TurnLine

# T505

www.tungaloy.com/cn

Tungaloy Report No. 539-C

# T505 - 最新的铸铁车削牌号，具有非常出色的耐磨性

INDUSTRY 4.0

FEED the SPEED!

倍　速　加　工

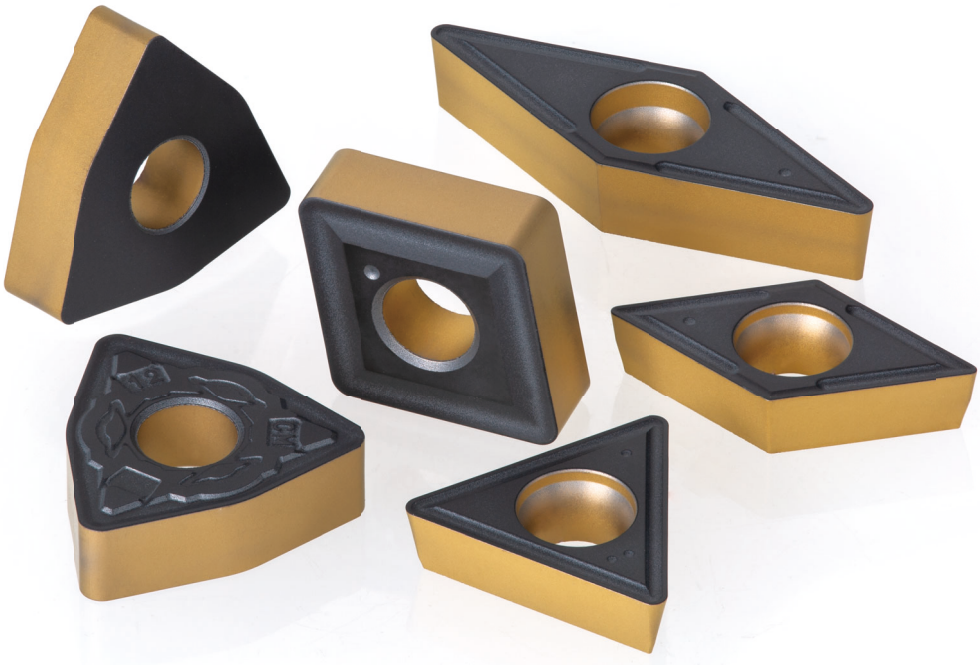
TurnLine

# T505

TUNGALOY

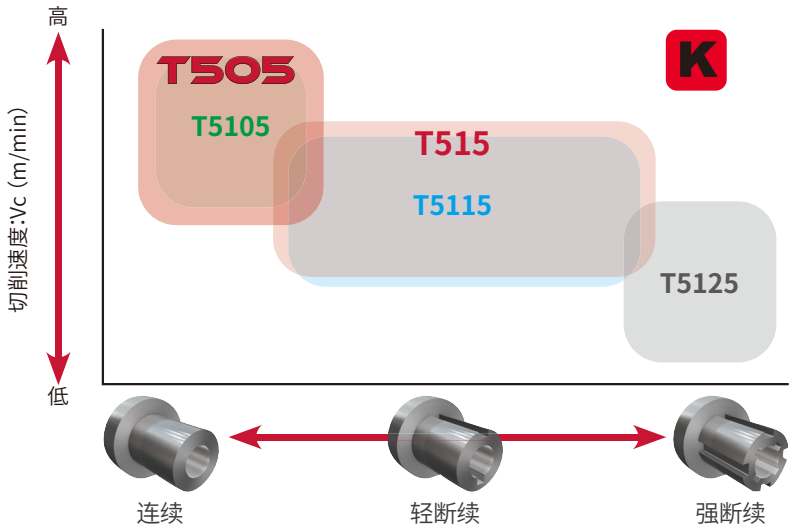
TUNGTURN FORCE

ACCELERATED MACHINING



## 铸铁新 T505 材质，T515 的有效补充

# 新的 T505 - 极佳的 CVD 材质
## 用于铸铁的高速加工



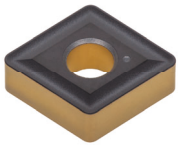

New

**T505**

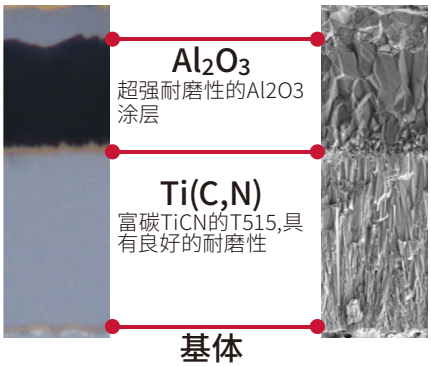
与T515材质互补
高耐磨性
高速加工的首选材质
加工K05 - K20

## 所有 Tungaloy CVD 材质中最厚的涂层

New



T505的涂层厚度是传统材质的1.5倍。




**出色的耐磨性!!**

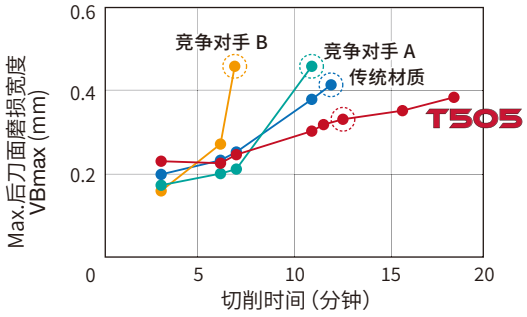
Tungaloy 所有材质中最厚的涂层
高耐磨性的Al2O3涂层
耐
高碳含量的富碳TiCN
具有高导热率的新基体
导热率

| ISO | 材质 | 基体 | | | 涂层 | |
|---|---|---|---|---|---|---|
| | | 比重 | 硬度(HRA) | 横向抗拉强度（Gpa） | 主要构成 | 厚度（μm） |
