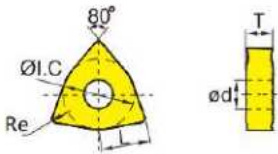
		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金														○	×		
			H	淬硬钢														○			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ØI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	WNMG080404	8.7	12.7	4.76	5.16	0.4	▲	▲	●					●		●					
	WNMG080408	8.7	12.7	4.76	5.16	0.8	▲	▲	●					●		●					
	WNMG080412	8.7	12.7	4.76	5.16	1.2	▲	▲	●					●		●					
	WNMG080404L/R-X	8.7	12.7	4.76	5.16	0.4	▲	▲	●					●							
	WNMG080408L/R-X	8.7	12.7	4.76	5.16	0.8	▲	▲	●					●							
	WNMG080412L/R-X	8.7	12.7	4.76	5.16	1.2	▲	▲	●					●							
	WNMG080404-PMB	8.7	12.7	4.76	5.16	0.4	▲	▲	●					●		●	●				
	WNMG080408-PMB	8.7	12.7	4.76	5.16	0.8	▲	▲	●					●		●	●				
	WNMG080412-PMB	8.7	12.7	4.76	5.16	1.2	▲	▲	●					●		●	●				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 PMB			槽型特点 L/R-X			槽型特点 通槽		
	刀尖部分	MB的升级槽型, 新增的倒棱设计, 大大增强刃口强度, 有效提高刀具寿命。		刀尖部分	平行断屑槽。中进给量条件下, 切屑处理良好。		刀尖部分	碳钢、合金钢中切削用第二推荐断屑槽。扁平棱边刃形, 切削刃强度高。通用性高的全周断屑槽形状。
	主切削刃部分			主切削刃部分			主切削刃部分	

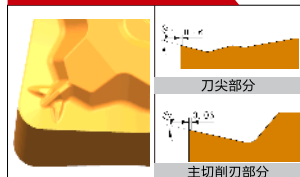
适用刀具			
DWLNRL KAPR:95° 	PWLNRL KAPR:95° 	MWLNRL KAPR:95° 	PWLNRL KAPR:95°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																				
		工件材料 Workpiece Material	P	钢	√	○	×					○	×									
			M	不锈钢											√	○	○	×				
			K	铸铁					√	○	×											
			N	有色金属																		
			S	耐热合金、钛合金																	○	×
H	淬硬钢																	○				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10	
	WNMG06T304-MF	6.5	9.525	3.97	3.81	0.4										●	●	▲	●			
	WNMG06T308-MF	6.5	9.525	3.97	3.81	0.8										●	●	▲	●			
	WNMG06T312-MF	6.5	9.525	3.97	3.81	1.2										●	●	▲	●			
	WNMG060404-MF	6.5	9.525	4.76	3.81	0.4										●	●	▲	●			
	WNMG060408-MF	6.5	9.525	4.76	3.81	0.8										●	●	▲	●			
	WNMG060412-MF	6.5	9.525	4.76	3.81	1.2										●	●	▲	●			
	WNMG080404-MF	8.7	12.7	4.76	5.16	0.4										●	●	▲	●			
	WNMG080408-MF	8.7	12.7	4.76	5.16	0.8										●	●	▲	●			
	WNMG080412-MF	8.7	12.7	4.76	5.16	1.2										●	●	▲	●			
	WNMG06T304-MJ	6.5	9.525	3.97	3.81	0.4										●	●	▲	●			
	WNMG06T308-MJ	6.5	9.525	3.97	3.81	0.8										●	●	▲	●			
	WNMG06T312-MJ	6.5	9.525	3.97	3.81	1.2										●	●	▲	●			
	WNMG060404-MJ	6.5	9.525	4.76	3.81	0.4										●	●	▲	●			
	WNMG060408-MJ	6.5	9.525	4.76	3.81	0.8										●	●	▲	●			
	WNMG060412-MJ	6.5	9.525	4.76	3.81	1.2										●	●	▲	●			
	WNMG080404-MJ	8.7	12.7	4.76	5.16	0.4										●	●	▲	●			
	WNMG080408-MJ	8.7	12.7	4.76	5.16	0.8										●	●	▲	●			
	WNMG080412-MJ	8.7	12.7	4.76	5.16	1.2										●	●	▲	●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

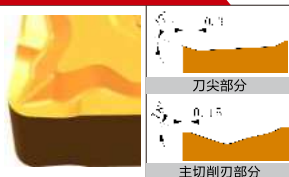
● 按订单生产可选牌号 Make-to-order

MF 槽型特点



M级双面断屑槽，刃口锋利，有效解决不锈钢断屑，粘刀、表面硬化等加工难点，获得高质量加工表面。

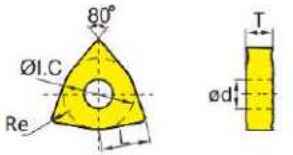
MJ 槽型特点



切削刃锋利，阻力小；带刃倾角设计，导屑好；断屑台前移可在小余量加工状况下实现良好断屑。

适用刀具

DWLNR/L
KAPR:95°PWLNR/L
KAPR:95°MWLNR/L
KAPR:95°PWLNR/L
KAPR:95°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																				
		工件材料 Workpiece Material	P	钢			√	○	×					○	×							
			M	不锈钢											√	○	○	×				
			K	铸铁						√	○	×										
			N	有色金属																		
			S	耐热合金、钛合金															○	×		
			H	淬硬钢															○			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10	
	WNMG060408-MM-B	6.5	9.525	4.76	3.81	0.8										●	▲	▲				
	WNMG060412-MM-B	6.5	9.525	4.76	3.81	1.2										●	▲	▲				
	WNMG080404-MM-B	8.7	12.7	4.76	5.16	0.4										●	▲	▲				
	WNMG080408-MM-B	8.7	12.7	4.76	5.16	0.8										●	▲	▲				
	WNMG080412-MM-B	8.7	12.7	4.76	5.16	1.2										●	▲	▲				
	WNMG060408-MP	6.5	9.525	4.76	3.81	0.8										●	▲	▲				
	WNMG060412-MP	6.5	9.525	4.76	3.81	1.2										●	▲	▲				
	WNMG080404-MP	8.7	12.7	4.76	5.16	0.4										●	▲	▲				
	WNMG080408-MP	8.7	12.7	4.76	5.16	0.8										●	▲	▲				
	WNMG080412-MP	8.7	12.7	4.76	5.16	1.2										●	▲	▲				
	WNMG080404L/R-M	8.7	12.7	4.76	5.16	0.4										●	▲	▲				
	WNMG080408L/R-M	8.7	12.7	4.76	5.16	0.8										●	▲	▲				
	WNMG080412L/R-M	8.7	12.7	4.76	5.16	1.2										●	▲	▲				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 L/R-M		槽型特点 MP		槽型特点 MM-B	
	主切削刃部分		主切削刃部分		主切削刃部分
双面断屑槽，抗冲击能力强，槽型设计在刃口安全性和锋利性取得了最佳平衡点，解决不锈钢粗加工等问题。		通用型中切正棱刃断屑槽，凭借强化刃口处理技术平衡切削锋利度与耐用性，是法兰盘台阶车削、轴类零件多工序加工等中等负荷钢件车削的理想选择。		刀尖刃口同时兼具锋利性和强度。具有良好的排屑效果，适用于半精偏精加工。	

适用刀具			
DWLNLR/L KAPR:95° 	PWLNLR/L KAPR:95° 	MWLNLR/L KAPR:95° 	PWLNLR/L KAPR:95°

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
			M	不锈钢										√	○	○	×
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)	L	ØI.C	T	Φd	r	CVD涂层						PVD涂层			
								KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286
	WNMG080408-ZR	8.7	12.7	4.76	5.16	0.8					•	•	▲				
	WNMG080412-ZR	8.7	12.7	4.76	5.16	1.2					•	•	▲				
	WNMG080408-GH	8.7	12.7	4.76	5.16	0.8					•	▲	▲				
	WNMG080412-GH	8.7	12.7	4.76	5.16	1.2					•	▲	▲				

▲ 为主推荐牌号 Recommended grade (Always stock available)

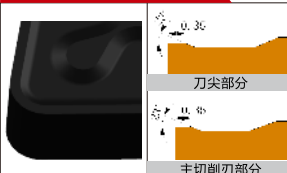
● 按订单生产可选牌号 Make-to-order

ZR 槽型特点



碳钢、合金钢、不锈钢
准重切削用采用以往
产品3倍以上的安装
面积与宽棱边,在断续
切削、黑皮切削中发
挥出色的切削刃稳定
性。

GH 槽型特点



宽棱边与大容量槽组
合,实现高进给量加
工。适用于断续切削、
黑皮切削。

适用刀具

DWLNRL
KAPR:95°



PWLNRL
KAPR:95°

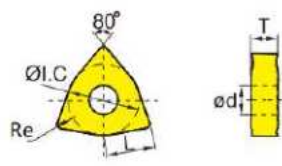


MWLNRL
KAPR:95°



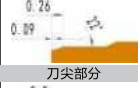
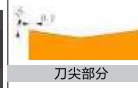
PWLNRL
KAPR:95°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢		√	○	×					○	×							
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
H	淬硬钢															○					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层							PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	WNMG080404-UC	8.7	12.7	4.76	5.16	0.4					●	▲	▲								
	WNMG080408-UC	8.7	12.7	4.76	5.16	0.8					●	▲	▲								
	WNMG080412-UC	8.7	12.7	4.76	5.16	1.2					●	▲	▲								
	WNMG080416-UC	8.7	12.7	4.76	5.16	1.6					●	▲	▲								
	WNMG080408-ZD	8.7	12.7	4.76	5.16	0.8					●	▲	▲								
	WNMG080412-ZD	8.7	12.7	4.76	5.16	1.2					●	▲	▲								
	WNMG080416-ZD	8.7	12.7	4.76	5.16	1.6					●	▲	▲								

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 ZD		槽型特点 UC	
	 刀尖部分 0.25 0.09 0.3		 刀尖部分 0.25 0.09 0.3
	适用于铸铁和硬材料的粗加工采用特质涂层，兼具高耐磨性与抗冲击性能，显著延长刀具寿命。支持高进给与高速切削，适合连续或轻微断续车削工况，提升生产效率。		碳钢、合金钢中切削用第二推荐断屑槽。扁平棱边刃形，切削刃强度高。通用性高的全周断屑槽形状。
	主切削刃部分		主切削刃部分

适用刀具			
DWLNLR/L KAPR:95° 	PWLNLR/L KAPR:95° 	MWLNLR/L KAPR:95° 	PWLNLR/L KAPR:95° 

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

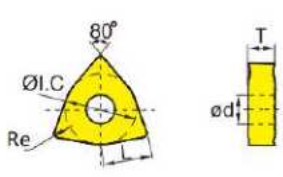
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

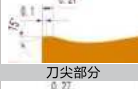
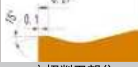
J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
			M	不锈钢										√	○	○	×
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)	L	ØI.C.	T	ød	r	CVD涂层						PVD涂层			
								KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286
	WNMG080404-ZK	8.7	12.7	4.76	5.16	0.4					•	▲	▲				
	WNMG080408-ZK	8.7	12.7	4.76	5.16	0.8					•	▲	▲				
	WNMG080412-ZK	8.7	12.7	4.76	5.16	1.2					•	▲	▲				
	WNMG080416-ZK	8.7	12.7	4.76	5.16	1.6					•	▲	▲				
	WNMA080408	8.7	12.7	4.76	5.16	0.8					•	▲	▲				
	WNMA080412	8.7	12.7	4.76	5.16	1.2					•	▲	▲				
	WNMA080416	8.7	12.7	4.76	5.16	1.6					•	▲	▲				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

ZK 槽型特点

	 刀尖部分	碳钢/合金钢中切削专用全周断屑槽，扁平棱边强化刃口设计在保持通用性的同时提升刃口刚性，特别适用于液压杆连续车削、传动轴台阶加工等中等负荷钢件车削场景。	 刀尖部分
	 主切削刃部分		

通槽 槽型特点

	 刀尖部分	碳钢、合金钢中切削用第二推荐断屑槽。扁平棱边刃形，切削刃强度高。通用性高的全周断屑槽形状。	 主切削刃部分

适用刀具

DWLNR/L
KAPR:95°



PWLNR/L
KAPR:95°

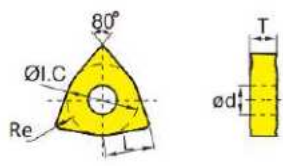


MWLNR/L
KAPR:95°



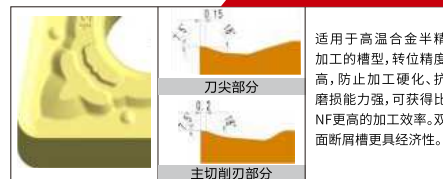
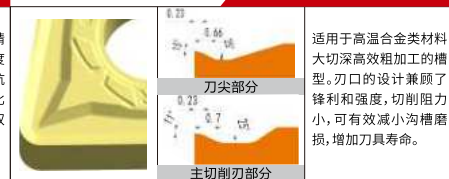
PWLNR/L
KAPR:95°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢											√	○	○	×
		K	铸铁					√	○	×							
		N	有色金属														
		S	耐热合金、钛合金														○
		H	淬硬钢													○	×
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	WNMG080408-NR	8.7	12.7	4.76	5.16	0.8											● ▲
	WNMG080412-NR	8.7	12.7	4.76	5.16	1.2											● ▲
	WNMG080408-NM	8.7	12.7	4.76	5.16	0.8											● ▲
	WNMG080412-NM	8.7	12.7	4.76	5.16	1.2											● ▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

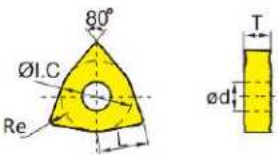
● 按订单生产可选牌号 Make-to-order

槽型特点 NM

槽型特点 NR

适用刀具
DWLN/L
 KAPR:95°

PWLN/L
 KAPR:95°

MWLN/L
 KAPR:95°

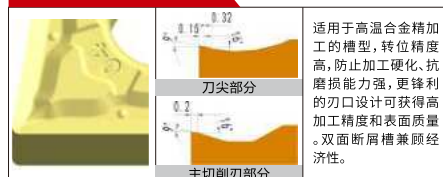
PWLN/L
 KAPR:95°


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
			M	不锈钢										√	○	○	×
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)	L	ØI.C	T	Φd	r	CVD涂层						PVD涂层			
								KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286
	WNMG080404-NF	8.7	12.7	4.76	5.16	0.4											
	WNMG080408-NF	8.7	12.7	4.76	5.16	0.8											
	WNMG080408-M2	8.7	12.7	4.76	5.16	0.8											
	WNMG080412-M2	8.7	12.7	4.76	5.16	1.2											

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

NF 槽型特点



M2 槽型特点



适用刀具

DWLNRL
KAPR:95°



PWLNRL
KAPR:95°

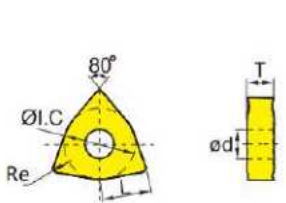


MWLNRL
KAPR:95°



PWLNRL
KAPR:95°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金															○	×	
			H	淬硬钢															○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层								
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	WNNMG080404-TFA	8.7	12.7	4.76	5.16	0.4													▲		
	WNNMG080408-TFA	8.7	12.7	4.76	5.16	0.8													▲		
	WNNMG080412-TFA	8.7	12.7	4.76	5.16	1.2													▲		
	WNNMG080404-CM	8.7	12.7	4.76	5.16	0.4													▲		
	WNNMG080408-CM	8.7	12.7	4.76	5.16	0.8													▲		
	WNNMG080412-CM	8.7	12.7	4.76	5.16	1.2													▲		
	WNNMG080404-CF	8.7	12.7	4.76	5.16	0.4													▲		
	WNNMG080408-CF	8.7	12.7	4.76	5.16	0.8													▲		
	WNNMG080412-CF	8.7	12.7	4.76	5.16	1.2													▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 CF		槽型特点 CM		槽型特点 TFA	
	刀尖部分 主切削刃部分		刀尖部分 主切削刃部分		刀尖部分 主切削刃部分
刃口锋利, 切削轻快; 适用于淬硬钢等难加工材料的连续精加工, 表面质量优良。		双前角设计, 断屑范围宽; 适用于淬硬钢等难加工材料的断续半精加工及粗加工。		大前角设计, 切削力低; 适用于淬硬钢等难加工材料的轻断续精加工, 加工表面质量好。	

适用刀具			
DWLNLR/L KAPR:95° 	PWLNLR/L KAPR:95° 	MWLNLR/L KAPR:95° 	PWLNLR/L KAPR:95°

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

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H 刀杆和刀盘

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		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
工件材料 Workpiece Material	P	钢	√	○	×					○	×						
	M	不锈钢										√	○	○	×		
	K	铸铁				√	○	×									
	N	有色金属															
	S	耐热合金、钛合金														○	×
	H	淬硬钢														○	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	CCMT060202-GM	6.4	6.35	2.38	2.8	0.2	▲	▲	●		●			●			
	CCMT060204-GM	6.4	6.35	2.38	2.8	0.4	▲	▲	●		●			●			
	CCMT060208-GM	6.4	6.35	2.38	2.8	0.8	▲	▲	●		●			●			
	CCMT09T304-GM	9.7	9.525	3.97	4.4	0.4	▲	▲	●		●			●			
	CCMT09T308-GM	9.7	9.525	3.97	4.4	0.8	▲	▲	●		●			●			
	CCMT120404-GM	12.9	12.7	4.76	5.56	0.4	▲	▲	●		●			●			
	CCMT120408-GM	12.9	12.7	4.76	5.56	0.8	▲	▲	●		●			●			
	CCMT120412-GM	12.9	12.7	4.76	5.56	1.2	▲	▲	●		●			●			
	CCMT060204-PMK	6.4	6.35	2.38	2.8	0.4	▲	▲	●		●			●			
	CCMT060208-PMK	6.4	6.35	2.38	2.8	0.8	▲	▲	●		●			●			
	CCMT09T304-PMK	9.7	9.525	3.97	4.4	0.4	▲	▲	●		●			●			
	CCMT09T308-PMK	9.7	9.525	3.97	4.4	0.8	▲	▲	●		●			●			
	CCMT120404-PMK	12.9	12.7	4.76	5.56	0.4	▲	▲	●		●			●			
	CCMT120408-PMK	12.9	12.7	4.76	5.56	0.8	▲	▲	●		●			●			
	CCMT120412-PMK	12.9	12.7	4.76	5.56	1.2	▲	▲	●		●			●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

GM 槽型特点



PMK 槽型特点



适用刀具

SCACR/L
KAPR:90°



SCLCR/L
KAPR:95°



SCLCR/L
KAPR:95°

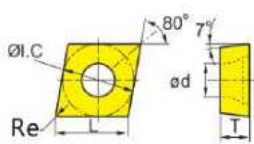


SCFCR/L
KAPR:90°



SCLCR/L
KAPR:95°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢									√	○	○	×					
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金													○	×			
			H	淬硬钢													○				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	CCMT060202-MF	6.4	6.35	2.38	2.8	0.2	▲	●							●	▲		●			
	CCMT060204-MF	6.4	6.35	2.38	2.8	0.4	▲	●							●	▲		●			
	CCMT060208-MF	6.4	6.35	2.38	2.8	0.8	▲	●							●	▲		●			
	CCMT09T302-MF	9.7	9.525	3.97	4.4	0.2	▲	●							●	▲		●			
	CCMT09T304-MF	9.7	9.525	3.97	4.4	0.4	▲	●							●	▲		●			
	CCMT09T308-MF	9.7	9.525	3.97	4.4	0.8	▲	●							●	▲		●			
	CCMT120404-MF	12.9	12.7	4.76	5.56	0.4	▲	●							●	▲		●			
	CCMT120408-MF	12.9	12.7	4.76	5.56	0.8	▲	●							●	▲		●			
CCMT120412-MF	12.9	12.7	4.76	5.56	1.2	▲	●							●	▲		●				
	CCMT060202-MM	6.4	6.35	2.38	2.8	0.2									●	▲	●	●			
	CCMT060204-MM	6.4	6.35	2.38	2.8	0.4									●	▲	●	●			
	CCMT060208-MM	6.4	6.35	2.38	2.8	0.8									●	▲	●	●			
	CCMT09T302-MM	9.7	9.525	3.97	4.4	0.2									●	▲	●	●			
	CCMT09T304-MM	9.7	9.525	3.97	4.4	0.4									●	▲	●	●			
	CCMT09T308-MM	9.7	9.525	3.97	4.4	0.8									●	▲	●	●			
	CCMT120404-MM	12.9	12.7	4.76	5.56	0.4									●	▲	●	●			
	CCMT120408-MM	12.9	12.7	4.76	5.56	0.8									●	▲	●	●			
	CCMT120412-MM	12.9	12.7	4.76	5.56	1.2									●	▲	●	●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 MM		槽型特点 MF	
	 刀尖部分		 刀尖部分
	 主切削刃部分		 主切削刃部分
	M类材料半精加工推荐槽型M级精度, 刃口强度较好, 可获得更高的加工效率。		M级精度, 刃口锋利, 适合于不锈钢、软钢等粘性材料的精加工。

适用刀具				
SCACR/L KAPR:90° 	SCLCR/L KAPR:95° 	SCLCR/L KAPR:95° 	SCFCR/L KAPR:90° 	SCLCR/L KAPR:95°

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
工件材料 Workpiece Material	P	钢	√	○	×							○	×				
	M	不锈钢												√	○	○	×
	K	铸铁				√	○	×									
	N	有色金属															
	S	耐热合金、钛合金															○
	H	淬硬钢														○	×
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	CCMT09T304-XF	9.7	9.525	3.97	4.4	0.4											
	CCMT09T308-SF	9.7	9.525	3.97	4.4	0.8											
	CCMW060204	6.4	6.35	2.38	2.8	0.4	●	▲							●	▲	
	CCMW09T304	9.7	9.525	3.97	4.4	0.4	●	▲							●	▲	
	CCMW09T308	9.7	9.525	3.97	4.4	0.8	●	▲							●	▲	
	CCMW120404	12.9	12.7	4.76	5.56	0.4	●	▲							●	▲	
	CCMW120408	12.9	12.7	4.76	5.56	0.8	●	▲							●	▲	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

平板 槽型特点



适用刀具

SCACR/L
KAPR:90°



SCLCR/L
KAPR:95°



SCLCR/L
KAPR:95°

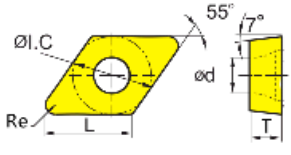
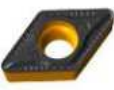
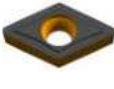


SCFCR/L
KAPR:90°



SCLCR/L
KAPR:95°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
			M	不锈钢									√	○	○	×	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)						CVD涂层						PVD涂层			
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	DCMT070202-GM	7.8	6.35	2.38	2.8	0.2	▲	▲	●		●			●			
	DCMT070204-GM	7.8	6.35	2.38	2.8	0.4	▲	▲	●		●			●			
	DCMT070208-GM	7.8	6.35	2.38	2.8	0.8	▲	▲	●		●			●			
	DCMT11T302-GM	11.6	9.525	3.97	4.4	0.2	▲	▲	●		●			●			
	DCMT11T304-GM	11.6	9.525	3.97	4.4	0.4	▲	▲	●		●			●			
	DCMT11T308-GM	11.6	9.525	3.97	4.4	0.8	▲	▲	●		●			●			
	DCMT11T312-GM	11.6	9.525	3.97	4.4	1.2	▲	▲	●		●			●			
	DCMT070204-PMK	7.8	6.35	2.38	2.8	0.4	▲	▲	●		●			●			
	DCMT070208-PMK	7.8	6.35	2.38	2.8	0.8	▲	▲	●		●			●			
	DCMT11T302-PMK	11.6	9.525	3.97	4.4	0.2	▲	▲	●		●			●			
	DCMT11T304-PMK	11.6	9.525	3.97	4.4	0.4	▲	▲	●		●			●			
	DCMT11T308-PMK	11.6	9.525	3.97	4.4	0.8	▲	▲	●		●			●			
	DCMT11T312-PMK	11.6	9.525	3.97	4.4	1.2	▲	▲	●		●			●			
	DCMT11T312-PMK	11.6	9.525	3.97	4.4	1.2	▲	▲	●		●			●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 PMK

槽型特点 GM

适用刀具
SDACR/L
 KAPR:90°

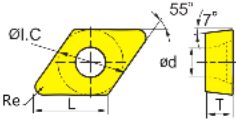
SDJCR/L
 KAPR:93°

SDNCN
 KAPR:62°30'

SDQCR/L
 KAPR:107°30'

SDUCR/L
 KAPR:93°

SDZCR/L
 KAPR:93°


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×						○	×							
			M	不锈钢										√	○	○	×				
			K	铸铁					√	○	×										
			N	有色金属																	
			S	耐热合金、钛合金																○	×
H	淬硬钢																○				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层						
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	DCMT070202-MF	7.8	6.35	2.38	2.8	0.2	▲	●							●	▲		●			
	DCMT070204-MF	7.8	6.35	2.38	2.8	0.4	▲	●							●	▲		●			
	DCMT070208-MF	7.8	6.35	2.38	2.8	0.8	▲	●							●	▲		●			
	DCMT11T302-MF	11.6	9.525	3.97	4.4	0.2	▲	●							●	▲		●			
	DCMT11T304-MF	11.6	9.525	3.97	4.4	0.4	▲	●							●	▲		●			
	DCMT11T308-MF	11.6	9.525	3.97	4.4	0.8	▲	●							●	▲		●			
	DCMT070202-MM	7.8	6.35	2.38	2.8	0.2									●	▲	●	●			
	DCMT070204-MM	7.8	6.35	2.38	2.8	0.4									●	▲	●	●			
	DCMT070208-MM	7.8	6.35	2.38	2.8	0.8									●	▲	●	●			
	DCMT11T302-MM	11.6	9.525	3.97	4.4	0.2									●	▲	●	●			
	DCMT11T304-MM	11.6	9.525	3.97	4.4	0.4									●	▲	●	●			
	DCMT11T308-MM	11.6	9.525	3.97	4.4	0.8									●	▲	●	●			
	DCMW070204	7.8	6.35	2.38	2.8	0.4	●	▲								●	▲				
	DCMW11T304	11.6	9.525	3.97	4.4	0.4	●	▲								●	▲				
	DCMW11T308	11.6	9.525	3.97	4.4	0.8	●	▲								●	▲				

▲ 为主推荐牌号 Recommended grade (Always stock available)

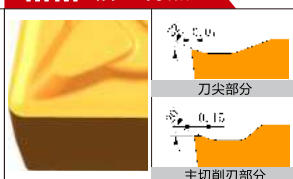
● 按订单生产可选牌号 Make-to-order

MF 槽型特点



M级精度，刃口锋利，适合于不锈钢、软钢等粘性材料的精加工。

MM 槽型特点



M类材料半精加工推荐槽型M级精度，刃口强度较好，可获得更高的加工效率。

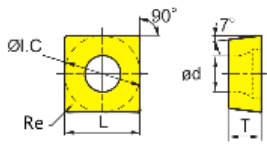
平板 槽型特点



刀尖刃口强度号，适合断续车削加工。

适用刀具

SDACR/L
KAPR:90°SDJCR/L
KAPR:93°SDNCN
KAPR:62°30'SDQCR/L
KAPR:107°30'SDUCR/L
KAPR:93°SDZCR/L
KAPR:93°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
		M	不锈钢										√	○	○	×	
		K	铸铁					√	○	×							
		N	有色金属														
		S	耐热合金、钛合金														○
		H	淬硬钢													○	×
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						PVD涂层				
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S
	SCMT09T302-GM	9.525	9.525	3.97	4.4	0.2	▲	▲	●		●			●			
	SCMT09T304-GM	9.525	9.525	3.97	4.4	0.4	▲	▲	●		●			●			
	SCMT09T308-GM	9.525	9.525	3.97	4.4	0.8	▲	▲	●		●			●			
	SCMT120404-GM	12.7	12.7	4.76	5.56	0.4	▲	▲	●		●			●			
	SCMT120408-GM	12.7	12.7	4.76	5.56	0.8	▲	▲	●		●			●			
	SCMT120412-GM	12.7	12.7	4.76	5.56	1.2	▲	▲	●		●			●			
	SCMT09T304-PMK	9.525	9.525	3.97	4.4	0.4	▲	▲	●		●			●			
	SCMT09T308-PMK	9.525	9.525	3.97	4.4	0.8	▲	▲	●		●			●			
	SCMT09T312-PMK	9.525	9.525	3.97	4.4	1.2	▲	▲	●		●			●			
	SCMT120404-PMK	12.7	12.7	4.76	5.56	0.4	▲	▲	●		●			●			
	SCMT120408-PMK	12.7	12.7	4.76	5.56	0.8	▲	▲	●		●			●			
	SCMT120412-PMK	12.7	12.7	4.76	5.56	1.2	▲	▲	●		●			●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 PMK

槽型特点 GM

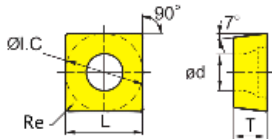
适用刀具
SSBCR/L
 KAPR:75°

SSDCN
 KAPR:45°

SSKCR/L
 KAPR:75°

SSSCR/L
 KAPR:45°

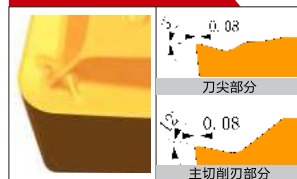
SSKCR/L
 KAPR:75°


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																				
		工件材料 Workpiece Material	P	钢	√	○	×						○	×								
			M	不锈钢											√	○	○	×				
			K	铸铁					√	○	×											
			N	有色金属																		
			S	耐热合金、钛合金																○	×	
			H	淬硬钢																○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10	
	SCMT09T302-MF	9.525	9.525	3.97	4.4	0.2	▲	●								●	▲		●			
	SCMT09T304-MF	9.525	9.525	3.97	4.4	0.4	▲	●								●	▲		●			
	SCMT09T308-MF	9.525	9.525	3.97	4.4	0.8	▲	●								●	▲		●			
	SCMT120404-MF	12.7	12.7	4.76	5.56	0.4	▲	●								●	▲		●			
	SCMT120408-MF	12.7	12.7	4.76	5.56	0.8	▲	●								●	▲		●			
	SCMT120412-MF	12.7	12.7	4.76	5.56	1.2	▲	●								●	▲		●			
	SCMT09T302-MM	9.525	9.525	3.97	4.4	0.2										●	▲	●	●			
	SCMT09T304-MM	9.525	9.525	3.97	4.4	0.4										●	▲	●	●			
	SCMT09T308-MM	9.525	9.525	3.97	4.4	0.8										●	▲	●	●			
	SCMT120404-MM	12.7	12.7	4.76	5.56	0.4										●	▲	●	●			
	SCMT120408-MM	12.7	12.7	4.76	5.56	0.8										●	▲	●	●			
	SCMT120412-MM	12.7	12.7	4.76	5.56	1.2										●	▲	●	●			
	SCMW060204	6.35	6.35	2.38	2.8	0.4	●	▲									●	▲				
	SCMW09T304	9.525	9.525	3.97	4.4	0.4	●	▲									●	▲				
	SCMW09T308	9.525	9.525	3.97	4.4	0.8	●	▲									●	▲				
	SCMW120408	12.7	12.7	4.76	5.56	0.8	●	▲									●	▲				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

MF 槽型特点



M级精度，刃口锋利，适合于不锈钢、软钢等粘性材料的精加工。

MM 槽型特点



M类材料半精加工推荐槽型M级精度，刃口强度较好，可获得更高的加工效率。

平板 槽型特点



刀尖刃口强度号，适合断续车削加工。

适用刀具

SSBCR/L
KAPR:75°



SSDCN
KAPR:45°



SSKCR/L
KAPR:75°



SSSCR/L
KAPR:45°



SSKCR/L
KAPR:75°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions															
		工件材料 Workpiece Material	P	钢	√	○	×					○	×				
			M	不锈钢									√	○	○	×	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)	L	ØI.C	T	φd	r	CVD涂层						PVD涂层			
								KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286
	TCMT090202-GM	9.6	5.56	2.38	2.5	0.2	0.2	▲	▲	●		●			●		
	TCMT090204-GM	9.6	5.56	2.38	2.5	0.4	0.4	▲	▲	●		●			●		
	TCMT090208-GM	9.6	5.56	2.38	2.5	0.8	0.8	▲	▲	●		●			●		
	TCMT110202-GM	11	6.35	2.38	2.8	0.2	0.2	▲	▲	●		●			●		
	TCMT110204-GM	11	6.35	2.38	2.8	0.4	0.4	▲	▲	●		●			●		
	TCMT110208-GM	11	6.35	2.38	2.8	0.8	0.8	▲	▲	●		●			●		
	TCMT16T304-GM	16.5	9.525	3.97	4.4	0.4	0.4	▲	▲	●		●			●		
	TCMT16T308-GM	16.5	9.525	3.97	4.4	0.8	0.8	▲	▲	●		●			●		
	TCMT090204-PMK	9.6	5.56	2.38	2.5	0.4	0.4	▲	▲	●		●			●		
	TCMT090208-PMK	9.6	5.56	2.38	2.5	0.8	0.8	▲	▲	●		●			●		
	TCMT110204-PMK	11	6.35	2.38	2.8	0.4	0.4	▲	▲	●		●			●		
	TCMT110208-PMK	11	6.35	2.38	2.8	0.8	0.8	▲	▲	●		●			●		
	TCMT110212-PMK	11	6.35	2.38	2.8	1.2	1.2	▲	▲	●		●			●		
	TCMT16T304-PMK	16.5	9.525	3.97	4.4	0.4	0.4	▲	▲	●		●			●		
	TCMT16T308-PMK	16.5	9.525	3.97	4.4	0.8	0.8	▲	▲	●		●			●		
	TCMT16T312-PMK	16.5	9.525	3.97	4.4	1.2	1.2	▲	▲	●		●			●		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 PMK



槽型特点 GM



适用刀具

STACR/L
KAPR:90°



STFCR/L
KAPR:91°

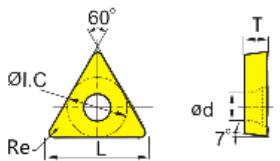


STGCR/L
KAPR:91°



STFCR/L
KAPR:91°

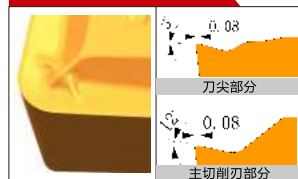


		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																				
		工件材料 Workpiece Material	P	钢	√	○	×						○	×								
			M	不锈钢											√	○	○	×				
			K	铸铁					√	○	×											
			N	有色金属																		
			S	耐热合金、钛合金																○	×	
H	淬硬钢																○					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层								PVD涂层							
		L	ΦI.C	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10	
	TCMT090202-MF	9.6	5.56	2.38	2.5	0.2	▲	●								●	▲		●			
	TCMT090204-MF	9.6	5.56	2.38	2.5	0.4	▲	●								●	▲		●			
	TCMT110202-MF	11	6.35	2.38	2.8	0.2	▲	●								●	▲		●			
	TCMT110204-MF	11	6.35	2.38	2.8	0.4	▲	●								●	▲		●			
	TCMT110208-MF	11	6.35	2.38	2.8	0.8	▲	●								●	▲		●			
	TCMT16T304-MF	16.5	9.525	3.97	4.4	0.4	▲	●								●	▲		●			
	TCMT16T308-MF	16.5	9.525	3.97	4.4	0.8	▲	●								●	▲		●			
	TCMT090202-MM	9.6	5.56	2.38	2.5	0.2										●	▲	●	●			
	TCMT090204-MM	9.6	5.56	2.38	2.5	0.4										●	▲	●	●			
	TCMT110202-MM	11	6.35	2.38	2.8	0.2										●	▲	●	●			
	TCMT110204-MM	11	6.35	2.38	2.8	0.4										●	▲	●	●			
	TCMT110208-MM	11	6.35	2.38	2.8	0.8										●	▲	●	●			
	TCMT16T304-MM	16.5	9.525	3.97	4.4	0.4										●	▲	●	●			
	TCMT16T308-MM	16.5	9.525	3.97	4.4	0.8										●	▲	●	●			
	TCMW110204	11	6.35	2.38	2.8	0.4	●	▲									●	▲				
	TCMW16T304	16.5	9.525	3.97	4.4	0.4	●	▲									●	▲				
	TCMW16T308	16.5	9.525	3.97	4.4	0.8	●	▲									●	▲				
	TCMW16T312	16.5	9.525	3.97	4.4	1.2	●	▲									●	▲				
	TCMW220408	22	12.7	4.76	5.5	0.8	●	▲									●	▲				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

MF 槽型特点



M级精度, 刃口锋利, 适合于不锈钢、软钢等粘性材料的精加工。

MM 槽型特点



M类材料半精加工推荐槽型M级精度, 刃口强度较好, 可获得更高的加工效率。

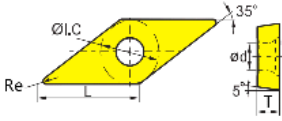
平板 槽型特点



刀尖刃口强度号, 适合断续车削加工。

适用刀具

STACR/L
KAPR:90°STFCR/L
KAPR:91°STGCR/L
KAPR:91°STFCR/L
KAPR:91°

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions																			
		工件材料 Workpiece Material	P	钢	√	○	×					○	×								
			M	不锈钢										√	○	○	×				
			K	铸铁				√	○	×											
			N	有色金属																	
			S	耐热合金、钛合金														○	×		
			H	淬硬钢														○			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层							PVD涂层							
		L	ΦLC	T	Φd	r	KT1153	KT1253	KT1373	KT3123	KT3263	KT3253	KP015	KP025	KT8206	KT8286	KT8284S	KT8287N	KT6109	KS05	KS10
	VBMT110304-GM	11	6.35	3.18	2.8	0.4	▲	▲	●		●			●							
	VBMT110308-GM	11	6.35	3.18	2.8	0.8	▲	▲	●		●			●							
	VBMT160404-GM	16.5	9.525	4.76	4.4	0.4	▲	▲	●		●			●							
	VBMT160408-GM	16.5	9.525	4.76	4.4	0.8	▲	▲	●		●			●							
	VBMT160412-GM	16.5	9.525	4.76	4.4	1.2	▲	▲	●		●			●							
	VBMT110304-PMK	11	6.35	3.18	2.8	0.4	▲	▲	●		●			●							
	VBMT110308-PMK	11	6.35	3.18	2.8	0.8	▲	▲	●		●			●							
	VBMT160404-PMK	16.5	9.525	4.76	4.4	0.4	▲	▲	●		●			●							
	VBMT160408-PMK	16.5	9.525	4.76	4.4	0.8	▲	▲	●		●			●							
	VBMT160412-PMK	16.5	9.525	4.76	4.4	1.2	▲	▲	●		●			●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 PMK

槽型特点 GM

适用刀具
SVJBR/L
 KAPR:93°

SVABR/L
 KAPR:90°

SVVBN
 KAPR:72°30'

SVQBR/L
 KAPR:107°30'

SVUBR/L
 KAPR:93°

A
 车削刀片

B
 铣削刀片

C
 铝合金刀片

D
 孔加工刀片

E
 刮管刀片

F
 非标异形刀片

G
 圆棒和立铣刀

H
 刀杆和刀盘

I
 加工案例

J
 通用技术信息

车削 / 普通车削

General Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

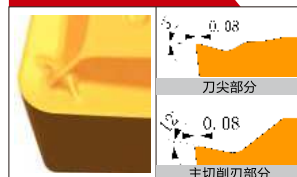
J 通用技术信息

|--|--|

▲ 为主推荐牌号 Recommended grade (Always stock available)

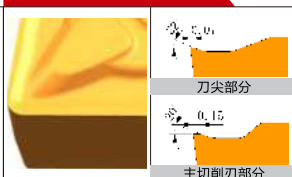
● 按订单生产可选牌号 Make-to-order

MF 槽型特点



M级精度，刃口锋利，适合于不锈钢、软钢等粘性材料的精加工。

MM 槽型特点



M类材料半精加工推荐槽型M级精度，刃口强度较好，可获得更高的加工效率。

平板 槽型特点



刀尖刃口强度号，适合断续车削加工。

适用刀具

SVJBR/L
KAPR:93°



SVABR/L
KAPR:90°



SVVBN
KAPR:72°30'

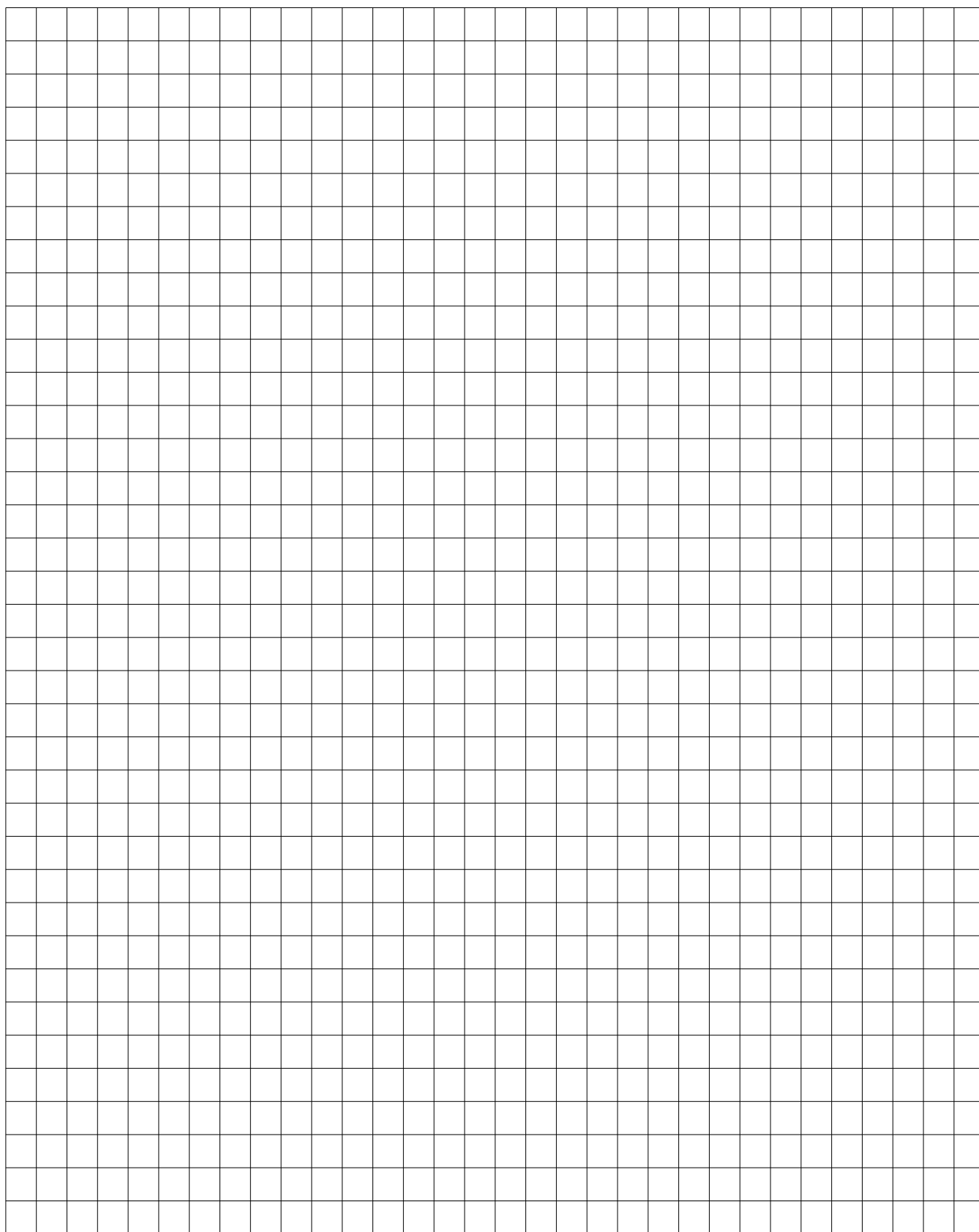


SVQBR/L
KAPR:107°30'



SVUBR/L
KAPR:93°




A
 车削刀片

B
 铣削刀片

C
 铝合金刀片

D
 孔加工刀片

E
 刮管刀片

F
 非标异形刀片

G
 圆棒和立铣刀

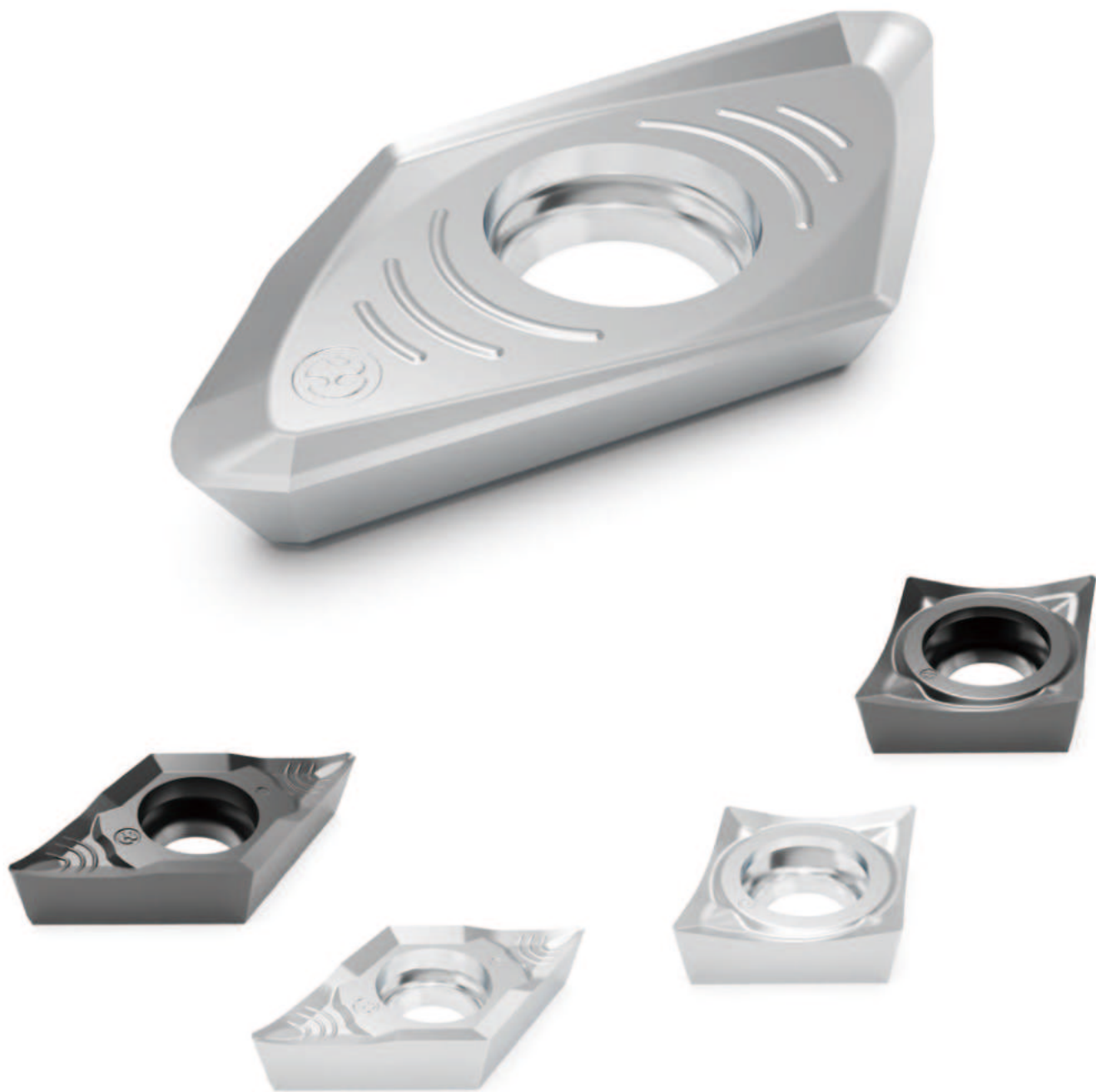
H
 刀杆和刀盘

I
 加工案例

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 通用技术信息

铝合金系列

ALUMINUM ALLOY SERIES



- 高硬度合金，抗磨损，寿命更长
- 精密刃口设计，切削流畅不粘屑

- 轻松应对铝板、铝型材等加工需求
- 适用于 CNC、手动切割等多种场景



铝合金系列

Aluminum Alloy Series

硬质合金牌号 Uncoated Grades	001
铝用产品牌号一览表	
Recommended Grade Overview for Aluminum Inserts	002
铝合金车削 Aluminum Alloy Turning	003
铝合金铣削 Aluminum Alloy Milling	008

铝用刀牌号

硬质合金牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KT3100	N05~N20	无涂层	\	1. 低钴的细晶粒硬质合金材质, 结合特殊的后处理工艺, 具有优异的耐磨性和抗黏结性。 2. 适用于有色金属的车削精加工。
KT3120	N10~N30	无涂层	\	1. 低钴含量的亚微晶粒硬质合金材质, 结合特殊的后处理工艺, 具有优异的耐磨性和抗黏结性。 2. 适用于有色金属的车削加工。

Grade Information

Uncoated Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Application
KT3100	N05~N20	Uncoated	\	1. The fine grain carbide grade with low cobalt content, combined with a special post-treatment process, has excellent wear resistance and adhesion resistance. 2. It is suitable for finishing turning of non-ferrous metals.
KT3120	N10~N30	Uncoated	\	1. Low cobalt submicro grain cemented carbide grade, combined with a special post-treatment process, has excellent wear resistance and adhesion resistance. 2. It is suitable for turning of non-ferrous metals.

A

车削刀片

B

铣削刀片

C

铝合金刀片

D

孔加工刀片

E

刮管刀片

F

非标异形刀片

G

圆棒和立铣刀

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铝用产品牌号一览表 Recommended Grade Table

工件材料 Workpiece materials	ISO代号 ISO Code	CVD	PVD	金属陶瓷 Cermet	硬质合金 Cemented carbide	超硬材料 Superhard materials
P	P01					
	P10					
	P20					
	P30					
	P40					
M	M01					
	M10					
	M20					
	M30					
	M40					
K	K01					
	K10					
	K20					
	K30					
N	N01				KT3100 KT3120	
	N10					
	N20					
	N30					
S	S01					
	S10					
	S20					
	S30					
H	H01					
	H10					
	H20					
	H30					

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

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铝合金 / 铝合金车削

Aluminum Alloy Turning

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

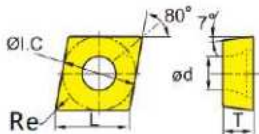
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions							
		工件材料 Workpiece Material	P	钢					
			M	不锈钢					
			K	铸铁					
			N	有色金属				○	○
			S	耐热合金、钛合金					
			H	淬硬钢					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					无涂层		
		L	ØI.C	T	Φd	r	KT3100	KT3120	
	CCGX060202-AK	6.4	6.35	2.38	2.8	0.2	▲	●	
	CCGX060204-AK	6.4	6.35	2.38	2.8	0.4	▲	●	
	CCGX09T304-AK	9.7	9.525	3.97	4.4	0.4	▲	●	
	CCGX09T308-AK	9.7	9.525	3.97	4.4	0.8	▲	●	
	CCGX120404-AK	12.9	12.7	4.76	5.56	0.4	▲	●	
	CCGX120408-AK	12.9	12.7	4.76	5.56	0.8	▲	●	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

AK 槽型特点



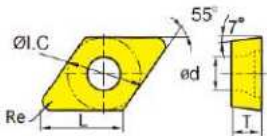
适用刀具

SCACR/L
KAPR:90°



SCLCR/L
KAPR:95°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions								
		工件材料 Workpiece Material	P	钢						
			M	不锈钢						
			K	铸铁						
			N	有色金属					○	○
			S	耐热合金、钛合金						
			H	淬硬钢						
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					无涂层			
		L	ØI.C	T	Φd	r	KT3100	KT3120		
	DCGX070202-AK	7.8	6.35	2.38	2.8	0.1	●	▲		
	DCGX070204-AK	7.8	6.35	2.38	2.8	0.2	●	▲		
	DCGX11T302-AK	7.8	6.35	2.38	2.8	0.4	●	▲		
	DCGX11T304-AK	11.6	9.525	3.97	4.4	0.4	●	▲		
	DCGX11T308-AK	11.6	9.525	3.97	4.4	0.8	●	▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 AK



适用刀具

SDNCNR/L
KAPR:62.5°



SDJCR/L
KAPR:93°



SDACR/L
KAPR:90°



铝合金 / 铝合金车削

Aluminum Alloy Turning

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

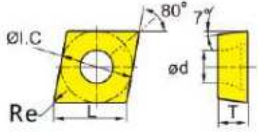
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions						
工件材料 Workpiece Material	P	钢						
	M	不锈钢						
	K	铸铁						
	N	有色金属					○	○
	S	耐热合金、钛合金						
	H	淬硬钢						
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层	
		L	ØI.C	T	Φd	r	KT3100	KT3120
	SCGX09T308-AK	9.525	9.525	3.97	4.4	0.8	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

AK 槽型特点



适用刀具

SSBCR/L
KAPR:75°



SSDCR/L
KAPR:45°

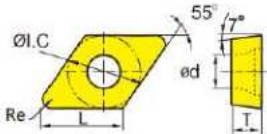


SSKCR/L
KAPR:75°



SSSCR/L
KAPR:75°



		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions								
		工件材料 Workpiece Material	P	钢						
			M	不锈钢						
			K	铸铁						
			N	有色金属					○	○
			S	耐热合金、钛合金						
			H	淬硬钢						
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					无涂层			
		L	ØI.C	T	Φd	r	KT3100	KT3120		
	TCGX06T104-AK	6.4	3.97	1.98	2.2	0.4	▲	●		
	TCGX090202-AK	9.6	5.56	2.38	2.5	0.2	▲	●		
	TCGX090204-AK	9.6	5.56	2.38	2.5	0.4	▲	●		
	TCGX110202-AK	11	6.35	2.38	2.8	0.2	▲	●		
	TCGX110204-AK	11	6.35	2.38	2.8	0.4	▲	●		
	TCGX110208-AK	11	6.35	2.38	2.8	0.8	▲	●		
	TCGX110302-AK	11	6.35	3.18	2.26	0.2	▲	●		
	TCGX110304-AK	11	6.35	3.18	2.26	0.4	▲	●		
	TCGX110308-AK	11	6.35	3.18	2.26	0.8	▲	●		
	TCGX16T304-AK	16.5	9.525	3.97	4.4	0.4	▲	●		
	TCGX16T308-AK	16.5	9.525	3.97	4.4	0.8	▲	●		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

槽型特点 AK



适用刀具

STACR/L
KAPR:90°

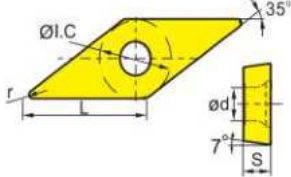


STFCR/L
KAPR:91°



STGCR/L
KAPR:91°



		√ 良好工况 Good working conditions					○ 一般工况 General working conditions		× 不稳定工况 Unstable working conditions	
		工件材料 Workpiece Material	P	钢						
		M	不锈钢							
		K	铸铁							
		N	有色金属				○	○		
		S	耐热合金、钛合金							
		H	淬硬钢							
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					无涂层			
		L	ØI.C	T	Φd	r	KT3100	KT3120		
	VCGX110202-AK	11	6.35	2.38	2.8	0.2	●	▲		
	VCGX110204-AK	11	6.35	2.38	2.8	0.4	●	▲		
	VCGX110302-AK	11	6.35	3.18	2.8	0.2	●	▲		
	VCGX110304-AK	11	6.35	3.18	2.8	0.4	●	▲		
	VCGX160404-AK	16.6	9.525	4.76	4.4	0.4	●	▲		
	VCGX160408-AK	16.6	9.525	4.76	4.4	0.8	●	▲		
	VCGX160412-AK	16.6	9.525	4.76	4.4	1.2	●	▲		
	VCGX220520-AK	22	12.7	5.56	5.5	2.0	●	▲		
	VCGX220530-AK	22	12.7	5.56	5.5	3.0	●	▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

AK 槽型特点



适用刀具



铝合金铣削 Aluminum Alloy Milling

√ 良好工况 Good working conditions		○ 一般工况 General working conditions					× 不稳定工况 Unstable working conditions	
		P	钢					
		M	不锈钢					
		K	铸铁					
		N	有色金属					○
		S	耐热合金、钛合金					
		H	淬硬钢					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					硬质合金	
		L	LE	S	BS	Re	KT3100	KT3120
	XDGX175004PDFR-GL	23.0	16.9	5.0	1.7	0.4	▲	●
	XDGX175008PDFR-GL	23.0	17.0	5.0	1.3	0.8	▲	●
	XDGX175012PDFR-GL	23.0	17.0	5.0	0.9	1.2	▲	●
	XDGX175016PDFR-GL	22.0	16.4	5.0	1.4	1.6	▲	●
	XDGX175020PDFR-GL	22.0	16.4	5.0	1.0	2.0	▲	●
	XDGX175024PDFR-GL	22.0	16.4	5.0	0.6	2.4	▲	●
	XDGX175030PDFR-GL	21.1	16.1	5.0	0.8	3.0	▲	●
	XDGX175032PDFR-GL	21.1	16.1	5.0	0.6	3.2	▲	●
	XDGX175040PDFR-GL	20.0	15.6	5.0	0.8	4.0	▲	●
	XDGX175050PDFR-GL	19.4	15.3	5.0	0.4	5.0	▲	●
	XDGX175004PDFR-GM	23.0	17.0	5.0	1.7	0.4	▲	●
	XDGX175008PDFR-GM	23.0	17.0	5.0	1.2	0.8	▲	●
	XDGX175012PDFR-GM	23.0	17.0	5.0	0.9	1.2	▲	●
	XDGX175016PDFR-GM	22.0	15.9	5.0	1.3	1.6	▲	●
	XDGX175020PDFR-GM	22.0	15.9	5.0	0.8	2.0	▲	●
	XDGX175024PDFR-GM	22.0	15.9	5.0	0.4	2.4	▲	●
	XDGX175030PDFR-GM	21.1	16.0	5.0	0.6	3.0	▲	●
	XDGX175032PDFR-GM	21.1	16.0	5.0	0.4	3.2	▲	●
	XDGX175040PDFR-GM	20.0	14.8	5.0	0.5	4.0	▲	●
	XDGX175050PDFR-GM	19.4	15.0	5.0	0.3	5.0	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料	硬度HB	刀片牌号	切削用量		
			V(m/min)	f (mm/z)	
				GL	GM
N	铝合金	Si<5%	KT3100	1000 (200-3000)	0.1(0.05-0.25)
			KT3120	1000 (200-3000)	0.1(0.05-0.25)

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

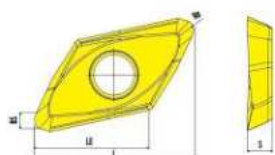
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

√ 良好工况 Good working conditions		○ 一般工况 General working conditions					× 不稳定工况 Unstable working conditions	
	工件材料 Workpiece Material	P	钢					
		M	不锈钢					
		K	铸铁					
		N	有色金属					○
		S	耐热合金、钛合金					
		H	淬硬钢					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					硬质合金	
		L	LE	S	BS	Re	KT3100	KT3120
	XDGX175004PDFR-GM	23.0	17.0	5.0	1.7	0.4	●	▲
	XDGX175008PDFR-GM	23.0	17.0	5.0	1.2	0.8	●	▲
	XDGX175012PDFR-GM	23.0	17.0	5.0	0.9	1.2	●	▲
	XDGX175016PDFR-GM	22.0	15.9	5.0	1.3	1.6	●	▲
	XDGX175020PDFR-GM	22.0	15.9	5.0	0.8	2.0	●	▲
	XDGX175024PDFR-GM	22.0	15.9	5.0	0.4	2.4	●	▲
	XDGX175030PDFR-GM	21.0	16.0	5.0	0.6	3.0	●	▲
	XDGX175032PDFR-GM	21.1	16.0	5.0	0.4	3.2	●	▲
	XDGX175040PDFR-GM	20.0	14.8	5.0	0.5	4.0	●	▲
	XDGX175050PDFR-GM	19.4	15.0	5.0	0.3	5.0	●	▲
	XDGX175004PDER-GM	23.0	17.0	5.0	1.7	0.4	●	▲
	XDGX175008PDER-GM	23.0	17.0	5.0	1.2	0.8	●	▲
	XDGX175012PDER-GM	23.0	17.0	5.0	0.9	1.2	●	▲
	XDGX175016PDER-GM	22.0	15.9	5.0	1.3	1.6	●	▲
	XDGX175020PDER-GM	22.0	15.9	5.0	0.8	2.0	●	▲
	XDGX175024PDER-GM	22.0	15.9	5.0	0.4	2.4	●	▲
	XDGX175030PDER-GM	21.0	16.0	5.0	0.6	3.0	●	▲
	XDGX175032PDER-GM	21.1	16.0	5.0	0.4	3.2	●	▲
	XDGX175040PDER-GM	20.0	14.8	5.0	0.5	4.0	●	▲
	XDGX175050PDER-GM	19.4	15.0	5.0	0.3	5.0	●	▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料	硬度HB	刀片牌号	切削用量		
			V(m/min)	f (mm/z)	
				GL	GM
N	铝合金	Si < 5%	KT3100	4000 (2000-5000)	0.1 (0.05-0.25)
			KT3120	4000 (2000-5000)	0.1 (0.05-0.25)

√ 良好工况 Good working conditions		○ 一般工况 General working conditions					× 不稳定工况 Unstable working conditions	
	工件材料 Workpiece Material	P	钢					
		M	不锈钢					
		K	铸铁					
		N	有色金属					○
		S	耐热合金、钛合金					
		H	淬硬钢					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					硬质合金	
		L	LE	S	BS	Re	KT3100	KT3120
	XDGX175004PDFR-GL	23.0	16.9	5.0	1.7	0.4	▲	●
	XDGX175008PDFR-GL	23.0	17.0	5.0	1.3	0.8	▲	●
	XDGX175012PDFR-GL	23.0	17.0	5.0	0.9	1.2	▲	●
	XDGX175016PDFR-GL	22.0	16.4	5.0	1.4	1.6	▲	●
	XDGX175020PDFR-GL	22.0	16.4	5.0	1.0	2.0	▲	●
	XDGX175024PDFR-GL	22.0	16.4	5.0	0.6	2.4	▲	●
	XDGX175030PDFR-GL	21.1	16.1	5.0	0.8	3.0	▲	●
	XDGX175032PDFR-GL	21.1	16.1	5.0	0.6	3.2	▲	●
	XDGX175040PDFR-GL	20.0	15.6	5.0	0.8	4.0	▲	●
	XDGX175050PDFR-GL	19.4	15.3	5.0	0.4	5.0	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料	硬度HB	刀片牌号	切削用量		
			V(m/min)	f (mm/z)	
				GL	GM
N	铝合金	Si<5%	KT3100	4000 (2000-5000)	0.1(0.05-0.25)
			KT3120	4000 (2000-5000)	0.1(0.05-0.25)

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

铝合金 / 铝合金铣削

Aluminum Alloy Milling

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

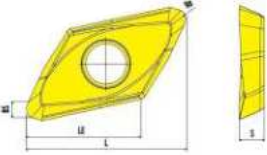
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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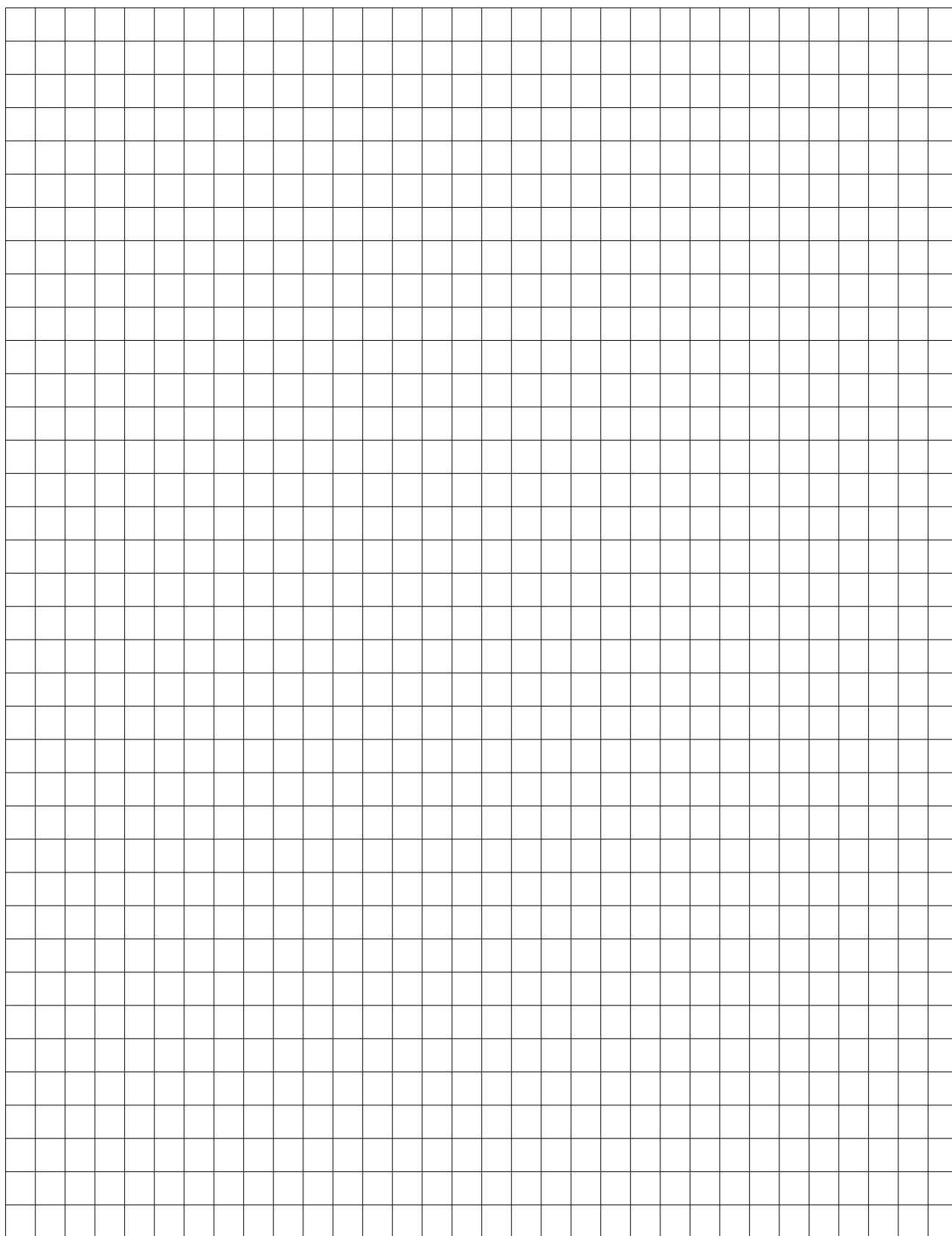
√ 良好工况 Good working conditions		○ 一般工况 General working conditions					× 不稳定工况 Unstable working conditions	
	工件材料 Workpiece Material	P	钢					
		M	不锈钢					
		K	铸铁					
		N	有色金属					○
		S	耐热合金、钛合金					
		H	淬硬钢					
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					硬质合金	
		L	LE	S	BS	Re	KT3100	KT3120
	XDGX227008PDFR-GL	30.0	21.6	7.0	2.0	0.8	▲	●
	XDGX227016PDFR-GL	30.0	21.7	7.0	1.2	1.6	▲	●
	XDGX227020PDFR-GL	30.0	21.7	7.0	0.8	2.0	▲	●
	XDGX227030PDFR-GL	28.8	21.2	7.0	0.8	3.0	▲	●
	XDGX227032PDFR-GL	28.8	21.2	7.0	0.6	3.2	▲	●
	XDGX227040PDFR-GL	27.5	20.6	7.0	0.9	4.0	▲	●
	XDGX227050PDFR-GL	27.0	20.3	7.0	0.4	5.0	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料	硬度HB	刀片牌号	切削用量		
			V(m/min)	f (mm/z)	
				GL	GM
N	铝合金	Si < 5%	KT3100	1000 (200-3000)	0.1 (0.05-0.25)
			KT3120	1000 (200-3000)	0.1 (0.05-0.25)


A
 车削刀片

B
 铣削刀片

C
 铝合金刀片

D
 孔加工刀片

E
 刮管刀片

F
 非标异形刀片

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 圆棒和立铣刀

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负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
1	CNMG090304-MB	2	0.4	4	0.2	0.1	0.3
2	CNMG090308-MB	2	0.5	4	0.3	0.15	0.5
3	CNMG120404-MB	3	0.4	5.5	0.2	0.1	0.3
4	CNMG120408-MB	3	0.5	5.5	0.3	0.15	0.5
5	CNMG120412-MB	3	0.8	5.5	0.35	0.18	0.6
6	CNMG120416-MB	3	1	5.5	0.4	0.23	0.65
7	CNMG160608-MB	4	0.5	7.2	0.3	0.15	0.5
8	CNMG160612-MB	4	0.8	7.2	0.35	0.18	0.6
9	CNMG160616-MB	4	1	7.2	0.4	0.23	0.65
10	CNMG190608-MB	4	0.5	8.6	0.3	0.15	0.5
11	CNMG190612-MB	4	0.8	8.6	0.35	0.18	0.6
12	CNMG190616-MB	4	1	8.6	0.4	0.23	0.65
13	DNMG110404-MB	2	0.4	5	0.2	0.1	0.3
14	DNMG110408-MB	2	0.5	5	0.3	0.15	0.5
15	DNMG110412-MB	2	0.8	5	0.35	0.18	0.5
16	DNMG150404-MB	3	0.4	6	0.2	0.1	0.3
17	DNMG150408-MB	3	0.5	6	0.3	0.15	0.5
18	DNMG150412-MB	3	0.8	6	0.35	0.18	0.6
19	DNMG150604-MB	3	0.4	6	0.2	0.1	0.3
20	DNMG150608-MB	3	0.5	6	0.3	0.15	0.5
21	DNMG150612-MB	3	0.8	6	0.35	0.18	0.6
22	DNMG150616-MB	3	1	6	0.4	0.23	0.65
23	SNMG090304-MB	2	0.4	4.5	0.21	0.1	0.31
24	SNMG090308-MB	2	0.5	4.5	0.31	0.16	0.52
25	SNMG120404-MB	3	0.4	6	0.21	0.1	0.31
26	SNMG120408-MB	3	0.5	6	0.31	0.16	0.52
27	SNMG120412-MB	3	0.8	6	0.36	0.19	0.62
28	SNMG120416-MB	3	1	6	0.41	0.24	0.67
29	SNMG150612-MB	4	0.8	7.5	0.36	0.19	0.62
30	SNMG150616-MB	4	1	7.5	0.41	0.24	0.67
31	TNMG160404-MB	3	0.4	5	0.2	0.1	0.3
32	TNMG160408-MB	3	0.5	5	0.3	0.15	0.5
33	TNMG160412-MB	3	0.8	5	0.35	0.18	0.6
34	TNMG220404-MB	4	0.4	6.6	0.2	0.1	0.3
35	TNMG220408-MB	4	0.5	6.6	0.3	0.15	0.5
36	TNMG220412-MB	4	0.8	6.6	0.35	0.18	0.6
37	TNMG220416-MB	4	1	6.6	0.4	0.23	0.65
38	WNMG060408-MB	2	0.5	3	0.3	0.15	0.5
39	WNMG060412-MB	2	0.8	3	0.35	0.18	0.6
40	WNMG080408-MB	2.5	0.5	4	0.3	0.15	0.5

负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
41	WNMG080412-MB	2.5	0.8	4	0.35	0.18	0.6
42	WNMG080416-MB	3	1	4	0.4	0.23	0.65
43	VNMG160408-MB	2	0.5	4	0.3	0.15	0.5
44	VNMG160412-MB	2	0.8	4	0.35	0.18	0.6
45	CNMG090304-PMB	2	0.4	4	0.2	0.1	0.3
46	CNMG090308-PMB	2	0.5	4	0.3	0.15	0.5
47	CNMG120404-PMB	3	0.4	5.5	0.2	0.1	0.3
48	CNMG120408-PMB	3	0.5	5.5	0.3	0.15	0.5
49	CNMG120412-PMB	3	0.8	5.5	0.35	0.18	0.6
50	CNMG120416-PMB	3	1	5.5	0.4	0.23	0.65
51	CNMG160608-PMB	4	0.5	7.2	0.3	0.15	0.5
52	CNMG160612-PMB	4	0.8	7.2	0.35	0.18	0.6
53	CNMG160616-PMB	4	1	7.2	0.4	0.23	0.65
54	CNMG190608-PMB	4	0.5	8.6	0.3	0.15	0.5
55	CNMG190612-PMB	4	0.8	8.6	0.35	0.18	0.6
56	CNMG190616-PMB	4	1	8.6	0.4	0.23	0.65
57	DNMG110404-PMB	2	0.4	5	0.2	0.1	0.3
58	DNMG110408-PMB	2	0.5	5	0.3	0.15	0.5
59	DNMG110412-PMB	2	0.8	5	0.35	0.18	0.5
60	DNMG150404-PMB	3	0.4	6	0.2	0.1	0.3
61	DNMG150408-PMB	3	0.5	6	0.3	0.15	0.5
62	DNMG150412-PMB	3	0.8	6	0.35	0.18	0.6
63	DNMG150604-PMB	3	0.4	6	0.2	0.1	0.3
64	DNMG150608-PMB	3	0.5	6	0.3	0.15	0.5
65	DNMG150612-PMB	3	0.8	6	0.35	0.18	0.6
66	DNMG150616-PMB	3	1	6	0.4	0.23	0.65
67	SNMG090304-PMB	2	0.4	4.5	0.21	0.1	0.31
68	SNMG090308-PMB	2	0.5	4.5	0.31	0.16	0.52
69	SNMG120404-PMB	3	0.4	6	0.21	0.1	0.31
70	SNMG120408-PMB	3	0.5	6	0.31	0.16	0.52
71	SNMG120412-PMB	3	0.8	6	0.36	0.19	0.62
72	SNMG120416-PMB	3	1	6	0.41	0.24	0.67
73	SNMG150612-PMB	4	0.8	7.5	0.36	0.19	0.62
74	SNMG150616-PMB	4	1	7.5	0.41	0.24	0.67
75	TNMG160404-PMB	3	0.4	5	0.2	0.1	0.3
76	TNMG160408-PMB	3	0.5	5	0.3	0.15	0.5
77	TNMG160412-PMB	3	0.8	5	0.35	0.18	0.6
78	TNMG220404-PMB	4	0.4	6.6	0.2	0.1	0.3
79	TNMG220408-PMB	4	0.5	6.6	0.3	0.15	0.5
80	TNMG220412-PMB	4	0.8	6.6	0.35	0.18	0.6

