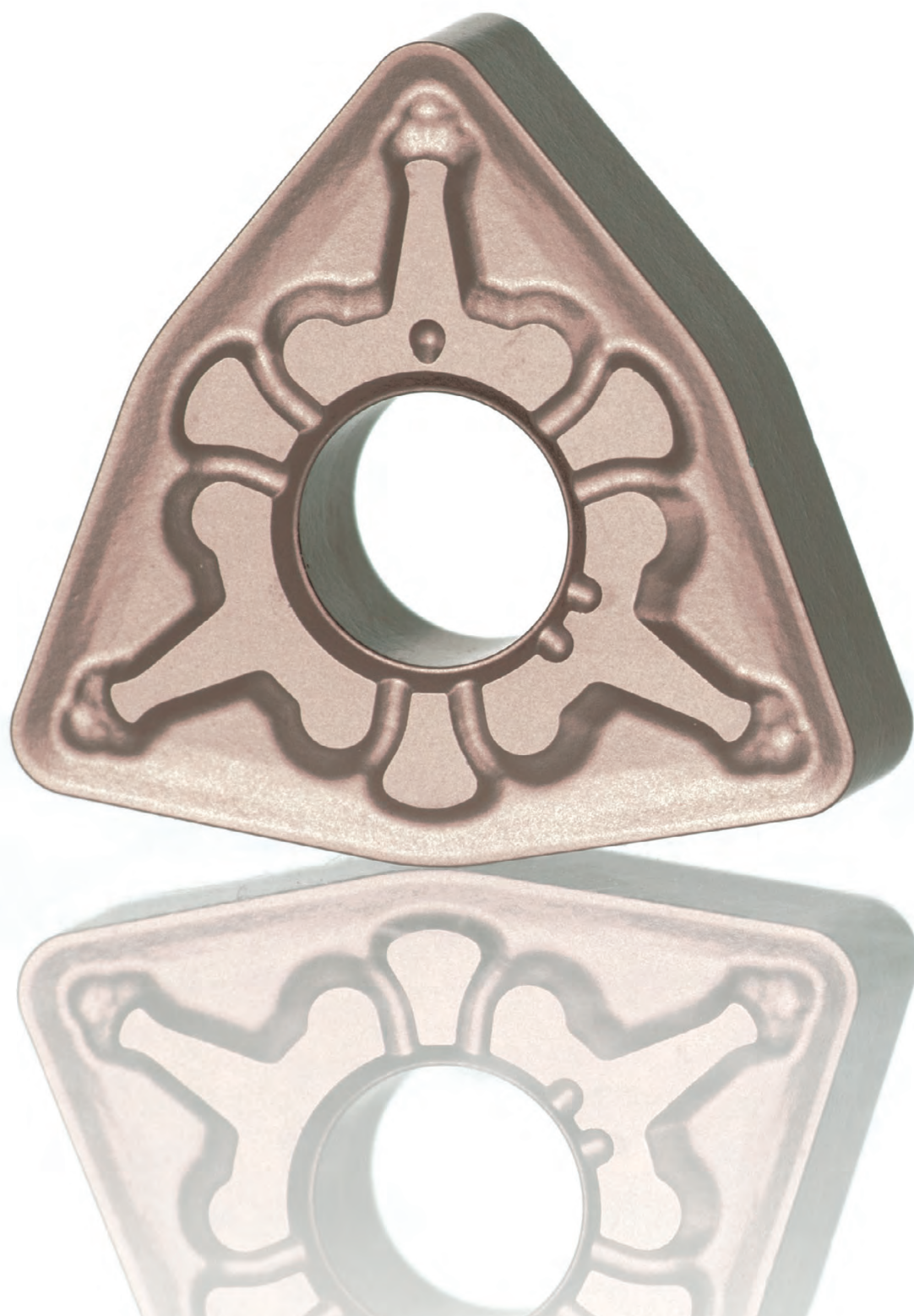


刀片



刀片 - 内容

- 刀片分组为正前角型，负前角型，CBN 和 PCD。
- 名单是按字母顺序排列的。
- 名单是按字母顺序排列的 C (80°) → D (55°) → R (360°) → S (90°) → T (60°) → V (35°) → W (80°) → Y (25°) → 其它形状
- 刀片的顺序
 - 负前角型 (每种形状都包含有孔和无孔)
 - 正前角型 (每种形状都包含有孔和无孔)
- 断屑槽的顺序
 - 从精密加工到重切削，按切削深度和进给速度的值顺序排列。
- 每个形状无断屑槽的刀片在最后一页
- 介绍了根据工件材料和工件形状提出的刀片方案。
- 典型断屑槽的标准切削条件在页底。
- 目录中的●描述了我们的标准库存产品，▲是指将来将停止销售的产品。

如何使用这个页面

方法①

在右侧选择刀片对象，在左侧根据刀片类型 (1) 和刀片的形状 (2) 选择对应的信息页。

方法②

从 B003 (1) 索引上查找每个刀片类型的页面，根据刀片的形状 (2) 选择设置信息页面。

The diagram illustrates the navigation process. On the left, a sidebar (1) lists blade types (CN, TF, D1, H, C, TSF, FW, AFW) and shapes (C, D, G, R, S, T, V, W, Y). The main content area (3) shows a table of blade types with their respective shapes and parameters. A detailed blade selection table (4) provides specific data for various blade types, including material, shape, and cutting conditions. The bottom right corner (10) shows a reference table for blade types and their corresponding product codes.

方法③

根据槽型介绍和 B006 - B029 的选择指南选择刀片，在产品页面查看详细信息。

This diagram details the selection of chip breakers. It includes a table of chip breaker types (TF, TM, THS) and their corresponding cutting conditions. The table lists parameters such as cutting speed (Vc), feed rate (Fz), and chip breaker type. The bottom right corner (10) shows a reference table for blade types and their corresponding product codes.

方法④

在 B030 - B053 的槽型列表中选择刀片，并检查每一页的详细信息。

This diagram details the selection of chip breakers. It includes a table of chip breaker types (TF, O1, A-D, W, TSF, FW, AFW) and their corresponding cutting conditions. The table lists parameters such as cutting speed (Vc), feed rate (Fz), and chip breaker type. The bottom right corner (10) shows a reference table for blade types and their corresponding product codes.

当订购时

- 请注明名称、材质和数量

例：CNMG120408-TM T9115...10片 (每个包装 10 个刀片)

* 如果每个包装的数量不是 10，你会看到一个注释。

刀片



负前角型

涂层硬质合金 CVD/PVD, 金属陶瓷, 不涂层硬质合金, 陶瓷

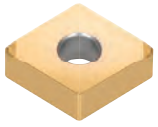
B054



正前角型

涂层硬质合金 CVD/PVD, 金属陶瓷, 不涂层硬质合金, 陶瓷

B109



CBN / PCD 刀片

CBN (T-CBN), PCD (T-DIA)

B165

刀片型号的表示方法

遵循“切削刀具可转位刀片 - 表示方法 (JIS B4120-1998 和 ISO 1832/AM1-1998)

代号	形状	刀尖角 (度)	图
H	正六边形	120°	
O	正八边形	135°	
P	正五边形	108°	
S	正方形	90°	
T	正三角形	60°	
C	菱形	80°	
D		55°	
E		75°	
F		50°	
G	G形 (泰珂洛自创规格)	70°	
M	菱形	86°	
V		35°	
Y	Y形 (泰珂洛自创规格)	25°	
W	六边形	80°	
L	长方形	90°	
A	平行四边形	85°	
B		82°	
K		55°	
R	圆形	-	

1 形状

注意：在菱形和平行四边形刀片中，小角为刀尖角。

代号	后角
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	其它
X	---



2 后角

代号 (级)	公差 (mm)		
	刀尖高 (M)	厚度 (S)	内切圆直径 (IC)
A	±0.005	±0.025	±0.025
F	±0.005	±0.025	±0.013
C	±0.013	±0.025	±0.025
H	±0.013	±0.025	±0.013
E	±0.025	±0.025	±0.025
G	±0.025	±0.13	±0.025
J	±0.005	±0.025	±0.005 ~ ±0.13
K	±0.013	±0.025	±0.05 ~ ±0.13
L	±0.025	±0.025	±0.05 ~ ±0.13
M	±0.08 ~ ±0.18	±0.13	±0.05 ~ ±0.13
N	±0.08 ~ ±0.18	±0.025	±0.05 ~ ±0.13
U	±0.13 ~ ±0.38	±0.13	±0.08 ~ ±0.25

3 精度

1
T

2
N

3
M

4
G

5
16

1
C

2
C

3
G

4
T

5
09

4 槽和孔代号				
代号	孔	孔形状	断屑槽	形状
N	无	-	无	
R			单-面	
F	双面			
A	有	圆柄孔	无	
M			单-面	
G	双面			
W	部分圆柱孔, 单面	无		
T	40° ~ 60° 埋头孔	单-面		
Q	部分圆柱孔, 双面	无		
U	40° ~ 60° 埋头孔	双面		
B	部分圆柱孔, 单面	无		
H	70° ~ 90° 埋头孔	单-面		
C	部分圆柱孔, 双面	无		
J	70° ~ 90° 埋头孔	双面		
X	---	---	---	---

5 切削刃长度和内切圆代号																
代号	R		S		C		W		T		D		V		K	内切圆直径
	长度	代号	长度	代号	长度	代号	长度	代号	长度	代号	长度	代号	长度	代号		
		03	3.97	03	4.0			06	6.9	04	4.8					3.97
		04	4.76	04	4.8			08	8.2	05	5.8	08	8.3			4.76
05	5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	5
		05	5.56	05	5.6	03	3.8	09	9.6	06	6.8					5.56
06	6	-	-	-	-	-	-	-	-	-	-	-	-	-	-	6
		06	6.35	06	6.5	04	4.3	11	11	07	7.8	11	11.2			6.35
08	8	-	-	-	-	-	-	-	-	-	-	-	-	-	-	7.94
09	9.525	09	9.525	09	9.7	06	6.5	16	16.5	11	11.6	16	16.6	16	19.7	9.525
10	10	-	-	-	-	-	-	-	-	-	-	-	-	-	-	10
12	12	-	-	-	-	-	-	-	-	-	-	-	-	-	-	12
12	12.7	12	12.7	12	12.9	08	8.7	22	22	15	15.5	22	22.1			12.7
15	15.875	15	15.875	16	16.1	10	10.9	27	27.5	19	19.4					15.875
16	16	-	-	-	-	-	-	-	-	-	-	-	-	-	-	16
19	19.05	19	19.05	19	19.3	13	13	33	33	23	23.3					19.05
20	20	-	-	-	-	-	-	-	-	-	-	-	-	-	-	20
		22	22.225	22	22.6			38	38.5	27	27.1					22.225
25	25	-	-	-	-	-	-	-	-	-	-	-	-	-	-	25
25	25.4	25	25.4	25	25.8			44	44	31	31					25.4
31	31.75	31	31.75	32	32.2			55	55	38	38.8					31.75
32	32	-	-	-	-	-	-	-	-	-	-	-	-	-	-	32

*名称中含有 M0 表明内切圆直径为公制尺寸。

(mm)

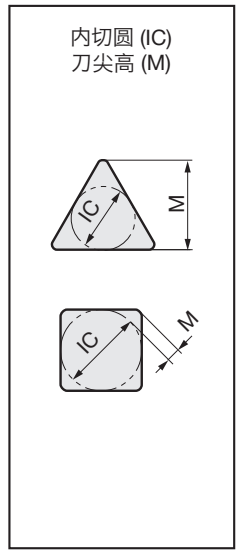
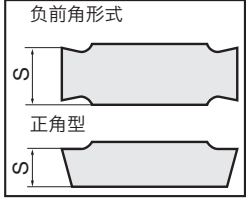
J、K、L、M、N 和 U 级不同形状尺寸的精度
刀尖角超过 55° 的刀片

内切圆	内切圆直径 (IC) 的公差		刀尖高 (M) 的公差		适用刀片形状
	J,K,L,M,N (级)	U (级)	J,K,L,M,N (级)	U (级)	
6.35	±0.05	±0.08	±0.08	±0.13	
9.525					
12.7	±0.08	±0.13	±0.13	±0.2	
15.875	±0.1	±0.18	±0.15	±0.27	
19.05					
25.4	±0.13	±0.25	±0.18	±0.38	
31.75	±0.15	±0.25	±0.2	±0.38	
32					