| K | T505 | 15 | 91 | 2.4 | 连续的柱状晶体 TiCN + $Al_2O_3$ | 23 |

## 切削性能

### 新的 CVD 材质 - 在铸铁车削工作中的多功能性！

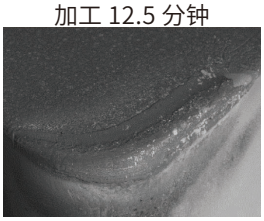
#### FC200 / GG25



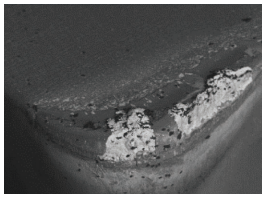

| | |
|---|---|
| 工件材料 | : FC200 / GG25 |
| 切削速度 | : *Vc* = 700 m/min |
| 进给量 | : *f* = 0.3 mm/rev |
| 切深 | : *ap* = 2 mm |
| 加工 | : 连续切削 |
| 冷却方式 | : 湿式 |

**T505在铸铁的加速加工中表现出良好的耐磨性。**

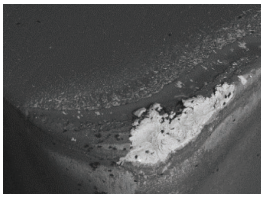
**T505**
加工 12.5 分钟



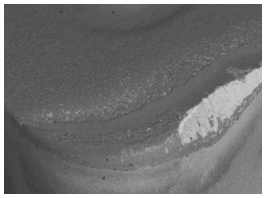
**传统材质**
加工 12 分钟



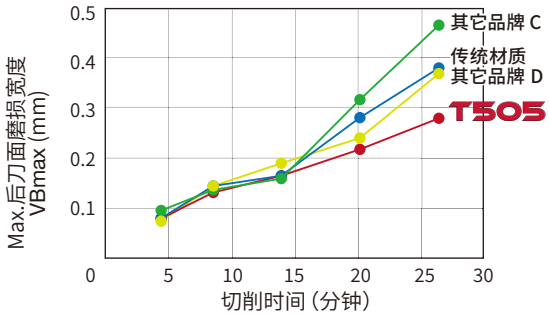
**竞争对手 A**
加工 11 分钟



**竞争对手 B**
加工 7 分钟



#### FCD600 / GGG60

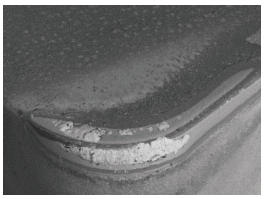



| | |
|---|---|
| 工件材料 | : FCD600 / GGG60 |
| 切削速度 | : *Vc* = 150 m/min |
| 进给量 | : *f* = 0.3 mm/rev |
| 切深 | : *ap* = 2 mm |
| 加工 | : 连续切削 |
| 冷却方式 | : 湿式 |