A 车削刀片

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负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
81	TNMG220416-PMB	4	1	6.6	0.4	0.23	0.65
82	WNMG060408-PMB	2	0.5	3	0.3	0.15	0.5
83	WNMG060412-PMB	2	0.8	3	0.35	0.18	0.6
84	WNMG080408-PMB	2.5	0.5	4	0.3	0.15	0.5
85	WNMG080412-PMB	2.5	0.8	4	0.35	0.18	0.6
86	WNMG080416-PMB	3	1	4	0.4	0.23	0.65
87	VNMG160408-PMB	2	0.5	4	0.3	0.15	0.5
88	VNMG160412-PMB	2	0.8	4	0.35	0.18	0.6
89	CNMG090304-GMR	2.4	0.48	4.8	0.24	0.12	0.36
90	CNMG090308-GMR	2.4	0.6	4.8	0.36	0.18	0.6
91	CNMG120404-GMR	3.6	0.48	6.6	0.24	0.12	0.36
92	CNMG120408-GMR	3.6	0.6	6.6	0.36	0.18	0.6
93	CNMG120412-GMR	3.6	0.96	6.6	0.42	0.216	0.72
94	CNMG120416-GMR	3.6	1.2	6.6	0.48	0.276	0.78
95	CNMG160608-GMR	4.8	0.6	8.64	0.36	0.18	0.6
96	CNMG160612-GMR	4.8	0.96	8.64	0.42	0.216	0.72
97	CNMG160616-GMR	4.8	1.2	8.64	0.48	0.276	0.78
98	CNMG190608-GMR	4.8	0.6	10.32	0.36	0.18	0.6
99	CNMG190612-GMR	4.8	0.96	10.32	0.42	0.216	0.72
100	CNMG190616-GMR	4.8	1.2	10.32	0.48	0.276	0.78
101	DNMG110404-GMR	2.4	0.48	6	0.24	0.12	0.36
102	DNMG110408-GMR	2.4	0.6	6	0.36	0.18	0.6
103	DNMG110412-GMR	2.4	0.96	6	0.42	0.216	0.6
104	DNMG150404-GMR	3.6	0.48	7.2	0.24	0.12	0.36
105	DNMG150408-GMR	3.6	0.6	7.2	0.36	0.18	0.6
106	DNMG150412-GMR	3.6	0.96	7.2	0.42	0.216	0.72
107	DNMG150604-GMR	3.6	0.48	7.2	0.24	0.12	0.36
108	DNMG150608-GMR	3.6	0.6	7.2	0.36	0.18	0.6
109	DNMG150612-GMR	3.6	0.96	7.2	0.42	0.216	0.72
110	DNMG150616-GMR	3.6	1.2	7.2	0.48	0.276	0.78
111	SNMG090304-GMR	2.4	0.48	5.4	0.252	0.12	0.372
112	SNMG090308-GMR	2.4	0.6	5.4	0.372	0.192	0.624
113	SNMG120404-GMR	3.6	0.48	7.2	0.252	0.12	0.372
114	SNMG120408-GMR	3.6	0.6	7.2	0.372	0.192	0.624
115	SNMG120412-GMR	3.6	0.96	7.2	0.432	0.228	0.744
116	SNMG120416-GMR	3.6	1.2	7.2	0.492	0.288	0.804
117	SNMG150612-GMR	4.8	0.96	9	0.432	0.228	0.744
118	SNMG150616-GMR	4.8	1.2	9	0.492	0.288	0.804
119	TNMG160404-GMR	3.6	0.48	6	0.24	0.12	0.36
120	TNMG160408-GMR	3.6	0.6	6	0.36	0.18	0.6

负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
121	TNMG160412-GMR	3.6	0.96	6	0.42	0.216	0.72
122	TNMG220404-GMR	4.8	0.48	7.92	0.24	0.12	0.36
123	TNMG220408-GMR	4.8	0.6	7.92	0.36	0.18	0.6
124	TNMG220412-GMR	4.8	0.96	7.92	0.42	0.216	0.72
125	TNMG220416-GMR	4.8	1.2	7.92	0.48	0.276	0.78
126	WNMG060408-GMR	2.4	0.6	3.6	0.36	0.18	0.6
127	WNMG060412-GMR	2.4	0.96	3.6	0.42	0.216	0.72
128	WNMG080408-GMR	3	0.6	4.8	0.36	0.18	0.6
129	WNMG080412-GMR	3	0.96	4.8	0.42	0.216	0.72
130	WNMG080416-GMR	3.6	1.2	4.8	0.48	0.276	0.78
131	VNMG160408-GMR	2.4	0.6	4.8	0.36	0.18	0.6
132	VNMG160412-GMR	2.4	0.96	4.8	0.42	0.216	0.72
133	CNMG090304-PMK	2.4	0.48	4.8	0.24	0.12	0.36
134	CNMG090308-PMK	2.4	0.6	4.8	0.36	0.18	0.6
135	CNMG120404-PMK	3.6	0.48	6.6	0.24	0.12	0.36
136	CNMG120408-PMK	3.6	0.6	6.6	0.36	0.18	0.6
137	CNMG120412-PMK	3.6	0.96	6.6	0.42	0.216	0.72
138	CNMG120416-PMK	3.6	1.2	6.6	0.48	0.276	0.78
139	CNMG160608-PMK	4.8	0.6	8.64	0.36	0.18	0.6
140	CNMG160612-PMK	4.8	0.96	8.64	0.42	0.216	0.72
141	CNMG160616-PMK	4.8	1.2	8.64	0.48	0.276	0.78
142	CNMG190608-PMK	4.8	0.6	10.32	0.36	0.18	0.6
143	CNMG190612-PMK	4.8	0.96	10.32	0.42	0.216	0.72
144	CNMG190616-PMK	4.8	1.2	10.32	0.48	0.276	0.78
145	DNMG110404-PMK	2.4	0.48	6	0.24	0.12	0.36
146	DNMG110408-PMK	2.4	0.6	6	0.36	0.18	0.6
147	DNMG110412-PMK	2.4	0.96	6	0.42	0.216	0.6
148	DNMG150404-PMK	3.6	0.48	7.2	0.24	0.12	0.36
149	DNMG150408-PMK	3.6	0.6	7.2	0.36	0.18	0.6
150	DNMG150412-PMK	3.6	0.96	7.2	0.42	0.216	0.72
151	DNMG150604-PMK	3.6	0.48	7.2	0.24	0.12	0.36
152	DNMG150608-PMK	3.6	0.6	7.2	0.36	0.18	0.6
153	DNMG150612-PMK	3.6	0.96	7.2	0.42	0.216	0.72
154	DNMG150616-PMK	3.6	1.2	7.2	0.48	0.276	0.78
155	SNMG090304-PMK	2.4	0.48	5.4	0.252	0.12	0.372
156	SNMG090308-PMK	2.4	0.6	5.4	0.372	0.192	0.624
157	SNMG120404-PMK	3.6	0.48	7.2	0.252	0.12	0.372
158	SNMG120408-PMK	3.6	0.6	7.2	0.372	0.192	0.624
159	SNMG120412-PMK	3.6	0.96	7.2	0.432	0.228	0.744
160	SNMG120416-PMK	3.6	1.2	7.2	0.492	0.288	0.804

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序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
161	SNMG150612-PMK	4.8	0.96	9	0.432	0.228	0.744
162	SNMG150616-PMK	4.8	1.2	9	0.492	0.288	0.804
163	TNMG160404-PMK	3.6	0.48	6	0.24	0.12	0.36
164	TNMG160408-PMK	3.6	0.6	6	0.36	0.18	0.6
165	TNMG160412-PMK	3.6	0.96	6	0.42	0.216	0.72
166	TNMG220404-PMK	4.8	0.48	7.92	0.24	0.12	0.36
167	TNMG220408-PMK	4.8	0.6	7.92	0.36	0.18	0.6
168	TNMG220412-PMK	4.8	0.96	7.92	0.42	0.216	0.72
169	TNMG220416-PMK	4.8	1.2	7.92	0.48	0.276	0.78
170	WNMG060408-PMK	2.4	0.6	3.6	0.36	0.18	0.6
171	WNMG060412-PMK	2.4	0.96	3.6	0.42	0.216	0.72
172	WNMG080408-PMK	3	0.6	4.8	0.36	0.18	0.6
173	WNMG080412-PMK	3	0.96	4.8	0.42	0.216	0.72
174	WNMG080416-PMK	3.6	1.2	4.8	0.48	0.276	0.78
175	VNMG160408-PMK	2.4	0.6	4.8	0.36	0.18	0.6
176	VNMG160412-PMK	2.4	0.96	4.8	0.42	0.216	0.72
177	CNMG090304-PR	2.4	0.48	4.8	0.24	0.12	0.36
178	CNMG090308-PR	2.4	0.6	4.8	0.36	0.18	0.6
179	CNMG120404-PR	3.6	0.48	6.6	0.24	0.12	0.36
180	CNMG120408-PR	3.6	0.6	6.6	0.36	0.18	0.6
181	CNMG120412-PR	3.6	0.96	6.6	0.42	0.216	0.72
182	CNMG120416-PR	3.6	1.2	6.6	0.48	0.276	0.78
183	CNMG160608-PR	4.8	0.6	8.64	0.36	0.18	0.6
184	CNMG160612-PR	4.8	0.96	8.64	0.42	0.216	0.72
185	CNMG160616-PR	4.8	1.2	8.64	0.48	0.276	0.78
186	CNMG190608-PR	4.8	0.6	10.32	0.36	0.18	0.6
187	CNMG190612-PR	4.8	0.96	10.32	0.42	0.216	0.72
188	CNMG190616-PR	4.8	1.2	10.32	0.48	0.276	0.78
189	DNMG110404-PR	2.4	0.48	6	0.24	0.12	0.36
190	DNMG110408-PR	2.4	0.6	6	0.36	0.18	0.6
191	DNMG110412-PR	2.4	0.96	6	0.42	0.216	0.6
192	DNMG150404-PR	3.6	0.48	7.2	0.24	0.12	0.36
193	DNMG150408-PR	3.6	0.6	7.2	0.36	0.18	0.6
194	DNMG150412-PR	3.6	0.96	7.2	0.42	0.216	0.72
195	DNMG150604-PR	3.6	0.48	7.2	0.24	0.12	0.36
196	DNMG150608-PR	3.6	0.6	7.2	0.36	0.18	0.6
197	DNMG150612-PR	3.6	0.96	7.2	0.42	0.216	0.72
198	DNMG150616-PR	3.6	1.2	7.2	0.48	0.276	0.78
199	SNMG090304-PR	2.4	0.48	5.4	0.252	0.12	0.372
200	SNMG090308-PR	2.4	0.6	5.4	0.372	0.192	0.624

负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
201	SNMG120404-PR	3.6	0.48	7.2	0.252	0.12	0.372
202	SNMG120408-PR	3.6	0.6	7.2	0.372	0.192	0.624
203	SNMG120412-PR	3.6	0.96	7.2	0.432	0.228	0.744
204	SNMG120416-PR	3.6	1.2	7.2	0.492	0.288	0.804
205	SNMG150612-PR	4.8	0.96	9	0.432	0.228	0.744
206	SNMG150616-PR	4.8	1.2	9	0.492	0.288	0.804
207	TNMG160404-PR	3.6	0.48	6	0.24	0.12	0.36
208	TNMG160408-PR	3.6	0.6	6	0.36	0.18	0.6
209	TNMG160412-PR	3.6	0.96	6	0.42	0.216	0.72
210	TNMG220404-PR	4.8	0.48	7.92	0.24	0.12	0.36
211	TNMG220408-PR	4.8	0.6	7.92	0.36	0.18	0.6
212	TNMG220412-PR	4.8	0.96	7.92	0.42	0.216	0.72
213	TNMG220416-PR	4.8	1.2	7.92	0.48	0.276	0.78
214	WNMG060408-PR	2.4	0.6	3.6	0.36	0.18	0.6
215	WNMG060412-PR	2.4	0.96	3.6	0.42	0.216	0.72
216	WNMG080408-PR	3	0.6	4.8	0.36	0.18	0.6
217	WNMG080412-PR	3	0.96	4.8	0.42	0.216	0.72
218	WNMG080416-PR	3.6	1.2	4.8	0.48	0.276	0.78
219	VNMG160408-PR	2.4	0.6	4.8	0.36	0.18	0.6
220	VNMG160412-PR	2.4	0.96	4.8	0.42	0.216	0.72
221	CNMG090304-GD	1.6	0.32	3.2	0.16	0.08	0.24
222	CNMG090308-GD	1.6	0.4	3.2	0.24	0.12	0.4
223	CNMG120404-GD	2.4	0.32	4.4	0.16	0.08	0.24
224	CNMG120408-GD	2.4	0.4	4.4	0.24	0.12	0.4
225	CNMG120412-GD	2.4	0.64	4.4	0.28	0.144	0.48
226	CNMG120416-GD	2.4	0.8	4.4	0.32	0.184	0.52
227	CNMG160608-GD	3.2	0.4	5.76	0.24	0.12	0.4
228	CNMG160612-GD	3.2	0.64	5.76	0.28	0.144	0.48
229	CNMG160616-GD	3.2	0.8	5.76	0.32	0.184	0.52
230	CNMG190608-GD	3.2	0.4	6.88	0.24	0.12	0.4
231	CNMG190612-GD	3.2	0.64	6.88	0.28	0.144	0.48
232	CNMG190616-GD	3.2	0.8	6.88	0.32	0.184	0.52
233	DNMG110404-GD	1.6	0.32	4	0.16	0.08	0.24
234	DNMG110408-GD	1.6	0.4	4	0.24	0.12	0.4
235	DNMG110412-GD	1.6	0.64	4	0.28	0.144	0.4
236	DNMG150404-GD	2.4	0.32	4.8	0.16	0.08	0.24
237	DNMG150408-GD	2.4	0.4	4.8	0.24	0.12	0.4
238	DNMG150412-GD	2.4	0.64	4.8	0.28	0.144	0.48
239	DNMG150604-GD	2.4	0.32	4.8	0.16	0.08	0.24
240	DNMG150608-GD	2.4	0.4	4.8	0.24	0.12	0.4

A 车削刀片

B 铣削刀片

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负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
241	DNMG150612-GD	2.4	0.64	4.8	0.28	0.144	0.48
242	DNMG150616-GD	2.4	0.8	4.8	0.32	0.184	0.52
243	SNMG090304-GD	1.6	0.32	3.6	0.168	0.08	0.248
244	SNMG090308-GD	1.6	0.4	3.6	0.248	0.128	0.416
245	SNMG120404-GD	2.4	0.32	4.8	0.168	0.08	0.248
246	SNMG120408-GD	2.4	0.4	4.8	0.248	0.128	0.416
247	SNMG120412-GD	2.4	0.64	4.8	0.288	0.152	0.496
248	SNMG120416-GD	2.4	0.8	4.8	0.328	0.192	0.536
249	SNMG150612-GD	3.2	0.64	6	0.288	0.152	0.496
250	SNMG150616-GD	3.2	0.8	6	0.328	0.192	0.536
251	TNMG160404-GD	2.4	0.32	4	0.16	0.08	0.24
252	TNMG160408-GD	2.4	0.4	4	0.24	0.12	0.4
253	TNMG160412-GD	2.4	0.64	4	0.28	0.144	0.48
254	TNMG220404-GD	3.2	0.32	5.28	0.16	0.08	0.24
255	TNMG220408-GD	3.2	0.4	5.28	0.24	0.12	0.4
256	TNMG220412-GD	3.2	0.64	5.28	0.28	0.144	0.48
257	TNMG220416-GD	3.2	0.8	5.28	0.32	0.184	0.52
258	WNMG060408-GD	1.6	0.4	2.4	0.24	0.12	0.4
259	WNMG060412-GD	1.6	0.64	2.4	0.28	0.144	0.48
260	WNMG080408-GD	2	0.4	3.2	0.24	0.12	0.4
261	WNMG080412-GD	2	0.64	3.2	0.28	0.144	0.48
262	WNMG080416-GD	2.4	0.8	3.2	0.32	0.184	0.52
263	VNMG160408-GD	1.6	0.4	3.2	0.24	0.12	0.4
264	VNMG160412-GD	1.6	0.64	3.2	0.28	0.144	0.48
265	CNMG090304-GF	0.4	0.25	1.5	0.15	0.07	0.3
266	CNMG090308-GF	0.4	0.3	1.5	0.15	0.1	0.3
267	CNMG120404-GF	0.4	0.25	1.5	0.15	0.07	0.3
268	CNMG120408-GF	0.4	0.3	1.5	0.2	0.1	0.4
269	CNMG120412-GF	0.8	0.35	1.5	0.25	0.15	0.5
270	DNMG110404-GF	0.4	0.25	1.5	0.15	0.07	0.3
271	DNMG110408-GF	0.4	0.3	1.5	0.2	0.1	0.4
272	DNMG110412-GF	0.8	0.35	1.5	0.25	0.15	0.5
273	DNMG150408-GF	0.4	0.3	1.5	0.2	0.1	0.4
274	DNMG150412-GF	0.8	0.35	1.5	0.25	0.15	0.5
275	DNMG150604-GF	0.4	0.25	1.5	0.15	0.07	0.3
276	DNMG150608-GF	0.4	0.3	1.5	0.2	0.1	0.4
277	DNMG150612-GF	0.8	0.35	1.5	0.25	0.15	0.5
278	SNMG120408-GF	0.4	0.3	1.5	0.21	0.1	0.41
279	SNMG120412-GF	0.8	0.35	1.5	0.26	0.16	0.52
280	TNMG160404-GF	0.4	0.25	1.5	0.15	0.07	0.3

负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
281	TNMG160408-GF	0.4	0.3	1.5	0.2	0.1	0.4
282	TNMG160412-GF	0.8	0.35	1.5	0.25	0.15	0.5
283	TNMG220408-GF	0.4	0.3	1.5	0.2	0.1	0.4
284	TNMG220412-GF	0.8	0.35	1.5	0.25	0.15	0.5
285	WNMG060404-GF	0.4	0.25	1.5	0.15	0.07	0.3
286	WNMG060408-GF	0.4	0.3	1.5	0.2	0.1	0.4
287	WNMG060412-GF	0.8	0.4	1.5	0.25	0.15	0.5
288	WNMG080404-GF	0.4	0.25	1.5	0.15	0.07	0.3
289	WNMG080408-GF	0.4	0.3	1.5	0.2	0.1	0.4
290	WNMG080412-GF	0.8	0.4	1.5	0.25	0.15	0.5
291	VNMG160404-GF	0.4	0.25	1.5	0.15	0.07	0.3
292	VNMG160408-GF	0.4	0.3	1.5	0.2	0.1	0.4
293	CNMG090304-MP	1.5	0.15	4	0.25	0.1	0.4
294	CNMG090308-MP	2	0.5	4	0.25	0.1	0.4
295	CNMG120408-MP	3	0.5	5.7	0.25	0.1	0.45
296	CNMG120412-MP	3	0.5	5.7	0.3	0.1	0.6
297	CNMG160608-MP	4	0.5	7.2	0.25	0.1	0.45
298	CNMG160612-MP	4	0.5	7.2	0.3	0.1	0.6
299	CNMG160616-MP	4	0.5	7.2	0.37	0.1	0.65
300	CNMG190608-MP	4	0.5	8.5	0.25	0.1	0.45
301	CNMG190612-MP	4	0.5	8.5	0.3	0.1	0.6
302	CNMG190616-MP	4	0.5	8.5	0.37	0.1	0.65
303	DNMG110408-MP	2	0.5	4.4	0.25	0.1	0.45
304	DNMG110412-MP	2	0.5	4.4	0.3	0.1	0.6
305	DNMG150608-MP	3	0.5	6.4	0.25	0.1	0.45
306	DNMG150612-MP	3	0.5	6.4	0.3	0.1	0.6
307	SNMG120408-MP	3	0.5	6.35	0.26	0.1	0.47
308	SNMG120412-MP	3	0.5	6.35	0.31	0.1	0.62
309	SNMG120416-MP	3	0.5	6.35	0.38	0.1	0.67
310	SNMG150612-MP	4	0.5	8	0.31	0.1	0.62
311	SNMG150616-MP	4	0.5	8	0.38	0.1	0.67
312	SNMG190612-MP	4	0.5	9.5	0.31	0.1	0.62
313	SNMG190616-MP	4	0.5	9.5	0.38	0.1	0.67
314	TNMG160408-MP	3	0.5	4.8	0.25	0.1	0.45
315	TNMG160412-MP	3	0.5	4.8	0.3	0.1	0.6
316	TNMG220412-MP	4	0.5	6.6	0.3	0.1	0.6
317	TNMG220416-MP	4	0.5	6.6	0.37	0.1	0.65
318	WNMG060408-MP	2	0.5	3	0.25	0.1	0.45
319	WNMG060412-MP	2	0.5	3	0.3	0.1	0.6
320	WNMG080408-MP	2.5	0.5	4	0.25	0.1	0.45

A 车削刀片

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负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
321	WNMG080412-MP	2.5	0.5	4	0.3	0.1	0.6
322	VNMG160408-MP	2	0.5	4	0.25	0.1	0.45
323	CNMG090304-MM-B	1.5	0.15	4	0.25	0.1	0.4
324	CNMG090308-MM-B	2	0.5	4	0.25	0.1	0.4
325	CNMG120408-MM-B	3	0.5	5.7	0.25	0.1	0.45
326	CNMG120412-MM-B	3	0.5	5.7	0.3	0.1	0.6
327	CNMG160608-MM-B	4	0.5	7.2	0.25	0.1	0.45
328	CNMG160612-MM-B	4	0.5	7.2	0.3	0.1	0.6
329	CNMG160616-MM-B	4	0.5	7.2	0.37	0.1	0.65
330	CNMG190608-MM-B	4	0.5	8.5	0.25	0.1	0.45
331	CNMG190612-MM-B	4	0.5	8.5	0.3	0.1	0.6
332	CNMG190616-MM-B	4	0.5	8.5	0.37	0.1	0.65
333	DNMG110408-MM-B	2	0.5	4.4	0.25	0.1	0.45
334	DNMG110412-MM-B	2	0.5	4.4	0.3	0.1	0.6
335	DNMG150608-MM-B	3	0.5	6.4	0.25	0.1	0.45
336	DNMG150612-MM-B	3	0.5	6.4	0.3	0.1	0.6
337	SNMG120408-MM-B	3	0.5	6.35	0.26	0.1	0.47
338	SNMG120412-MM-B	3	0.5	6.35	0.31	0.1	0.62
339	SNMG120416-MM-B	3	0.5	6.35	0.38	0.1	0.67
340	SNMG150612-MM-B	4	0.5	8	0.31	0.1	0.62
341	SNMG150616-MM-B	4	0.5	8	0.38	0.1	0.67
342	SNMG190612-MM-B	4	0.5	9.5	0.31	0.1	0.62
343	SNMG190616-MM-B	4	0.5	9.5	0.38	0.1	0.67
344	TNMG160408-MM-B	3	0.5	4.8	0.25	0.1	0.45
345	TNMG160412-MM-B	3	0.5	4.8	0.3	0.1	0.6
346	TNMG220412-MM-B	4	0.5	6.6	0.3	0.1	0.6
347	TNMG220416-MM-B	4	0.5	6.6	0.37	0.1	0.65
348	WNMG060408-MM-B	2	0.5	3	0.25	0.1	0.45
349	WNMG060412-MM-B	2	0.5	3	0.3	0.1	0.6
350	WNMG080408-MM-B	2.5	0.5	4	0.25	0.1	0.45
351	WNMG080412-MM-B	2.5	0.5	4	0.3	0.1	0.6
352	VNMG160408-MM-B	2	0.5	4	0.25	0.1	0.45
353	CNMG090304-MJ	0.4	0.1	1.5	0.15	0.05	0.25
354	CNMG090308-MJ	0.4	0.1	1.5	0.2	0.1	0.35
355	CNMG120404-MJ	0.4	0.1	1.5	0.15	0.05	0.3
356	CNMG120408-MJ	0.4	0.1	1.5	0.2	0.1	0.4
357	CNMG120412-MJ	0.8	0.2	2.5	0.25	0.15	0.5
358	DNMG110404-MJ	0.4	0.1	1.5	0.15	0.05	0.3
359	DNMG110408-MJ	0.4	0.1	1.5	0.2	0.1	0.4
360	DNMG150404-MJ	0.4	0.1	1.5	0.15	0.05	0.3

负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
361	DNMG150408-MJ	0.4	0.1	1.5	0.2	0.1	0.4
362	DNMG150412-MJ	0.8	0.2	1.5	0.25	0.15	0.5
363	DNMG150604-MJ	0.4	0.1	1.5	0.15	0.05	0.3
364	DNMG150608-MJ	0.4	0.1	1.5	0.2	0.1	0.4
365	DNMG150612-MJ	0.8	0.2	1.5	0.25	0.15	0.5
366	SNMG120404-MJ	0.4	0.1	1.5	0.16	0.05	0.31
367	SNMG120408-MJ	0.4	0.1	1.5	0.21	0.1	0.41
368	TNMG160404-MJ	0.4	0.1	1.5	0.15	0.05	0.3
369	TNMG160408-MJ	0.4	0.1	1.5	0.2	0.1	0.4
370	WNMG060404-MJ	0.4	0.1	1.5	0.15	0.05	0.3
371	WNMG060408-MJ	0.4	0.1	1.5	0.2	0.1	0.4
372	WNMG080404-MJ	0.4	0.1	1.5	0.15	0.05	0.3
373	WNMG080408-MJ	0.4	0.1	4	0.2	0.1	0.4
374	VNMG160404-MJ	0.4	0.1	4	0.15	0.05	0.3
375	VNMG160408-MJ	0.8	0.2	5.7	0.15	0.08	0.3
376	CNMG120408-ZR	3.5	0.38	5.7	0.38	0.19	0.53
377	CNMG120412-ZR	3.5	0.5	7.2	0.5	0.25	0.7
378	CNMG120416-ZR	3.5	0.75	7.2	0.61	0.28	0.85
379	CNMG160612-ZR	4.7	0.8	7.2	0.55	0.28	0.77
380	CNMG160616-ZR	4.7	1	8.5	0.61	0.3	0.85
381	CNMG190612-ZR	7	1	8.5	0.55	0.28	0.77
382	CNMG190616-ZR	7	1.5	8.5	0.61	0.3	0.85
383	DNMG150408-ZR	3.5	0.38	4.4	0.34	0.17	0.47
384	DNMG150412-ZR	3.5	0.5	4.4	0.45	0.23	0.63
385	DNMG150608-ZR	3.5	0.38	6.4	0.34	0.17	0.47
386	DNMG150612-ZR	3.5	0.5	6.4	0.45	0.23	0.63
387	DNMG150616-ZR	3.5	0.75	6.35	0.5	0.25	0.69
388	SNMG120408-ZR	3.5	0.38	6.35	0.39	0.2	0.55
389	SNMG120412-ZR	3.5	0.5	6.35	0.52	0.29	0.72
390	SNMG120416-ZR	3.5	0.75	8	0.57	0.29	0.8
391	SNMG150612-ZR	4.4	0.63	8	0.57	0.29	0.8
392	SNMG150616-ZR	4.4	0.94	9.5	0.63	0.31	0.88
393	SNMG190616-ZR	6.1	1.31	9.5	0.63	0.31	0.88
394	TNMG160408-ZR	3.2	0.34	4.8	0.3	0.17	0.42
395	TNMG160412-ZR	3.2	0.45	4.8	0.4	0.2	0.56
396	TNMG160416-ZR	3.2	0.68	6.6	0.44	0.22	0.62
397	TNMG220408-ZR	3.5	0.38	6.6	0.38	0.19	0.53
398	TNMG220412-ZR	3.5	0.5	3	0.5	0.25	0.7
399	WNMG060408-ZR	2.2	0.24	3	0.3	0.17	0.42
400	WNMG060412-ZR	2.2	0.32	4	0.4	0.2	0.56

A 车削刀片

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负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
401	WNMG080408-ZR	2.7	0.29	5.5	0.34	0.17	0.47
402	WNMG080412-ZR	2.7	0.39	5.5	0.45	0.23	0.63
403	CNMG120408-GH	3.5	0.38	7	0.38	0.19	0.53
404	CNMG120412-GH	3.5	0.5	7	0.5	0.25	0.7
405	CNMG120416-GH	3.5	0.75	7	0.61	0.28	0.85
406	CNMG160612-GH	4.7	0.8	9.3	0.55	0.28	0.77
407	CNMG160616-GH	4.7	1	9.3	0.61	0.3	0.85
408	CNMG190612-GH	7	1	14	0.55	0.28	0.77
409	CNMG190616-GH	7	1.5	14	0.61	0.3	0.85
410	DNMG150408-GH	3.5	0.38	7	0.34	0.17	0.47
411	DNMG150412-GH	3.5	0.5	7	0.45	0.23	0.63
412	DNMG150608-GH	3.5	0.38	7	0.34	0.17	0.47
413	DNMG150612-GH	3.5	0.5	7	0.45	0.23	0.63
414	DNMG150616-GH	3.5	0.75	7	0.5	0.25	0.69
415	SNMG120408-GH	3.5	0.38	7	0.39	0.2	0.55
416	SNMG120412-GH	3.5	0.5	7	0.52	0.29	0.72
417	SNMG120416-GH	3.5	0.75	7	0.57	0.29	0.8
418	SNMG150612-GH	4.4	0.63	8.8	0.57	0.29	0.8
419	SNMG150616-GH	4.4	0.94	8.8	0.63	0.31	0.88
420	SNMG190616-GH	6.1	1.31	12.3	0.63	0.31	0.88
421	TNMG160408-GH	3.2	0.34	6.2	0.3	0.17	0.42
422	TNMG160412-GH	3.2	0.45	6.3	0.4	0.2	0.56
423	TNMG160416-GH	3.2	0.68	6.2	0.44	0.22	0.62
424	TNMG220408-GH	3.5	0.38	7	0.38	0.19	0.53
425	TNMG220412-GH	3.5	0.5	7	0.5	0.25	0.7
426	WNMG060408-GH	2.2	0.24	4.5	0.3	0.17	0.42
427	WNMG060412-GH	2.2	0.32	4.5	0.4	0.2	0.56
428	WNMG080408-GH	2.7	0.29	5.5	0.34	0.17	0.47
429	WNMG080412-GH	2.7	0.39	5.5	0.45	0.23	0.63
430	CNMG120408-ZD	5.25	0.57	10.5	0.57	0.285	0.795
431	CNMG120412-ZD	5.25	0.75	10.5	0.75	0.375	1.05
432	CNMG120416-ZD	5.25	1.125	10.5	0.915	0.42	1.275
433	CNMG160612-ZD	7.05	1.2	13.95	0.825	0.42	1.155
434	CNMG160616-ZD	7.05	1.5	13.95	0.915	0.45	1.275
435	CNMG190612-ZD	10.5	1.5	21	0.825	0.42	1.155
436	CNMG190616-ZD	10.5	2.25	21	0.915	0.45	1.275
437	DNMG150408-ZD	5.25	0.57	10.5	0.51	0.255	0.705
438	DNMG150412-ZD	5.25	0.75	10.5	0.675	0.345	0.945
439	DNMG150608-ZD	5.25	0.57	10.5	0.51	0.255	0.705
440	DNMG150612-ZD	5.25	0.75	10.5	0.675	0.345	0.945

负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
441	DNMG150616-ZD	5.25	1.125	10.5	0.75	0.375	1.035
442	SNMG120408-ZD	5.25	0.57	10.5	0.585	0.3	0.825
443	SNMG120412-ZD	5.25	0.75	10.5	0.78	0.435	1.08
444	SNMG120416-ZD	5.25	1.125	10.5	0.855	0.435	1.2
445	SNMG150612-ZD	6.6	0.945	13.2	0.855	0.435	1.2
446	SNMG150616-ZD	6.6	1.41	13.2	0.945	0.465	1.32
447	SNMG190616-ZD	9.15	1.965	18.45	0.945	0.465	1.32
448	TNMG160408-ZD	4.8	0.51	9.3	0.45	0.255	0.63
449	TNMG160412-ZD	4.8	0.675	9.45	0.6	0.3	0.84
450	TNMG160416-ZD	4.8	1.02	9.3	0.66	0.33	0.93
451	TNMG220408-ZD	5.25	0.57	10.5	0.57	0.285	0.795
452	TNMG220412-ZD	5.25	0.75	10.5	0.75	0.375	1.05
453	WNMG060408-ZD	3.3	0.36	6.75	0.45	0.255	0.63
454	WNMG060412-ZD	3.3	0.48	6.75	0.6	0.3	0.84
455	WNMG080408-ZD	4.05	0.435	8.25	0.51	0.255	0.705
456	WNMG080412-ZD	4.05	0.585	8.25	0.675	0.345	0.945
457	CNMA120408	5.25	0.57	10.5	0.57	0.285	0.795
458	CNMA120412	5.25	0.75	10.5	0.75	0.375	1.05
459	CNMA120416	5.25	1.125	10.5	0.915	0.42	1.275
460	CNMA160612	7.05	1.2	13.95	0.825	0.42	1.155
461	CNMA160616	7.05	1.5	13.95	0.915	0.45	1.275
462	CNMA190612	10.5	1.5	21	0.825	0.42	1.155
463	CNMA190616	10.5	2.25	21	0.915	0.45	1.275
464	DNMA150408	5.25	0.57	10.5	0.51	0.255	0.705
465	DNMA150412	5.25	0.75	10.5	0.675	0.345	0.945
466	DNMA150608	5.25	0.57	10.5	0.51	0.255	0.705
467	DNMA150612	5.25	0.75	10.5	0.675	0.345	0.945
468	DNMA150616	5.25	1.125	10.5	0.75	0.375	1.035
469	SNMA120408	5.25	0.57	10.5	0.585	0.3	0.825
470	SNMA120412	5.25	0.75	10.5	0.78	0.435	1.08
471	SNMA120416	5.25	1.125	10.5	0.855	0.435	1.2
472	SNMA150612	6.6	0.945	13.2	0.855	0.435	1.2
473	SNMA150616	6.6	1.41	13.2	0.945	0.465	1.32
474	SNMA190616	9.15	1.965	18.45	0.945	0.465	1.32
475	TNMA160408	4.8	0.51	9.3	0.45	0.255	0.63
476	TNMA160412	4.8	0.675	9.45	0.6	0.3	0.84
477	TNMA160416	4.8	1.02	9.3	0.66	0.33	0.93
478	TNMA220408	5.25	0.57	10.5	0.57	0.285	0.795
479	TNMA220412	5.25	0.75	10.5	0.75	0.375	1.05
480	WNMA060408	3.3	0.36	6.75	0.45	0.255	0.63

A 车削刀片

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G 圆棒和立铣刀

H 刀杆和刀盘

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负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
481	WNMA060412	3.3	0.48	6.75	0.6	0.3	0.84
482	WNMA080408	4.05	0.435	8.25	0.51	0.255	0.705
483	WNMA080412	4.05	0.585	8.25	0.675	0.345	0.945
484	CNMG090304-MF	0.4	0.1	1.5	0.15	0.05	0.25
485	CNMG090308-MF	0.4	0.1	1.5	0.2	0.1	0.35
486	CNMG120404-MF	0.4	0.1	1.5	0.15	0.05	0.3
487	CNMG120408-MF	0.4	0.1	1.5	0.2	0.1	0.4
488	CNMG120412-MF	0.8	0.2	2.5	0.25	0.15	0.5
489	DNMG110404-MF	0.4	0.1	1.5	0.15	0.05	0.3
490	DNMG110408-MF	0.4	0.1	1.5	0.2	0.1	0.4
491	DNMG150404-MF	0.4	0.1	1.5	0.15	0.05	0.3
492	DNMG150408-MF	0.4	0.1	1.5	0.2	0.1	0.4
493	DNMG150412-MF	0.8	0.2	2.5	0.25	0.15	0.5
494	DNMG150604-MF	0.4	0.1	1.5	0.15	0.05	0.3
495	DNMG150608-MF	0.4	0.1	1.5	0.2	0.1	0.4
496	DNMG150612-MF	0.8	0.2	2.5	0.25	0.15	0.5
497	SNMG120404-MF	0.4	0.1	1.5	0.16	0.05	0.31
498	SNMG120408-MF	0.4	0.1	1.5	0.21	0.1	0.41
499	TNMG160404-MF	0.4	0.1	1.5	0.15	0.05	0.3
500	TNMG160408-MF	0.4	0.1	1.5	0.2	0.1	0.4
501	WNMG060404-MF	0.4	0.1	1.5	0.15	0.05	0.3
502	WNMG060408-MF	0.4	0.1	1.5	0.2	0.1	0.4
503	WNMG080404-MF	0.4	0.1	1.5	0.15	0.05	0.3
504	WNMG080408-MF	0.4	0.1	1.5	0.2	0.1	0.4
505	VNMG160404-MF	0.4	0.1	1.5	0.15	0.05	0.3
506	VNMG160408-MF	0.8	0.2	2.5	0.15	0.08	0.3
507	CNMG090304-CF	0.4	0.1	1.5	0.15	0.05	0.25
508	CNMG090308-CF	0.4	0.1	1.5	0.2	0.1	0.35
509	CNMG120404-CF	0.4	0.1	1.5	0.15	0.05	0.3
510	CNMG120408-CF	0.4	0.1	1.5	0.2	0.1	0.4
511	CNMG120412-CF	0.8	0.2	2.5	0.25	0.15	0.5
512	DNMG110404-CF	0.4	0.1	1.5	0.15	0.05	0.3
513	DNMG110408-CF	0.4	0.1	1.5	0.2	0.1	0.4
514	DNMG150404-CF	0.4	0.1	1.5	0.15	0.05	0.3
515	DNMG150408-CF	0.4	0.1	1.5	0.2	0.1	0.4
516	DNMG150412-CF	0.8	0.2	2.5	0.25	0.15	0.5
517	DNMG150604-CF	0.4	0.1	1.5	0.15	0.05	0.3
518	DNMG150608-CF	0.4	0.1	1.5	0.2	0.1	0.4
519	DNMG150612-CF	0.8	0.2	2.5	0.25	0.15	0.5
520	SNMG120404-CF	0.4	0.1	1.5	0.16	0.05	0.31

负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
521	SNMG120408-CF	0.4	0.1	1.5	0.21	0.1	0.41
522	TNMG160404-CF	0.4	0.1	1.5	0.15	0.05	0.3
523	TNMG160408-CF	0.4	0.1	1.5	0.2	0.1	0.4
524	WNMG060404-CF	0.4	0.1	1.5	0.15	0.05	0.3
525	WNMG060408-CF	0.4	0.1	1.5	0.2	0.1	0.4
526	WNMG080404-CF	0.4	0.1	1.5	0.15	0.05	0.3
527	WNMG080408-CF	0.4	0.1	1.5	0.2	0.1	0.4
528	VNMG160404-CF	0.4	0.1	1.5	0.15	0.05	0.3
529	VNMG160408-CF	0.8	0.2	2.5	0.15	0.08	0.3
530	CNMG090304-CM	0.48	0.12	1.8	0.18	0.06	0.3
531	CNMG090308-CM	0.48	0.12	1.8	0.24	0.12	0.42
532	CNMG120404-CM	0.48	0.12	1.8	0.18	0.06	0.36
533	CNMG120408-CM	0.48	0.12	1.8	0.24	0.12	0.48
534	CNMG120412-CM	0.96	0.24	3	0.3	0.18	0.6
535	DNMG110404-CM	0.48	0.12	1.8	0.18	0.06	0.36
536	DNMG110408-CM	0.48	0.12	1.8	0.24	0.12	0.48
537	DNMG150404-CM	0.48	0.12	1.8	0.18	0.06	0.36
538	DNMG150408-CM	0.48	0.12	1.8	0.24	0.12	0.48
539	DNMG150412-CM	0.96	0.24	3	0.3	0.18	0.6
540	DNMG150604-CM	0.48	0.12	1.8	0.18	0.06	0.36
541	DNMG150608-CM	0.48	0.12	1.8	0.24	0.12	0.48
542	DNMG150612-CM	0.96	0.24	3	0.3	0.18	0.6
543	SNMG120404-CM	0.48	0.12	1.8	0.192	0.06	0.372
544	SNMG120408-CM	0.48	0.12	1.8	0.252	0.12	0.492
545	TNMG160404-CM	0.48	0.12	1.8	0.18	0.06	0.36
546	TNMG160408-CM	0.48	0.12	1.8	0.24	0.12	0.48
547	WNMG060404-CM	0.48	0.12	1.8	0.18	0.06	0.36
548	WNMG060408-CM	0.48	0.12	1.8	0.24	0.12	0.48
549	WNMG080404-CM	0.48	0.12	1.8	0.18	0.06	0.36
550	WNMG080408-CM	0.48	0.12	1.8	0.24	0.12	0.48
551	VNMG160404-CM	0.48	0.12	1.8	0.18	0.06	0.36
552	VNMG160408-CM	0.96	0.24	3	0.18	0.096	0.36
553	CNMG090304-TFA	0.32	0.08	1.2	0.12	0.04	0.2
554	CNMG090308-TFA	0.32	0.08	1.2	0.16	0.08	0.28
555	CNMG120404-TFA	0.32	0.08	1.2	0.12	0.04	0.24
556	CNMG120408-TFA	0.32	0.08	1.2	0.16	0.08	0.32
557	CNMG120412-TFA	0.64	0.16	2	0.2	0.12	0.4
558	DNMG110404-TFA	0.32	0.08	1.2	0.12	0.04	0.24
559	DNMG110408-TFA	0.32	0.08	1.2	0.16	0.08	0.32
560	DNMG150404-TFA	0.32	0.08	1.2	0.12	0.04	0.24

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负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
561	DNMG150408-TFA	0.32	0.08	1.2	0.16	0.08	0.32
562	DNMG150412-TFA	0.64	0.16	2	0.2	0.12	0.4
563	DNMG150604-TFA	0.32	0.08	1.2	0.12	0.04	0.24
564	DNMG150608-TFA	0.32	0.08	1.2	0.16	0.08	0.32
565	DNMG150612-TFA	0.64	0.16	2	0.2	0.12	0.4
566	SNMG120404-TFA	0.32	0.08	1.2	0.128	0.04	0.248
567	SNMG120408-TFA	0.32	0.08	1.2	0.168	0.08	0.328
568	TNMG160404-TFA	0.32	0.08	1.2	0.12	0.04	0.24
569	TNMG160408-TFA	0.32	0.08	1.2	0.16	0.08	0.32
570	WNMG060404-TFA	0.32	0.08	1.2	0.12	0.04	0.24
571	WNMG060408-TFA	0.32	0.08	1.2	0.16	0.08	0.32
572	WNMG080404-TFA	0.32	0.08	1.2	0.12	0.04	0.24
573	WNMG080408-TFA	0.32	0.08	1.2	0.16	0.08	0.32
574	VNMG160404-TFA	0.32	0.08	1.2	0.12	0.04	0.24
575	VNMG160408-TFA	0.64	0.16	2	0.12	0.064	0.24
576	CNMG120404-NF	0.4	0.15	1.5	0.12	0.08	0.22
577	CNMG120408-NF	0.5	0.2	1.5	0.15	0.1	0.25
578	CNMG120412-NF	0.8	0.4	2	0.17	0.12	0.3
579	DNMG110404-NF	0.4	0.15	1.5	0.12	0.08	0.22
580	DNMG110408-NF	0.5	0.2	1.5	0.15	0.1	0.25
581	DNMG150404-NF	0.4	0.15	1.5	0.12	0.08	0.22
582	DNMG150408-NF	0.5	0.2	1.5	0.15	0.1	0.25
583	DNMG150604-NF	0.4	0.15	1.5	0.12	0.08	0.22
584	DNMG150608-NF	0.5	0.2	1.5	0.15	0.1	0.25
585	DNMG150612-NF	0.8	0.4	2	0.17	0.12	0.3
586	TNMG160404-NF	0.4	0.15	1.5	0.12	0.08	0.22
587	TNMG160408-NF	0.5	0.2	1.5	0.15	0.1	0.25
588	TNMG160412-NF	0.8	0.4	2	0.17	0.12	0.3
589	WNMG080404-NF	0.4	0.15	1.5	0.12	0.08	0.22
590	WNMG080408-NF	0.5	0.2	1.5	0.15	0.1	0.25
591	VNMG160404-NF	0.4	0.15	1.5	0.12	0.08	0.2
592	VNMG160408-NF	0.5	0.2	1.5	0.15	0.1	0.22
593	VNMG160412-NF	0.8	0.4	2	0.17	0.12	0.25
594	CNMG120404-M2	0.4	0.15	1.5	0.12	0.08	0.22
595	CNMG120408-M2	0.5	0.2	1.5	0.15	0.1	0.25
596	CNMG120412-M2	0.8	0.4	2	0.17	0.12	0.3
597	DNMG110404-M2	0.4	0.15	1.5	0.12	0.08	0.22
598	DNMG110408-M2	0.5	0.2	1.5	0.15	0.1	0.25
599	DNMG150404-M2	0.4	0.15	1.5	0.12	0.08	0.22
600	DNMG150408-M2	0.5	0.2	1.5	0.15	0.1	0.25

负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
601	DNMG150604-M2	0.4	0.15	1.5	0.12	0.08	0.22
602	DNMG150608-M2	0.5	0.2	1.5	0.15	0.1	0.25
603	DNMG150612-M2	0.8	0.4	2	0.17	0.12	0.3
604	TNMG160404-M2	0.4	0.15	1.5	0.12	0.08	0.22
605	TNMG160408-M2	0.5	0.2	1.5	0.15	0.1	0.25
606	TNMG160412-M2	0.8	0.4	2	0.17	0.12	0.3
607	WNMG080404-M2	0.4	0.15	1.5	0.12	0.08	0.22
608	WNMG080408-M2	0.5	0.2	1.5	0.15	0.1	0.25
609	VNMG160404-M2	0.4	0.15	1.5	0.12	0.08	0.2
610	VNMG160408-M2	0.5	0.2	1.5	0.15	0.1	0.22
611	VNMG160412-M2	0.8	0.4	2	0.17	0.12	0.25
612	CNMG120408-ZK	3	0.2	6	0.35	0.15	0.5
613	CNMG120412-ZK	3	0.3	6	0.4	0.15	0.6
614	CNMG120416-ZK	3	0.3	6	0.45	0.2	0.7
615	CNMG160608-ZK	4	0.2	8	0.35	0.15	0.5
616	CNMG160612-ZK	4	0.3	8	0.4	0.15	0.6
617	CNMG160616-ZK	4	0.3	8	0.45	0.2	0.7
618	CNMG190612-ZK	4.5	0.3	9	0.4	0.15	0.6
619	CNMG190616-ZK	4.5	0.3	9	0.45	0.2	0.7
620	DNMG110408-ZK	2	0.2	3.5	0.35	0.15	0.5
621	DNMG110412-ZK	2	0.3	3.5	0.4	0.15	0.6
622	DNMG150408-ZK	2.5	0.2	5	0.35	0.15	0.5
623	DNMG150412-ZK	2.5	0.3	5	0.4	0.15	0.6
624	DNMG150608-ZK	2.5	0.2	5	0.35	0.15	0.5
625	DNMG150612-ZK	2.5	0.3	5	0.4	0.15	0.6
626	SNMG090308-ZK	2.5	0.2	4.5	0.36	0.16	0.52
627	SNMG120408-ZK	3	0.2	6	0.36	0.16	0.52
628	SNMG120412-ZK	3	0.3	6	0.41	0.16	0.62
629	SNMG120416-ZK	3	0.3	6	0.47	0.21	0.72
630	SNMG150612-ZK	4	0.3	8	0.41	0.16	0.62
631	SNMG150616-ZK	4	0.3	8	0.47	0.21	0.72
632	SNMG190612-ZK	4.5	0.3	9	0.41	0.16	0.62
633	SNMG190616-ZK	4.5	0.3	9	0.47	0.21	0.72
634	TNMG160408-ZK	3	0.2	5.5	0.35	0.15	0.5
635	TNMG160412-ZK	3	0.3	5.5	0.4	0.15	0.6
636	TNMG220408-ZK	4	0.2	8	0.35	0.15	0.5
637	TNMG220412-ZK	4	0.3	8	0.4	0.15	0.6
638	TNMG220416-ZK	4	0.3	8	0.45	0.2	0.7
639	WNMG060408-ZK	2	0.2	4	0.35	0.15	0.5
640	WNMG060412-ZK	2	0.3	4	0.4	0.15	0.6

A 车削刀片

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序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
641	WNMG080408-ZK	2.5	0.2	5	0.35	0.15	0.5
642	WNMG080412-ZK	2.5	0.3	5	0.4	0.15	0.6
643	WNMG080416-ZK	2.5	0.3	5	0.45	0.2	0.7
644	VNMG160408-ZK	2	0.2	3.5	0.3	0.15	0.4
645	VNMG160412-ZK	2	0.3	3.5	0.35	0.15	0.5
646	CNMG120408-UC	3	0.2	6	0.35	0.15	0.5
647	CNMG120412-UC	3	0.3	6	0.4	0.15	0.6
648	CNMG120416-UC	3	0.3	6	0.45	0.2	0.7
649	CNMG160608-UC	4	0.2	8	0.35	0.15	0.5
650	CNMG160612-UC	4	0.3	8	0.4	0.15	0.6
651	CNMG160616-UC	4	0.3	8	0.45	0.2	0.7
652	CNMG190612-UC	4.5	0.3	9	0.4	0.15	0.6
653	CNMG190616-UC	4.5	0.3	9	0.45	0.2	0.7
654	DNMG110408-UC	2	0.2	3.5	0.35	0.15	0.5
655	DNMG110412-UC	2	0.3	3.5	0.4	0.15	0.6
656	DNMG150408-UC	2.5	0.2	5	0.35	0.15	0.5
657	DNMG150412-UC	2.5	0.3	5	0.4	0.15	0.6
658	DNMG150608-UC	2.5	0.2	5	0.35	0.15	0.5
659	DNMG150612-UC	2.5	0.3	5	0.4	0.15	0.6
660	SNMG090308-UC	2.5	0.2	4.5	0.36	0.16	0.52
661	SNMG120408-UC	3	0.2	6	0.36	0.16	0.52
662	SNMG120412-UC	3	0.3	6	0.41	0.16	0.62
663	SNMG120416-UC	3	0.3	6	0.47	0.21	0.72
664	SNMG150612-UC	4	0.3	8	0.41	0.16	0.62
665	SNMG150616-UC	4	0.3	8	0.47	0.21	0.72
666	SNMG190612-UC	4.5	0.3	9	0.41	0.16	0.62
667	SNMG190616-UC	4.5	0.3	9	0.47	0.21	0.72
668	TNMG160408-UC	3	0.2	5.5	0.35	0.15	0.5
669	TNMG160412-UC	3	0.3	5.5	0.4	0.15	0.6
670	TNMG220408-UC	4	0.2	8	0.35	0.15	0.5
671	TNMG220412-UC	4	0.3	8	0.4	0.15	0.6
672	TNMG220416-UC	4	0.3	8	0.45	0.2	0.7
673	WNMG060408-UC	2	0.2	4	0.35	0.15	0.5
674	WNMG060412-UC	2	0.3	4	0.4	0.15	0.6
675	WNMG080408-UC	2.5	0.2	5	0.35	0.15	0.5
676	WNMG080412-UC	2.5	0.3	5	0.4	0.15	0.6
677	WNMG080416-UC	2.5	0.3	5	0.45	0.2	0.7
678	VNMG160408-UC	2	0.2	3.5	0.3	0.15	0.4
679	VNMG160412-UC	2	0.3	3.5	0.35	0.15	0.5
680	CNMG120408	3	0.2	6	0.35	0.15	0.5

负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
681	CNMG120412	3	0.3	6	0.4	0.15	0.6
682	CNMG120416	3	0.3	6	0.45	0.2	0.7
683	CNMG160608	4	0.2	8	0.35	0.15	0.5
684	CNMG160612	4	0.3	8	0.4	0.15	0.6
685	CNMG160616	4	0.3	8	0.45	0.2	0.7
686	CNMG190612	4.5	0.3	9	0.4	0.15	0.6
687	CNMG190616	4.5	0.3	9	0.45	0.2	0.7
688	DNMG110408	2	0.2	3.5	0.35	0.15	0.5
689	DNMG110412	2	0.3	3.5	0.4	0.15	0.6
690	DNMG150408	2.5	0.2	5	0.35	0.15	0.5
691	DNMG150412	2.5	0.3	5	0.4	0.15	0.6
692	DNMG150608	2.5	0.2	5	0.35	0.15	0.5
693	DNMG150612	2.5	0.3	5	0.4	0.15	0.6
694	SNMG090308	2.5	0.2	4.5	0.36	0.16	0.52
695	SNMG120408	3	0.2	6	0.36	0.16	0.52
696	SNMG120412	3	0.3	6	0.41	0.16	0.62
697	SNMG120416	3	0.3	6	0.47	0.21	0.72
698	SNMG150612	4	0.3	8	0.41	0.16	0.62
699	SNMG150616	4	0.3	8	0.47	0.21	0.72
700	SNMG190612	4.5	0.3	9	0.41	0.16	0.62
701	SNMG190616	4.5	0.3	9	0.47	0.21	0.72
702	TNMG160408	3	0.2	5.5	0.35	0.15	0.5
703	TNMG160412	3	0.3	5.5	0.4	0.15	0.6
704	TNMG220408	4	0.2	8	0.35	0.15	0.5
705	TNMG220412	4	0.3	8	0.4	0.15	0.6
706	TNMG220416	4	0.3	8	0.45	0.2	0.7
707	WNMG060408	2	0.2	4	0.35	0.15	0.5
708	WNMG060412	2	0.3	4	0.4	0.15	0.6
709	WNMG080408	2.5	0.2	5	0.35	0.15	0.5
710	WNMG080412	2.5	0.3	5	0.4	0.15	0.6
711	WNMG080416	2.5	0.3	5	0.45	0.2	0.7
712	VNMG160408	2	0.2	3.5	0.3	0.15	0.4
713	VNMG160412	2	0.3	3.5	0.35	0.15	0.5
714	CNMG090304R/L-M	2.4	0.48	4.8	0.24	0.12	0.36
715	CNMG090308R/L-M	2.4	0.6	4.8	0.36	0.18	0.6
716	CNMG120404R/L-M	3.6	0.48	6.6	0.24	0.12	0.36
717	CNMG120408R/L-M	3.6	0.6	6.6	0.36	0.18	0.6
718	CNMG120412R/L-M	3.6	0.96	6.6	0.42	0.216	0.72
719	CNMG120416R/L-M	3.6	1.2	6.6	0.48	0.276	0.78
720	CNMG160608R/L-M	4.8	0.6	8.64	0.36	0.18	0.6

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序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
721	CNMG160612R/L-M	4.8	0.96	8.64	0.42	0.216	0.72
722	CNMG160616R/L-M	4.8	1.2	8.64	0.48	0.276	0.78
723	CNMG190608R/L-M	4.8	0.6	10.32	0.36	0.18	0.6
724	CNMG190612R/L-M	4.8	0.96	10.32	0.42	0.216	0.72
725	CNMG190616R/L-M	4.8	1.2	10.32	0.48	0.276	0.78
726	DNMG110404R/L-M	2.4	0.48	6	0.24	0.12	0.36
727	DNMG110408R/L-M	2.4	0.6	6	0.36	0.18	0.6
728	DNMG110412R/L-M	2.4	0.96	6	0.42	0.216	0.6
729	DNMG150404R/L-M	3.6	0.48	7.2	0.24	0.12	0.36
730	DNMG150408R/L-M	3.6	0.6	7.2	0.36	0.18	0.6
731	DNMG150412R/L-M	3.6	0.96	7.2	0.42	0.216	0.72
732	DNMG150604R/L-M	3.6	0.48	7.2	0.24	0.12	0.36
733	DNMG150608R/L-M	3.6	0.6	7.2	0.36	0.18	0.6
734	DNMG150612R/L-M	3.6	0.96	7.2	0.42	0.216	0.72
735	DNMG150616R/L-M	3.6	1.2	7.2	0.48	0.276	0.78
736	SNMG090304R/L-M	2.4	0.48	5.4	0.252	0.12	0.372
737	SNMG090308R/L-M	2.4	0.6	5.4	0.372	0.192	0.624
738	SNMG120404R/L-M	3.6	0.48	7.2	0.252	0.12	0.372
739	SNMG120408R/L-M	3.6	0.6	7.2	0.372	0.192	0.624
740	SNMG120412R/L-M	3.6	0.96	7.2	0.432	0.228	0.744
741	SNMG120416R/L-M	3.6	1.2	7.2	0.492	0.288	0.804
742	SNMG150612R/L-M	4.8	0.96	9	0.432	0.228	0.744
743	SNMG150616R/L-M	4.8	1.2	9	0.492	0.288	0.804
744	TNMG160404R/L-M	3.6	0.48	6	0.24	0.12	0.36
745	TNMG160408R/L-M	3.6	0.6	6	0.36	0.18	0.6
746	TNMG160412R/L-M	3.6	0.96	6	0.42	0.216	0.72
747	TNMG220404R/L-M	4.8	0.48	7.92	0.24	0.12	0.36
748	TNMG220408R/L-M	4.8	0.6	7.92	0.36	0.18	0.6
749	TNMG220412R/L-M	4.8	0.96	7.92	0.42	0.216	0.72
750	TNMG220416R/L-M	4.8	1.2	7.92	0.48	0.276	0.78
751	WNMG060408R/L-M	2.4	0.6	3.6	0.36	0.18	0.6
752	WNMG060412R/L-M	2.4	0.96	3.6	0.42	0.216	0.72
753	WNMG080408R/L-M	3	0.6	4.8	0.36	0.18	0.6
754	WNMG080412R/L-M	3	0.96	4.8	0.42	0.216	0.72
755	WNMG080416R/L-M	3.6	1.2	4.8	0.48	0.276	0.78
756	VNMG160408R/L-M	2.4	0.6	4.8	0.36	0.18	0.6
757	VNMG160412R/L-M	2.4	0.96	4.8	0.42	0.216	0.72
758	CNMG120408R/L-X	3.2	0.56	5.6	0.28	0.16	0.4
759	CNMG120412R/L-X	3.2	0.8	5.6	0.32	0.2	0.56
760	CNMG120416R/L-X	3.2	1.2	5.6	0.4	0.256	0.6

负角刀片切削参数 Negative Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
761	CNMG160608R/L-X	4	0.56	6.4	0.28	0.16	0.4
762	CNMG160612R/L-X	4	0.8	6.4	0.32	0.2	0.56
763	CNMG160616R/L-X	4	1.2	6.4	0.4	0.24	0.64
764	CNMG160624R/L-X	4	1.6	6.4	0.4	0.256	0.72
765	CNMG190608R/L-X	4	0.56	8	0.28	0.16	0.4
766	CNMG190612R/L-X	4	0.8	8	0.32	0.2	0.56
767	CNMG190616R/L-X	4	1.2	8	0.4	0.24	0.64
768	CNMG190624R/L-X	4	1.6	8	0.4	0.256	0.72
769	DNMG150408R/L-X	3.2	0.56	4.8	0.28	0.16	0.4
770	DNMG150412R/L-X	3.2	0.8	4.8	0.32	0.2	0.56
771	DNMG150416R/L-X	3.2	1.2	4.8	0.4	0.24	0.6
772	DNMG150608R/L-X	3.2	0.56	4.8	0.28	0.16	0.4
773	DNMG150612R/L-X	3.2	0.8	4.8	0.32	0.2	0.56
774	DNMG150616R/L-X	3.2	1.2	4.8	0.4	0.256	0.6
775	DNMG190608R/L-X	4	0.8	6.4	0.28	0.16	0.4
776	DNMG190612R/L-X	4	0.96	6.4	0.32	0.2	0.56
777	SNMG120408R/L-X	3.2	0.56	5.6	0.288	0.168	0.416
778	SNMG120412R/L-X	3.2	0.8	5.6	0.328	0.208	0.576
779	SNMG120416R/L-X	3.2	1.2	5.6	0.416	0.264	0.624
780	SNMG150608R/L-X	4	1.2	6.4	0.288	0.168	0.416
781	SNMG150612R/L-X	4	0.8	6.4	0.328	0.208	0.576
782	SNMG150616R/L-X	4	1.2	6.4	0.416	0.248	0.664
783	SNMG150624R/L-X	4	1.6	6.4	0.416	0.264	0.744
784	SNMG190608R/L-X	4	0.56	8	0.288	0.168	0.416
785	SNMG190612R/L-X	4	0.8	8	0.328	0.208	0.576
786	SNMG190616R/L-X	4	1.2	8	0.416	0.248	0.664
787	SNMG190624R/L-X	4	1.6	8	0.416	0.264	0.744
788	TNMG160408R/L-X	2.4	0.56	4.8	0.28	0.16	0.44
789	TNMG160412R/L-X	2.4	0.8	4.8	0.32	0.2	0.52
790	TNMG220408R/L-X	3.2	0.56	5.6	0.28	0.16	0.44
791	TNMG220412R/L-X	3.2	0.8	5.6	0.32	0.2	0.52
792	TNMG220416R/L-X	3.2	1.2	5.6	0.4	0.256	0.6
793	WNMG060408R/L-X	2.4	0.56	2.8	0.24	0.16	0.36
794	WNMG060412R/L-X	2.4	0.64	2.8	0.28	0.2	0.44
795	WNMG080408R/L-X	3.2	0.56	4	0.28	0.16	0.44
796	WNMG080412R/L-X	3.2	0.8	4	0.32	0.2	0.56
797	WNMG080416R/L-X	3.2	1.2	4	0.4	0.256	0.6
798	CNMG120408-NR	2	0.5	4	0.3	0.1	0.4
799	CNMG120412-NR	2	0.5	4	0.32	0.12	0.42
800	CNMG120416-NR	2	0.5	4	0.35	0.15	0.45

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序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
801	CNMG160616-NR	4	1	6	0.4	0.3	0.5
802	CNMG190612-NR	6	1	9	0.35	0.25	0.42
803	CNMG190616-NR	6	1	9	0.4	0.3	0.5
804	DNMG150408-NR	1.5	0.15	2.5	0.2	0.1	0.25
805	DNMG150412-NR	2	0.2	3	0.22	0.1	0.3
806	DNMG150608-NR	1.5	0.15	2.5	0.2	0.1	0.25
807	DNMG150612-NR	2	0.2	3	0.22	0.1	0.3
808	DNMG150616-NR	2	0.3	3	0.25	0.12	0.3
809	SNMG120408-NR	2	0.5	5	0.26	0.16	0.41
810	SNMG120412-NR	2	0.5	5	0.31	0.19	0.47
811	SNMG120416-NR	2	0.5	5	0.36	0.19	0.52
812	SNMG150616-NR	5	1	8	0.52	0.31	0.72
813	SNMG190612-NR	6	1	9	0.36	0.26	0.43
814	SNMG190616-NR	7	1	10	0.52	0.31	0.72
815	WNMG080408-NR	2	0.5	4	0.3	0.1	0.4
816	WNMG080412-NR	2	0.5	4	0.32	0.12	0.42

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正角刀片切削参数 Positive Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
1	CCMT060204-GM	0.64	0.2	2.4	0.11	0.06	0.17
2	CCMT060208-GM	0.64	0.4	2.4	0.15	0.08	0.23
3	CCMT09T304-GM	0.64	0.25	3	0.15	0.08	0.23
4	CCMT09T308-GM	0.8	0.5	3	0.2	0.1	0.3
5	CCMT120404-GM	0.96	0.3	3.6	0.18	0.09	0.27
6	CCMT120408-GM	0.96	0.6	3.6	0.24	0.12	0.36
7	DCMT070204-GM	0.6	0.19	2.25	0.11	0.06	0.17
8	DCMT070208-GM	0.6	0.38	2.25	0.15	0.08	0.23
9	DCMT11T304-GM	0.8	0.25	3	0.15	0.08	0.23
10	DCMT11T308-GM	0.8	0.5	3	0.2	0.1	0.3
11	DCMT11T312-GM	0.8	0.6	3	0.24	0.12	0.36
12	SCMT09T304-GM	0.8	0.25	3	0.16	0.08	0.24
13	SCMT09T308-GM	0.8	0.5	3	0.21	0.1	0.31
14	SCMT120408-GM	0.96	0.6	3.6	0.25	0.12	0.37
15	TCMT090204-GM	0.6	0.19	2.25	0.11	0.06	0.17
16	TCMT090208-GM	0.6	0.38	2.25	0.15	0.08	0.23
17	TCMT110304-GM	0.67	0.21	2.5	0.13	0.06	0.19
18	TCMT110308-GM	0.67	0.42	2.5	0.17	0.09	0.26
19	TCMT110312-GM	0.65	0.5	2.5	0.2	0.1	0.31
20	TCMT16T304-GM	0.8	0.25	3	0.15	0.08	0.23
21	TCMT16T308-GM	0.8	0.5	3	0.2	0.1	0.3
22	TCMT16T312-GM	0.8	0.6	3	0.24	0.12	0.36
23	TCMT220408-GM	0.96	0.6	3.6	0.24	0.12	0.36
24	VBMT160404-GM	0.72	0.23	2.7	0.14	0.07	0.2
25	VBMT160408-GM	0.72	0.45	2.7	0.18	0.09	0.27
26	VBMT160412-GM	0.72	0.54	2.7	0.22	0.11	0.32
27	VCMT110308-GM	0.77	0.61	2.55	0.2	0.13	0.33
28	CCMT060204-PMK	0.768	0.24	2.88	0.132	0.072	0.204
29	CCMT060208-PMK	0.768	0.48	2.88	0.18	0.096	0.276
30	CCMT09T304-PMK	0.768	0.3	3.6	0.18	0.096	0.276
31	CCMT09T308-PMK	0.96	0.6	3.6	0.24	0.12	0.36
32	CCMT120404-PMK	1.152	0.36	4.32	0.216	0.108	0.324
33	CCMT120408-PMK	1.152	0.72	4.32	0.288	0.144	0.432
34	DCMT070204-PMK	0.72	0.228	2.7	0.132	0.072	0.204
35	DCMT070208-PMK	0.72	0.456	2.7	0.18	0.096	0.276
36	DCMT11T304-PMK	0.96	0.3	3.6	0.18	0.096	0.276
37	DCMT11T308-PMK	0.96	0.6	3.6	0.24	0.12	0.36
38	DCMT11T312-PMK	0.96	0.72	3.6	0.288	0.144	0.432
39	SCMT09T304-PMK	0.96	0.3	3.6	0.192	0.096	0.288
40	SCMT09T308-PMK	0.96	0.6	3.6	0.252	0.12	0.372

A 车削刀片

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		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
41	SCMT120408-PMK	1.152	0.72	4.32	0.3	0.144	0.444
42	TCMT090204-PMK	0.72	0.228	2.7	0.132	0.072	0.204
43	TCMT090208-PMK	0.72	0.456	2.7	0.18	0.096	0.276
44	TCMT110304-PMK	0.804	0.252	3	0.156	0.072	0.228
45	TCMT110308-PMK	0.804	0.504	3	0.204	0.108	0.312
46	TCMT110312-PMK	0.78	0.6	3	0.24	0.12	0.372
47	TCMT16T304-PMK	0.96	0.3	3.6	0.18	0.096	0.276
48	TCMT16T308-PMK	0.96	0.6	3.6	0.24	0.12	0.36
49	TCMT16T312-PMK	0.96	0.72	3.6	0.288	0.144	0.432
50	TCMT220408-PMK	1.152	0.72	4.32	0.288	0.144	0.432
51	VBMT160404-PMK	0.864	0.276	3.24	0.168	0.084	0.24
52	VBMT160408-PMK	0.864	0.54	3.24	0.216	0.108	0.324
53	VBMT160412-PMK	0.864	0.648	3.24	0.264	0.132	0.384
54	VCMT110308-PMK	0.924	0.732	3.06	0.24	0.156	0.396
55	CCMW060204	0.768	0.24	2.88	0.132	0.072	0.204
56	CCMW060208	0.768	0.48	2.88	0.18	0.096	0.276
57	CCMW09T304	0.768	0.3	3.6	0.18	0.096	0.276
58	CCMW09T308	0.96	0.6	3.6	0.24	0.12	0.36
59	CCMW120404	1.152	0.36	4.32	0.216	0.108	0.324
60	CCMW120408	1.152	0.72	4.32	0.288	0.144	0.432
61	DCMW070204	0.72	0.228	2.7	0.132	0.072	0.204
62	DCMW070208	0.72	0.456	2.7	0.18	0.096	0.276
63	DCMW11T304	0.96	0.3	3.6	0.18	0.096	0.276
64	DCMW11T308	0.96	0.6	3.6	0.24	0.12	0.36
65	DCMW11T312	0.96	0.72	3.6	0.288	0.144	0.432
66	SCMW09T304	0.96	0.3	3.6	0.192	0.096	0.288
67	SCMW09T308	0.96	0.6	3.6	0.252	0.12	0.372
68	SCMW120408	1.152	0.72	4.32	0.3	0.144	0.444
69	TCMW090204	0.72	0.228	2.7	0.132	0.072	0.204
70	TCMW090208	0.72	0.456	2.7	0.18	0.096	0.276
71	TCMW110304	0.804	0.252	3	0.156	0.072	0.228
72	TCMW110308	0.804	0.504	3	0.204	0.108	0.312
73	TCMW110312	0.78	0.6	3	0.24	0.12	0.372
74	TCMW16T304	0.96	0.3	3.6	0.18	0.096	0.276
75	TCMW16T308	0.96	0.6	3.6	0.24	0.12	0.36
76	TCMW16T312	0.96	0.72	3.6	0.288	0.144	0.432
77	TCMW220408	1.152	0.72	4.32	0.288	0.144	0.432
78	VBMW160404	0.864	0.276	3.24	0.168	0.084	0.24
79	VBMW160408	0.864	0.54	3.24	0.216	0.108	0.324
80	VBMW160412	0.864	0.648	3.24	0.264	0.132	0.384

正角刀片切削参数 Positive Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
81	VCMW110308	0.924	0.732	3.06	0.24	0.156	0.396
82	CCMT060202-MF	0.3	0.06	1.7	0.06	0.03	0.11
83	CCMT060204-MF	0.3	0.1	1.7	0.08	0.05	0.17
84	CCMT09T302-MF	0.35	0.08	2	0.08	0.04	0.15
85	CCMT09T304-MF	0.35	0.11	2	0.11	0.06	0.23
86	CCMT09T308-MF	0.35	0.15	2	0.15	0.08	0.3
87	CCMT120404-MF	0.42	0.14	2.4	0.14	0.07	0.27
88	DCMT070202-MF	0.26	0.06	1.5	0.06	0.03	0.11
89	DCMT070204-MF	0.26	0.08	1.5	0.08	0.05	0.17
90	DCMT11T302-MF	0.35	0.08	2	0.08	0.04	0.15
91	DCMT11T304-MF	0.35	0.11	2	0.11	0.06	0.23
92	DCMT11T308-MF	0.35	0.15	2	0.15	0.08	0.3
93	SCMT09T304-MF	0.35	0.11	2	0.11	0.06	0.24
94	SCMT09T308-MF	0.35	0.15	2	0.16	0.08	0.31
95	TCMT06T102-MF	0.26	0.06	1.5	0.06	0.03	0.11
96	TCMT06T104-MF	0.26	0.08	1.5	0.08	0.05	0.17
97	TCMT06T108-MF	0.26	0.11	1.5	0.11	0.06	0.23
98	TCMT090202-MF	0.3	0.06	1.7	0.06	0.03	0.13
99	TCMT090204-MF	0.3	0.1	1.7	0.1	0.05	0.19
100	TCMT110302-MF	0.3	0.06	1.7	0.06	0.03	0.13
101	TCMT110304-MF	0.3	0.1	1.7	0.1	0.05	0.19
102	TCMT110308-MF	0.3	0.13	1.7	0.13	0.07	0.26
103	TCMT16T304-MF	0.35	0.11	2	0.11	0.06	0.23
104	VBMT110302-MF	0.3	0.06	1.7	0.06	0.03	0.13
105	VBMT110304-MF	0.3	0.1	1.7	0.1	0.05	0.19
106	VBMT110308-MF	0.3	0.13	1.7	0.13	0.07	0.26
107	VBMT160402-MF	0.32	0.07	1.8	0.07	0.04	0.14
108	VBMT160404-MF	0.32	0.1	1.8	0.1	0.05	0.2
109	VBMT160408-MF	0.32	0.14	1.8	0.14	0.07	0.27
110	VBMT160412-MF	0.32	0.14	1.8	0.16	0.09	0.32
111	VCMT110304-MF	0.3	0.1	1.5	0.1	0.05	0.2
112	CCMT060204-MM	0.64	0.2	2.4	0.11	0.06	0.17
113	CCMT060208-MM	0.64	0.4	2.4	0.15	0.08	0.23
114	CCMT09T304-MM	0.64	0.25	3	0.15	0.08	0.23
115	CCMT09T308-MM	0.8	0.5	3	0.2	0.1	0.3
116	CCMT120404-MM	0.96	0.3	3.6	0.18	0.09	0.27
117	CCMT120408-MM	0.96	0.6	3.6	0.24	0.12	0.36
118	CCMT120412-MM	0.96	0.72	3.6	0.29	0.14	0.3
119	DCMT070204-MM	0.6	0.19	2.25	0.11	0.06	0.17
120	DCMT070208-MM	0.6	0.38	2.25	0.15	0.08	0.23

A 车削刀片

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序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
121	DCMT11T304-MM	0.8	0.25	3	0.15	0.08	0.23
122	DCMT11T308-MM	0.8	0.5	3	0.2	0.1	0.3
123	DCMT11T312-MM	0.8	0.6	3	0.24	0.12	0.36
124	SCMT09T304-MM	0.8	0.25	3	0.16	0.08	0.24
125	SCMT09T308-MM	0.8	0.5	3	0.21	0.1	0.31
126	SCMT120404-MM	0.96	0.3	3.6	0.19	0.09	0.28
127	SCMT120408-MM	0.96	0.6	3.6	0.25	0.12	0.37
128	SCMT120412-MM	0.96	0.72	3.6	0.3	0.14	0.45
129	TCMT090204-MM	0.6	0.19	2.25	0.11	0.06	0.17
130	TCMT090208-MM	0.6	0.38	2.25	0.15	0.08	0.23
131	TCMT110304-MM	0.67	0.21	2.5	0.13	0.06	0.19
132	TCMT110308-MM	0.67	0.42	2.5	0.17	0.09	0.26
133	TCMT16T304-MM	0.8	0.25	3	0.15	0.08	0.23
134	TCMT16T308-MM	0.8	0.5	3	0.2	0.1	0.3
135	TCMT16T312-MM	0.8	0.6	3	0.24	0.12	0.36
136	TCMT220408-MM	0.96	0.6	3.6	0.24	0.12	0.36
137	VBMT160404-MM	0.72	0.23	2.7	0.14	0.07	0.2
138	VBMT160408-MM	0.72	0.45	2.7	0.18	0.09	0.27
139	VBMT160412-MM	0.72	0.54	2.7	0.22	0.11	0.32
140	VCMT110304-MM	0.77	0.31	2.55	0.15	0.1	0.25
141	VCMT110308-MM	0.77	0.61	2.55	0.2	0.13	0.33
142	CCGX060202-AK	1.00	0.30	3.00	0.12	0.05	0.15
143	CCGX060204-AK	1.00	0.30	3.00	0.12	0.05	0.15
144	CCGX09T304-AK	1.50	0.50	5.00	0.20	0.10	0.30
145	CCGX09T308-AK	1.50	0.50	5.00	0.30	0.15	0.60
146	CCGX120404-AK	1.50	0.50	7.00	0.20	0.10	0.30
147	CCGX120408-AK	1.50	0.50	7.00	0.30	0.15	0.60
148	DCGX070202-AK	1.00	0.30	4.00	0.12	0.05	0.15
149	DCGX070204-AK	1.50	0.50	4.00	0.20	0.10	0.30
150	DCGX11T302-AK	1.00	0.30	5.50	0.12	0.05	0.15
151	DCGX11T304-AK	1.50	0.50	5.50	0.20	0.10	0.30
152	DCGX11T308-AK	1.50	0.50	5.50	0.30	0.15	0.60
153	RCGX0602M0-AK	1.00	0.60	2.40	0.24	0.13	0.38
154	RCGX0803M0-AK	1.50	0.80	3.20	0.35	0.16	0.54
155	RCGX10T3M0-AK	2.00	1.00	4.00	0.36	0.16	0.63
156	RCGX1204M0-AK	2.50	1.20	4.80	0.46	0.19	0.79
157	SCGX09T308-AK	1.50	0.50	5.00	0.31	0.16	0.62
158	TCGX06T104-AK	1.00	0.50	2.00	0.20	0.10	0.30
159	TCGX090202-AK	1.00	0.30	4.00	0.12	0.05	0.15
160	TCGX090204-AK	1.50	0.50	4.00	0.20	0.10	0.30