刀尖角为 55° 的 M 级刀片 (形状 :D)、
35° (形状 :V)、25° (形状 :Y) 的 M 级刀片

内切圆	内切圆直径 (IC) 的公差		刀尖高 (M) 的公差		适用刀片形状
	J,K,L,M,N (级)	U (级)	J,K,L,M,N (级)	U (级)	
6.35	±0.05	±0.08	±0.11	±0.15	D
9.525					
12.7	±0.08	±0.13	±0.15	±0.2	
15.875	±0.1	±0.18	±0.15	±0.27	
19.05					
6.35	±0.05	±0.08	±0.16	±0.2	V
9.525					Y

● 有关刀片厚度的注意事项
对于带断屑槽的刀片，刀尖位置的刀片高度更低。在这种情况下，图纸中刀片厚度轮廓的外形尺寸与右图中的“S”相等。



代号	厚度 (mm)
X1	1.39
01	1.59
T1	1.98(1.79)
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35
07	7.94
09	9.52

厚度

示例

6 04 08 - TM

6 7 8 9 10 T3 04 F N - JS

(任意代号) (任意代号) (补充代号)

7 刀尖圆角半径	
代号	刀尖圆角半径 RE (mm)
00	0.03
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
28	2.8
32	3.2

8 主切削刃形状代号		
代号	刀尖	形状
F	形状	
E	圆弧刃	
W.T	负倒棱角	
S	结合	

9 刀片方向代号	
代号	方向
R	右手
L	左手
N	中置

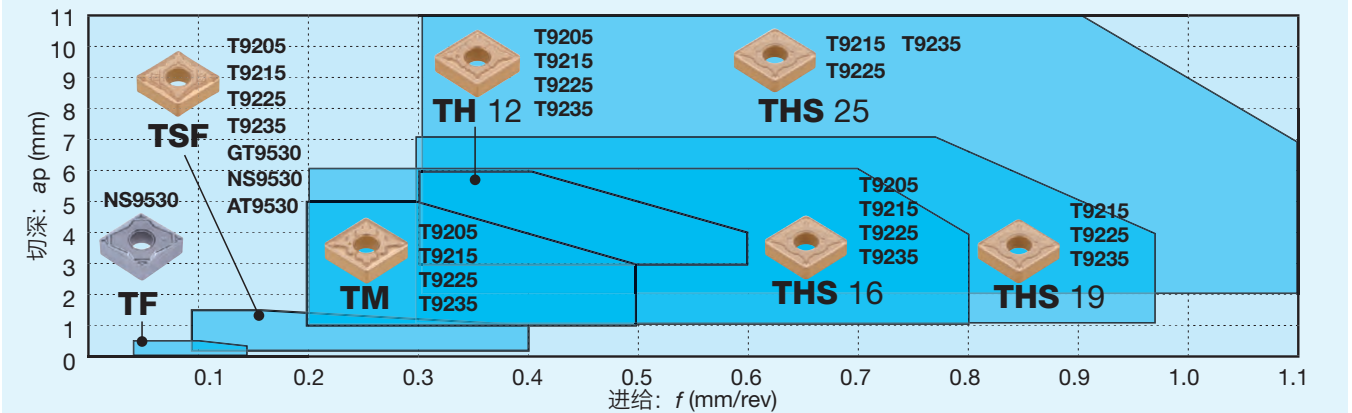
10 断屑槽			
代号	应用	代号	应用
01(TF)	精密切削 (基本选择)	AFW	小切深、大进给 (修光刃型刀片)
TS	精切削 (基本选择)	ASW	小切深、大进给 (修光刃型刀片)
TSF	精切削 (基本选择)	CB	半精加工
TM	半精切削 (基本选择)	CM	铸铁半精切削
THS	中至重载加工 (基本选择)	CS	半精加工
TRS	中至重载加工	A	精切削 (右手和左手)
TUS	重载加工	B	精切削 (右手和左手)
DM	半精加工	C	精切削 (右手和左手)
HRF	精加工	D	精切削 (右手和左手)
HRM	精加工到半精加工	P	铝合金精切削
HMM	精加工到半精加工	W	精切削 (导向型)
SF	不锈钢精切削	PSF	精切削 (正前角型)
SS	不锈钢和软钢精切削	PSS	精加工到轻切削 (正角刀片)
SM	不锈钢半精切削	PS	精加工到半精加工 (正前角型基本选择)
S	不锈钢半精切削	PM	半精切削 (正前角型)
SH	不锈钢半精 ~ 强力切削	AL	铝合金精切削 ~ 半精切削
SA	耐热合金和不锈钢	RS	半精切削 (圆刀片)
ZF	精切削和仿形切削	W□□	精切削 (导向型)
ZM	精切削 ~ 半精切削和仿形加工	H□□	精切削到半精切削 (平行)
NS	精切削和仿形切削	11	精加工
NM	精切削 ~ 半精切削和仿形加工	61	小切深、大进给 (圆刀片)
AS	小切深、大进给	S1	精切削 (KNMX 型)
TA	半精加工	J08,J10	小型机床用
TQ	半精加工	JS	小型机床用
AM	小切深、大进给	JRP	小型机床用
FW	精切削 (修光刃型)	JPP	小型机床用
SW	精加工到半精加工 (修光刃型)	JSP	小型机床用

断屑槽介绍

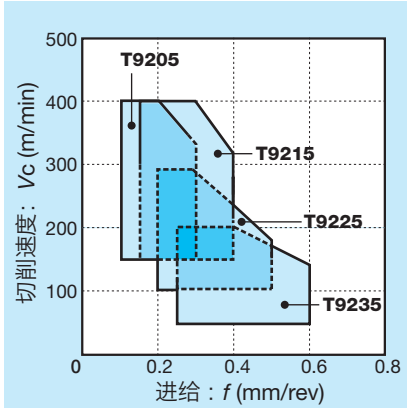
基本断屑槽：负前角刀片

P 钢

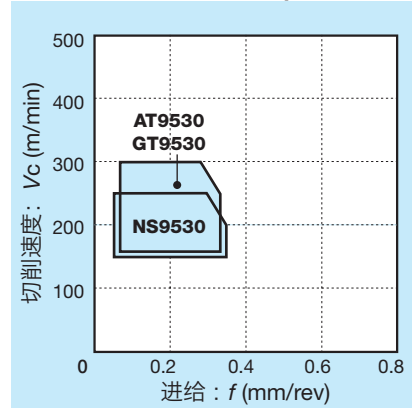
车削用断屑槽系统（负前角刀片）



CVD 涂层硬质合金材质



涂层硬质合金金属陶瓷 / 金属陶瓷



断屑槽	形状	特征
TF		锋利的切削刃以及刀尖附近抬起的突出部分有助于在极小切深、小进给时提供出众的排屑性能。属经济型 M 级公差规格、低成本。
TSF		钢材材料精切时的首选断屑槽。锋利的切削刃和靠近刀尖处的弧形突起确保了良好的切屑控制。

断屑槽	形状	特征
TM		常规断屑槽、用于半精切削。独一无二的断屑槽形状、锋利的切削刃和大前角设计可确保在众多切削条件下轻松切削。
TH		双面3D断屑槽、具有坚韧的切削刃和出色的切屑控制。甚至适用于大进给加工。
THS		在多种切深都具有出众的排屑性能。强壮的切削刃、适合进行断续和大进给加工。

标准加工参数

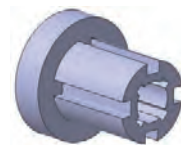
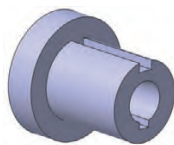
ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度：Vc (m/min)		
							低碳钢、 合金钢	中碳钢、 合金钢	高碳钢、 合金钢
P	精密加工	连续 ~ 弱断续	TF	NS9530	0.05 - 0.5	0.03 - 0.15	150 - 250	100 - 250	100 - 200
		连续 ~ 弱断续	TSF	GT9530	0.2 - 1.5	0.08 - 0.4	150 - 300	80 - 250	80 - 200
	精加工	连续 ~ 弱断续	TSF	AT9530	0.2 - 1.5	0.08 - 0.4	150 - 300	80 - 250	80 - 200
		强断续	TSF	T9225	0.2 - 1.5	0.08 - 0.4	120 - 300	120 - 300	100 - 250
		连续到强断续	TM	T9205	1 - 5	0.2 - 0.5	180 - 400	180 - 400	150 - 350
	半精切削	连续到强断续	TM	T9215	1 - 5	0.2 - 0.5	150 - 400	150 - 400	120 - 300
		连续到强断续	TM	T9225	1 - 5	0.2 - 0.5	120 - 300	120 - 300	100 - 250
		连续到强断续	TM	T9235	1 - 5	0.2 - 0.5	50 - 200	50 - 200	50 - 150
		连续到强断续	TH	T9205	3 - 6	0.3 - 0.6	180 - 400	180 - 400	150 - 350
		连续到强断续	TH	T9215	3 - 6	0.3 - 0.6	150 - 400	150 - 400	120 - 300
中到重载加工	连续到强断续	TH	T9225	3 - 6	0.3 - 0.6	120 - 300	120 - 300	100 - 250	
	连续到强断续	TH	T9235	3 - 6	0.3 - 0.6	50 - 200	50 - 200	50 - 150	

低碳钢、合金钢：S10C、SCM415、SS400、SCr420H 等 C10、18CrMo4、E275A、20Cr4 等 中碳钢、合金钢：S45C、SCM440 等 C45、42CrMo4 等 高碳钢、合金钢：SNM439 等 41CrNiMo2 等

选择系统

选择系统：负前角刀片

P 钢



连续

轻断续

强断续

精密加工 [$a_p = \sim 0.5 \text{ mm}$]	<p>基本</p>  <p>TF NS9530 B030</p> <p>崩损 → TSF GT9530 B030</p>	<p>基本</p>  <p>TF NS9530 B030</p> <p>崩损 → TSF GT9530 B030</p>		
	<p>基本</p>  <p>TSF GT9530 B030</p> <p>切屑控制 → ZF GT9530 B031</p>	<p>基本</p>  <p>TSF GT9530 B030</p> <p>崩损 → TSF T9215 B030</p>	<p>基本</p>  <p>TSF T9225 B030</p> <p>崩损 → TSF T9235 B030</p>	
	<p>基本</p>  <p>TM T9215 B032</p> <p>磨损 → TM T9205 B032</p> <p>切屑控制 → ZM T9215 B033</p>	<p>基本</p>  <p>TM T9225 B032</p> <p>崩损 → TM T9235 B032</p> <p>磨损 → TM T9215 B032</p>	<p>基本</p>  <p>TM T9235 B032</p> <p>崩损 → DM T9235 B033</p>	
	<p>基本</p>  <p>TH T9215 B036</p> <p>磨损 → TH T9205 B036</p> <p>切屑控制 → TM T9215 B032</p>	<p>基本</p>  <p>TH T9225 B036</p> <p>崩损 → TH T9235 B036</p> <p>磨损 → TH T9215 B036</p>	<p>基本</p>  <p>TH T9235 B036</p> <p>崩损 → TUS T9235 B037</p>	
中至重载加工 [$a_p = 3 \sim 6 \text{ mm}$]				