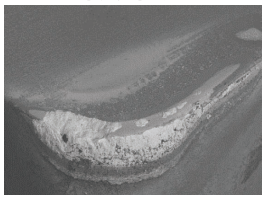
**T505在球墨铸铁加工过程中表现出良好的耐磨性。**

**加工 26 分钟**

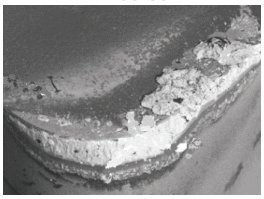
**T505**



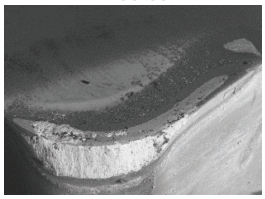
**传统材质**



**其它品牌 C**



**其它品牌 D**



T505
TUNGALOY

# 标准加工参数

## 负角刀片

| 断屑槽 | 材质 | 刀尖圆角半径 RE | 切深 *ap* (mm) | 进给量 *f* (mm/rev) | 切削速度：Vc (m/min) | |
|---|---|---|---|---|---|---|
| | | | | | 灰铸铁 | 球墨铸铁 |
| CM | T505 | 0.4 | 1 - 5 | 0.1 - 0.25 | 180 - 700 | 180 - 400 |
| | T505 | 0.8 | 1 - 5 | 0.15 - 0.4 | 180 - 700 | 180 - 400 |
| | T505 | 1.2 | 1 - 5 | 0.15 - 0.5 | 180 - 700 | 180 - 400 |
| 全周 | T505 | 0.4 | 1 - 6 | 0.2 - 0.3 | 180 - 700 | 180 - 400 |
| | T505 | 0.8 | 1 - 6 | 0.2 - 0.5 | 180 - 700 | 180 - 400 |
| | T505 | 1.2 | 1 - 6 | 0.2 - 0.5 | 180 - 700 | 180 - 400 |
| | T505 | 1.6 | 1 - 6 | 0.3 - 0.5 | 180 - 700 | 180 - 400 |
| 平板 | T505 | 0.8 | 0.05 - 2 | 0.2 - 0.45 | 180 - 700 | 180 - 400 |
| | T505 | 1.2 | 0.05 - 2 | 0.2 - 0.6 | 180 - 700 | 180 - 400 |

## 正角刀片

| 断屑槽 | 材质 | 刀尖圆角半径 RE | 切深 *ap* (mm) | 进给量 *f* (mm/rev) | 切削速度：Vc (m/min) | |
|---|---|---|---|---|---|---|
| | | | | | 灰铸铁 | 球墨铸铁 |
| CM | T505 | 0.4 | 0.05 - 2 | 0.05 - 0.2 | 180 - 700 | 180 - 400 |
| | T505 | 0.8 | 0.05 - 2 | 0.05 - 0.3 | 180 - 700 | 180 - 400 |
| | T505 | 1.2 | 0.05 - 2 | 0.05 - 0.3 | 180 - 700 | 180 - 400 |

# 刀片

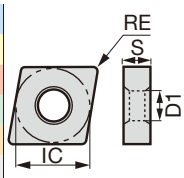
负前角型

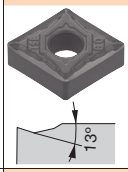
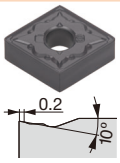
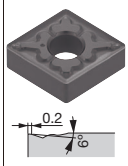
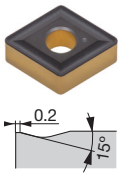
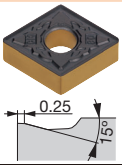
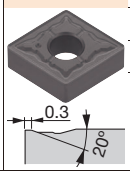
●：连续切削
ⓒ：轻断续切削
✠：强断续切削

## CN

菱形，80°
带内冷孔

| | | |
|---|---|---|
| P | 钢 | |
| M | 不锈钢 | |
| K | 铸铁 | ● ●ⓒ |
| N | 非铁金属 | |
| S | 超级合金 | |
| H | 硬材料 | |