正角刀片切削参数 Positive Inserts

序号 No.	刀片 Type	切深 a_p (mm)			进给 f (mm/r)		
		推荐值 Recommendation	最小值 Minimum	最大值 Maximum	推荐值 Recommendation	最小值 Minimum	最大值 Maximum
161	TCGX110202-AK	1.00	0.30	5.00	0.12	0.05	0.15
162	TCGX110204-AK	1.50	0.50	5.00	0.20	0.10	0.30
163	TCGX110208-AK	1.50	0.50	5.00	0.30	0.15	0.60
164	TCGX110302-AK	1.00	0.30	5.00	0.12	0.05	0.15
165	TCGX110304-AK	1.50	0.50	5.00	0.20	0.10	0.30
166	TCGX110308-AK	1.50	0.50	5.00	0.30	0.15	0.60
167	TCGX16T304-AK	1.50	0.50	7.00	0.20	0.10	0.30
168	TCGX16T308-AK	1.50	0.50	7.00	0.30	0.15	0.60
169	VCGX110202-AK	1.00	0.30	3.00	0.12	0.05	0.15
170	VCGX110204-AK	1.50	0.50	3.00	0.20	0.10	0.30
171	VCGX110302-AK	1.00	0.30	3.00	0.12	0.05	0.15
172	VCGX110304-AK	1.50	0.50	3.00	0.20	0.10	0.30
173	VCGX160404-AK	1.50	0.50	5.00	0.20	0.10	0.30
174	VCGX160408-AK	1.50	0.50	5.00	0.30	0.15	0.60
175	VCGX160412-AK	1.50	0.50	5.00	0.40	0.15	0.80
176	VCGX220520-AK	1.50	0.50	7.00	0.60	0.25	1.00
177	VCGX220530-AK	1.50	0.50	7.00	0.60	0.25	1.00

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材料编号 No.	工件材料 Workpiece	特定切削力 Cutting Force	布氏硬度 HB	←耐磨性 Wear Resistance				
				KT1153	KT1253	KT1373	KP015	KP025
				进给(Fr)mm/r				
				0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3
				切削速度(Vc),m/min				
P10	非合金钢 Non Alloy Steel	1500-1700	125-170	340-265-190	320-245-175	300-230-165	340-265-190	320-245-175
P20	低合金钢 Low Alloy Steel	1700-2050	180-350	300-215-130	290-210-120	250-180-100	300-215-130	290-210-120
P30	高合金钢 High Alloy Steel	1950-3000	200-325	200-130-95	150-125-95	135-100-65	200-130-95	150-125-95
P40	铸钢 Cast Steel	1550-2050	180-225	260-185-140	240-185-130	200-140-80	260-185-140	240-185-130

材料编号 No.	工件材料 Workpiece	特定切削力 Cutting Force	布氏硬度 HB	←耐磨性Wear Resistance			
				KT8206	KT8286	KT8284S	KT8287N
				进给(Fr)mm/r			
				0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3
				切削速度(Vc),m/min			
N10	铁素体/马氏体 Ferrolites/Martensitic 棒材/锻件 Rods/Forged	1800-2850	200-330	260-180-90	230-150-70	200-130-50	230-150-70
N20	奥氏体 Authentic 棒材/锻件 Rods/Forged	1800-2850	180-200	250-175-100	180-125-75	150-110-70	180-125-75
M30	铁素体/马氏体 Ferrolites/Martensitic 铸件 Casted	1700-2450	200-330	220-170-110	160-110-60	150-100-60	160-110-60
M40	奥氏体铸件 Authentic Casted	1700-2450	180-330	190-145-100	170-130-90	165-120-75	170-130-90

车削参数一览表 Turning Parameters Reference Table

材料编号 No.	工件材料 Workpiece	特定切削力 Cutting Force	布氏硬度 HB	←耐磨性 Wear Resistance		
				KT3123	KT3263	KT3253
				进给(Fr)mm/r		
				0.1-0.25-0.3	0.1-0.2-0.3	0.1-0.25-0.4
				切削速度 (Vc) ,m/min		
K10	可锻铸铁 Malleable Cast Iron	790-900	130-230	310-250-210	300-250-200	240-140-140
K20	灰口铸铁 Grey Cast Iron	890-970	180-220	330-260-190	310-240-170	280-225-165
K30	球墨铸铁 Nodular Cast Iron	900-2100	160-380	300-230-165	285-220-160	260-200-150

材料编号 No.	工件材料 Workpiece	特定切削力 Cutting Force	布氏硬度 HB	←耐磨性 Wear Resistance	
				KS05	KS10
				进给(Fr)mm/r	
				0.05-0.1-0.2	0.05-0.1-0.2
				切削速度 (Vc),m/min	
S10	高温合金铁基 Fe-based Superalloy	2400-2500	200-280	110-75-45	100-65-35
S20	镍基 Ni-based	2650-3000	250-320	70-40-17	40-25-10
S30	钴基合金 Co-based	2700-3100	200-320	70-40-17	40-25-10
S40	钛合金 Ti-based	1300-1400	400-1050	120-80-40	100-65-30

材料编号	工件材料 Workpiece	特定切削力 Cutting Force	洛氏硬度 HRC	←耐磨性 Wear Resistance	
				KT6109	
				进给mm/r	
				0.05-0.15-0.25	
				切削速度 (Vc),m/min	
H10	硬钢 Hardened Steel	2500-3650	45-55HRC	150-110-70	
	超硬钢 Super Hardened Steel	4300-5000	60-65HRC	125-90-50	

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

车削刀片断屑槽选择对照表(负角刀片) Comparison Table of Chipbreaker(Negative)

ISO 分类	加工 范畴 Application	KELITE 科力特	HUAREAL 华锐	OKE 欧科亿	GESAC 金鹭	ACHTECK 澳克泰	SANDVIK 山特维克	TUNGALOY 泰珂洛	TAEGUTEC 特固克	KYOCERA 京瓷	KORLOY 克洛伊	MITSUBISHI 三菱	ZCC.CT 株洲钻石
P	超精加工 Superfinishing			R/L-F	PS		QF,LC	01,TF ZF,11	FA,FX	DP,GP PP,VF,XP XP-T,XF	HU	PK,FH,FY FP,FS	
	精加工 Finishing	GF	GF,GC	OPF,53 Z	GF,QF TS	BS PB1,SC1	PF,XF	NS,27 TDF,AS,TQ	FG,FM	HQ,CQ PQ	HF	LP,C SA,SH	DF
	精加工 (软钢) Finishing (Mild Steel)			OPF				17	FC	XQ,XS	HF	SY	SF
	精加工 (修光刃) Finishing (Wiper)						WL,WF	AFW,ASW FW,SW	WS	WF,WP WQ	HW	SW	WGF
	半精加工 Semi-finishing	MB,GMR PMB,PMK GD	GQ,GM 通槽, MT	OPM KPM	GM,SM QM,TP SV,WMV	PB3,PC3 PD3	PM,QM XM	NM,ZM,AM TM,DM,37 33,38	PC,FT MT,SM MP	PG,CJ GS,PS HS,PT	HA,HC HM	MP,MA MHS	DM,PM
	半精加工 (修光刃) Semi-finishing (Wiper)						WMX WM		WT	WE		MW	WDM
	轻载 粗加工 Light Roughing	GR L/R-X	GR	OPR	QR	SL3,PL5 PD5,PC8	PR,HM XMR	TH	RT	RH,GT		RP,GH	LR(单面) DR(双面)
	重载 粗加工 Heavy Roughing		GZ,GX	OPR OPH	QH	PD8,PC9 PD9	QR,PR HR,MR	TU,TRS TUS	RX,HD HY,HT RT,RH HZ,EH	PX	HR,HH	HM,HL HZ,HX HV,HR	HDR HPR

ISO 分类	加工 范畴 Application	KELITE 科力特	HUAREAL 华锐	OKE 欧科亿	GESAC 金鹭	ACHTECK 澳克泰	SANDVIK 山特维克	TUNGALOY 泰珂洛	TAEGUTEC 特固克	KYOCERA 京瓷	KORLOY 克洛伊	MITSUBISHI 三菱	ZCC.CT 株洲钻石
M	精加工 Finishing	MF,MJ	BF	OMF MSF	SF,LF	SC1,MB2 UF,F	MF	SS	SF	MQ,GU	HA	SH,LM	EF
	半精加工 Semi-finishing	MP,MB MM-B	BM 通槽, 无槽	OMM MF	LV,LM SM	MC3,H	MM,QM XM,K	SF,SA SM,S	ML,EM MM,VF	MS,MU,SU HU,ST,TK	HS	MS,ES GM,MM,MA	EM
	粗加工 Roughing	L/R-M	BR	OMR	LR	Mc4	MR	TH,SH	MT		GS,HM	GH,HZ RM,HL	ER
K	精加工 Finishing	MB		OKM 通槽			KF	CF		KQ		VA,AH	PM
	半精加工 Semi-finishing	UC,ZK		TK,OKM 通槽	TP WMV	Pc4	KM	CM	MC	KG,C	全周槽 HM	V,AE	PM
	粗加工 Roughing	ZD,ZR		OPR 平板	HK,VK	KC4,KD5	KR,KRR		KT	KH,GC	GR,HR GH	RE	无断屑槽
S	精加工 Finishing	NF,M2		OSF	SF	SC1	SF SGF	HRF	EA	MQ		FJ,LS MJ	NF/NGF
	半精加工 Semi-finishing	NM	SM	OSM	LM	SC3	NGP SM	HRM,SA HMM		SQ,MS MU,TK		MS	NM
	粗加工 Roughing	NR		OSM		MC4	SR SMR		ET	SG,SX		GJ,RS	SNR

车削刀片断屑槽选择对照表(正角刀片) Comparison Table of Chipbreaker(Positive)

ISO 分类	加工 范畴 Application	KELITE 科力特	HUAREAL 华锐	OKE 欧科亿	GESAC 金鹭	ACHTECK 澳克泰	SANDVIK 山特维克	TUNGALOY 泰珂洛	TAEGUTEC 特固克	KYOCERA 京瓷	KORLOY 克洛伊	MITSUBISHI 三菱	ZCC.CT 株洲钻石
P	精加工 Finishing	MF	TF	OTF	PS,MM GS	BS,PB1	PEF,UF FX	PF,PSF PS,PSS	FA,FG FX	GP,XP VF,PP	HFP	FV,SV FP,LP	SF,HF
	精加工 (修光刃) Finishing (Wiper)						WF			WP		SW	
	半精加工 Semi-finishing	GM,PMK	通槽 TM,MR	OTM	TP,KM GP	PC2,KC2 PD8	UM,XM PM,PR,XR	PM 23,24	MT,PC	HQ,XQ GK,MF	HMP C25	MV,MP	HM
	半精加工 (修光刃) Semi-finishing (Wiper)			OTR			WM		WT			MW	
M	精加工 Finishing	MF	TF	MSF,OTF	PS,MM GS	LF,UF,F	MF	PF,PSF PS,PSS		CF,CK,GQ GF,MQ,SK	HFP	FM,LM	EF
	半精加工 Semi-finishing	MM	TM	OTM	TP	PC2,KC2 M,Y	MM	PM		HQ,GK	HMP C25	MM	EM
K	半精加工 Semi-finishing	GM,PMK	TM	OTM	TP,KM GP	KC2	KF,KM KR	CM 无断屑槽		无断屑槽	HMP C25	MK 无断屑槽	HM HR无断屑槽
S	精加工 /半精加工 Finishing /Semi-finishing		TF	OSM						MQ		FS,LS,FJ FS-P,LS-P	NGF

A
车削刀片

B
铣削刀片

C
铝合金刀片

D
孔加工刀片

E
刮管刀片

F
非标异形刀片

G
圆棒和立铣刀

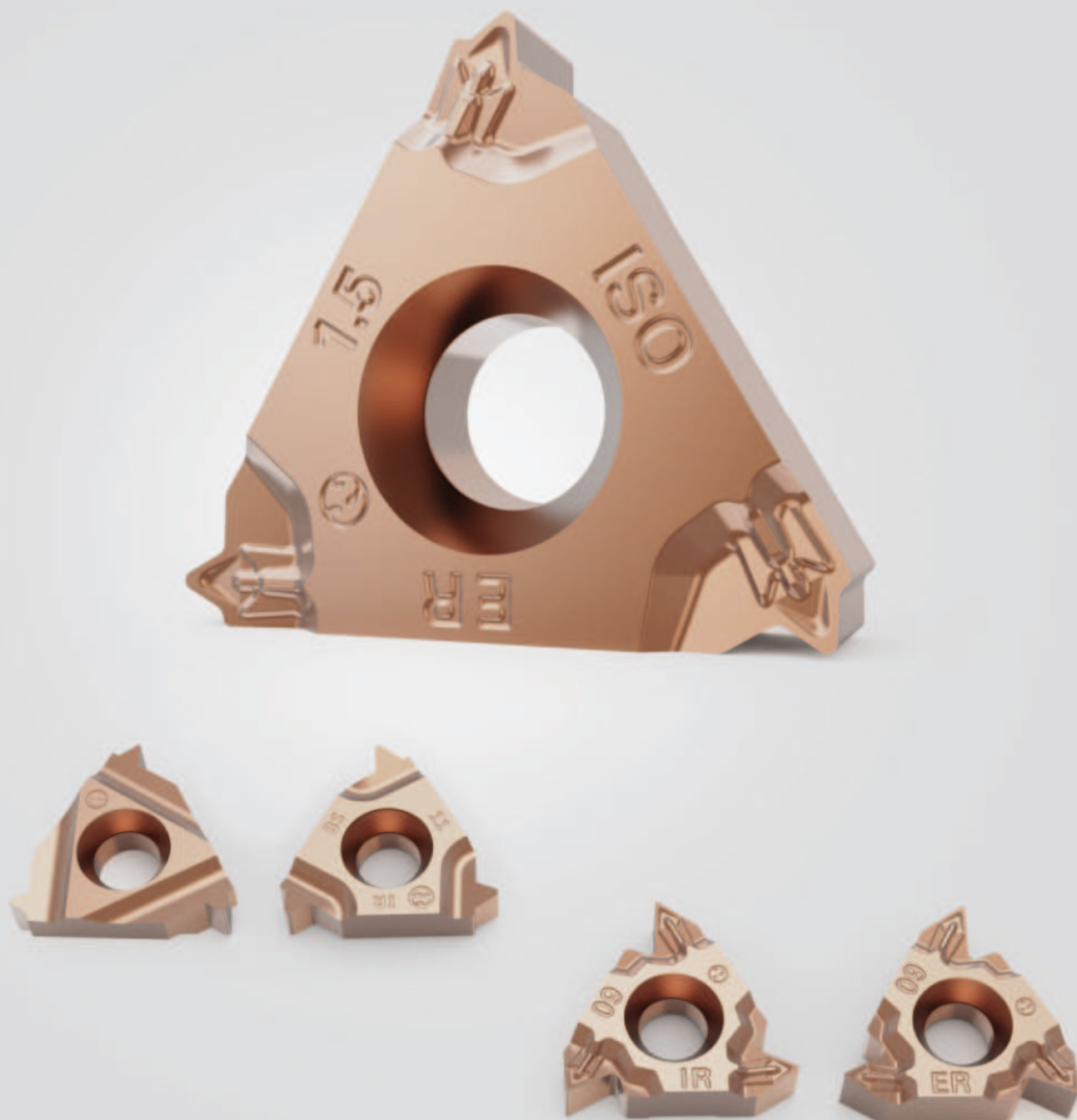
H
刀杆和刀盘

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螺纹刀片

THREADING INSERTS



- 切削顺畅，螺纹清晰，告别毛刺和崩刀；
- 高硬度基材，耐磨性显著提高；
- 多规格适配，覆盖公制、英制、管螺纹等满足不同客户需求。

螺纹刀片牌号介绍

PVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KT8294	P10~P30 M10~M30	PVD 古铜色	TiSiAlN	1. 采用亚微晶粒硬质合金基体, 搭配超细TiAlSiN纳米涂层, 具有优异的耐磨性、耐高温性能。 2. 适用于钢件、不锈钢材料的螺纹车削加工。
KT8254S	M15~M30 S15~S20	PVD 古铜色	TiAlSiN	1. 中钴含量的细晶粒硬质合金基体, 结合高光洁度、高耐磨性的TiAlSiN涂层, 兼具耐磨性和韧性, 且热稳定性能优异。 2. 适用于不锈钢的螺纹车削加工。
KT6109	H05~H25	PVD 七彩色	AlTiCrSiN	1. 采用较低钴含量的超细晶粒硬质合金基体, 搭配全新升级的多层复合纳米PVD涂层, 获得较强的涂层结合力、高耐磨性和高抗氧化性能。 2. 适用于HRC42以上淬硬钢的螺纹车削加工。

Grade Information

PVD Coated Grades

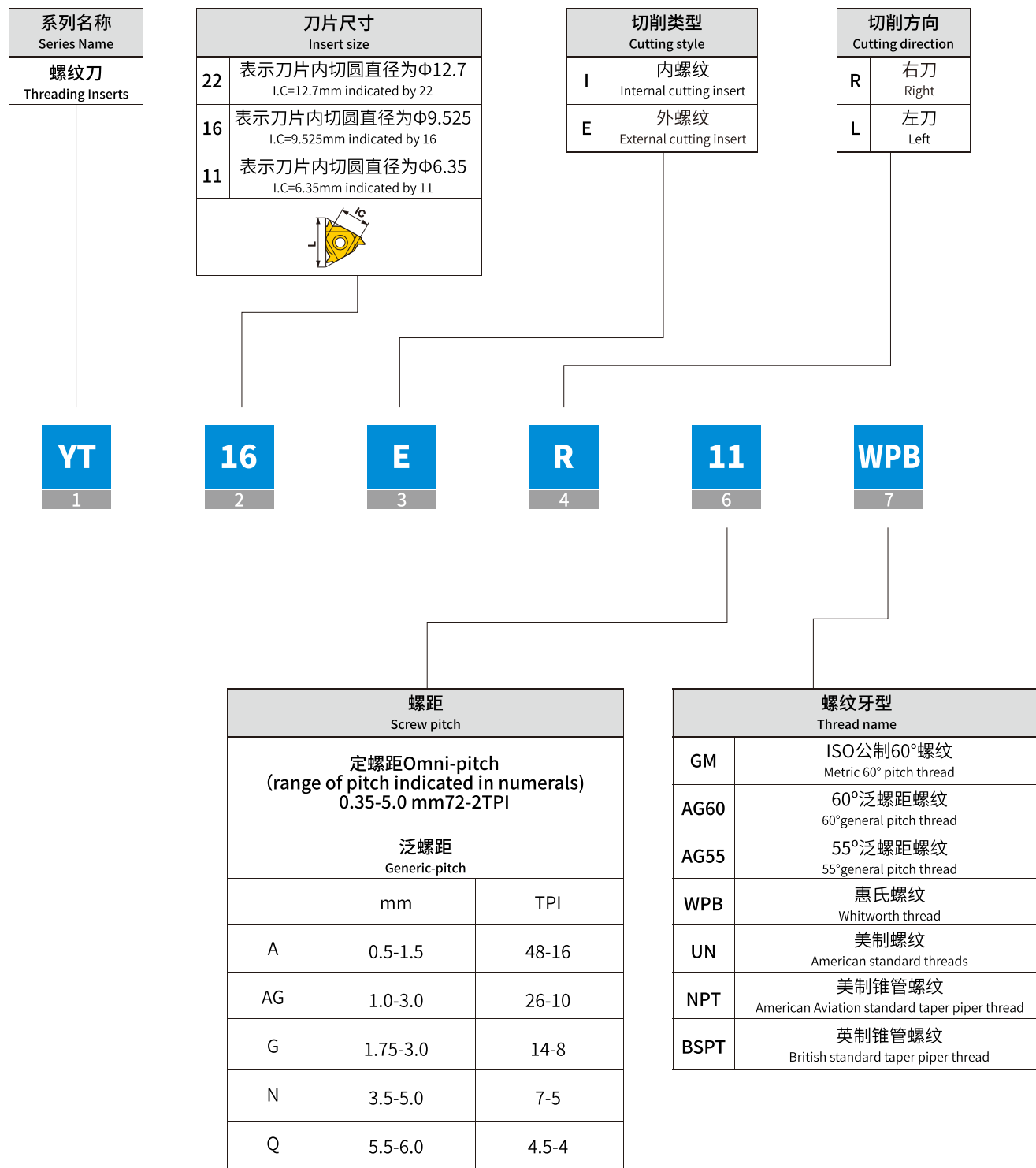
Grade	ISO	Types of Coating	Coating Composition	Features and Applications
KT8294	P10~P30 M10~M30	PVD Copper	TiSiAlN	1. It uses a submicron grain cemented carbide substrate combined with an ultra fine TiAlSiN nano coating, featuring excellent wear resistance and high - temperature resistance. 2. It is suitable for threading of steel and stainless steel.
KT8254S	M15~M30 S15~S20	PVD Copper	TiAlSiN	1. A fine-grained cemented carbide substrate with medium cobalt content is combined with a TiAlSiN coating featuring high surface finish and wear resistance, offering excellent wear resistance, toughness, and thermal stability. 2. It is suitable for threading of stainless steel.
KT6109	H05~H25	PVD Multiple-color	AlTiCrSiN	1.The ultra-fine grain cemented carbide matrix with low cobalt content is used with the newly upgraded multi-layer composite nano PVD coating to obtain strong coating adhesion, high wear resistance and high oxidation resistance. 2. It is suitable for threading of hardend steel over HRC 42.

A	车削刀片
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螺纹刀产品牌号一览表 Recommended Grade Table

工件材料 Workpiece materials	ISO代号 ISO Code	CVD	PVD	金属陶瓷 Cermet	硬质合金 Cemented carbide	超硬材料 Superhard materials
P	P01					
	P10		KT8294			
	P20					
	P30					
	P40					
M	M01					
	M10		KT8254S			
	M20		KT8294			
	M30					
	M40					
K	K01					
	K10					
	K20					
	K30					
N	N01					
	N10					
	N20					
	N30					
S	S01					
	S10					
	S20					
	S30					
H	H01		KT6109			
	H10					
	H20					
	H30					

螺纹刀片型号命名规则 Threading Inserts Naming Rules


A
车削刀片

B
铣削刀片

C
铝合金刀片

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孔加工刀片

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H
刀杆和刀盘

I
加工案例

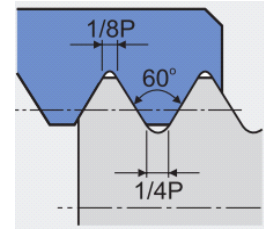
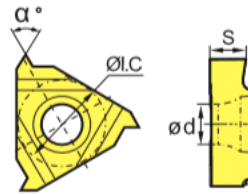
J
通用技术信息

公制 ISO螺纹 有顶切 ISO Metric Threading Inserts With End

ISO 965-1980 DIN 13

GB/T 197-2003

公差等级：6g/6H



产品 Inserts Shape		型号 Type		尺寸 Dimensions (mm)				PVD涂层		
		右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
外螺纹 External threading		YT16ER-0.5ISO-S	YT16EL-0.5ISO-S	0.5	9.525	3.52	4.0	▲	▲	●
		YT16ER-0.75ISO-S	YT16EL-0.75ISO-S	0.75	9.525	3.52	4.0	▲	▲	●
		YT16ER-1.0ISO-S	YT16EL-1.0ISO-S	1	9.525	3.52	4.0	▲	▲	●
		YT16ER-1.25ISO-S	YT16EL-1.25ISO-S	1.25	9.525	3.52	4.0	▲	▲	●
		YT16ER-1.5ISO-S	YT16EL-1.5ISO-S	1.5	9.525	3.52	4.0	▲	▲	●
		YT16ER-1.75ISO-S	YT16EL-1.75ISO-S	1.75	9.525	3.52	4.0	▲	▲	●
		YT16ER-2.0ISO-S	YT16EL-2.0ISO-S	2	9.525	3.52	4.0	▲	▲	●
		YT16ER-2.5ISO-S	YT16EL-2.5ISO-S	2.5	9.525	3.52	4.0	▲	▲	●
		YT16ER-3.0ISO-S	YT16EL-3.0ISO-S	3	9.525	3.52	4.0	▲	▲	●
		YT22ER-3.5ISO-S	YT22EL-3.5ISO-S	3.5	12.7	4.65	5.0	▲	▲	●
		YT22ER-4.0ISO-S	YT22EL-4.0ISO-S	4	12.7	4.65	5.0	▲	▲	●
		YT22ER-4.5ISO-S	YT22EL-4.5ISO-S	4.5	12.7	4.65	5.0	▲	▲	●
		YT22ER-5.0ISO-S	YT22EL-5.0ISO-S	5	12.7	4.65	5.0	▲	▲	●
		YT22ER-5.5ISO-S	YT22EL-5.5ISO-S	5.5	12.7	4.65	5.0	▲	▲	●
		YT22ER-6.0ISO-S	YT22EL-6.0ISO-S	6	12.7	4.65	5.0	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

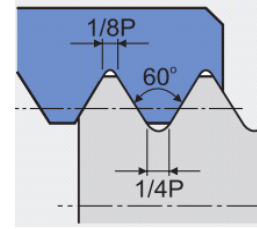
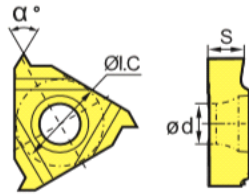
● 按订单生产可选牌号 Make-to-order

公制 ISO螺纹 有顶切 ISO Metric Threading Inserts With End

ISO 965-1980 DIN 13

GB/T 197-2003

公差等级：6g/6H



产品 Inserts Shape		型号 Type		尺寸 Dimensions (mm)				PVD涂层		
		右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
内 螺 纹 Internal threading		YT11IR-0.5ISO-S	YT11IL-0.5ISO-S	0.50	6.35	3.05	3.2	▲	▲	●
		YT11IR-0.75ISO-S	YT11IL-0.75ISO-S	0.75	6.35	3.05	3.2	▲	▲	●
		YT11IR-1.0ISO-S	YT11IL-1.0ISO-S	1.00	6.35	3.05	3.2	▲	▲	●
		YT11IR-1.25ISO-S	YT11IL-1.25ISO-S	1.25	6.35	3.05	3.2	▲	▲	●
		YT11IR-1.5ISO-S	YT11IL-1.5ISO-S	1.5	6.35	3.05	3.2	▲	▲	●
		YT11IR-1.75ISO-S	YT11IL-1.75ISO-S	1.75	6.35	3.05	3.2	▲	▲	●
		YT11IR-2.0ISO-S	YT11IL-2.0ISO-S	2	6.35	3.05	3.2	▲	▲	●
		YT16IR-0.5ISO-S	YT16IL-0.5ISO-S	0.50	9.525	3.52	4.0	▲	▲	●
		YT16IR-0.75ISO-S	YT16IL-0.75ISO-S	0.75	9.525	3.52	4.0	▲	▲	●
		YT16IR-1.0ISO-S	YT16IL-1.0ISO-S	1.00	9.525	3.52	4.0	▲	▲	●
		YT16IR-1.25ISO-S	YT16IL-1.25ISO-S	1.25	9.525	3.52	4.0	▲	▲	●
		YT16IR-1.5ISO-S	YT16IL-1.5ISO-S	1.50	9.525	3.52	4.0	▲	▲	●
		YT16IR-1.75ISO-S	YT16IL-1.75ISO-S	1.75	9.525	3.52	4.0	▲	▲	●
		YT16IR-2.0ISO-S	YT16IL-2.0ISO-S	2.00	9.525	3.52	4.0	▲	▲	●
		YT16IR-2.5ISO-S	YT16IL-2.5ISO-S	2.50	9.525	3.52	4.0	▲	▲	●
		YT16IR-3.0ISO-S	YT16IL-3.0ISO-S	3.00	9.525	3.52	4.0	▲	▲	●
		YT22IR-3.5ISO-S	YT22IL-3.5ISO-S	3.50	12.70	4.65	5.0	▲	▲	●
		YT22IR-4.0ISO-S	YT22IL-4.0ISO-S	4.00	12.70	4.65	5.0	▲	▲	●
		YT22IR-4.5ISO-S	YT22IL-4.5ISO-S	4.50	12.70	4.65	5.0	▲	▲	●
		YT22IR-5.0ISO-S	YT22IL-5.0ISO-S	5.00	12.70	4.65	5.0	▲	▲	●
		YT22IR-5.5ISO-S	YT22IL-5.5ISO-S	5.50	12.70	4.65	5.0	▲	▲	●
		YT22IR-6.0ISO-S	YT22IL-6.0ISO-S	6.00	12.70	4.65	5.0	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

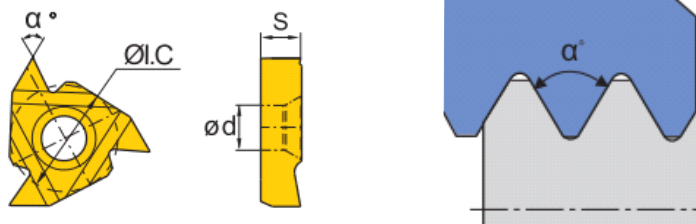
J 通用技术信息

泛用螺纹 无顶切 General Pitch Threading Inserts Without End

ISO 965-1980 DIN 13

GB/T 197-2003

公差等级：6g/6H



产品 Inserts Shape			型号 Type		尺寸 Dimensions (mm)				PVD涂层		
			右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
外 螺 纹 External threading	55°		YT16ER-A55-S	YT16EL-A55-S	0.5-1.5	9.525	3.52	4	▲	▲	●
			YT16ER-G55-S	YT16EL-G55-S	1.75-3.0	9.525	3.52	4	▲	▲	●
			YT16ER-AG55-S	YT16EL-AG55-S	0.5-3.0	9.525	3.52	4	▲	▲	●
			YT22ER-N55-S	YT22EL-N55-S	3.5-5.0	12.7	4.65	5	▲	▲	●
	60°		YT11ER-AG60-S		0.5-1.5	6.35	3.05	3.2	▲	▲	●
			YT16ER-A60-S	YT16EL-A60-S	0.5-1.5	9.525	3.52	4	▲	▲	●
			YT16ER-G60-S	YT16EL-G60-S	1.75-3.0	9.525	3.52	4	▲	▲	●
			YT16ER-AG60-S	YT16EL-AG60-S	0.5-3.0	9.525	3.52	4	▲	▲	●
			YT22ER-N60-S	YT22EL-N60-S	3.5-5.0	12.7	4.65	5	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

产品 Inserts Shape			型号 Type		尺寸 Dimensions (mm)				PVD涂层		
			右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
内 螺 纹 Internal threading	55°		YT11IR-A55-S	YT11IL-A55-S	0.5-1.5	6.350	3.05	3.2	▲	▲	●
			YT16IR-A55-S	YT16IL-A55-S	0.5-1.5	9.525	3.52	4.0	▲	▲	●
			YT16IR-G55-S	YT16IL-G55-S	1.75-3.0	9.525	3.52	4.0	▲	▲	●
			YT16IR-AG55-S	YT16IL-AG55-S	0.5-3.0	9.525	3.52	4.0	▲	▲	●
			YT22IR-N55-S	YT22IL-N55-S	3.5-5.0	22.000	4.65	5.0	▲	▲	●
	60°		YT11IR-A60-S	YT11IL-A60-S	0.5-1.5	6.350	3.05	3.2	▲	▲	●
			YT16IR-A60-S	YT16IL-A60-S	0.5-1.5	9.525	3.52	4.0	▲	▲	●
			YT16IR-G60-S	YT16IL-G60-S	1.75-3.0	9.525	3.52	4.0	▲	▲	●
			YT16IR-AG60-S	YT16IL-AG60-S	0.5-3.0	9.525	3.52	4.0	▲	▲	●
			YT22IR-N60-S	YT22IL-N60-S	3.5-5.0	22.000	4.65	5.0	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

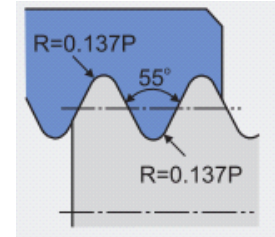
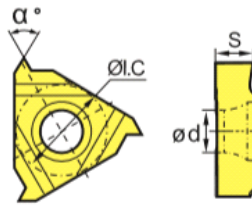
● 按订单生产可选牌号 Make-to-order

惠氏螺纹 有顶切 Whitworth Threading Inserts With End

ISO 228/1:1982

DIN 259,B.S.84:1956

公差等级:Medium classA



产品 Inserts Shape		型号 Type		尺寸 Dimensions (mm)			PVD涂层			
		右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
外 螺 纹 External threading		YT16ER-8WPB-S	YT16EL-8WPB-S	8	9.525	3.52	4	▲	▲	●
		YT16ER-9WPB-S	YT16EL-9WPB-S	9	9.525	3.52	4	▲	▲	●
		YT16ER-10WPB-S	YT16EL-10WPB-S	10	9.525	3.52	4	▲	▲	●
		YT16ER-11WPB-S	YT16EL-11WPB-S	11	9.525	3.52	4	▲	▲	●
		YT16ER-12WPB-S	YT16EL-12WPB-S	12	9.525	3.52	4	▲	▲	●
		YT16ER-14WPB-S	YT16EL-14WPB-S	14	9.525	3.52	4	▲	▲	●
		YT16ER-16WPB-S	YT16EL-16WPB-S	16	9.525	3.52	4	▲	▲	●
		YT16ER-18WPB-S	YT16EL-18WPB-S	18	9.525	3.52	4	▲	▲	●
		YT16ER-19WPB-S	YT16EL-19WPB-S	19	9.525	3.52	4	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

产品 Inserts Shape		型号 Type		尺寸 Dimensions (mm)				PVD涂层		
		右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
内 螺 纹 Internal threading		YT16IR-8WPB-S	YT16IL-8WPB-S	8	9.525	3.52	4	▲	▲	●
		YT16IR-9WPB-S	YT16IL-9WPB-S	9	9.525	3.52	4	▲	▲	●
		YT16IR-10WPB-S	YT16IL-10WPB-S	10	9.525	3.52	4	▲	▲	●
		YT16IR-11WPB-S	YT16IL-11WPB-S	11	9.525	3.52	4	▲	▲	●
		YT16IR-12WPB-S	YT16IL-12WPB-S	12	9.525	3.52	4	▲	▲	●
		YT16IR-14WPB-S	YT16IL-14WPB-S	14	9.525	3.52	4	▲	▲	●
		YT16IR-16WPB-S	YT16IL-16WPB-S	16	9.525	3.52	4	▲	▲	●
		YT16IR-18WPB-S	YT16IL-18WPB-S	18	9.525	3.52	4	▲	▲	●
		YT16IR-19WPB-S	YT16IL-19WPB-S	19	9.525	3.52	4	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

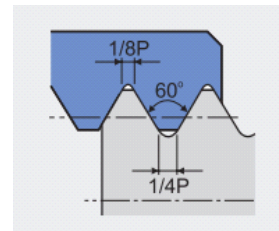
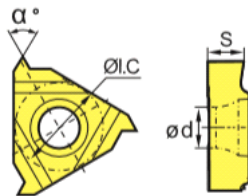
I 加工案例

J 通用技术信息

UN统一协定螺纹 有顶切 UN Threading Inserts With End

ASME B1.1-1989

公差等级: 2A/2B



产品 Inserts Shape		型号 Type		尺寸 Dimensions (mm)				PVD涂层		
		右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
外螺纹 External threading		YT16ER-8UN-S	YT16EL-8UN-S	8	9.525	3.52	4.0	▲	▲	●
		YT16ER-10UN-S	YT16EL-10UN-S	10	9.525	3.52	4.0	▲	▲	●
		YT16ER-12UN-S	YT16EL-12UN-S	12	9.525	3.52	4.0	▲	▲	●
		YT16ER-14UN-S	YT16EL-14UN-S	14	9.525	3.52	4.0	▲	▲	●
		YT16ER-16UN-S	YT16EL-16UN-S	16	9.525	3.52	4.0	▲	▲	●
		YT16ER-18UN-S	YT16EL-18UN-S	18	9.525	3.52	4.0	▲	▲	●
		YT16ER-20UN-S	YT16EL-20UN-S	20	9.525	3.52	4.0	▲	▲	●
		YT16ER-24UN-S	YT16EL-24UN-S	24	9.525	3.52	4.0	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

产品 Inserts Shape		型号 Type		尺寸 Dimensions (mm)				PVD涂层		
		右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
内螺纹 Internal threading		YT16IR-8UN-S	YT16IL-8UN-S	8	9.525	3.52	4.0	▲	▲	●
		YT16IR-10UN-S	YT16IL-10UN-S	10	9.525	3.52	4.0	▲	▲	●
		YT16IR-12UN-S	YT16IL-12UN-S	12	9.525	3.52	4.0	▲	▲	●
		YT16IR-14UN-S	YT16IL-14UN-S	14	9.525	3.52	4.0	▲	▲	●
		YT16IR-16UN-S	YT16IL-16UN-S	16	9.525	3.52	4.0	▲	▲	●
		YT16IR-18UN-S	YT16IL-18UN-S	18	9.525	3.52	4.0	▲	▲	●
		YT16IR-20UN-S	YT16IL-20UN-S	20	9.525	3.52	4.0	▲	▲	●
		YT16IR-24UN-S	YT16IL-24UN-S	24	9.525	3.52	4.0	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

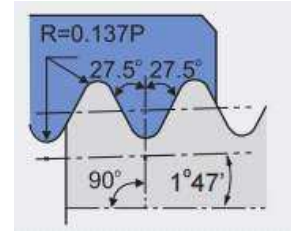
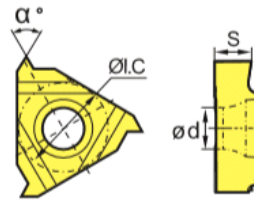
● 按订单生产可选牌号 Make-to-order

BSPT英国标准锥管螺纹 有顶切 BSPT Threading Inserts With End

ISO 7/1:1994

B.S.21:1985

Standard BSPT



产品 Inserts Shape		型号 Type		尺寸 Dimensions (mm)				PVD涂层		
		右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
External 外螺纹		YT16ER-11BSPT-S	YT16EL-11BSPT-S	11	9.525	3.52	4	▲	▲	●
		YT16ER-14BSPT-S	YT16EL-14BSPT-S	14	9.525	3.52	4	▲	▲	●
		YT16ER-19BSPT-S	YT16EL-19BSPT-S	19	9.525	3.52	4	▲	▲	●
		YT16ER-28BSPT-S	YT16EL-28BSPT-S	28	9.525	3.52	4	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

产品 Inserts Shape		型号 Type		尺寸 Dimensions (mm)				PVD涂层		
		右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
Internal 内螺纹		YT16IR-11BSPT-S	YT16IL-11BSPT-S	11	9.525	3.52	4	▲	▲	●
		YT16IR-14BSPT-S	YT16IL-14BSPT-S	14	9.525	3.52	4	▲	▲	●
		YT16IR-19BSPT-S	YT16IL-19BSPT-S	19	9.525	3.52	4	▲	▲	●
		YT16IR-28BSPT-S	YT16IL-28BSPT-S	28	9.525	3.52	4	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

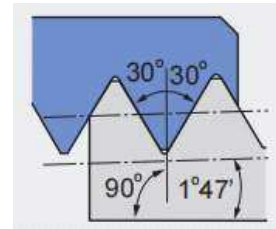
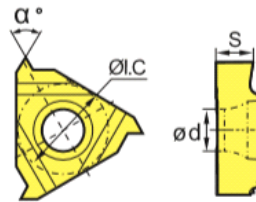
I 加工案例

J 通用技术信息

NPT美国标准锥管螺纹 有顶切 NPT Threading Inserts With End

ASME B1.20.1-1983

Standard NPT



产品 Inserts Shape		型号 Type		尺寸 Dimensions (mm)				PVD涂层		
		右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
External 外螺纹		YT16ER-8NPT-S	YT16EL-8NPT-S	8	9.525	3.52	4	▲	▲	●
		YT16ER-11.5NPT-S	YT16EL-11.5NPT-S	11.5	9.525	3.52	4	▲	▲	●
		YT16ER-14NPT-S	YT16EL-14NPT-S	14	9.525	3.52	4	▲	▲	●
		YT16ER-18NPT-S	YT16EL-18NPT-S	18	9.525	3.52	4	▲	▲	●
		YT16ER-27NPT-S	YT16EL-27NPT-S	27	9.525	3.52	4	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

产品 Inserts Shape		型号 Type		尺寸 Dimensions (mm)				PVD涂层		
		右手型 Right hand type	左手型 Left hand type	螺距 pitch	ØI.C	S	Φd	KT8294	KT8254S	KT6109
Internal 内螺纹		YT16IR-8NPT-S	YT16IL-8NPT-S	8	9.525	3.52	4	▲	▲	●
		YT16IR-11.5NPT-S	YT16IL-11.5NPT-S	11.5	9.525	3.52	4	▲	▲	●
		YT16IR-14NPT-S	YT16IL-14NPT-S	14	9.525	3.52	4	▲	▲	●
		YT16IR-18NPT-S	YT16IL-18NPT-S	18	9.525	3.52	4	▲	▲	●
		YT16IR-27NPT-S	YT16IL-27NPT-S	27	9.525	3.52	4	▲	▲	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

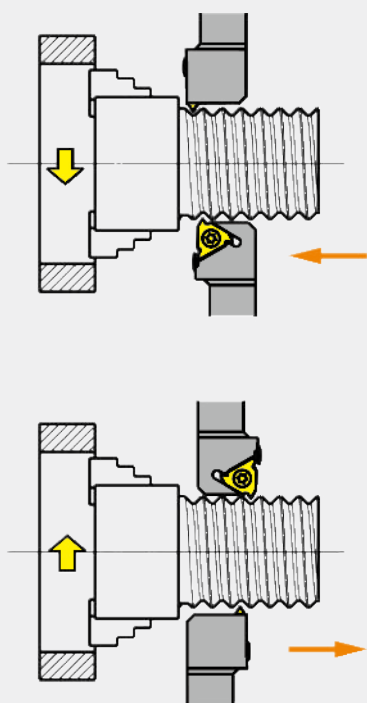
● 按订单生产可选牌号 Make-to-order

螺纹加工应用资料 为获得最好的螺纹加工效果, 请按照以下步骤:

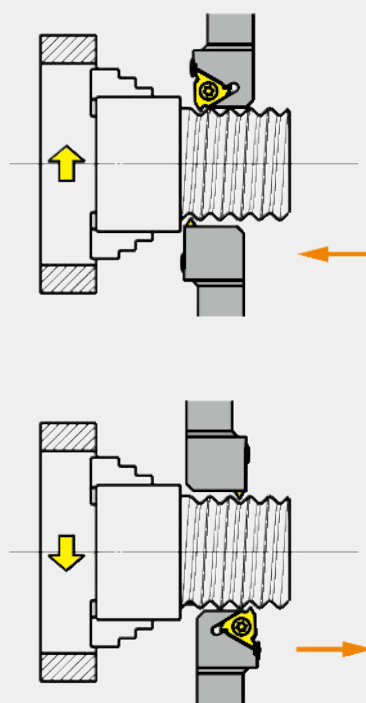
- ① 选择恰当的螺纹加工方式
- ② 决定螺旋升角, 选择刀垫
- ③ 选择合适的刀片和刀杆尺寸
- ④ 参照标准螺纹的加工程序编制用参数表, 选择合适的螺纹切削走刀数据
- ⑤ 选择进刀方法

螺纹刀具加工方式

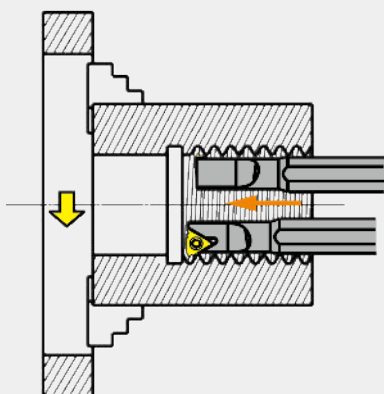
外螺纹加工 右螺纹



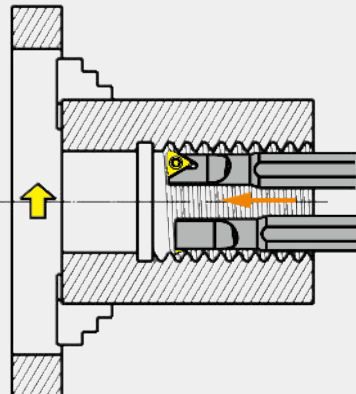
外螺纹加工 左螺纹



内螺纹加工 右螺纹



内螺纹加工 左螺纹



A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

决定螺旋升角, 选择刀垫

螺纹车削后角基本上是顺着刀边(后刀面)。这将对散热、刀具磨损扩展以及后续的刀具寿命、生产安全性和切削的螺纹质量产生显著影响。刀片螺纹牙型后刀面的后角取决于螺纹的螺旋升角。因为两者有些相似。如果刀片的刀倾角与螺旋升角不一样, 则刀片的后角亦会不同。

螺纹的螺旋升角必须与刀片的刀倾角一致, 以尽可能地避免在一个后刀面上过多的磨损而导致刀具寿命缩短。螺旋升角按照下式计算:

$$e = \arctan \frac{P}{d_2 \times \pi}$$

P=螺距

d_2 =螺纹中径

最常用的刀倾角为1°, MT标准刀垫其倾角也为1°。

后角的计算:

刀具的后角 β 按照下式计算:

$$\beta = \arctan (\tan \theta \times \tan \alpha)$$

2 θ =螺纹牙型角

α =刀具的前角, 标准刀具外螺纹为10°, 内螺纹为15°

当螺纹的螺旋升角 $\leq$ 刀具后角时, 刀片侧面会产生干涉, 必须更换刀垫。

请通过更换刀垫将螺纹螺旋升角与刀垫刀倾角差值调整至2°~0°之内。

例如: 对于P=1.5、 d_2 =24mm

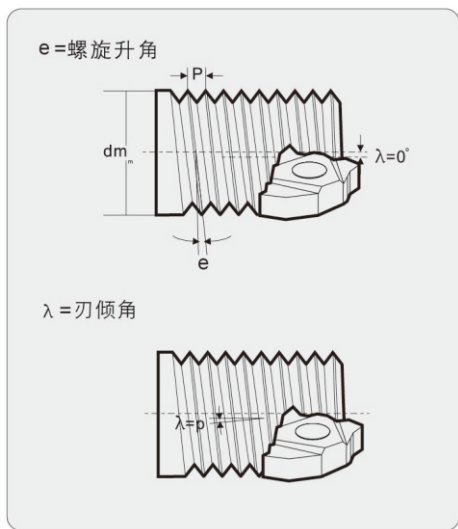
螺旋升角1.14°-(2°~0°)=刀倾角(-0.86°~1.14°)

使用标准刀垫1°即可切削。

刀垫规格表如下:

螺距范围	刀片尺寸	倾斜角	刀垫
0.5-3.0	16	0	MT16-00MN
		1	MT16-01MN
		2	MT16-02MN
		3	MT16-03MN
3.5-6.0	22	0	MT22-00MN
		1	MT22-01MN
		2	MT22-02MN
		3	MT22-03MN

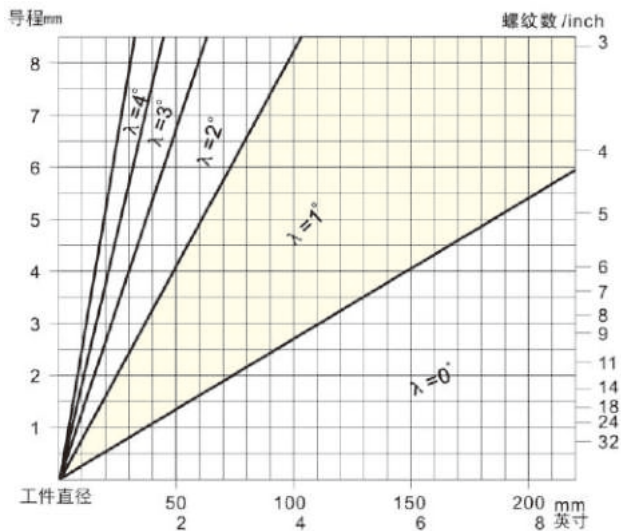
注: 我公司螺纹刀具刀垫标准配置为1度。(MT16-01MN或MT22-01MN)



具体值参考下表:

螺纹牙型角2 θ	β	
	外螺纹	内螺纹
60°	5.8°	8.79°
55°	5.24°	7.94°
30°	2.7°	4.1°
29°	2.6°	3.96°

选择刀垫:



切削用量推荐表

ISO	材料		单位切削力 Kc0.4 N/mm ²	硬度 HB	牌号
					KT8294 KT8254S KT6109
					切削速度m/min
P	碳素钢	C=0.15%	1900	125	150-175
		C=0.35%	2100	150	140-155
		C=0.60%	2250	200	130-145
	合金钢	退火	2100	180	110-130
		淬硬	2600	275	80-100
		淬硬	2700	300	70-90
		淬硬	2850	350	60-80
	高合金钢	退火	2600	200	90-115
		淬硬	3900	325	70-90
	铸钢	非合金	2000	180	180-210
		低合金	2500	200	90-115
		高合金	2700	225	90-115
		马氏体钢12%Mn	3600	250	40-50
M	不锈钢	奥氏体	2450	180	110-130
		马素体/铁素体	2300	200	130-170
K	可锻铸铁	铁素体	1100	130	110-140
		珠光体	1100	230	85-105
	灰口铸铁	低拉伸强度	1100	180	110-140
		高拉伸强度	1500	260	90-115
	球墨铸铁	铁素体	1100	160	110-130
		珠光体	1800	250	80-100
N	铝合金	未时效处理	500	60	1300-1450
		时效处理	800	100	450-500
	铸铝合金	未时效处理	750	75	430-470
		时效处理	900	90	250-290
S	耐热合金	镍基	退火	3000	35-50
			时效	3050	25-35
		镍基或钴基	退火	3500	15-25
			时效	4150	10-20
			铸造	4150	10-15
H	淬火钢	淬火钢	4500	HRC55	40-50

◆ 上表为范围值,实际切削时,可适当取高值,当试用新切削速度时,应仔细查看切削刃的状况。

◆ 进行不锈钢螺纹切削时,应使用足够高的切削速度,以避免“积屑瘤”的形成。

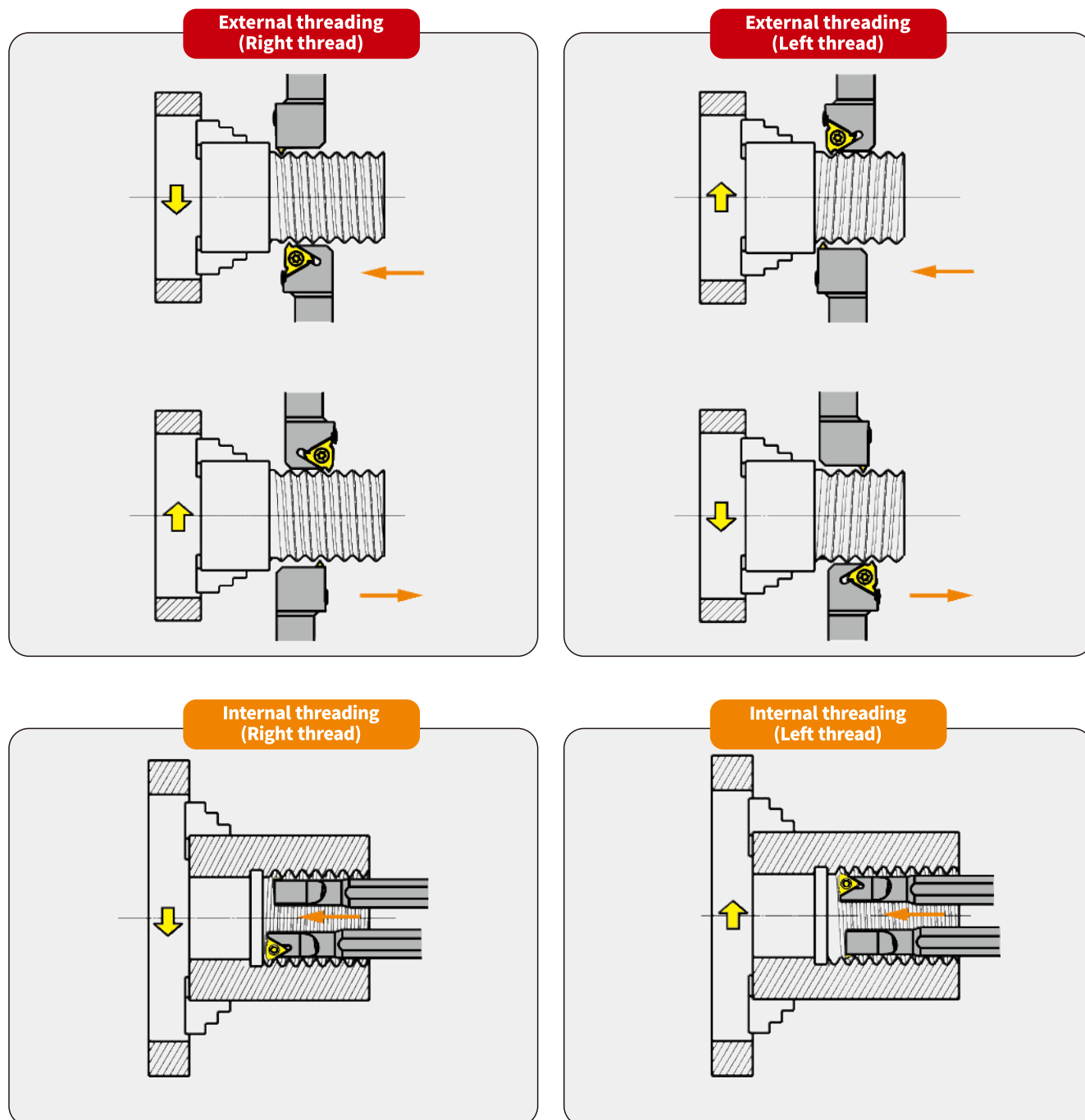
◆ 当切削小螺距螺纹和使用小刀尖半径刀具时,应适当减小切削参数。

Application of Threading Inserts

Please follow the following steps to get the best threading results:

- ① Select proper thread machining method.
- ② Decide helical angle, select shim.
- ③ Choose proper insert and tool holder size.
- ④ By checking reference table of standard threading program, select feasible cutting parameters.
- ⑤ Selection feed way.

Machining ways



Decide helical angle, select shim

The cutting edge clearance angle affects the dissipation of heat, balance of insert wear, thread pitch quality, and security of the cutting edge. The clearance angle of thread pitch on clearance face is determined by thread helical angle. These two angles are similar to each other. If the inclined angle of the insert is different from the helical angle, then clearance angle won't be the same. The pitch of the helical angle must be the same as the inclined angle of the insert in order to prevent premature wear on the clearance face. The helical angle is calculated as below:

$$e = \arctan \frac{P}{d_2 \times \pi}$$

P=Pitch

d_2 =pitch diameter

The common inclined angel is 1°, MT standard shim and its inclined angle is 1° too

The calculation of clearance angle:

Clearance angle B is calculated as below:

$$\beta = \arctan (\tan \theta \times \tan \alpha)$$

2θ=Thread profile angle

α=The rake angle of external standard threading tools is 10°; the rake angle of internal standard threading tools is 15°

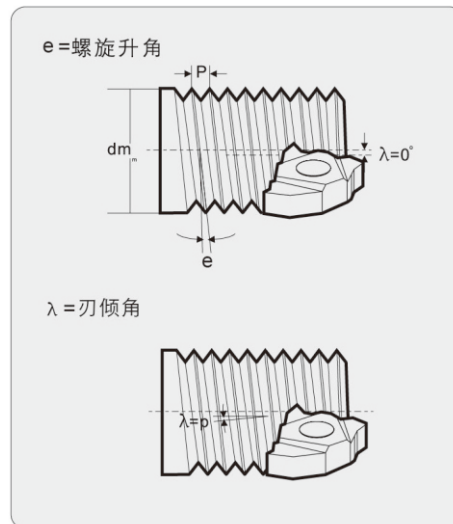
The shim has to be changed when helical angle of thread is < clearance angle of the insert, which would cause interference with insert flank. Please change shim to adjust the difference between helical angle of thread and inclined angle of shim to be within 2°~0°.

For example: when P=1.5mm, $D_2=24$ mm
 Helical Angle $1.14^\circ - (2^\circ - 0^\circ) = \text{Inclined Angle}$
 $(-0.86^\circ \sim 1.14^\circ)$
 It's feasible by using standard shim 1°.

Shim specification table are as following:

Screw pitch range	Insert dimensions	Inclined angle	Shim
0.5-3.0	16	0	MT16-00MN
		1	MT16-01MN
		2	MT16-02MN
		3	MT16-03MN
3.5-6.0	22	0	MT22-00MN
		1	MT22-01MN
		2	MT22-02MN
		3	MT22-03MN

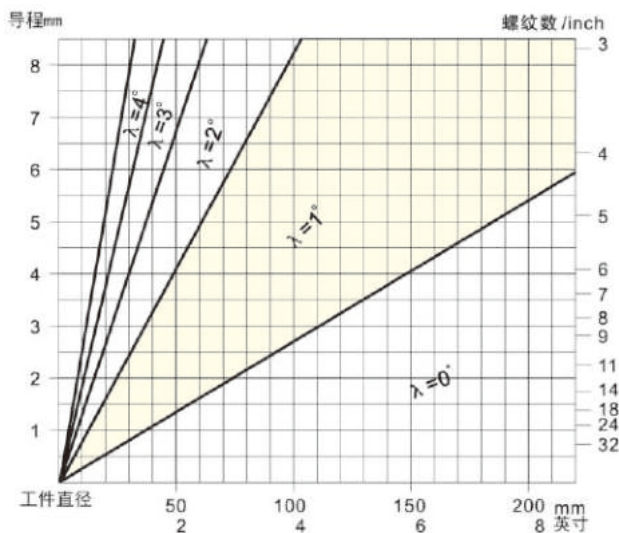
注: 我公司螺纹刀具刀垫标准配置为1度。(MT16-01MN或MT22-01MN)



Please refer to table below for actual value:

Thread profile angle 2θ	β	
	External thread	Internal thread
60°	5.8°	8.79°
55°	5.24°	7.94°
30°	2.7°	4.1°
29°	2.6°	3.96°

Select shim:



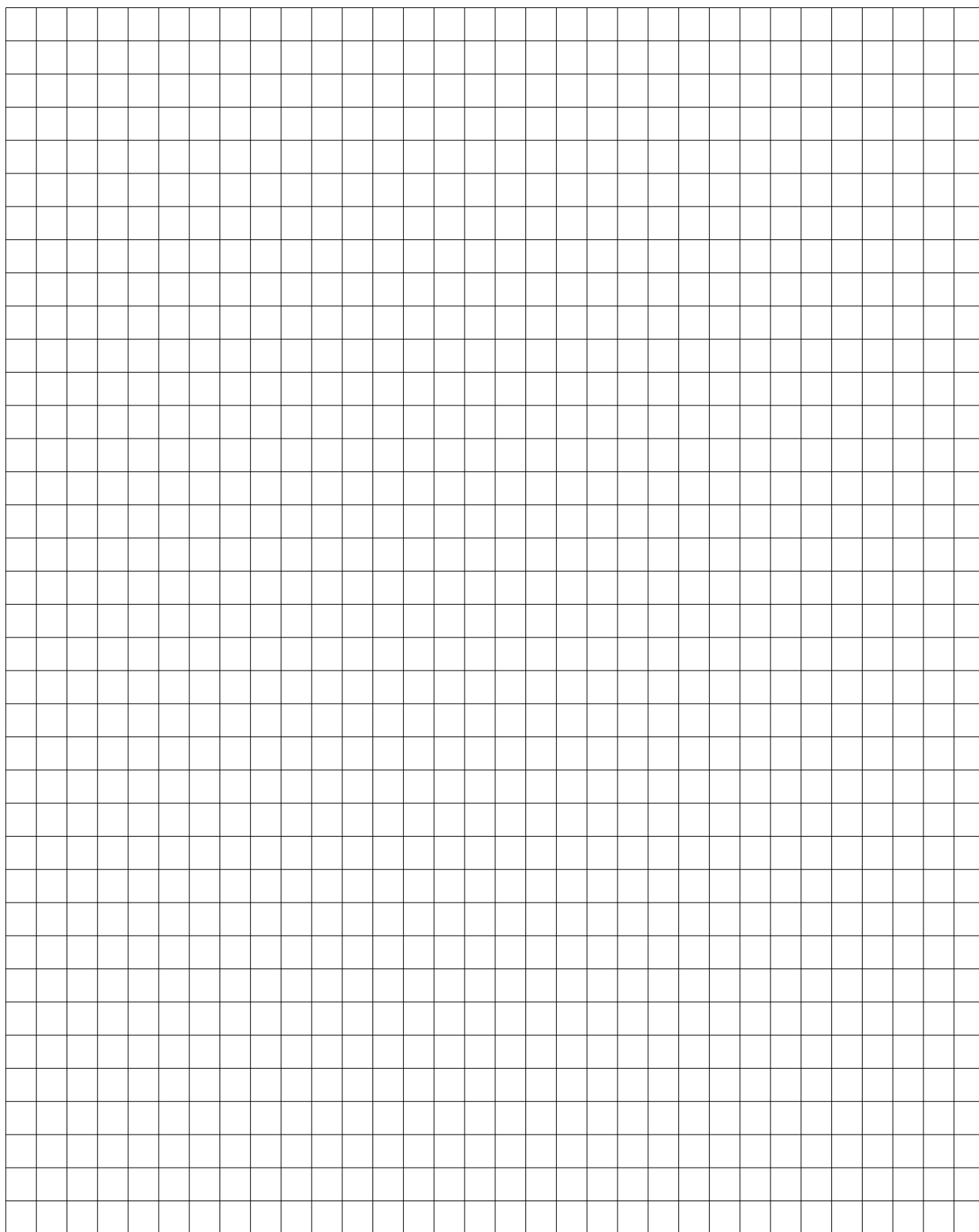
Recommended cutting parameters

ISO	Material		Unit cutting force Kc0.4 N/mm ²	Hardness HB	Grade
					KT8294 KT8254S KT6109
					Cutting speed(m/min)
P	Carbon steel	C=0.15%	1900	125	500-600
		C=0.35%	2100	150	450-500
		C=0.60%	2250	200	400-500
	Alloy steel	Anneal	2100	180	360-400
		Hardened	2600	275	260-300
		Hardened	2700	300	230-300
		Hardened	2850	350	200-260
	High alloy steel	Anneal	2600	200	300-400
		Hardened	3900	325	230-300
	Cast steel	Non-alloy	2000	180	600-700
		low alloy	2500	200	300-400
		high alloy	2700	225	300-400
		Martensite steel 12%Mn	3600	250	130-160
M	Stainless steel	Austenite	2450	180	360-400
		Martensite/Ferrite	2300	200	400-550
K	Malleable cast iron	Ferrite	1100	130	360-450
		Pearlite	1100	230	300-300
	Gray cast iron	Low tensile-strength	1100	180	360-450
		High tensile-strength	1500	260	300-350
N	Al alloy	Non-aging treatment	500	60	4300-4800
		Aging treatment	800	100	1500-1600
	Cast aluminum alloy	Non-aging treatment	750	75	1400-1500
		Aging treatment	900	90	800-1000
S	Heat resistant alloy	Iron base	Anneal	200	100-150
			Aging	280	90-110
	Heat resistant alloy	Ni- or Co-base	Anneal	250	50-80
			Aging	350	30-60
H	Hardened steel	Hardened steel	4150	320	30-50
			4500	HRC55	130-160

Note: • The values in the above table are range values. High values in the range could be considered in actual cutting. When trying new cutting speed, please check the cutting edge condition before operation.

• In stainless steel threading, high cutting speed should be used to prevent built-up edge.

• The cutting parameters should be reduced when cutting small pitch thread and when using tools with small nose radius.


A
 车削刀片

B
 铣削刀片

C
 铝合金刀片

D
 孔加工刀片

E
 刮管刀片

F
 非标异形刀片

G
 圆棒和立铣刀

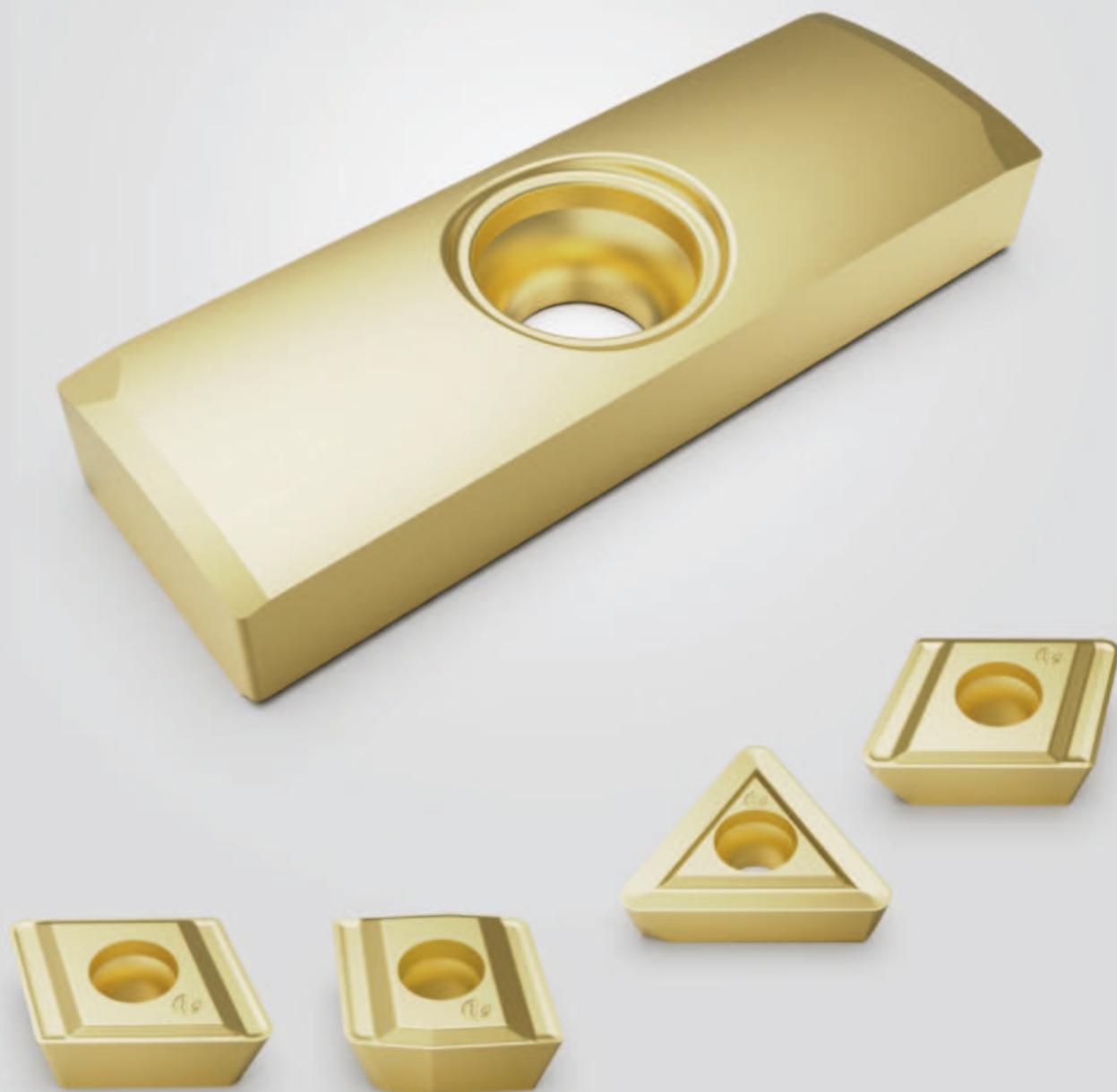
H
 刀杆和刀盘

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深孔钻刀片

DEEP-HOLE DRILLING INSERTS



独特槽型结构，排屑流畅优化刃口，几何角度，高效切削，生产效率倍增；
采用高硬质合金材质寿命延长 30%，适用于钢、不锈钢、铸铁等材料，轻松应对深孔加工挑战。



孔加工刀片

Hole Machining Inserts

PVD硬质合金牌号 PVD Coated Grades	001
钻削产品牌号一览表	
Recommended Grade Overview For Drilling Inserts	003
深孔钻刀片 Deep-hole Drilling Inserts	004
深孔钻切削参数表 Deep-hole Drilling Cutting Parameters	010
浅孔钻刀片 Shallow-hole Drilling Inserts	013
浅孔钻切削参数表 Shallow-hole Drilling Cutting Parameters	014

钻削牌号

PVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KT1378G	P15~P30 M15~M30	PVD 紫铜色	AlTiN	1.结合硬质合金基体的高韧性和涂层的高耐磨性,在加工中表现出长寿命、高稳定性。 2.适用于钢件、不锈钢材质的铣削、钻削加工。
KT8208	P10~P25 M10~M25	PVD 紫红色	TiAlSiN	1.采用亚微晶粒的中钴基体,搭配极高热稳定性的含硅PVD涂层,具有耐磨性好,耐高温性能优异的特点。 2.适用于钢件、不锈钢材料的钻削加工,适合追求耐磨性的场合。
KT8296	P10~P30 M10~M30	PVD 灰黑色	TiAlN	1.较高耐磨性的细晶粒中钴基体,搭配通用性好的TiAlN涂层,具有良好的膜基结合力、耐磨性和抗氧化性能。 2.适用于合金钢、不锈钢等材料的钻削加工,通用性很好的材质。
KT8295	P10~P30 M10~M30	PVD 黄色	TiAlN	1.采用中钴含量的高耐磨性细晶硬质合金基体,搭配高铝TiAlN纳米涂层,具有高的涂层硬度、优良的耐高温性能,为切削刃提供有效保护。 2.适用于合金钢、不锈钢等材料的钻削加工。
KT6259	H15~H30	PVD 七彩色	AlTiCrSiN	1.采用低钴含量的细晶粒硬质合金基体,结合优异性能的纳米结构PVD涂层,具有优异的耐磨性和耐高温性能。 2.适用于淬硬钢材质的钻削加工。

A

车削刀片

B

铣削刀片

C

铝合金刀片

D

孔加工刀片

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Grade Information

PVD Coated Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Applications
KT1378G	P15~P30 M15~M30	PVD Purple Bronze	AlTiN	1. Combining the high toughness of the cemented carbide substrate with the high wear resistance of the coating, it demonstrates long tool life and high stability during machining. 2. It is suitable for milling and drilling of steel and stainless steel.
KT8208	P10~P25 M10~M25	PVD Purple	TiAlSiN	1. Combining the sub-micron grain medium cobalt cemented carbide substrate with an ultra high thermal stability silicon containing PVD coating, it features excellent wear resistance and high temperature resistance. 2. It is suitable for drilling steel and stainless steel, ideal for machining requiring high wear resistance.
KT8296	P10~P30 M10~M30	PVD Gray-black	TiAlN	1. The fine-grain medium cobalt substrate with high wear resistance is match with high universality of TiAlN coating, it has good film-based adhesion, wear resistance and oxidation resistance. 2. It is a general grade for drilling of materials such as alloy steel and stainless steel.
KT8295	P10~P30 M10~M30	PVD Yellow	TiAlN	1. It uses a fine grained medium cobalt cemented carbide substrate with high wear resistance, combined with a high aluminum TiAlN nano coating. It has high coating hardness and excellent high temperature resistance, effectively protecting the cutting edge. 2. It is suitable for drilling of alloy steel, stainless steel and other materials.
KT6259	H15~H30	PVD Multiple-color	AlTiCrSiN	1. Utilizing a fine-grained cemented carbide substrate with low cobalt content combined with a high-performance nano-structured PVD coating, this product exhibits excellent wear resistance and high-temperature resistance. 2. It is suitable for drilling of hardend steel.