详细信息请见B***页。

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

用户指南

索引

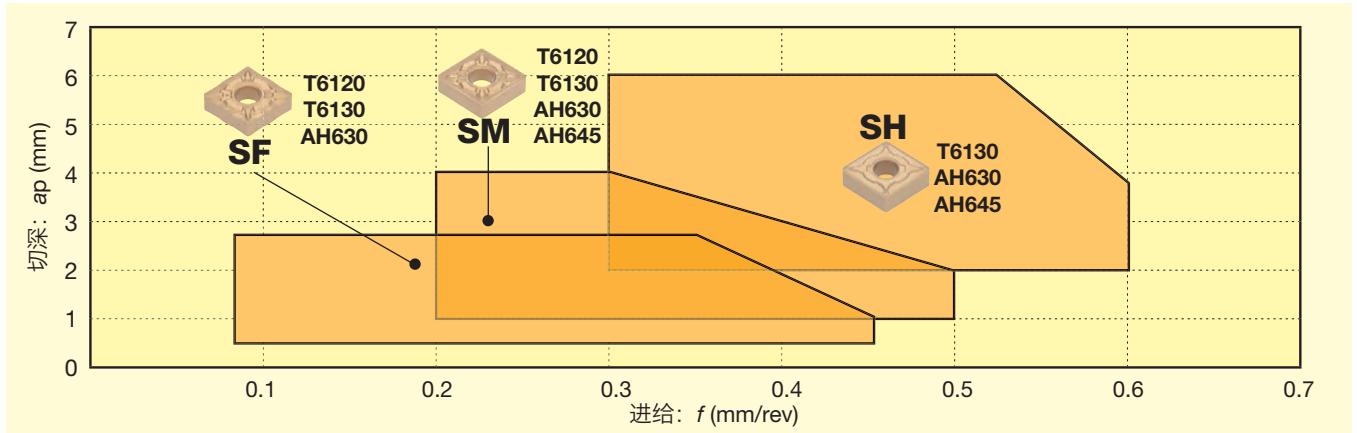


断屑槽介绍

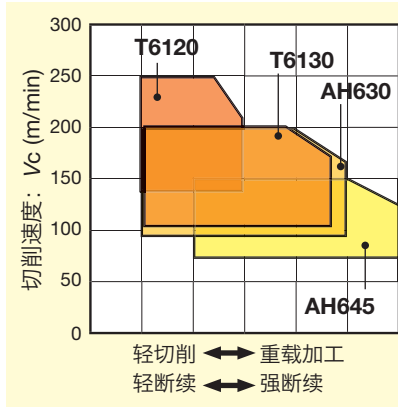
基本断屑槽：负前角刀片

M 不锈钢

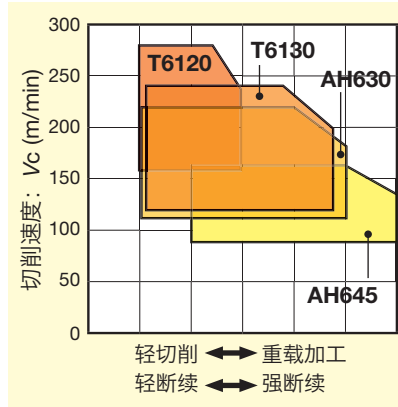
车削用断屑槽系统（负前角刀片）



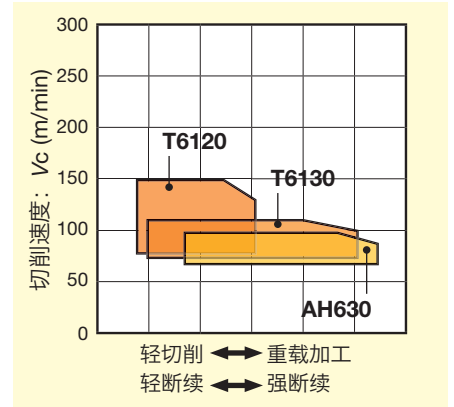
奥氏体不锈钢



铁素体 / 马氏体不锈钢



析出硬化不锈钢



断屑槽	形状	特征
SF		在小切深、大进给车削加工时具有出色的排屑性能。适用于不锈钢精加工。
SH		特别强化的刃口具有较高的抗崩损性、适用于中等到重型切削。强壮的切削刃、适合进行粗切削和断续切削。

断屑槽	形状	特征
SM		具有锋利的切削刃和良好的切屑控制、适合众多切削环境。不锈钢加工首选。

标准加工参数

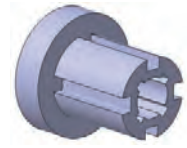
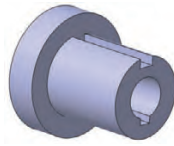
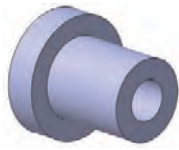
ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度 Vc (m/min)
M	精加工	连续	SF	T6120	0.5 - 2.5	0.08 - 0.45	140 - 240
		连续 ~ 弱断续	SF	T6130	0.5 - 2.5	0.08 - 0.45	100 - 200
		强断续	SF	AH630	0.5 - 2.5	0.08 - 0.45	90 - 190
	半精加工	连续	SM	T6120	1 - 4	0.2 - 0.5	140 - 240
		连续 ~ 弱断续	SM	T6130	1 - 4	0.2 - 0.5	100 - 200
		轻断续	SM	AH630	1 - 4	0.2 - 0.5	90 - 190
		强断续	SM	AH645	1 - 4	0.2 - 0.5	70 - 150
	中到重载加工	连续 ~ 弱断续	SH	T6130	2 - 6	0.3 - 0.6	100 - 200
		轻断续	SH	AH630	2 - 6	0.3 - 0.6	90 - 190
强断续		SH	AH645	2 - 6	0.3 - 0.6	70 - 150	

不锈钢: SUS304、SUS316 等 X5CrNi18-9、X5CrNiMo17-12-3 等

选择系统

选择系统：负前角刀片

M 不锈钢



连续

轻断续

强断续

精加工 $[a_p = 0.5 \sim 1.5 \text{ mm}]$	基本 SF T6120 B031	崩损 SF T6130 B031	基本 SF T6130 B031	崩损 SF AH630 B031	磨损 SF T6120 B031	基本 SF AH630 B031	崩损 SF AH645 B031	磨损 SF T6130 B031	
	半精加工 $[a_p = 1 \sim 4 \text{ mm}]$	基本 SM T6130 B035	磨损 SM T6120 B035	切屑控制 SF T6130 B031	基本 SM AH630 B035	崩损 SM AH645 B035	磨损 SM T6130 B035	基本 SM AH645 B035	崩损 SH AH645 B037
	中至重载加工 $[a_p = 2 \sim 6 \text{ mm}]$	基本 SH T6130 B037	崩损 SH AH630 B037	磨损 SH T6120 B037	切屑控制 SM T6130 B035	基本 SH AH630 B037	崩损 SH AH645 B037	磨损 SH T6130 B037	基本 SH AH645 B037

详细信息请见B***页。

材质

刀片

外圆刀杆

内孔刀杆

螺紋加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

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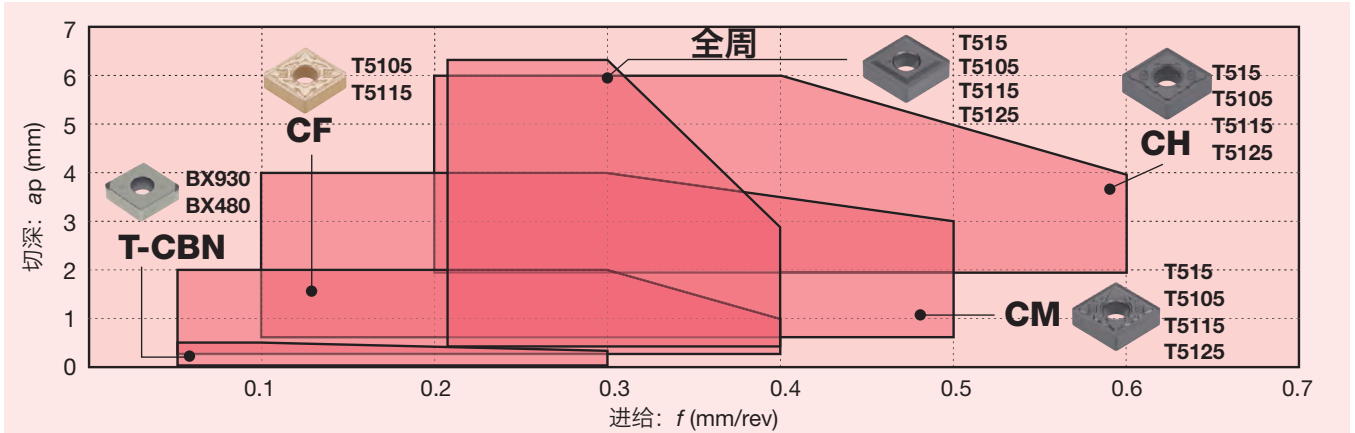


断屑槽介绍

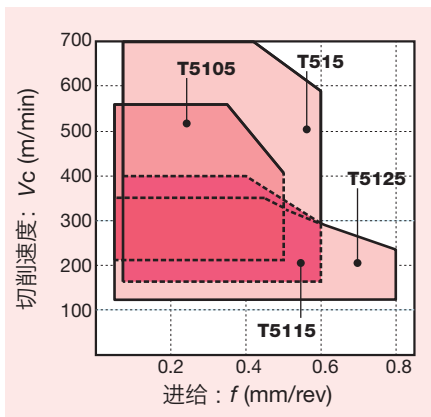
基本断屑槽：负前角刀片

K 铸铁

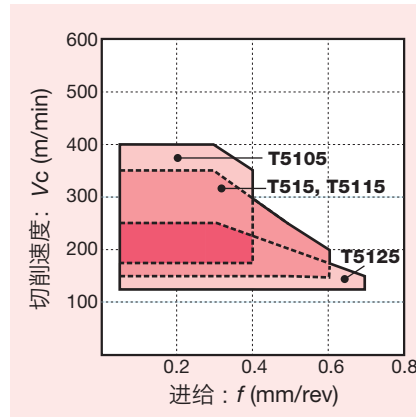
车削用断屑槽系统（负前角刀片）



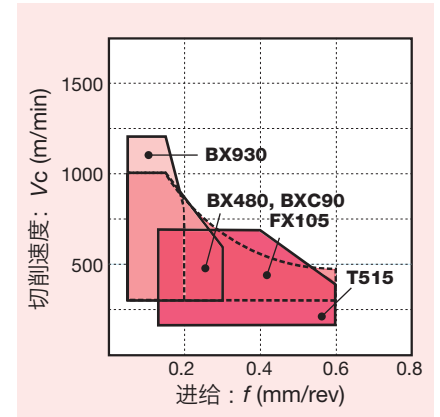
灰铸铁



球墨铸铁



高速切削: 适合加工灰口铸铁



断屑槽	形状	特征
无断屑槽 (T-CBN)		T-CBN 刀片。对铸铁进行高速精密切削时有着很好表现。
CF		低切削力断屑槽、适合切削铸铁。采用圆弧形的大前角实际前角 20°、可显著降低切削力、抑制薄壁组件的变形程度及减少毛刺。
全周		断屑槽极其可靠、适合在从连续切削到断续切削等众多加工方式下执行半精切削。

断屑槽	形状	特征
CM		铸铁加工首选。采用正前角刃带和大排屑槽、适应连续到断续广泛加工方式的万能断屑槽
CH		采用强化切削刃的断屑槽。采用刃带支撑和负前角刃带设计、强力切削条件下也能实现稳定的刀具嵌合性和切削刃强度。

标准加工参数

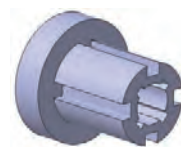
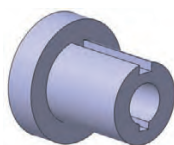
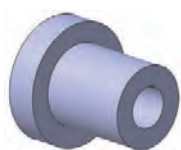
ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度: Vc (m/min)	
							灰铸铁	球墨铸铁
K	高速切削	连续	无	BX930	0.05 - 0.5	0.05 - 0.2	300 - 1200	100 - 500
		轻断续	无	BX480	0.05 - 0.5	0.05 - 0.3	300 - 1000	100 - 300
		连续	无	BXC90	0.08 - 3	0.05 - 0.4	300 - 1000	100 - 300
	精加工	连续	全周	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
		轻断续	全周	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
		强断续	全周	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
	半精加工	连续	全周	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
		轻断续	全周	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370
		强断续	CH	T515	3 - 6	0.2 - 0.6	150 - 700	140 - 370
中至重载加工	连续	全周	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370	
	轻断续	全周	T515	1 - 5	0.1 - 0.5	150 - 700	140 - 370	
	强断续	CH	T515	3 - 6	0.2 - 0.6	150 - 700	140 - 370	