| 应用 | 形状 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 精加工 | TSF | CNMG120404-TSF | | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| |  | CNMG120408-TSF | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412-TSF | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| 精加工到半精加工（修光刃） | SW | CNMG120408-SW | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| |  | CNMG120412-SW | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | * 修光刃 | | | | | | |
| 半精加工 | TM | CNMG090404E-TM | | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| |  | CNMG090408E-TM | | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | CNMG090412E-TM | | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| | | CNMG120404-TM | | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | CNMG120408-TM | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412-TM | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | CNMG120416-TM | | ● | 1.6 | 12.7 | 4.76 | 5.16 |
| | 全周 | CNMG120404 | ● | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| |  | CNMG120408 | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412 | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | CNMG120416 | ● | ● | 1.6 | 12.7 | 4.76 | 5.16 |
| | | CNMG160612 | | ● | 1.2 | 15.875 | 6.35 | 6.35 |
| | | CNMG160616 | | ● | 1.6 | 15.875 | 6.35 | 6.35 |
| | | CNMG190612 | | ● | 1.2 | 19.05 | 6.35 | 7.93 |
| | | CNMG190616 | | ● | 1.6 | 19.05 | 6.35 | 7.93 |
| | CM | CNMG120404-CM | ● | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| |  | CNMG120408-CM | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412-CM | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | CNMG160612-CM | | ● | 1.2 | 15.875 | 6.35 | 6.35 |
| 中至重载加工 | TH | CNMG120408-TH | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| |  | CNMG120412-TH | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | CNMG120416-TH | | ● | 1.6 | 12.7 | 4.76 | 5.16 |

●: 新
●: 阵容

# 刀片

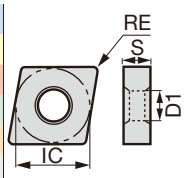
负前角型

●：连续切削
ⓒ：轻断续切削
✠：强断续切削

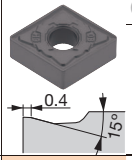
## CN

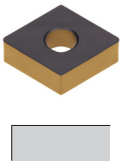
菱形，80°
带内冷孔

| | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |




| 应用 | 形状 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 中至重载加工 | CH | CNMG120408-CH | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMG120412-CH | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| 精加工到半精加工 | - | CNMA090404E | | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| | | CNMA090408E | | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | CNMA090412E | | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| | | CNMA090416E | | ● | 1.6 | 9.525 | 4.76 | 3.81 |
| | | CNMA120408 | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | CNMA120412 | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | CNMA160612 | | ● | 1.2 | 15.875 | 6.35 | 6.35 |
| | | CNMA160616 | | ● | 1.6 | 15.875 | 6.35 | 6.35 |
| | | CNMA190612 | | ● | 1.2 | 19.05 | 6.35 | 7.93 |
| | | CNMA190616 | | ● | 1.6 | 19.05 | 6.35 | 7.93 |



●: 新
●: 阵容

## 刀片

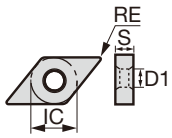
负前角型

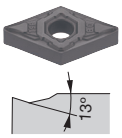
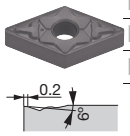
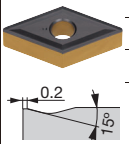
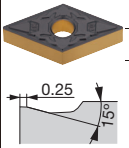
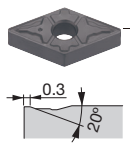
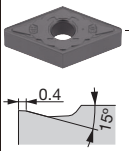
●：连续切削
ⓒ：轻断续切削
✠：强断续切削

# DN

55°菱形
带内冷孔

| | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |




| 应用 | 形状 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 精加工 | TSF | DNMG150404-TSF | | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | DNMG150408-TSF | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | DNMG150412-TSF | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| |  | | | | | | | |
| 半精加工 | TM | DNMG150404-TM | | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | DNMG150408-TM | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | DNMG150412-TM | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | DNMG150416-TM | | ● | 1.6 | 12.7 | 4.76 | 5.16 |
| |  | | | | | | | |
| | 全周 | DNMG150408 | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | DNMG150412 | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | DNMG150608 | ● | ● | 0.8 | 12.7 | 6.35 | 5.16 |
| | | DNMG150612 | ● | ● | 1.2 | 12.7 | 6.35 | 5.16 |
| |  | | | | | | | |
| | CM | DNMG150404-CM | ● | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | DNMG150408-CM | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | DNMG150412-CM | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| |  | | | | | | | |
| 中至重载加工 | TH | DNMG150408-TH | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | DNMG150412-TH | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| |  | | | | | | | |
| | CH | DNMG150408-CH | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | DNMG150412-CH | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| |  | | | | | | | |
| 半精加工到精加工 | - | DNMA110404E | | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| | | DNMA110408E | | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | DNMA110412E | | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| | | DNMA150404 | ● | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | DNMA150408 | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | DNMA150604 | ● | ● | 0.4 | 12.7 | 6.35 | 5.16 |
| | | DNMA150608 | ● | ● | 0.8 | 12.7 | 6.35 | 5.16 |