A
车削刀片B
铣削刀片C
铝合金刀片D
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钻削产品牌号一览表

Recommended Grade Table

工件材料 Workpiece materials	ISO代号 ISO Code	CVD	PVD	金属陶瓷 Cermet	硬质合金 Cemented carbide	超硬材料 Superhard materials
P	P01					
	P10		KT8295			
	P20		KT1378G			
	P30					
	P40					
M	M01					
	M10		KT8208			
	M20		KT8296			
	M30		KT1378G			
	M40					
K	K01					
	K10					
	K20					
	K30					
N	N01					
	N10					
	N20					
	N30					
S	S01					
	S10					
	S20					
	S30					
H	H01					
	H10		KT6259			
	H20					
	H30					

A

车削刀片

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铝合金刀片

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F

非标异形刀片

G

圆棒和立铣刀

H

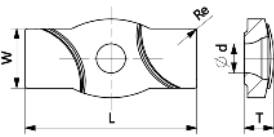
刀杆和刀盘

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		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions									
		工件材料 Workpiece Material	P	钢				○		○	
			M	不锈钢			√	○			○
			K	铸铁							
			N	有色金属							
			S	耐热合金、钛合金							
			H	淬硬钢					○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				PVD涂层					
		W	S	L	a	KT8208	KT1378G	KT6259	KT8295	KT8296	
	LNMT2506	6	3	4.30	0°				▲		
	LNMT2507	7	3.5	4.30	0°				▲		
	LNMT2508	8	4.5	4.30	0°				▲		
	LNMT2510	10	4.5	4.30	0°				▲		
	LNMT2512	12	5.5	4.30	0°				▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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孔加工 / 深孔钻刀片

Deep-hole Drilling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

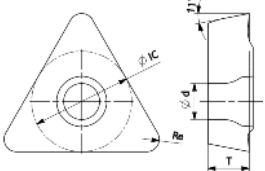
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

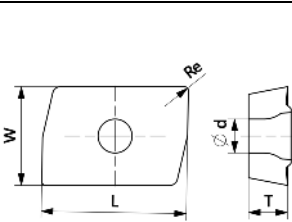
I 加工案例

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		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions								
		工件材料 Workpiece Material	P	钢			○		○	
			M	不锈钢		√	○			○
			K	铸铁						
			N	有色金属						
			S	耐热合金、钛合金						
			H	淬硬钢				○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				PVD涂层				
		ØI.C	T	Φd	Re	KT8208	KT1378G	KT6259	KT8295	KT8296
	TPMT16T312R-GM	9.53	3.97	3.40	1.2				▲	
	TPMT220612R-GM	12.70	6.35	4.40	1.2				▲	
	TPMT16T312R-GF	9.53	3.97	3.40	1.2				▲	
	TPMT220612R-GF	12.70	6.35	4.40	1.2				▲	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

		√ 良好工况 Good working conditions				○ 一般工况 General working conditions		× 不稳定工况 Unstable working conditions			
		工件材料 Workpiece Material	P	钢			○		○		
			M	不锈钢		√		○			○
			K	铸铁							
			N	有色金属							
			S	耐热合金、钛合金							
			H	淬硬钢					○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				PVD涂层					
		ØI.C	S	Φd	r	KT8208	KT1378G	KT6259	KT8295	KT8296	
	XPMT13T308-GM	10.00	3.97	3.40	0.8				▲		
	XPMT180608-GM	11.55	6.35	4.40	0.8				▲		
	XPMT13T308-GF	10.00	3.97	3.40	0.8				▲		
	XPMT180608-GF	11.55	6.35	4.40	0.8				▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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孔加工 / 深孔钻刀片

Deep-hole Drilling Inserts

A 车削刀片

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E 刮管刀片

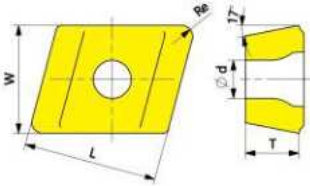
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

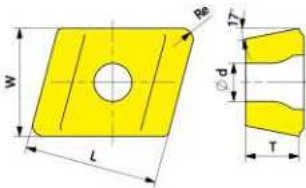
I 加工案例

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		√ 良好工况 Good working conditions		○ 一般工况 General working conditions		× 不稳定工况 Unstable working conditions				
		工件材料 Workpiece Material	P	钢			○		○	
			M	不锈钢	√		○			○
			K	铸铁						
			N	有色金属						
			S	耐热合金、钛合金						
			H	淬硬钢				○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				PVD涂层				
		I	iW	s	r	KT8208	KT1378G	KT6259	KT8295	KT8296
	ZPMT-050308M-C-G	5.56	9.87	3.18	0.8				▲	
	ZPMT-06T308M-C-G	6.35	9.87	3.97	0.8				▲	
	ZPMT-08T308M-C-G	7.94	9.87	3.97	0.8				▲	
	ZPMT-10T308M-C-G	9.53	9.87	3.97	0.8				▲	
	ZPMT-12T308M-C-G	12.70	9.87	3.97	0.8				▲	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions									
		工件材料 Workpiece Material	P	钢			○			○	
			M	不锈钢	√		○				○
			K	铸铁							
			N	有色金属							
			S	耐热合金、钛合金							
			H	淬硬钢				○			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				PVD涂层					
		l	iW	s	r	KT8208	KT1378G	KT6259	KT8295	KT8296	
	ZPMT-050308M-I-G	5.56	9.87	3.18	0.8				▲		
	ZPMT-06T308M-I-G	6.35	9.87	3.97	0.8				▲		
	ZPMT-08T308M-I-G	7.94	9.87	3.97	0.8				▲		
	ZPMT-12T308M-I-G	12.70	9.87	3.97	0.8				▲		
	ZPMT-050308M-I-L	5.56	9.87	3.18	0.8				▲		
	ZPMT-06T308M-I-L	6.35	9.87	3.97	0.8				▲		
	ZPMT-08T308M-I-L	7.94	9.87	3.97	0.8				▲		
	ZPMT-12T308M-I-L	12.70	9.87	3.97	0.8				▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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孔加工 / 深孔钻刀片

Deep-hole Drilling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

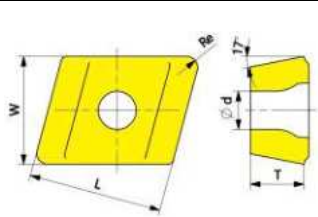
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions								
		工件材料 Workpiece Material	P	钢			○		○	
			M	不锈钢	√		○			○
			K	铸铁						
			N	有色金属						
			S	耐热合金、钛合金						
			H	淬硬钢				○		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				PVD涂层				
		I	iW	s	r	KT8208	KT1378G	KT6259	KT8295	KT8296
	ZPMT-060308H-P-L	6.50	8.00	3.18	0.8				▲	
	ZPMT-08T308H-P-L	8.50	9.00	3.97	0.8				▲	
	ZPMT-09T308H-P-L	9.68	9.00	3.97	0.8				▲	
	ZPMT-11T308H-P-L	12.75	9.00	3.97	0.8				▲	
	ZPMT-060308H-P-G	6.50	8.00	3.18	0.8				▲	
	ZPMT-08T308H-P-G	8.50	9.00	3.97	0.8				▲	
	ZPMT-09T308H-P-G	9.68	9.00	3.97	0.8				▲	
	ZPMT-11T308H-P-G	12.75	9.00	3.97	0.8				▲	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

深孔钻切削参数表 Table of Recommended Cutting for Deep-hole Drilling

ISO	材料 Material		硬度 HB	进给量 f mm/r		切削速度 Vc m/min
				直径 Dc mm		
				25.00-43.00	43.01-65.00	
P	非合金	非淬硬0.1-0.25%C	90-200	0.11-0.41	0.14-0.45	70-130
		非淬硬0.25-0.55%C	125-225	0.11-0.41	0.14-0.45	70-130
		非淬硬0.55-0.80%C	150-250	0.11-0.41	0.14-0.45	70-130
		高碳钢.退火	180-275	0.11-0.41	0.14-0.45	70-130
	低合金	非淬硬	150-260	0.11-0.41	0.20-0.45	70-120
		调质	220-450	0.11-0.41	0.20-0.45	55-110
	高合金	退火	150-250	0.11-0.41	0.20-0.45	70-120
		退火高速钢	150-250	0.11-0.41	0.20-0.45	70-120
		淬火工具钢	250-350	0.11-0.38	0.20-0.40	55-110
		淬火钢、其他	250-450	0.20-0.38	0.20-0.40	55-110
	铸钢	非合金	90-225	0.11-0.33	0.2-0.38	55-110
		低合金 (合金元素<5%)	150-250	0.11-0.33	0.2-0.38	55-110
	铸钢	奥氏体不锈钢	150-250	0.11-0.33	0.20-0.38	50-100
		铝钢12-14%Mn	200-300	0.11-0.33	0.20-0.38	35-85
M	轧制/锻造	铁氏体、马氏体非淬硬	150-270	0.11-0.41	0.2-0.45	40-110
	轧制/锻造	奥氏体	150-275	0.11-0.41	0.2-0.45	40-110
	轧制/锻造	奥氏体/铁素体 (双相) 不可焊接>=0,05%C	180-290	40-110	0.11-0.33	0.20-0.35
		奥氏体/铁素体 (双相) 可焊接<0,05%C	200-320	40-80	0.11-0.33	0.20-0.35
K	可锻铸铁	铁素体	110-145	80-120	0.11-0.38	0.24-0.41
		珠光体	150-270	80-120	0.11-0.38	0.24-0.41
	灰口铸铁	低拉伸强度	150-220	60-110	0.11-0.38	0.24-0.41
		高拉伸强度	200-330	60-110	0.11-0.38	0.24-0.41
	球墨铸铁	铁素体	125-230	50-110	0.11-0.38	0.24-0.41
		珠光体	200-300	50-110	0.11-0.38	0.24-0,41
N	铝合金	锻造或锻造+冷作, 非时效处理	30-100	65-150	0.09-0.33	0.24-0.35
		锻造或锻造加时效处理	30-150	65-150	0.09-0.33	0.24-0.35
	铝合金	铸造, 非时效	40-100	65-150	0.09-0.33	0.24-0.35
		铸造或铸造加时效处理	70-140	65-150	0.09-0.33	0.24-0.35
	铜和铜合金	易切合金Pb>1%	70-160	65-150	0.09-0.33	0.24-0.35
		黄铜, 加铅青铜Pb≤1%	50-200	65-150	0.09-0.33	0.24-0.35
S	铁基	退火或固溶处理	180-230	10-55	0.09-0.30	0.20-0.33
	镍基	退火或固溶处理	140-300	10-55	0.09-0.30	0.20-0.33
	钴基	退火或固溶处理	180-230	10-55	0.09-0.30	0.20-0.33
	钛	α, 近α与α+退火处理的β 合金	Rm³)600-1100	30-60	0.09-0.30	0.20-0.33

A 车削刀片

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E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

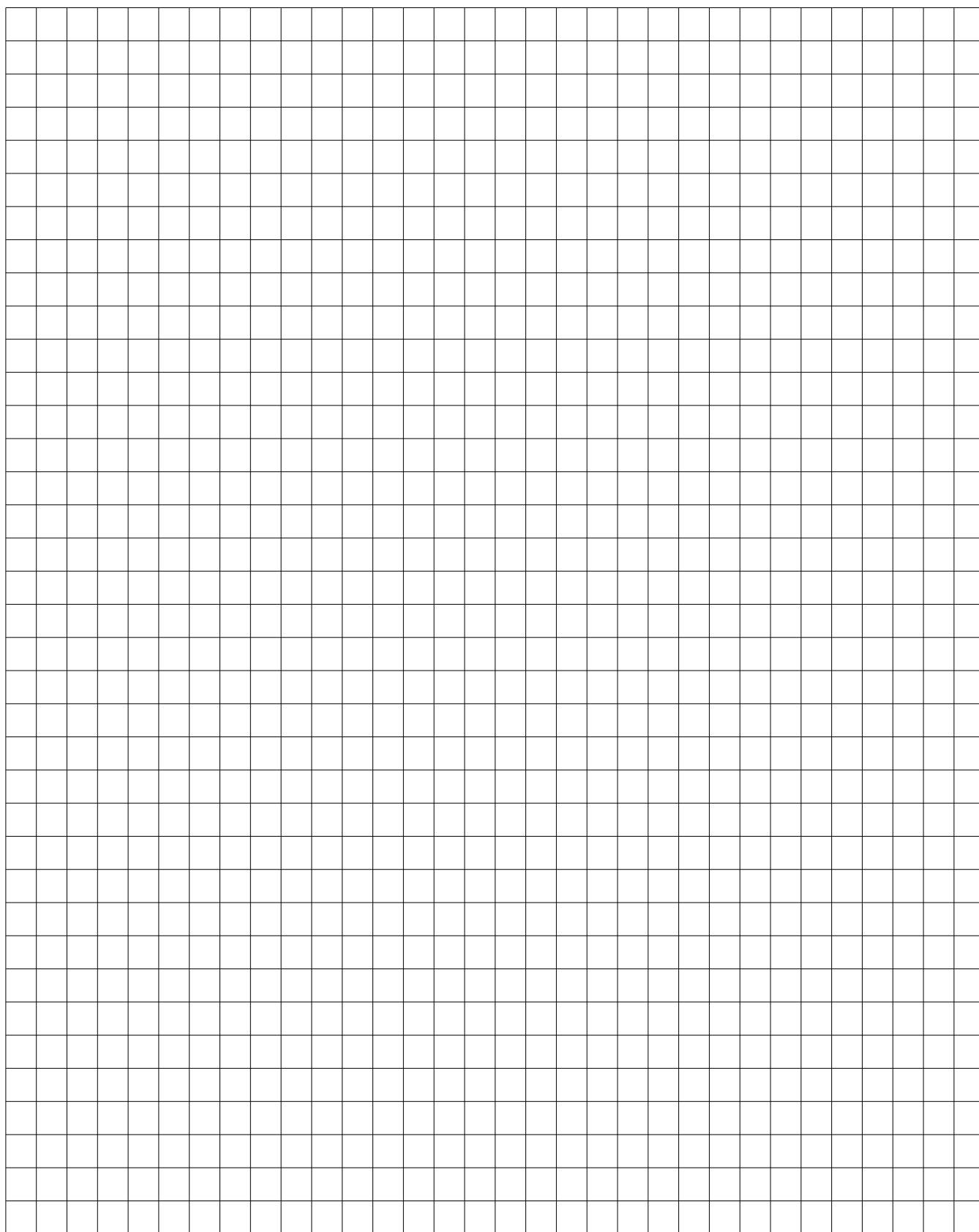
H 刀杆和刀盘

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Cutting Parameters for Deep-hole Drilling

ISO	Material		HB	f mm/r		Vc m/min
				Dc mm		
				25.00-43.00	43.01-65.00	
P	Non Ferrous	Non Hardening 0.1-0.25%C	90-200	0.11-0.41	0.14-0.45	70-130
		Non Hardening 0.25-0.55%C	125-225	0.11-0.41	0.14-0.45	70-130
		Non Hardening 0.55-0.80%C	150-250	0.11-0.41	0.14-0.45	70-130
		High Carbon, annealing	180-275	0.11-0.41	0.14-0.45	70-130
	Low Alloy	Non Hardening	150-260	0.11-0.41	0.20-0.45	70-120
		Quenching and Tempering	220-450	0.11-0.41	0.20-0.45	55-110
	High Alloy	Annealing	150-250	0.11-0.41	0.20-0.45	70-120
		Annealing HSS	150-250	0.11-0.41	0.20-0.45	70-120
		Hardening Tool Steel	250-350	0.11-0.38	0.20-0.40	55-110
		Hardening Steel and Others	250-450	0.20-0.38	0.20-0.40	55-110
	Cast Steel	Non Ferrous	90-225	0.11-0.33	0.2-0.38	55-110
		Low Alloy(Alloy<5%)	150-250	0.11-0.33	0.2-0.38	55-110
	Cast Steel	Authentic Stainless Steel	150-250	0.11-0.33	0.20-0.38	50-100
		Aluminum Steel 12-14% Mn	200-300	0.11-0.33	0.20-0.38	35-85
M	Rolling/Forging	Ferrolite, martensitic non hardening	150-270	0.11-0.41	0.2-0.45	40-110
	Rolling/Forging	Authentic	150-275	0.11-0.41	0.2-0.45	40-110
	Rolling/Forging	Duplex non welding>=0,05%C	180-290	40-110	0.11-0.33	0.20-0.35
		Duplex welding><0,05%C	200-320	40-80	0.11-0.33	0.20-0.35
K	Malleable Cast Iron	Ferrolites	110-145	80-120	0.11-0.38	0.24-0.41
		Pearlite	150-270	80-120	0.11-0.38	0.24-0.41
	Gray Cast Iron	Low Tensile	150-220	60-110	0.11-0.38	0.24-0.41
		High Tensile	200-330	60-110	0.11-0.38	0.24-0.41
	Nodular Cast Iron	Ferrolites	125-230	50-110	0.11-0.38	0.24-0.41
		Pearlite	200-300	50-110	0.11-0.38	0.24-0.41
N	Aluminum	Forging or forging +cold forming, non aging treatment	30-100	65-150	0.09-0.33	0.24-0.35
		Forging or plating with aging treatment	30-150	65-150	0.09-0.33	0.24-0.35
	Aluminum	Forging , non aging treatment	40-100	65-150	0.09-0.33	0.24-0.35
		Forging or plating with aging treatment	70-140	65-150	0.09-0.33	0.24-0.35
	Copper and Copper Alloy	Free cutting alloy Pb>1%	70-160	65-150	0.09-0.33	0.24-0.35
		Brass, leaded bronze Pb≤1%	50-200	65-150	0.09-0.33	0.24-0.35
S	Fe-based	Annealing or solid solution	180-230	10-55	0.09-0.30	0.20-0.33
	Ni-based	Annealing or solid solution	140-300	10-55	0.09-0.30	0.20-0.33
	Co-based	Annealing or solid solution	180-230	10-55	0.09-0.30	0.20-0.33
	Ti	α, α & α+annealing β alloy	Rm³)600-1100	30-60	0.09-0.30	0.20-0.33


A
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孔加工 / 浅孔钻刀片

Shallow-hole Drilling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

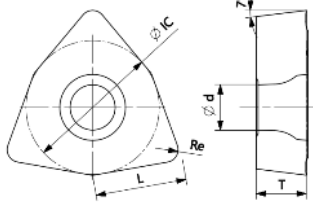
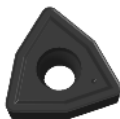
F 非标异形刀片

G 圆棒和立铣刀

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		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions									
		工件材料 Workpiece Material	P	钢			○			○	
		M	不锈钢		√		○				○
		K	铸铁								
		N	有色金属								
		S	耐热合金、钛合金								
		H	淬硬钢					○			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					PVD涂层				
		L	ØI.C	T	Φd	Re	KT8208	KT1378G	KT6259	KT8295	KT8296
	WCMX 030204-DC	3.8	5.56	2.38	2.80	0.4		●			▲
	WCMX 030208-DC	3.8	5.56	2.38	2.80	0.8		●			▲
	WCMX 040204-DC	4.3	6.35	2.38	3.10	0.4		●			▲
	WCMX 040208-DC	4.3	6.35	2.38	3.10	0.8		●			▲
	WCMX 050308-DC	5.4	7.94	3.18	3.20	0.8		●			▲
	WCMX 06T308-DC	6.5	9.53	3.97	3.70	0.8		●			▲
	WCMX 080412-DC	8.7	12.70	4.76	4.30	1.2		●			▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

浅孔钻切削参数表 Cutting Parameters for Shallow-hole Drilling

ISO	材料 Material	硬度HB	直径Dc mm	进给量 f mm/r	切削速度 Vc m/min
P	碳钢 Carbon steel	80-200	16.0-23.0	0.05-0.09	200(170-240)
			24.0-30.0	0.05-0.09	
			31.0-38.0	0.06-0.10	
			39.0-46.0	0.07-0.11	
			47.0-58.0	0.08-0.12	
	低合金钢 Low alloy steel	150-260	16.0-23.0	0.05-0.09	170(140-220)
			24.0-30.0	0.05-0.12	
			31.0-38.0	0.06-0.14	
			39.0-46.0	0.08-0.16	
	高合金钢 High alloy steel	150-320	16.0-23.0	0.05-0.09	150(120-180)
			24.0-30.0	0.05-0.12	
			31.0-38.0	0.06-0.14	
			39.0-46.0	0.08-0.16	
M	不锈钢 Stainless steel 铁素体 Ferritic stainless steel 马氏体 Martensitic stainless steel	150-270	16.0-23.0	0.05-0.09	160(110-230)
			24.0-30.0	0.05-0.12	
			39.0-46.0	0.06-0.16	
			31.0-38.0	0.08-0.18	
	奥氏体 Austenitic stainless steel	150-275	47.0-58.0	0.10-0.22	140(110-220)
			16.0-23.0	0.05-0.09	
K	可锻铸铁 Malleable cast iron	150-230	24.0-30.0	0.05-0.11	140(110-220)
			31.0-38.0	0.06-0.13	
			39.0-46.0	0.08-0.14	
	灰口铸铁 Grey cast iron	150-220	47.0-58.0	0.10-0.16	160(120-220)
			16.0-23.0	0.05-0.10	
			24.0-30.0	0.05-0.14	
	球墨铸铁 Nodular cast iron	160-250	31.0-38.0	0.08-0.16	200(170-240)
			39.0-46.0	0.10-0.20	
			47.0-58.0	0.12-0.24	
N	铝合金 Aluminium alloy	60-110	16.0-23.0	0.05-0.10	300(250-350)
			24.0-30.0	0.05-0.14	
			31.0-38.0	0.08-0.16	
			39.0-46.0	0.10-0.20	
			47.0-58.0	0.12-0.24	

A 车削刀片

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切断切槽刀片

PARTING AND GROOVING INSERTS



TMA

优秀的切削刃设计使这款刀片在车削于切槽加工中都有着优秀的表现。通过顶角处设计的小点，减小切屑宽度并实现平稳的切屑控制。



CMA

切削刃两侧独特的切屑槽设计，可产生更窄的切屑，更有助于切屑的排出。这款刀片专为切槽加工应用而设计，优异的切削控制能力使切槽加工更加轻松。



MMD

适用于车削和切槽，顶部尖角的凸点设计减小切削宽度和平滑切削控制。



RMA

全半径几何形状，适用于需要进行仿形加工的应用；
可应用于退刀槽加工。

切槽切断刀片牌号介绍

CVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KP025	P15~P35	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.新一代钢件车削牌号, KP系列中应用最广泛的材质。 2.中等含钴量基体, 搭配高耐磨性涂层。 3.可在较高切削速度下加工, 适用于连续和断续车削, 在恶劣工况下也具有较高的抗机械损伤能力, 并保持出色的耐磨性。
KT1251	P15~P35	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.高强韧性的中钴梯度硬质合金基体, 搭配柱状细晶TiCN和高强度定向生产的Al ₂ O ₃ 涂层。 2.适用于碳钢、合金钢等材料的切槽切断加工。
KT1252	P15~P35	CVD 黑色	MT-TiCN+Al ₂ O ₃	1.全新的纳米柱状结构MT-TiCN和厚Al ₂ O ₃ 涂层, 与韧性、强度兼备的中钴梯度硬质合金基体相结合。 2.适用于碳钢、合金钢等材料的切槽切断加工, 具有更优异的耐磨性能。
KT3262	K15~K35	CVD 黑色	MT-TiCN+Al ₂ O ₃	1.中等晶粒的强韧性基体, 搭配全新升级的MT-TiCN和Al ₂ O ₃ 涂层工艺, 经特殊后处理工艺, 刃口强度好, 表面光滑。 2.适用于铸铁材料的切槽切断加工。

A 车削刀片

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G 圆棒和立铣刀

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PVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KT8296	P10~P30 M10~M30	PVD 灰黑色	TiAlN	1. 较高耐磨性的细晶粒中钴基体, 搭配通用性好的TiAlN涂层, 具有良好的膜基结合力、耐磨性和抗氧化性能。 2. 适用于合金钢、不锈钢等材料的切槽切断加工。
KT8298	M10~M30 S10~S25	PVD 紫红色	TiSiAlN	1. 采用中钴含量的高耐磨性细晶硬质合金基体, 搭配超细TiAlN纳米涂层, 具有高的涂层硬度、优良的耐高温性能, 为切削刃提供有效保护。 2. 适用于不锈钢、高温合金材料的切槽切断加工。
KS10	M10~M20 S10~S20	PVD 香槟色	Oxide	1. 细颗粒的硬质合金基体搭配纳米复合涂层技术结构, 防止了涂层过程中的微观裂纹的产生, 提高了抗崩性, 又不失刀片的锋利性; 2. 适用于高温合金、不锈钢材质的切槽切断加工。
KT6109	H05~H25	PVD 七彩色	AlTiCrSiN	1. 采用较低钴含量的超细晶粒硬质合金基体, 搭配全新升级的多层复合纳米PVD涂层, 获得较强的涂层结合力、高耐磨性和高抗氧化性能。 2. 适用于HRC42以上淬硬钢的切槽切断加工。

金属陶瓷牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KC5280	P10~P25 M10~M25	无涂层	\	1. TiCN基金属陶瓷牌号, 细小弥散的硬质相颗粒、粘结相强化和环形相结构控制三者结合, 使之表现出优异的耐磨性、红硬性和抗月牙洼磨损性能。 2. 适用于钢件、不锈钢的切槽切断加工。

Grade Information

CVD Coated Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Applications
KP025	P15~P35	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. A new generation of turning grade for steel parts, which is the most widely applied material in the KP series. 2. The substrate with a medium cobalt content is combined with a coating of high wear resistance. 3. It can be processed at relatively high cutting speeds and is suitable for both continuous and intermittent turning. It also has a high resistance to mechanical damage under harsh working conditions and maintains excellent wear resistance.
KT1251	P15~P35	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. A medium-cobalt gradient cemented carbide substrate with high strength and toughness is coated with a columnar fine-grained TiCN coating and a high-strength, directional Al ₂ O ₃ coating. 2. It is suitable for grooving and parting of materials such as carbon steel and alloy steel.
KT1252	P15~P35	CVD Black	MT-TiCN+Al ₂ O ₃	1. Using new nano-columnar structure of MT-TiCN and thick Al ₂ O ₃ coating, combined with medium cobalt gradient cemented carbide substrate with both toughness and strength. 2. It is suitable for grooving and parting of materials such as carbon steel and alloy steel, offering superior wear resistance.
KT3262	K15~K35	CVD Black	MT-TiCN+Al ₂ O ₃	1. Using strong toughness substrate of medium crystal grain, combined with new upgraded MT-TiCN and Al ₂ O ₃ coating, and it has excellent edge strength and smooth surface after the special post-treatment. 2. It is suitable for grooving and parting of cast iron.

A
车削刀片

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PVD Coated Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Applications
KT8296	P10~P30 M10~M30	PVD Gray-black	TiAlN	1.The fine-grain medium cobalt substrat with high wear resistance is matched with high universality of TiAlN coating. It has good film-based adhesion, wear resistance and oxidation resistance. 2. It is suitable for grooving and parting of materials such as alloy steel and stainless steel.
KT8298	M10~M30 S10~S25	PVD Purple	TiSiAlN	1. Using the fine-grain medium cobalt cemented carbide substrate, combined with high wear resistance ultrafine TiAlN nanometer coating, providing effective protection for cutting edge. It has good film-based adhesion, wear resistance and oxidation resistance. 2. It is suitable for grooving and parting of materials such as stainless steel and superalloy.
KS10	M10~M20 S10~S20	PVD Champagne	Oxide	1. The fine-grained cemented carbide substrate is combined with the nano-composite coating technology structure, which prevents the generation of micro-cracks during the coating process. It improves the chipping resistance while maintaining the sharpness of the insert. 2. It is suitable for the finishing and semi-finishing of superalloy and stainless steel in applications with extremely high requirements for tool life and stability.
KT6109	H05~H25	PVD Multiple-color	AlTiCrSiN	1.The ultra-fine grain cemented carbide matrix with low cobalt content is used with the newly upgraded multi-layer composite nano PVD coating to obtain strong coating adhesion, high wear resistance and high oxidation resistance. 2. It is suitable for grooving and parting of hardend steel over HRC 42.

Cermet Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Applications
KC5280	P10~P25 M10~M25	Uncoated	\	1.The TiCN-based cermet grade combines three features: finely dispersed hard-phase particles, adhesive phase for strengthening, and rim-phase for structure control. This combination makes it with excellent wear resistance, hot hardness, and resistance to crater wear. 2. It is suitable for grooving and parting of steel and stainless steel.

切 断 切 槽 牌 号 一 览 表

Recommended Grade Table

工件材料 Workpiece materials	ISO代号 ISO Code	CVD	PVD	金属陶瓷 Cermet	硬质合金 Cemented carbide	超硬材料 Superhard materials
P	P01					
	P10	KT1252		KC5280		
	P20	KT1251				
	P30	KP025				
	P40					
M	M01					
	M10		KT8298			
	M20		KT8296			
	M30					
	M40					
K	K01					
	K10	KT3262				
	K20					
	K30					
N	N01					
	N10					
	N20					
	N30					
S	S01					
	S10		KS10			
	S20					
	S30					
H	H01					
	H10		KT6109			
	H20					
	H30					

A
 车削刀片

B
 铣削刀片

C
 铝合金刀片

D
 孔加工刀片

E
 刮管刀片

F
 非标异形刀片

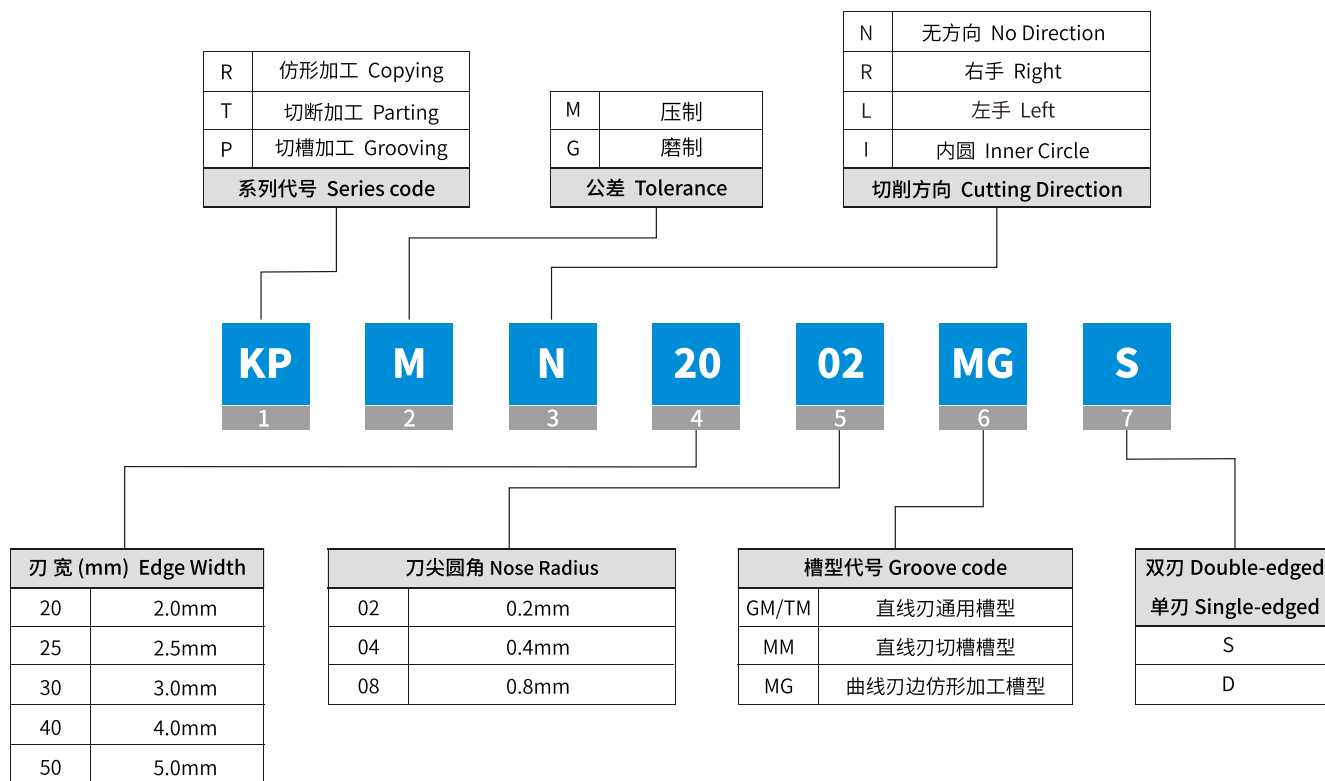
G
 圆棒和立铣刀

H
 刀杆和刀盘

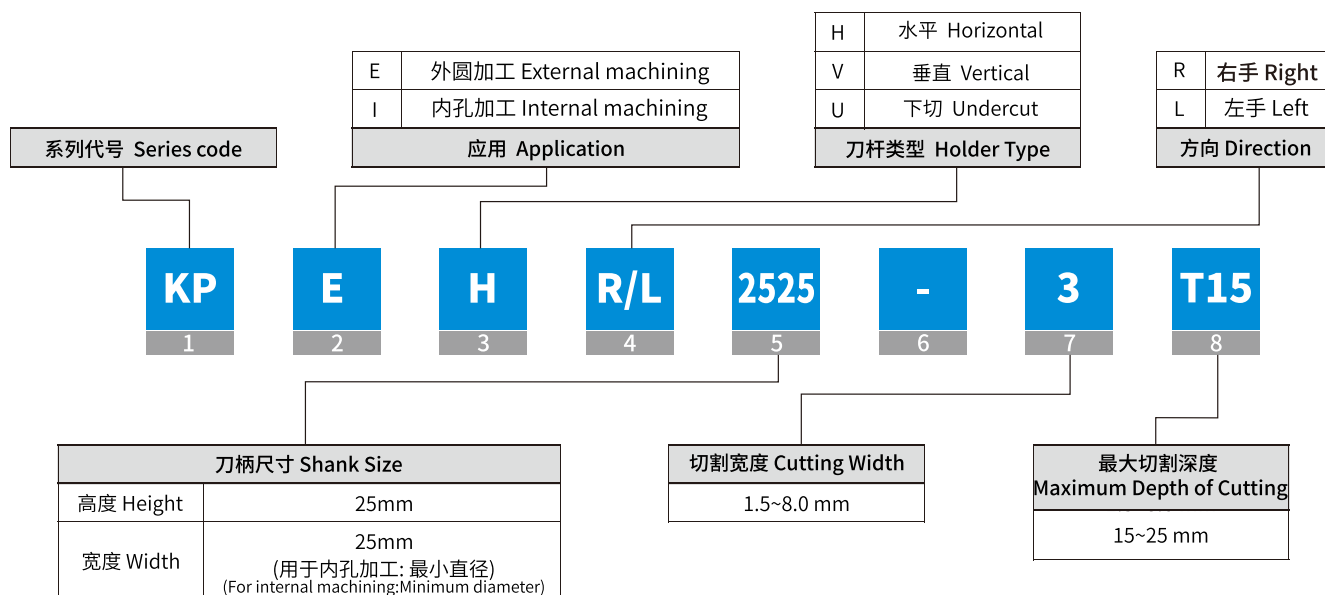
I
 加工案例

J
 通用技术信息

切断切槽刀片型号命名规则 Parting and Grooving Inserts Naming Rules



切断切槽刀杆型号命名规则 Parting and Grooving Holder Naming Rules



切断切槽刀片槽型一览表 Chipbreaker Table For Parting and Grooving Inserts

KPMN-MMD		1、中央设计有特殊的断屑结构, 与传统的平顶型面相比, 在开槽时更有利于切屑的排出。 2、特意设置的凸点有助于在外圆加工中控制切屑, 让切屑流动更平稳。 3、此断屑槽专为车削和切槽加工应用而设计。 1. There is a special chip-breaking structure designed in the center. Compared with the traditional flat-top type, it is more conducive to the evacuation of chips during grooving. 2. The specially set coating points help control the chips during external circular machining, making the chip flow more stable. 3. Specifically designed for turning and grooving applications.
KPMN-GMD		1、切削刃两侧独特的的切屑槽设计, 可产生更窄的切屑, 更有助于切屑的排出。 2、这款刀片专为切槽加工应用而设计, 优异的切削控制能力使切槽加工更加轻松。 1. The unique chip groove design on both sides of the cutting edge produces narrower chips and significantly improves chip evacuation efficiency. 2. Specifically designed for grooving applications. Its excellent cutting control ability makes grooving operations much easier.
KPMN-TMD		1、优秀的切削刃设计使这款刀片在车削于切槽加工中都有着优秀的表现。 2、通过顶角处设计的小点, 减小切屑宽度并实现平稳的切屑控制。 1. The excellent cutting edge design makes this insert to perform outstandingly both in turning and grooving operations. 2. Through the small dots designed at the apex angle, the width of the chips is reduced and smooth chip control is achieved.
KRMN-MGD		1、全半径几何形状, 适用于需要进行仿形加工的应用。 2、可应用于退刀槽加工。 1. The full radius geometry is suitable for applications that require profiling machining. 2. It can be applied to the machining of relief grooves.

A 车削刀片

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E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

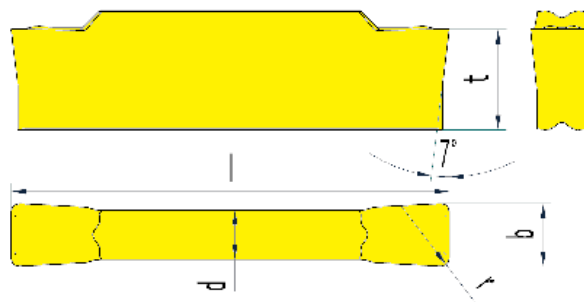
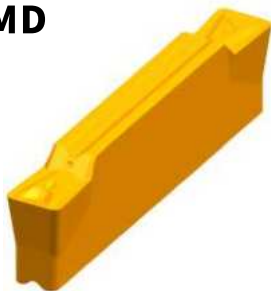
H 刀杆和刀盘

I 加工案例

J 通用技术信息

开槽与车削 Grooving and Turning

KPMN-MMD



型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层		
	b	r	l	d	t	KT1251	KT1252	KT3262	KT6109	KT8296	KT8298
KPMN2002-MMD	2	0.2	16	1.6	3.5		●	▲	●	▲	
KPMN2502-MMD	2.5	0.2	18.5	2	3.85		●	▲	●	▲	
KPMN3002-MMD	3	0.2	21	2.35	4.83		●	▲	●	▲	
KPMN3004-MMD	3	0.4	21	2.35	4.83		●	▲	●	▲	
KPMN3503-MMD	3.5	0.3	21	2.9	4.83		●	▲	●	▲	
KPMN4002-MMD	4	0.2	21	3.3	4.83		●	▲	●	▲	
KPMN4004-MMD	4	0.4	21	3.3	4.83		●	▲	●	▲	
KPMN5004-MMD	5	0.4	26	4.1	5.82		●	▲	●	▲	
KPMN5008-MMD	5	0.8	26	4.1	5.82		●	▲	●	▲	
KPMN6008-MMD	6	0.8	26	5	5.81		●	▲	●	▲	
KPMN8008-MMD	8	0.8	31	6	6.52		●	▲	●	▲	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

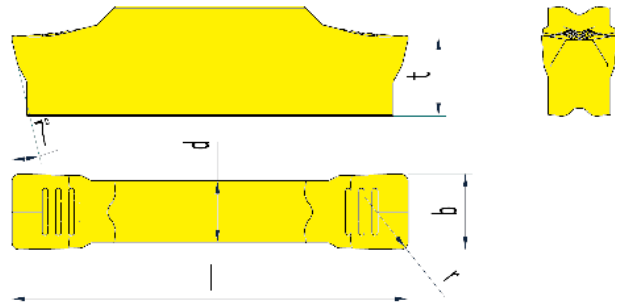
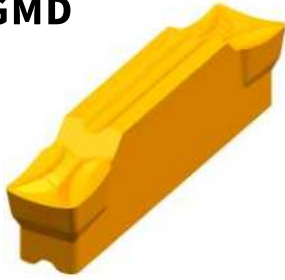
G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

切槽 Grooving KPMN-GMD



型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层		
	b	r	l	d	t	KT1251	KT1252	KT3262	KT6109	KT8296	KT8298
KPMN15015-GMD	1.5	0.15	16	1.2	3.5		●	▲	●	▲	
KPMN2002-GMD	2	0.2	16	1.6	3.5		●	▲	●	▲	
KPMN2502-GMD	2.5	0.2	18.5	2	3.85		●	▲	●	▲	
KPMN3003-GMD	3	0.3	21	2.35	4.83		●	▲	●	▲	
KPMN4003-GMD	4	0.3	21	3.3	4.83		●	▲	●	▲	
KPMN5005-GMD	5	0.5	26	4.1	5.82		●	▲	●	▲	
KPMN6008-GMD	6	0.8	26	5	5.81		●	▲	●	▲	

▲ 为主推荐牌号 Recommended grade (Always stock available)

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G 圆棒和立铣刀

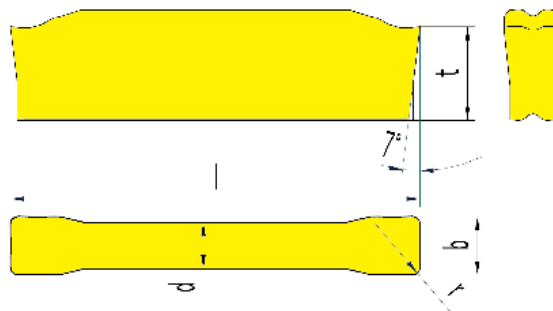
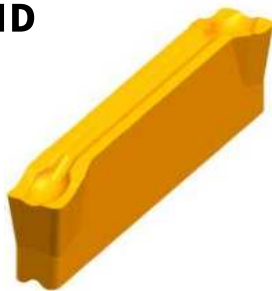
H 刀杆和刀盘

I 加工案例

J 通用技术信息

切槽与车削加工 Grooving and Turning

KPMN-TMD



型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层		
	b	r	l	d	t	KT1251	KT1252	KT3262	KT6109	KT8296	KT8298
KPMN15015-TMD	1.5	0.15	16	1.2	3.5		●	▲	●	▲	
KPMN2002-TMD	2	0.2	16	1.6	3.5		●	▲	●	▲	
KPMN3004-TMD	3	0.4	21	2.35	4.83		●	▲	●	▲	
KPMN4004-TMD	4	0.4	21	3.3	4.83		●	▲	●	▲	
KPMN5004-TMD	5	0.4	26	4.1	5.82		●	▲	●	▲	
KPMN5008-TMD	5	0.8	26	4.1	5.82		●	▲	●	▲	
KPMN6008-TMD	6	0.8	26	5	5.81		●	▲	●	▲	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

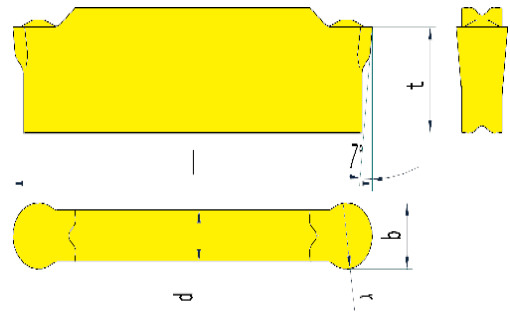
H 刀杆和刀盘

I 加工案例

J 通用技术信息

仿形加工 Profiling

KPMN-MGD



型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层		
	b	r	l	d	t	KT1251	KT1252	KT3262	KT6109	KT8296	KT8298
KRMN2010-MGD	2	1	16	1.5	3.5		●	▲	●	▲	
KRMN3015-MGD	3	1.5	21	2.35	4.83		●	▲	●	▲	
KRMN4020-MGD	4	2	21	3.3	4.83		●	▲	●	▲	
KRMN5025-MGD	5	2.5	26	4.1	5.82		●	▲	●	▲	
KRMN6020-MGD	6	3	26	5	5.81		●	▲	●	▲	
KRMN8040-MGD	8	4	31	6	6.52		●	▲	●	▲	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

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F 非标异形刀片

G 圆棒和立铣刀

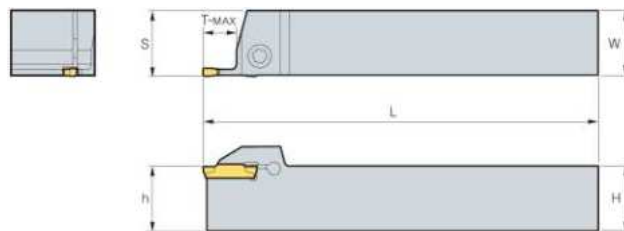
H 刀杆和刀盘

I 加工案例

J 通用技术信息

KPEHR/L

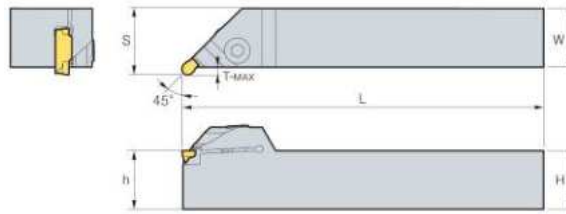
用于开槽, 车削, 切断, 让刀和仿形加工 For grooving, turning, parting, relieving and profiling



型号 Type		尺寸 Dimensions (mm)					适用刀片
		H=(h)	W	L	S	T-Max	
KPEHR/L	1616-1.5	16	16	100	16.2	14	KPMN150-GMD
	2020-1.5	20	20	125	20.2	14	
	2525-1.5	25	25	150	25.2	14	
	1212-2	12	12	100	14.25	14	KPMN200-GMD KPMN200-MMD KPMN200-□□-□□
	1616-2	16	16	100	16.25	14	
	2020-2	20	20	125	20.25	14	
	2525-2	25	25	150	25.25	14	KPMN250-GMD KPMN250-MMD
	1616-2.5	16	16	100	16.3	16	
	2020-2.5	20	20	125	20.3	16	
	2525-2.5	25	25	150	25.3	16	KPMN300-M/TMD KRMN300-MGD
	1616-3	16	16	100	16.35	18	
	2020-3-T10	20	20	125	20.4	10	
	2020-3	20	20	125	20.4	18	
	2525-3-T10	25	25	150	25.4	10	
	2525-3	25	25	150	25.4	18	
	3232-3-T10	32	32	170	32.4	10	KPMN400-M/TMD KRMN400-MGD
	3232-3	32	32	170	32.4	18	
	2020-4-T10	20	20	125	20.4	10	
	2020-4	20	20	125	20.4	18	
	2525-4-T10	25	25	150	25.4	10	
	2525-4	25	25	150	25.4	18	
	3232-4-T10	32	32	170	32.4	10	KPMN500-M/TMD KRMN500-MGD
	3232-4	32	32	170	32.4	18	
	2020-5-T15	20	20	150	20.5	15	
	2020-5	20	20	150	20.5	23	
	2525-5-T15	25	25	150	25.5	15	
	2525-5	25	25	150	25.5	23	
	3232-5-T15	32	32	170	32.5	15	KPMN600-MMD KRMN600-MGD
	3232-5	32	32	170	32.5	23	
	2020-6-T15	20	20	125	20.6	15	
	2020-6	20	20	125	20.6	23	
	2525-6-T15	25	25	150	25.6	15	
	2525-6	25	25	150	25.6	23	
	3232-6-T15	32	32	170	32.6	15	KRMN800-MGD KPMN800-MMD
	3232-6	32	32	170	32.6	23	
	2525-8-T15	25	25	150	26.1	15	
	2525-8	25	25	150	26.1	28	
	3232-8-T15	32	32	170	33.1	16	
	3232-8	32	32	170	33.1	28	

KPEHR/L

用于仿形加工与让刀加工 For profiling and relieving



型号 Type		尺寸 Dimensions (mm)					适用刀片
		H=(h)	W	L	S	T-Max	
KPEHR/L	2020-3	20	20	125	23	3	KRMN300-MGD
	2525-3	25	25	150	28	3	
	3232-3	32	32	170	35	3	
	2020-4	20	20	125	23	3	KRMN400-MGD
	2525-4	25	25	150	28	3	
	3232-4	32	32	170	35	3	
	2020-5	20	20	125	24	4	KRMN500-MGD
	2525-5	25	25	150	29	4	
	3232-5	32	32	170	36	4	
	2020-6	20	20	125	24	4	KRMN600-MGD
	2525-6	25	25	150	29	4	
	3232-6	32	32	170	36	4	
	2525-8	25	25	150	30	5	KRMN800-MGD
	3232-8	32	32	170	37	5	

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

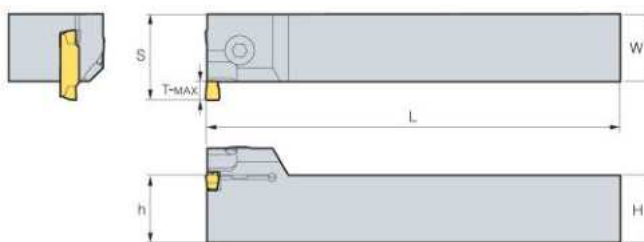
H 刀杆和刀盘

I 加工案例

J 通用技术信息

KPEVR/L

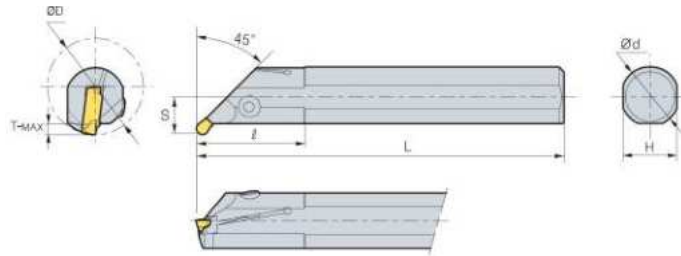
用于切槽、车削、仿形加工 For grooving, turning, profiling



型号 Type		尺寸 Dimensions (mm)						适用刀片
		H=(h)	W	L	S	T-Max	最小内孔加工直径	
KPEVR/L	2020-1.5	20	20	125	23	3	85	KPMN150-GMD
	2525-1.5	25	25	150	28	3	85	
	3232-1.5	32	32	170	35	3	85	
	2020-2	20	20	125	23.5	3.5	65	KPMN200-MMD KPMN200-GMD
	2525-2	25	25	150	28.5	3.5	65	
	3232-2	32	32	170	35.5	3.5	65	
	2020-2.5	20	20	125	24	4	65	KPMN250-MMD KPMN250-GMD
	2525-2.5	25	25	150	29	4	65	
	3232-2.5	32	32	170	36	4	65	
	2020-3	20	20	125	25.5	5	75	KPMN300-M/TMD KRMN300-MGD
	2525-3	25	25	150	30.5	5	75	
	3232-3	32	32	170	37.5	5	75	
	2020-4	20	20	125	25.5	5	70	KPMN400-M/TMD KRMN400-MGD
	2525-4	25	25	150	30.5	5	70	
	3232-4	32	32	170	37.5	5	70	
	2020-5	20	20	125	27	7	75	KPMN500-M/TMD KRMN500-MGD
	2525-5	25	25	150	32	7	75	
	3232-5	32	32	170	39	7	75	
	2020-6	20	20	125	27	7	70	KPMN600-MMD KRMN600-MGD
	2525-6	25	25	150	32	7	70	
	3232-6	32	32	170	39	7	70	
	2525-8	25	25	150	34	9	50	KRMN800-MGD KPMN800-MMD
	3232-8	32	32	170	41	9	50	

KPIUR/L

用于让刀和仿形加工 For relieving and profiling



型号 Type		尺寸 Dimensions (mm)							适用刀片
		φD	φd	L	ℓ	T-Max	H	S	
KPIUR/L	3520-3	35	20	150	45	3.5	18	13	KRMN300-MGD
	4025-3	40	25	200	45	3.5	23	15.5	
	5032-3	50	32	250	65	3.5	30	19	
	3520-4	35	20	150	45	3.5	18	13	KRMN400-MGD
	4025-4	40	25	200	45	3.5	23	15.5	
	5032-4	50	32	250	65	3.5	30	19	
	4025-5	40	25	200	45	3.5	23	15.5	KRMN500-MGD
	5032-5	50	32	250	65	3.5	30	19	
	4025-6	40	25	200	45	3.5	23	19	KRMN800-MGD
	5032-6	50	32	250	65	3.5	30	19	
	4025-8	40	25	200	45	6.5	23	15.5	KRMN600-MGD
	5032-8	50	32	250	65	6.5	30	19	

A 车削刀片

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G 圆棒和立铣刀

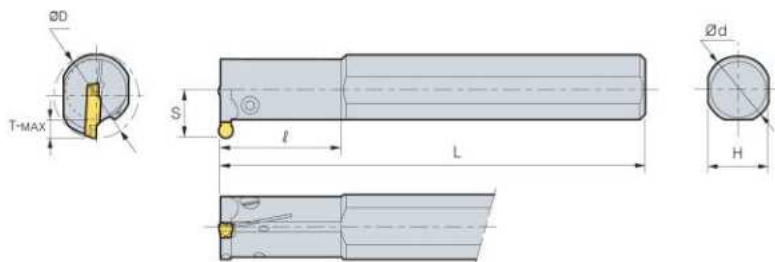
H 刀杆和刀盘

I 加工案例

J 通用技术信息

KPIVR/L

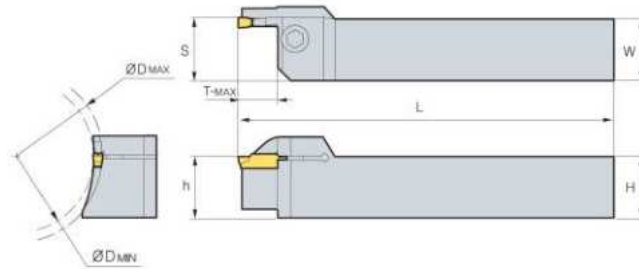
用于切槽、车削、仿形加工 For grooving, turning, profiling



型号 Type		尺寸 Dimensions (mm)							适用刀片
		φD	φd	L	ℓ	T-Max	H	S	
KPIVR/L	2016-1.5	20	16	125	35	3.5	15	11.3	KPMN150-GMD
	2520-1.5	25	20	150	45	3.5	18	13.1	
	2925-1.5	29	25	200	45	3.5	23	16.2	
	2016-2	20	16	125	35	4.5	15	12.4	KPMN200-GMD KPMN200-MMD KRMN200-MGD
	2520-2	25	20	150	45	4.5	18	14	
	2925-2	29	25	200	45	4.5	23	17.2	
	2016-2.5	20	16	125	35	4.5	15	12.5	KPMN250-GMD KPMN250-MMD
	2520-2.5	25	20	150	45	4.5	18	15.1	
	2925-2.5	29	25	200	45	4.5	23	18.2	
	2520-3	25	20	150	45	5	18	15.6	KPMN300-M/T/GMD KRMN300-MGD
	2520-3-T7	25	20	150	49.3	7	18	19.92	
	3125-3	31	25	200	45	6	23	18.9	
	3125-3-T10	31	25	200	45	10	23	18.9	
	3732-3	37	32	250	65	6	30	21.5	
	3732-3-T12	37	32	250	65	12	30	21.5	KPMN400-M/T/GMD KRMN400-MGD
	2520-4	25	20	150	45	6	18	15.6	
	2520-4-T7	25	20	150	45	7	18	15.6	
	3125-4	31	25	200	45	6	23	18.9	
	3125-4-T10	31	25	200	45	10	23	19	
	3732-4	37	32	250	65	6	30	21.5	
	3732-4-T12	37	32	250	65	12	30	21.5	KPMN500-M/G/TMD KRMN500-MGD
	3125-5	31	25	200	45	8	23	19.4	
	3732-5	37	32	250	65	8	30	21.5	
	3125-6	31	25	200	45	8	23	19.4	KPMN600-M/GMD KRMN600-MGD
	3732-6	37	32	250	65	8	30	21.5	
	3732-8	37	32	250	65	10	30	23.4	KRMN800-MGD KPMN800-MMD
	4540-8	45	40	300	70	10	37	27.2	

KPFHR/L

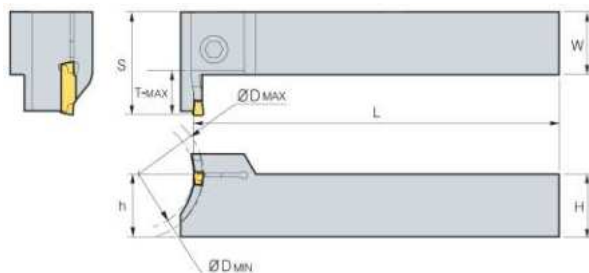
用于端面开槽加工 For face grooving



型号 Type		尺寸 Dimensions (mm)					φD		适用刀片
		H=(h)	W	L	S	T-Max	Min	Max	
KPFHR/L	425-62/120-T15	25	25	150	25.6	15	62	120	KPMN400-M/TMD
	425-112/200-T15	25	25	150	25.6	15	112	200	

KPFVR/L

用于端面开槽加工 For face grooving



型号 Type		尺寸 Dimensions (mm)					φD		适用刀片
		H=(h)	W	L	S	T-Max	Min	Max	
KPFVR/L	425-44/60-T15	25	25	150	41	15	44	60	KPMN400-M/TMD
	425-60/120-T15	25	25	150	41	15	60	120	
	425-112/200-T15	25	25	150	41	15	112	200	

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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切断加工参数 Parting Parameters

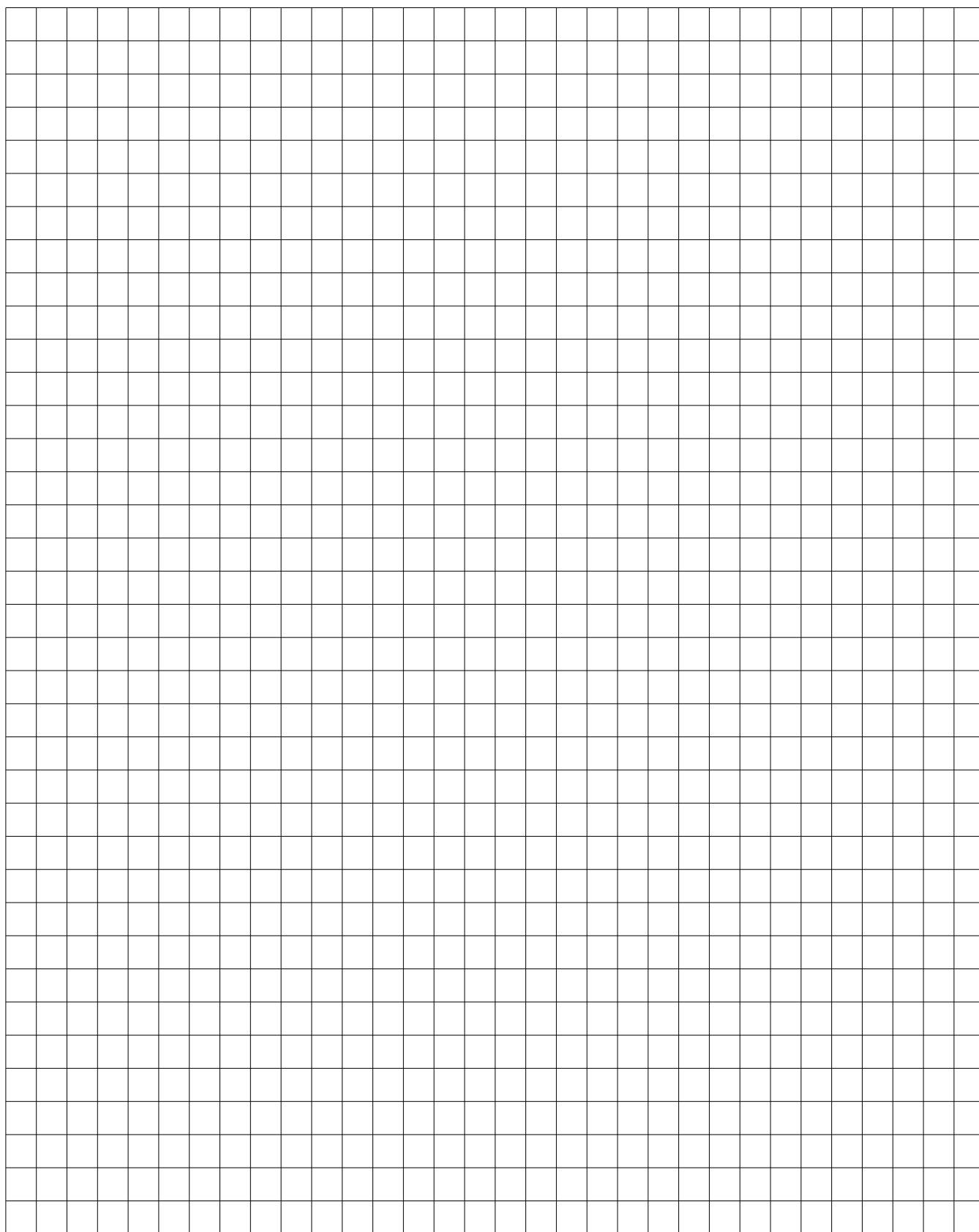
型号 Type	切削速度 (Vc = m/min)				进给 (f = mm/rev)				
	CVD		PVD		切削宽度(Width = mm)				
	KT1252	KT3262	KT6109	KT8296	2	3	4	5	6
淬硬钢 Hardened Steel			50-100		0.02~0.15	0.03~0.20	0.08~0.30	0.10~0.40	0.12~0.50
合金钢 Alloy Steel	70~150				0.02~0.15	0.03~0.20	0.08~0.30	0.10~0.40	0.12~0.50
铸铁 Cast Iron		50~100			0.05~0.12	0.10~0.25	0.10~0.30	0.10~0.35	0.10~0.40
不锈钢 Stainless Steel				60~140	0.02~0.10	0.03~0.15	0.08~0.25	0.10~0.35	0.12~0.40

端面加工参数 Face Grooving Parameters

型号 Type	切削速度 (Vc = m/min)				进给 (f = mm/rev)		
	CVD		PVD		切削宽度(Width = mm)		
	KT1252	KT3262	KT6109	KT8296	3	4	5
淬硬钢 Hardened Steel			40-90		0.05~0.10	0.05~0.12	0.05~0.15
合金钢 Alloy Steel	50~130				0.05~0.10	0.05~0.12	0.05~0.15
铸铁 Cast Iron		120~150			0.05~0.10	0.05~0.12	0.05~0.15
不锈钢 Stainless Steel				60-150	0.05~0.10	0.05~0.12	0.05~0.15

开槽及车削加工参数 Grooving And Turning Parameters

型号 Type	切削速度 (Vc = m/min)				进给 (f = mm/rev)					
	CVD		PVD		切削宽度(Width = mm)					
	KT1252	KT3262	KT6109	KT8296	0.5~1.0	1.0~2.0	2~3	3~4	4~5	6~8
淬硬钢 Hardened Steel			50-110		0.03~0.08	0.04~0.09	0.05~0.1	0.05~0.12	0.05~0.15	0.05~0.2
合金钢 Alloy Steel	80~180				0.03~0.07	0.04~0.08	0.05~0.08	0.05~0.1	0.05~0.12	0.05~0.15
铸铁 Cast Iron		60~130			0.03~0.07	0.04~0.08	0.05~0.08	0.05~0.1	0.05~0.10	0.05~0.12
不锈钢 Stainless Steel				60-100	0.03~0.08	0.04~0.09	0.05~0.10	0.05~0.12	0.05~0.12	0.05~0.15


A
 车削刀片

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 刮管刀片

F
 非标异形刀片

G
 圆棒和立铣刀

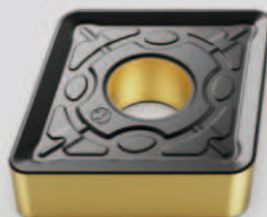
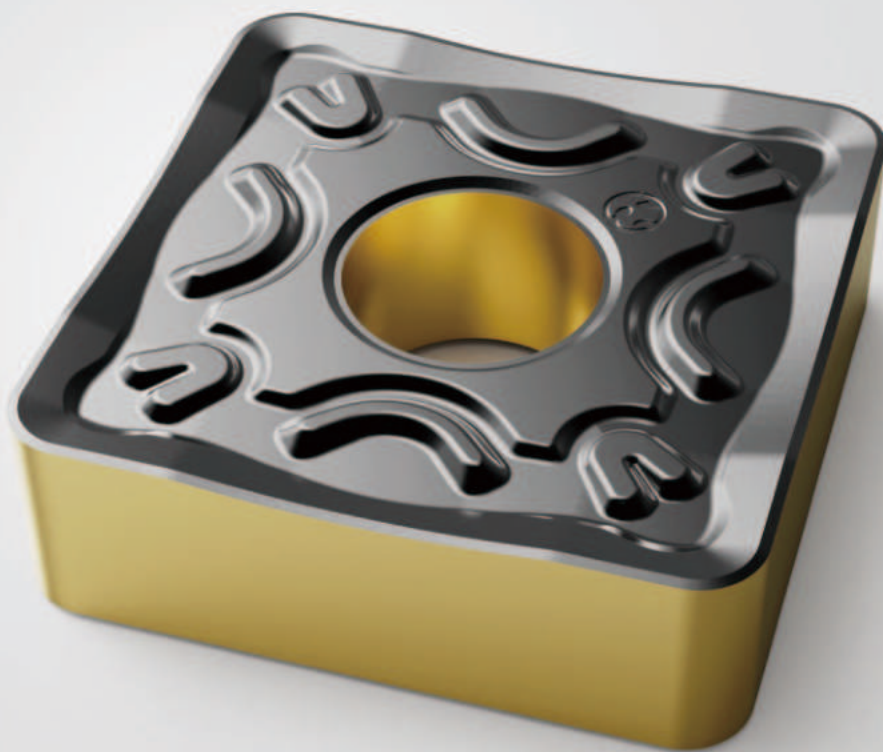
H
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重力切削刀片

HEAVY DUTY INSERTS



- 超致密硬质合金基体，抗冲击韧性提升 50%
- MT-TiAlN 复合涂层（微米 + 纳米叠层），耐高温 1100°C+
- 负前角强刀口 + 强化 R 角过渡，抗崩裂性能翻倍
- 超大容屑槽，重切削排屑流畅不堵刀

重载刀片牌号

CVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KP025	P15~P35	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.新一代钢件车削牌号, KP系列中应用最广泛的材质。 2.中等含钴量基体, 搭配高耐磨性涂层, 具有优异的耐磨性和抗冲击性能。 3.适用于钢件的重载车削加工。
KP035	P20~P45	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.新一代钢件车削牌号, KP系列中韧性最好的材质。 2.适用于钢件材质的粗加工、重载加工。
KT1253	P15~P35	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.全新的纳米柱状结构MT-TiCN和厚Al ₂ O ₃ 涂层, 与韧性、强度兼备的中钴梯度硬质合金基体相结合。 2.适用于碳钢、合金钢等材料的半精加工到粗加工, 亦可用于重载车削加工。
KT1371	P20~P40	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.高韧性基体搭配合适厚度的MT-TiCN和Al ₂ O ₃ 涂层, 使得材质在强冲击力工况下仍能兼顾耐磨性和稳定性。 2.适用于碳钢、合金钢等材料的车削粗加工, 重载加工。

A	车削刀片
B	铣削刀片
C	铝合金刀片
D	孔加工刀片
E	刮管刀片
F	非标异形刀片
G	圆棒和立铣刀
H	刀杆和刀盘
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Grade Information CVD Coated Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Application
KP025	P15~P35	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. A new generation of turning grade for steel , which is the most widely applied material in the KP series. 2. The substrate with a medium cobalt content is combined with a coating of high wear resistance, it has excellent performance of wear resistance and chipping resistance. 3. It is suitable for heavy-duty turning applications.
KP035	P20~P45	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. A new generation of turning grade for steel, which is the material with the best toughness in the KP series. 2. It is suitable for roughing processing of steel and heavy-duty applications.
KT1253	P15~P35	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. Using new nano-columnar structure of MT-TiCN and thick Al₂O₃ coating, combined with medium cobalt gradient cemented carbide substrate with both toughness and strength. 2. It is suitable for semi-finishing to roughing processing of carbon steel, alloy steel and other materials, and as well as for heavy-duty turning applications.
KT1371	P20~P40	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. High toughness substrate with suitable thickness of MT-TiCN and Al₂O₃ coating, which makes the material keep the wear resistance and stability under strong impact conditions. 2. It is suitable for roughing processing of carbon steel, alloy steel and other materials turning as well as for heavy-duty applications.

A 车削刀片

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重载产品牌号一览表 Recommended Grade Table

工件材料 Workpiece materials	ISO代号 ISO Code	CVD	PVD	金属陶瓷 Cermets	硬质合金 Cemented carbide	超硬材料 Superhard materials
P	P01					
	P10					
	P20	KT1253				
	P30	KT1371				
	P40	KP025				
M	M01	KP035				
	M10					
	M20					
	M30					
	M40					
K	K01					
	K10					
	K20					
	K30					
N	N01					
	N10					
	N20					
	N30					
S	S01					
	S10					
	S20					
	S30					
H	H01					
	H10					
	H20					
	H30					

A
车削刀片

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车削 / 重力车削刀片

Heavy-duty Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

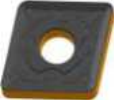
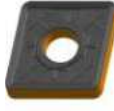
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

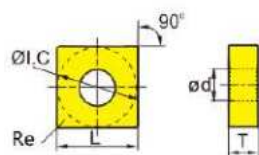
I 加工案例

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		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions							
		工件材料 Workpiece Material	P	M	K	N	S	H	
			钢	不锈钢	铸铁	有色金属	耐热合金、钛合金	淬硬钢	
			○	×	○	×	○	×	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			
		IC	S	Re	ød	KT1253	KT1373	KP025	KP035
	CNMM120408-GZ	12.7	4.76	0.8	5.16	▲	▲	●	●
	CNMM120412-GZ	12.7	4.76	1.2	5.16	▲	▲	●	●
	CNMM160612-GZ	15.875	6.35	1.2	6.35	▲	▲	●	●
	CNMM160616-GZ	15.875	6.35	1.6	6.35	▲	▲	●	●
	CNMM190612-GZ	19.05	6.35	1.2	7.93	▲	▲	●	●
	CNMM190616-GZ	19.05	6.35	1.6	7.93	▲	▲	●	●
	CNMM190624-GZ	19.05	6.35	2.4	7.93	▲	▲	●	●
	CNMM250924-GZ	25.4	9.52	2.4	9.12	▲	▲	●	●
	CNMM120408-MZ	12.7	4.76	0.8	5.16	▲	▲	●	●
	CNMM120412-MZ	12.7	4.76	1.2	5.16	▲	▲	●	●
	CNMM120416-MZ	12.7	4.76	1.6	5.16	▲	▲	●	●
	CNMM160612-MZ	15.875	6.35	1.2	6.35	▲	▲	●	●
	CNMM160616-MZ	15.875	6.35	1.6	6.35	▲	▲	●	●
	CNMM190612-MZ	19.05	6.35	1.2	7.93	▲	▲	●	●
	CNMM190616-MZ	19.05	6.35	1.6	7.93	▲	▲	●	●
	CNMM190624-MZ	19.05	6.35	2.4	7.93	▲	▲	●	●
	CNMM120408-KZ	12.7	4.76	0.8	5.16	▲	▲	●	●
	CNMM120412-KZ	12.7	4.76	1.2	5.16	▲	▲	●	●
	CNMM120416-KZ	12.7	4.76	1.6	5.16	▲	▲	●	●
	CNMM160612-KZ	15.875	6.35	1.2	6.35	▲	▲	●	●
	CNMM160616-KZ	15.875	6.35	1.6	6.35	▲	▲	●	●
	CNMM190612-KZ	19.05	6.35	1.2	7.93	▲	▲	●	●
	CNMM190616-KZ	19.05	6.35	1.6	7.93	▲	▲	●	●
	CNMM190616-KZ	19.05	6.35	1.6	7.93	▲	▲	●	●

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions									
		工件材料 Workpiece Material	P	钢				○	×	○	×
			M	不锈钢							
			K	铸铁							
			N	有色金属							
			S	耐热合金、钛合金							
			H	淬硬钢							
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层					
		IC	S	Re	ød	KT1253	KT1373	KP025	KP035		
	SNMM120408-GZ	12.7	4.76	0.8	5.16	▲	▲	●	●		
	SNMM120412-GZ	12.7	4.76	1.2	5.16	▲	▲	●	●		
	SNMM150612-GZ	15.875	6.35	1.2	6.35	▲	▲	●	●		
	SNMM190612-GZ	19.05	6.35	1.2	7.93	▲	▲	●	●		
	SNMM190616-GZ	19.05	6.35	1.6	7.93	▲	▲	●	●		
	SNMM190624-GZ	19.05	6.35	2.4	7.93	▲	▲	●	●		
	SNMM250724-GZ	25.4	7.94	2.4	9.12	▲	▲	●	●		
	SNMM250924-GZ	25.4	9.52	2.4	9.12	▲	▲	●	●		
	SNMM120408-MZ	12.7	4.76	0.8	5.16	▲	▲	●	●		
	SNMM120412-MZ	12.7	4.76	1.2	5.16	▲	▲	●	●		
	SNMM150612-MZ	15.875	6.35	1.2	6.35	▲	▲	●	●		
	SNMM190612-MZ	19.05	6.35	1.2	7.93	▲	▲	●	●		
	SNMM190616-MZ	19.05	6.35	1.6	7.93	▲	▲	●	●		
	SNMM190624-MZ	19.05	6.35	2.4	7.93	▲	▲	●	●		
	SNMM120408-KZ	12.7	4.76	0.8	5.16	▲	▲	●	●		
	SNMM120412-KZ	12.7	4.76	1.2	5.16	▲	▲	●	●		
	SNMM150612-KZ	15.875	6.35	1.2	6.35	▲	▲	●	●		
	SNMM190612-KZ	19.05	6.35	1.2	7.93	▲	▲	●	●		
	SNMM190616-KZ	19.05	6.35	1.6	7.93	▲	▲	●	●		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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车削 / 重力车削刀片

Heavy-duty Turning Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

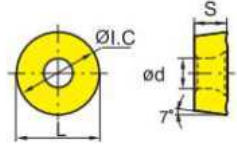
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

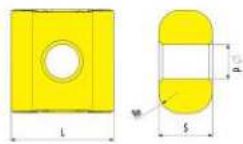
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		√ 良好工况 Good working conditions		○ 一般工况 General working conditions		× 不稳定工况 Unstable working conditions				
		工件材料 Workpiece Material	P	钢			○	×	○	×
			M	不锈钢						
			K	铸铁						
			N	有色金属						
			S	耐热合金、钛合金						
			H	淬硬钢						
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层				
		IC	S	Re	ød	KT1253	KT1373	KP025	KP035	
	RCMX1606MO	16	6.35	/	5.2	▲	▲	●	●	
	RCMX2006MO	20	6.35	/	6.5	▲	▲	●	●	
	RCMX2507MO	25	7.94	/	7.2	▲	▲	●	●	
	RCMX3209MO	32	9.52	/	9.5	▲	▲	●	●	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions								
		工件材料 Workpiece Material	P	钢			○	×	○	×
			M	不锈钢						
			K	铸铁						
			N	有色金属						
			S	耐热合金、钛合金						
			H	淬硬钢						
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层				
		IC	S	Re	ød	KT1253	KT1373	KP025	KP035	
	LINUX191940SN-DF	19.05	10	4	6.35	▲	▲	●	●	
	LINUX301940SN-DM	30	19	4	6.35	▲	▲	●	●	
	LNMX191940-RF	19.05	10	4	6.35	▲	▲	●	●	
	LNMX191940-DF	19.05	10	4	6.35	▲	▲	●	●	
	LNMX191940-DM	19.05	10	4	6.35	▲	▲	●	●	
	LNMX191940-RM	19.05	10	4	6.35	▲	▲	●	●	
	LNMX301940-RF	30	19	4	6.35	▲	▲	●	●	
	LNMX301940-DF	30	19	4	6.35	▲	▲	●	●	
	LNMX301940-DM	30	19	4	6.35	▲	▲	●	●	
	LNMX301940-RM	30	19	4	6.35	▲	▲	●	●	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

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E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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Ingenuity Quality, Stable and Efficient.

匠心品质 稳定高效



TUBE SCRAPER INSERTS

刮管刀片



刮管刀片

Tube Scraper Inserts

刮管刀片牌号介绍	Tube Scraper Inserts Grade Information	001
刮管刀产品牌号一览表		
Recommended Grade Overview for Tube Scraper Inserts		003
刮管刀片	Tube Scraper Inserts	004

刮管刀牌号

CVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KT1151	P10~P25	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.梯度结构的高硬度专用基体, 结合中温TiCN和超细Al ₂ O ₃ 涂层, 刀片具备优异的耐磨性能。 2.适用于钢件的车削加工, 追求高耐磨性场合。
KT1251	P15~P35	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.全新的纳米柱状结构MT-TiCN和厚Al ₂ O ₃ 涂层, 与韧性、强度兼备的中钴梯度硬质合金基体相结合。 2.适用于碳钢、合金钢等材料的半精加工到粗加工。
KT3221	P20~P35	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.采用中钴含量的韧性硬质合金基体, 结合中温TiCN和厚的Al ₂ O ₃ 涂层, 具有优良的耐磨性和抗崩缺性能。 2.适用于软钢、低碳钢、低碳合金钢的广泛车削加工。
KT1331	P25~P45	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.添加提高红硬性的组元、高韧性的高钴硬质合金基体, 结合高耐磨性的CVD涂层, 在恶劣工况下仍保持优异的加工性能。 2.适用于钢件的车削粗加工, 刮管加工。
KT1411	P25~P45	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.采用良好韧性的高钴基体, 结合专用CVD涂层, 在强断续加工时稳定可靠。 2.适用于钢件的车削粗加工, 常用于刮管、去毛刺等应用场合。

A

车削刀片

B

铣削刀片

C

铝合金刀片

D

孔加工刀片

E

刮管刀片

F

非标异形刀片

G

圆棒和立铣刀

H

刀杆和刀盘

I

加工案例

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通用技术信息

Grade Information

CVD Coated Grades

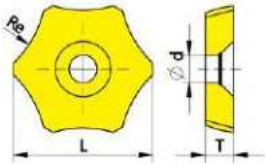
Grade	ISO	Types of Coating	Coating Composition	Features and Application
KT1151	P10~P25	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. Using the special high-hardness substrate of gradient structure, combined with medium temperature TiCN and ultra-fine Al ₂ O ₃ coating. It has excellent performance of wear resistance. 2. It is suitable for turning of steel and in pursuit of high wear-resistant occasions.
KT1251	P15~P35	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. Using new nano-columnar structure of MT-TiCN and thick Al ₂ O ₃ coating, combined with medium Cobalt gradient cemented carbide substrate with both toughness and strength. 2. It is suitable for semi-finishing to roughing processing of carbon steel, alloy steel and other materials.
KT3221	P20~P35	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. It uses medium cobalt content tough cemented carbide substrate, combined with medium temperature TiCN and thick Al ₂ O ₃ coating, which has excellent performance of wear resistance and chipping resistance. 2. It is suitable for a wide range of turning of soft steel, low carbon steel and low carbon alloy steel.
KT1331	P25~P45	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. Using a high-cobalt carbide substrate with enhanced hot hardness and toughness, combined with a highly wear-resistant CVD coating, delivers exceptional machining performance even under severe conditions. 2. It is suitable for rough turning of steel and tube scraping machining.
KT1411	P25~P45	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. Using high Cobalt content substrate with good toughness, combined with special CVD coating. It is stable and reliable in strong interrupted machining. 2. It is suitable for roughing processing of steel turning, and is commonly used in applications such as pipe scraping and deburring.