灰口铸铁: FC250 等 250 等 球墨铸铁: FCD450 等 450-10S 等

选择系统

选择系统：负前角刀片

K 铸铁



连续

轻断续

强断续

加工类型	连续	轻断续	强断续
精加工 [$a_p = 0.5 \sim 2 \text{ mm}$]	<p>基本 → 磨损 → 全周 T5105 (B033)</p> <p>全周 T515 (B033) → 产生毛刺 → CF T5105 (B031)</p>	<p>基本 → 磨损 → 全周 T5105 (B033)</p> <p>全周 T515 (B033) → 崩损 → CH T515 (B037)</p> <p>全周 T515 (B033) → 产生毛刺 → CF T5115 (B031)</p>	<p>基本 → 磨损 → CH T5105 (B037)</p> <p>全周 T515 (B037) → 崩损 → CH T5125 (B037)</p> <p>CH T515 (B037) → 产生毛刺 → 全周 T515 (B033)</p>
半精加工 [$a_p = 1 \sim 5 \text{ mm}$]	<p>基本 → 磨损 → 全周 T5105 (B033)</p> <p>全周 T515 (B033) → 产生毛刺 → CF T5105 (B031)</p>	<p>基本 → 磨损 → 全周 T5105 (B033)</p> <p>全周 T515 (B033) → 崩损 → CH T515 (B037)</p> <p>全周 T515 (B033) → 产生毛刺 → CF T5115 (B031)</p>	<p>基本 → 磨损 → CH T5105 (B037)</p> <p>全周 T515 (B037) → 崩损 → CH T5125 (B037)</p> <p>CH T515 (B037) → 产生毛刺 → 全周 T515 (B033)</p>
中至重载加工 [$a_p = 3 \sim 6 \text{ mm}$]	<p>基本 → 磨损 → 全周 T5105 (B033)</p> <p>全周 T515 (B033) → 产生毛刺 → CF T5105 (B031)</p>	<p>基本 → 磨损 → 全周 T5105 (B033)</p> <p>全周 T515 (B033) → 崩损 → CH T515 (B037)</p> <p>全周 T515 (B033) → 产生毛刺 → CF T5115 (B031)</p>	<p>基本 → 磨损 → CH T5105 (B037)</p> <p>全周 T515 (B037) → 崩损 → CH T5125 (B037)</p> <p>CH T515 (B037) → 产生毛刺 → 全周 T515 (B033)</p>

详细信息请见B***页。

材质

刀片

外圆刀杆

内孔刀杆

螺旋加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

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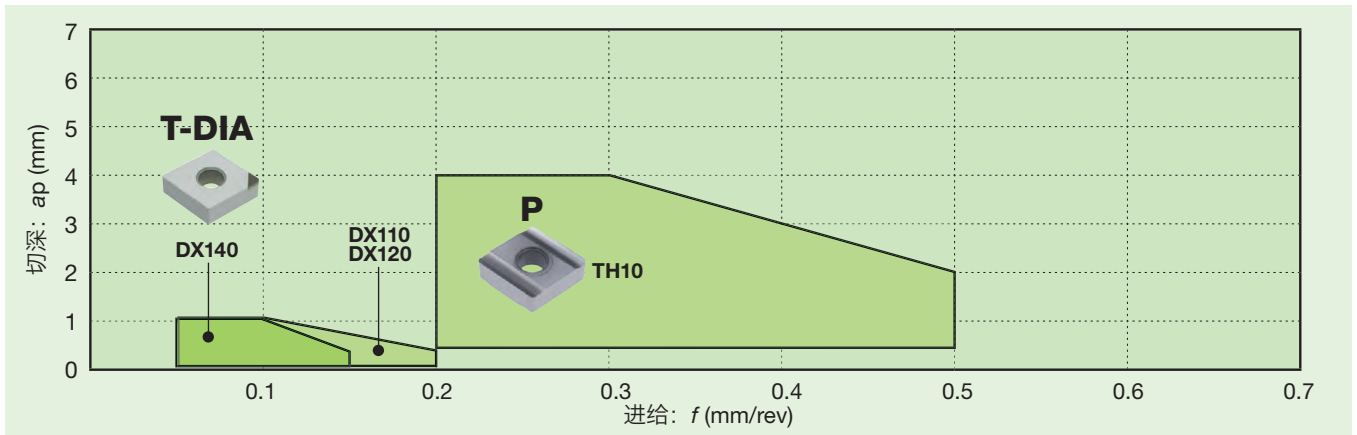


断屑槽介绍

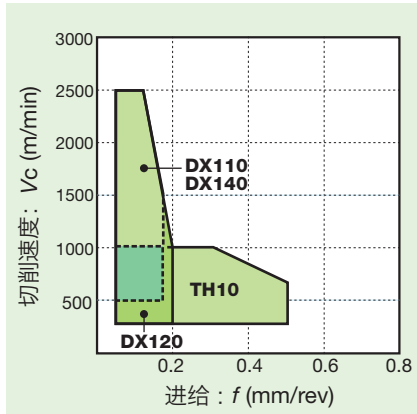
基本断屑槽：负前角刀片

N 非铁金属

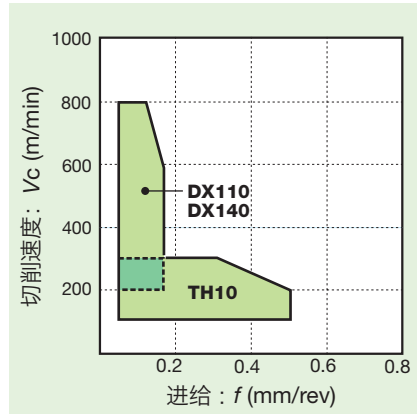
车削用断屑槽系统（负前角刀片）



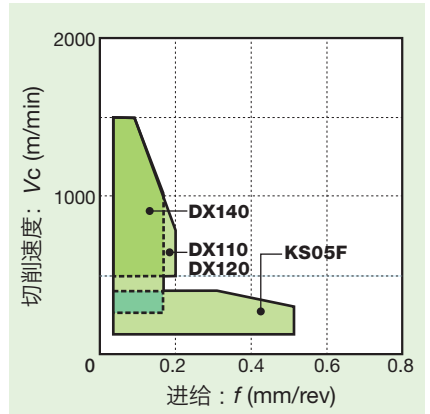
铝合金 (硅 < 12%)



铝合金 (硅 ≥ 12%)



铜合金



断屑槽	形状	特征
无断屑槽 (T-DIA)		对非铁金属材料进行高速精切削时有着很好的表现, 如铝合金和铜合金、刀尖上有金刚石烧结体。
P		拥有锋利的切削刃、能够有效地用于加工如铝合金和铜合金等非铁金属。

断屑槽	形状	特征
有断屑槽 (T-DIA)		宽断屑槽可提供出众的排屑性能。

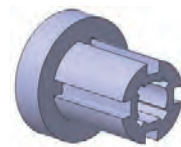
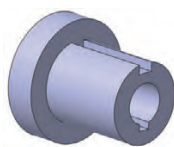
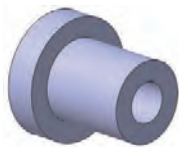
标准加工参数

ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度：Vc (m/min)		
							铝合金 (硅 < 12%)	铝合金 (硅 ≥ 12%)	铜合金
N	精密精加工	连续	有	DX110	0.05 - 0.5	0.05 - 0.15	500 - 2500	400 - 800	500 - 1500
		轻型断续	无	DX140	0.05 - 0.5	0.05 - 0.20	300 - 2500	-	500 - 1500
	精加工	连续	无	DX140	0.05 - 2	0.05 - 0.15	500 - 2500	400 - 800	500 - 1500
		轻型断续	无	DX140	0.05 - 2	0.05 - 0.15	300 - 1800	400 - 600	400 - 1200
		重型断续	P	TH10	0.5 - 4	0.2 - 0.5	100 - 500	100 - 200	100 - 200
	半精加工	连续	P	TH10	0.5 - 4	0.2 - 0.5	100 - 1000	100 - 300	100 - 300
		轻型断续	P	TH10	0.5 - 4	0.2 - 0.5	100 - 800	100 - 200	100 - 200
		重型断续	P	TH10	0.5 - 4	0.2 - 0.5	100 - 500	100 - 200	100 - 200

选择系统

选择系统：负前角刀片

N 非铁金属



连续

轻断续

强断续

精密加工 [$a_p = \sim 0.5 \text{ mm}$]	<p>基本</p>  <p>带断屑槽 DX110</p> <p>B192, B194</p> <p>磨损 → T-DIA DX140 B193, B195, B196</p>	<p>基本</p>  <p>T-DIA DX140</p> <p>B193, B195, B196</p> <p>表面质量 → 有断屑槽 T-DIA DX110 B192, B194</p> <p>磨损 → T-DIA DX160 B193, B196</p>		
	<p>基本</p>  <p>T-DIA DX140</p> <p>B193, B195, B196</p> <p>表面质量 → 有断屑槽 T-DIA DX110 B192, B194</p> <p>磨损 → T-DIA DX160 B193, B196</p>	<p>基本</p>  <p>T-DIA DX140</p> <p>B193, B195, B196</p> <p>崩损 → P TH10 B035</p> <p>磨损 → T-DIA DX160 B193, B196</p>	<p>基本</p>  <p>P TH10</p> <p>B035</p>	
	<p>基本</p>  <p>P TH10</p> <p>B035</p> <p>磨损 → T-DIA DX140 B193, B195, B196</p>	<p>基本</p>  <p>P TH10</p> <p>B035</p> <p>磨损 → T-DIA DX140 B193, B195, B196</p>	<p>基本</p>  <p>P TH10</p> <p>B035</p>	
半精加工 [$a_p = 1 \sim 4 \text{ mm}$]				

详细信息请见B***页。

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

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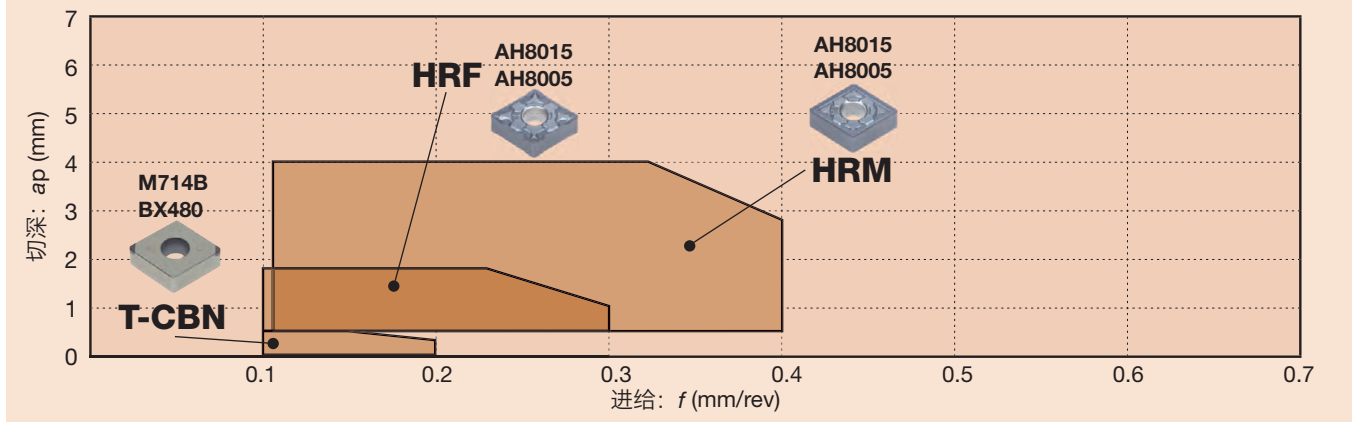
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断屑槽介绍

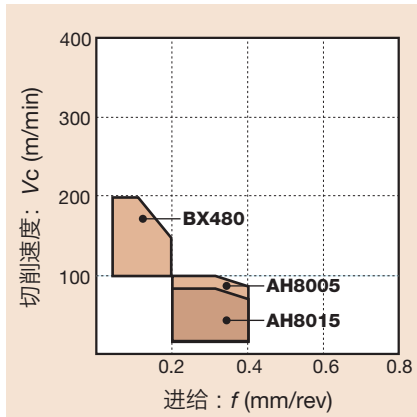
基本断屑槽：负前角刀片

S 耐热合金和钛合金

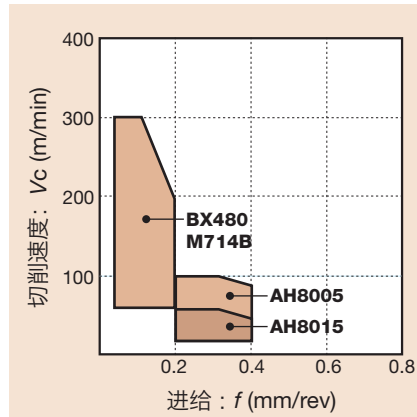
车削用断屑槽系统（负前角刀片）



钛合金



镍基合金



断屑槽	形状	特征
HRF		适合对耐热合金进行精切削。特别设计的突出部分在较小的切深具备出众的排屑性能。
HRM		耐热合金车削时的首选断屑槽。刃形经过优化、在各种切深都具备稳定的排屑性能。