●: 新
●: 阵容

# T505
TUNGALOY

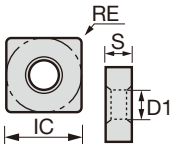
## 刀片 负前角型

●：连续切削
ⓒ：轻断续切削
✠：强断续切削

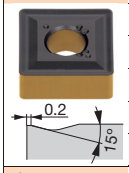
# SN

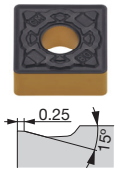
方形，90°
带内冷孔

| | | | |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |




| 应用 | 形状 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工 | 全周 | SNMG090304 | | ● | 0.4 | 9.525 | 3.18 | 3.81 |
| | | SNMG090308 | | ● | 0.8 | 9.525 | 3.18 | 3.81 |
| | | SNMG120404 | | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | SNMG120408 | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | SNMG120412 | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | SNMG120416 | | ● | 1.6 | 19.05 | 6.35 | 7.93 |
| | CM | SNMG120408-CM | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | SNMG120412-CM | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| 半精加工到精加工 | - | SNMA120408 | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | SNMA120412 | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |



●: 新
●: 阵容

## 刀片

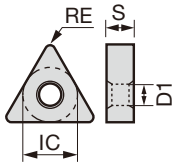
负前角型

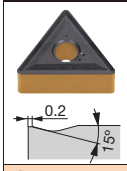
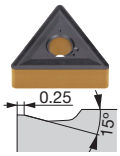
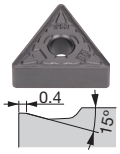
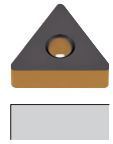
●：连续切削
ⓒ：轻断续切削
✠：强断续切削

# TN

三角形，60°
带内冷孔

| | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |




| 应用 | 形状 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工 | 全周 | TNMG160404 | ● | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| |  | TNMG160408 | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | TNMG160412 | ● | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| | CM | TNMG160404-CM | ● | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| |  | TNMG160408-CM | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | TNMG160412-CM | ● | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| 中至重载加工 | CH | TNMG160404-CH | | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| |  | TNMG160408-CH | | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | TNMG160412-CH | | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| 半精加工到精加工 | - | TNMA110404E | | ● | 0.4 | 6.35 | 4.76 | 2.26 |
| |  | TNMA110408E | | ● | 0.8 | 6.35 | 4.76 | 2.26 |
| | | TNMA110412E | | ● | 1.2 | 6.35 | 4.76 | 2.26 |
| | | TNMA160404 | ● | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| | | TNMA160408 | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | TNMA160412 | ● | ● | 1.2 | 9.525 | 4.76 | 3.81 |

●: 新
●: 阵容

# 刀片

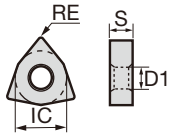
负前角型

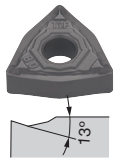
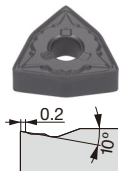
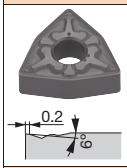
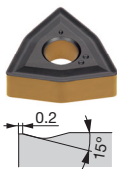
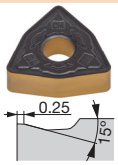
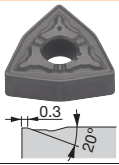
●：连续切削
ⓒ：轻断续切削
✠：强断续切削

## WN

凸三角形，80度带孔

| | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |




| 应用 | 形状 | 型号 | T505 | T515 | RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 精加工 | TSF  | WNMG080404-TSF | | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | WNMG080408-TSF | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | WNMG080412-TSF | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| 精加工到半精加工（修光刃） | SW  | WNMG080408-SW | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | WNMG080412-SW | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | * 修光刃 | | | | | | |
| 半精加工 | TM  | WNMG080404-TM | | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | WNMG080408-TM | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | WNMG080412-TM | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | WNMG080416-TM | | ● | 1.6 | 12.7 | 4.76 | 5.16 |
| | 全周  | WNMG080404 | ● | ● | 0.4 | 12.7 | 4.76 | 5.16 |
| | | WNMG080408 | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | WNMG080412 | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | WNMG080416 | ● | ● | 1.6 | 12.7 | 4.76 | 5.16 |
| | CM  | WNMG080408-CM | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | WNMG080412-CM | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| 中至重载加工 | TH  | WNMG080408-TH | | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | WNMG080412-TH | | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | WNMG080416-TH | | ● | 1.6 | 12.7 | 4.76 | 5.16 |