A
车削刀片B
铣削刀片C
铝合金刀片D
孔加工刀片E
刮管刀片F
非标异形刀片G
圆棒和立铣刀H
刀杆和刀盘I
加工案例J
通用技术信息

刮管刀产品牌号一览表

Recommended Grade Table

工件材料 Workpiece materials	ISO代号 ISO Code	CVD	PVD	金属陶瓷 Cermet	硬质合金 Cemented carbide	超硬材料 Superhard materials
P	P01					
	P10	KT1151				
	P20	KT1251				
	P30	KT3221				
	P40	KT1331				
M	M01	KT1411				
	M10					
	M20					
	M30					
	M40					
K	K01					
	K10					
	K20					
	K30					
N	N01					
	N10					
	N20					
	N30					
S	S01					
	S10					
	S20					
	S30					
H	H01		KT6109			
	H10					
	H20					
	H30					

		√ 良好工况 Good working conditions				○ 一般工况 General working conditions		× 不稳定工况 Unstable working conditions		
		工件材料 Workpiece Material	P	钢		√	○	○	×	×
			M	不锈钢						
			K	铸铁						
			N	有色金属						
			S	耐热合金、钛合金						
			H	淬硬钢						
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层				
		L	T	Φd	r	KT1151	KT1251	KT1331	KT3221	KT1411
	HDMB 20K-R12	20.7	4.76	5.2	12		●	▲		
	HDMB 20K-R15	20.7	4.76	5.2	15		●	▲		
	HDMB 20K-R20	20.7	4.76	5.2	20		●	▲		
	HDMB 20K-R25	20.7	4.76	5.2	25		●	▲		
	HDMB 20K-R40	20.7	4.76	5.2	40		●	▲		
	HDMB 20K-R50	20.7	4.76	5.2	50		●	▲		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

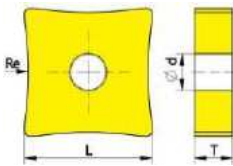
G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

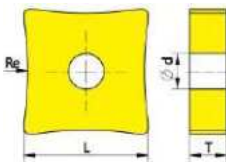
J 通用技术信息

- A车削刀片
- B铣削刀片
- C铝合金刀片
- D孔加工刀片
- E刮管刀片
- F非标异形刀片
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- H刀杆和刀盘
- I加工案例
- J通用技术信息

		√ 良好工况 Good working conditions				○ 一般工况 General working conditions		× 不稳定工况 Unstable working conditions		
		工件材料 Workpiece Material	P	钢		√	○	○	×	×
			M	不锈钢						
			K	铸铁						
			N	有色金属						
			S	耐热合金、钛合金						
			H	淬硬钢						
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层				
		L	T	Φd	r	KT1151	KT1251	KT1331	KT3221	KT1411
	SDUB 20K-R50	22	6	6.35	50	▲	●	●		
	SDUB 20K-R75	22	6	6.35	75	▲	●	●		
	SDUB 20K-R100	22	6	6.35	100	▲	●	●		
	SPUB 1904K-R12	19.05	4.76	5.2	12	▲	●	●		
	SPUB 1904K-R15	19.05	4.76	5.2	15	▲	●	●		
	SPUB 1904K-R18	19.05	4.76	5.2	18	▲	●	●		
	SPUB 1904K-R20	19.05	4.76	5.2	20	▲	●	●		
	SPUB 1904K-R23	19.05	4.76	5.2	23	▲	●	●		
	SPUB 1904K-R25	19.05	4.76	5.2	25	▲	●	●		
	SPUB1904K-R30	19.05	4.76	5.2	30	▲	●	●		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions						
		工件材料 Workpiece Material	P 钢	√	○	○	×	×
	型号 Type	M 不锈钢						
		K 铸铁						
		N 有色金属						
		S 耐热合金、钛合金						
		H 淬硬钢						
	尺寸 Dimensions (mm)	CVD涂层						
		L	T	r	KT1151	KT1251	KT1331	KT3221
	SNGN 12K-R10	12.70	8.00	10.00		●		▲
	SNGN 12K-R16	12.70	8.00	16.00		●		▲
	SNGN 12K-R20	12.70	8.00	20.00		●		▲
	SNGN 12K-R25	12.70	8.00	25.00		●		▲
	SNGN 12K-R30	12.70	8.00	30.00		●		▲
	SNGN 12K-R40	12.70	8.00	40.00		●		▲
	SNGN 12K-R50	12.70	8.00	50.00		●		▲
	SNGN 12K-R60	12.70	8.00	60.00		●		▲
	SNGN 12K-R70	12.70	8.00	70.00		●		▲
	SNGN 12K-R80	12.70	8.00	80.00		●		▲
	SNGN 12K-R90	12.70	8.00	90.00		●		▲
	SNGN12K-R12.5	12.70	8.00	12.50		●		▲
	SNGN 12K-R14.5	12.70	8.00	14.50		●		▲
	SNGN 12K-R18	12.70	8.00	18.00		●		▲
	SNGN 12K-R23	12.70	8.00	23.00		●		▲
	SNGN 12K-R28	12.70	8.00	28.00		●		▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

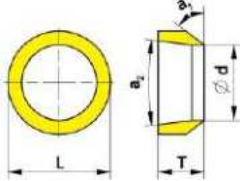
G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

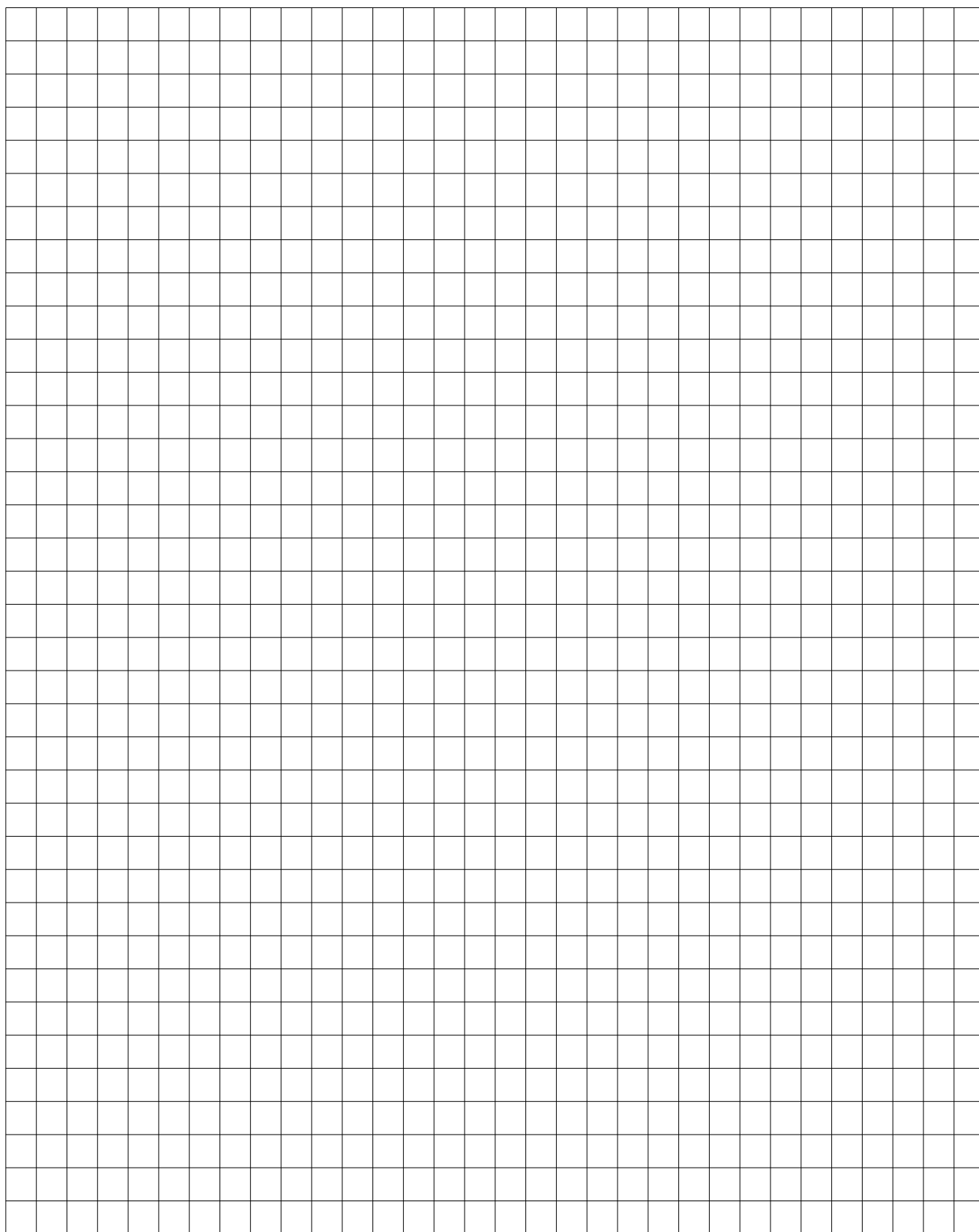
J 通用技术信息

- A车削刀片
- B铣削刀片
- C铝合金刀片
- D孔加工刀片
- E刮管刀片
- F非标异形刀片
- G圆棒和立铣刀
- H刀杆和刀盘
- I加工案例
- J通用技术信息

		√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions											
		工件材料 Workpiece Material	P	钢					√	○	○	×	×
			M	不锈钢									
			K	铸铁									
			N	有色金属									
			S	耐热合金、钛合金									
			H	淬硬钢									
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层						
		L	T	Φd	α1	α2	KT1151	KT1251	KT1331	KT3221	KT1411		
	RNGX1004N06-AR6.5	10	4.5	6	24	48			▲				
	RNGX1910N09-AR10	19	10	9	17	42			▲				
	RNGX2212N12-AR14	22	12	12	35	36			▲				
	RNGX3512N20-AR23	35	12	20	50.6	36			▲				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order


A
 车削刀片

B
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 通用技术信息

Ingenuity Quality, Stable and Efficient.

匠心品质 稳定高效



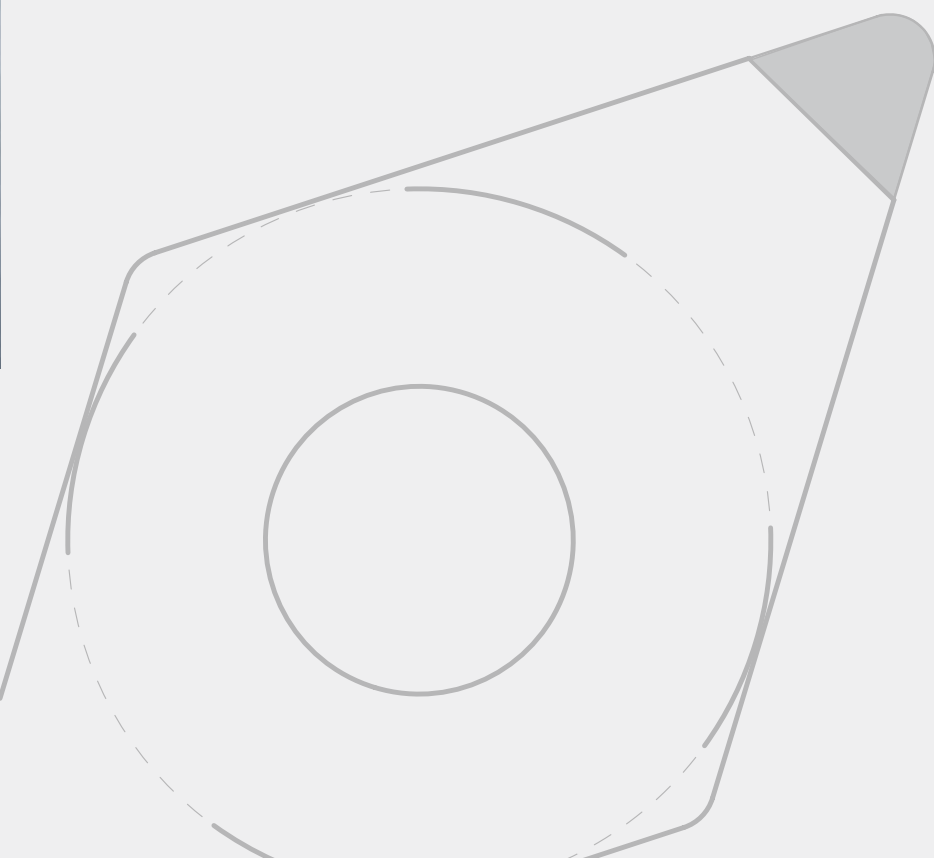
PCBN INSERTS

PCBN 刀片



PCBN 刀片

PCBN Inserts



PCBN刀片命名规则

PCBN Insert Naming Rules

形状代号 Shape

C N G A 12 04 08

 A	 B	 C
 D	 E	 H
 K	 L	 M
 P	 S	 T
 V	 W	其他 Z

断屑槽及夹固形式代号 Chip Breaker and Hole

C N G A 12 04 08

代号 Symbol	有无孔 Center Hole	刀片剖面 Insert Profile
N	无	
B	有	
C	有	
A	有	
W	有	
Q	有	
X	---	特殊

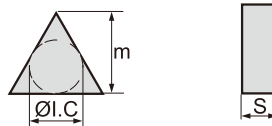
后角代号 Clearance Angle

C N G A 12 04 08

A	B
	
C	D
	
E	F
	
G	N
	
P	O
	其它后角 Others

精度代号 Tolerance

C N G A 12 04 08



等级	刀尖高度 M 公差(mm)	内接圆ØI.C 公差(mm)	厚度 S 公差(mm)	等级	刀尖高度 M 公差(mm)	内接圆ØI.C 公差(mm)	厚度 S 公差(mm)
A	±0.005	±0.025	±0.025	J	±0.005	±0.05-±0.13	±0.025
F	±0.005	±0.013	±0.025	K	±0.013	±0.05-±0.13	±0.025
C	±0.013	±0.025	±0.025	L	±0.025	±0.05-±0.13	±0.025
H	±0.013	±0.013	±0.025	M	±0.08-±0.18	±0.05-±0.13	±0.13
E	±0.025	±0.025	±0.025	N	±0.08-±0.18	±0.05-±0.13	±0.025
G	±0.025	±0.025	±0.13	U	±0.13-±0.38	±0.08-±0.25	±0.13

PCBN刀片命名规则

PCBN Insert Naming Rules

切削刃长度代号 Cutting Edge Length

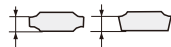
C N G A **12** 04 08

内切圆直径 Inscribed Circle diameter(mm)	刀片外形 Insert Shape					
	C	D	S	T	V	W
3.97				06		
5						
5.56				09		
6						
6.35	06	07		11	11	
8						
9.525	09	11	09	16	16	06
10						
12						
12.7	12	15	12	22	22	08
15.875	16		15	27		
16			16			
19.05	19		19	33		
20						
25	25	25				
25.4			25			
31.75						
32						

刀片厚度代号 Thickness

C N G A 12 **04** 08

代号 Symbol	刀片厚度 Thickness(mm)
02	2.38
T2	2.58
03	3.18
T3	3.97
04	4.76
T4	4.96
05	5.56
T5	5.95
06	6.35
T6	6.75
07	7.94
09	9.52
T9	9.72
11	11.11
12	12.7



厚度指刀片底面与切削刃最高部分之间的高度
The Height Between Insert Bottom And Nose

刀尖圆弧代号 Corner Radius

C N G A 12 04 **08**

代号 Symbol	刀尖圆弧半径 (mm) Corner Radius (mm)
00	无圆角
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2
24	2.4
32	3.2
X	其它 Special

刀片直径尺寸mo (公制)
Diameter Dimension

圆形刀片
Round Insert

T 020 20 - 2

刃口形式

Type of edge

代号 Code	形式 Form	图形 Shape
F	锋利刃口 Sharpedge	
E	钝化 Passivation	
T	倒棱 Chamfering	
S	倒棱+钝化 Chamfering Passivation	

倒棱宽度

Chamfering width



010	0.10	040	0.40
015	0.15	045	0.45
020	0.20	050	0.50
025	0.25	100	1.00
030	0.30	200	2.00
035	0.35		

倒棱角度

Chamfering angle



05	5°
10	10°
15	15°
20	20°
25	25°
30	30°

刀尖数量

Number of insert tip

代号 Code	刃数 Number of edge	图形 Shape
未注 N/M	单刃 Single-edged	
2	二刃 Double-edged	
3	三刃 Three-edged	
4	四刃 Four-edged	

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

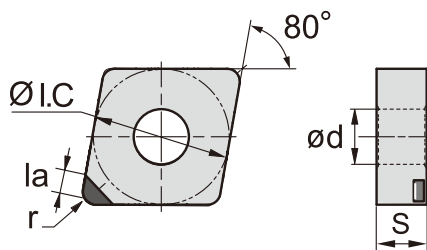
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

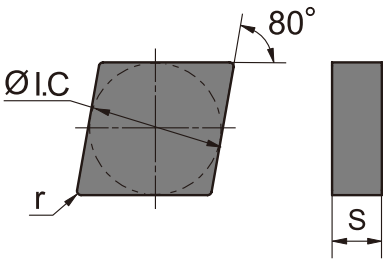
J 通用技术信息



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	Ød	r	la	KB4011	KB4012	KD7011	KD7012
	CNGA120404	12.7	4.76	5.16	0.4	2.5	•	•		
	CNGA120408	12.7	4.76	5.16	0.8	2.4	•	•		
	CNGA120412	12.7	4.76	5.16	1.2	2.3	•	•		
	CNGA120404-2	12.7	4.76	5.16	0.4	2.5	▲	▲		
	CNGA120408-2	12.7	4.76	5.16	0.8	2.4	▲	▲		
	CNGA120412-2	12.7	4.76	5.16	1.2	2.3	•	•		
	CNGA120404-2	12.7	4.76	5.16	0.4	2.5			•	
	CNGA120408-2	12.7	4.76	5.16	0.8	2.4			•	
	CNGA120412-2	12.7	4.76	5.16	1.2	2.3			•	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)			牌号 Grade			
		ØI.C	S	r	KB4011	KB4012	KD7011	KD7012
	CNGN120404	12.7	4.76	0.4			•	
	CNGN12T608	12.7	6.75	0.8			•	
	CNGN120712	12.7	7.94	1.2			•	

▲ 为主推荐牌号 Recommended grade (Always stock available) ● 按订单生产可选牌号 Make-to-order

- A** 车削刀片
- B** 铣削刀片
- C** 铝合金刀片
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- E** 刮管刀片
- F** 非标异形刀片
- G** 圆棒和立铣刀
- H** 刀杆和刀盘
- I** 加工案例
- J** 通用技术信息

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

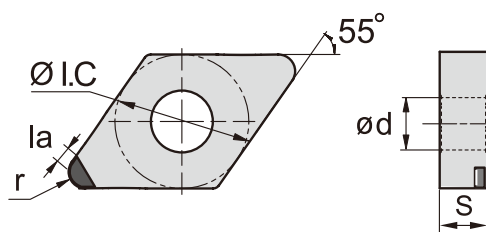
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

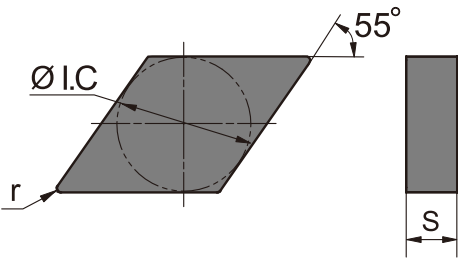
J 通用技术信息



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	Ød	r	la	KB4011	KB4012	KD7011	KD7012
	DNGA150404	12.7	4.76	5.16	0.4	2.5	•	•		
	DNGA150408	12.7	4.76	5.16	0.8	2.1	•	•		
	DNGA150412	12.7	4.76	5.16	1.2	2.0	•	•		
	DNGA150602	12.7	6.35	5.16	0.2	2.7	•	•		
	DNGA150604	12.7	6.35	5.16	0.4	2.5	•	•		
	DNGA150608	12.7	6.35	5.16	0.8	2.1	•	•		
	DNGA150612	12.7	6.35	5.16	1.2	2.0	•	•		
	DNGA150404-2	12.7	4.76	5.16	0.4	2.5	▲	▲		
	DNGA150408-2	12.7	4.76	5.16	0.8	2.1	▲	▲		
	DNGA150412-2	12.7	4.76	5.16	1.2	2.0	•	•		
	DNGA150602-2	12.7	6.35	5.16	0.2	2.7	•	•		
	DNGA150604-2	12.7	6.35	5.16	0.4	2.5	•	•		
	DNGA150608-2	12.7	6.35	5.16	0.8	2.1	•	•		
	DNGA150612-2	12.7	6.35	5.16	1.2	2.0	•	•		
	DNGA150404-2	12.7	4.76	5.16	0.4	2.5			•	
	DNGA150408-2	12.7	4.76	5.16	0.8	2.1			•	
	DNGA150412-2	12.7	4.76	5.16	1.2	2.0			•	
	DNGA150604-2	12.7	6.35	5.16	0.4	2.5			•	
	DNGA150608-2	12.7	6.35	5.16	0.8	2.1			•	
	DNGA150612-2	12.7	6.35	5.16	1.2	2.0			•	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)			牌号 Grade			
		ØI.C	S	r	KB4011	KB4012	KD7011	KD7012
	DNGN110404	9.525	4.76	04			•	
	DNGN110408	9.525	4.76	0.8			•	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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J 通用技术信息

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

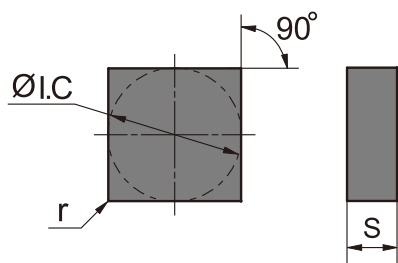
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

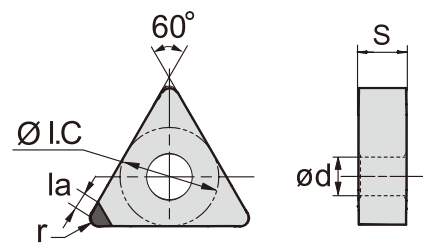
J 通用技术信息



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)			牌号 Grade			
		ØI.C	S	r	KB4011	KB4012	KD7011	KD7012
	SNGN120404	12.7	4.76	0.4			•	
	SNGN120408	12.7	4.76	0.8			•	
	SNGN12T612	12.7	6.75	1.2			•	
	SNGN150716	15.875	7.94	1.6			•	
	SNGN150720	15.875	7.94	2.0			•	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	Ød	r	la	KB4011	KB4012	KD7011	KD7012
	TNGA160402	9.525	4.76	3.81	0.2	2.5	▲	▲		
	TNGA160404	9.525	4.76	3.81	0.4	2.5	▲	▲		
	TNGA160408	9.525	4.76	3.81	0.8	2.2	●	●		
	TNGA160412	9.525	4.76	3.81	1.2	2.0	●	●		
	TNGA160402-3	9.525	4.76	3.81	0.2	2.5	●	●		
	TNGA160404-3	9.525	4.76	3.81	0.4	2.5	●	●		
	TNGA160408-3	9.525	4.76	3.81	0.8	2.2	●	●		
	TNGA160412-3	9.525	4.76	3.81	1.2	2.0	●	●		
	TNGA160404-3	9.525	4.76	3.81	0.4	2.5			●	
	TNGA160408-3	9.525	4.76	3.81	0.8	2.2			●	
	TNGA160412-3	9.525	4.76	3.81	1.2	2.0			●	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A
车削刀片

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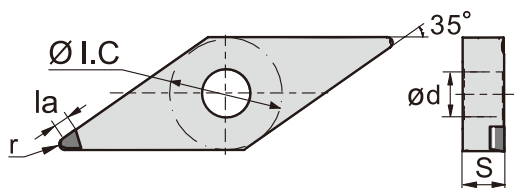
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

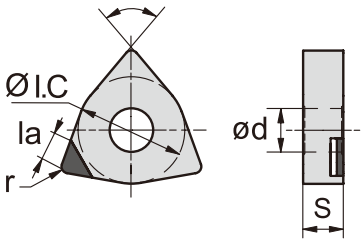
J 通用技术信息



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	Ød	r	la	KB4011	KB4012	KD7011	KD7012
	VNGA160402	9.525	4.76	3.81	0.2	3.3	●	●		
	VNGA160404	9.525						●		
	VNGA160408	9.525	4.76	3.81	0.8	2.5	●	●		
	VNGA160412	9.525	4.76	3.81	1.2	2.0	●	●		
	VNGA160402-2	9.525	4.76	3.81	0.2	3.3	●	●		
	VNGA160404-2	9.525	4.76	3.81	0.4	2.8	▲	▲		
	VNGA160408-2	9.525	4.76	3.81	0.8	2.5	▲	▲		
	VNGA160412-2	9.525	4.76	3.81	1.2	2.0	●	●		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	Ød	r	la	KB4011	KB4012	KD7011	KD7012
	WNGA080404-3	12.7	4.76	5.16	0.4	3.3	▲	▲		
	WNGA080408-3	12.7	4.76	5.16	0.8	2.8	▲	▲		
	WNGA080412-3	12.7	4.76	5.16	1.2	2.8	●	●		
	WNGA080404-3	12.7	4.76	5.16	0.4	3.3			●	
	WNGA080408-3	12.7	4.76	5.16	0.8	2.8			●	
	WNGA080412-3	12.7	4.76	5.16	1.2	2.8			●	

▲ 为主推荐牌号 Recommended grade (Always stock available) ● 按订单生产可选牌号 Make-to-order

- A** 车削刀片
- B** 铣削刀片
- C** 铝合金刀片
- D** 孔加工刀片
- E** 刮管刀片
- F** 非标异形刀片
- G** 圆棒和立铣刀
- H** 刀杆和刀盘
- I** 加工案例
- J** 通用技术信息

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

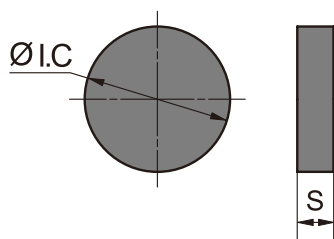
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

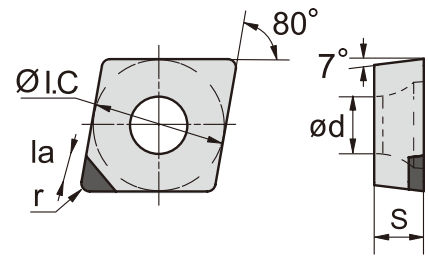
J 通用技术信息



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)		牌号 Grade			
		ØI.C	S	KB4011	KB4012	KD7011	KD7012
	RNGN090300	9.525	3.18			•	
	RNGN120400	12.7	4.76			•	
	RNGN120700	12.7	7.94			•	
	RNGN150700	15.875	7.94			•	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	Ød	r	la	KB4011	KB4012	KD7011	KD7012
	CCGW060204	6.35	2.38	2.8	0.4	2.5	•	•		▲
	CCGW060208	6.35	2.38	2.8	0.8	2.4	•	•		▲
	CCGW09T304	9.525	3.97	4.4	0.4	2.5	•	•		▲
	CCGW09T308	9.525	3.97	4.4	0.8	2.4	•	•		▲
	CCGW120404	12.7	4.76	5.5	0.4	2.5	•	•		
	CCGW120408	12.7	4.76	5.5	0.8	2.4	•	•		▲
	CCGW120412	12.7	4.76	5.5	1.2	2.3	•	•		
	CCGW060204-2	6.35	2.38	2.8	0.4	2.5	•	•		
	CCGW060208-2	6.35	2.38	2.8	0.8	2.4	•	•		
	CCGW09T304-2	9.525	3.97	4.4	0.4	2.5	▲	▲		
	CCGW09T308-2	9.525	3.97	4.4	0.8	2.4	▲	▲		
	CCGW120404-2	12.7	4.76	5.5	0.4	2.5	▲	▲		
	CCGW120408-2	12.7	4.76	5.5	0.8	2.4	▲	▲		
	CCGW120412-2	12.7	4.76	5.5	1.2	2.3	•	•		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A
车削刀片

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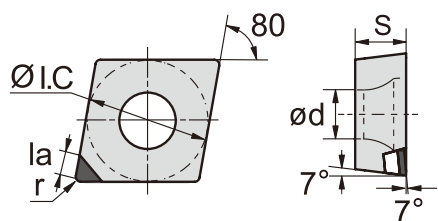
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

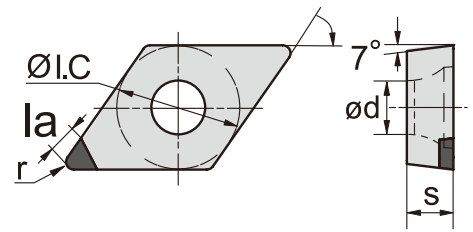
J 通用技术信息

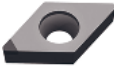


刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		$\varnothing I.C$	S	$\varnothing d$	r	la	KB4011	KB4012	KD7011	KD7012
	CCMX060202	6.35	2.38	2.8	0.2	2.5				▲
	CCMX060204	6.35	2.38	2.8	0.4	2.5				▲
	CCMX060208	6.35	2.38	2.8	0.8	2.4				▲
	CCMX09T304	9.525	3.97	4.4	0.4	2.5				▲
	CCMX09T308	9.525	3.97	4.4	0.8	2.4				▲
	CCMX120408	12.7	4.76	5.5	0.8	2.4				▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

◆ 按订单生产可选牌号 Make-to-order



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	ød	r	la	KB4011	KB4012	KD7011	KD7012
	DCGW070202	6.35	2.38	2.8	0.2	2.7	•	•		▲
	DCGW070204	6.35	2.38	2.8	0.4	2.5	•	•		▲
	DCGW070208	6.35	2.38	2.8	0.8	2.1	•	•		
	DCGW11T304	9.525	3.97	4.4	0.4	2.5	•	•		▲
	DCGW11T308	9.525	3.97	4.4	0.8	2.1	•	•		▲
	DCGW070202-2	6.35	2.38	2.8	0.2	2.7	•	•		
	DCGW070204-2	6.35	2.38	2.8	0.4	2.5	•	•		
	DCGW070208-2	6.35	2.38	2.8	0.8	2.1	•	•		
	DCGW11T304-2	9.525	3.97	4.4	0.4	2.5	▲	▲		
	DCGW11T308-2	9.525	3.97	4.4	0.8	2.1	▲	▲		
	DCMX070202	6.35	2.38	2.8	0.2	2.7				▲
	DCMX070204	6.35	2.38	2.8	0.4	2.5				▲
	DCMX11T304	9.525	3.97	4.4	0.4	2.5				▲
	DCMX11T308	9.525	3.97	4.4	0.8	2.1				▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

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E 刮管刀片

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D 孔加工刀片

E 刮管刀片

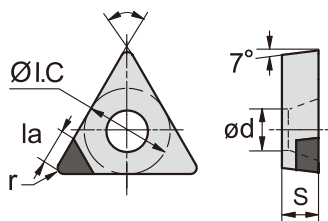
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

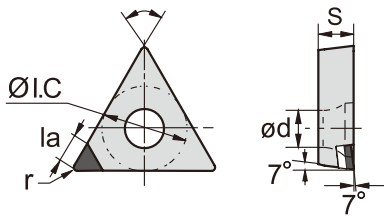
J 通用技术信息



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	ød	r	la	KB4011	KB4012	KD7011	KD7012
	TCGW090204	5.56	2.38	2.5	0.4	2.5	●	●		▲
	TCGW090208	5.56	2.38	2.5	0.8	2.2	●	●		▲
	TCGW110202	6.35	2.38	2.8	0.2	2.5	●	●		▲
	TCGW110204	6.35	2.38	2.8	0.4	2.5	●	●		▲
	TCGW110208	6.35	2.38	2.8	0.8	2.2	●	●		▲
	TCGW110304	6.35	3.18	2.8	0.4	2.5	●	●		▲
	TCGW16T304	9.525	3.97	4.4	0.4	2.5	●	●		▲
	TCGW16T308	9.525	3.97	4.4	0.8	2.2	●	●		▲
	TCGW16T312	9.525	3.97	4.4	1.2	2.0	●	●		▲
	TCGW090204-3	5.56	2.38	2.5	0.4	2.5	●	●		
	TCGW090208-3	5.56	2.38	2.5	0.8	2.2	●	●		
	TCGW110202-3	6.35	2.38	2.8	0.2	2.5	●	●		
	TCGW110204-3	6.35	2.38	2.8	0.4	2.5	▲	▲		
	TCGW110208-3	6.35	2.38	2.8	0.8	2.2	▲	▲		
	TCGW110304-3	6.35	3.18	2.8	0.4	2.5	▲	▲		
	TCGW16T304-3	9.525	3.97	4.4	0.4	2.5	▲	▲		
	TCGW16T308-3	9.525	3.97	4.4	0.8	2.2	▲	▲		
	TCGW16T312-3	9.525	3.97	4.4	1.2	2.0	●	●		

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	Ød	r	la	KB4011	KB4012	KD7011	KD7012
	TCMX090204	5.56	2.38	2.5	0.4	2.5				▲
	TCMX090208	5.56	2.38	2.5	0.8	2.0				▲
	TCMX110202	6.35	2.38	2.8	0.2	2.5				▲
	TCMX110204	6.35	2.38	2.8	0.4	2.5				▲
	TCMX110208	6.35	2.38	2.8	0.8	2.0				▲
	TCMX110304	6.35	3.18	2.8	0.4	2.5				▲
	TCMX16T304	9.525	3.97	4.4	0.4	2.5				▲
	TCMX16T308	9.525	3.97	4.4	0.8	2.0				▲
	TCMX16T312	9.525	3.97	4.4	1.2	2.0				▲

▲ 为主推荐牌号 Recommended grade (Always stock available) ● 按订单生产可选牌号 Make-to-order

- A 车削刀片
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- E 刮管刀片
- F 非标异形刀片
- G 圆棒和立铣刀
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- I 加工案例
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A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

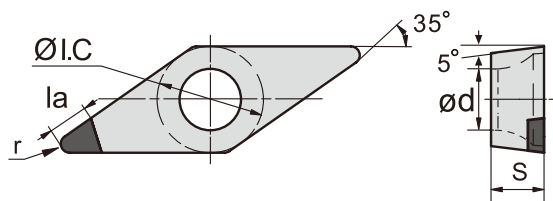
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

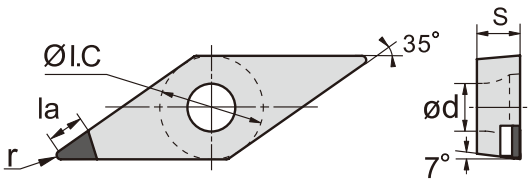
J 通用技术信息



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	Ød	r	la	KB4011	KB4012	KD7011	KD7012
	VBGW160404	9.525	4.76	4.4	0.4	2.8	●	●		▲
	VBGW160408	9.525	4.76	4.4	0.8	2.5	●	●		▲
	VBGW160412	9.525	4.76	4.4	1.2	2.0	●	●		▲
	VBGW160404-2	9.525	4.76	4.4	0.4	2.8	▲	▲		
	VBGW160408-2	9.525	4.76	4.4	0.8	2.5	▲	▲		
	VBGW160412-2	9.525	4.76	4.4	1.2	2.0	●	●		
	VBMX160404	9.525	4.76	4.4	0.4	2.8				▲
	VBMX160408	9.525	4.76	4.4	0.8	2.5				▲
	VBMX160412	9.525	4.76	4.4	1.2	2.0				▲

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order



刀片外形 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					牌号 Grade			
		ØI.C	S	Ød	r	la	KB4011	KB4012	KD7011	KD7012
	VCGW160404	9.525	4.76	4.4	0.4	2.8				▲
	VCGW160408	9.525	4.76	4.4	0.8	2.5				▲
	VCGW160412	9.525	4.76	4.4	1.2	2.0				▲
	VCMX160404	9.525	4.76	4.4	0.4	2.8				▲
	VCMX160408	9.525	4.76	4.4	0.8	2.5				▲
	VCMX160412	9.525	4.76	4.4	1.2	2.0				▲

▲ 为主推荐牌号 Recommended grade (Always stock available) ● 按订单生产可选牌号 Make-to-order

A
 车削刀片

B
 铣削刀片

C
 铝合金刀片

D
 孔加工刀片

E
 刮管刀片

F
 非标异形刀片

G
 圆棒和立铣刀

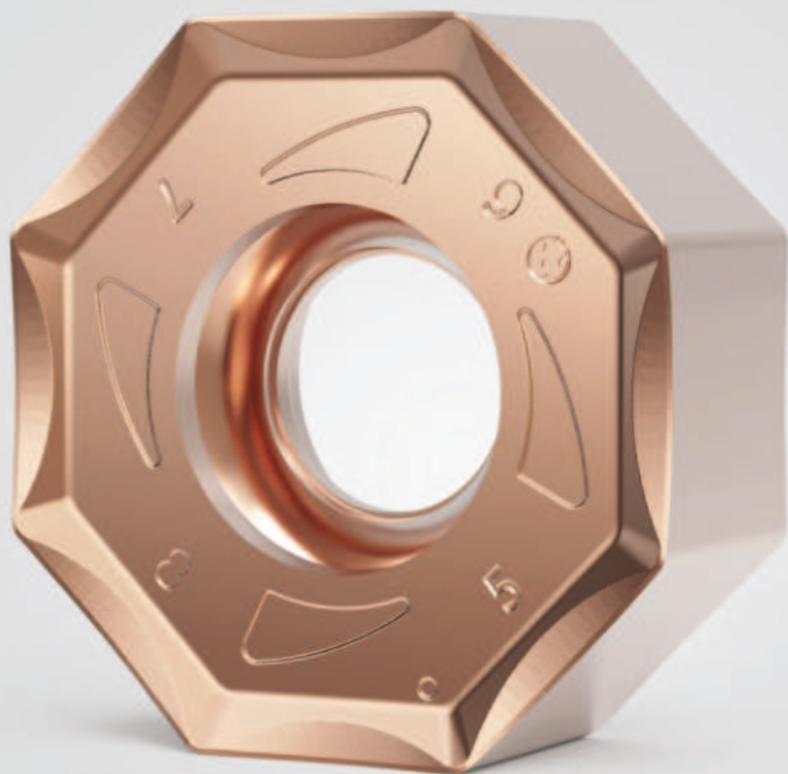
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铣削刀片

MILLING INSERTS



双面刃口，经济加倍

强悍材质，持久耐用

高效切削，省时省力

灵活适配，广泛兼容



铣削刀片

Milling Inserts

铣削刀片牌号介绍	Milling Inserts Grade Information	001
铣削产品牌号一览表		
Recommended Grade Overview For Milling Inserts		006
铣削刀片型号命名规则	Milling Inserts Naming Rules	007
铣削刀片	Milling Inserts	009

铣削牌号

CVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KT1311	P15~P30	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.采用高强度和高韧性的硬质合金基体, 结合薄的氧化铝CVD涂层, 具有优异耐磨性和抗冲击性能。 2.适用于钢件材料的半精铣削加工。
KT2252	P15~P35 M10~M30	CVD 黑色	MT-TiCN+Al ₂ O ₃	1.采用中钴成分的高韧性梯度合金基体, 搭配细晶柱状TiCN和超细的薄的Al ₂ O ₃ 涂层, 具有优异的抗崩缺能力和高温强度。 2.适用于合金钢、碳素钢、不锈钢材料的半精铣和粗铣加工。
KT2302	P25~P40 M20~M35	CVD 黑色	MT-TiCN+Al ₂ O ₃	1.高韧性的硬质合金基体与TiCN、薄Al ₂ O ₃ 涂层的结合, 最大强度保证刃口强度和抗冲击性能。 2.适用于钢件、不锈钢材料的粗铣加工。
KT3262	K15~K35	CVD 黑色	MT-TiCN+Al ₂ O ₃	1.中等晶粒的强韧性基体, 结合MT-TiCN和厚的Al ₂ O ₃ 涂层工艺, 具备良好的刃口强度和优异的耐磨性能。 2.适用于铸铁的粗铣及半精铣削加工。
KT3252	K15~K35	CVD 黑色	MT-TiCN+Al ₂ O ₃	1.高韧性基体, 优异的抗破损能力。 2.适用于铸铁铣削粗加工, 大切深, 大进给, 工况差场合。

A
车削刀片

B
铣削刀片

C
铝合金刀片

D
孔加工刀片

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PVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KT1236	P15~P35	PVD 黑色	TiAlN	1.含特殊组元的中钴含量基体,与纳米复合高铝PVD涂层协同强化,赋予刀片刀口卓越的红硬性。 2.适用于模具钢、合金结构钢等材料的铣削加工。
KT8287N	M15~M30 S15~S20	PVD 银白色	Oxide	1.升级的强韧性基体,搭配高热稳定性、高耐磨性和防粘结的多层复合氧化物涂层。 2.适用于不锈钢、钛合金等的铣削加工。
KT8296	P10~P30 M10~M30	PVD 灰黑色	TiAlN	1.较高耐磨性的细晶粒中钴基体,搭配通用性好的TiAlN涂层,具有良好的膜基结合力、耐磨性和抗氧化性能。 2.适用于合金钢、不锈钢等材料的半精铣削加工,为钢件、不锈钢铣削首选牌号。
KT8295	P10~P30 M10~M30	PVD 黄色	TiAlN	1.采用中钴含量的高耐磨性细晶硬质合金基体,搭配高铝TiAlN纳米涂层,具有高的涂层硬度、优良的耐高温性能,为切削刃提供有效保护。 2.适用于合金钢、不锈钢等材料的半精铣削加工。
KT8326	P20~P35 M20~M35	PVD 灰黑色	TiAlN	1.在韧性和耐磨性较高的硬质合金基体上,沉积纳米TiAlN涂层,具有优异的抗崩刃性,加工稳定性好,可获得了较好的刀具寿命。 2.适用于钢件、不锈钢的半精、粗铣加工,亦可用于不稳定工况下的铣削加工。
KW40	P10~P30 M10~M30 S10~S25	PVD 黄色	TiAlN	1.高钴含量的细颗粒硬质合金基体,增强了抗冲击性,采用PVD镀层,具有高耐磨性和耐热性,尤其适合低切削速度和小进给量的工况。 2.适用于钢件与不锈钢的稳定工况加工,适用于高温合金的精铣和半精铣。
KT1455	P25~P40 M25~M40 S10~S25	PVD 黄色	TiAlN	1.采用高韧性的硬质合金基体,结合高铝纳米TiAlN涂层,具有优异的抗崩刃性和热稳定性。 2.适用于钢和不锈钢的半精、粗铣加工,以及耐热合金的低速、半精铣削加工。
KT1405	P25~P40	PVD 黄色	TiAlN	1.采用高粘结相的中颗粒硬质合金基体,具有最佳的抗崩刃性。 2.适用于钢件的半精、粗铣加工。
KS20	S10~S25	PVD 香槟色	Oxide	1.中钴含量的细颗粒硬质合金基体,搭配多层复合氧化物涂层,提供了优异的刀口强度和热稳定性。 2.适用于高温合金的铣削加工。
KT6259	H15~H30	PVD 七彩色	AlTiCrSiN	1.采用低钴含量的细晶粒硬质合金基体,结合优异性能的纳米结构PVD涂层,具有优异的耐磨性和耐高温性能。 2.适用于淬硬钢的半精和精铣削加工。

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Grade Information

CVD Coated Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Application
KT1311	P15~P30	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. Using high strength and toughness cemented carbide substrate, combined with thin Al₂O₃ CVD coating, it has excellent performance of wear resistance and impact resistance. 2. It is suitable for semi-finishing processing of steel milling.
KT2252	P15~P35 M10~M30	CVD Black	MT-TiCN+Al ₂ O ₃	1. Using high toughness gradient cemented carbide substrate with medium cobalt content, matched with fine crystalline columnar TiCN and ultra-fine Al₂O₃ coating. It has excellent performance of chipping resistance and high temperature resistance. 2. It is suitable for semi-finishing and roughing processing of alloy steel, carbon steel and stainless steel milling.
KT2302	P25~P40 M20~M35	CVD Black	MT-TiCN+Al ₂ O ₃	1. The combination of high toughness carbide substrate with TiCN and thin Al₂O₃ coating highly ensures the edge strength and performance of impact resistance. 2. It is suitable for roughing processing of steel and stainless steel milling.
KT3262	K15~K35	CVD Black	MT-TiCN+Al ₂ O ₃	1. Using strong toughness substrate of medium crystal grain, combined with MT-TiCN and thick Al₂O₃ coating process. It has excellent edge strength and performance of wear resistance. 2. It is suitable for roughing and semi-finishing processing of cast iron milling.
KT3252	K15~K35	CVD Black	MT-TiCN+Al ₂ O ₃	1. High-toughness substrate, with excellent fracture resistance ability. 2. It is suitable for rough processing of cast iron, with large cutting depth and high feed rate, and is applicable to the poor cutting conditions.

A 车削刀片

B 铣削刀片

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PVD Coated Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Application
KT1236	P15~P35	PVD Black	TiAlN	1. The substrate with medium cobalt content containing special components and is strengthened together with the high-aluminum nano-composite PVD coating, making the cutting edge with excellent red hardness. 2. It is suitable for the processing of die steel and alloy structural steel.
KT8287N	M15~M30 S15~S20	PVD Silver	Oxide	1. The upgraded tough substrate is paired with a multi-layer composited oxide coating featuring high thermal stability, high wear resistance, and anti-adhesion properties. 2. It is suitable for the processing of stainless steel, titanium alloy, etc.
KT8296	P10~P30 M10~M30	PVD Gray-black	TiAlN	1. The fine-grain medium cobalt substrate with high wear resistance is matched with high universality of TiAlN coating. It has good film-based adhesion, wear resistance and oxidation resistance. 2. It is suitable for semi-finishing milling of alloy steel, stainless steel, superalloy and other materials, and is the preferred grade for steel and stainless steel milling.
KT8295	P10~P30 M10~M30	PVD Yellow	TiAlN	1. It adopts a fine-grained medium cobalt content substrate with high wear resistance, and is coated with a high-aluminum TiAlN nanocoating. It has high coating hardness and excellent high-temperature resistance, providing effective protection for the cutting edge. 2. It is suitable for semi-finishing of alloy steel and stainless steel.
KT8326	P20~P35 M20~M35	PVD Gray-black	TiAlN	1. Both high toughness and wear resistance of cemented carbide substrate is matching with the deposition of nano-TiAlN coating, it has excellent edge collapse resistance, good processing stability and good tool life. 2. It is suitable for semi-finishing and roughing milling of steel and stainless steel, and also for milling under unstable working conditions.
KW40	P10~P30 M10~M30 S10~S25	PVD Yellow	TiAlN	1. The fine-grained substrate with high cobalt content enhances the impact resistance. And the adoption of PVD coating ensures high wear resistance and heat resistance, making it particularly suitable for the working conditions with low cutting speed and small feed rate. 2. It is suitable for the steel and stainless steel with stable working conditions, and is applicable to the finishing and semi-finishing processing of superalloys.
KT1455	P25~P40 M25~M40 S10~S25	PVD Yellow	TiAlN	1. A high-toughness substrate combined with high-aluminum nano TiAlN coating, which has excellent edge chipping resistance and thermal stability. 2. It is suitable for semi-finishing and roughing of steel and stainless steel, as well as low cutting speed and semi-finishing of heat-resistant alloys.
KT1405	P25~P40	PVD Yellow	TiAlN	1. A medium-grained substrate with a high bonding phase, which has the best cutting edge chipping resistance. 2. It is suitable for semi-finishing and roughing of steel.
KS20	S10~S25	PVD Champagne	Oxide	1. The fine-grained substrate with a medium cobalt content, paired with a multi-layer composite oxide coating, provides excellent cutting edge strength and thermal stability. 2. It is suitable for the milling processing of superalloys.
KT6259	H15~H30	PVD Multiple-color	AlTiCrSiN	1. Using the fine-grained cemented carbide substrate with low cobalt content, combined with high excellent performance of PVD nano-coating. It has excellent wear resistance and high temperature resistance. 2. It is suitable for semi-finishing and finishing milling of hardened steel.

A
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金属陶瓷牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KC5280	P10~P25 M10~M25 K10~K25	无涂层	\	1.TiCN基金属陶瓷牌号, 细小弥散的硬质相颗粒、粘结相强化和环形相结构控制三者结合, 使之表现出优异的耐磨性和抗月牙洼磨损性能。 2.适用于钢件、不锈钢、铸铁材料的精铣加工。
KC5230	P10~P25 M10~M25 K10~K25	无涂层	\	1.TiCN基金属陶瓷牌号, 具有均匀、晶粒细化组织, 环形相结构, 提高了材料的强度和耐磨性。 2.适用于钢件、不锈钢、铸铁材料的精铣、半精铣削加工。

Cermet Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Application
KC5280	P10~P25 M10~M25 K10~K25	UNCOATED	\	1.TiCN-based cermet grade, fine dispersion hard phase particles, bonded phase reinforcement and annular phase structure control are combined to show excellent wear resistance, and crater wear resistance. 2.It is suitable for finishing milling processing of steel, stainless steel, cast iron materials.
KC5230	P10~P25 M10~M25 K10~K25	UNCOATED	\	1. TiCN-based cermet grade, with uniform, grain refinement structure, annular phase structure, improve the strength and wear resistance of the material. 2. It is suitable for finishing milling and semi-finishing milling of steel, stainless steel and cast iron materials.

铣削产品牌号一览表

Milling Inserts Recommended Grade Table

工件材料 Workpiece materials	ISO代号 ISO Code	CVD	PVD	金属陶瓷 Cermet	硬质合金 Cemented carbide	超硬材料 Superhard materials
P	P01					
	P10	KT1311	KT1236 KT8295	KC5280 KC5230		
	P20	KT2252	KT8326			
	P30		KT1405			
	P40					
M	M01					
	M10		KT8287N KT8296 KW40	KC5280 KC5230		
	M20	KT2252				
	M30	KT2302	KT1455			
	M40					
K	K01					
	K10	KT3262				
	K20	KT3252				
	K30					
N	N01					
	N10					
	N20					
	N30					
S	S01					
	S10		KS20 KW40			
	S20					
	S30					
H	H01					
	H10		KT6259			
	H20					
	H30					

A
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铣削刀片型号命名规则 Milling Inserts Naming Rules

形状代号 Shape

A **P** **M** **T** **II** **35** **PD** **E** **R** — **GM**

A	B	C
		
D	E	H
		
K	L	M
		
O	P	R
		
S	T	T
		
V	W	
		

断屑槽及夹固形式代号 Chip Breaker and Hole

A **P** **M** **T** **II** **35** **PD** **E** **R** — **GM**

代号 Symbol	有无孔 Center Hole	有无断屑槽 Chip Breaker	刀片剖面 Insert Profile	代号 Symbol	有无孔 Center Hole	有无断屑槽 Chip Breaker	刀片剖面 Insert Profile
B	有(Y)	无(N)		N	无(N)	无(N)	
H	有(Y)	单面(S)		R	无(N)	单面(S)	
C	有(Y)	无(N)		F	无(N)	双面(D)	
J	有(Y)	双面(D)		A	有(Y)	无(N)	
W	有(Y)	无(N)		M	有(Y)	单面(S)	
T	有(Y)	单面(S)		G	有(Y)	双面(D)	
Q	有(Y)	无(N)		X			
U	有(Y)	双面(D)					

后角代号 Clearance Angle

A **P** **M** **T** **II** **35** **PD** **E** **R** — **GM**

A	B
	
C	D
	
E	F
	
G	N
	
P	O
	其它后角 Others

精度代号 Tolerance

A **P** **M** **T** **II** **35** **PD** **E** **R** — **GM**

代号 Symbol	刀尖高度m 公差 (mm) m(mm)	内接圆ΦI.C 公差 (mm) d=I.C. (mm)	厚度S 公差 (mm) s (mm)	(参考) M级精度详细情况 (按形状、大小分) ●刀尖高度公差(mm) (reference) M grade tolerance detail (according to shape, size.) Tolerance of insert nose height												
				内切圆 Inscribed Circle	正三角形 Regular Triangle	正方形 Square	80°菱形 80° Rhombus	55°菱形 55° Rhombus	35°菱形 35° Rhombus	圆形 Round						
				6.35	±0.08	±0.08	±0.08	±0.11	±0.16	...						
				9.525	±0.08	±0.08	±0.08	±0.11	±0.16	...						
				12.7	±0.13	±0.13	±0.13	±0.15	...	...						
A	±0.005	±0.025	±0.025	15.875	±0.15	±0.15	±0.15	±0.18	...	...						
F	±0.005	±0.013	±0.025	19.05	±0.15	±0.15	±0.15	±0.18	...	...						
C	±0.013	±0.025	±0.025	25.4	...	±0.18	...	...	...	...						
H	±0.013	±0.013	±0.013	●内接圆ΦI.C公差 (mm) ●Tolerance of Inscribed Circle												
E	±0.025	±0.025	±0.025	内切圆 Inscribed Circle	正三角形 Regular Triangle	正方形 Square	80°菱形 80° Rhombus	55°菱形 55° Rhombus	35°菱形 35° Rhombus	圆形 Round						
G	±0.025	±0.025	±0.13													
J	±0.005	±0.05-±0.13	±0.025								6.35	±0.05	±0.05	±0.05	±0.05	±0.05
K	±0.013	±0.05-±0.13	±0.025								9.525	±0.05	±0.05	±0.05	±0.05	±0.05
L	±0.025	±0.05-±0.13	±0.025	12.7	±0.08	±0.08	±0.08	±0.08	...	±0.08						
M	±0.08-±0.18	±0.05-±0.13	±0.13	15.875	±0.1	±0.1	±0.10	±0.10	...	±0.1						
N	±0.08-±0.18	±0.05-±0.13	±0.025	19.05	±0.1	±0.1	±0.10	±0.10	...	±0.1						
U	±0.13-±0.38	±0.08-±0.25	±0.13	25.4	...	...	±0.13	...	...	±0.13						

铣削刀片型号命名规则 Milling Inserts Naming Rules

切前刃长度代号 Cutting Edge Length

A P M T **II** 35 PD E R — GM

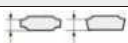
内切圆直径 Inscribed Circle diameter(mm)	刀片外形 Insert Shape							
	C	D	R	S	T	V	W	K
								
3.97					06			
5			05					
5.56					09			
6			06					
6.35	06	07			11	11		
8			08					
9.525	09	11	09	09	16	16	06	16
10			10					
12			12					
12.7	12	15	12	12	22	22	08	
15.875	16		15	15	27			
16			16	16				
19.05	19		19	19	33			
20			20					
25	25	25	25					
25.4			25	25				
31.75			31					
32			32					

刀片厚度代号 Thickness

A P M T II 35 PD E R — GM

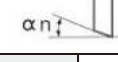
代号 Symbol	刀片厚度 Thickness(mm)
00	0.79
T0	0.99
01	1.59
T1	1.98
02	2.38
T2	2.58
03	3.18
T3	3.97
04	4.76
T4	4.96
05	5.56
T5	5.95
06	6.35
T6	6.75
07	7.94
09	9.52
T9	9.72
11	11.11
12	12.7

厚度指刀片底面与切削刃最高部分之间的高度
The Height Between Insert Bottom And Nose



修光刃代号 Wiper Code

A P M T II 35 PD E R — GM

			
A	45°	A	3°
D	60°	B	5
E	75	C	70
F	85	D	15
P	90°	E	20°
Z	其它	F	25
		G	30
		N	0°
		P	11°
		Z	其它

切削刃倒棱代号 Cutting Edge Chamfering

A P M T II 35 PD **E** R — GM

F							K
E		0	5	0	0.1		P
		1	10°	1	0.15		
T		2	15°	2	0.2		W
		4	20°	3	0.25		
		5	25°	4	0.3		
S			30°	5	0.35		不 标
				6	0.4		
				7	0.45		

切削方向代号 Cutting Direction

A P M T II 35 PD E **R** — GM

R	右 Right
L	左 Left
N	双向 Neutral

断屑槽型代号 Chip Breaker Code

A P M T II 35 PD E R — GM

GH	GM	GL
		
HM	SM	AK
		

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

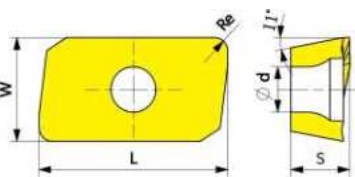
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

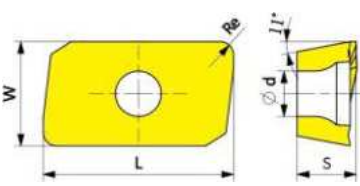
√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions								
		工件材料 Workpiece Material	P 钢	○	×		√	×	√	○		○	√	○								
			M 不锈钢					○	○	○	○	○	√	○		○						
			K 铸铁			○				○		○	√						○	○		
			N 有色金属																○	○		
			S 耐热合金、钛合金						○						√	○						
			H 淬硬钢																			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层										硬质合金		
		L	W	Φd	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120	
	AOMT090304R-GM	9.52	3.35	2.8	3.35	0.4			▲			▲		●	▲	●						
	AOMT11T308R-GM	11.3	3.8	2.8	3.8	0.8			▲			▲		●	▲	●						
	AOMT130408R-GM	13.6	4.76	2.8	4.76	0.8			▲			▲		●	▲	●						
	AOMT170608R-GM	17.5	6.15	4.4	6.15	0.8			▲			▲		●	▲	●						
	AOGX09T3PER-GM	9.52	3.35	2.8	3.35	0.4			▲			▲		●	▲	●						
	AOGX1706PER-GM	13.6	4.76	2.8	4.76	0.8			▲			▲		●	▲	●						
	AOMT0903PER-GM	17.5	6.15	4.4	6.15	0.8			▲			▲		●	▲	●						
	AOGT1304PER-GM	11.3	3.8	2.8	3.8	0.8			▲			▲		●	▲	●						
	AOGT1706PER-GM	17.5	6.15	4.4	6.15	0.8			▲			▲		●	▲	●						
	AOGT130404R-GM	13.6	4.76	2.8	4.76	0.4			▲			▲		●	▲	●						
	AOGT130430R-GM	13.6	4.76	2.8	4.76	3			▲			▲		●	▲	●						
	AOGT130440R-GM	13.6	4.76	2.8	4.76	4			▲			▲		●	▲	●						
	AOGT170612R-GM	17.5	6.15	4.4	6.15	1.2			▲			▲		●	▲	●						
	AOGT170616R-GM	17.5	6.15	4.4	6.15	1.6			▲			▲		●	▲	●						
	AOGT170620R-GM	17.5	6.15	4.4	6.15	2			▲			▲		●	▲	●						
	AOGT170632R-GM	17.5	6.15	4.4	6.15	3.2			▲			▲		●	▲	●						
	AOGT170640R-GM	17.5	6.15	4.4	6.15	4			▲			▲		●	▲	●						

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	/	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

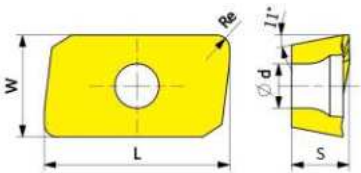
√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions							
		工件材料 Workpiece Material	P	钢	○	×		√	×	√	○		○	√	○						
			M	不锈钢					○	○	○	○	○	√	○		○				
			K	铸铁			○				○		○	√							
			N	有色金属														○	○		
			S	耐热合金、钛合金						○						√	○				
			H	淬硬钢																	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层								硬质合金			
		L	W	Φd	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120
	AOMT090304R-GH	9.52	3.35	2.8	3.35	0.4			▲			▲		●	▲	●					
	AOMT130408R-GH	13.6	4.76	2.8	4.76	0.8			▲			▲		●	▲	●					
	AOMT190712R-GH	19	7.04	4.4	7.04	1.2			▲			▲		●	▲	●					
	AOMT090302R-GL	9.52	3.35	2.8	3.35	0.2						▲		●	▲	●					
	AOMT090304R-GL	9.52	3.35	2.8	3.35	0.4						▲		●	▲	●					
	AOMT090308R-GL	9.52	3.35	2.8	3.35	0.8						▲		●	▲	●					
	AOMT090312R-GL	9.52	3.35	2.8	3.35	1.2						▲		●	▲	●					
	AOMT090316R-GL	9.52	3.35	2.8	3.35	1.6						▲		●	▲	●					
	AOMT090320R-GL	9.52	3.35	2.8	3.35	2						▲		●	▲	●					
	AOMT11T304R-GL	11.3	3.8	2.8	3.8	0.4						▲		●	▲	●					
	AOMT11T308R-GL	11.3	3.8	2.8	3.8	0.8						▲		●	▲	●					
	AOMT11T312R-GL	11.3	3.8	2.8	3.8	1.2						▲		●	▲	●					
	AOMT130408R-GL	13.6	4.76	2.8	4.76	0.8						▲		●	▲	●					
	AOMT130412R-GL	13.6	4.76	2.8	4.76	1.2						▲		●	▲	●					
	AOMT130416R-GL	13.6	4.76	2.8	4.76	1.6						▲		●	▲	●					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions							
		工件材料 Workpiece Material	P	钢	○	×		√	×	√	○		○	√	○						
			M	不锈钢					○	○	○	○	○	√	○			○			
			K	铸铁			○					○		○	√						
			N	有色金属															○	○	
			S	耐热合金、钛合金						○							√	○			
			H	淬硬钢																	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层								硬质合金			
		L	W	Φd	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120
	AOGT11T3PER-HM	11.3	3.8	2.8	3.8	0.8			▲			▲		●	▲	●					
	AOGT1304PER-HM	13.6	4.76	2.8	4.76	0.8			▲			▲		●	▲	●					
	AOGT1706PER-HM	17.5	6.15	4.4	6.15	0.8			▲			▲		●	▲	●					
	AOGT11T330R-HM	11.3	3.8	2.8	3.8	3			▲			▲		●	▲	●					
	AOGT130416R-HM	13.6	4.76	2.8	4.76	1.6			▲			▲		●	▲	●					
	AOGT170616R-HM	17.5	6.15	4.4	6.15	1.6			▲			▲		●	▲	●					
	AOGT11T3PER-SM	11.3	3.8	2.8	3.8	0.8												▲			
	AOGT1304PER-SM	13.6	4.76	2.8	4.76	0.8												▲			
	AOGT1706PER-SM	17.5	6.15	4.4	6.15	0.8												▲			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

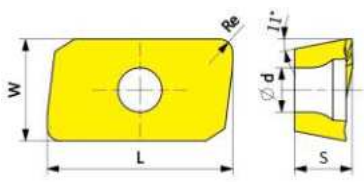
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

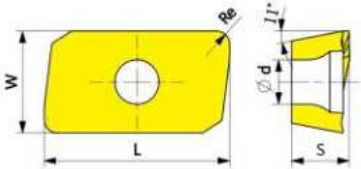
√ 良好工况 Good working conditions							○ 一般工况 General working conditions										× 不稳定工况 Unstable working conditions									
		工件材料 Workpiece Material	P	钢		○	×		√	×	√	○		○	√	○										
			M	不锈钢						○	○	○	○	○	√	○		○								
			K	铸铁				○				○		○	√											
			N	有色金属																	○	○				
			S	耐热合金、钛合金							○						√	○								
			H	淬硬钢																						
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层										硬质合金						
		L	W	Φd	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120					
	AOHX0803PEL-AK	9.52	3.35	2.80	3.35	0.4														●	▲					
	AOHX0803PER-AK	9.52	3.35	2.80	3.35	0.4														●	▲					
	AOHX10T3PER-AK	11.30	3.80	2.80	3.8	0.8														●	▲					
	AOHX1204PEL-AK	13.60	4.76	2.80	4.76	0.8														●	▲					
	AOHX1204PER-AK	13.60	4.76	2.80	4.76	0.8														●	▲					
	AOHX1606PEL-AK	17.50	6.15	4.40	6.15	0.8														●	▲					
	AOHX1606PER-AK	17.50	6.15	4.40	6.15	0.8														●	▲					
	AOHX120416L-AK	13.60	4.76	2.80	4.76	1.6														●	▲					
	AOHX120416R-AK	13.60	4.76	2.80	4.76	1.6														●	▲					
	AOHX120430L-AK	13.60	4.76	2.80	4.76	3														●	▲					
	AOHX120440R-AK	13.60	4.76	2.80	4.76	4														●	▲					
	AOHX160616L-AK	17.50	6.15	4.40	6.15	1.6														●	▲					
	AOHX160616R-AK	17.50	6.15	4.40	6.15	1.6														●	▲					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	/	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions							
		工件材料 Workpiece Material	P	钢	○	×		√	×	√	○		○	√	○						
			M	不锈钢					○	○	○	○	○	√	○		○				
			K	铸铁			○				○		○	√							
			N	有色金属														○	○		
			S	耐热合金、钛合金						○						√	○				
			H	淬硬钢																	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层								硬质合金			
		L	W	Φd	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120
	APKT1003PDER-GL	11.6	6.76	3.5	2.8	0.8					▲		●	▲	●						
	APKT1003PDER-GH	11.6	6.76	3.5	2.8	0.8			▲		▲		●	▲	●						
	APKT1003PDER-GM	1.6	6.76	3.5	2.8	0.8			▲		▲		●	▲	●						
	APKT100304PDER-GM	11.6	6.76	3.5	2.8	0.4			▲		▲		●	▲	●						
	APKT1003012PDER-GM	11.6	6.76	3.5	2.8	1.2			▲		▲		●	▲	●						
	APKT100316PDER-GM	11.6	6.76	3.5	2.8	1.6			▲		▲		●	▲	●						
	APKT100325PDER-GM	11.6	6.76	3.5	2.8	2.5			▲		▲		●	▲	●						
	APKT100330PDER-GM	11.6	6.76	3.5	2.8	3			▲		▲		●	▲	●						
▲ 为主推荐牌号 Recommended grade (Always stock available) ● 按订单生产可选牌号 Make-to-order																					

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

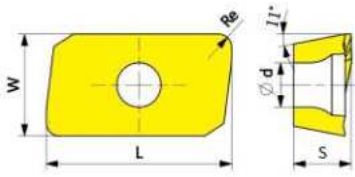
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

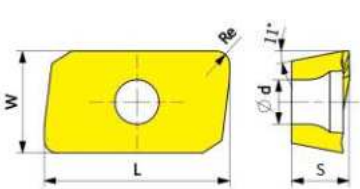
√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions								
		工件材料 Workpiece Material	P	钢	○	×		√	×	√	○		○	√	○							
			M	不锈钢						○	○	○	○	○	√	○		○				
			K	铸铁			○					○		○	√							
			N	有色金属															○	○		
			S	耐热合金、钛合金						○							√	○				
			H	淬硬钢																		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层										硬质合金		
		L	W	Φd	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120	
	APMT113504PDER-GL	11.25	6.2	3.5	2.8	0.4						▲		●	▲	●						
	APMT113508PDER-GL	11.25	6.2	3.5	2.8	0.8						▲		●	▲	●						
	APMT113512PDER-GL	11.25	6.2	3.5	2.8	1.2						▲		●	▲	●						
	APMT113516PDER-GL	11.25	6.2	3.5	2.8	1.6						▲		●	▲	●						
	APMT113504PDER-GM	11.25	6.2	3.5	2.8	0.4			▲			▲		●	▲	●						
	APMT113508PDER-GM	11.25	6.2	3.5	2.8	0.8			▲			▲		●	▲	●						
	APMT113512PDER-GM	11.25	6.2	3.5	2.8	1.2			▲			▲		●	▲	●						
	APMT113516PDER-GM	11.25	6.2	3.5	2.8	1.6			▲			▲		●	▲	●						
	APMT113504PDER-GH	11.25	6.2	3.5	2.8	0.4			▲			▲		●	▲	●						
	APMT113508PDER-GH	11.25	6.2	3.5	2.8	0.8			▲			▲		●	▲	●						
	APMT113512PDER-GH	11.25	6.2	3.5	2.8	1.2			▲			▲		●	▲	●						
	APMT113516PDER-GH	11.25	6.2	3.5	2.8	1.6			▲			▲		●	▲	●						
▲ 为主推荐牌号 Recommended grade (Always stock available) ● 按订单生产可选牌号 Make-to-order																						

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions							
		工件材料 Workpiece Material	P	钢		○	×		√	×	√	○		○	√	○					
M	不锈钢							○	○	○	○	○	√	○		○					
K	铸铁				○					○		○	√								
N	有色金属																○	○			
S	耐热合金、钛合金								○						√	○					
H	淬硬钢																				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层								硬质合金			
		L	W	Φd	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120
	APMT160404PDER-GL	17.8	9.3	4.76	4.4	0.4						▲		●	▲	●					
	APMT160408PDER-GL	17.8	9.3	4.76	4.4	0.8						▲		●	▲	●					
	APMT160412PDER-GL	17.8	9.3	4.76	4.4	1.2						▲		●	▲	●					
	APMT160416PDER-GL	17.8	9.3	4.76	4.4	1.6						▲		●	▲	●					
	APMT160404PDER-GM	17.8	9.3	4.76	4.4	0.4			▲			▲		●	▲	●					
	APMT160408PDER-GM	17.8	9.3	4.76	4.4	0.8			▲			▲		●	▲	●					
	APMT160412PDER-GM	17.8	9.3	4.76	4.4	1.2			▲			▲		●	▲	●					
	APMT160416PDER-GM	17.8	9.3	4.76	4.4	1.6			▲			▲		●	▲	●					
	APMT160404PDER-GH	17.8	9.3	4.76	4.4	0.4			▲			▲		●	▲	●					
	APMT160408PDER-GH	17.8	9.3	4.76	4.4	0.8			▲			▲		●	▲	●					
	APMT160412PDER-GH	17.8	9.3	4.76	4.4	1.2			▲			▲		●	▲	●					
	APMT160416PDER-GH	17.8	9.3	4.76	4.4	1.6			▲			▲		●	▲	●					
▲ 为主推荐牌号 Recommended grade (Always stock available)							● 按订单生产可选牌号 Make-to-order														

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

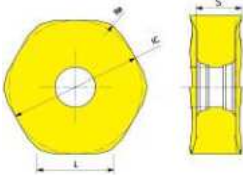
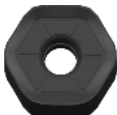
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

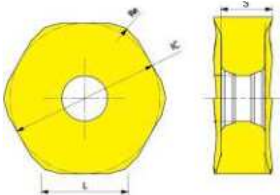
√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions												
		工件材料 Workpiece Material	P	钢			○	×		√	×	√	○		○	√	○							
			M	不锈钢							○	○	○	○	○	√	○			○				
			K	铸铁					○					○		○	√							
			N	有色金属																		○	○	
			S	耐热合金、钛合金									○						√	○				
			H	淬硬钢																				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层										硬质合金					
		L	I.C	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120				
	HNGX0604-GH	6.44	12	4.45	1			▲			●		●	▲	●									
	HNGX0604-GH	6.44	12	4.45	1.6			▲			●		●	▲	●									
	HNGX0604-GH	6.44	12	4.45	3.2			▲			●		●	▲	●									
	HNGX0905-GH	9	15.88	5.56	1.2			▲			●		●	▲	●									
	HNGX0905-GH	9	15.88	5.56	2			▲			●		●	▲	●									
	HNGX0905-GH	9	15.88	5.56	3.5			▲			●		●	▲	●									
	HNGX1307-GH	12.83	22.23	7.41	1.2			▲			●		●	▲	●									
	HNGX1307-GH	12.83	22.23	7.41	2			▲			●		●	▲	●									
	HNGX1307-GH	12.83	22.23	7.41	3.5			▲			●		●	▲	●									
	HNGX0604-GM	6.44	12	4.45	1			▲			●		●	▲	●									
	HNGX0604-GM	6.44	12	4.45	1.6			▲			●		●	▲	●									
	HNGX0604-GM	6.44	12	4.45	3.2			▲			●		●	▲	●									
	HNGX0905-GM	9	15.88	5.56	1.2			▲			●		●	▲	●									
	HNGX0905-GM	9	15.88	5.56	2			▲			●		●	▲	●									
	HNGX0905-GM	9	15.88	5.56	3.5			▲			●		●	▲	●									
	HNGX1307-GM	12.83	22.23	7.41	1.2			▲			●		●	▲	●									
	HNGX1307-GM	12.83	22.23	7.41	2			▲			●		●	▲	●									
	HNGX1307-GM	12.83	22.23	7.41	3.5			▲			●		●	▲	●									

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	/	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions											
		工件材料 Workpiece Material	P	钢			○	×		√	×	√	○		○	√	○						
			M	不锈钢							○	○	○	○	○	√	○			○			
			K	铸铁					○				○		○	√							
			N	有色金属																	○	○	
			S	耐热合金、钛合金								○						√	○				
			H	淬硬钢																			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层								硬质合金						
		L	I.C	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120			
	HNGX0604-GL	6.44	12	4.45	1						●		●	▲	●								
	HNGX0604-GL	6.44	12	4.45	1.6						●		●	▲	●								
	HNGX0604-GL	6.44	12	4.45	3.2						●		●	▲	●								
	HNGX0905-GL	9	15.88	5.56	1.2						●		●	▲	●								
	HNGX0905-GL	9	15.88	5.56	2						●		●	▲	●								
	HNGX0905-GL	9	15.88	5.56	3.5						●		●	▲	●								
	HNGX0905-SM	9	15.88	5.56	1.2												▲						
	HNGX0905-SM	9	15.88	5.56	2												▲						
	HNGX0905-SM	9	15.88	5.56	3.5												▲						

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

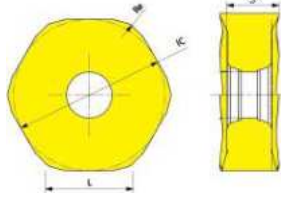
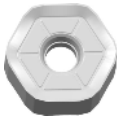
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

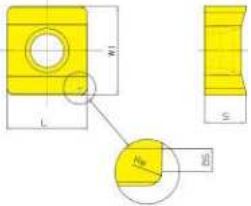
√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions												
		工件材料 Workpiece Material	P	钢			○	×		√	×	√	○		○	√	○							
			M	不锈钢							○	○	○	○	○	√	○			○				
			K	铸铁					○				○		○	√								
			N	有色金属																		○	○	
			S	耐热合金、钛合金									○						√	○				
			H	淬硬钢																				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层								硬质合金							
		L	I.C	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120				
	HNGX0604-AK	6.44	12	4.45	1															●	▲			
	HNGX0604-AK	6.44	12	4.45	1.6															●	▲			
	HNGX0604-AK	6.44	12	4.45	3.2															●	▲			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions									
	工件材料 Workpiece Material	P	钢					○	×		√	×	√	○		○	√	○					
		M	不锈钢									○	○	○	○	○	√	○		○			
		K	铸铁							○				○		○	√						
		N	有色金属																		○	○	
		S	耐热合金、钛合金										○					√	○				
		H	淬硬钢																				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层								硬质合金					
		W1	L	S	BS	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120		
	K3043505E-KL	9.5	4.6	3.5	0.4	0.5			▲						▲	●							
	K3054508E-KL	9.5	5.7	4.45	1.2	0.8			▲						▲	●							
	K3084508E-KL	9.5	7.7	4.45	1.2	0.8			▲						▲	●							
	K3084520E-KL	9.5	6.5	4.5	1.2	2.0			▲						▲	●							
	K3115008E-KL	11.5	10.7	4.95	1.2	0.8			▲						▲	●							
	K3115020E-KL	11.5	9.5	5	1.2	2.0			▲						▲	●							
	K3145008E-KL	11.5	13.7	4.95	1.2	0.8			▲						▲	●							
	K3043505M-KM	9.5	4.6	3.5	0.4	0.5			▲						▲	●							
	K3054508E-KM	9.5	5.7	4.45	1.2	0.8			▲						▲	●							
	K3054508M-KM	9.5	5.7	4.45	1.2	0.8			▲						▲	●							
	K3084508E-KM	9.5	7.7	4.45	1.2	0.8			▲						▲	●							
	K3084508M-KM	9.5	7.7	4.45	1.2	0.8			▲						▲	●							
	K3084520E-KM	9.5	6.5	4.45	1.2	2.0			▲						▲	●							
	K3115008E-KM	11.5	10.7	4.95	1.2	0.8			▲						▲	●							
	K3115008M-KM	11.5	10.7	4.95	1.2	0.8			▲						▲	●							
	K3115020E-KM	11.5	9.5	4.95	1.2	2.0			▲						▲	●							
	K3145008E-KM	11.5	13.7	4.95	1.2	0.8			▲						▲	●							
	K3145008M-KM	11.5	13.7	4.95	1.2	0.8			▲						▲	●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