断屑槽	形状	特征
无断屑槽 (T-CBN)		T-CBN 刀片。对耐热合金或钛合金进行精切削时有着很好表现。

标准加工参数

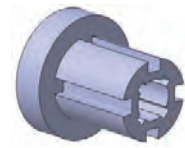
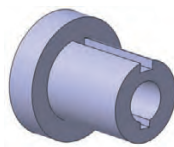
ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度: Vc (m/min)	
							钛合金	镍基合金
S	精密精加工	连续	无	BX480	0.1 - 0.5	0.05 - 0.2	100 - 200	70 - 300
			无	M714B	0.1 - 0.5	0.05 - 0.2	-	70 - 400
		轻断续	无	BX480	0.1 - 0.5	0.05 - 0.2	100 - 200	-
	精加工到半精加工	连续	HRF	AH8005	0.5 - 1.5	0.05 - 0.25	20 - 100	20 - 100
			HRF	AH8015	0.5 - 1.5	0.05 - 0.25	20 - 80	20 - 50
		强断续	HRF	AH8015	0.5 - 1.5	0.05 - 0.25	10 - 60	10 - 40
	半精加工	连续	HRM	AH8005	0.5 - 4	0.1 - 0.4	20 - 100	20 - 100
			HRM	AH8015	0.5 - 4	0.1 - 0.4	20 - 80	20 - 50
		强断续	HRM	AH8015	0.5 - 4	0.1 - 0.4	10 - 60	10 - 40

镍基合金: INCONEL718 等 钛合金: Ti-6Al-4V 等

选择系统

选择系统：负前角刀片

S 耐热合金和钛合金



连续

轻断续

强断续

精密加工 [$a_p = \sim 0.5 \text{ mm}$]	<p>基本</p> <p>T-CBN BX470 M714B</p> <p>B170 - B190</p>	<p>基本</p> <p>T-CBN BX470</p> <p>B170 - B190</p> <p>崩损 → 无断屑槽 TH10 B038</p>	
	<p>基本</p> <p>HRF AH8005</p> <p>B031</p> <p>崩损 → HRF AH8015 B031</p> <p>切屑控制 → 28 AH8005 B034</p>	<p>基本</p> <p>HRF AH8015</p> <p>B031</p> <p>崩损 → HRM AH8015 B035</p> <p>磨损 → HRF AH8005 B031</p> <p>切屑控制 → 28 AH8015 B034</p>	<p>基本</p> <p>HRF AH8015</p> <p>B031</p> <p>崩损 → HRM AH8015 B035</p> <p>磨损 → HRF AH8005 B031</p>
	<p>基本</p> <p>HRM AH8005</p> <p>B035</p> <p>崩损 → HRM AH8015 B035</p> <p>产生毛刺 → HRF AH8015 B031</p> <p>切屑控制 → 28 AH8005 B034</p>	<p>基本</p> <p>HRM AH8015</p> <p>B035</p> <p>崩损 → SM AH630 B035</p> <p>磨损 → HRM AH8005 B035</p> <p>切屑控制 → 28 AH8015 B034</p>	<p>基本</p> <p>HRM AH8015</p> <p>B035</p> <p>崩损 → SM AH630 B035</p> <p>磨损 → HRF AH8005 B031</p>

详细信息请见B***页。

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

用户指南

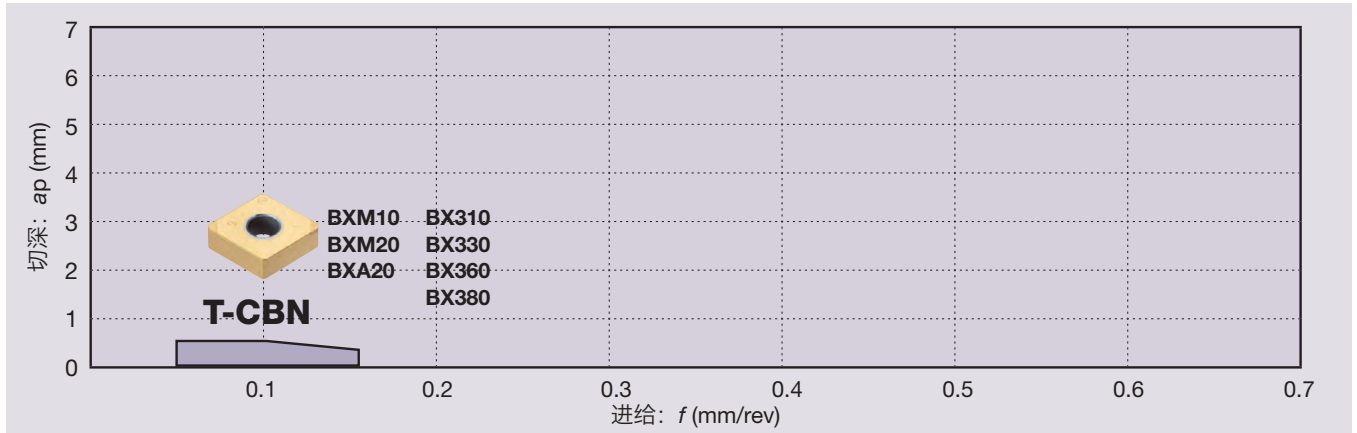
索引

断屑槽介绍

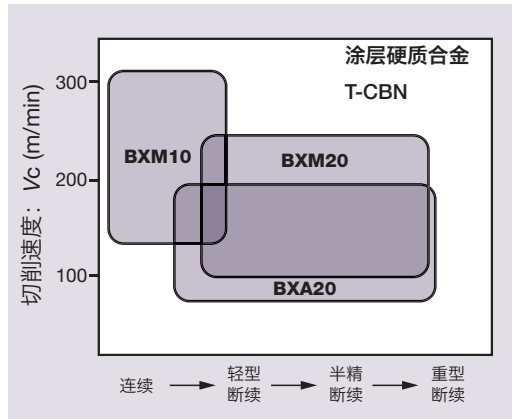
基本断屑槽：负前角刀片

H 硬材料

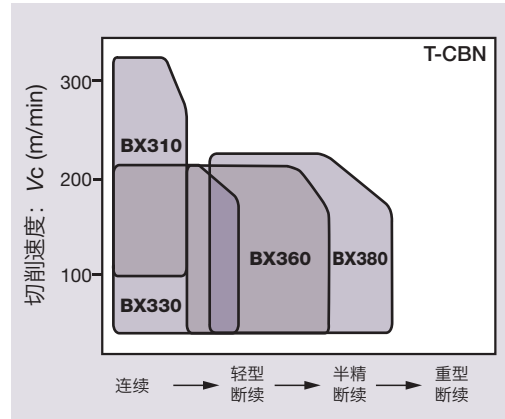
车削用断屑槽系统（负前角刀片）



涂层硬质合金T-CBN



T-CBN



断屑槽	形状	特征
无断屑槽 (T-CBN)		对淬火钢进行精切削时有着很好表现。

断屑槽	形状	特征
HF		用来去除渗碳层时、在小切深具有出众的排屑性能。
HM		用来去除渗碳层时、在大切深具有出众的排屑性能。
HP		精密加工时具有出色的切削控制

标准加工参数

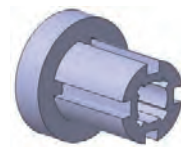
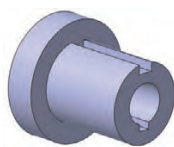
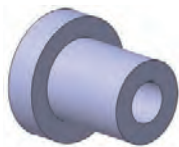
ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度 Vc (m/min)	
H	精密加工	连续到轻断续	HP	BXM10 BXA20	0.05 - 0.2	0.03 - 0.18	150 - 350	
	精加工	连续到强断续	无	BXM10 BXM20 BXA20	0.05 - 0.5	0.05 - 0.25	70 - 220	
	去除渗碳层	连续	连续	HF	BXM20	0.2 - 0.75	0.05 - 0.2	70 - 200
			连续	HM	BXM20 BXA20	0.5 - 1	0.05 - 0.2	70 - 200

淬火钢、预硬钢：SKD11、SKD61 等 X153CrMoV12、X40CrMoV5-1 等

选择系统

选择系统：负前角刀片

H 硬材料




连续

轻断续

强断续

精密加工
[$a_p \sim 0.2 \text{ mm}$]


基本



**T-CBN
HP
BXM10**

B171 - B179

基本



**T-CBN
BXA20**

B170 - B179

崩损 → **-H
BXM20**
B170 - B179

高速磨损 → **T-CBN
BXM10**
B170 - B179

基本




**T-CBN
BXM20**

B170 - B179

崩损 → **-H
BXM20**
B170 - B179

精加工
[$a_p \sim 0.5 \text{ mm}$]

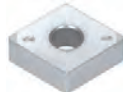
基本



**T-CBN
BXM10**

B170 - B179

基本




**T-CBN
BXA20**

B170 - B179

崩损 → **-H
BXM20**
B170 - B179

高速磨损 → **T-CBN
BXM10**
B170 - B179

基本



**T-CBN
BXM20**

B170 - B179

崩损 → **-H
BXM20**
B170 - B179

详细信息请见B***页。

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

用户指南

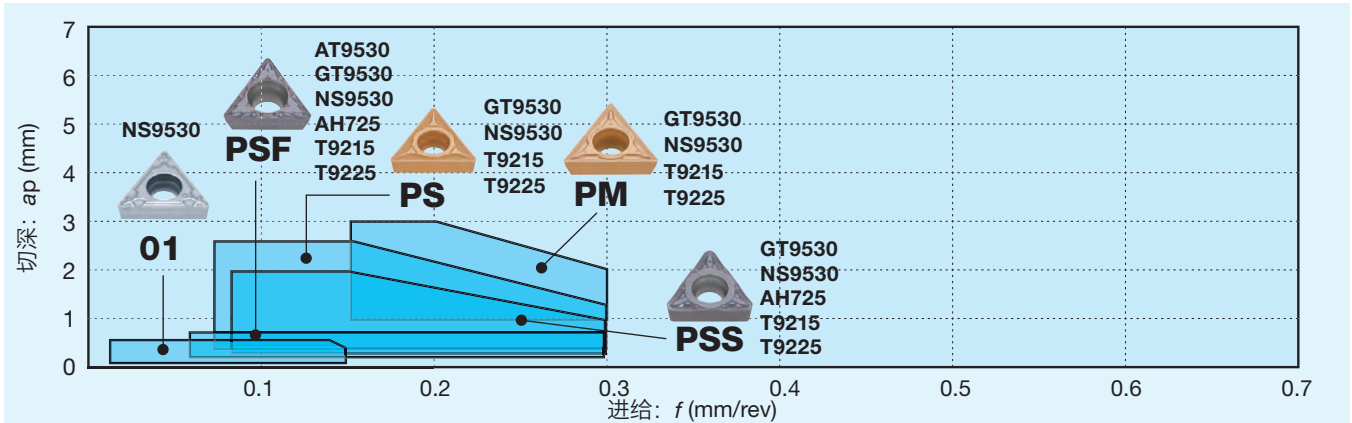
索引

断屑槽介绍

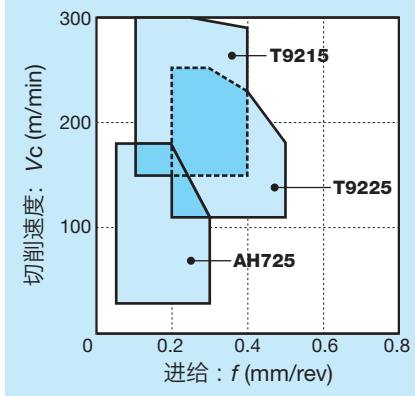
基本断屑槽：正前角刀片

P 钢

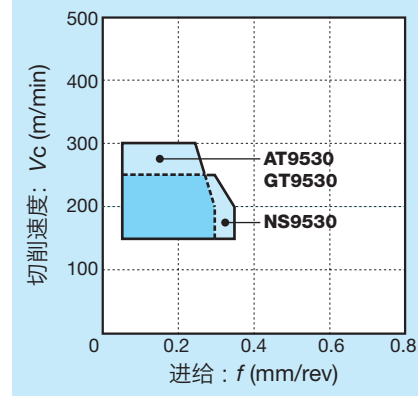
车削用断屑槽系统（正前角刀片）



CVD/PVD 涂层硬质合金材质



涂层硬质合金金属陶瓷/金属陶瓷



断屑槽	形状	特征
01		锋利的切削刃以及刀尖附近抬起的突出部分有助于在极小切深、小进给时提供出众的排屑性能。
PSF		低切削力和高耐磨性。精加工首选。精加工中良好的切屑控制可防止内孔加工中的切屑缠绕。
PSS		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。