●: 新
●: 阵容

## 刀片

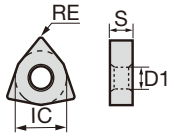
负前角型

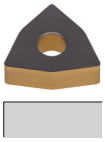
●：连续切削
ⓒ：轻断续切削
✠：强断续切削

# WN

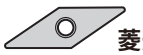
凸三角形，80度带孔

| | | | |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |



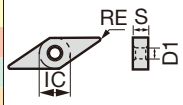

| 应用 | 形状 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工 精加工到 | - | WNMA060404E | | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| |  | WNMA060408E | | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | WNMA060412E | | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| | | WNMA060416E | | ● | 1.6 | 9.525 | 4.76 | 3.81 |
| | | WNMA080408 | ● | ● | 0.8 | 12.7 | 4.76 | 5.16 |
| | | WNMA080412 | ● | ● | 1.2 | 12.7 | 4.76 | 5.16 |
| | | WNMA080416 | ● | ● | 1.6 | 12.7 | 4.76 | 5.16 |

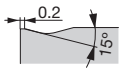
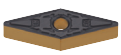
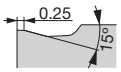
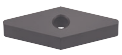
# VN



菱形，35°带孔

| | | | |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |




| 应用 | 断屑槽 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工 | 全周 | VNMG160404 | ● | ● | 0.4 | 9.525 | 4.76 | 3.81 |
| | | VNMG160408 | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| | | VNMG160412 | ● | ● | 1.2 | 9.525 | 4.76 | 3.81 |
| |   | | | | | | | |
| | CM | VNMG160408-CM | ● | ● | 0.8 | 9.525 | 4.76 | 3.81 |
| |  | | | | | | | |
| |   | | | | | | | |
| 半精加工 精加工到 | - | VNMA120404E | | ● | 0.4 | 7.15 | 4.76 | 3.81 |
| |  | VNMA120408E | | ● | 0.8 | 7.15 | 4.76 | 3.81 |

●: 新
●: 阵容

# 刀片

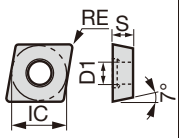
正前角型

●：连续切削
ⓒ：轻断续切削
✠：强断续切削

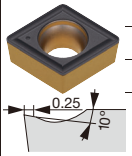
## CC

菱形，80°
带内冷孔
7°正前角

| | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |



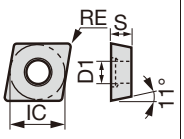

| 应用 | 形状 | 型号 | T505 | T515 | RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工到精加工 | CM | CCMT060204-CM | ● | ● | 0.4 | 6.35 | 2.38 | 2.8 |
| | | CCMT060208-CM | ● | ● | 0.8 | 6.35 | 2.38 | 2.8 |
| | | CCMT09T304-CM | ● | ● | 0.4 | 9.525 | 3.97 | 4.4 |
| | | CCMT09T308-CM | ● | ● | 0.8 | 9.525 | 3.97 | 4.4 |



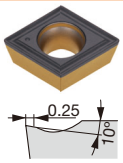

## CP

菱形，80°
带内冷孔
11°正前角

| | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |




| 应用 | 断屑槽 | 型号 | T505 | T515 | RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工到精加工 | CM | CPMT090304-CM | ● | ● | 0.4 | 9.525 | 3.18 | 4.4 |
| | | CPMT090308-CM | ● | ● | 0.8 | 9.525 | 3.18 | 4.4 |
| | | CPMT09T304-CM | ● | ● | 0.4 | 9.525 | 3.97 | 4.4 |
| | | CPMT09T308-CM | ● | ● | 0.8 | 9.525 | 3.97 | 4.4 |




●: 新
●: 阵容

## 刀片

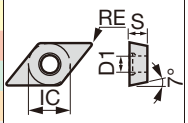
正前角型

●：连续切削
ⓒ：轻断续切削
✠：强断续切削

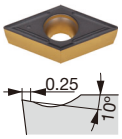
# DC

55°菱形
带内冷孔
7°正前角

| | |
|---|---|
| P | 钢 |
| M | 不锈钢 |
| K | 铸铁 |
| N | 非铁金属 |
| S | 超级合金 |
| H | 硬材料 |



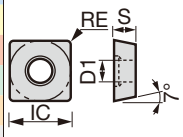

| 应用 | 形状 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工到精加工 | CM | DCMT11T304-CM | ● | ● | 0.4 | 9.525 | 3.97 | 4.4 |
| | | DCMT11T308-CM | ● | ● | 0.8 | 9.525 | 3.97 | 4.4 |