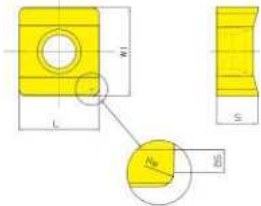
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

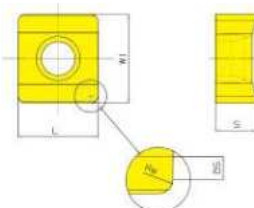
√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions											
		工 件 材 料 Work pie ce Ma te ri al	P	钢				○	×		√	×	√	○		○	√	○							
			M	不锈钢								○	○	○	○	○	√	○			○				
			K	铸铁						○					○		○	√						○	
			N	有色金属																			○	○	
			S	耐热合金、钛合金									○							√	○				
			H	淬硬钢																					
产 品 Inserts Shape	型 号 Type	尺 寸 Dimensions (mm)					CVD涂层			PVD涂层										硬 质 合 金					
		W1	L	S	BS	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120				
	K3043505H-AK	9.5	4.6	3.5	0.2	0.5															▲	●			
	K3054508H-AK	9.5	5.7	4.45	0.8	0.8															▲	●			
	K3084508H-AK	9.5	7.7	4.45	0.9	0.8															▲	●			
	K3115008H-AK	11.5	10.7	4.95	1.3	0.8															▲	●			
	K3145008H-AK	11.5	13.7	4.95	1.1	0.8															▲	●			
	K3043505H-PL	9.5	4.6	3.5	0.4	0.5						●			▲	●									
	K3054508H-PL	9.5	5.7	4.45	1.2	0.8						●			▲	●									
	K3084508H-PL	9.5	7.7	4.45	1.2	0.8						●			▲	●									
	K3084520H-PL	9.5	6.5	4.5	1.2	2.0						●			▲	●									
	K3115008H-PL	11.5	10.7	4.95	1.2	0.8						●			▲	●									
	K3115020H-PL	11.5	9.5	5	1.2	2.0						●			▲	●									
	K3145008H-PL	11.5	13.7	4.95	1.2	0.8						●			▲	●									
▲ 为主推荐牌号 Recommended grade (Always stock available) ● 按订单生产可选牌号 Make-to-order																									

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

切屑参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	/	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions							
	工件材料 Workpiece Material	P 钢	○	×		√	×	√	○		○	√	○								
		M 不锈钢						○	○	○	○	○	√	○		○					
		K 铸铁			○					○		○	√								
		N 有色金属														○	○				
		S 耐热合金、钛合金							○						√	○					
		H 淬硬钢																			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层							硬质合金				
		W1	L	S	BS	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120
	K3043505M-PM	9.5	4.6	3.5	0.4	0.5					●			▲	●						
	K3054508H-PM	9.5	5.7	4.45	1.2	0.8					●				▲	●					
	K3054508M-PM	9.5	5.7	4.45	1.2	0.8					●				▲	●					
	K3084508H-PM	9.5	7.7	4.45	1.2	0.8					●				▲	●					
	K3084508M-PM	9.5	7.7	4.45	1.2	0.8					●				▲	●					
	K3084520H-PM	9.5	6.5	4.45	1.2	2.0					●				▲	●					
	K3115008H-PM	11.5	10.7	4.95	1.2	0.8					●				▲	●					
	K3115008M-PM	11.5	10.7	4.95	1.2	0.8					●				▲	●					
	K3115020H-PM	11.5	9.5	4.95	1.2	2.0					●				▲	●					
	K3145008H-PM	11.5	13.7	4.95	1.2	0.8					●				▲	●					
	K3145008M-PM	11.5	13.7	4.95	1.2	0.8					●				▲	●					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

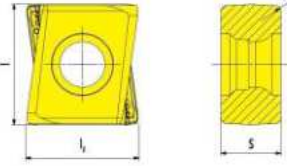
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

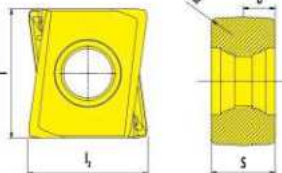
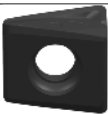
√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions										
		工件材料 Workpiece Material	P	钢			○	×		√	×	√	○		○	√	○					
			M	不锈钢							○	○	○	○	○	√	○			○		
			K	铸铁					○					○		○	√					
			N	有色金属																	○	○
			S	耐热合金、钛合金									○						√	○		
			H	淬硬钢																		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层								硬质合金					
		s	l	l ₂	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120		
	LNGX090304-GH	3.5	8	9	0.4			▲			▲		●	▲	●							
	LNGX090404-GH	4.5	8	9.4	0.4			▲			▲		●	▲	●							
	LNGX110508-GH	5.5	10	12.3	0.8			▲			▲		●	▲	●							
	LNGX130608-GH	6.5	12	13.9	0.8			▲			▲		●	▲	●							
	LNGX170812-GH	8	16	16.9	1.2			▲			▲		●	▲	●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions										
		工件材料 Workpiece Material	P	钢				○	×		√	×	√	○		○	√	○						
			M	不锈钢								○	○	○	○	○	√	○		○				
			K	铸铁						○				○		○	√							
			N	有色金属																	○	○		
			S	耐热合金、钛合金									○					√	○					
			H	淬硬钢																				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层								硬质合金						
		S	l	l ₂	Re	b	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120			
	LNGX100404R-GM	4.5	9	8.5	0.4	1.5			▲			▲		●	▲	●								
	LNGX100408R-GM	4.5	9	8.5	0.8	1.1			▲			▲		●	▲	●								
	LNGX100412R-GM	4.5	9	8.5	1.2	0.8			▲			▲		●	▲	●								
	LNGX100416R-GM	4.5	9	8.5	1.6	-			▲			▲		●	▲	●								
	LNGX100420R-GM	4.5	9	8.5	2	-			▲			▲		●	▲	●								
	LNGX140608R-GM	6.8	13	12	0.8	2.2			▲			▲		●	▲	●								
	LNGX140612R-GM	6.8	13	12	1.2	1.9			▲			▲		●	▲	●								
	LNGX140616R-GM	6.8	13	12	1.6	1.5			▲			▲		●	▲	●								
	LNGX140620R-GM	6.8	13	12	2	1.2			▲			▲		●	▲	●								
	LNGX140625R-GM	6.8	13	12	2.5	0.7			▲			▲		●	▲	●								
	LNGX140630R-GM	6.8	13	12	3	2.3			▲			▲		●	▲	●								
	LNGX140632R-GM	6.8	13	12	3.2	-			▲			▲		●	▲	●								
	LNGX170708R-GM	7.2	16	15.5	0.8	2.3			▲			▲		●	▲	●								
	LNGX170712R-GM	7.2	16	15.5	1.2	1.9			▲			▲		●	▲	●								
	LNGX170716R-GM	7.2	16	15.5	1.6	1.6			▲			▲		●	▲	●								
	LNGX100404R-GL	4.5	9	8.5	0.4	1.5						▲		●	▲	●								
	LNGX140608R-GL	6.8	13	12	0.8	2.2						▲		●	▲	●								

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮削刀片

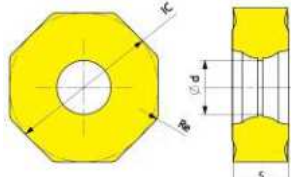
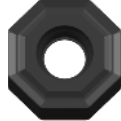
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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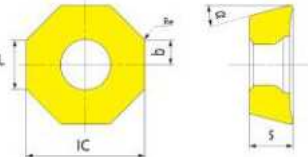
√ 良好工况 Good working conditions		○ 一般工况 General working conditions				× 不稳定工况 Unstable working conditions														
	工件材料 Workpiece Material	P	钢		○	×		√	×	√	○		○	√	○					
		M	不锈钢						○	○	○	○	○	√	○		○			
		K	铸铁				○				○		○	√						
		N	有色金属																○	○
		S	耐热合金、钛合金							○							√	○		
		H	淬硬钢																	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层										硬质合金	
		I.C	S	Φd	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120
	ONMU050408-GM	12.7	4.76	4.4	0.8						▲		●	▲	●					
	ONMU060408-GM	15.88	4.76	4.4	0.8						▲		●	▲	●					
	ONMU08T508-GM	20.2	5.95	5.4	0.8						▲		●	▲	●					
	ONMU050408-GH	12.7	4.76	4.4	0.8						▲		●	▲	●					
	ONMU060408-GH	15.88	4.76	4.4	0.8						▲		●	▲	●					
	ONMU08T508-GH	20.2	5.95	5.4	0.8						▲		●	▲	●					
	ONMU050408-GL	12.7	4.76	4.4	0.8						▲		●	▲	●					
	ONMU060408-GL	15.88	4.76	4.4	0.8						▲		●	▲	●					
	ONMU08T508-GL	20.2	5.95	5.4	0.8						▲		●	▲	●					
	ONMU050408-SM	12.7	4.76	4.4	0.8												▲			
	ONMU060408-SM	15.88	4.76	4.4	0.8												▲			
	ONMU08T508-SM	20.2	5.95	5.4	0.8												▲			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	/	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

√ 良好工况 Good working conditions								○ 一般工况 General working conditions								× 不稳定工况 Unstable working conditions								
		工件材料 Workpiece Material	P	钢		○	×		√	×	√	○		○	√	○								
			M	不锈钢							○	○	○	○	○	√	○			○				
			K	铸铁					○					○		○	√							
			N	有色金属																		○	○	
			S	耐热合金、钛合金									○						√	○				
			H	淬硬钢																				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)						CVD涂层			PVD涂层										硬质合金			
		S	I.C	L	Re	α	b	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120		
	ODMT0504ZZN-GH	4.76	12.7	5.26	0.8	15°	1.2							▲		●	▲	●						
	ODMT0605ZZN-GH	5.56	15.88	6.58	0.8	15°	1.6							▲		●	▲	●						
	ODMT0504ZZN-GM	4.76	12.7	5.26	0.8	15°	1.2							▲		●	▲	●						
	ODMT0605ZZN-GM	5.56	15.88	6.58	0.8	15°	1.6							▲		●	▲	●						
	ODMT0504ZZN-GL	4.76	12.7	5.26	0.8	15°	1.2							▲		●	▲	●						
	ODMT0605ZZN-GL	5.56	15.88	6.58	0.8	15°	1.6							▲		●	▲	●						
	ODHT0504ZZN-AK	4.76	12.7	5.26	0.8	15°	1.2															●	▲	
	ODHT0605ZZN-AK	5.56	15.88	6.58	0.8	15°	1.6															●	▲	
	ODMT0504ZZN-SM	4.76	12.7	5.26	0.8	15°	1.2													▲				
	ODMT0605ZZN-SM	5.56	15.88	6.58	0.8	15°	1.6													▲				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

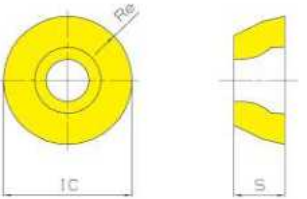
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

√ 良好工况 Good working conditions					○ 一般工况 General working conditions					× 不稳定工况 Unstable working conditions											
		工件材料 Workpiece Material	P	钢	○	×		√	×	√	○		○	√	○						
			M	不锈钢						○	○	○	○	○	√	○			○		
			K	铸铁			○					○		○	√						
			N	有色金属																○	○
			S	耐热合金、钛合金							○							√	○		
			H	淬硬钢																	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)			CVD涂层			PVD涂层										硬质合金			
		I.C	S	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120		
	RCKT10T3M0-KM	10.00	3.97	5			▲						▲	●							
	RCKT1204M0-KM	12.00	4.76	6			▲						▲	●							
	RCKT1606M0-KM	16.60	6.35	8			▲						▲	●							
	RCKT2006M0-KM	20.60	6.35	10			▲						▲	●							
	RCKT10T3M0-MM	10.00	3.97	5						▲		●	▲	●							
	RCKT1204M0-MM	12.00	4.76	6						▲		●	▲	●							
	RCKT1606M0-MM	16.60	6.35	8						▲		●	▲	●							
	RCKT2006M0-MM	20.60	6.35	10						▲		●	▲	●							
	RCKT10T3M0-PM	10.00	3.97	5						●		●	▲	●							
	RCKT1204M0-PM	12.00	4.76	6						●		●	▲	●							
	RCKT1606M0-PM	16.60	6.35	8						●		●	▲	●							
	RCKT2006M0-PM	20.60	6.35	10						●		●	▲	●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

▲ 为主推荐牌号 Recommended grade (Always stock available) ● 按订单生产可选牌号 Make-to-order

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
				GL	GM	GH	HM	SM	AK		
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

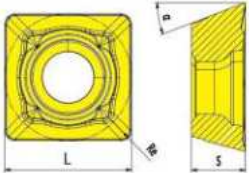
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

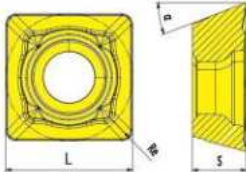
√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions										
		工件材料 Workpiece Material	P	钢			○	×		√	×	√	○		○	√	○					
			M	不锈钢							○	○	○	○	○	○	√	○		○		
			K	铸铁					○					○		○	√					
			N	有色金属																	○	○
			S	耐热合金、钛合金								○						√	○			
			H	淬硬钢																		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层								硬质合金					
		S	L	Re	α	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120		
	SOMT09T304-GH	3.97	9.52	0.4	15°			▲			▲		●	▲	●							
	SOMT09T308-GH	3.97	9.52	0.8	15°			▲			▲		●	▲	●							
	SOMT09T312-GH	3.97	9.52	1.2	15°			▲			▲		●	▲	●							
	SOMT09T316-GH	3.97	9.52	1.6	15°			▲			▲		●	▲	●							
	SOMT09T320-GH	3.97	9.52	2	15°			▲			▲		●	▲	●							
	SOMT120408-GH	4.76	12.7	0.8	15°			▲			▲		●	▲	●							
	SOMT120412-GH	4.76	12.7	1.2	15°			▲			▲		●	▲	●							
	SOMT120416-GH	4.76	12.7	1.6	15°			▲			▲		●	▲	●							
	SOMT120420-GH	4.76	12.7	2	15°			▲			▲		●	▲	●							
	SOMT120425-GH	4.76	12.7	2.5	15°			▲			▲		●	▲	●							

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions											
		工件材料 Workpiece Material	P	钢			○	×		√	×	√	○		○	√	○						
			M	不锈钢							○	○	○	○	○	√	○			○			
			K	铸铁					○				○		○	√							
			N	有色金属																	○	○	
			S	耐热合金、钛合金								○						√	○				
			H	淬硬钢																			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层								硬质合金						
		S	L	Re	α	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120			
	SOMT09T308-GM	3.97	9.52	0.8	15°			▲			▲		●	▲	●								
	SOMT120408-GM	4.76	12.7	0.8	15°			▲			▲		●	▲	●								
	SOMT09T308-GL	3.97	9.52	0.8	15°						▲		●	▲	●								
	SOMT120408-GL	4.76	12.7	0.8	15°						▲		●	▲	●								
	SDHT09T304-AK	3.97	9.52	0.4	15°														▲	●			
	SDHT09T308-AK	3.97	9.52	0.8	15°														▲	●			
	SDHT120408-AK	4.76	12.7	0.8	15°														▲	●			

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

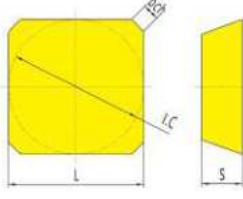
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

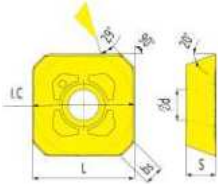
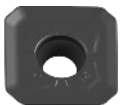
√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions											
		工件材料 Workpiece Material	P	钢			○	×		√	×	√	○		○	√	○						
			M	不锈钢							○	○	○	○	○	○	√	○		○			
			K	铸铁					○					○		○	√						
			N	有色金属																	○	○	
			S	耐热合金、钛合金								○							√	○			
			H	淬硬钢																			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层										硬质合金				
		L	I.C	S	bch	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120			
	SEEN1203AFTN	12.7	12.7	3.18	1.8						●		●	▲	●								
	SEKN1203AFFN	12.7	12.7	3.18	1.8						●		●	▲	●								
	SEKN1203AFN	12.7	12.7	3.18	1.8						●		●	▲	●								
	SEKN1203AFTN	12.7	12.7	3.18	1.8						●		●	▲	●								
	SEKN1504AFN	15.875	15.875	4.76	1.6						●		●	▲	●								
	SEKN1504AFTN	15.875	15.875	4.76	1.6						●		●	▲	●								
	SEMR1203AN-GM	12.7	12.7	3.3	-						●		●	▲	●								
	SEMR1504AN-GM	12.7	12.7	3.3	-						●		●	▲	●								
	SEKR1203AN-GM	15.875	15.875	4.9	-						●		●	▲	●								
	SEKR1504AN-GM	15.875	15.875	4.9	-						●		●	▲	●								

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	/	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

√ 良好工况 Good working conditions			○ 一般工况 General working conditions					× 不稳定工况 Unstable working conditions														
	工件材料 Workpiece Material	P 钢	○	×		√	×	√	○		○	√	○									
		M 不锈钢					○	○	○	○	○	√	○		○							
		K 铸铁			○				○		○	√										
		N 有色金属																○	○			
		S 耐热合金、钛合金						○							√	○						
		H 淬硬钢																				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层										硬质合金		
		L	I.C	S	Ød	bs	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120	
	SEET12T3-GH	13.4	13.4	3.97	4.1	2.55			▲	▲		▲		●	▲	●		▲				
	SEET12T3-GM	13.4	13.4	3.97	4.1	2.55			▲	▲		▲		●	▲	●		▲				
	SEET12T3-GL	13.4	13.4	3.97	4.1	2.55						▲		●	▲	●		▲				
	SEET12T3-SM	13.4	13.4	3.97	4.1	2.55												▲				
	SEET12T3-AK	13.4	13.4	3.97	4.1	2.55														●	▲	

▲ 为主推荐牌号 Recommended grade (Always stock available)

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► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

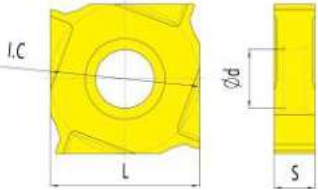
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

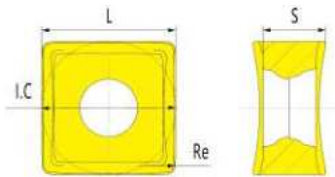
√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions												
		工件材料 Workpiece Material	P	钢			○	×		√	×	√	○		○	√	○							
			M	不锈钢								○	○	○	○	○	√	○			○			
			K	铸铁					○					○		○	√							
			N	有色金属																		○		○
			S	耐热合金、钛合金									○							√	○			
			H	淬硬钢																				
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层										硬质合金					
		I.C	L	S	Ød	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120				
	SNEQ1202	12.7	12.7	2.3	5			▲	▲		▲		●	▲	●									
	SENQ1203	12.7	12.7	3	5			▲	▲		▲		●	▲	●									
	SNEQ12T3	12.7	12.7	3.5	5			▲	▲		▲		●	▲	●									
	SNEQ1204	12.7	12.7	4	5			▲	▲		▲		●	▲	●									
	SNEQ12T4	12.7	12.7	4.5	5			▲	▲		▲		●	▲	●									

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions								
		工件材料 Workpiece Material	P	钢		○	×		√	×	√	○		○	√	○				
			M	不锈钢						○	○	○	○	○	√	○		○		
			K	铸铁				○				○		○	√					
			N	有色金属															○	○
			S	耐热合金、钛合金							○						√	○		
			H	淬硬钢																
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层								硬质合金			
		L	S	I.C	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120
	SNMX12T512-GH	12.7	5.65	12.7	1.2			▲			▲		●	▲	●					
	SNMX090408-GH	9.52	4.87	9.52	0.8			▲			▲		●	▲	●					
	SNMX0904ANN-GH	9.52	4.72	9.52	1.2			▲			▲		●	▲	●					
	SNMX0904ZNN-GH	9.52	4.93	9.52	1			▲			▲		●	▲	●					
	SNMX12T5ANN-GH	12.7	5.59	12.7	1.5			▲			▲		●	▲	●					
	SNMX160620-GH	16	6.38	16	2			▲			▲		●	▲	●					
	SNMX12T512-GM	12.7	5.5	12.7	1.2			▲			▲		●	▲	●					
	SNMX090408-GM	9.52	4.87	9.52	0.8			▲			▲		●	▲	●					
	SNMX0904ANN-GM	9.52	4.69	9.52	1.2			▲			▲		●	▲	●					
	SNMX0904ZNN-GM	9.52	4.91	9.52	1			▲			▲		●	▲	●					
	SNMX12T520-GM	12.7	5.5	12.7	2			▲			▲		●	▲	●					
	SNMX12T5ANN-GM	12.7	5.54	12.7	1.5			▲			▲		●	▲	●					
	SNMX12T5ENN-GM	12.7	5.61	12.7	1.2			▲			▲		●	▲	●					
	SNMX12T5ZNN-GM	12.7	5.77	12.7	1.2			▲			▲		●	▲	●					
	SNMX160620-GM	16	6.38	16	2			▲			▲		●	▲	●					
	SNMX160640-GM	16	6.38	16	4			▲			▲		●	▲	●					

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
KT8296			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

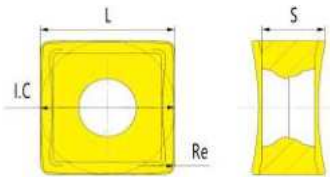
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

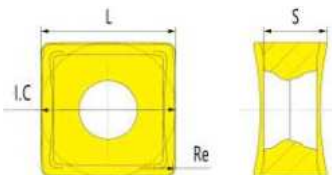
√ 良好工况 Good working conditions				○ 一般工况 General working conditions				× 不稳定工况 Unstable working conditions													
		工件材料 Workpiece Material	P	钢		○	×		√	×	√	○		○	√	○					
			M	不锈钢						○	○	○	○	○	√	○			○		
			K	铸铁				○				○		○	√						
			N	有色金属																○	○
			S	耐热合金、钛合金							○							√	○		
			H	淬硬钢																	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层								硬质合金				
		L	S	I.C	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120	
	SNMX12T512-GL	12.7	5.63	12.7	1.2						▲		●	▲	●						
	SNMX090408-GL	9.52	4.87	9.52	0.8						▲		●	▲	●						
	SNMX0904ANN-GL	9.52	4.72	9.52	1.2						▲		●	▲	●						
	SNMX0904ZNN-GL	9.52	4.93	9.52	1						▲		●	▲	●						
	SNMX12T5ANN-GL	12.7	5.54	12.7	1.5						▲		●	▲	●						

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions									
		工件材料 Workpiece Material	P 钢	○	×		√	×	√	○		○	√	○							
			M 不锈钢						○	○	○	○	○	√	○			○			
			K 铸铁			○					○		○	√							
			N 有色金属																○	○	
			S 耐热合金、钛合金							○							√	○			
			H 淬硬钢																		
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层								硬质合金				
		L	S	ΦI.C	be	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120	
	SNGX12T5ANN-GH	12.7	5.59	12.7	1.5			▲			▲		●	▲	●						
	SNGX12T5ENN-GH	12.7	5.65	12.7	1.2			▲			▲		●	▲	●						
	SNGX12T5ZNN-GH	12.7	5.77	12.7	1.2			▲			▲		●	▲	●						
	SNGX0904ANN-GM	9.52	4.69	9.52	1.2			▲			▲		●	▲	●						
	SNGX0904ZNN-GM	9.52	4.9	9.52	1			▲			▲		●	▲	●						
	SNGX12T512-GM	12.7	5.6	12.7	1.2			▲			▲		●	▲	●						
	SNGX12T5ANN-GM	12.7	5.54	12.7	1.5			▲			▲		●	▲	●						
	SNGX12T5ENN-GM	12.7	5.61	12.7	1.2			▲			▲		●	▲	●						
	SNGX12T5ZNN-GM	12.7	5.77	12.7	1.2			▲			▲		●	▲	●						
	SNGX1606ANN-GM	16	6.3	16	1.8			▲			▲		●	▲	●						
	SNGX0904ANN-GL	9.52	4.72	9.52	1.2						▲		●	▲	●						
	SNGX0904ZNN-GL	9.52	4.93	9.52	1						▲		●	▲	●						
	SNGX12T5ANN-GL	12.7	5.54	12.7	1.5						▲		●	▲	●						
	SNGX12T5ENN-GL	12.7	5.64	12.7	1.2						▲		●	▲	●						
	SNGX12T5ZNN-GL	12.7	5.8	12.7	1.2						▲		●	▲	●						

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

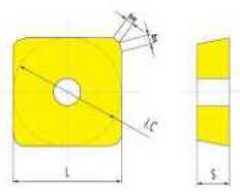
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

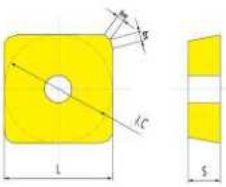
√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions								
	工件材料 Workpiece Material	P	钢					○	×		√	×	√	○		○	√	○				
		M	不锈钢									○	○	○	○	○	√	○		○		
		K	铸铁							○					○		○	√				
		N	有色金属																		○	○
		S	耐热合金、钛合金										○						√	○		
		H	淬硬钢																			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层										硬质合金		
		L	S	I.C	be	bs	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120	
	SPKN1203EDER	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDEL	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDFR	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDFL	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDSKR	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDSKL	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDTKR	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDTKL	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDS31R	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDS31L	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDT31R	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1203EDT31L	12.7	12.7	3.18	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDER	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDEL	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDFR	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDFL	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDSKR	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDSKL	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDTKR	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDTKL	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDS32R	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDS32L	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDT32R	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						
	SPKN1504EDT32L	15.875	15.875	4.76	1	1.4			▲	●		▲		●	▲	●						

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	/	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

√ 良好工况 Good working conditions				○ 一般工况 General working conditions				× 不稳定工况 Unstable working conditions														
		工件材料 Workpiece Material	P 钢	○	×		√	×	√	○		○	√	○								
			M 不锈钢					○	○	○	○	○	√	○			○					
			K 铸铁			○				○		○	√									
			N 有色金属															○	○			
			S 耐热合金、钛合金						○						√	○						
			H 淬硬钢																			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层										硬质合金		
		L	S	I.C	be	bs	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120	
	SPKR1504EDR-GM	15.875	15.875	4.76	1	1.4			▲	●	▲		●	▲	●							
	SPKR1504EDL-GM	15.875	15.875	4.76	1	1.4			▲	●	▲		●	▲	●							
	SPKR1203EDR-GM	12.7	12.7	3.18	1	1.4			▲	●	▲		●	▲	●							
	SPKR1203EDL-GM	12.7	12.7	3.18	1	1.4			▲	●	▲		●	▲	●							
	SPKR1504EDR-GM	15.875	15.875	4.76	1	1.4			▲	●	▲		●	▲	●							
	SPKR1504EDL-GM	15.875	15.875	4.76	1	1.4			▲	●	▲		●	▲	●							

▲ 为主推荐牌号 Recommended grade (Always stock available) ● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

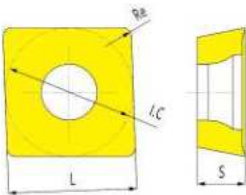
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions											
		工件材料 Workpiece Material	P	钢			○	×		√	×	√	○		○	√	○						
			M	不锈钢							○	○	○	○	○	√	○		○				
			K	铸铁					○					○		○	√						
			N	有色金属																	○	○	
			S	耐热合金、钛合金									○						√	○			
			H	淬硬钢																			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层								硬质合金						
		L	S	ΦI.C	Re	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120			
	MPKT120408-GH	12.7	4.76	12.7	0.8			▲			▲		●	▲	●								
	MPKT120408-GM	12.7	4.76	12.7	0.8			▲			▲		●	▲	●								
	MPKT120408-GL	12.7	4.76	12.7	0.8						▲		●	▲	●								

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	/	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08 (0.02-0.15)	/	

▲ 为主推荐牌号 Recommended grade (Always stock available)

- 按订单生产可洗牌号 Make-to-order

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
				GL	GM	GH	HM	SM	AK		
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
KT8296			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

B 铣削刀片

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

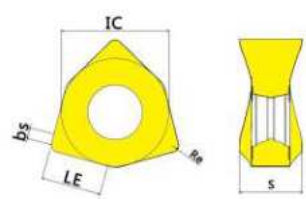
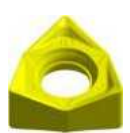
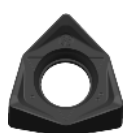
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions											
	工件材料 Workpiece Material	P	钢					○	×			√	×	√	○		○	√	○						
		M	不锈钢										○	○	○	○	○	√	○			○			
		K	铸铁								○					○		○	√						
		N	有色金属																				○	○	
		S	耐热合金、钛合金											○							√	○			
		H	淬硬钢																						
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层										硬质合金					
		Re	bs	LE	I.C	S	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120				
	WNMU040304EN-GH	0.4	0.8	4	6.7	3.29			▲			▲		●	▲	●									
	WNMU040308EN-GH	0.8	0.4	4	6.7	3.29			▲			▲		●	▲	●									
	WNMU080608EN-GH	0.8	1.3	7.5	12.48	6.45			▲			▲		●	▲	●									
	WNMU080612EN-GH	1.2	0.9	7.5	12.48	6.45			▲			▲		●	▲	●									
	WNMU080616EN-GH	1.6	0.5	7.5	12.48	6.45			▲			▲		●	▲	●									
	WNMU040304EN-GM	0.4	0.8	4	6.7	3.29			▲			▲		●	▲	●									
	WNMU040308EN-GM	0.8	0.4	4	6.7	3.29			▲			▲		●	▲	●									
	WNMU080608EN-GM	0.8	1.3	7.5	12.48	6.45			▲			▲		●	▲	●									
	WNMU080612EN-GM	1.2	0.9	7.5	12.48	6.45			▲			▲		●	▲	●									
	WNMU080616EN-GM	1.6	0.5	7.5	12.48	6.45			▲			▲		●	▲	●									
	WNMU040304EN-GL	0.4	0.8	4	6.7	3.29						▲		●	▲	●									
	WNMU040308EN-GL	0.8	0.4	4	6.7	3.29						▲		●	▲	●									
	WNMU080608EN-GL	0.8	1.3	7.5	12.48	6.45						▲		●	▲	●									
														●	▲	●									
														●	▲	●									
	WNMU040304EN-SM	0.4	0.8	4	6.7	3.29													▲						
	WNMU040308EN-SM	0.8	0.4	4	6.7	3.29													▲						
	WNMU080608EN-SM	0.8	1.3	7.5	12.48	6.45													▲						
	WNMU080612EN-SM	1.2	0.9	7.5	12.48	6.45													▲						
	WNMU080616EN-SM	1.6	0.5	7.5	12.48	6.45													▲						

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

√ 良好工况 Good working conditions							○ 一般工况 General working conditions							× 不稳定工况 Unstable working conditions							
		工件材料 Workpiece Material	P	钢		○	×		√	×	√	○		○	√	○					
			M	不锈钢						○	○	○	○	○	√	○		○			
			K	铸铁				○					○		○	√					
			N	有色金属															○	○	
			S	耐热合金、钛合金								○						√	○		
			H	淬硬钢																	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层			PVD涂层								硬质合金			
		s	I.C	L	Re	b	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120
	XNMU0705ANN-GH	5.88	14.5	6.98	0.8	1.1			●			●		●	▲	●					
	XNMU0906ANN-GH	5.00	19.05	9.18	0.8	1.4			●			●		●	▲	●					
	XNMU0705ANN-GM	5.88	14.5	6.98	0.8	1.1			●			●		●	▲	●					
	XNMU0906ANN-GM	5.00	19.05	9.18	0.8	1.4			●			●		●	▲	●					
	XNMU0705ANN-GL	5.88	14.5	6.98	0.8	1.1						●		●	▲	●					
	XNMU0906ANN-GL	5.00	19.05	9.18	0.8	1.4						●		●	▲	●					

▲ 为主推荐牌号 Recommended grade (Always stock available)

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► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

铣削 / 铣削刀片

Milling Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮削刀片

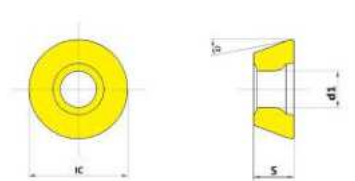
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

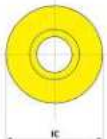
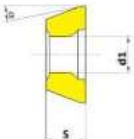
√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions									
	工件材料 Workpiece Material	P 钢	○	×		√	×	√	○		○	√	○								
		M 不锈钢					○	○	○	○	○	√	○			○					
		K 铸铁			○					○		○	√								
		N 有色金属																○	○		
		S 耐热合金、钛合金						○							√	○					
		H 淬硬钢																			
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层										硬质合金		
		s	I.C	α	d ₁	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120	
	ROHX1003MOT-GH	3.18	10	3.18	4.4			▲			●		●	▲	●						
	ROHX12T3M0T-GH	3.18	10	3.18	4.4			▲			●		●	▲	●						
	ROHX1604M0T-GH	3.97	10	15°	4.4			▲			●		●	▲	●						
	ROHX2006M0T-GH	3.97	12	15°	4.4			▲			●		●	▲	●						
	ROMX1003M0T-GH	3.97	12	15°	4.4			▲			●		●	▲	●						
	ROMX12T3M0T-GH	4.76	12	15°	4.4			▲			●		●	▲	●						
	ROMX1604M0T-GH	4.76	16	15°	5.5			▲			●		●	▲	●						
	ROMW10T3M0T-GH	4.76	16	15°	5.5			▲			●		●	▲	●						
	ROMW1204M0T-GH	5.56	16	15°	5.5			▲			●		●	▲	●						
	ROMW1605M0T-GH	6.35	20	15°	6.5			▲			●		●	▲	●						
	ROMW2006M0T-GH	6.35	20	15°	6.5			▲			●		●	▲	●						

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

√ 良好工况 Good working conditions						○ 一般工况 General working conditions						× 不稳定工况 Unstable working conditions								
		工件材料 Workpiece Material	P 钢	○	×		√	×	√	○		○	√	○						
			M 不锈钢					○	○	○	○	○	√	○			○			
			K 铸铁			○				○		○	√							
			N 有色金属															○	○	
			S 耐热合金、钛合金						○						√	○				
			H 淬硬钢																	
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层			PVD涂层								硬质合金			
		s	d	α	d ₁	KT1312	KT2252	KT3262	KT1236	KT1405	KT1455	KT8295	KT8287N	KT8296	KT8326	KC5280	KS20	KW40	KT3100	KT3120
	ROMT10T3MO-GM	3.97	12	15°	4.4			▲			●		●	▲	●					
	ROMT1204MO-GM	4.76	12	15°	4.4			▲			●		●	▲	●					
	ROMT1605MO-GM	5.56	16	15°	5.5			▲			●		●	▲	●					
	ROMT2006MO-GM	6.35	20	15°	6.5			▲			●		●	▲	●					
	ROMX0501M0-GM	1.47	5	15°	2.2			▲			●		●	▲	●					
	ROMX07T1M0-GM	2.35	7	15°	2.8			▲			●		●	▲	●					
	ROMX1003M0-GM	3.18	10	3.18	4.4			▲			●		●	▲	●					
	ROMX12T3M0-GM	3.97	12	15°	4.4			▲			●		●	▲	●					
	ROMX1604M0-GM	4.76	16	15°	5.5			▲			●		●	▲	●					
	ROMX2006M0-GM	6.35	20	15°	6.5			▲			●		●	▲	●					

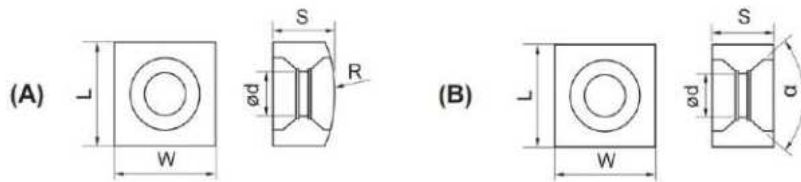
▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

► 切削参数推荐表 Recommended cutting parameters

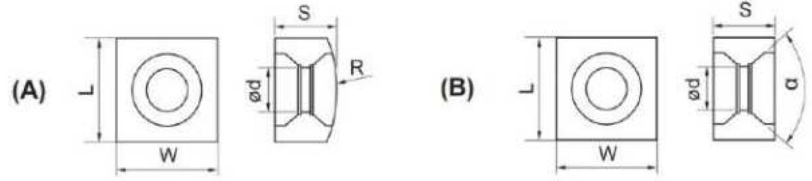
被加工材料		硬度HB	刀片牌号	切削用量							ae
				V(m/min)	f(mm/z)						
					GL	GM	GH	HM	SM	AK	
P	低碳钢、软钢	≤180	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	高碳钢、合金钢	180-280	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
	合金工具钢	280-350	KT1455	320(200-400)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
KT8296			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
KT8326			300(320-350)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/		
M	不锈钢	270	KT1455	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8287N	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8296	200(110-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	180(150-300)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
K	铸铁	180-250	KT3262	180(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	≤0.5D
			KT8296	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
			KT8326	200(150-250)	0.1(0.08-0.15)	0.2(0.1-0.25)	0.25(0.12-0.3)	0.2(0.1-0.25)	/	/	
N	有色金属	60-100	KT3100	250-500	/	/	/	/	/	0.2(0.05-0.35)	≤0.5D
			KT3120	250-500	/	/	/	/	/	0.2(0.05-0.35)	
S	高温合金	≤400	KT1455	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	≤0.5D
			KS20	100(60-120)	/	/	/	/	0.08(0.02-0.15)	/	

常规铣削刀片 Milling inserts



型号 Type	尺寸 Dimensions (mm)						可选牌号 Grade for Choice		
	W	Φd	R	S	L	a	KT8208	KT1378G	KT6259
(B)SNC 33-DR0	9.525	9.53	4.76	4.4	90	0	▲	●	
(A)SNC 33-DR10	9.525	9.53	4.76	4.4	90	10	▲	●	
(A)SNC 33-DR11	9.525	9.53	4.76	4.4	90	11	▲	●	
(A)SNC 33-DR15	9.525	9.53	4.76	4.4	90	15	▲	●	
(A)SNC 33-DR20	9.525	9.53	4.76	4.4	90	20	▲	●	
(B)SNC 44-DRO	12.70	12.70	7.94	5.4	90	0	▲	●	
(A)SNC 44-DR15	12.70	12.70	7.94	5.4	90	15	▲	●	
(A)SNC 44-DR20	12.70	12.70	7.94	5.4	90	20	▲	●	
(A)SNC 44-DR40	12.70	12.70	7.94	5.4	90	40	▲	●	
(B)SNC 55-DRO	15.90	15.90	7.94	5.4	90	0	▲	●	
(A)SNC 55-DR13	15.90	15.90	7.94	5.4	90	13	▲	●	
(A)SNC 55-DR14	15.90	15.90	7.94	5.4	90	14	▲	●	
(A)SNC 55-DR23.5	15.90	15.90	7.94	5.4	90	23.5	▲	●	
(B)LNE 313-DR0-6.35	12.70	9.53	6.35	4.5	90	0	▲	●	
(A)LNE 313-DR10-6.35	12.70	9.53	6.35	4.5	90	10	▲	●	
(A)LNE 313-DR11-6.35	12.70	9.53	6.35	4.5	90	11	▲	●	
(A)LNE 313-DR15-6.35	12.70	9.53	6.35	4.5	90	15	▲	●	
(A)LNE 313-DR20-6.35	12.70	9.53	6.35	4.5	90	20	▲	●	
(B)LNE 313-DR0-5.56	12.70	9.53	5.56	4.5	90	0	▲	●	
(A)LNE 313-DR10-5.56	12.70	9.53	5.56	4.5	90	10	▲	●	
(A)LNE 313-DR11-5.56	12.70	9.53	5.56	4.5	90	11	▲	●	
(A)LNE 313-DR15-5.56	12.70	9.53	5.56	4.5	90	15	▲	●	
(A)LNE 313-DR20-5.56	12.70	9.53	5.56	4.5	90	20	▲	●	
(B)LNE 323-DR0	15.88	9.53	5.56	4.5	90	0	▲	●	
(A)LNE 323-DR10	15.88	9.53	5.56	4.5	90	10	▲	●	
(A)LNE 323-DR11	15.88	9.53	5.56	4.5	90	11	▲	●	
(A)LNE 323-DR15	15.88	9.53	5.56	4.5	90	15	▲	●	

常规铣削刀片 Milling inserts



型号 Type	尺寸 Dimensions (mm)						可选牌号 Grade for Choice		
	W	Φd	R	S	L	a	KT8208	KT1378G	KT6259
(A)LNE 323-DR20	15.88	9.53	5.56	4.5	90	20	▲	●	
(B)LNE 424-DRO	15.88	12.70	7.94	5.6	90	0	▲	●	
(A)LNE 424-DR10	15.88	12.70	7.94	5.6	90	10	▲	●	
(A)LNE 424-DR11.5	15.88	12.70	7.94	5.6	90	11.5	▲	●	
(A)LNE 424-DR13	15.88	12.70	7.94	5.6	90	13	▲	●	
(A)LNE 424-DR14.5	15.88	12.70	7.94	5.6	90	14.5	▲	●	
(A)LNE 424-DR15.2	15.88	12.70	7.94	5.6	90	15.2	▲	●	
(A)LNE 424-DR16	15.88	12.70	7.94	5.6	90	16	▲	●	
(A)LNE 424-DR19	15.88	12.70	7.94	5.6	90	19	▲	●	
(A)LNE 424-DR20	15.88	12.70	7.94	5.6	90	20	▲	●	
(A)LNE 424-DR25	15.88	12.70	7.94	5.6	90	25	▲	●	
(A)LNE 424-DR40	15.88	12.70	7.94	5.6	90	40	▲	●	
(A)LNE 424-DR80	15.88	12.70	7.94	5.6	90	80	▲	●	
(B)LNE 434-DR0-6.35	19.05	14.30	6.35	5.6	90	0	▲	●	
(A)LNE 434-DR10-6.35	19.05	14.30	6.35	5.6	90	10	▲	●	
(A)LNE 434-DR11-6.35	19.05	14.30	6.35	5.6	90	11	▲	●	
(A)LNE 434-DR15-6.35	19.05	14.30	6.35	5.6	90	15	▲	●	
(A)LNE 434-DR20-6.35	19.05	14.30	6.35	5.6	90	20	▲	●	
(A)LNE 434-DR25-6.35	19.05	14.30	6.35	5.6	90	25	▲	●	
(A)LNE 434-DR30-6.35	19.05	14.30	6.35	5.6	90	30	▲	●	
(B)LNE 434-DR0-7.94	19.05	14.30	7.94	5.6	90	0	▲	●	
(A)LNE 434-DR10-7.94	19.05	14.30	7.94	5.6	90	10	▲	●	
(A)LNE 434-DR10-7.94	19.05	14.30	7.94	5.6	90	11	▲	●	
(A)LNE 434-DR10-7.94	19.05	14.30	7.94	5.6	90	15	▲	●	
(A)LNE 434-DR10-7.94	19.05	14.30	7.94	5.6	90	20	▲	●	
(A)LNE 434-DR10-7.94	19.05	14.30	7.94	5.6	90	25	▲	●	
(A)LNE434-DR10-7.94	19.05	14.30	7.94	5.6	90	30	▲	●	

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

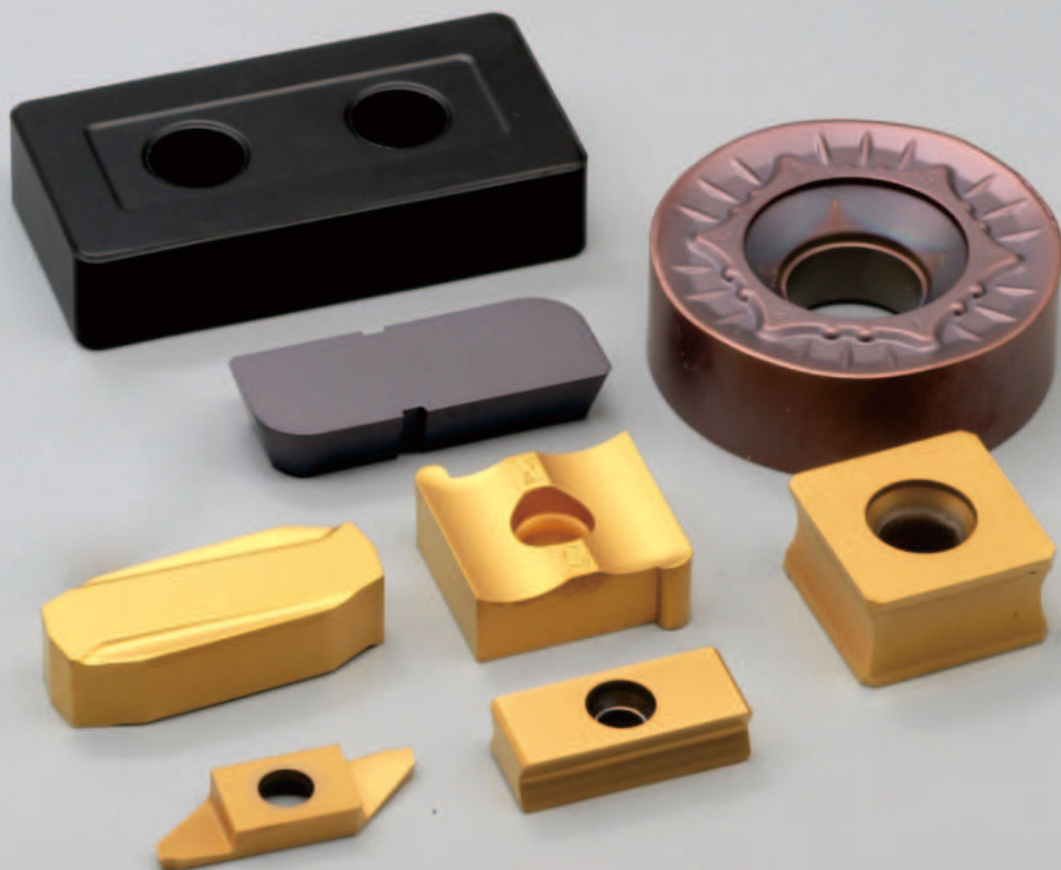
H 刀杆和刀盘

I 加工案例

J 通用技术信息

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SPECIAL DESIGN INSERTS

非标异形刀片



非标异形刀片 Special Design Inserts

非标异形刀片牌号介绍 Special Design Inserts Grade Information	001
非标异形刀片牌号一览表	
Recommended Grade Overview for Special Design Inserts	002
非标异形刀片 Special Design Inserts	003

非标刀片牌号

CVD涂层牌号

产品牌号	ISO	涂层类型	涂层组成	特点及应用
KT3221	P20~P35	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.采用中钴含量的韧性硬质合金基体, 结合中温TiCN和厚的Al ₂ O ₃ 涂层, 具有优良的耐磨性和抗崩缺性能。 2.适用于软钢、低碳钢、低碳合金钢的广泛车削加工。
KT3223	P20~P35	CVD 双色	MT-TiCN+Al ₂ O ₃ +TiN	1.采用固溶强化的中钴含量硬质合金基体, 搭配梯度复合涂层, 拥有优异的高温稳定性和高耐磨性。 2.适用于钢件的车削加工, 亦可用于断续加工。
KT1251	P15~P35	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.全新的纳米柱状结构MT-TiCN和厚Al ₂ O ₃ 涂层, 与韧性、强度兼备的中钴梯度硬质合金基体相结合。 2.适用于碳钢、合金钢等材料的半精加工到粗加工。
KT1371	P20~P40	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.高韧性基体搭配合适厚度的MT-TiCN和Al ₂ O ₃ 涂层, 使得材质在强冲击工况下仍能兼顾耐磨性和稳定性。 2.适用于碳钢、合金钢等材料的车削粗加工。
KT1331	P25~P45	CVD 黄色	MT-TiCN+Al ₂ O ₃ +TiN	1.添加提高红硬性的组元、高韧性的高钴硬质合金基体, 结合高耐磨性的CVD涂层, 在恶劣工况下仍保持优异的加工性能。 2.适用于钢件的车削粗加工。
KT8296	P10~P30 M10~M30	PVD 灰黑色	TiAlN	1. 较高耐磨性的细晶粒中钴基体, 搭配通用性好的TiAlN涂层, 具有良好的膜基结合力、耐磨性和抗氧化性能。 2. 适用于合金钢、不锈钢等材料的车削、铣削加工。

A

车削刀片

B

铣削刀片

C

铝合金刀片

D

孔加工刀片

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Grade Information

CVD Coated Grades

Grade	ISO	Types of Coating	Coating Composition	Features and Application
KT3221	P20~P35	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. It uses medium cobalt content tough cemented carbide substrate, combined with medium temperature TiCN and thick Al ₂ O ₃ coating, which has excellent performance of wear resistance and chipping resistance. 2. It is suitable for a wide range of turning of mild steel, low carbon steel and low carbon alloy steel.
KT3223	P20~P35	CVD Bicolor	MT-TiCN+Al ₂ O ₃ +TiN	1. Using a solid solution strengthened medium cobalt carbide substrate with gradient composite coating, which has excellent performance of high temperature stability and high wear resistance. 2. It is suitable for turning of steel, as well as for interrupted machining.
KT1251	P15~P35	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. Using new nano-columnar structure of MT-TiCN and thick Al ₂ O ₃ coating, combined with medium cobalt gradient cemented carbide substrate with both toughness and strength. 2. It is suitable for semi-finishing to roughing processing of carbon steel, alloy steel and other materials.
KT1371	P20~P40	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. High toughness substrate with suitable thickness of MT-TiCN and Al ₂ O ₃ coating, which makes the material keep the wear resistance and stability under strong impact conditions. 2. It is suitable for roughing processing of carbon steel, alloy steel and other materials turning.
KT1331	P25~P45	CVD Yellow	MT-TiCN+Al ₂ O ₃ +TiN	1. Using a high cobalt carbide substrate with enhanced hot hardness and toughness, combined with a highly wear resistant CVD coating, delivers exceptional machining performance even under severe conditions. 2. It is suitable for roughing processing of steel turning.
KT8296	P10~P30 M10~M30	PVD Grey-black	TiAlN	1. The fine-grain medium cobalt substrate with high wear resistance is matched with high universality of TiAlN coating. It has good film-based adhesion, wear resistance and oxidation resistance. 2. It is suitable for turning and milling of alloy steel, stainless steel etc.

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G 圆棒和立铣刀

H 刀杆和刀盘

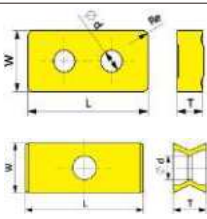
I 加工案例

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非标异形产品牌号一览表

Recommended Grade Table

工件材料 Workpiece materials	ISO代号 ISO Code	CVD	PVD	金属陶瓷 Cermet	硬质合金 Cemented carbide	超硬材料 Superhard materials
P	P01					
	P10	KT1251 KT3221	KT8296			
	P20					
	P30	KT1331				
	P40					
M	M01					
	M10		KT8296			
	M20					
	M30					
	M40					
K	K01					
	K10					
	K20					
	K30					
N	N01					
	N10					
	N20					
	N30					
S	S01					
	S10					
	S20					
	S30					
H	H01					
	H10					
	H20					
	H30					

√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions													
	工件材料 Workpiece Material	P	钢					√	○	○	○	×	○
		M	不锈钢										√
		K	铸铁										
		N	有色金属										
		S	耐热合金、钛合金										
		H	淬硬钢										
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)					CVD涂层					PVD涂层	
		L	W	Φd	T	r	KT1331	KT3221	KT3223	KT1251	KT1371	KT8296	
	LNMT402514K-SK	40	25.4	9.2	11.2	1.4	▲	●					
	LNMT502514K-SK	50	25.4	9.2	11.2	1.4	▲	●					
	LNKX 0912-V	12	9	4.4	6							▲	
	LNKX 0921-V	21	9	4.4	6							▲	

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

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J 通用技术信息

非标异形 / 非标异形刀片

Special Design Inserts

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

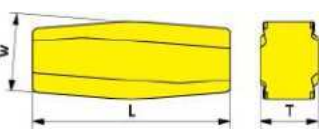
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

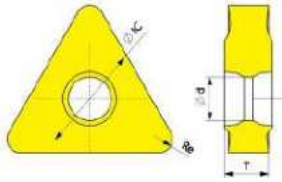
I 加工案例

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√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions										
	工件材料 Workpiece Material	P	钢			√	○	○	○	×
		M	不锈钢							√
		K	铸铁							
		N	有色金属							
		S	耐热合金、钛合金							
		H	淬硬钢							
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)			CVD涂层					PVD涂层
		L	W	T	KT1331	KT3221	KT3223	KT1251	KT1371	KT8296
	LNMG2006K-E	20.5	8	6	▲	●				
	TNMX1106K-Z	31	12	7.5	▲	▲				
	TNMX1509K-Z	37	17.8	12	▲	▲				
	TNMX1509K-C	37	17.8	12	▲	▲				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions											
	工件材料 Workpiece Material	P	钢			√	○	○	○	×	○
		M	不锈钢								√
		K	铸铁								
		N	有色金属								
		S	耐热合金、钛合金								
		H	淬硬钢								
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)				CVD涂层					PVD涂层
		ØI.C	Φd	T	r	KT1331	KT3221	KT3223	KT1251	KT1371	KT8296
	TNMX1106K-Z	15.875	6.35	6.35	1.6	▲	●				
	TNMX1509K-C	22.225	7.94	9.72	1.6	▲	●				
	TNMX1108-YP	22	7	8	1.6	▲	●				

▲ 为主推荐牌号 Recommended grade (Always stock available)

● 按订单生产可选牌号 Make-to-order

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非标异形 / 非标异形刀片

Special Design Inserts

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C 铝合金刀片

D 孔加工刀片

E 刮管刀片

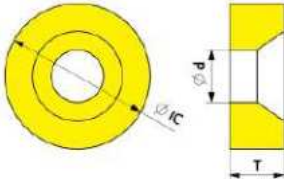
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

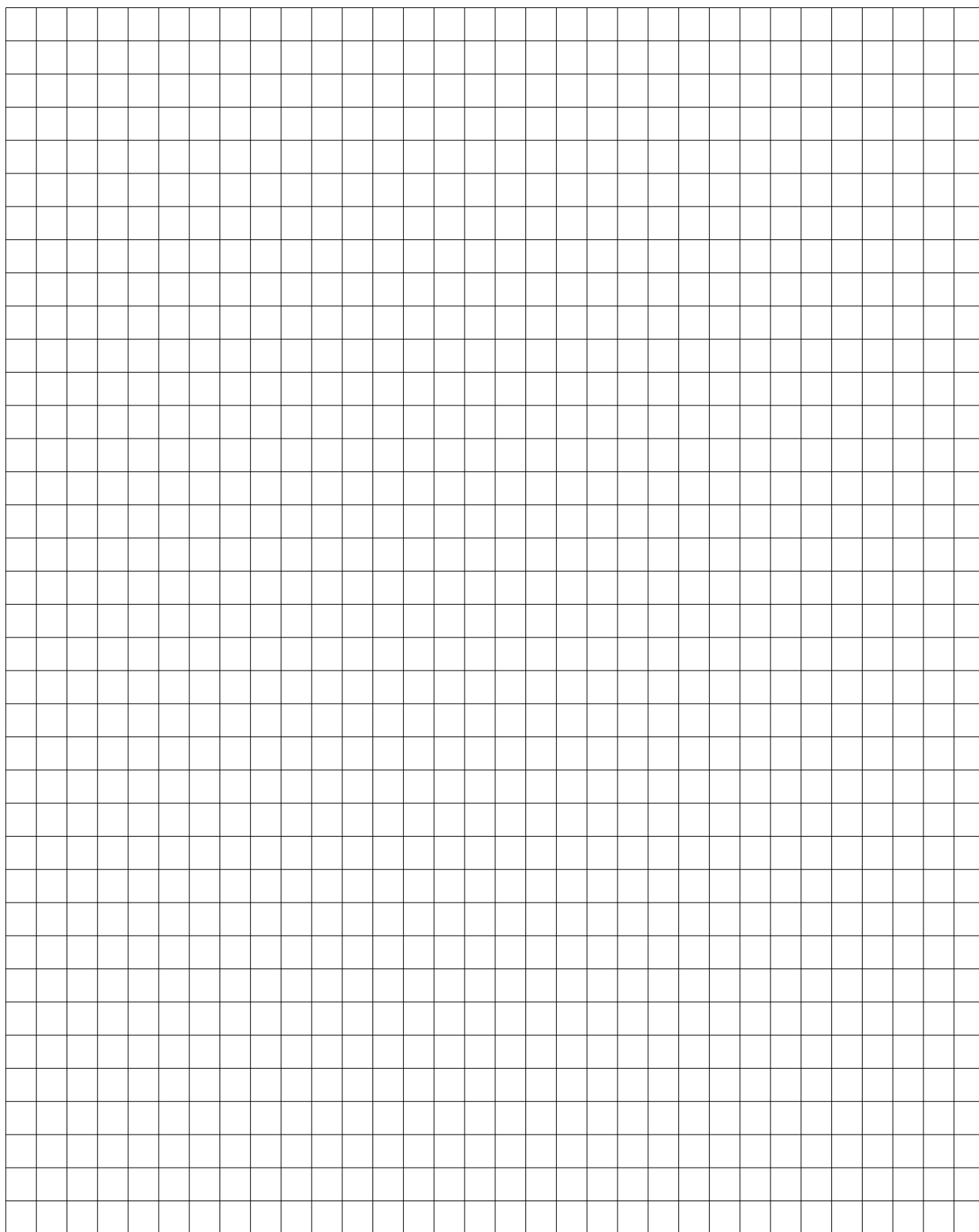
I 加工案例

J 通用技术信息

√ 良好工况 Good working conditions ○ 一般工况 General working conditions × 不稳定工况 Unstable working conditions										
	工件材料 Workpiece Material	P	钢	√	○	○	○	×	○	
		M	不锈钢						√	
		K	铸铁							
		N	有色金属							
		S	耐热合金、钛合金							
		H	淬硬钢							
产品 Inserts Shape	型号 Type	尺寸 Dimensions (mm)			CVD涂层					PVD涂层
		ØI.C	Φd	T	KT1331	KT3221	KT3223	KT1251	KT1371	KT8296
	RNMH 2509K-RR	25.4	9.12	9.5	▲	●				
	RNGH3812K-RR	38.1	12.8	12.7	▲	●				

▲ 为主推荐牌号 Recommended grade (Always stock available)

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CARBIDE RODS AND SOLID CARBIDE END MILL

圆棒和立铣刀



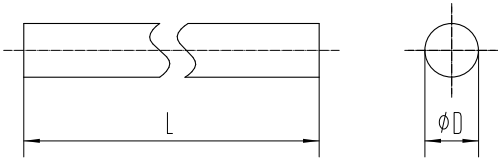
圆棒和立铣刀

Carbide Rods and Solid Carbide End Mill

硬质合金圆棒 Carbide Rods	001
硬质合金立铣刀 Solid Carbide End Mill	004

实心金属陶瓷圆棒毛坯

Blank Solid Cermet Rods



规格 Specifications	尺寸范围 Dimensions(mm)			
	直径 Diameter	直径公差 Diameter tolerance	长度 Length	长度公差 Length tolerance
Φ3*50	3	+0.20~+0.30	50	+1.0/0
Φ4*50	4	+0.20~+0.30	50	+1.0/0
Φ4*75	4	+0.20~+0.30	75	+1.0/0
Φ5*50	5	+0.25~+0.35	50	+1.0/0
Φ5*75	5	+0.25~+0.35	75	+1.0/0
Φ6*50	6	+0.25~+0.35	50	+1.0/0
Φ6*75	6	+0.25~+0.35	75	+1.0/0
Φ8*60	8	+0.30~+0.40	60	+1.0/0
Φ8*75	8	+0.30~+0.40	75	+1.0/0
Φ8*100	8	+0.30~+0.40	100	+2.0/0
Φ10*75	10	+0.30~+0.40	75	+1.0/0
Φ10*100	10	+0.30~+0.40	100	+2.0/0
Φ11*75	11	+0.35~+0.45	75	+1.0/0
Φ12*75	12	+0.35~+0.45	75	+1.0/0
Φ12*100	12	+0.35~+0.45	100	+2.0/0
Φ14*75	14	+0.35~+0.45	75	+1.0/0
Φ14*100	14	+0.35~+0.45	100	+2.0/0
Φ16*100	16	+0.35~+0.45	100	+2.0/0

可根据客户需求, 定制其他规格的金属陶瓷棒材产品 Customize other specifications cermet rods

A
车削刀片

B
铣削刀片

C
铝合金刀片

D
孔加工刀片

E
刮管刀片

F
非标异形刀片

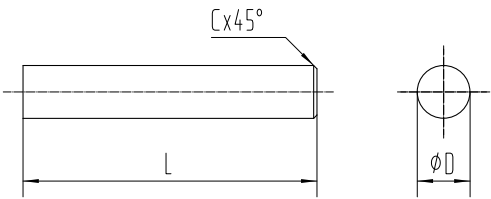
G
圆棒和立铣刀

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精磨实心金属陶瓷小圆棒
Fine Grinding Solid Cermet Rods



规格 Specifications	尺寸范围 Dimensions(mm)			
	直径 Diameter	直径公差 Diameter tolerance	长度 Length	长度公差 Length tolerance
Φ1.5*15	1.5	0~-0.008	15	+1.0/0
Φ2.0*15	2	0~-0.008	15	+1.0/0
Φ2.5*15	2.5	0~-0.008	15	+1.0/0
Φ3.0*15	3	0~-0.008	15	+1.0/0
Φ3.5*15	3.5	0~-0.008	15	+1.0/0
Φ4.0*15	4	0~-0.010	15	+1.0/0
Φ4.0*20	4	0~-0.010	20	+1.0/0
Φ4.5*20	4.5	0~-0.010	20	+1.0/0
Φ5.0*15	5	0~-0.010	15	+1.0/0
Φ5.0*20	5	0~-0.010	20	+1.0/0
Φ5.5*15	5.5	0~-0.010	15	+1.0/0
Φ5.5*20	5.5	0~-0.010	20	+1.0/0
Φ6.0*15	6	0~-0.010	15	+1.0/0
Φ6.0*20	6	0~-0.010	20	+1.0/0
Φ6.5*15	6.5	0~-0.010	15	+1.0/0
Φ6.5*20	6.5	0~-0.010	20	+1.0/0
Φ8.0*15	8	0~-0.010	15	+1.0/0
Φ8.0*20	8	0~-0.010	20	+1.0/0

可根据客户需求, 定制其他规格的金属陶瓷棒材产品 Customize other specifications cermet rods

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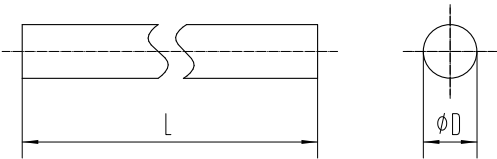
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精磨实心金属陶瓷小圆棒

Fine Grinding Solid Cermet Rods



规格 Specifications	尺寸范围 Dimensions(mm)			
	直径 Diameter	直径公差 Diameter tolerance	长度 Length	长度公差 Length tolerance
$\phi 3 \times 50$	3	0~-0.008	50	+1.0/0
$\phi 4 \times 50$	4	0~-0.008	50	+1.0/0
$\phi 4 \times 75$	4	0~-0.008	75	+1.0/0
$\phi 5 \times 50$	5	0~-0.008	50	+1.0/0
$\phi 5 \times 75$	5	0~-0.008	75	+1.0/0
$\phi 6 \times 50$	6	0~-0.010	50	+1.0/0
$\phi 6 \times 75$	6	0~-0.010	75	+1.0/0
$\phi 8 \times 60$	8	0~-0.010	60	+1.0/0
$\phi 8 \times 75$	8	0~-0.010	75	+1.0/0
$\phi 8 \times 100$	8	0~-0.010	100	+1.0/0
$\phi 10 \times 75$	10	0~-0.010	75	+1.0/0
$\phi 10 \times 100$	10	0~-0.010	100	+1.0/0
$\phi 11 \times 75$	11	0~-0.013	75	+1.0/0
$\phi 12 \times 75$	12	0~-0.013	75	+1.0/0
$\phi 12 \times 100$	12	0~-0.013	100	+1.0/0
$\phi 14 \times 75$	14	0~-0.013	75	+1.0/0
$\phi 14 \times 100$	14	0~-0.013	100	+1.0/0
$\phi 16 \times 100$	16	0~-0.013	100	+1.0/0

可根据客户需求, 定制其他规格的金属陶瓷棒材产品 Customize other specifications cermet rods

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刀杆和刀盘

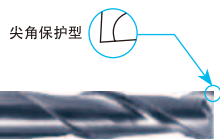
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二刃直柄平头立铣刀

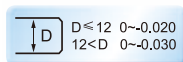
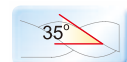
Two Flutes Square End Mill

KGM-2E



● 最适宜沟槽铣削。
Suitable for Groove Milling

● 适用范围广泛。
Wide Range of Applications



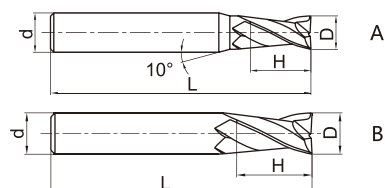
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-2E-D1.0S	1.0	4	3	50	2	A	●
KGM-2E-D1.5S	1.5	4	4	50	2	A	●
KGM-2E-D2.0S	2.0	4	6	50	2	A	●
KGM-2E-D2.5S	2.5	4	8	50	2	A	●
KGM-2E-D3.0S	3.0	4	8	50	2	A	●
KGM-2E-D4.0S	4.0	4	11	50	2	B	●
KGM-2E-D1.0	1.0	6	3	50	2	A	●
KGM-2E-D1.5	1.5	6	4	50	2	A	●
KGM-2E-D2.0	2.0	6	6	50	2	A	●
KGM-2E-D2.5	2.5	6	8	50	2	A	●
KGM-2E-D3.0	3.0	6	8	50	2	A	●
KGM-2E-D3.5	3.5	6	10	50	2	A	●
KGM-2E-D4.0	4.0	6	11	50	2	A	●
KGM-2E-D4.5	4.5	6	11	50	2	A	●
KGM-2E-D5.0	5.0	6	13	50	2	A	●
KGM-2E-D5.5	5.5	6	16	50	2	A	●
KGM-2E-D6.0	6.0	6	16	50	2	B	●
KGM-2E-D7.0	7.0	8	20	60	2	A	●
KGM-2E-D8.0	8.0	8	20	60	2	B	●
KGM-2E-D9.0	9.0	10	22	75	2	A	●
KGM-2E-D10.0	10.0	10	25	75	2	B	●
KGM-2E-D11.0	11.0	12	26	75	2	A	●
KGM-2E-D12.0	12.0	12	30	75	2	B	●
KGM-2E-D14.0	14.0	14	32	75	2	B	●
KGM-2E-D16.0	16.0	16	45	100	2	B	●
KGM-2E-D18.0	18.0	18	45	100	2	B	●
KGM-2E-D20.0	20.0	20	45	100	2	B	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

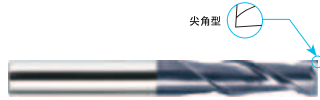
圆棒和立铣刀 / 硬质合金立铣刀

Solid Carbide Endmill

二刃直柄平头立铣刀

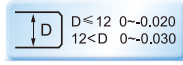
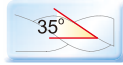
Two Flutes Square End Mill

KGM-2F



● 最适宜沟槽铣削。
Suitable for Groove Milling

● 适用范围广泛。
Wide Range of Applications



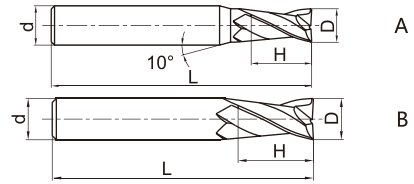
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-2F-D1.0S	1.0	4	3	50	2	A	○
KGM-2F-D1.5S	1.5	4	4	50	2	A	○
KGM-2F-D2.0S	2.0	4	6	50	2	A	○
KGM-2F-D2.5S	2.5	4	8	50	2	A	○
KGM-2F-D3.0S	3.0	4	8	50	2	A	○
KGM-2F-D4.0S	4.0	4	11	50	2	B	○
KGM-2F-D1.0	1.0	6	3	50	2	A	○
KGM-2F-D1.5	1.5	6	4	50	2	A	○
KGM-2F-D2.0	2.0	6	6	50	2	A	○
KGM-2F-D2.5	2.5	6	8	50	2	A	○
KGM-2F-D3.0	3.0	6	8	50	2	A	○
KGM-2F-D3.5	3.5	6	10	50	2	A	○
KGM-2F-D4.0	4.0	6	11	50	2	A	○
KGM-2F-D4.5	4.5	6	11	50	2	A	○
KGM-2F-D5.0	5.0	6	13	50	2	A	○
KGM-2F-D5.5	5.5	6	16	50	2	A	○
KGM-2F-D6.0	6.0	6	16	50	2	B	○
KGM-2F-D7.0	7.0	8	20	60	2	A	○
KGM-2F-D8.0	8.0	8	20	60	2	B	○
KGM-2F-D9.0	9.0	10	22	75	2	A	○
KGM-2F-D10.0	10.0	10	25	75	2	B	○
KGM-2F-D11.0	11.0	12	26	75	2	A	○
KGM-2F-D12.0	12.0	12	30	75	2	B	○
KGM-2F-D14.0	14.0	14	32	75	2	B	○
KGM-2F-D16.0	16.0	16	45	100	2	B	○
KGM-2F-D18.0	18.0	18	45	100	2	B	○
KGM-2F-D20.0	20.0	20	45	100	2	B	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

二刃直柄长刃平头立铣刀

Two Flutes Long Cutting Length Square End Mill

KGM-2EL



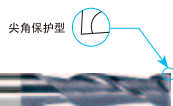
侧面加工
Side Milling



台阶加工
Profile Milling

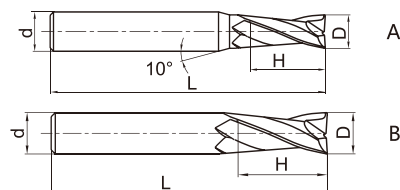
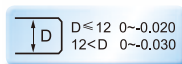


直角槽加工
Slutting



GM™2E的长刃系列°

GM-2E Long Cutting Length Series



规格 Specifications	基本尺寸Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-2EL-D3.0	3.0	6	12	75	2	A	●
KGM-2EL-D4.0	4.0	6	15	75	2	A	●
KGM-2EL-D5.0	5.0	6	20	75	2	A	●
KGM-2EL-D6.0	6.0	6	20	75	2	B	●
KGM-2EL-D8.0	8.0	8	25	100	2	B	●
KGM-2EL-D10.0	10.0	10	30	100	2	B	●
KGM-2EL-D12.0	12.0	12	35	100	2	B	●
KGM-2EL-D14.0	14.0	14	40	100	2	B	●
KGM-2EL-D16.0	16.0	16	50	150	2	B	●
KGM-2EL-D20.0	20.0	20	55	150	2	B	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

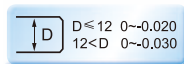
二刃直柄长刃平头立铣刀

Two Flutes Long Cutting Length Square End Mill

KGM-2FL



● GM-2F的长刃系列。
GM-2F Long Cutting Length Series



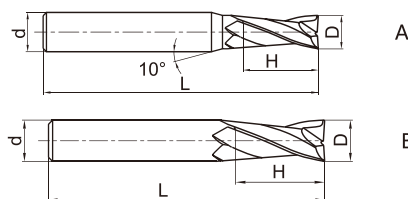
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-2FL-D3.0	3.0	6	12	75	2	A	○
KGM-2FL-D4.0	4.0	6	15	75	2	A	○
KGM-2FL-D5.0	5.0	6	20	75	2	A	○
KGM-2FL-D6.0	6.0	6	20	75	2	B	○
KGM-2FL-D8.0	8.0	8	25	100	2	B	○
KGM-2FL-D10.0	10.0	10	30	100	2	B	○
KGM-2FL-D12.0	12.0	12	35	100	2	B	○
KGM-2FL-D14.0	14.0	14	40	100	2	B	○
KGM-2FL-D16.0	16.0	16	50	150	2	B	○
KGM-2FL-D20.0	20.0	20	55	150	2	B	○

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■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

二刃直柄长刃平头立铣刀

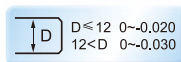
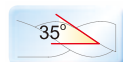
Two Flutes Long Cutting Length Square End Mill

KGM-2EX



- 超长刃设计，适合深侧壁加工。

GM-2E Long Cutting Length Series



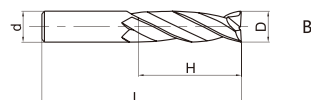
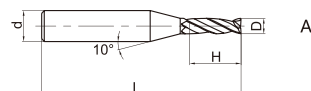
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-2EX-D3.0	3.0	6	20	75	2	A	○
KGM-2EX-D4.0	4.0	6	25	75	2	A	○
KGM-2EX-D5.0	5.0	6	30	75	2	A	○
KGM-2EX-D6.0	6.0	6	30	75	2	B	○
KGM-2EX-D8.0	8.0	8	40	100	2	B	○
KGM-2EX-D10.0	10.0	10	50	110	2	B	○
KGM-2EX-D12.0	12.0	12	50	110	2	B	○
KGM-2EX-D16.0	16.0	16	70	150	2	B	○
KGM-2EX-D20.0	20.0	20	75	150	2	B	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

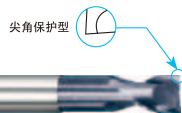
I 加工案例

J 通用技术信息

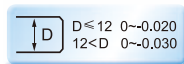
二刃直柄长颈短刃平头立铣刀

Two Flutes Long Neck Short Cutting Length Square End Mill

KGM-2EFP



- 高刚性短刃设计，适用于重切削，也可用于深型腔的铣削加工。
Short cutting length design for heavy cutting and deep cavity milling



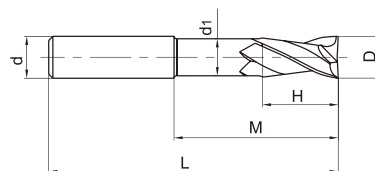
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸 Dimensions (mm)						齿数 Number of teeth Z	库存 Stock
	D	d	H	M	d ₁	L		
KGM-2EFP-D6.0	6.0	6	9	30	5.8	75	2	○
KGM-2EFP-D8.0	8.0	8	12	40	7.8	100	2	○
KGM-2EFP-D10.0	10.0	10	15	50	9.6	100	2	○
KGM-2EFP-D12.0	12.0	12	18	50	11.5	100	2	○
KGM-2EFP-D16.0	16.0	16	24	50	15.5	150	2	○
KGM-2EFP-D20.0	20.0	20	30	60	19.5	150	2	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

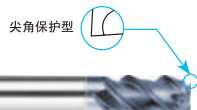
被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

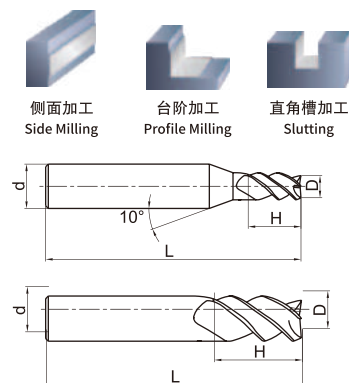
三刃直柄平头立铣刀

Three Flutes Square End Mill

KGM-3E



- 优异的抗振性能，可实现槽铣、侧铣、钻铣多种加工。
Excellent anti-vibration performance, suitable for slot milling, side milling and drilling