断屑槽	形状	特征
PS		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。
PM		优异的锋利度和良好的切屑控制使其成为半精加工的首选。实现了不锈钢的稳定加工。

标准加工参数

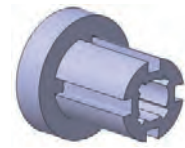
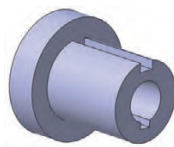
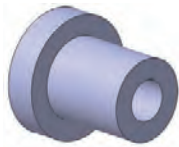
ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度：Vc (m/min)		
							低碳钢、合金钢	中碳钢、合金钢	高碳钢、合金钢
P	精密精加工	连续	01	NS9530	0.05 - 0.5	0.03 - 0.15	150 - 250	80 - 220	80 - 180
		轻断续	01	NS9530	0.05 - 0.5	0.03 - 0.15	150 - 250	80 - 220	80 - 180
	精加工	连续	PSS	NS9530	0.1 - 0.5	0.05 - 0.3	150 - 250	80 - 220	80 - 180
		轻断续	PSS	NS9530	0.1 - 0.5	0.05 - 0.3	150 - 250	80 - 220	80 - 180
		强断续	PSS	NS9530	0.1 - 0.5	0.05 - 0.3	150 - 250	80 - 220	80 - 180
		连续	PS	NS9530	0.3 - 2	0.08 - 0.3	150 - 250	80 - 220	80 - 180
	精加工到轻切削	轻断续	PS	NS9530	0.3 - 2	0.08 - 0.3	150 - 250	80 - 220	80 - 180
		强断续	PS	NS9530	0.3 - 2	0.08 - 0.3	150 - 250	80 - 220	80 - 180
		连续到强断续	PS	T9215	0.5 - 2.5	0.08 - 0.3	120 - 350	100 - 350	80 - 250
		强断续	PS	T9225	0.5 - 2.5	0.08 - 0.3	100 - 300	80 - 300	80 - 250
精加工到半精加工	连续到强断续	PM	-	1 - 3	0.15 - 0.3	150	100 - 200	80 - 180	
	强断续	PM	-	1 - 3	0.15 - 0.3	120	80 - 180	80 - 120	

低碳钢、合金钢：S10C、SCM415、SS400、SCr420H等 C10、18CrMo4、E275A、20Cr4等 中碳钢、合金钢：S45C、SCM440等 C45、42CrMo4、等 高碳钢、合金钢：SNM439等 41CrNiMo2等

选择系统

选择系统：正前角刀片

P 钢



连续

轻断续

强断续

精密加工 [$a_p = \sim 0.5 \text{ mm}$]	<p>基本</p> <p>01 NS9530</p> <p>B040, B045</p>	<p>基本</p> <p>01 NS9530</p> <p>B040, B045</p> <p>崩损 → PSF NS9530 B040, B045, B049</p>	
	<p>基本</p> <p>PSS NS9530</p> <p>B040, B045, B049</p> <p>磨损 → PSS GT9530 B040, B045, B049</p> <p>崩损 → PS NS9530 B040, B045, B049</p> <p>切屑控制 → PSF NS9530 B040, B045, B049</p>	<p>基本</p> <p>PSS NS9530</p> <p>B040, B045, B049</p> <p>磨损 → PSS GT9530 B040, B045, B049</p> <p>崩损 → PS NS9530 B040, B045, B049</p> <p>切屑控制 → PSF NS9530 B040, B045, B049</p>	<p>基本</p> <p>PSS NS9530</p> <p>B040, B045, B049</p> <p>磨损 → PSS GT9530 B040, B045, B049</p> <p>崩损 → PS NS9530 B040, B045, B049</p> <p>切屑控制 → PSF NS9530 B040, B045, B049</p>
	<p>基本</p> <p>PS T9215</p> <p>B040, B045, B049</p> <p>崩损 → PS T9215 B040, B045, B049</p> <p>磨损 → PS NS9530 B040, B045, B049</p>	<p>基本</p> <p>PS T9215</p> <p>B040, B045, B049</p> <p>崩损 → PS T9215 B040, B045, B049</p> <p>磨损 → PS NS9530 B040, B045, B049</p>	<p>基本</p> <p>PS T9215</p> <p>B040, B045, B049</p> <p>崩损 → PM T9215 B042, B046</p> <p>切屑控制 → TSF T9215 B040, B045</p>
	<p>基本</p> <p>PM T9215</p> <p>B042, B046</p> <p>磨损 → PM NS9530 B042, B046</p>	<p>基本</p> <p>PM T9215</p> <p>B042, B046</p> <p>崩损 → PM T9215 B042, B046</p>	<p>基本</p> <p>PM T9215</p> <p>B042, B046</p> <p>切屑控制 → TM T9215 B041, B045</p>
半精加工 [$a_p = 1 \sim 3 \text{ mm}$]			

请在以下页面检查详细信息：B***/7°后角, B***/11°后角, B***/5°后角。

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

用户指南

索引

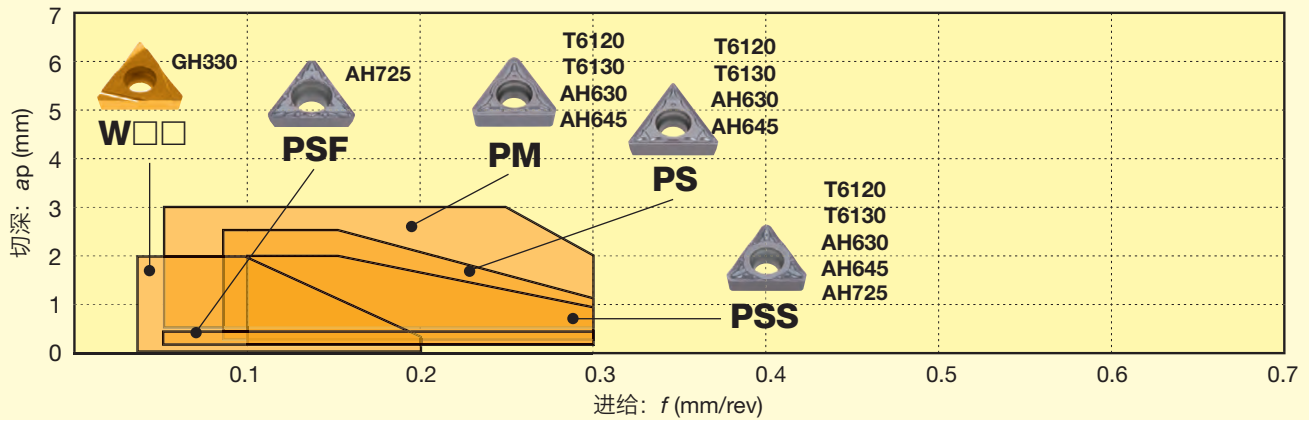


断屑槽介绍

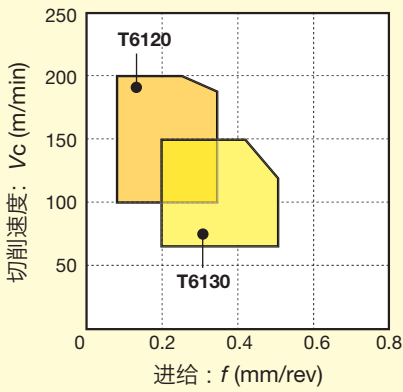
基本断屑槽：正前角刀片

M 不锈钢

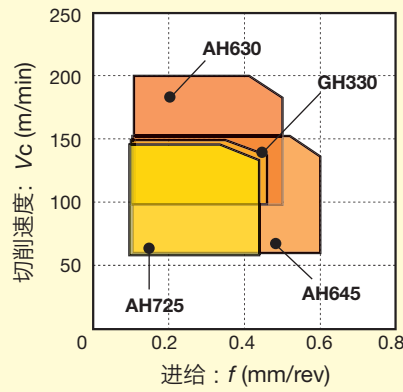
车削用断屑槽系统（正前角刀片）



CVD 涂层硬质合金材质



PVD 涂层硬质合金材质



断屑槽	形状	特征
W□□		采用了可控制排屑方向的设计、用于在镗孔时精密切削。具备出众的排屑能力、有助于加工高精度内孔。
PSF		低切削力和高耐磨性。精加工首选。精加工中良好的切屑控制可防止内孔加工中的切屑缠绕。

断屑槽	形状	特征
PSS		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。
PS		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。
PM		优异的锋利度和良好的切屑控制使其成为半精加工的首选。实现了不锈钢的稳定加工。

标准加工参数

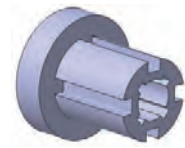
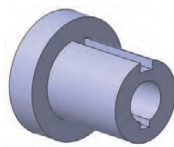
ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度 Vc (m/min)
M	精密加工	连续	W□□	GH330	0.05 - 2.0	0.03 - 0.2	100 - 150
		连续	PSF	AH725	0.1 - 0.5	0.05 - 0.3	50 - 150
	精加工	轻断续	PSF	AH725	0.1 - 0.5	0.05 - 0.3	50 - 150
		强断续	PSF	AH725	0.1 - 0.5	0.05 - 0.3	50 - 120
	精加工到轻切削	连续	PSS	AH630	0.3 - 2	0.08 - 0.3	90 - 190
		轻断续	PSS	AH630	0.3 - 2	0.08 - 0.3	90 - 190
		强断续	PSS	AH630	0.3 - 2	0.08 - 0.3	90 - 190
	精加工到半精加工	连续	PS	T6130	0.5 - 2.5	0.08 - 0.3	100 - 200
		轻断续	PS	AH630	0.5 - 2.5	0.08 - 0.3	90 - 190
		强断续	PS	AH630	0.5 - 2.5	0.08 - 0.3	90 - 190
	半精加工	连续	PM	T6130	1 - 3*	0.15 - 0.3	100 - 200
		轻断续	PM	AH630	1 - 3*	0.15 - 0.3	90 - 190
		强断续	PM	AH630	1 - 3*	0.15 - 0.3	90 - 190

* CCMT0602 和 DCMT0702 型刀片的 ap = 0.5 - 2.5
 不锈钢: SUS304、SUS316 等 X5CrNi18-9、X5CrNiMo17-12-3 等

选择系统

选择系统：正前角刀片

M 不锈钢



连续

轻断续

强断续

精密加工
[$a_p \sim 0.5 \text{ mm}$]

基本



W
GH330

B041, B046, B049

基本



W
GH330

B041, B046, B049

精加工
[$a_p = 0.3 \sim 1.5 \text{ mm}$]

基本

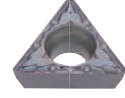


PSF
AH725

B040, B045, B049

磨损 → **PSS T6130**
B040, B045, B049

基本



PSF
AH725

B040, B045, B049

崩损 → **PSS AH630**
B040, B045, B049

磨损 → **PSS T6130**
B040, B045, B049

基本



PSF
AH725

B040, B045, B049

崩损 → **PSS AH630**
B040, B045, B049

精加工到半精加工
[$a_p = 0.5 \sim 2.5 \text{ mm}$]

基本

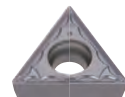


PSS
AH630

B040, B045, B049

磨损 → **PS T6130**
B040, B045, B049

基本



PS
AH630

B040, B045, B049

崩损 → **PM AH645**
B042, B046

磨损 → **PS T6130**
B040, B045, B049

基本



PS
AH630

B040, B045, B049

崩损 → **PM AH645**
B042, B046

磨损 → **PS T6130**
B040, B045, B049

半精加工
[$a_p = 1 \sim 3 \text{ mm}$]