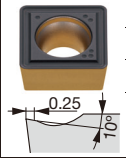

# SC

方形，90°
带内冷孔
7°正前角

| | |
|---|---|
| P | 钢 |
| M | 不锈钢 |
| K | 铸铁 |
| N | 非铁金属 |
| S | 超级合金 |
| H | 硬材料 |




| 应用 | 断屑槽 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工到精加工 | CM | SCMT09T304-CM | ● | ● | 0.4 | 9.525 | 3.97 | 4.4 |
| | | SCMT09T308-CM | ● | ● | 0.8 | 9.525 | 3.97 | 4.4 |
| | | SCMT120404-CM | ● | ● | 0.4 | 12.7 | 4.76 | 5.5 |
| | | SCMT120408-CM | ● | ● | 0.8 | 12.7 | 4.76 | 5.5 |




●: 新
●: 阵容

# T505

TUNGALOY

## 刀片

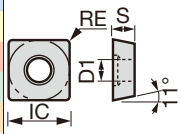
正前角型

●：连续切削
ⓒ：轻断续切削
✠：强断续切削

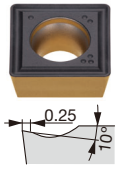
### SP

方形，90°
带内冷孔
11°正前角

| | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |



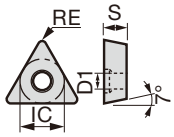

| 应用 | 形状 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工到精加工 | CM | SPMT120404-CM | ● | ● | 0.4 | 12.7 | 4.76 | 5.5 |
| | | SPMT120408-CM | ● | ● | 0.8 | 12.7 | 4.76 | 5.5 |



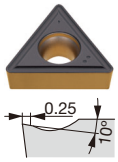

### TC

三角形，60°
带内冷孔
7°正前角

| | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |




| 应用 | 断屑槽 | 型号 | 涂层 T505 | 涂层 T515 | 尺寸 (mm) RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工到精加工 | CM | TCMT16T304-CM | ● | ● | 0.4 | 9.525 | 3.97 | 4.4 |
| | | TCMT16T308-CM | ● | ● | 0.8 | 9.525 | 3.97 | 4.4 |
| | | TCMT16T312-CM | ● | ● | 1.2 | 9.525 | 3.97 | 4.4 |



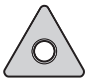

●: 新
●: 阵容

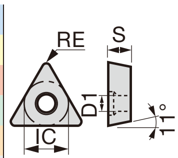
● : 连续切削
◐ : 轻断续切削
✠ : 强断续切削

# 刀片 正前角型

## TP

三角形，60°
带内冷孔
11°正前角

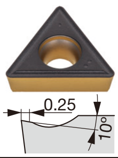





| 材料 | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●◐ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |

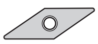
| 应用 | 形状 | 型号 | T505 | T515 | RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工到精加工 | PM | TPMT16T304-CM | 🔴 | ● | 0.4 | 9.525 | 3.97 | 4.4 |
| | | TPMT16T308-CM | 🔴 | ● | 0.8 | 9.525 | 3.97 | 4.4 |
| | | TPMT16T312-CM | 🔴 | ● | 1.2 | 9.525 | 3.97 | 4.4 |

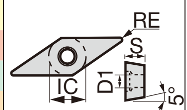
涂层 / 尺寸 (mm)




## VB

35°菱形
带内冷孔
5°正前角

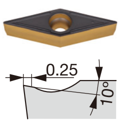





| 材料 | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●◐ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |

| 应用 | 断屑槽 | 型号 | T505 | T515 | RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工到精加工 | CM | VBMT160404-CM | 🔴 | ● | 0.4 | 9.525 | 4.76 | 4.4 |
| | | VBMT160408-CM | 🔴 | ● | 0.8 | 9.525 | 4.76 | 4.4 |
| | | VBMT160412-CM | 🔴 | ● | 1.2 | 9.525 | 4.76 | 4.4 |

涂层 / 尺寸 (mm)




🔴: 新
●: 阵容

# T505

TUNGALOY

## 刀片

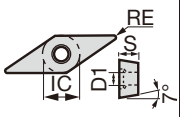
正前角型

●：连续切削
ⓒ：轻断续切削
✠：强断续切削

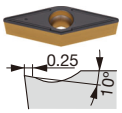
# VC

**35°菱形**
**带内冷孔**
**7°正前角**

| | | T505 | T515 |
|---|---|---|---|
| P | 钢 | | |
| M | 不锈钢 | | |
| K | 铸铁 | ● | ●ⓒ |
| N | 非铁金属 | | |
| S | 超级合金 | | |
| H | 硬材料 | | |