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-3E-D1.0S	1.0	4	3	50	3	A	○
KGM-3E-D1.5S	1.5	4	4	50	3	A	○
KGM-3E-D2.0S	2.0	4	6	50	3	A	○
KGM-3E-D2.5S	2.5	4	8	50	3	A	○
KGM-3E-D3.0S	3.0	4	8	50	3	A	○
KGM-3E-D4.0S	4.0	4	11	50	3	B	○
KGM-3E-D1.0	1.0	6	3	50	3	A	○
KGM-3E-D1.5	1.5	6	4	50	3	A	○
KGM-3E-D2.0	2.0	6	6	50	3	A	○
KGM-3E-D2.5	2.5	6	8	50	3	A	○
KGM-3E-D3.0	3.0	6	8	50	3	A	○
KGM-3E-D3.5	3.5	6	10	50	3	A	○
KGM-3E-D4.0	4.0	6	11	50	3	A	○
KGM-3E-D4.5	4.5	6	11	50	3	A	○
KGM-3E-D5.0	5.0	6	13	50	3	A	○
KGM-3E-D5.5	5.5	6	16	50	3	A	○
KGM-3E-D6.0	6.0	6	16	50	3	B	○
KGM-3E-D7.0	7.0	8	20	60	3	A	○
KGM-3E-D8.0	8.0	8	20	60	3	B	○
KGM-3E-D9.0	9.0	10	22	75	3	A	○
KGM-3E-D10.0	10.0	10	25	75	3	B	○
KGM-3E-D11.0	11.0	12	26	75	3	A	○
KGM-3E-D12.0	12.0	12	30	75	3	B	○
KGM-3E-D14.0	14.0	14	32	75	3	B	○
KGM-3E-D16.0	16.0	16	45	100	3	B	○
KGM-3E-D18.0	18.0	18	45	100	3	B	○
KGM-3E-D20.0	20.0	20	45	100	3	B	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

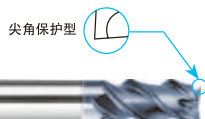
■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

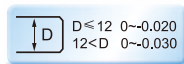
三刃直柄长刃平头立铣刀

Three Flutes Long Cutting Length Square End Mill

KGM-3EL



● GM-3E的长刃系列。
GM-3E Long Cutting Length Series



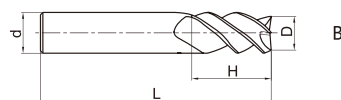
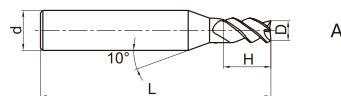
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-3EL-D3.0	3.0	6	12	75	3	A	○
KGM-3EL-D4.0	4.0	6	15	75	3	A	○
KGM-3EL-D5.0	5.0	6	20	75	3	A	○
KGM-3EL-D6.0	6.0	6	20	75	3	B	○
KGM-3EL-D8.0	8.0	8	25	100	3	B	○
KGM-3EL-D10.0	10.0	10	30	100	3	B	○
KGM-3EL-D12.0	12.0	12	35	100	3	B	○
KGM-3EL-D14.0	14.0	14	40	100	3	B	○
KGM-3EL-D16.0	16.0	16	50	150	3	B	○
KGM-3EL-D20.0	20.0	20	55	150	3	B	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

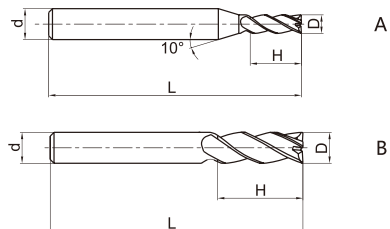
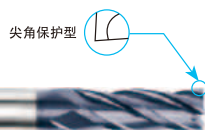
■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

四刃直柄平头立铣

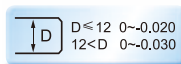
Four Flutes Square End Mill

KGM-4E-G



● 最适宜侧面铣削。
Suitable for Side Milling

● 适用范围广泛。
Wide range of applications



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-4E-D1.0S-G	1.0	4	3	50	4	A	●
KGM-4E-D1.5S-G	1.5	4	4	50	4	A	●
KGM-4E-D2.0S-G	2.0	4	6	50	4	A	●
KGM-4E-D2.5S-G	2.5	4	8	50	4	A	●
KGM-4E-D3.0S-G	3.0	4	8	50	4	A	●
KGM-4E-D4.0S-G	4.0	4	11	50	4	B	●
KGM-4E-D1.0-G	1.0	6	3	50	4	A	●
KGM-4E-D1.5-G	1.5	6	4	50	4	A	●
KGM-4E-D2.0-G	2.0	6	6	50	4	A	●
KGM-4E-D2.5-G	2.5	6	8	50	4	A	●
KGM-4E-D3.0-G	3.0	6	8	50	4	A	●
KGM-4E-D3.5-G	3.5	6	10	50	4	A	●
KGM-4E-D4.0-G	4.0	6	11	50	4	A	●
KGM-4E-D4.5-G	4.5	6	11	50	4	A	●
KGM-4E-D5.0-G	5.0	6	13	50	4	A	●
KGM-4E-D5.5-G	5.5	6	16	50	4	A	●
KGM-4E-D6.0-G	6.0	6	16	50	4	B	●
KGM-4E-D7.0-G	7.0	8	20	60	4	A	●
KGM-4E-D8.0-G	8.0	8	20	60	4	B	●
KGM-4E-D9.0-G	9.0	10	22	75	4	A	●
KGM-4E-D10.0-G	10.0	10	25	75	4	B	●
KGM-4E-D11.0-G	11.0	12	26	75	4	A	●
KGM-4E-D12.0-G	12.0	12	30	75	4	B	●
KGM-4E-D14.0-G	14.0	14	32	75	4	B	●
KGM-4E-D16.0-G	16.0	16	45	100	4	B	●
KGM-4E-D18.0-G	18.0	18	45	100	4	B	●
KGM-4E-D20.0-G	20.0	20	45	100	4	B	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

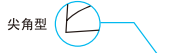
圆棒和立铣刀 / 硬质合金立铣刀

Solid Carbide Endmill

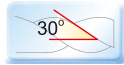
四刃直柄平头立铣刀

Four Flutes Square End Mill

KGM-4F-G



● 最适宜侧面铣削。
Suitable for Side Milling



● 适用范围广泛。
Wide range of applications



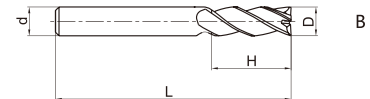
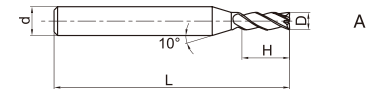
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-4F-D1.0S-G	1.0	4	3	50	4	A	○
KGM-4F-D1.5S-G	1.5	4	4	50	4	A	○
KGM-4F-D2.0S-G	2.0	4	6	50	4	A	○
KGM-4F-D2.5S-G	2.5	4	8	50	4	A	○
KGM-4F-D3.0S-G	3.0	4	8	50	4	A	○
KGM-4F-D4.0S-G	4.0	4	11	50	4	B	○
KGM-4F-D1.0-G	1.0	6	3	50	4	A	○
KGM-4F-D1.5-G	1.5	6	4	50	4	A	○
KGM-4F-D2.0-G	2.0	6	6	50	4	A	○
KGM-4F-D2.5-G	2.5	6	8	50	4	A	○
KGM-4F-D3.0-G	3.0	6	8	50	4	A	○
KGM-4F-D3.5-G	3.5	6	10	50	4	A	○
KGM-4F-D4.0-G	4.0	6	11	50	4	A	○
KGM-4F-D4.5-G	4.5	6	11	50	4	A	○
KGM-4F-D5.0-G	5.0	6	13	50	4	A	○
KGM-4F-D5.5-G	5.5	6	16	50	4	A	○
KGM-4F-D6.0-G	6.0	6	16	50	4	B	○
KGM-4F-D7.0-G	7.0	8	20	60	4	A	○
KGM-4F-D8.0-G	8.0	8	20	60	4	B	○
KGM-4F-D9.0-G	9.0	10	22	75	4	A	○
KGM-4F-D10.0-G	10.0	10	25	75	4	B	○
KGM-4F-D11.0-G	11.0	12	26	75	4	A	○
KGM-4F-D12.0-G	12.0	12	30	75	4	B	○
KGM-4F-D14.0-G	14.0	14	32	75	4	B	○
KGM-4F-D16.0-G	16.0	16	45	100	4	B	○
KGM-4F-D18.0-G	18.0	18	45	100	4	B	○
KGM-4F-D20.0-G	20.0	20	45	100	4	B	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

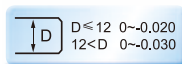
四刃直柄长刃平头立铣刀

Four Flutes Long Cutting Length Square End Mill

KGM-4EL-G



● GM-4E-G的长刃系列。
GM-4E-G Long Cutting Length Series



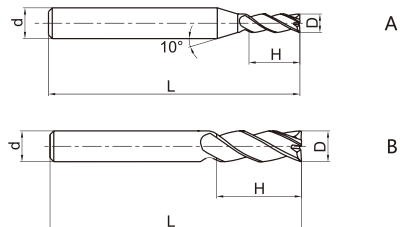
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-4EL-D3.0-G	3.0	6	12	75	4	A	○
KGM-4EL-D4.0-G	4.0	6	15	75	4	A	○
KGM-4EL-D5.0-G	5.0	6	20	75	4	A	○
KGM-4EL-D6.0-G	6.0	6	20	75	4	B	○
KGM-4EL-D8.0-G	8.0	8	25	100	4	B	○
KGM-4EL-D10.0-G	10.0	10	30	100	4	B	○
KGM-4EL-D12.0-G	12.0	12	35	100	4	B	○
KGM-4EL-D14.0-G	14.0	14	40	100	4	B	○
KGM-4EL-D16.0-G	16.0	16	50	150	4	B	○
KGM-4EL-D20.0-G	20.0	20	55	150	4	B	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

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被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

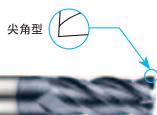
I 加工案例

J 通用技术信息

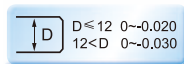
四刃直柄长刃平头立铣刀

Four Flutes Long Cutting Length Square End Mill

KGM-4FL-G



● GM-4F-G的长刃系列。
GM-4F-G Long Cutting Length Series



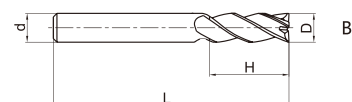
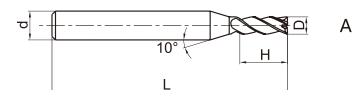
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-4FL-D3.0-G	3.0	6	12	75	4	A	○
KGM-4FL-D4.0-G	4.0	6	15	75	4	A	○
KGM-4FL-D5.0-G	5.0	6	20	75	4	A	○
KGM-4FL-D6.0-G	6.0	6	20	75	4	B	○
KGM-4FL-D8.0-G	8.0	8	25	100	4	B	○
KGM-4FL-D10.0-G	10.0	10	30	100	4	B	○
KGM-4FL-D12.0-G	12.0	12	35	100	4	B	○
KGM-4FL-D14.0-G	14.0	14	40	100	4	B	○
KGM-4FL-D16.0-G	16.0	16	50	150	4	B	○
KGM-4FL-D20.0-G	20.0	20	55	150	4	B	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

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被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

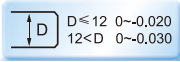
四刃直柄特长刃平头立铣刀

Four Flutes Super Long Cutting Length Square End Mill

KGM-4EX-G



● 超长刃设计 适合深侧壁的加工
Super long cutting length design, suitable for deep side milling



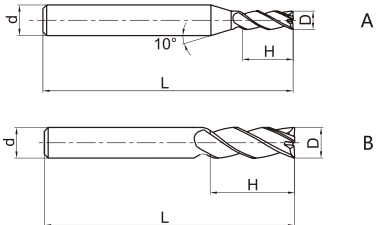
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-4EX-D3.0-G	3.0	6	20	75	4	A	○
KGM-4EX-D4.0-G	4.0	6	25	75	4	A	○
KGM-4EX-D5.0-G	5.0	6	30	75	4	A	○
KGM-4EX-D6.0-G	6.0	6	30	75	4	B	○
KGM-4EX-D8.0-G	8.0	8	40	100	4	B	○
KGM-4EX-D10.0-G	10.0	10	50	110	4	B	○
KGM-4EX-D12.0-G	12.0	12	50	110	4	B	○
KGM-4EX-D16.0-G	16.0	16	70	150	4	B	○
KGM-4EX-D20.0-G	20.0	20	75	150	4	B	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
◎	◎	◎	○			○	◎				

圆棒和立铣刀 / 硬质合金立铣刀

Solid Carbide Endmill

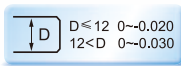
四刃直柄平头立铣刀

Four Flutes Square End Mill

KGM-4E



● 最适宜侧面铣削，浅槽加工。
Suitable for side milling, shallow grooving



● 适用范围广泛。
Wide range of applications



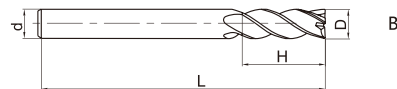
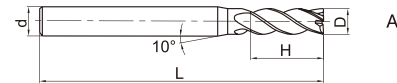
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-4E-D1.0S	1.0	4	3	50	4	A	●
KGM-4E-D1.5S	1.5	4	4	50	4	A	●
KGM-4E-D2.0S	2.0	4	6	50	4	A	●
KGM-4E-D2.5S	2.5	4	8	50	4	A	●
KGM-4E-D3.0S	3.0	4	8	50	4	A	●
KGM-4E-D4.0S	4.0	4	11	50	4	B	●
KGM-4E-D1.0	1.0	6	3	50	4	A	●
KGM-4E-D1.5	1.5	6	4	50	4	A	●
KGM-4E-D2.0	2.0	6	6	50	4	A	●
KGM-4E-D2.5	2.5	6	8	50	4	A	●
KGM-4E-D3.0	3.0	6	8	50	4	A	●
KGM-4E-D3.5	3.5	6	10	50	4	A	●
KGM-4E-D4.0	4.0	6	11	50	4	A	●
KGM-4E-D4.5	4.5	6	11	50	4	A	●
KGM-4E-D5.0	5.0	6	13	50	4	A	●
KGM-4E-D5.5	5.5	6	16	50	4	A	●
KGM-4E-D6.0	6.0	6	16	50	4	B	●
KGM-4E-D7.0	7.0	8	20	60	4	A	●
KGM-4E-D8.0	8.0	8	20	60	4	B	●
KGM-4E-D9.0	9.0	10	22	75	4	A	●
KGM-4E-D10.0	10.0	10	25	75	4	B	●
KGM-4E-D11.0	11.0	12	26	75	4	A	●
KGM-4E-D12.0	12.0	12	30	75	4	B	●
KGM-4E-D14.0	14.0	14	32	75	4	B	●
KGM-4E-D16.0	16.0	16	45	100	4	B	●
KGM-4E-D18.0	18.0	18	45	100	4	B	●
KGM-4E-D20.0	20.0	20	45	100	4	B	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ● 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

四刃直柄长刃平头立铣刀

Four Flutes Long Cutting Length Square End Mill

KGM-4EL



侧面加工
Side Milling



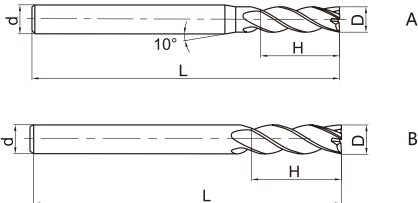
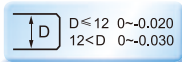
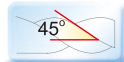
台阶加工
Profile Milling



直角槽加工
Slutting

GM-4E的长刃系列。

GM-4E Long Cutting Length Series



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-4EL-D3.0	3.0	6	12	75	4	A	●
KGM-4EL-D4.0	4.0	6	15	75	4	A	●
KGM-4EL-D5.0	5.0	6	20	75	4	A	●
KGM-4EL-D6.0	6.0	6	20	75	4	B	●
KGM-4EL-D8.0	8.0	8	25	100	4	B	●
KGM-4EL-D10.0	10.0	10	30	100	4	B	●
KGM-4EL-D12.0	12.0	12	35	100	4	B	●
KGM-4EL-D14.0	14.0	14	40	100	4	B	●
KGM-4EL-D16.0	16.0	16	50	150	4	B	●
KGM-4EL-D20.0	20.0	20	55	150	4	B	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

四刃直柄长颈短刃平头立铣刀

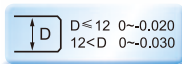
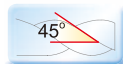
Four Flutes Long Neck Short Cutting Length Square End Mill

KGM-4EFP



- 高刚性短刃设计，适用于重切削，也可用于深型腔的铣削加工。

Short cutting length design, suitable for heavy cutting and deep cavity milling



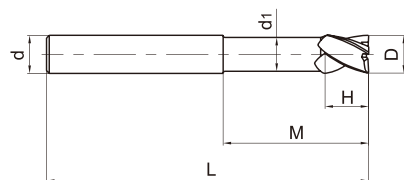
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸Dimensions (mm)						齿数 Number of teeth Z	库存 Stock
	D	d	H	M	d ₁	L		
KGM-4EFP-D6.0	6.0	6	9	30	5.8	75	4	○
KGM-4EFP-D8.0	8.0	8	12	40	7.8	100	4	○
KGM-4EFP-D10.0	10.0	10	15	50	9.6	100	4	○
KGM-4EFP-D12.0	12.0	12	18	50	11.5	100	4	○
KGM-4EFP-D16.0	16.0	16	24	50	15.5	150	4	○
KGM-4EFP-D20.0	20.0	20	30	60	19.5	150	4	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

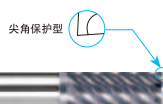
被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

六刃直柄平头立铣刀

Six Flutes Square End Mill

KGM-6E



侧面加工
Side Milling

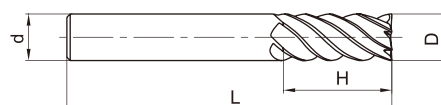
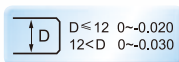
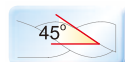


台阶加工
Profile Milling



直角槽加工
Slutting

- 刀具刚性好，最适宜侧面精铣加工。
Good rigidity, suitable for side finishing milling
- 可进行高速，大进给加工。
High speed, high feed milling



规格 Specifications	基本尺寸Dimensions (mm)				齿数 Number of teeth Z	库存 Stock
	D	d	H	L		
KGM-6E-D6.0	6.0	6	18	60	6	●
KGM-6E-D8.0	8.0	8	20	60	6	●
KGM-6E-D10.0	10.0	10	30	75	6	●
KGM-6E-D12.0	12.0	12	32	75	6	●
KGM-6E-D16.0	16.0	16	40	100	6	●
KGM-6E-D20.0	20.0	20	45	100	6	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

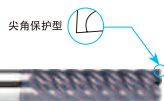
被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

六刃直柄长刃平头立铣刀

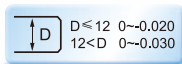
Six Flutes Long Cutting Length Square End Mill

KGM-6EL



● GM-6E的长刃系列。

GM-6E long cutting length series



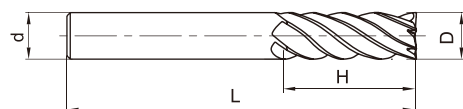
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	库存 Stock
	D	d	H	L		
KGM-6EL-D6.0	6.0	6	24	75	6	●
KGM-6EL-D8.0	8.0	8	32	75	6	●
KGM-6EL-D10.0	10.0	10	40	100	6	●
KGM-6EL-D12.0	12.0	12	45	100	6	●
KGM-6EL-D16.0	16.0	16	64	150	6	●
KGM-6EL-D20.0	20.0	20	75	150	6	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

二刃直柄长颈短刃平头立铣刀

Two Flutes Long Neck Short Cutting Length Square End Mill

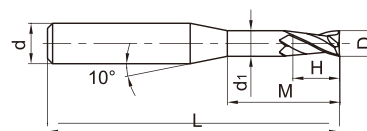
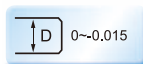
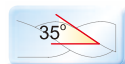
KGM-2EP



平头深沟加工
Flat deep groove processing

- 适用于细槽加工或会产生干涉的细微部分的加工。

Suitable for fine groove processing



规格 Specifications	基本尺寸 Dimensions (mm)						齿数 Number of teeth Z	库存 Stock
	D	d	H	M	d ₁	L		
KGM-2EP-D0.5-M04	0.5	4	0.7	4	0.45	50	2	●
KGM-2EP-D0.5-M06	0.5	4	0.7	6	0.45	50	2	●
KGM-2EP-D0.5-M08	0.5	4	0.7	8	0.45	50	2	●
KGM-2EP-D0.8-M04	0.8	4	1.2	4	0.75	50	2	●
KGM-2EP-D0.8-M06	0.8	4	1.2	6	0.75	50	2	●
KGM-2EP-D0.8-M08	0.8	4	1.2	8	0.75	50	2	●
KGM-2EP-D0.8-M10	0.8	4	1.2	10	0.75	50	2	●
KGM-2EP-D1.0-M04	1.0	4	1.5	4	0.95	50	2	●
KGM-2EP-D1.0-M06	1.0	4	1.5	6	0.95	50	2	●
KGM-2EP-D1.0-M08	1.0	4	1.5	8	0.95	50	2	●
KGM-2EP-D1.0-M10	1.0	4	1.5	10	0.95	50	2	●
KGM-2EP-D1.0-M12	1.0	4	1.5	12	0.95	50	2	●
KGM-2EP-D1.0-M14	1.0	4	1.5	14	0.95	50	2	●
KGM-2EP-D1.2-M06	1.2	4	1.8	6	1.15	50	2	●
KGM-2EP-D1.2-M08	1.2	4	1.8	8	1.15	50	2	●
KGM-2EP-D1.2-M10	1.2	4	1.8	10	1.15	50	2	●
KGM-2EP-D1.2-M12	1.2	4	1.8	12	1.15	50	2	●
KGM-2EP-D1.5-M06	1.5	4	2.3	6	1.45	50	2	●
KGM-2EP-D1.5-M08	1.5	4	2.3	8	1.45	50	2	●
KGM-2EP-D1.5-M10	1.5	4	2.3	10	1.45	50	2	●
KGM-2EP-D1.5-M12	1.5	4	2.3	12	1.45	50	2	●
KGM-2EP-D1.5-M14	1.5	4	2.3	14	1.45	50	2	●
KGM-2EP-D2.0-M06	2.0	4	3.0	6	1.95	50	2	●
KGM-2EP-D2.0-M08	2.0	4	3.0	8	1.95	50	2	●
KGM-2EP-D2.0-M10	2.0	4	3.0	10	1.95	50	2	●
KGM-2EP-D2.0-M12	2.0	4	3.0	12	1.95	50	2	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

二刃直柄长颈短刃平头立铣刀

Two Flutes Long Neck Short Cutting Length Square End Mill

KGM-2EP

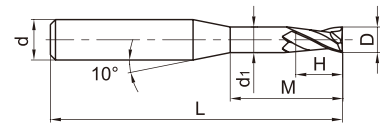
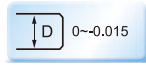


平头深沟加工
Flat deep groove processing



- 适用于细槽加工或会产生干涉的细微部分的加工。

Suitable for fine groove processing



规格 Specifications	基本尺寸 Dimensions (mm)						齿数 Number of teeth Z	库存 Stock
	D	d	H	M	d ₁	L		
KGM-2EP-D2.0-M14	2.0	4	3.0	14	1.95	50	2	●
KGM-2EP-D2.0-M16	2.0	4	3.0	16	1.95	50	2	●
KGM-2EP-D2.5-M08	2.5	4	3.7	8	2.4	50	2	●
KGM-2EP-D2.5-M10	2.5	4	3.7	10	2.4	50	2	●
KGM-2EP-D2.5-M12	2.5	4	3.7	12	2.4	50	2	●
KGM-2EP-D2.5-M14	2.5	4	3.7	14	2.4	50	2	●
KGM-2EP-D2.5-M16	2.5	4	3.7	16	2.4	60	2	●
KGM-2EP-D2.5-M18	2.5	4	3.7	18	2.4	60	2	●
KGM-2EP-D2.5-M20	2.5	4	3.7	20	2.4	60	2	●
KGM-2EP-D3.0-M06	3.0	6	4.5	6	2.85	50	2	●
KGM-2EP-D3.0-M08	3.0	6	4.5	8	2.85	50	2	●
KGM-2EP-D3.0-M10	3.0	6	4.5	10	2.85	50	2	●
KGM-2EP-D3.0-M12	3.0	6	4.5	12	2.85	50	2	●
KGM-2EP-D3.0-M14	3.0	6	4.5	14	2.85	60	2	●
KGM-2EP-D3.0-M16	3.0	6	4.5	16	2.85	60	2	●
KGM-2EP-D3.0-M18	3.0	6	4.5	18	2.85	60	2	●
KGM-2EP-D3.0-M20	3.0	6	4.5	20	2.85	60	2	●
KGM-2EP-D4.0-M12	4.0	6	6.0	12	3.85	50	2	●
KGM-2EP-D4.0-M16	4.0	6	6.0	16	3.85	60	2	●
KGM-2EP-D4.0-M20	4.0	6	6.0	20	3.85	60	2	●
KGM-2EP-D4.0-M25	4.0	6	6.0	25	3.85	60	2	●
KGM-2EP-D5.0-M16	5.0	6	7.5	16	4.85	60	2	●
KGM-2EP-D5.0-M25	5.0	6	7.5	25	4.85	70	2	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

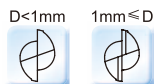
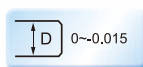
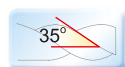
二刃直柄微小径平头立铣刀

Two Flutes Miniature Square End Mill

KGM-2ES



● 微小径铣刀可充分发挥加工中心高速、高精度性能，常用于电子零件等精密零件的加工。



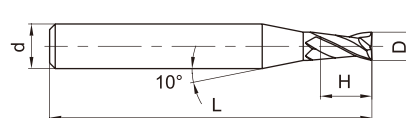
侧面加工
Side Milling



台阶加工
Profile Milling



直角槽加工
Slutting



The high-speed,high-precision performance of the machining center can be fully utilized.Commonly used in the processing of precision parts such as electronic parts

规格 Specifications	基本尺寸 Dimensions (mm)				齿数 Number of teeth Z	库存 Stock
	D	d	H	L		
KGM-2ES-D0.3	0.3	4	0.6	50	2	●
KGM-2ES-D0.4	0.4	4	0.8	50	2	●
KGM-2ES-D0.5	0.5	4	1.0	50	2	●
KGM-2ES-D0.6	0.6	4	1.2	50	2	●
KGM-2ES-D0.7	0.7	4	1.4	50	2	●
KGM-2ES-D0.8	0.8	4	1.6	50	2	●
KGM-2ES-D0.9	0.9	4	1.8	50	2	●
KGM-2ES-D1.0	1.0	4	2.0	50	2	●
KGM-2ES-D1.1	1.1	4	2.0	50	2	●
KGM-2ES-D1.2	1.2	4	2.5	50	2	●
KGM-2ES-D1.3	1.3	4	2.5	50	2	●
KGM-2ES-D1.4	1.4	4	3.0	50	2	●
KGM-2ES-D1.5	1.5	4	3.0	50	2	●
KGM-2ES-D1.6	1.6	4	3.5	50	2	●
KGM-2ES-D1.7	1.7	4	3.5	50	2	●
KGM-2ES-D1.8	1.8	4	4.0	50	2	●
KGM-2ES-D1.9	1.9	4	4.0	50	2	●
KGM-2ES-D2.0	2.0	4	4.0	50	2	●
KGM-2ES-D2.1	2.1	4	4.0	50	2	●
KGM-2ES-D2.2	2.2	4	4.5	50	2	●
KGM-2ES-D2.3	2.3	4	4.5	50	2	●
KGM-2ES-D2.4	2.4	4	5.0	50	2	●
KGM-2ES-D2.5	2.5	4	5.0	50	2	●
KGM-2ES-D2.6	2.6	4	5.0	50	2	●
KGM-2ES-D2.7	2.7	4	5.5	50	2	●
KGM-2ES-D2.8	2.8	4	5.5	50	2	●
KGM-2ES-D2.9	2.9	4	6.0	50	2	●
KGM-2ES-D3.0	3.0	4	6.0	50	2	●

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable ● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

圆棒和立铣刀 / 硬质合金立铣刀

Solid Carbide Endmill

二刃直柄球头立铣刀

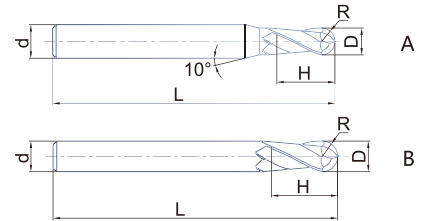
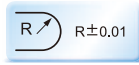
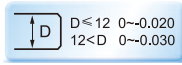
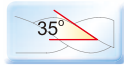
Two Flutes Ball Nose End Mill

KGM-2B



● 适用于仿形铣削，可作高速加工。
Suitable for profile milling, high speed machining

● 适用范围广泛。
Wide range of applications



规格 Specifications	基本尺寸 Dimensions (mm)					齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	R	d	H	L			
KGM-2B-R0.5S	1.0	0.5	4	2	50	2	A	●
KGM-2B-R0.75S	1.5	0.75	4	3	50	2	A	●
KGM-2B-R1.0S	2.0	1.0	4	4	50	2	A	●
KGM-2B-R1.25S	2.5	1.25	4	5	50	2	A	●
KGM-2B-R1.5S	3.0	1.5	4	6	50	2	A	●
KGM-2B-R2.0S	4.0	2.0	4	8	50	2	B	●
KGM-2B-R0.5	1.0	0.5	6	2	50	2	A	●
KGM-2B-R0.75	1.5	0.75	6	3	50	2	A	●
KGM-2B-R1.0	2.0	1.0	6	4	50	2	A	●
KGM-2B-R1.25	2.5	1.25	6	5	50	2	A	●
KGM-2B-R1.5	3.0	1.5	6	6	50	2	A	●
KGM-2B-R1.75	3.5	1.75	6	8	50	2	A	●
KGM-2B-R2.0	4.0	2.0	6	8	50	2	A	●
KGM-2B-R2.5	5.0	2.5	6	10	50	2	A	●
KGM-2B-R2.75	5.5	2.75	6	12	50	2	A	●
KGM-2B-R3.0	6.0	3.0	6	12	50	2	B	●
KGM-2B-R3.5	7.0	3.5	8	14	60	2	B	●
KGM-2B-R4.0	8.0	4.0	8	16	60	2	B	●
KGM-2B-R4.5	9.0	4.5	10	18	75	2	B	●
KGM-2B-R5.0	10	5.0	10	20	75	2	B	●
KGM-2B-R6.0	12	6.0	12	24	75	2	B	●
KGM-2B-R7.0	14	7.0	14	28	75	2	B	●
KGM-2B-R8.0	16	8.0	16	32	100	2	B	●
KGM-2B-R10.0	20	10.0	20	40	100	2	B	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

二刃直柄长柄球头立铣刀

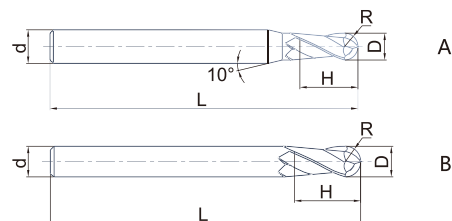
Two Flutes Long Shank Ball Nose End Mill

KGM-2BL



● GM-2B的长柄系列。

GM-2B Long Shank Series



规格 Specifications	基本尺寸 Dimensions (mm)					齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	R	d	H	L			
KGM-2BL-R1.0	2.0	1.0	6	4	75	2	A	●
KGM-2BL-R1.25	2.5	1.25	6	5	75	2	A	●
KGM-2BL-R1.5	3.0	1.5	6	6	75	2	A	●
KGM-2BL-R1.75	3.5	1.75	6	8	75	2	A	●
KGM-2BL-R2.0	4.0	2.0	6	8	75	2	A	●
KGM-2BL-R2.5	5.0	2.5	6	10	75	2	A	●
KGM-2BL-R2.75	5.5	2.75	6	12	75	2	A	●
KGM-2BL-R3.0	6.0	3.0	6	12	75	2	B	●
KGM-2BL-R3.5	7.0	3.5	8	14	75	2	A	●
KGM-2BL-R4.0	8.0	4.0	8	16	100	2	A	●
KGM-2BL-R4.5	9.0	4.5	10	18	100	2	A	●
KGM-2BL-R5.0	10.0	5.0	10	20	100	2	B	●
KGM-2BL-R6.0	12.0	6.0	12	24	100	2	B	●
KGM-2BL-R7.0	14.0	7.0	14	28	100	2	B	●
KGM-2BL-R8.0	16.0	8.0	16	32	150	2	B	●
KGM-2BL-R10.0	20.0	10.0	20	40	150	2	B	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

圆棒和立铣刀 / 硬质合金立铣刀

Solid Carbide Endmill

二刃直柄长颈短刃球头立铣刀

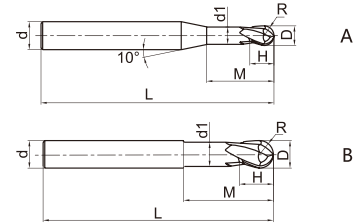
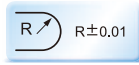
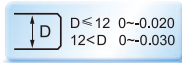
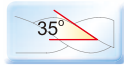
Two Flutes Long Neck Short Cutting Length Ball Nose End Mill

KGM-2BFP



- 高刚性短刃设计，适合重切削。

Short cutting length design, suitable for heavy cutting



规格 Specifications	基本尺寸 Dimensions (mm)							齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	R	H	d ₁	M	d	L			
KGM-2BFP-R0.5	1.0	0.5	1	0.95	2.5	6	75	2	A	○
KGM-2BFP-R0.75	1.5	0.75	1	1.45	3	6	75	2	A	○
KGM-2BFP-R1.0	2.0	1.0	2	1.95	4	6	75	2	A	○
KGM-2BFP-R1.5	3.0	1.5	3	2.85	6	6	75	2	A	○
KGM-2BFP-R2.0	4.0	2.0	4	3.85	8	6	75	2	A	○
KGM-2BFP-R2.5	5.0	2.5	5	4.85	10	6	75	2	A	○
KGM-2BFP-R3.0	6.0	3.0	6	5.8	12	6	75	2	B	○
KGM-2BFP-R4.0	8.0	4.0	8	7.8	16	8	100	2	B	○
KGM-2BFP-R5.0	10.0	5.0	10	9.6	20	10	100	2	B	○
KGM-2BFP-R6.0	12.0	6.0	12	11.5	24	12	100	2	B	○
KGM-2BFP-R8.0	16.0	8.0	16	15.5	32	16	150	2	B	○
KGM-2BFP-R10.0	20.0	10.0	20	19.5	40	20	150	2	B	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

四刃直柄球头立铣刀

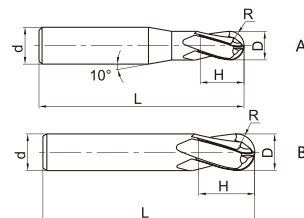
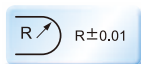
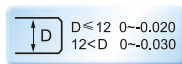
Four Flutes Ball Nose End Mill

KGM-4B



- 四刃球头铣刀可实现较高的进给速度，实现较高的切削加工效率。

High feed machining, High efficient processing



规格 Specifications	基本尺寸 Dimensions (mm)					齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	R	d	H	L			
KGM-4B-R1.5	3.0	1.5	6	6	50	4	A	●
KGM-4B-R2.0	4.0	2.0	6	8	50	4	A	●
KGM-4B-R2.5	5.0	2.5	6	10	50	4	A	●
KGM-4B-R3.0	6.0	3.0	6	12	50	4	A	●
KGM-4B-R4.0	8.0	4.0	8	16	60	4	A	●
KGM-4B-R5.0	10.0	5.0	10	20	75	4	A	●
KGM-4B-R6.0	12.0	6.0	12	24	75	4	B	●
KGM-4B-R7.0	14.0	7.0	14	28	75	4	B	●
KGM-4B-R8.0	16.0	8.0	16	32	100	4	B	●
KGM-4B-R9.0	18.0	9.0	18	36	100	4	B	●
KGM-4B-R10.0	20.0	10.0	20	40	100	4	B	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

四刃直柄长柄球头立铣刀

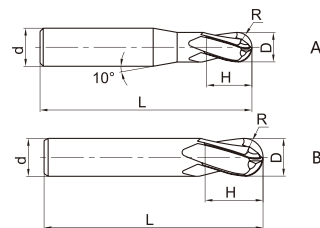
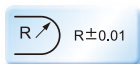
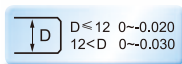
Four Flutes Long Shank Ball Nose End Mill

KGM-4BL



● GM-4B的长柄系列。

GM-4 B Long Shank Series



规格 Specifications	基本尺寸 Dimensions (mm)					齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	R	d	H	L			
KGM-4BL-R1.5	3.0	1.5	6	6	75	4	A	○
KGM-4BL-R2.0	4.0	2.0	6	8	75	4	A	○
KGM-4BL-R2.5	5.0	2.5	6	10	75	4	A	○
KGM-4BL-R3.0	6.0	3.0	6	12	75	4	B	○
KGM-4BL-R4.0	8.0	4.0	8	16	100	4	B	○
KGM-4BL-R5.0	10.0	5.0	10	20	100	4	B	○
KGM-4BL-R6.0	12.0	6.0	12	24	100	4	B	○
KGM-4BL-R7.0	14.0	7.0	14	28	100	4	B	○
KGM-4BL-R8.0	16.0	8.0	16	32	150	4	B	○
KGM-4BL-R9.0	18.0	9.0	18	36	150	4	B	○
KGM-4BL-R10.0	20.0	10.0	20	40	150	4	B	○

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

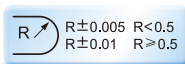
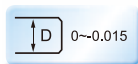
二刃直柄微小径球头立铣刀

Two Flutes Miniature Ball Nose End Mill

KGM-2BS



● 微小径铣刀可充分发挥加工中心高速、高精度性能，常用于电子零件等精密零件的加工。



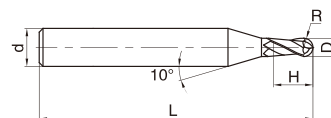
仿形加工
Profile Milling



型腔加工
Cavity machining



球形槽加工
Spherical groove machining



The high-speed,high-precision performance of the machining center can be fully utilized.Commonly used in the processing of precision parts such as electronic parts

规格 Specifications	基本尺寸 Dimensions (mm)					齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L		
KGM-2BS-R0.15	0.30	0.15	4	0.5	50	2	●
KGM-2BS-R0.20	0.40	0.20	4	0.6	50	2	●
KGM-2BS-R0.25	0.50	0.25	4	0.8	50	2	●
KGM-2BS-R0.30	0.60	0.30	4	0.9	50	2	●
KGM-2BS-R0.35	0.70	0.35	4	1.0	50	2	●
KGM-2BS-R0.40	0.80	0.40	4	1.2	50	2	●
KGM-2BS-R0.45	0.90	0.45	4	1.3	50	2	●
KGM-2BS-R0.50	1.00	0.50	4	1.5	50	2	●
KGM-2BS-R0.60	1.20	0.60	4	1.8	50	2	●
KGM-2BS-R0.70	1.40	0.70	4	2.0	50	2	●
KGM-2BS-R0.75	1.50	0.75	4	2.3	50	2	●
KGM-2BS-R0.80	1.60	0.80	4	2.5	50	2	●
KGM-2BS-R0.90	1.80	0.90	4	2.7	50	2	●
KGM-2BS-R1.00	2.00	1.00	4	3.0	50	2	●
KGM-2BS-R1.25	2.50	1.25	4	3.7	50	2	●
KGM-2BS-R1.50	3.00	1.50	4	4.5	50	2	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

二刃直柄长颈短刃球头立铣刀

Two Flutes Long Neck Short Cutting Length Ball Nose End Mill

KGM-2BP

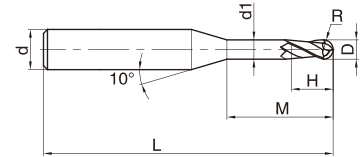
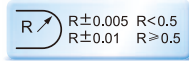
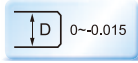
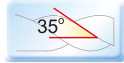


平头深沟加工
Flat deep groove processing



- 适用于细槽加工以及自由曲面加工。

Suitable for fine groove machining and freeform machining



规格 Specifications	基本尺寸 Dimensions (mm)							齿数 Number of teeth Z	库存 Stock
	D	R	H	d ₁	M	d	L		
KGM-2BP-R0.25-M04	0.5	0.25	0.7	0.45	4	4	50	2	●
KGM-2BP-R0.25-M06	0.5	0.25	0.7	0.45	6	4	50	2	●
KGM-2BP-R0.3-M04	0.6	0.3	0.9	0.55	4	4	50	2	●
KGM-2BP-R0.3-M06	0.6	0.3	0.9	0.55	6	4	50	2	●
KGM-2BP-R0.3-M08	0.6	0.3	0.9	0.55	8	4	50	2	●
KGM-2BP-R0.4-M04	0.8	0.4	1.2	0.75	4	4	50	2	●
KGM-2BP-R0.4-M06	0.8	0.4	1.2	0.75	6	4	50	2	●
KGM-2BP-R0.4-M08	0.8	0.4	1.2	0.75	8	4	50	2	●
KGM-2BP-R0.4-M10	0.8	0.4	1.2	0.75	10	4	50	2	●
KGM-2BP-R0.5-M04	1.0	0.5	1.5	0.95	4	4	50	2	●
KGM-2BP-R0.5-M06	1.0	0.5	1.5	0.95	6	4	50	2	●
KGM-2BP-R0.5-M08	1.0	0.5	1.5	0.95	8	4	50	2	●
KGM-2BP-R0.5-M10	1.0	0.5	1.5	0.95	10	4	50	2	●
KGM-2BP-R0.5-M12	1.0	0.5	1.5	0.95	12	4	50	2	●
KGM-2BP-R0.6-M06	1.2	0.6	1.8	1.15	6	4	50	2	●
KGM-2BP-R0.6-M08	1.2	0.6	1.8	1.15	8	4	50	2	●
KGM-2BP-R0.6-M12	1.2	0.6	1.8	1.15	12	4	50	2	●
KGM-2BP-R0.6-M16	1.2	0.6	1.8	1.15	16	4	50	2	●
KGM-2BP-R0.75-M08	1.5	0.75	2.3	1.45	8	4	50	2	●
KGM-2BP-R0.75-M12	1.5	0.75	2.3	1.45	12	4	50	2	●
KGM-2BP-R0.75-M16	1.5	0.75	2.3	1.45	16	4	50	2	●
KGM-2BP-R1.0-M06	2.0	1.0	3.0	1.95	6	4	50	2	●
KGM-2BP-R1.0-M08	2.0	1.0	3.0	1.95	8	4	50	2	●
KGM-2BP-R1.0-M10	2.0	1.0	3.0	1.95	10	4	50	2	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

二刃直柄长颈短刃球头立铣刀

Two Flutes Long Neck Short Cutting Length Ball Nose End Mill

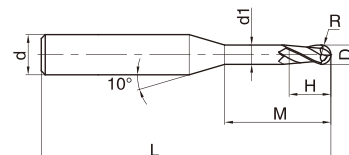
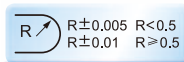
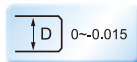
KGM-2BP



平头深沟加工
Flat deep groove processing

- 适用于细槽加工以及自由曲面加工。

Suitable for fine groove machining and freeform machining



规格 Specifications	基本尺寸 Dimensions (mm)							齿数 Number of teeth Z	库存 Stock
	D	R	H	d ₁	M	d	L		
KGM-2BP-R1.0-M12	2.0	1.0	3.0	1.95	12	4	50	2	●
KGM-2BP-R1.0-M16	2.0	1.0	3.0	1.95	16	4	50	2	●
KGM-2BP-R1.0-M20	2.0	1.0	3.0	1.95	20	4	50	2	●
KGM-2BP-R1.25-M08	2.5	1.25	3.7	2.4	8	4	50	2	●
KGM-2BP-R1.25-M12	2.5	1.25	3.7	2.4	12	4	50	2	●
KGM-2BP-R1.25-M16	2.5	1.25	3.7	2.4	16	4	60	2	●
KGM-2BP-R1.25-M20	2.5	1.25	3.7	2.4	20	4	60	2	●
KGM-2BP-R1.5-M08	3.0	1.5	4.5	2.85	8	6	50	2	●
KGM-2BP-R1.5-M10	3.0	1.5	4.5	2.85	10	6	50	2	●
KGM-2BP-R1.5-M12	3.0	1.5	4.5	2.85	12	6	50	2	●
KGM-2BP-R1.5-M16	3.0	1.5	4.5	2.85	16	6	60	2	●
KGM-2BP-R1.5-M20	3.0	1.5	4.5	2.85	20	6	60	2	●
KGM-2BP-R2.0-M10	4.0	2.0	6.0	3.85	10	6	60	2	●
KGM-2BP-R2.0-M16	4.0	2.0	6.0	3.85	16	6	60	2	●
KGM-2BP-R2.0-M20	4.0	2.0	6.0	3.85	20	6	60	2	●
KGM-2BP-R2.0-M25	4.0	2.0	6.0	3.85	25	6	60	2	●
KGM-2BP-R2.5-M16	5.0	2.5	7.5	4.85	16	6	60	2	●
KGM-2BP-R2.5-M25	5.0	2.5	7.5	4.85	25	6	70	2	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

圆棒和立铣刀 / 硬质合金立铣刀

Solid Carbide Endmill

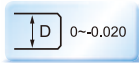
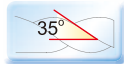
两刃直柄圆弧立铣刀

Two Flutes Corner Radius End Mill

KGM-2R



- 适用范围广泛，可实现多种形态的加工。
Wide range of applications



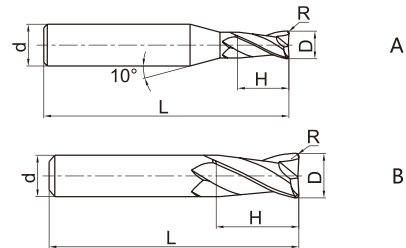
R型加工
R type processing



仿形加工
Profile Milling



R槽加工
R groove processing



规格 Specifications	基本尺寸 Dimensions (mm)					齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	R	d	H	L			
KGM-2R-D1.0R0.2	1.0	0.2	4	3	50	2	A	●
KGM-2R-D1.5R0.2	1.5	0.2	4	4	50	2	A	●
KGM-2R-D2.0R0.2	2.0	0.2	4	6	50	2	A	●
KGM-2R-D2.0R0.5	2.0	0.5	4	6	50	2	A	●
KGM-2R-D2.5R0.2	2.5	0.2	4	8	50	2	A	●
KGM-2R-D2.5R0.5	2.5	0.5	4	8	50	2	A	●
KGM-2R-D3.0R0.2	3.0	0.2	4	8	50	2	A	●
KGM-2R-D3.0R0.3	3.0	0.3	4	8	50	2	A	●
KGM-2R-D3.0R0.5	3.0	0.5	4	8	50	2	A	●
KGM-2R-D4.0R0.2	4.0	0.2	4	11	50	2	B	●
KGM-2R-D4.0R0.3	4.0	0.3	4	11	50	2	B	●
KGM-2R-D4.0R0.5	4.0	0.5	4	11	50	2	B	●
KGM-2R-D4.0R1.0	4.0	1.0	4	11	50	2	B	●
KGM-2R-D5.0R0.3	5.0	0.3	6	13	50	2	A	●
KGM-2R-D5.0R0.5	5.0	0.5	6	13	50	2	A	●
KGM-2R-D5.0R1.0	5.0	1.0	6	13	50	2	A	●
KGM-2R-D6.0R0.3	6.0	0.3	6	16	50	2	B	●
KGM-2R-D6.0R0.5	6.0	0.5	6	16	50	2	B	●
KGM-2R-D6.0R1.0	6.0	1.0	6	16	50	2	B	●
KGM-2R-D8.0R0.3	8.0	0.3	8	20	60	2	B	●
KGM-2R-D8.0R0.5	8.0	0.5	8	20	60	2	B	●
KGM-2R-D8.0R1.0	8.0	1.0	8	20	60	2	B	●
KGM-2R-D10.0R0.5	10.0	0.5	10	25	75	2	B	●
KGM-2R-D10.0R1.0	10.0	1.0	10	25	75	2	B	●
KGM-2R-D10.0R1.5	10.0	1.5	10	25	75	2	B	●
KGM-2R-D10.0R2.0	10.0	2.0	10	25	75	2	B	●
KGM-2R-D12.0R0.5	12.0	0.5	12	30	75	2	B	●
KGM-2R-D12.0R1.0	12.0	1.0	12	30	75	2	B	●
KGM-2R-D12.0R1.5	12.0	1.5	12	30	75	2	B	●
KGM-2R-D12.0R2.0	12.0	2.0	12	30	75	2	B	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

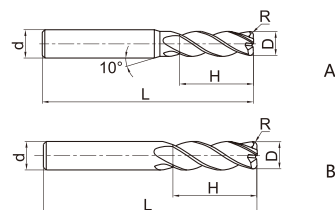
四刃直柄圆弧立铣刀

Four Flutes Corner Radius End Mill

KGM-4R



● 适用范围广泛，可实现多种形态的加工。
Wide range of applications



规格 Specifications	基本尺寸 Dimensions (mm)					齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	R	d	H	L			
KGM-4R-D3.0R0.2	3.0	0.2	4	8	50	4	A	●
KGM-4R-D4.0R0.3	4.0	0.3	4	10	50	4	B	●
KGM-4R-D4.0R0.5	4.0	0.5	4	10	50	4	B	●
KGM-4R-D5.0R0.5	5.0	0.5	6	13	50	4	A	●
KGM-4R-D5.0R1.0	5.0	1.0	6	13	50	4	A	●
KGM-4R-D6.0R0.5	6.0	0.5	6	16	50	4	B	●
KGM-4R-D6.0R1.0	6.0	1.0	6	16	50	4	B	●
KGM-4R-D8.0R0.5	8.0	0.5	8	20	60	4	B	●
KGM-4R-D8.0R1.0	8.0	1.0	8	20	60	4	B	●
KGM-4R-D10.0R0.5	10.0	0.5	10	25	75	4	B	●
KGM-4R-D10.0R1.0	10.0	1.0	10	25	75	4	B	●
KGM-4R-D10.0R2.0	10.0	2.0	10	25	75	4	B	●
KGM-4R-D10.0R3.0	10.0	3.0	10	25	75	4	B	●
KGM-4R-D12.0R0.5	12.0	0.5	12	30	75	4	B	●
KGM-4R-D12.0R1.0	12.0	1.0	12	30	75	4	B	●
KGM-4R-D12.0R2.0	12.0	2.0	12	30	75	4	B	●
KGM-4R-D12.0R3.0	12.0	3.0	12	30	75	4	B	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

圆棒和立铣刀 / 硬质合金立铣刀

Solid Carbide Endmill

四刃直柄长柄圆弧立铣刀

Four Flutes Long Shank Corner Radius End Mill

KGM-4RL



R型加工
R type processing



仿形加工
Profile Milling

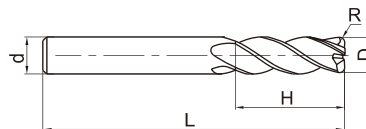
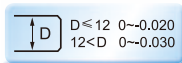


R槽加工
R grooving processing



● GM-4R的长柄系列。

GM-4R Long shank series



规格 Specifications	基本尺寸 Dimensions (mm)					齿数 Number of teeth Z	库存 Stock
	D	R	d	H	L		
KGM-4RL-D6.0R0.5	6.0	0.5	6	16	75	4	●
KGM-4RL-D6.0R1.0	6.0	1.0	6	16	75	4	●
KGM-4RL-D8.0R0.5	8.0	0.5	8	20	100	4	●
KGM-4RL-D8.0R1.0	8.0	1.0	8	20	100	4	●
KGM-4RL-D10.0R0.5	10.0	0.5	10	25	100	4	●
KGM-4RL-D10.0R1.0	10.0	1.0	10	25	100	4	●
KGM-4RL-D10.0R2.0	10.0	2.0	10	25	100	4	●
KGM-4RL-D12.0R0.5	12.0	0.5	12	30	100	4	●
KGM-4RL-D12.0R1.0	12.0	1.0	12	30	100	4	●
KGM-4RL-D12.0R2.0	12.0	2.0	12	30	100	4	●
KGM-4RL-D16.0R1.0	16.0	1.0	16	45	150	4	●
KGM-4RL-D16.0R2.0	16.0	2.0	16	45	150	4	●

● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

■ 被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
⊙	⊙	⊙	○			○	⊙				

四刃直柄平头波形刃立铣

Four Flutes Roughing End Mill

KGM-4W



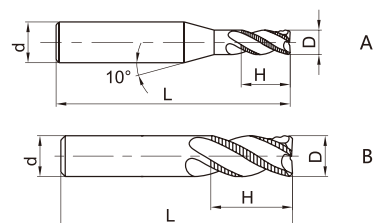
侧面加工
Side Milling



台阶加工
Profile Milling

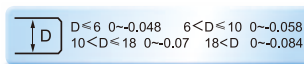
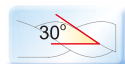


直角槽加工
Slutting



● 最适宜高效粗加工。

Suitable for roughing machining



规格 Specifications	基本尺寸Dimensions (mm)				齿数 Number of teeth Z	形式 Inserts Shape	库存 Stock
	D	d	H	L			
KGM-4W-D6.0	6.0	6	16	50	4	B	●
KGM-4W-D7.0	7.0	8	20	60	4	A	●
KGM-4W-D8.0	8.0	8	20	60	4	B	●
KGM-4W-D9.0	9.0	10	22	75	4	A	●
KGM-4W-D10.0	10.0	10	25	75	4	B	●
KGM-4W-D11.0	11.0	12	26	75	4	A	●
KGM-4W-D12.0	12.0	12	30	75	4	B	●
KGM-4W-D16.0	16.0	16	45	100	4	B	●
KGM-4W-D20.0	20.0	20	45	100	4	B	●

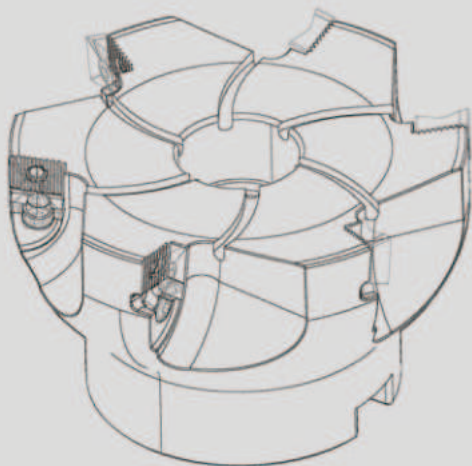
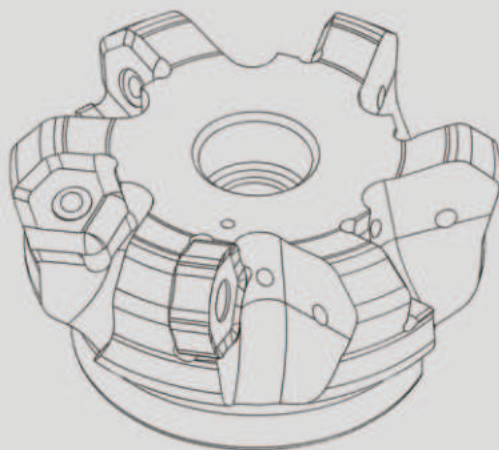
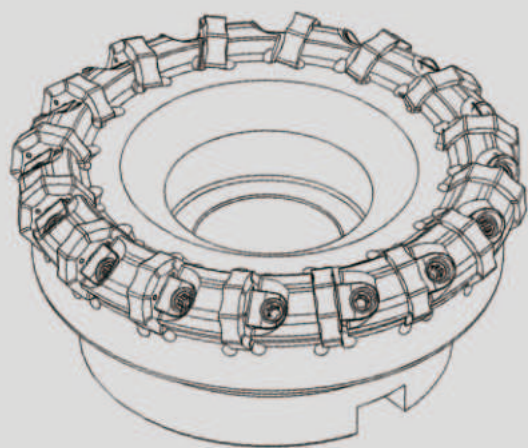
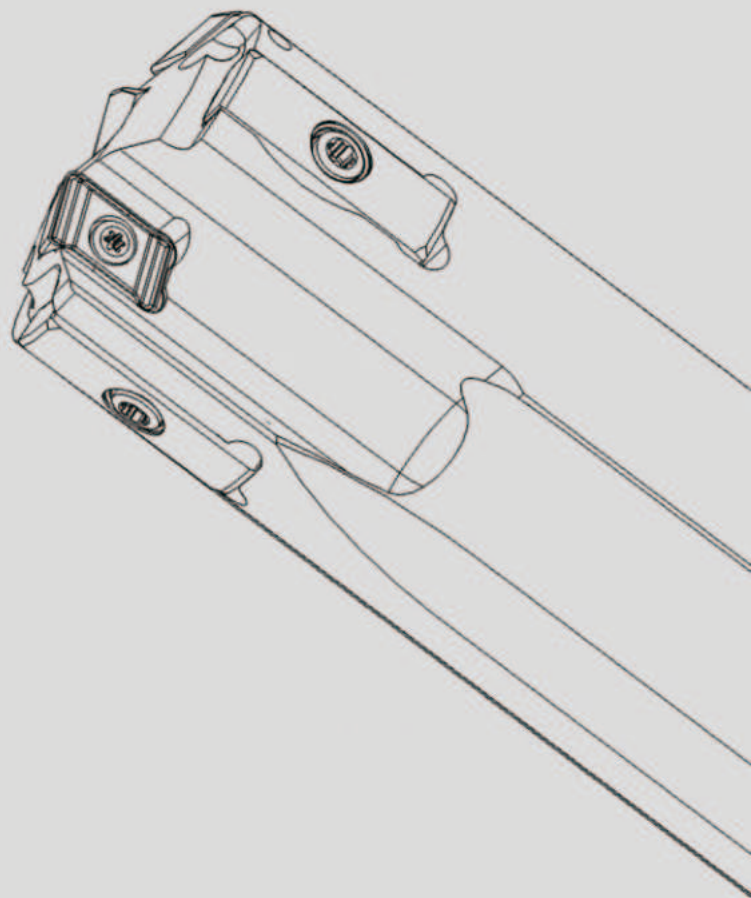
● 推荐型号 Recommended type ○ 按订单生产 Make-to-order

被加工材料适用表 Applicable materials for processing ○ 非常适合 Very suitable ○ 适合 Suitable

被加工材料 Processed Materials											
碳素钢 Carbon steel	合金钢 Alloy steel	预硬钢、淬硬钢 Pre-hardened steel Hardened steel				不锈钢 Stainless steel	铸铁 Cast iron 球墨铸铁 Ductile iron	铜合金 Copper alloy	铝合金 Aluminum alloy	钛合金 Titanium alloy	耐热合金 Heat-resistant alloy
		~40HRC	~50HRC	~55HRC	~68HRC						
○	○	○	○			○	○				

刀杆和刀盘

HOLDER AND CUTTER



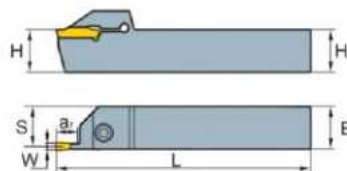


刀杆和刀盘

Holder and Cutter

车削刀具 Turning Tools	001
可转位铣削刀具 Indexable Milling Tools	002

车削刀具 Turning Tools



型号 Type		尺寸 Dimensions(mm)					适装刀片 Applicable Inserts
		H*B	L	S	W	ar _{max}	
QEFD	1616R/L10	16*16	125	14.8	3	10	GPMN3004K-M GPMN3004K-G
	1616R/L17	16*16	125	14.8	3	17	
	2020R/L10	20*20	125	18.8	3	10	
	2020R/L17	20*20	125	18.8	3	17	
	2525R/L10	25*25	150	23.8	3	10	
	2525R/L17	25*25	150	23.8	3	17	
QEGD	2020R/L13	20*20	140	18.5	4	13	GPMN4004K-M GPMN4004K-G
	2020R/L22	20*20	140	18.5	4	22	
	2525R/L13	25*25	150	23.5	4	13	
	2525R/L22	25*25	150	23.5	4	22	
	3232R/L13	32*32	170	30.5	4	13	
	3232R/L22	32*32	170	30.5	4	22	
QEHD	2525R/L13	25*25	150	23	5	13	GPMN5005K-M GPMN5008K-G
	2525R/L22	25*25	150	23	5	22	
QEHS	2525N30	25*25	150	12.5	5	30	Z□HS05□□
QEHD	3232R/L13	32*32	170	30	5	13	GPMN50058K-M GPMN5008K-G
	3232R/L22	32*32	170	30	5	22	
QEHS	3232N30	32*32	170	16	5	30	GPMN50058K-M GPMN5008K-G

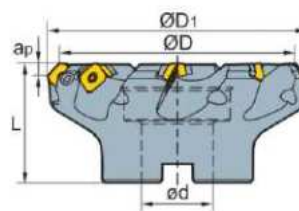
可转位铣削刀具 Indexable Milling Tools

MXA01 P M K N S



密齿等齿距

Fixed Pitch Space



型号 Type		尺寸 Dimensions(mm)					齿数 Number of teeth Z	适装刀片 Applicable Inserts
		ΦD	ΦD ₁	Φd	L	ar _{max}		
MXA01	-050-A22-SE12-04	50	61	22	40	6	4	SEET12T3-□□
	-063-A22-SE12-05	63	74	22	40	6	5	
	-080-A27-SE12-06	80	91	27	50	6	6	
	-100-B32-SE12-07	100	107	32	50	6	7	
	-125-B40-SE12-08	125	136	40	63	6	8	
	-160-B40-SE12-10	160	170	40	63	6	10	
	-200-C60-SE12-12	200	210	60	63	6	12	
	-250-C60-SE12-14	250	260	60	63	6	14	
	-315-D60-SE12-18	315	325	60	70	6	18	

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

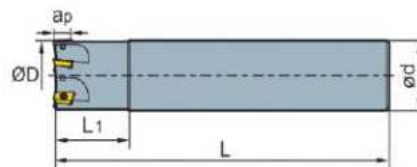
H 刀杆和刀盘

I 加工案例

J 通用技术信息

可转位铣削刀具 Indexable Milling Tools

FJP01 P M K N



型号 Type		尺寸 Dimensions(mm)					齿数 Number of teeth Z	适装刀片 Applicable Inserts
		ΦD	Φd	L	L1	ap _{max}		
FJP01	-012-G16-AP11-01	12	16	85	25	10.5	2	APMT1135□□□□-□M
	-016-G16-AP11-02	16	16	90	25	10.5	2	
	-020-G20-AP11-02	20	20	100	30	10.5	2	
	-025-G25-AP11-03	25	25	115	35	10.5	3	
	-032-G32-AP11-04	32	32	125	40	10.5	4	
	-025-G25-AP16-02	25	25	115	35	15.5	2	APMT1604□□□□-□M
	-032-G32-AP16-03	32	32	125	40	15.5	3	
	-040-G32-AP16-04	40	32	130	42	15.5	4	
	-050-G32-AP16-05	50	32	135	45	15.5	5	
	-063-G32-AP16-06	63	32	135	45	15.5	6	

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

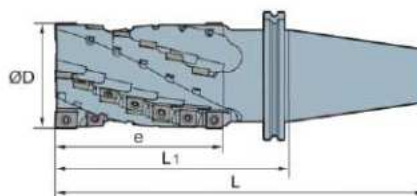
H 刀杆和刀盘

I 加工案例

J 通用技术信息

可转位铣削刀具 Indexable Milling Tools

LXP01 P K



型号 Type		尺寸 Dimensions(mm)				齿数 Number of teeth Z	适装刀片 Applicable Inserts
		ΦD	e	L1	ap _{max}		
LXP01	-050*84-JT50-SP12-04	50	84	145	246.75	4	APKT150412K-BM SPMT120408K-BM
	-063*74-JT50-SP12-04	63	74	135	236.75	4	
	-063*104-JT50-SP12-04	63	104	165	266.75	4	
	-063*134-JT50-SP12-04	63	134	195	296.75	4	
	-080*104-JT50-SP12-04	80	104	165	266.75	4	
	-080*144-JT50-SP12-04	80	144	205	306.75	4	
	-050*84-BT50-SP12-04	50	84	145	246.8	4	
	-063*74-BT50-SP12-04	63	74	135	236.8	4	
	-063*104-BT50-SP12-04	63	104	165	266.8	4	
	-063*134-BT50-SP12-04	63	134	195	296.8	4	
	-080*104-BT50-SP12-04	80	104	165	266.8	4	
	-080*144-BT50-SP12-04	80	144	205	306.8	4	

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

轨道交通解决方案

SOLUTION FOR RAILWAY APPLICATION





加工案例

Application Cases

钢件加工案例	Steel Processing Application Cases	001
不锈钢加工案例	Stainless Steel Processing Application Cases	002
铸铁加工案例	Cast Iron Processing Application Cases	003
铣削加工案例	Milling Processing Application Cases	005
耐热合金加工案例	Heat-resistant Alloy Processing Cases	007

钢件加工案例 Steel Processing Application Cases

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

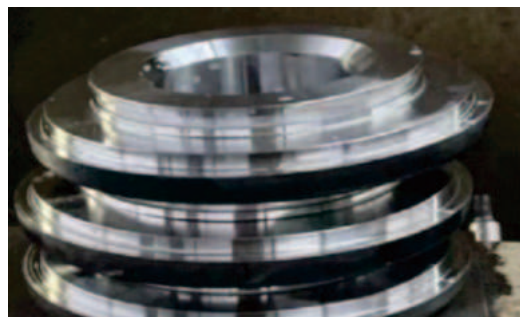
F 非标异形刀片

G 圆棒和立铣刀

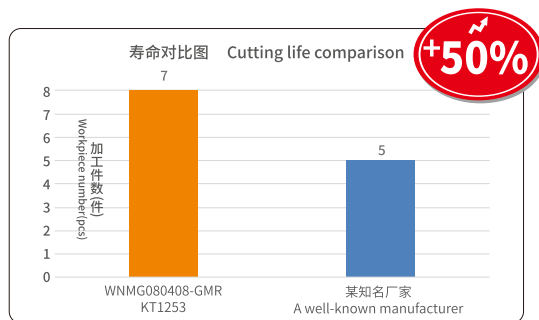
H 刀杆和刀盘

I 加工案例

J 通用技术信息



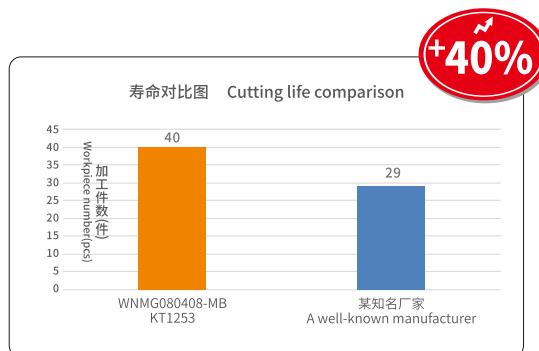
客户名称:****机械制造有限公司
工件名称:端盖
被加工材料:42CrMo
加工设备:数控车床
使用刀片:WNMG080408-GMR/KT1253
对比刀片:国外某知名厂家
冷却方式:冷却液
加工内容:粗车外圆
加工参数: $V_c=200\text{m/min}$, $F_n=0.24\text{mm/r}$, $A_p=1.3\text{mm}$



Customer: ***Machinery Manufacturing Co., Ltd
Work piece: End bracket
Work piece material: 42CrMo
Lathe type: CNC lathe
Kerno insert: WNMG080408-GMR/KT1253
Compare insert: Well-known foreign brand
Cooling type: Cooling liquid
Processing content: External roughing turning
Cutting parameters: $V_c=200\text{m/min}$, $F_n=0.24\text{mm/r}$, $A_p=1.3\text{mm}$

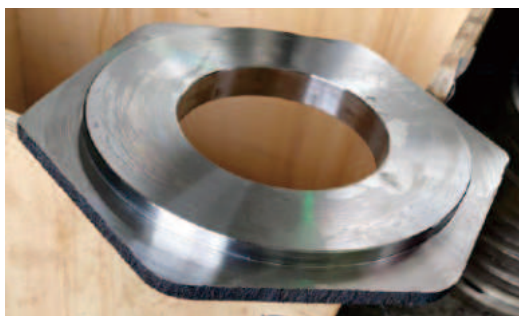


客户名称:****制造有限公司
工件名称:球笼
被加工材料:钢件
加工设备:数控车床
使用刀片:WNMG080408-MB/KT1253
对比刀片:国内某知名厂家
冷却方式:冷却液
加工内容:粗车(断续)
加工参数: $V_c=120\text{m/min}$, $F_n=0.14\text{mm/r}$, $A_p=1.2\text{mm}$

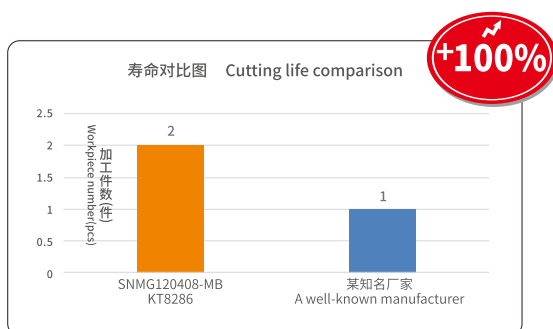


Customer: ****Machinery Manufacturing Co., Ltd
Work piece: Ball cage
Work piece material: Steel
Lathe type: CNC lathe
Kerno insert: WNMG080408-MB/KT1253
Compare insert: Well-known domestic brand
Cooling type: Cooling liquid
Processing content: Roughing turning (interrupted cutting)
Cutting parameters: $V_c=120\text{m/min}$, $F_n=0.14\text{mm/r}$, $A_p=1.2\text{mm}$

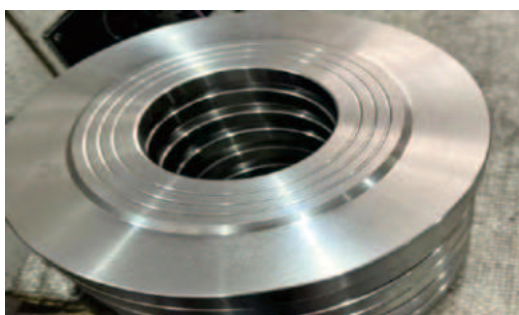
不锈钢加工案例 Stainless Steel Processing Application Cases



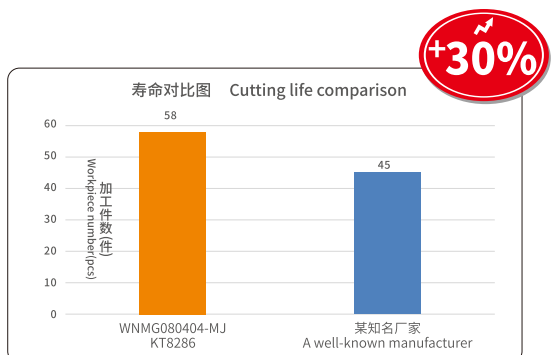
客户名称:****法兰制造有限公司
 工件名称:法兰
 被加工材料:不锈钢304
 加工设备:数控车床
 使用刀片:SNMG120408-MB/KT8286
 对比刀片:国内某知名厂家
 冷却方式:冷却液
 加工内容:粗车(断续)
 加工参数: $V_c=135\text{m/min}$, $F_n=0.12\text{mm/r}$, $A_p=1.5\text{mm}$



Customer: *** Flange Manufacturing Co., Ltd
 Work piece: Flange
 Work piece material: Stainless steel 304
 Lathe type: CNC lathe
 Kerno insert: SNMG120408-MB/KT8286
 Compare insert: Well-known domestic brand
 Cooling type: Cooling liquid
 Processing content: Roughing turning (interrupted cutting)
 Cutting parameters: $V_c=135\text{m/min}$, $F_n=0.12\text{mm/r}$, $A_p=1.5\text{mm}$



客户名称:****法兰制造有限公司
 工件名称:法兰
 被加工材料:不锈钢304
 加工设备:数控车床
 使用刀片:WNMG080404-MJ/KT8286
 对比刀片:国内某知名厂家
 冷却方式:冷却液
 加工内容:精车
 加工参数: $V_c=185\text{m/min}$, $F_n=0.1\text{mm/r}$, $A_p=0.5\text{mm}$



Customer: *** Flange Manufacturing Co., Ltd
 Work piece: Flange
 Work piece material: Stainless steel 304
 Lathe type: CNC lathe
 Kerno insert: WNMG080404-MJ/KT8286
 Compare insert: Well-known domestic brand
 Cooling type: Cooling liquid
 Processing content: Finishing turning
 Cutting parameters: $V_c=185\text{m/min}$, $F_n=0.1\text{mm/r}$, $A_p=0.5\text{mm}$

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

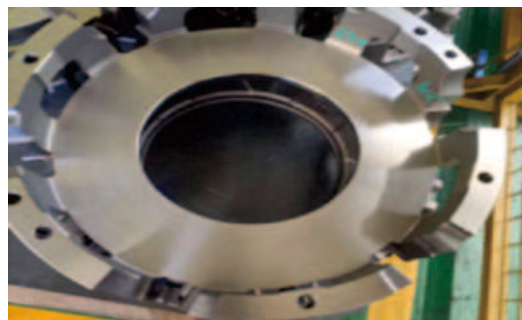
G 圆棒和立铣刀

H 刀杆和刀盘

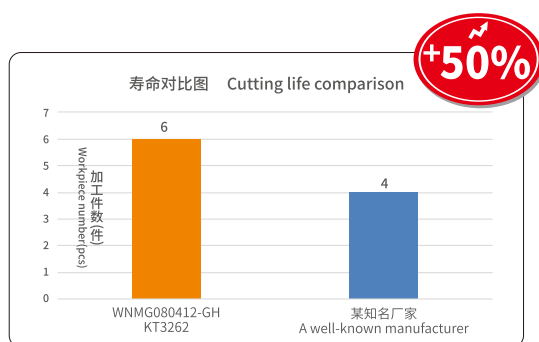
I 加工案例

J 通用技术信息

铸铁加工案例 Cast Iron Processing Application Cases



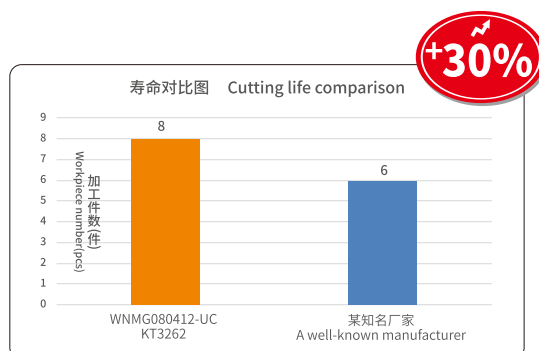
客户名称: 苏州****制造有限公司
 工件名称: 离合器壳体
 被加工材料: HT250
 加工设备: 数控车床
 使用刀片: WNMG080412-GH/KT3262
 对比刀片: 国外某知名厂家
 冷却方式: 冷却液
 加工内容: 粗车
 加工参数: $V_c=320\text{m/min}$, $F_n=0.25\text{mm/r}$, $A_p=1.5\text{mm}$



Customer: Suzhou **** Manufacturing Co., Ltd
 Work piece: Clutch housing
 Work piece material: HT250
 Lathe type: CNC lathe
 Kerno insert: WNMG080412-GH/KT3262
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Roughing turning
 Cutting parameters:
 $V_c=320\text{m/min}$, $F_n=0.25\text{mm/r}$, $A_p=1.5\text{mm}$



客户名称: 昆山**机械有限公司
 工件名称: 飞轮壳
 被加工材料: QT700
 加工设备: 数控车床
 使用刀片: WNMG080412-UC/KT3262
 对比刀片: 国内某知名厂家
 冷却方式: 冷却液
 加工内容: 粗车
 加工参数: $V_c=216\text{m/min}$, $F_n=0.35\text{mm/r}$, $A_p=2-3\text{mm}$