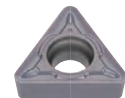
基本



PM
T6130

B042, B046

基本



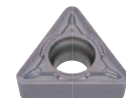
PM
AH630

B042, B046

崩损 → **PM AH645**
B042, B046

磨损 → **PM T6130**
B042, B046

基本



PM
AH630

B042, B046

崩损 → **PM AH645**
B042, B046

请在以下页面检查详细信息: B***/7°后角, B***/11°后角, B***/5°后角。

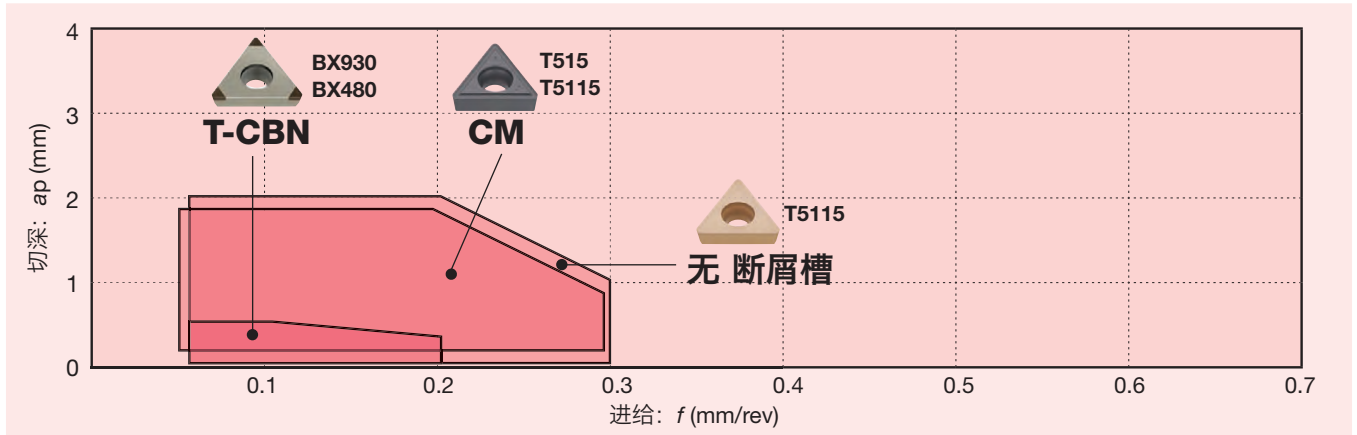


断屑槽介绍

基本断屑槽：正前角刀片

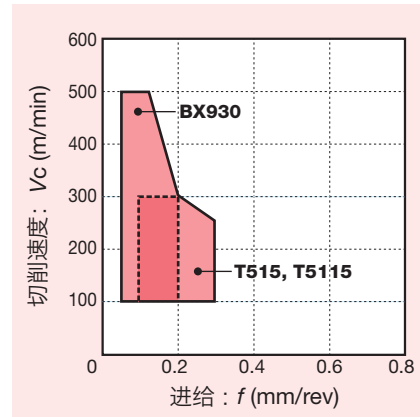
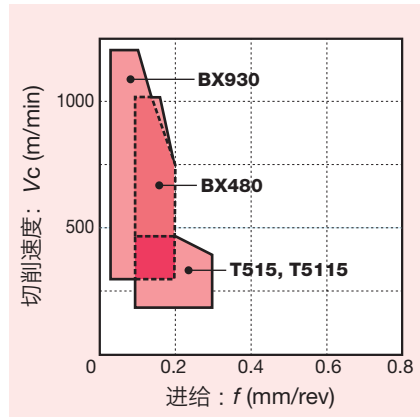
K 铸铁

车削用断屑槽系统（正前角刀片）



灰铸铁

球墨铸铁



断屑槽	形状	特征
无断屑槽 (T-CBN)		T-CBN 刀片。对铸铁进行高速精切削时有着很好表现。
无断屑槽		适合从铸铁精切削到粗加工在内的众多应用。具有出众的切削刃强度。

断屑槽	形状	特征
CM		功能全面的全周刃断屑槽、适用于常规切削、并可在精切削到半精切削中提供低切削力和出众的性能。

标准加工参数

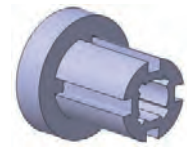
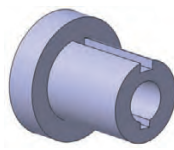
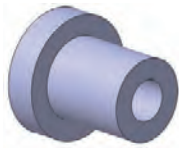
ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度：Vc (m/min)	
							灰铸铁	球墨铸铁
K	精密精加工	连续	无	BX930	0.05 - 0.5	0.05 - 0.2	300 - 1200	100 - 500
		轻断续	无	BX480	0.05 - 0.5	0.05 - 0.2	300 - 800	100 - 300
		轻断续	无	BX470	0.05 - 0.5	0.05 - 0.2	300 - 800	100 - 300
	精加工	连续	CM	T515	0.05 - 2	0.05 - 0.3	150 - 700	150 - 300
		强断续	CM	T515	0.05 - 2	0.05 - 0.3	100 - 200	100 - 200
		轻断续	CM	T515	0.05 - 2	0.05 - 0.3	100 - 300	100 - 250

灰口铸铁: FC250 等 250 等
球墨铸铁: FCD450 等 450-10S 等

选择系统

选择系统：正前角刀片

K 铸铁



连续

轻断续

强断续

精加工到半精加工
[$a_p = 0.5 \sim 3 \text{ mm}$]

基本

磨损

T-CBN BX930
B184 -

CM T515
B042, B046, B049

基本

CM T515
B042, B046, B049

基本

CM T515
B042, B046, B049

请在以下页面检查详细信息: B***/7°后角, B***/11°后角, B***/5°后角。

材质

刀片

外圆刀杆

内孔刀杆

螺紋加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

用户指南

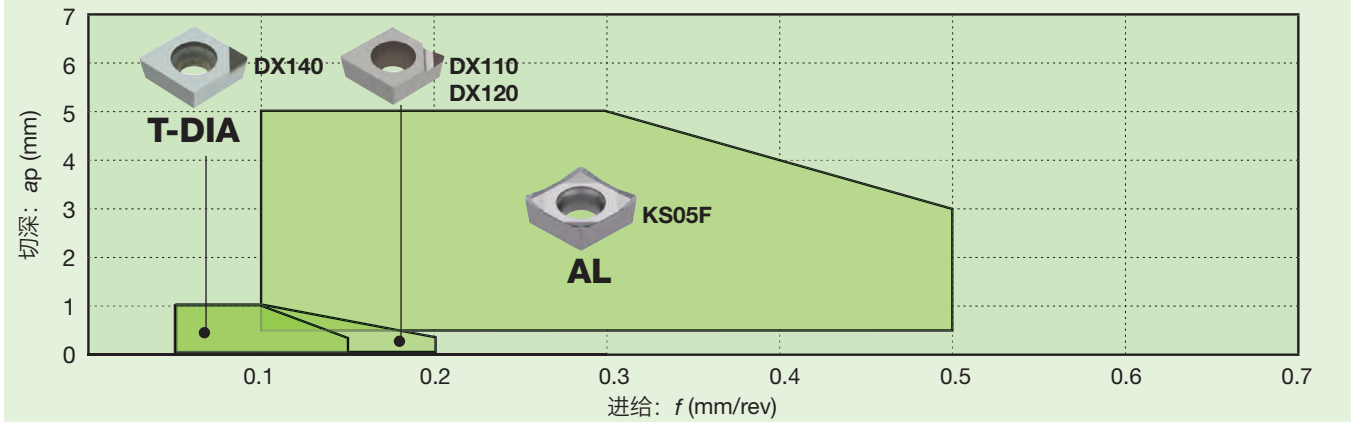
索引

断屑槽介绍

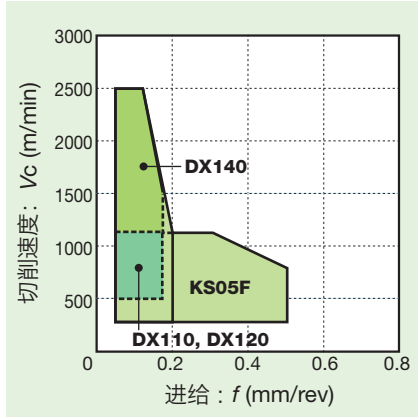
基本断屑槽：正前角刀片

N 非铁金属

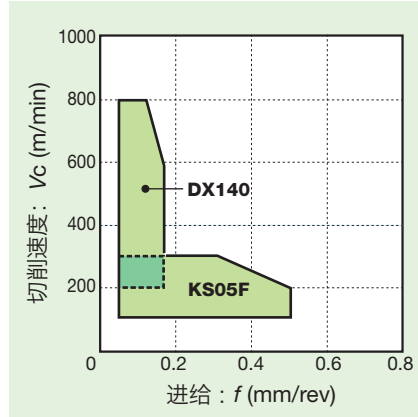
车削用断屑槽系统（正前角刀片）



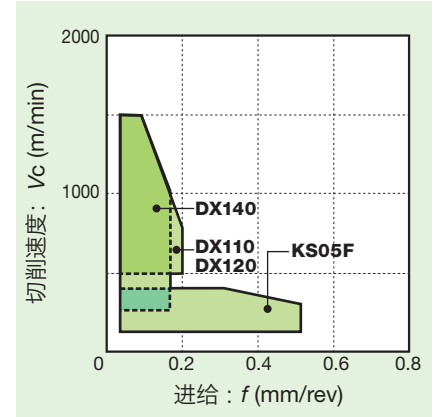
铝合金 (硅 < 12%)



铝合金 (硅 ≥ 12%)



铜合金



断屑槽	形状	特征
无断屑槽 (T-DIA)		对非铁金属材料进行高速精切削时有着很好表现。
AL		大的前角和锋利的切削刃降低了切削力。研磨的前刀面防止粘刀。大倾角的切削刃更稳定的切屑控制。

断屑槽	形状	特征
有断屑槽 (T-DIA)		宽断屑槽可提供出众的排屑性能。大前角降低了切削力。切削刃上的DIA提供高速加工和长刀具寿命。

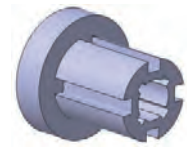
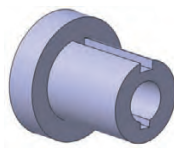
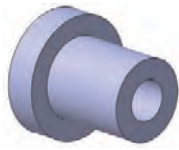
标准加工参数

ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度：Vc (m/min)		
							铝合金 (硅 < 12%)	铝合金 (硅 ≥ 12%)	铜合金
N	精密精加工	连续	有	DX110	0.05 - 1	0.05 - 0.15	500 - 2500	400 - 800	500 - 1500
		轻断续	无	DX140	0.05 - 1	0.05 - 0.2	300 - 2500	-	500 - 1500
	精加工	连续	无	DX140	0.05 - 1	0.05 - 0.15	500 - 2500	400 - 800	500 - 1500
		轻断续	无	DX140	0.05 - 1	0.05 - 0.15	300 - 1800	400 - 600	400 - 1200
	半精加工	强断续	AL	KS05F	0.5 - 5	0.1 - 0.5	100 - 600	100 - 200	-
		连续	AL	KS05F	0.5 - 5	0.1 - 0.5	100 - 1200	100 - 300	100 - 300
半精加工	轻断续	AL	KS05F	0.5 - 5	0.1 - 0.5	100 - 900	100 - 200	100 - 200	
	强断续	AL	KS05F	0.5 - 5	0.1 - 0.5	100 - 600	100 - 200	-	

选择系统

选择系统：正前角刀片

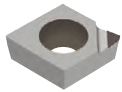
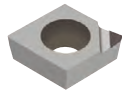
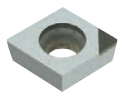
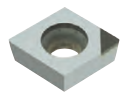
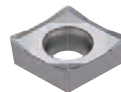

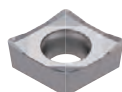
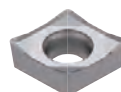
N 非铁金属