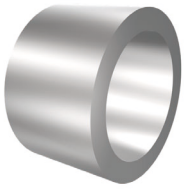
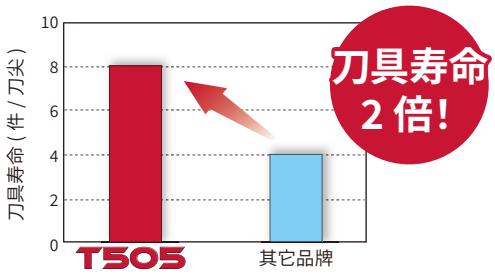
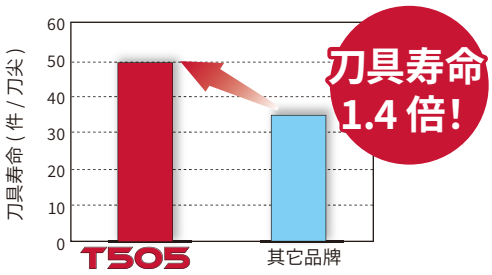

| 应用 | 形状 | 型号 | 涂层 T505 | 涂层 T515 | RE | IC | S | D1 |
|---|---|---|---|---|---|---|---|---|
| 半精加工到精加工 | CM | VCMT160404-CM | ● | ● | 0.4 | 9.525 | 4.76 | 4.4 |
| | | VCMT160408-CM | ● | ● | 0.8 | 9.525 | 4.76 | 4.4 |

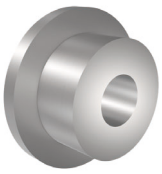
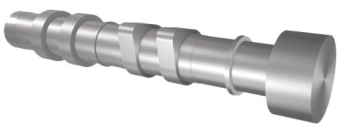
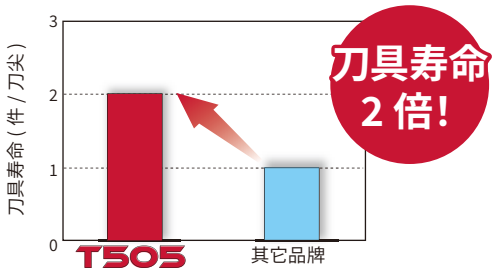
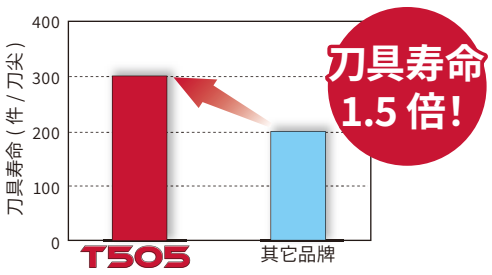



尺寸 (mm)

●: 新
●: 阵容

## 实例

| 工件类型 | | 飞轮 | 环形件 |
|---|---|---|---|
| 刀片 | | CNMG120408 | CNMG120408-CM |
| 材质 | | T505 | T505 |
| 工件材料 | | FC300 / GG30 / 300 | FCD500 |
| | | |  |
| 加工条件 | 切削速度：Vc（m/min） | 200 | 100 |
| | 进给：f (*mm*/rev) | 0.25 | 0.5 |
| | 切深：ap(mm) | 3 | 2 |
| | 加工 | 内孔和端面车削 | 外圆车削 |
| | 冷却方式 | 湿式 | 干切 |
| 结果 | |  <br>T505每个刀尖加工8个零件，刀具寿命加倍。 |  <br>T505每个刀尖加工50个零件，刀具寿命增加1.4倍。 |

| 工件类型 | | 汽车零部件 | 凸轮轴 |
|---|---|---|---|
| 刀片 | | CNMA120408 | DNMG150408 |
| 材质 | | T505 | T505 |
| 工件材料 | | FCD500 | FCD700 |
| | |  |  |
| 加工条件 | 切削速度：Vc（m/min） | 426 | 150 - 200 |
| | 进给：f (*mm*/rev) | 0.3 | 0.2 - 0.35 |
| | 切深：ap(mm) | 3 | 1 |
| | 加工 | 外圆车削 | 外圆、端面车削 |
| | 冷却方式 | 湿式 | 干切 |
| 结果 | |  <br>T505每个刀尖加工2个零件，刀具寿命加倍。 |  <br>T505每个刀尖加工300个零件，刀具寿命是竞争对手的1.5倍。 |

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