Customer: Kunshan ** Machinery Co., Ltd
 Work piece: Flywheel housing
 Work piece material: QT700
 Lathe type: CNC lathe
 Kerno insert: WNMG080412-UC/KT3262
 Compare insert: Well-known domestic brand
 Cooling type: Cooling liquid
 Processing content: Roughing turning
 Cutting parameters:
 $V_c=216\text{m/min}$, $F_n=0.35\text{mm/r}$, $A_p=2-3\text{mm}$

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

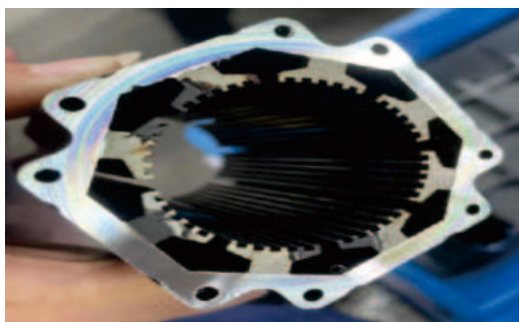
G 圆棒和立铣刀

H 刀杆和刀盘

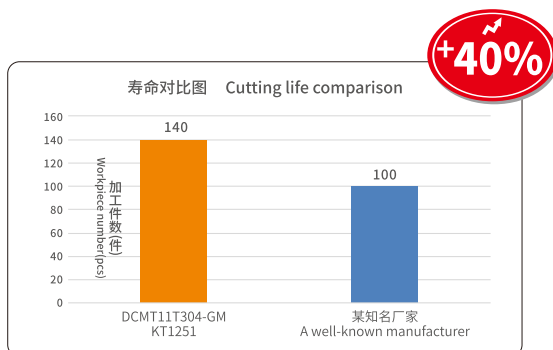
I 加工案例

J 通用技术信息

铸铁加工案例 Cast Iron Processing Application Cases



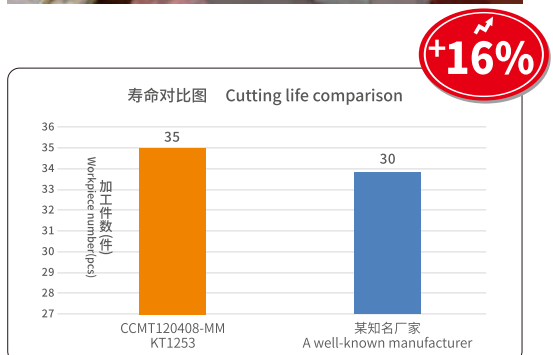
客户名称:常州**电机有限公司
 工件名称:电机壳
 被加工材料:夕钢片
 加工设备:数控车床
 使用刀片:DCMT11T304-GM/KT1251
 对比刀片:国外某知名厂家
 冷却方式:冷却液
 加工内容:精车
 加工参数: $V_c=320\text{m/min}$, $F_n=0.1\text{mm/r}$, $A_p=0.3\text{mm}$



Customer: Changzhou ** Motor Co., Ltd
 Work piece: Motor housing
 Work piece material: Silicon steel sheet
 Lathe type: CNC lathe
 Kerno insert: DCMT11T304-GM/KT1251
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Finishing turning
 Cutting parameters:
 $V_c=320\text{m/min}$, $F_n=0.1\text{mm/r}$, $A_p=0.3\text{mm}$



客户名称:**重工有限公司
 工件名称:箱体
 被加工材料:Q345
 加工设备:数控车床
 使用刀片:CCMT120408-MM/KT1253
 对比刀片:国外某知名厂家
 冷却方式:冷却液
 加工内容:粗镗
 加工参数: $V_c=100\text{m/min}$, $F_n=0.2\text{mm/r}$, $A_p=2.5\text{mm}$



Customer: **Heavy Industry Co., Ltd
 Work piece: Box
 Work piece material: Q345
 Lathe type: CNC lathe
 Kerno insert: CCMT120408-MM/KT1253
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Roughing boring
 Cutting parameters:
 $V_c=100\text{m/min}$, $F_n=0.2\text{mm/r}$, $A_p=2.5\text{mm}$

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

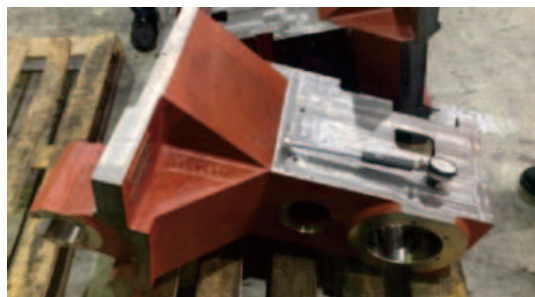
G 圆棒和立铣刀

H 刀杆和刀盘

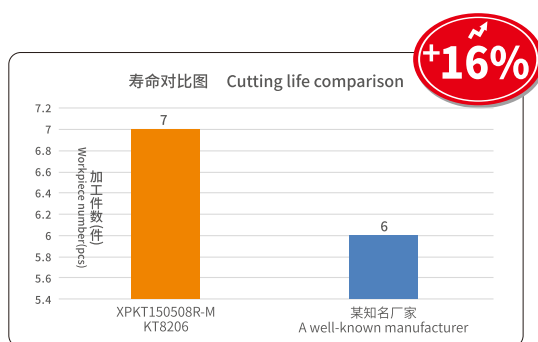
I 加工案例

J 通用技术信息

铣削加工案例 Milling Processing Application Cases



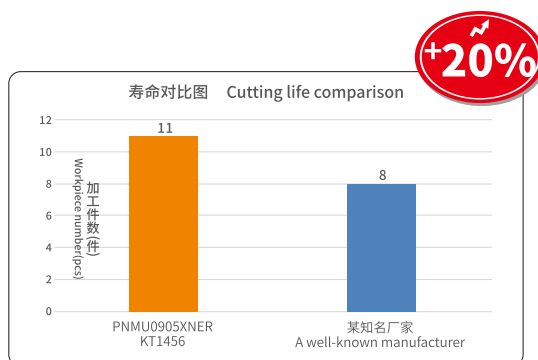
客户名称: 昆山**机械有限公司
 工件名称: 头部
 被加工材料: FC30
 加工设备: 加工中心
 使用刀片: XPEX150508R-M/KT8206
 对比刀片: 国外某知名厂家
 冷却方式: 冷却液
 加工内容: 粗铣端面
 加工参数: $V_c=125\text{m/min}$, $F_z=0.15\text{mm/r}$, $A_p=2.5\text{mm}$



Customer: Kunshan ** Machinery Co., Ltd
 Work piece: The head
 Work piece material: FC30
 Lathe type: Machining center
 Kerno insert: XPEX150508R-M/KT8206
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Roughing milling end face
 Cutting parameters:
 $V_c=125\text{m/min}$, $F_z=0.15\text{mm/r}$, $A_p=2.5\text{mm}$



客户名称: 江苏**制造有限公司
 工件名称: 涡轮壳
 被加工材料: 钢1.4837
 加工设备: 加工中心
 使用刀片: PNMU0905XNER/KT1456
 对比刀片: 国外某知名厂家
 冷却方式: 冷却液
 加工内容: 粗铣端面
 加工参数: $V_c=85\text{m/min}$, $F_z=0.18\text{mm/r}$, $A_p=2.5-3\text{mm}$



Customer: Jiangsu ** Manufacturing Co., Ltd
 Work piece: Turbine housing
 Work piece material: Steel 1.4837
 Lathe type: Machining center
 Kerno insert: PNMU0905XNER/KT1456
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Roughing milling end face
 Cutting parameters:
 $V_c=85\text{m/min}$, $F_z=0.18\text{mm/r}$, $A_p=2.5-3\text{mm}$

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

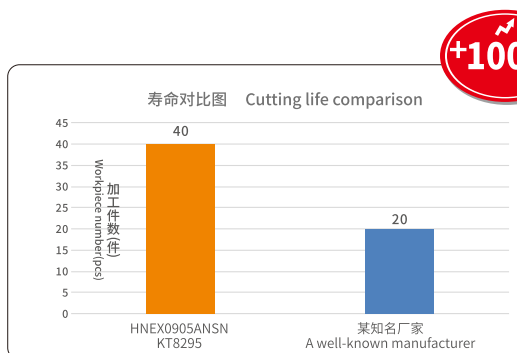
I 加工案例

J 通用技术信息

铣削加工案例 Milling Processing Application Cases



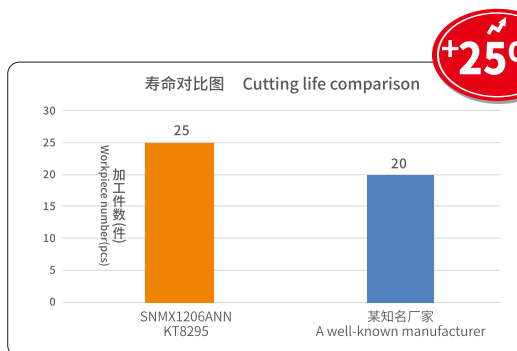
客户名称: 常州**机械有限公司
 工件名称: 电梯板
 被加工材料: Q345B
 加工设备: 加工中心
 使用刀片: HNEX0905ANSN/KT8295
 对比刀片: 国外某知名厂家
 冷却方式: 冷却液
 加工内容: 粗铣端面
 加工参数: $V_c=300\text{m/min}$, $F_z=0.42\text{mm/r}$, $A_p=0.7\text{mm}$



Customer: Changzhou ** Machinery Co., Ltd
 Work piece: Elevator board
 Work piece material: Q345B
 Lathe type: Machining center
 Kerno insert: HNEX0905ANSN/KT8295
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Roughing milling end face
 Cutting parameters:
 $V_c=300\text{m/min}$, $F_z=0.42\text{mm/r}$, $A_p=0.7\text{mm}$



客户名称: 杭州**有限公司
 工件名称: 电磁铁
 被加工材料: A3
 加工设备: 加工中心
 使用刀片: HNEX0905ANSN/KT8295
 对比刀片: 国内某知名厂家
 冷却方式: 冷却液
 加工内容: 铣面
 加工参数: $V_c=180\text{m/min}$, $F_z=0.0.15\text{mm/r}$, $A_p=0.3\text{mm}$



Customer: Hangzhou ** Co., Ltd
 Work piece: Electromagnet
 Work piece material: A3
 Lathe type: Machining center
 Kerno insert: HNEX0905ANSN/KT8295
 Compare insert: Well-known domestic brand
 Cooling type: Cooling liquid
 Processing content: Milling
 Cutting parameters:
 $V_c=180\text{m/min}$, $F_z=0.0.15\text{mm/r}$, $A_p=0.3\text{mm}$

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

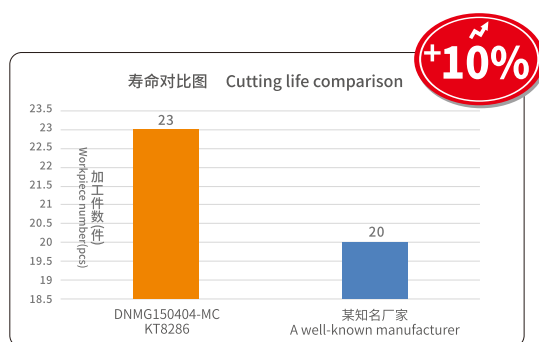
J 通用技术信息

耐热合金加工案例

Heat-resistant Alloy Processing Cases



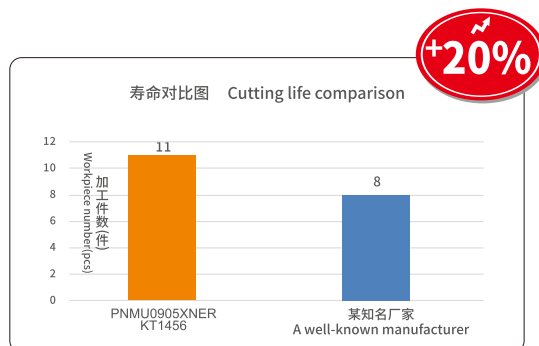
客户名称: 江苏**制造有限公司
 工件名称: 涡轮壳
 被加工材料: 钢1.4837
 加工设备: 加工中心
 使用刀片: DNMG150404/KT8286
 对比刀片: 国外某知名厂家
 冷却方式: 冷却液
 加工内容: 精铣内孔
 加工参数: $V_c=86\text{m/min}$, $F_z=0.12\text{mm/r}$, $A_p=0.5\text{mm}$



Customer: Jiangsu ** Manufacturing Co., Ltd
 Work piece: Turbine housing
 Work piece material: Steel 1.4837
 Lathe type: Machining center
 Kerno insert: DNMG150404/KT8286
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Inner hole finishing milling
 Cutting parameters:
 $V_c=86\text{m/min}$, $F_z=0.12\text{mm/r}$, $A_p=0.5\text{mm}$



客户名称: 江苏**制造有限公司
 工件名称: 涡轮壳
 被加工材料: 钢1.4837
 加工设备: 加工中心
 使用刀片: PNMU0905XNER/KT1456
 对比刀片: 国外某知名厂家
 冷却方式: 冷却液
 加工内容: 粗铣端面
 加工参数: $V_c=85\text{m/min}$, $F_z=0.18\text{mm/r}$, $A_p=2.5-3\text{mm}$



Customer: Jiangsu ** Manufacturing Co., Ltd
 Work piece: Turbine housing
 Work piece material: Steel 1.4837
 Lathe type: Machining center
 Kerno insert: PNMU0905XNER/KT1456
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Roughing milling end face
 Cutting parameters:
 $V_c=85\text{m/min}$, $F_z=0.18\text{mm/r}$, $A_p=2.5-3\text{mm}$

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

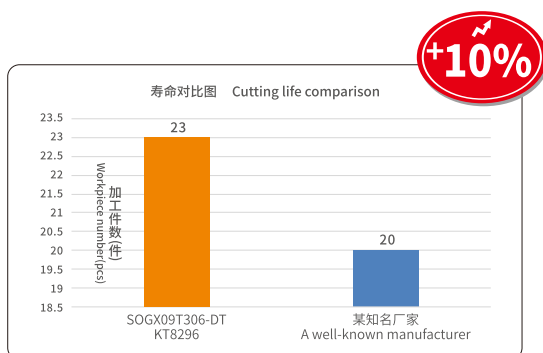
I 加工案例

J 通用技术信息

耐热合金加工案例 Heat-resistant Alloy Processing Cases



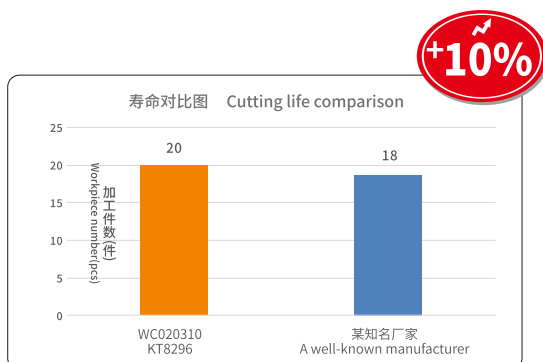
客户名称: 江苏**制造有限公司
 工件名称: 涡轮壳
 被加工材料: 钢1.4837
 加工设备: 加工中心
 使用刀片: SOGX09T306-DT/KT8296
 对比刀片: 国外某知名厂家
 冷却方式: 冷却液
 加工内容: 粗铣内孔
 加工参数: $V_c=40\text{m/min}$, $F_z=0.08\text{mm/r}$, $A_p=1.5\text{mm}$



Customer: Jiangsu ** Manufacturing Co., Ltd
 Work piece: Turbine housing
 Work piece material: Steel 1.4837
 Lathe type: Machining center
 Kerno insert: SOGX09T306-DT/KT8296
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Inner hole roughing milling
 Cutting parameters:
 $V_c=40\text{m/min}$, $F_z=0.08\text{mm/r}$, $A_p=1.5\text{mm}$



客户名称: 江苏**制造有限公司
 工件名称: 涡轮壳
 被加工材料: 钢1.4837
 加工设备: 加工中心
 使用刀片: WC020310/KT8296
 对比刀片: 国外某知名厂家
 冷却方式: 冷却液
 加工内容: 精铣内孔
 加工参数: $V_c=219\text{m/min}$, $F_z=0.05\text{mm/r}$, $A_p=0.2\text{mm}$



Customer: Jiangsu ** Manufacturing Co., Ltd
 Work piece: Turbine housing
 Work piece material: Steel 1.4837
 Lathe type: Machining center
 Kerno insert: WC020310/KT8296
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Inner hole finishing milling
 Cutting parameters:
 $V_c=219\text{m/min}$, $F_z=0.05\text{mm/r}$, $A_p=0.2\text{mm}$

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

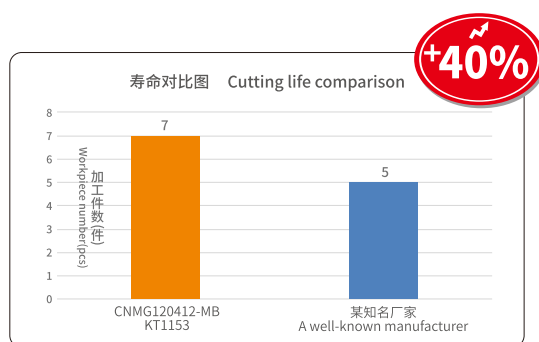
I 加工案例

J 通用技术信息

耐热合金加工案例 Heat-resistant Alloy Processing Cases



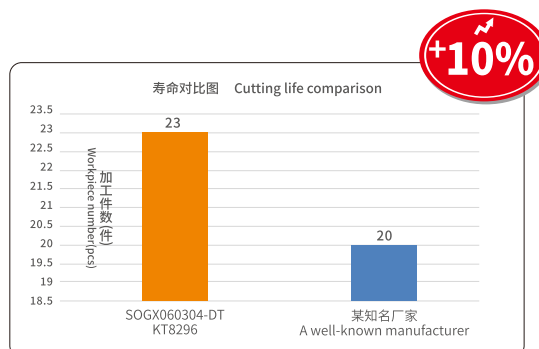
客户名称: 江苏**制造有限公司
 工件名称: 涡轮壳
 被加工材料: 钢1.4837
 加工设备: 加工中心
 使用刀片: CNMG120412-MB/KT1153
 对比刀片: 国外某知名厂家
 冷却方式: 冷却液
 加工内容: 粗铣内孔
 加工参数: $V_c=68\text{m/min}$, $F_z=0.2\text{mm/r}$, $A_p=1.3\text{mm}$



Customer: Jiangsu ** Manufacturing Co., Ltd
 Work piece: Turbine housing
 Work piece material: Steel 1.4837
 Lathe type: Machining center
 Kerno insert: CNMG120412-MB/KT1153
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Inner hole roughing milling
 Cutting parameters:
 $V_c=68\text{m/min}$, $F_z=0.2\text{mm/r}$, $A_p=1.3\text{mm}$



客户名称: 江苏**制造有限公司
 工件名称: 涡轮壳
 被加工材料: 钢1.4837
 加工设备: 加工中心
 使用刀片: SOGX060304-DT/KT8296
 对比刀片: 国外某知名厂家
 冷却方式: 冷却液
 加工内容: 精铣内孔
 加工参数: $V_c=81\text{m/min}$, $F_z=0.05\text{mm/r}$, $A_p=0.2\text{mm}$



Customer: Jiangsu ** Manufacturing Co., Ltd
 Work piece: Turbine housing
 Work piece material: Steel 1.4837
 Lathe type: Machining center
 Kerno insert: SOGX060304-DT/KT8296
 Compare insert: Well-known foreign brand
 Cooling type: Cooling liquid
 Processing content: Inner hole finishing milling
 Cutting parameters:
 $V_c=81\text{m/min}$, $F_z=0.05\text{mm/r}$, $A_p=0.2\text{mm}$

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

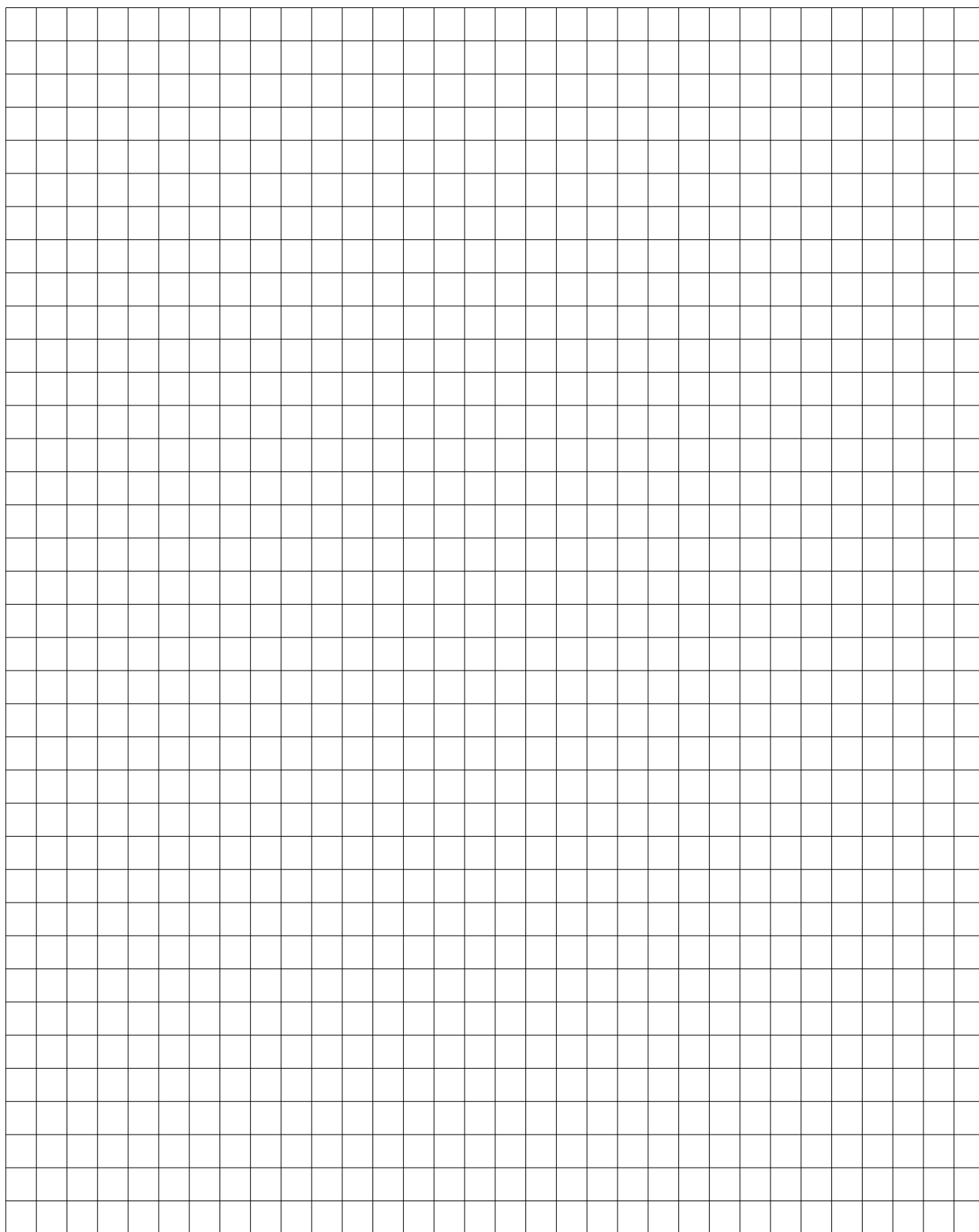
F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息


A
 车削刀片

B
 铣削刀片

C
 铝合金刀片

D
 孔加工刀片

E
 刮管刀片

F
 非标异形刀片

G
 圆棒和立铣刀

H
 刀杆和刀盘

I
 加工案例

J
 通用技术信息



GENERAL TECHNICAL INFORMATION

通用技术信息



通用技术信息

General Technical Information

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The Effect of Three Key Elements on Machining		006
孔加工孔常见问题及解决办法		
Common Problems and Solutions for Drilling		008
材料硬度与切削速度的修正系数表		
The Correction Coefficient Table of Hardness and Cutting Speed		011
材料对照表	Material Comparison	012
硬度对照表	Hardness Comparison	018

通用技术信息 / 牌号对照表

Grade Comparison Table

牌号对照表 Grade Comparison Table

CVD 涂层材料 CVD Coating

APPLICATION	ISO CODE		KLT	ZCC. CT	SANDVIK	WALTER	KENNAMETAL	SECO	ISCAR	MITSUBISHI	KYOCERA	TUNGALOY	TAEGUTEC	KORLOY
Turning	P	P10	KP015	YBC151 YBC152	GC4015 GC4215	WAP10	KC9110	TP1000	IC9150 IC9015	UE6105 MC6015	CA510 CA5505	T9105 T9005	TT1300	NC3010
		P20	KP025	YBC251 YBC252 YBC201	GC4025 GC4225	WAP20	KC9125	TP2000	IC9250 IC9025	MC6015 UE6110	CA515 CA5515	T9115 T9125	TT8125 TT1500	NC3215 NC3225
		P30	KP035	YBC351 YBC352 YBC301	GC4035 GC4235 GC4030	WAP30	KC8050	TP3000	IC9350 IC656	MC6025 UE6020	CA525 CA5525	T9035 T9135	TT3500 TT5100	NC3030
		P40	KT1401	YBC401	GC4035 GC235		KC9140 KC9040	TP400 TP3000	IC635	UE6035 UH6400	CA5535	T9035	TT450	
	M	M10		YBM151	GC2015	WAM10	KU10 K313	TM2000	IC9250 IC6015	MC7015 US7020	CA6515	T9015		
		M20	KT2252	YBM251 YBM253	GC5025	WAM20	KC9225	TM2000	IC9250 IC9025	MC7015 US7025	CA6515 CA6525	T9125 T6020	TT2500	NC9020
		M30	KT2302	YBM351 YBM353	GC2035 GC235	WAM30	KC8050	TM4000	IC9350 IC6025	MC7025	CA6525	T6030	TT3500	NC9025
		M40	KT3221	YBM40			KC9240	TM4000	IC6025 IC9350	US735			TT5100	
	K	K01	KT3122	YBD051 YBD052	GC3205 GC3210		KCK05	TH1500 TK1000	IC5005 IC9007	UC5105 MC5005	CA4505 CA4010	T5105		NC6205
		K10	KT3262	YBD151 YBD152	GC3205 GC3215	WAK10	KCK15 KCK20	TK1001 TK2000	IC5005 IC9150	MC5015 UC5115	CA4515 CA4115	T5115	TT1300	NC6210 NC6215
		K20	KT3263	YBD252	GC3215	WAK20	KCK20 KC9325	TK2000 TK2001	IC5010 IC8150	UC5115 UR6110	CA4515 CA4120	T5115 T5125	TT1500	NC6210 NC6215
	Milling	P	P10						MP1500	IC9080				
P20			KT2252	YBM253	GC4220	WAP25		MP1500 MP2500	IC5100	F7030		T3130		NC5340
P30			KT2302	YBM353	GC4230	WAP35	KCPK30	MP2500	IC4050	F7030		T3030	TT7300	NC5350 NC5340
P40					GC4240		KC935M							
M		M10					TN25M		IC9250					NC5330
		M20	KT2252	YBM253	GC2040		KC925M	MP2500	IC9350	F7030	CA6535	T3130		NC5340 NC5350
		M30	KT2302	YBM353		WTP35	KC930M	MP2500	IC9350	F7030	CA6535	T3130		
K		K10	KT3262	YBD152		WAK15				MC5020		T1115		NC5330
		K20	KT3262	YBD252	GC3220	WAK25	KC915M	MK2000	IC5100	MC5020		T1115		NC5340 NC5350
		K30	KT3252		GC3330		KC920M	MK3000	IC4050					

牌号对照表 Grade Comparison Table
PVD 涂层材料 PVD Coating

APPLICATION	ISO CODE	KLT	ZCC. CT	SANDVIK	WALTER	KENNAMETAL	SECO	ISCAR	MITSUBISHI	KYOCERA	TUNGALOY	TAEGUTEC	KORLOY	
Turning	P	P10		YBG102		KC5010 KC5510	CP200	IC507	VP10MF	PR915 PR930	AH710			
		P20	KT8206	YBG201 YBG202 YBG205	GC1020 GC1025		KC5025	CP250	IC908	VP15TF VP20MF	PR630 PR915	AH710 AH330	TT9030 TT9080	PC8110
		P30	KT8286	YBG201 YBG202 YBG205	GC1025 GC4125		K7010	CP500	IC928	VP15TF VP20MF	PR630 PR660	AH330 AH740	TT9030 TT9080	PC5300 PC8115
		P40	KT8326	YBG302	GC1020 GC2145		K7030	CP500	IC928 IC1008	VP15TF VP20MF	PR660	AH120		
	M	M10	KS05	YBG102			KC5010 KC5510	CP200	IC507	VP10MF	PR915 PR930	AH710		
		M20	KT8287N	YBG201 YBG205	GC1020 GC1025		KC5025 KC5525	CP250	IC908	VP15TF VP20MF	PR630 PR915	AH710 AH330	TT9030 TT9080	PC8115 PC9030
		M30	KT8326	YBG302	GC1020 GC2145		KC5025 KC5525	CP500	IC928 IC1008	VP15TF VP20MF	PR630 PR660	AH120	TT9080	PC9030 PC5400
		M40			GC2145						PR660			
	K	K10	KT3126	YBG102			KC5010 KC5510	CP200	IC507	VP10MF	PR915	AH110		
		K20	KT8286	YBG201 YBG205	GC1020		KC7015	CP250	IC908	VP15TF	PR915	AH120	TT9030 TT9080	PC5300 PC9030
		K30			GC4125		KC7225	CP500		VP15TF				
	S	S10	KS05				KC5010 KC5510	CP200				GH110 AH110		PC8105
		S20	KS10		GC1020		KC7015	CP250	IC928 IC1008	VP15TF		AH120	TT9080	PC8115 PC5400
		S30	KS20		GC4125		KC7225	CP500	IC928 IC908	VP15TF				
Milling	P	P10			GC1025	WXH15 WXM15	KC715M		IC903 IC950		PR830 PR730		PC2025 PC2010	
		P20	KT8296 KT8298	YBG202 YBG205	GC1025	WXM25	KC522M KC525M	F25M	IC928 IC900	VP15TF	PR630 PR730	GH330	TT7080 TT9030	PC3500
		P30	KT8326	YBG302	GC1030	WXM35	KC725M KC735M	F25M F30M	IC928	VP30RT VP15TF	PR630 PR730	AH330 AH120	TT7080 TT9030	PC3500 PC5300
	M	M10	KT8206		GC1025	WXM15	KC715M				PR630 PR730			
		M20	KT8296 KT8298	YBG202 YBG205	GC2030		KC522M KC525M	F25M	IC928 IC908	VP20RT VP15TF	PR630 PR730	GH330	TT7030 TT9030	PC3530
		M30	KT8326	YBG302	GC2030	WXM35	KC725M KC735M	F25M F30M	IC928	VP30RT VP15TF	PR630 PR730	AH330 AH120	TT7030 TT9030	PC5400 PC3530
	K	K10	KT3262	YBG102		WXH15 WXM15	KC510M		IC900 IC910	VP10MF	PR510 PR905	AH110	TT6080	PC8110
		K20	KT3262	YBG201 YBG205		WXM15	KC520M KC525M		IC910 IC950	VP15TF VP20RT	PR510 PR905	AH120	TT9030 TT9080	PC6510 PC5300
		K30	KT8296				KC725M KC735M		IC908 IC928	VP15TF VP20RT				
	S	S10	KS10				KC510M		IC908	VP15TF	PR660	AH120	TT6030	PC5300
		S20	KT8296		GC1025	WXM35	KC522M KC525M		IC908	VP15TF	PR660		TT8020	PC5400 PC9030
		S30	KT1456		GC2030		KC725M	F40M	IC328 IC928		PR660		TT8030 TT9080	

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

F 非标异形刀片

G 圆棒和立铣刀

H 刀杆和刀盘

I 加工案例

J 通用技术信息

通用技术信息 / 牌号对照表

Grade Comparison Table

牌号对照表 Grade Comparison Table

非涂层硬质合金 Uncoated cemented

APPLICATION		ISO CODE	KLT	ZCC. CT	SANDVIK	WALTER	KENNAMETAL	SECO	ISCAR	MTSUBISHI	KYOCERA	TUNGALOY	TREGUTEC	KORLOY
Turning	P	P10			S1P		P10		IC70				P10	ST10
		P20	KT3220	YC20	SMA		K125M TTM		IC70 IC50M	UTi20T		TX10S	P20	ST20
		P30	KT1330	YC40S	SM30		GK K600 TTR		IC50M IC54	UTi20T	PW30	TX20 TX25	P30	ST30A
		P40	KT1330	YC40	S6		G13		IC54			TX30 UX30		
	M	M10		YW1	H10A		K313	890				TU10	M10	U10
		M20	KT2250	YW2	H13A		K68 KMF	HX 883	IC08	UTi20T		TU20 UX30	M20	U20
		M30	KT2300		H10F SM30		K600 TTR		IC08 IC28	UTi20T		UX30		ST30A
		M40			S5		G13					TU40	M40	U40
	K	K01		YD051	H1P		K605			UTi05T		TH03 KS05F		H02
		K10	KT3120	YD101	H1P H10		K313 K110M	890	IC20	HTi10	KW10	G1F TH10	K10	H01
		K20	KT3260	YD201	H13A		K715 KMF	890 HX	IC20 IC10	UTi20T	GW10	G2F KS15F	K20	G10
	N	N01					K605					KS05F		
		N10	KT3120	YD101		WK10	K313 K110M	890 H15		HTi10		TH10 H10T	K10	K10
		N20	KT3260	YD201			K715 KMF	HX 883				KS15F		K20
Milling	P	P10			S1P								P10	S1P
		P20	KT3220	YC20			K125		IC50M	UTi20T		TX25	P20	
		P30	KT1330	YC40S			GX K600		IC50M IC28	UTi20T	PW30	UX30	P30	
		P40	KT1330	YC40					IC28		PW30			
	M	M10		YW1			K110M						M10	
		M20	KT2250	YW2			K313			UTi20T			M20	
		M30	KT2300				KFM K600		IC28	UTi20T		UX30		
		M40							IC28			TU40	M40	
	K	K01		YD051						KTi05T				
		K10	KT3120	YD101	H1P	WK10	K110M		IC20	HTi10	KW10	TH10	K10	H1P
		K20	KT3260	YD201			KFM	HX	IC20 IC10	UTi20T			K20	

牌号对照表 Grade Comparison Table
金属陶瓷 Cermet

APPLICATION	ISO CODE	KLT	ZCC. CT	SANDVIK	WALTER	KENAMETAL	SECO	ISCAR	MTSUBISHI	KYOCERA	TUNGALOY	TAEGUTEC	KORLOY
Turning	P	P10	YNG151 YNG151C			KT315 TT125	CM CMP	IC20N IC520N	AP25N NX2525	TN60 TN6020	NS520 AT520	PV3010	CC105 CN1000
		P20	YNG151 YNG151C	CT5015 GC1525		KT325	TP1030	IC20N IC520N	AP25N NX2525	TN10 TN6020	NS520 AT530	CT3000	CN1500 CN2000
		P30	YNG151 YNG151C	GC1525			C15M	IC75T IC30N	VP45N		NS530 NS730	CT7000	CN20
		P40											
	M	M10	YNG151 YNG151C	GC1525		KT315	CM CMP		AP25N NX2525	TN60 TN6020	NS520 AT530	PV3010 PV3030	CC105 CN1000
		M20	YNG151 YNG151C	GC1525		KT5020 KT125	TP1030 CMP		NX3035 AP25N NX2525	TN90 TN6020	NS530 GT730	CT3000	CN2000
		M30	YNG151 YNG151C			KT1120 KT175	TP1020 C15M		NX2525			CT7000	CN20
		M40											
	K	K01				KT315			AP25N NX2525	TN30		PV3030	CN1000
		K10	YNG151 YNG151C	CT5015		TT125 KT325			AP25N NX2525	TN60	NS520 AT520	CT3000	CN2000
		K20	YNG151 YNG151C						AP25N NX2525		NS530 GT730		
Milling	P	P10	YNG151 YNG151C				C15M	IC30N	NX2525	TN60		CT3000	
		P20	YNG151 YNG151C	CT530		KT530M HT7	C15M	IC30N	NX2525	TN100M	NS530	CT3000	
		P30	YNG151 YNG151C					IC30N	NX4545		NS530 NS540		
	M	M10	YNG151 YNG151C					IC30N	NX2525	TN60		CT3000	
		M20	YNG151 YNG151C	CT530		KT530M HT7	C15M	IC30N	NX2525	TN100M	NS530	CT3000	
		M30	YNG151 YNG151C						NX4545		NS540		
	K	K10	YNG151 YNG151C						NX2525	TN60	NS530	CT3000	
		K20	YNG151 YNG151C			KT530M HT7			NX2525			CT3000	
		K30	YNG151 YNG151C										

A 车削刀片

B 铣削刀片

C 铝合金刀片

D 孔加工刀片

E 刮管刀片

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刀具磨损与各类损伤

Inserts Wear and All Kinds of Damage

刀具损伤类型	现象	原因	对策
后刀面磨损 Flank wear	切削阻力增加 Increase cutting resistance 在后刀面逐渐形成沟槽磨损 Form groove abrasive	刀具材料过软 Workpiece material too soft 切削速度过高 Cutting speed too high 后角过小 Clearance angle too small 进给量太小 Feed rate too low	- 选用高耐磨性刀具材料 Select a more wear resistant grade - 降低切削速度 Reduce cutting speed - 增大后角 Increase clearance angle - 加大进给量 Increase feed rate
前刀面磨损 (月牙洼磨损) Crater wear	精加工表面恶化 Cause poor surface finish	刀具材料过软 Workpiece material too hard 切削速度过高 Cutting speed too high 进给量太大 Feed rate too high	- 选用高耐磨性刀具材料 Select a more wear resistant grade - 降低切削速度 Reduce cutting speed - 降低进给量 Reduce feed rate
崩刀 Mechanical fracture	突发性崩刀 Cause insert breakage	刀具材料过硬 Workpiece material too hard 进给量大 Feed rate too high 切削强度不足 Insufficiency of cutting edge strength 刀杆、刀柄刚性不足 tool holders too thin	- 选用韧性好的刀具材料 Select tougher grade - 降低进给量 Reduce feed rate - 加大刃口修磨量 (若是倒圆改为倒棱) Increase edge grinding (If fillet is changed to chamfer) - 加大刀杆尺寸 Increase the tool holders' diameter
破损 Insert breakage	切削阻力增大 Increase cutting resistance 表面粗糙度恶化 Causes poor surface finish	刀具材料过硬 Workpiece material too hard 进给量大 Feed rate too high 切削刃强度不足 Insufficiency of cutting edge strength 刀杆、刀柄刚性不足 Tool holders too thin	- 选用韧性好的刀具材料 Select tougher grade - 降低进给量 Reduce feed rate - 加大刃口修磨量 (若是倒圆改为倒棱) Increase edge grinding (If fillet is changed to chamfer) - 加大刀杆尺寸 Increase the tool holders' diameter
塑性变形 (刀刃塌下) Plastic deformation	工件尺寸变化 Change the size of workpiece 刀尖磨损 Cutting edge abrasion	刀具材料过软 workpiece material too soft 切削速度过高 Cutting speed too fast 切削深度、进给量太大 Cutting depth、Feed rate too high 切削刃温度过高 Too high cutting temperature on the rake face	- 选用高耐磨性刀具材料 Select a more wear resistant grade - 降低切削速度 Reduce cutting speed - 减小切削深度 进给量 Reduce cutting depth、feed speed
积屑瘤 (粘连) Built-up edge	精加工表面恶化 Cause poor surface finish 切削阻力增加 Increase cutting resistance	切削速度低 cutting speed too low 切削刃不锋利 Cutting edge not sharp 刀具材料不合适 Workpiece material unsuitable	- 提高切削速度 Increase cutting speed - 增大前角 Select a shaper edge geometry - 选用亲和力小的刀具材料 (涂层、金属陶瓷等) Select workpiece material with better adhesion resistance
热龟裂 Thermomechanical failure	由于热循环而崩损 Cause breakage due to thermal cycling 多出现在断续加工中 Appear in intermittent machining	切削热引起的膨胀与收缩 Thermal expansion and contraction caused by cutting heat 刀具材料过硬 Workpiece material too hard	- 干式切削 Dry cutting - 选用韧性好的刀具材料 Select a tougher grade with better resistance to thermal shocks
边界磨损 Notch wear	工件加工表面恶化 Cause poor surface finish 切削阻力增加 Increase cutting resistance	进给量过大 切削速度过高 Feed rate too high、cutting speed too fast	- 选用高耐磨性刀具材料 Select a more wear resistant grade - 增大前角使切削刃锋利 Select a sharper edge geometry - 降低切削速度 Reduce cutting speed

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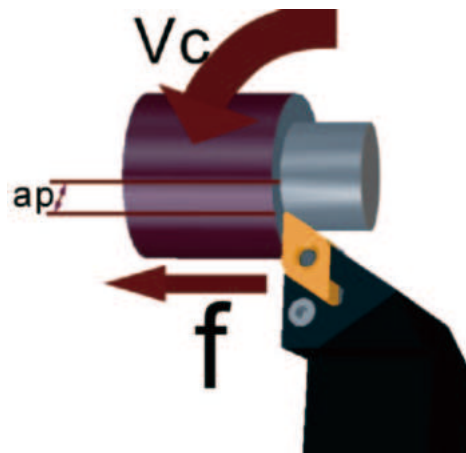
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三要素的影响 Effects of Three Main Parameters

我们在切削加工中，通常都希望获得短的加工时间，长的刀具寿命和高的加工精度。因此，必须充分考虑工件材料的材质、硬度、形状状况及机床的性能，选择合适的刀具并使用高效率的切削条件，即我们所说的三要素。

Normally, short machining time, long tool life and high machining precision are expected in machining, so the material quality, hardness, and shape of the workpiece, and properties of machine should be fully considered and then we can select suitable tools and adopt high-efficiency cutting parameters, namely three parameters.



切削速度 (Vc) Cutting Speed (Vc)

工件在车床上旋转，我们将其每分钟的转数定义为主轴转速 (n)。由于工件旋转，在其直径的切削点处产生切削速度，称为线速度，单位米/分钟。通常用线速度来考虑切削速度对加工的影响。

When the workpiece is rotating on the machine, the number of its rotation per minute is defined as Rotating speed of main axle (n). Because of its rotation, the cutting speed measured on the contacting point of diameter is defined as linear speed. m/min. Normally, linear speed is considered to measure the effect of cutting speed on machining.

切削速度的影响 Effect of Cutting Speed

切削速度对刀具寿命有非常大的影响。提高切削速度时，切削温度就上升，而使刀具寿命大大缩短。加工不同种类、硬度的工件，切削速度会有相应的变化。通过大量的切削实验得出：

Cutting speed has significant effect in tool life. When the cutting speed is increased, cutting temperature will increase and tool life will be shortened. Cutting speed varies according to the different types and hardness of work-piece. The below conclusions are reached after many cutting experiments:

(1) 在通常情况下，切削速度提高20%，刀具耐用度降低1/2；切削速度提高50%，刀具耐用度将降至原来的1/5。

(1) Normally tool life would be reduced to half when the cutting speed is increased by 20%. Tool life would be 20% of the original life if the cutting speed is raised by 50%.

(2) 低速 (20-40m/min) 切削易产生振动，使刀具寿命缩短。

(2) Low speed (20-40m/min) cutting could easily cause vibration and shorten tool life.

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车削三要素对加工的影响

The Effect of Three Key Elements on Machining

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进给量 (fn) Feed Rate(fn)

进给量是指工件每旋转一周,刀具的移动量,单位为毫米/转。

Feed rate is defined as the moving distance of tool after workpiece rotates for one circle, measured by mm/rotation.

进给量的影响 Feed Rate(fn)

进给量是决定被加工表面质量的关键因素,同时也影响加工时切屑形成的范围和切屑的厚度。

在对刀具寿命影响方面,进给量过小,后刀面磨损大,刀具寿命大幅降低;进给量过大,切削温度升高,后刀面磨损也增大,但较之切削速度对刀具寿命的影响要小。

Feed rate is a key factor that determines surface quality. Meanwhile it also affect the range of chip forming and the thickness of chips during machining.

In term of the effect on tool life, small feed rate leads to serious abrasion on clearance face, reducing tool life.

切削深度 (ap) Cutting Depth(ap)

切削深度指未加工表面与已加工表面之间的差值,单位毫米。它是工件未加工直径与已加工直径差值的一半。

Cutting depth is defined as the difference between machined surface and unmachined surface. Measured by mm. it is half the difference value between the original diameter and machined diameter.

切削深度的影响 Effect of Cutting Depth

切削深度应根据工件的加工余量、形状、机床功率、刚性及刀具的刚性来确定。

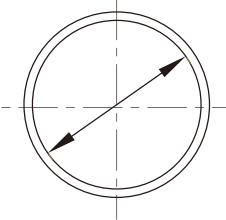
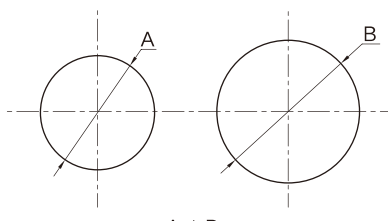
切削深度变化对刀具寿命影响不大。切削深度过小时,会造成刮擦,只切削工件表面的硬化层,缩短刀具寿命。当工件表面具有硬化的氧化层时,应在机床功率允许范围内选择尽可能大的切削深度,以避免刀尖只切削工件的表面硬化层,造成刀尖的异常磨损甚至破损。

Cutting depth should be determined by the machining allowance and shape of workpiece, power and rigidity of machine, and tool rigidity.

The change of cutting depth has little effect on tool life. If the cutting depth is too low. The cutting nose only scrapes the hardened layer on the workpiece surface, reducing tool life. When there is hardened oxide layer on workpiece surface, higher cutting depth should be adopted within the possible range of machine's power to avoid cutting just the hardened layer of workpiece.

孔加工孔常见问题及解决办法

Common Problems and Solutions for Drilling

现象 Problem	原因 Cause	解决方法 Solution
孔径扩大Oversize holes 	钻头装夹不好 主轴本身跳动量过大 Poor clamping Large run-out around spindle	选择精度高的刀柄及夹具 校正主轴 每次装夹钻头时，仔细测量与调整 Select the holder and chuch with high Precision calibrating spindle Check and adjust after clamping drill
	顶角不对称 钻头跳动过大 横刃偏心 Non-symmetric point angle Large run-out Chisel edge is off center	修磨刀具 修磨后检查精度 Regrind drill Check the precision after clamping drill
孔径的一致性较差 Irregular hole size 	顶角不对称 钻头跳动过大 横刃偏心 刃带棱面磨损过大 Non-symmetric point angle Large run-out Chisel edge is off center Excessive margin abrasion	选择精度高的刀柄及夹具 校正主轴 每次装夹钻头时，仔细测量与调整 Select the holder and chuch with high Precision Calibrating spindle Check and adjust after clamping drill
	钻头装夹不好 主轴本身跳动量大 工件装夹不牢固 Poor clamping Large run-out around spindle Workpiece is not firmly held	选择精度高的刀柄及夹具 校正主轴 每次装夹钻头时，仔细测量与调整 Select the holder and chuch with high Precision Calibrating spindle Check and adjust after clamping drill
	进给量过大 Feed rate is too high	降低进给速度 Reduce the feed speed
	切削液供给不足 Coolant provide is not enough	改变切削液供给方法，增加流量 Change the coolant supply method, Or increase coolant volume

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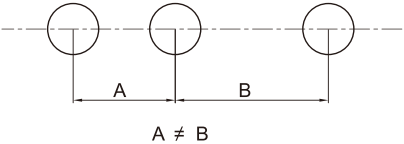
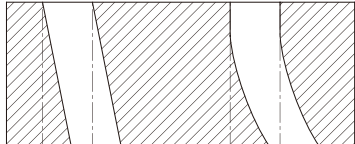
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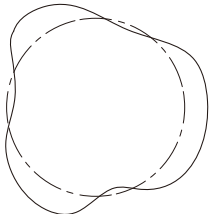
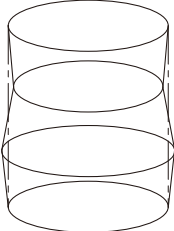
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现象 Problem	原因 Cause	解决方法 Solution
孔的位置精度较差 Low position accuracy 	机床主轴重复定位精度低 钻头装夹不好 主轴本身跳动量大 Poor re-positioning of spindle Poor clamping Large run-out around spindle	提高机床重复定位精度 选择精度高的刀柄及夹具 校正主轴 每次装夹钻头时, 仔细测量与调整 Improve the re-positioning precision of Machine select the holder and chuch With high precision Calibrating spindle Check and adjust after clamping drill
	被加工表面进给方向不垂直 The feed direction is not Vertical to the workpiece Surface	将被加工表面调整成与进给方向垂直 Adjust the feed direction vertical to The workpiece
	顶尖与轴心不重合(车床) Top center not align with the Spindle center	加工前仔细调整 Check and adjust alignment carefully Before drilling
直线度不良 垂直度不良 Bad linearity bad perpendicularity 	刀具磨损过大 Excessive margin abrasion	重新修磨 Regrind
	中心孔精度不好 Poor center hole accuracy	提高中心孔位置精度 Increase the position accuracy of hole
	顶角不对称 钻头跳动过大 横刃偏心 Non-symmetric point angle Large run-out Chisel edge is off center	修磨刀具 修磨后检查精度 Regrind drill Check the precision after regrinding
	钻头刚性不足 Insufficient drill rigidity	提高钻头刚性 Increase drill rigidity
	被切削平面不平 顶尖与轴心不重合(车床) Uneven workpiece rigidity Top center not align with the Spindle center (lathe)	调整为水平面或预加工为水平面 预钻中心孔 The workpiece must be horizontal or Premachined to horizontal before drilling Pre-drill a center hole

孔加工孔常见问题及解决办法

Common Problems and Solutions for Drilling

现象 Problem	原因 Cause	解决方法 Solution
圆度较差 Poor roundness 	顶角不对称 钻头跳动过大 横刃偏心 Non-symmetric point angle Large run-out Chisel edge is off center	修磨刀具 修磨后检查精度 Regrind drill Check the precision after regrinding
	钻头装夹不好 主轴本身跳动量大 工件装夹不牢固 Poor clamping Large run-out around spindle Workpiece is not firmly held	选择精度高的刀柄及夹具 校正主轴 每次装夹钻头时，仔细测量与调整 Select the holder and chuch with high Precisioncalibrating spindle check run Out and adjust after clamping drill
	后角过大 Clearance angle is too large	重新修磨切削刃 Regrind drill
	钻头刚性不足 Insufficient drill rigidity	提高钻头刚性 Increase drill rigidity
被加工工件表面质量差 Poor workpiece surface quality	修磨不当 Incorrect regrinding	重新修磨校正 Regrind calibration
	切削液供给不足或型号不匹配 Insufficient coolant or Unsuitable coolant type	改变切削液供给方法，增加流量 采用润滑性好的切削油 Change the coolant supply method, Or increase coolant volume
	钻头装夹不好 主轴本身跳动量大 Poor clamping Large run-out around spindle	选择精度高的刀柄及夹具 校正主轴 Select the holder and chuch with high Precisioncalibrating spindle
	进给速度过大 Feed rate is too high	降低进给速度 Decrease the feed rate
	切削刃磨损过大，刃带棱面粘结严重。 Excessive abrasion on Cuttingedge Excessive build-up on margin	重新修磨切削刃，使用涂层钻头 Regrind drill Select a coated drill
	切削阻塞 Chip jamming	重选钻头(容屑槽型、螺旋角等) 重选加工方法 (进给速度的调整，采用分步阶梯方式等) Select a suitable drill(considering flute Geometry, helical angle etc)change the Cutting method (adjust feed rate, use Step feed etc.)
圆柱度较差 Poor cylindricity 	顶角不对称 钻头跳动量过大 横刃偏心 刃带棱面磨损过大 Non-symmetric point angle Large run-out Chisel edge is off center Excessive margin abrasion	重修磨刀具 修磨后检查精度 Regrind drill Check the precision after regrinding
	进给速度过低 Feed rate is too low	提高进给速度 Increase the feed speed

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材料硬度与切削速度的修正系数表

The Correction Coefficient Table of Hardness and Cutting Speed

工件材料 Material		理论硬度 Theoretical Hardness	材料硬度与切削速度的修正系数 The Correction Coefficient Table Of Hardness and Cutting Speed								
			硬度降低 Hardness Decrease ← 硬度差值 (实测值—理论值) → Hardness Difference (Measured Difference - Theoretical Difference) 硬度增大 Hardness Increase								
			-60	-40	-20	0	20	40	60	80	100
P		HB180	1.42	1.24	1.11	1.00	0.91	0.84	0.77	0.72	0.67
M		HB180	1.44	1.25	1.11	1.00	0.91	0.84	0.78	0.73	0.68
K	灰口铸铁 Grey Cast Iron	HB220	1.21	1.13	1.06	1.00	0.95	0.9	0.86	0.82	0.79
	球墨铸铁 Nodular Cast Iron	HB250	1.33	1.21	1.09	1.00	0.91	0.84	0.75	0.7	0.65
N		HB75			1.05	1.00	0.95				
S		HB350			1.12	1.00	0.89				
HRC				-6	-3	0.00	3	6	9		
H		HRC60		1.10	1.02	1.00	0.96	0.93	0.9		

实际加工速度=推荐加工速度×切削速度修正系数

Actual Processing Speed=Recommended Processing Speed*Correction Factor Of Cutting Speed

推荐的切削参数见刀片包装盒 Recommended Cutting Parameters See Packaging

表格使用举例：当您要加工的材料为普通的合金钢，理论硬度为HB180，选择的刀片为CNMG120404-MM时，推荐切削速度： $V=250\text{m/min}$ 。如果实测硬度值为HB220，则硬度差值为 $220-180=40$ ，对照上表查到速度修正系数0.84，则实际加工速度 $V_c=250 \times 0.84=210\text{m/min}$ 。

i.e. Cutting general alloy steel, hardness HB180, CNMG120404-MM, the recommended cutting speed is $V=250\text{m/min}$. When measured hardness is HB220, the hardness difference is $40(220-180)$. Find The corresponding speed correction coefficient is 0.84 on above table, and then the actual processing speed $V_c=250 \times 0.84=210\text{mm/min}$

材料对照表

Material Comparison

钢 Steel

ISO	国家和标准 Nations And Standard										
	 中国	 德国	 美国	 英国	 意大利	 西班牙	 瑞典	 法国	 日本		
	GB (P类)	W-nr	DIN	AISI/SAE	BS	EN	UNI	UNE	SS	AFNOR	JIS
碳素钢材 Carbon Steel	15	1.0401	C15	1015	080M15		C15C16	F.111	1350	CC12	
	20	1.0402	C22	1020	050A20	2C	C20C21	F.112	1450	CC20	
	35	1.0501	C35	1035	060A35		C35	F.113	1550	CC35	
	45	1.0503	C45	1045	080M40		C45	F.114	1650	CC45	
	55	1.0535	C55	1055	070M55		C55		1655		
	60	1.0601	C60	1060	080A62	43D	C60			CC55	
	Y15	1.7015	9SMN28	1213	230M07		CF9SMn28	11SMn28	1912	S250	SUM22
锰钢材 Manganese Steel	40Mn	1.1157	40Mn4	1039	150M36	15				35M5	
	25	1.1158	Ck25	1025							S25C
	35Mn2	1.1167	36Mn5	1335				36Mn5	2120	40Mn5	SMn438(H)
	30Mn	1.117	28Mn6	1330	150M28	14A	C28Mn			20M5	SCMn1
	35Mn	1.1183	Cf35	1035	060A35		C36		1572	XS38TS	S35C
		1.0718	9SMnPb28	12L13			CF9MnPb28	11SMnPb28	1914	S250Pb	SUM22L
		1.0722	10SPb20				CF10Pb20	10SPb		10PbF2	
		1.0726	35S20	1140	212M36	8M		F210G	1957	35MF4	
	Y13	1.0736	9SMn36	1215	240M07	1B	CF9SMn36	12SMn35		S300	
		1.0737	9SMnPb36	12L14			CF9SMnPb36	12SMnPb35	1926	S300Pb	
	55Si2Mn	1.0904	55Si9	9255	250A53	45	55Si8	56Si7	2085	55S7	
		1.0961	60SiCr7	9262			60SiCr8	60SiCr8		60SC7	
	15	1.1141	Ck15	1015	080M15	32C	C16	C15K	1370	XC12	S15C
	Ck45	1.1191	45	1045	080M46		C45	C45K	1672	XC42	S45C
	55	1.1203	Ck55	1055	070M55		C50	C55K		XC45	S55C
	50	1.1213	Cf53	1050	060A52		C53		1674	XC48TS	S50C
	60Mn	1.1221	Ck60	1060	080A62	43D	C60		1678	XC60	S68C
		1.1274	Ck101	1095	060A96				1870		SUP4
		1.3401	X120Mn12		Z120M12		XG120Mn12	X120Mn12		X120M12	SCMnH/1
	Gr15,45Gr	1.3505	100Cr6	52100	534A99	31	100Cr6	F.131	2258	100C6	SUJ2
		1.5415	15Mo3	ASTMA204Gr,A	1501-240		16Mo3KW	16Mo3	2912	15D3	
		1.5426	16Mo5	4520	1503-245-420		16Mo5	16Mo5			
		1.5622	14Ni6	ASTMA350LF5			14Ni6	15Ni6		16N6	
		1.5662	X8Ni9	ASTM A353	1501-509:510		X10Ni9	XBNi09			

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	 中国	 德国		 美国	 英国		 意大利	 西班牙	 瑞典	 法国	 日本
	GB (P类)	W-nr	DIN	AISI/SAE	BS	EN	UNI	UNE	SS	AFNOR	JIS
镍铬钢材料 Nickel Chromium Steel		1.5680	12Ni19	2515						Z18N5	
		1.5710	36NiCr6	3135	640A35	111A				35NC6	SNC236
		1.5732	14NiCr10	3415			16NiCr11	15NiCr11		14NC11	SNC415(H)
		1.5752	14NiCr14	3415, 3310	655M13 655A12	36A				12NC15	SNC815(H)
镍铬钼钢材料 Nickel Chromium Molybdenum Steel		1.6511	36CrNiMo4	9840	816M40	110	38CrNiMo4(KB)	35CrNiMo4		40NCD3	
		1.6523	21NiCrMo2	8620	850M20	362	20NiCrMo2	20NiCrMo2	2503	20NCD2	SNCCM220(H)
		1.6546	40NiCrMo2	8740	311-Type7		40NiCrMo2(KB)	40NiCrMo2			SNC240
	40CrNiMoA	1.6582	34CrNiMo6	4340	817M40	24	35CrNiMo6(KB)		2541	35NCD6	
		1.6587	17CrNiMo6		820A16			14CrNiMo13		18NCD6	
铬钢材料 Chromium Steel	15Cr	1.7015	15Cr3	5015	523M15					12C3	SCr415(H)
	35Cr	1.7033	34Cr4	5132	530A32	18B	34Cr4(KB)	35Cr4		32C4	SCr430(H)
	40Cr	1.7035	41Cr4	5140	530M40	18	41Cr4	42Cr4		42C4	SCr440(H)
	40Cr	1.7045	42Cr4	5140				42Cr4	2245		SCr440
锰铬钢材料 Manganese Chromium Steel	18CrMn	1.7131	16MnCr15	5115	527M20		16MnCr15	16MnCr15	2511	16MC5	
	20CrMn	1.7176	55Cr3	5155	527A60	48				55C3	SUP9(A)
	30CrMn	1.7218	25CrMo4	4130	1717CDS110		25CrMo4(KB)	55Cr3	2225	25CD4	SCM420; SCM430
	35CrMo	1.722	34CrMo4	4137, 4135	708A37	19B	35CrMo4	34CrMo4	2234	35CD4	SCM432 SCRRM3
	40CrMoA	1.7223	41CrMo4	4140, 4142	708M40	19A	41CrMo4	41CrMo4	2244	42CD4TS	SCM440
	42CrMo, 42CrMnMo	1.7225	42CrMo4	4140	708M40	19A	42CrMo4	42CrMo4	2244	42CD4	SCM440(H)
铬钼钢材料 Chromium Molybdenum Steel		1.7262	15CrMo5					12CrMo4	2216	12CD4	SCM415(H)
		1.7335	13CrMo44	ASTM F11 A182 F12	1501-620Cr. 27		14CrMo44	14CrMo45	15CD3.5;15CD4.5		
		1.7361	32CrMo12		722M24	40B	32CrMo12	F.124.A	2240	30CD12	
		1.738	10CrMo910	ASTM A182 F22	1501-622Cr.31;45		12CrMo9,10	TU.H	2218	12CD9;10	
		1.7715	14MoV63		1503-660-440			13MoCrV6			
	50CrVA	1.8159	50CrV4	6150	735A50	47	50CrV4	51CrV4	2230	50CV4	SUP10
		1.8509	41CrAlMo7		905M39	41B	41CrAlMo7	41CrAlMo7	2940	40CAD6,12	
	1.8523	39CrMoV139		897M39	40C	36CrMoV12					

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	GB (P类)	W-nr	DIN	AISI/SAE	BS	EN	UNI	UNE	SS	AFNOR	JIS
钢类 Steel	T10	1.1545	C105W1	W.110			C98KU C100KU	F.515 F.516	1880	Y1105	
	T12A	1.1663	C125W	W.112			C120KU	(C120)		Y2120	SK2
	CrV,9SiCr	1.2067	100Cr6	L3	BL3			100Cr6		Y100C6	
	Cr12	1.208	X210Cr12	D3	BD3		X210Cr13KU X250Cr12KU	X210Cr12		Z200Cr12	SKD1
	4Cr5MoVSi	1.2344	X40CrMoV51	H13	BH13			X40CrMoV5	2242	Z40CDV5	SKD61
	Cr6WV	1.2363	X100CrMoV51	A2	BA2		X35CrMoV05KU X40CrMoV51KU	X100CrMoV5	2260	Z100CDV5	SKD12
	CrWMo	1.2419	105WCr6				X100CrMoV51KU	105WCr5	2140	105WC13	SKS31 SKS2 SKS3
	Cr12W	1.2436	X210CrW12				10WCr6 107WCr5KU	X210CrW12	2312		SKD2
	5CrNiMo	1.2542	45WCrV7	S1	BS1		X215CrW121KU	45WCrSi8	2710		
	3Cr2W8V	1.2581	X30WCrV93 X30WCrV93KU	H21	BH21		45WCrV8KU	X30WCrV9		Z30WCV9	SKD5
	Cr12MoV	1.2601	X165CrMoV12				X28W09KU X30WCrV93KU	X160CrMoV12	2310		SKD11
	5CrNiMo	1.2731	55NiCrMoV6	L6			X165CrMoW12KU	F.250.S		55NCDV7	SKT4
	V	1.2833	100V1	W210	BW2					Y1105V	SKS43
	W6Mo5Cr4V2Co5	1.3243	S6-5-2-5					HS6-5-2-5	2723	Z85WDCV	SKH55
	W18Cr4VCo5	1.3255	S18-1-2-5	T4	BT4		HS6-5-2-5	HS18-1-1-5		Z80WKCV 10-05-04-1	SKH3
	W6Mo5Cr4V2	1.3343	S6-5-2S	M2	BM2		X78WCo1805KU	HS6-5-2	2722	Z85WDCV 06-05-04-02	SKH9
		1.3348	S2-9-2	M7		Z	X82WMo0605KU	HS-2-9-2	2782	Z100WCWV 09-02-04-02	
	W18Cr4V	1.3355	S18-0-1	T1	BT1		HS2-9-2	HS18-0-1		Z80WCV 18-04-01	SKH2
	W6Mo5Cr4V3		S6-5-3	M3			X75W18KU				SKH52
				M42	BM42						SKH59

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	GB (P类)	W-nr	DIN	JIS	DAIDO	AISI/SAE
模型钢类 Die Steel				塑料模具钢		
					PX5N	P20mod
					NAK55	
					NAK80	
	3Cr13			SUS420J2mod	S-STAR	420mod
				冷作模具钢		
				SKS93	YK30	2
	9CrWMn			SKS3mod	GOA	01mod
	Cr12MoV	X165CrMoV12		SKD11	DC11	D2
				SKD11mod	DC53	D2mod
				热作模具钢		
	4Cr5MoSiV1	X40CrMoV51		SKD61	DHA1	H13
					DH21	
					DH31-S	
					DH2F	

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不锈钢 Stainless Steel

ISO	国家和标准 Nations And Standard										
	 中国	 德国		 美国	 英国		 意大利	 西班牙	 瑞典	 法国	 日本
	GB (P类)	W-nr	DIN	AISI/SAE	BS	EN	UNI	UNE	SS	AFNOR	JIS
不 锈 钢 Stainless Steel	0Cr13;1Cr12	1.4000	X6Cr13	403	403S17		X6Cr13	F.3110	2301	Z6C13	SUS403
		1.4001	X7Cr14					F.8401			
	1Cr13	1.4006	X10Cr13	410	410S21	56A	X12Cr13	F.3401	2302	Z10C14	SUS410
	1Cr17	1.4016	X6Cr17	430	430S15	60	X8Cr17	F.3113	220	Z8C17	SUS430
	2Cr13	1.4021	X20Cr13	410	S62	56B; 56C	X20C13	F.3401		Z20C13	SUS410
		1.4027	G-X20Cr14		420C29	56B				Z20C13M	SCS2
	4Cr13	1.4034	X46Cr13		420S45	56D	X40Cr14	F.3405	2304	Z40CM;Z38C13M	SUS420J2
	1Cr17Ni2	1.4057	X20CrNi172	431	431S29	57	X16CrNi16	F.3427	2321	Z15CNi6.02	SUS431
	Y1Cr17	1.4104	X12CrMoS17	430F			X10CrS17	F.3117	2383	Z10CF17	SUS430F
	1Cr17Mo	1.4113	X6CrMo171	434	434S17		x8CrMo17		2325	Z8CD17.01	SUS434
		1.4313	X5CrNi134		425C11					Z4CND13.4M	SCS5
		1.4408	G-X6CrNiMo1810		316C16			F.8414			SCS14
	4Cr9Si2	1.4718	X45CrSi93	HW3	401S45	52	X45CrSi8	F.322		Z45CS9	SUH1
	0Cr13Al	1.4724	X10CrAl13	405	403S17		X10CrAl12	F.311		Z10C13	SUS405
	Cr17	1.4742	X10CrAl18	430	430S15	60	X8Cr17	F.3113		Z10CAS18	SUS430
	8Cr20Si2Ni	1.4757	X80CrNiSi20	HNV6	443S65	59	X80CrSiNi20	F.320V		Z80CSN20.02	SUH4
	2Cr25N	1.4762	X10CrAl24	446			X16Cr26		2322	Z10CAS24	SUH446
不 锈 钢 Stainless Steel	0Cr18Ni9	1.4301	X5CrNi1810	304	304S15	58E	X5CrNi1810	F.3551 F.354 F.3504	2332	Z6CN18.09	SUS304
	1Cr18Ni9MoZr	1.4305	X10CrNiS189	303	303S21	58M	X10CrNiS18.09	F.3508	2346	Z10CNF18.09	SUS303
	0Cr19Ni10	1.4306	X2CrNi1911	304L	304S12		X2CrNi18.11	F.3503	2352	Z2CN18.10	SCS19
		1.4308	G-X6CrNi189		304C15					Z6CN18.10M	SCS13
	Cr17Ni7	1.4310	X12CrNi177	301			X12CrNi1707	F.3517	2331	Z12CN17.07	SUS301
		1.4311	X2CrNiN1810	304LN	304S62				2371	Z2CN18.10	SUS304LN
	0Cr19Ni9	1.4350	X5CrNi189	304	304S31	58E	X5CrNi1810			Z6CN18.09	SUS304
	0Cr17Ni11Mo2	1.4401	X5CrNiMo1712	316	316S16	Z6CND17.11	X5CrNiMo1712	F.3543	2347	1.4401	SUS316
	00Cr17Ni13Mo2	1.4429	X2CrNiMoN17133	316LN					2375	Z2CND17.13	SUS316LN
	0Cr27Ni12Mo3	1.4435	X2CrNiMo18143	316L	316S12		X2CrNiMo1713		2353	Z2CDN17.13	SCS16
	00Cr19Ni13Mo3	1.4438	X2CrNiMo17133	317L	317S12		X2CrNiMo18.16		2367	Z2CND19.15	SUS317L
		1.4460	X8CrNiMo275	329L					2324		SUS329L; SCH11 SCS11
	1Cr18Ni9Ti	1.4541	X6CrNiTi1810	321	2337	321S12	X6CrNiTi1811	F.3553	58B	Z6CNT18.10	SUS321
	1Cr18Ni11Nb	1.4550	X6CrNiNb1810	347	347S17	58F	X6CrNiTi1811	F.3552	2338	Z6CNNb18.1	SUS347
	Cr18Ni12Mo2Ti	1.4571	X6CrNiMoTi17122	316Ti	320S17	58J	X6CrNiMoTi17	F.3535	2350	Z6NDT17.12	
不 锈 钢 Stainless Steel		1.4581	G-X5CrNiMoNb1810		318C7		XG8CrNiMo18			Z4CNDNb1812M	SCS22
	Cr17Ni12Mo3Nb	1.4583	X10CrNiMoNb1812	318			X6CrNiMoTiNb17			Z6CNDNb1713B	
	1Cr23Ni13	1.4828	X15CrNiSi2012	309	309S24					Z15CNS20.1	SUH309
	0Cr25Ni20	1.4845	X12CrNi2521	310S	310S24		X6CrNi2520	F.331	2361	Z12CN2520	SUH310
	Cr15Ni36W3Ti	1.4864	X12NiCrSi3616	330						Z12CN35.1	SUH330
		1.4865	G-X40NiCrSi3818		330C11		XG50NiCr3919				SCH15
	5Cr2Mn9Ni4N	1.4871	X53CrMnNiN219	EV8	349S54;321S12	58B	X53CrMnNiN219			Z52CMN21.0	SUH35
	1Cr18Ni9Ti	1.4878	X12CrNiTi189	321	321S320	58C	X6CrNiTi1811	F.3523		Z6CNT18.12	Su321

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铸铁 Cast Iron

ISO	国家和标准 Nations And Standard										
	 中国	 德国		 美国	 英国		 意大利	 西班牙	 瑞典	 法国	 日本
	GB (P类)	W-nr	DIN	AISI/SAE	BS	EN	UNI	UNE	SS	AFNOR	JIS
球墨铸铁 Nodular Iron	QT400-18	GGG40		60-40-18	400/17		GS370-17	FGE38-17	0717-02	FGS370-17	FCD400
	QT450-10			65-45-12	420/12		GS400-13	FGE42-12		FGS400-12	FCD450
	QT500-7	GGG50		70-50-05	500/7		GS500-7	FGE50-7	0727-02	FGS500-7	FCD500
	QT600-3	GGG60		80-60-03	600/7		GS600-2	FGE60-2	0732-03	FGS600-2	FCD600
	QT700-2	GGG70		100-70-03	700/2		GS700-2	FGE70-2	0737-01	FGS700-2	FCD700
	QT800-2	GGG80		120-90-02	800/2		GS800-2	FGE80-2	0864-03	FGS800-2	FCD800
	QT900-2				900/2						
灰口铸铁 Grey Cast Iron		GG40		NO.60					0140	FGL400	FC350
	HT350	GG35		NO.50	350		G35	FG35	0135	FGL350	FC300
	HT300	GG30		NO.45	300		G30	FG30	0130	FGL300	FC250
	HT250	GG25		NO.35	250		G25	FG25	0125	FGL250	FC200
	HT200	GG20		NO.30	200		G20	FG20	0120	FGL200	FC150
	HT150	GG15		NO.20	150		G15	FG15	0115	FGL150	FC100
	Ht100				100		G10		0110		

硬度对照表

Hardness Comparison

硬度 Hardness				抗拉强度 Tensile Strength
洛氏 Rockwell Hardness(RH)		维氏 Vickers Hardness(VH)	布氏 Brinell Hardness(BH)	
HRC	HRA	HV	HB	
70.0	86.6	1037		
69.5	86.3	1017		
69.0	86.1	997		
68.5	85.8	978		
68.0	85.5	959		
67.5	85.2	941		
67.0	85.0	923		
66.5	84.7	906		
66.0	84.4	889		
65.5	84.1	872		
65.0	83.9	856		
64.5	83.6	840		
64.0	83.3	825		
63.5	83.1	810		
63.0	82.8	795		
62.5	82.5	780		
62.0	82.2	766		
61.5	82.0	752		
61.0	81.7	739		
60.5	81.4	726		
60.0	81.2	713		2555
59.5	80.9	700		2500
59.0	80.6	688		2450
58.5	80.3	676		2395
58.0	80.1	664		2345
57.5	79.8	653		2295
57.0	79.5	642		2250
56.5	79.3	631		2205
56.0	79.0	620		2160
55.5	78.7	609		2115
55.0	78.5	599		2075
54.5	78.2	589		2035
54.0	77.9	579		1995
53.5	77.7	570		1955
53.0	77.4	561		1920
52.5	77.1	551		1885
52.0	76.9	543		1850
51.5	76.6	534		1815

硬度 Hardness				抗拉强度 Tensile Strength
洛氏 Rockwell Hardness(RH)		维氏 Vickers Hardness(VH)	布氏 Brinell Hardness(BH)	
HRC	HRA	HV	HB	
51.0	76.3	501		1780
50.5	76.1	494		1750
50.0	75.8	488		1720
49.5	75.5	481		1690
49.0	75.3	474		1660
48.5	75.0	468		1630
48.0	74.7	461		1605
47.5	74.5	455		1575
47.0	74.2	449		1550
46.5	73.9	442		1525
46.0	73.7	436		1500
45.5	73.4	430		1475
45.0	73.2	424		1450
44.5	72.9	418		1430
44.0	72.6	413		1405
43.5	72.4	407		1385
43.0	72.1	401		1360
42.5	71.8	396		1340
42.0	71.6	391		1320
41.5	71.3	385		1300
41.0	71.1	380		1280
40.5	70.8	375		1260
40.0	70.5	370		1245
39.5	70.3	365		1225
39.0	70.0	360		1210
38.5		355		1190
38.0		350		1175
37.5		345		1160
37.0		341		1140
36.5		336		1125
36.0		332		1110
35.5		327		1095
35.0		323		1080
34.5		318		1065
34.0		314		1050
33.5		310		1035
33.0		306		1020
32.5		302		1010

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洛氏 Rockwell Hardness(RH)		维氏 Vickers Hardness(VH)	布氏 Brinell Hardness(BH)	
HRC	HRA	HV	HB	
32.0		304	298	995
31.5		300	294	980
31.0		296	291	970
30.5		292	287	960
30.0		289	283	950
29.5		285	280	935
29.0		281	276	920
28.5		278	273	910
28.0		274	269	900
27.5		271	266	890
27.0		268	263	880
26.5		264	260	870
26.0		261	257	860
25.5		258	254	850
25.0		255	251	835
24.5		252	248	830

硬度 Hardness				抗拉强度 Tensile Strength
洛氏 Rockwell Hardness(RH)		维氏 Vickers Hardness(VH)	布氏 Brinell Hardness(BH)	
HRC	HRA	HV	HB	
24.0		249	245	820
23.5		246	242	810
23.0		243	240	800
22.5		240	237	790
22.0		237	234	785
21.5		234	232	775
21.0		231	229	765
20.5		229	227	760
20.0		226	225	750
19.5		223	222	745
19.0		221	220	735
18.5		218	218	730
18.0		216	216	725
17.5		214	214	715
17.0		211	211	710