连续

轻断续

强断续

	连续	轻断续	强断续
精密加工 [$a_p \sim 0.5 \text{ mm}$]	<p>基本</p>  <p>带断屑槽 DX110 B192, B194</p> <p>磨损 → T-DIA DX140 B193, B195, B196</p>	<p>基本</p>  <p>带断屑槽 DX110 B192, B194</p> <p>磨损 → T-DIA DX140 B193, B195, B196</p>	
精加工 [$a_p = 0.5 \sim 2 \text{ mm}$]	<p>基本</p>  <p>T-DIA DX140 B193, B195, B196</p> <p>磨损 → T-DIA DX160 B193, B196</p> <p>切屑控制 → 带断屑槽 T-DIA DX110 B192, B194</p>	<p>基本</p>  <p>T-DIA DX140 B193, B195, B196</p> <p>崩损 → AL KS05F B042</p> <p>磨损 → T-DIA DX160 B193, B196</p>	<p>基本</p>  <p>AL KS05F B042</p>
半精加工 [$a_p = 1 \sim 5 \text{ mm}$]	<p>基本</p>  <p>AL KS05F B042</p> <p>磨损 → 带断屑槽 T-DIA DX120 B192, B194 - B193</p>	<p>基本</p>  <p>AL KS05F B042</p> <p>磨损 → T-DIA DX140 B193, B195, B196</p>	<p>基本</p>  <p>AL KS05F B042</p>

请在以下页面检查详细信息：B***/7°后角, B***/11°后角, B***/5°后角。

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

用户指南

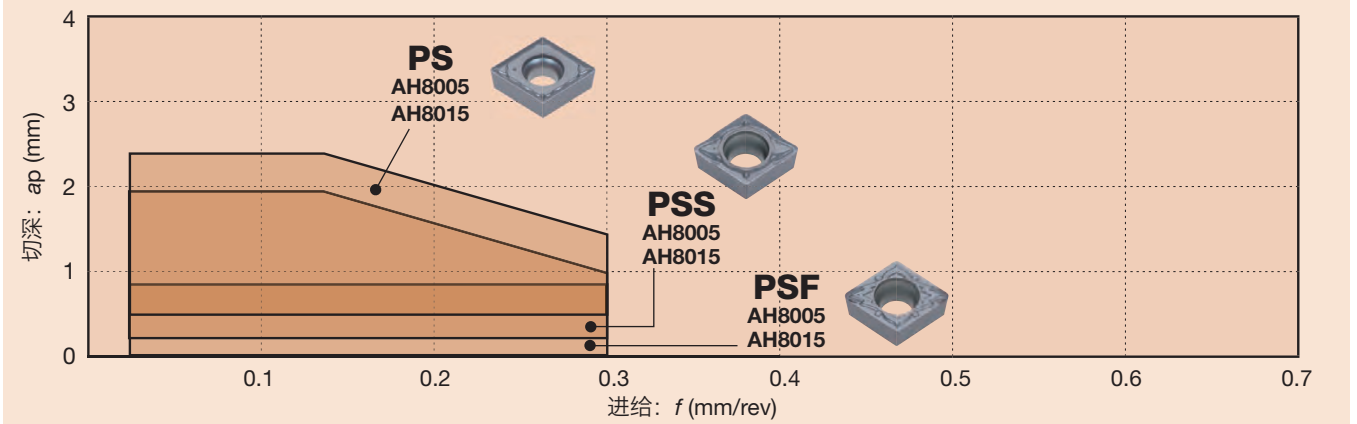
索引

断屑槽介绍

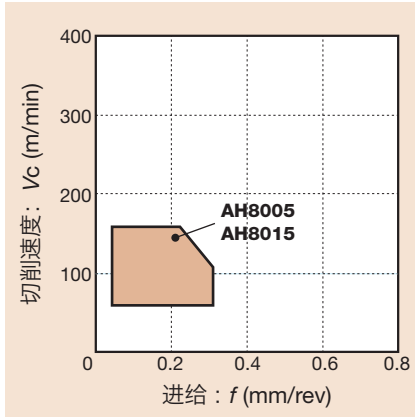
基本断屑槽：正前角刀片

S 耐热合金和钛合金

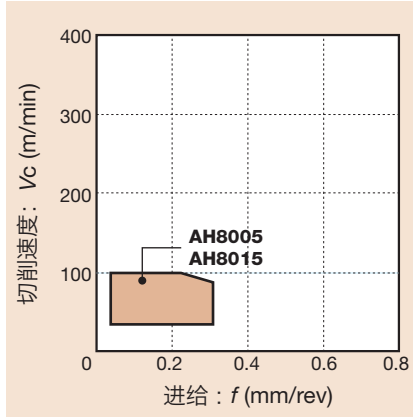
车削用断屑槽系统（正前角刀片）



钛合金



镍基合金



断屑槽	形状	特征
PS		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。

断屑槽	形状	特征
PSF		低切削力和高耐磨性。精加工首选。精加工中良好的切屑控制可防止内孔加工中的切屑缠绕。
PSS		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。

标准加工参数

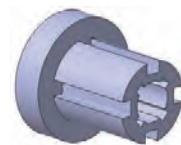
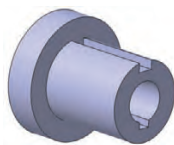
ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度：Vc (m/min)	
							钛合金	镍基合金
S	精加工	连续	PSS	AH8015	0.3 - 2	0.02 - 0.3	20 - 150	20 - 100
		轻断续	PSS	AH8015	0.3 - 2	0.02 - 0.3	20 - 150	20 - 100
	精加工到半精加工	连续	PS	AH8015	0.5 - 2.5	0.02 - 0.3	20 - 150	20 - 100
		轻断续	PS	AH8015	0.5 - 2.5	0.02 - 0.3	20 - 150	20 - 100

镍基合金: INCONEL718 等
钛合金: Ti - 6Al - 4V 等

选择系统

选择系统：正前角刀片

S 耐热合金和钛合金



连续

轻断续

强断续

精加工
[$a_p = 0.3 \sim 2 \text{ mm}$]

基本

PSS AH8015
B040, B045, B049

磨损 → **PSS AH8005**
B042, B045, B049

基本

PSS AH8015
B040, B045, B049

磨损 → **PSS AH8005**
B040, B045, B049

崩损 → **PS AH8015**
B040, B045, B049

精加工到半精加工
[$a_p = 0.5 \sim 2.5 \text{ mm}$]

基本

PS AH8015
B040, B045, B049

磨损 → **PSS AH8005**
B040, B045, B049

基本

PS AH8015
B040, B045, B049

崩损 → **全周 AH8015**
B042, B047

基本

PS AH8015
B040, B045, B049

崩损 → **全周 AH8015**
B042, B047

请在以下页面检查详细信息: B***/7°后角, B***/11°后角, B***/5°后角。

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

用户指南

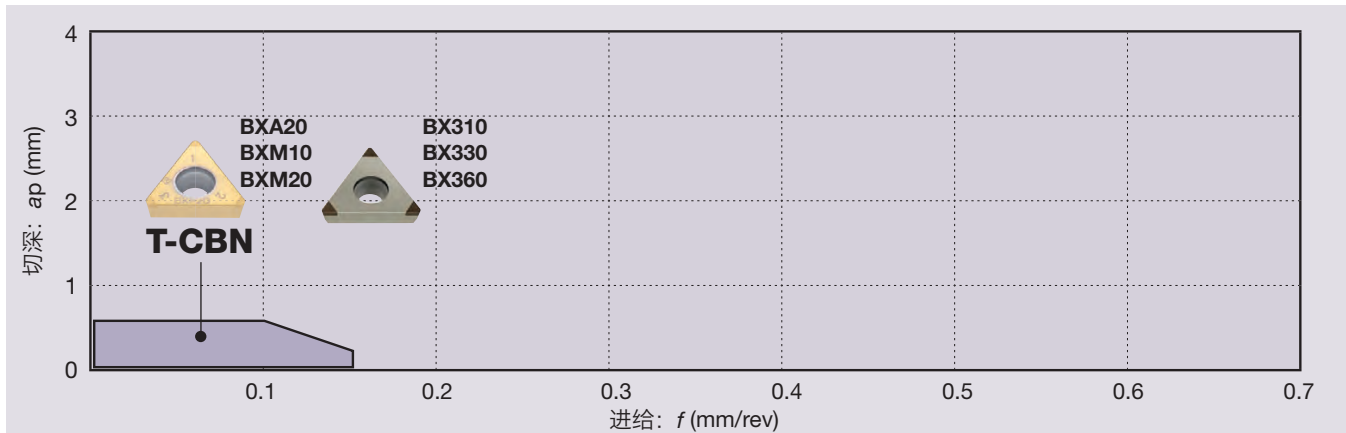
索引

断屑槽介绍

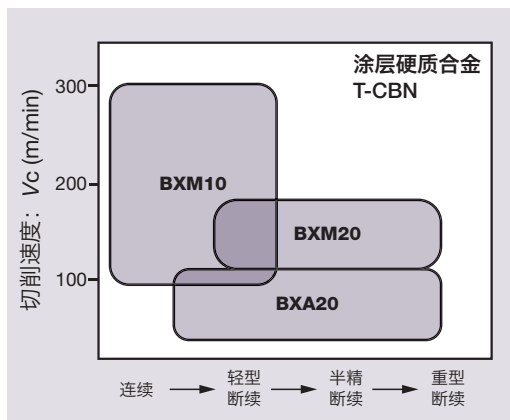
基本断屑槽：正前角刀片

H 硬材料

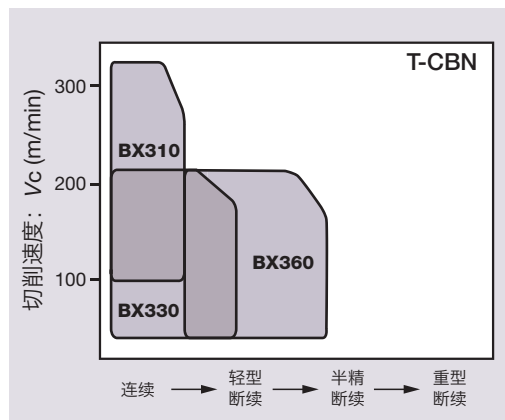
车削用断屑槽系统（正前角刀片）



涂层硬质合金T-CBN



T-CBN



断屑槽	形状	特征	断屑槽	形状	特征
无断屑槽 (T-CBN)		CBN烧结体在硬质材料高速精加工中具有优异性能。	HP (T-CBN)		精密加工时具有出色的切削控制

标准加工参数

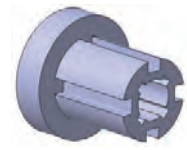
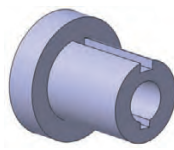
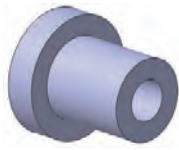
ISO	操作	加工条件	断屑槽	材质	切深 ap (mm)	进给量 f (mm/rev)	切削速度 Vc (m/min)
H	精密加工	连续	HP	BXM10	0.05 - 0.2	0.03 - 0.15	150 - 350
		轻断续	无	BXM20 BXA20	0.05 - 0.2	0.03 - 0.15	70 - 220
	精加工	连续到强断续	无	BXM20 BXA20	0.07 - 0.5	0.05 - 0.3	70 - 220

淬火钢、预硬钢：SKD11、SKD61 等 X153CrMoV12、X40CrMoV5-1 等

选择系统

选择系统：正前角刀片

H 硬材料



连续

轻断续

强断续






















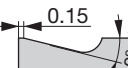





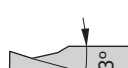














精密加工 [$a_p \sim 0.3 \text{ mm}$]	<p>基本</p>  <p>T-CBN HP BXM10</p> <p>B180 - B190</p>	<p>基本</p>  <p>T-CBN BXM10</p> <p>B180 - B190</p> <p>崩损 → T-CBN BXA20 B180 -</p>	
	<p>基本</p>  <p>T-CBN BXM10</p> <p>B180 - B190</p>	<p>基本</p>  <p>T-CBN BXM10</p> <p>B180 - B190</p> <p>崩损 → T-CBN BXA20 B180 - B190</p>	<p>基本</p>  <p>T-CBN BXM20</p> <p>B180 - B190</p> <p>崩损 → T-CBN BXA20 B180 - B190</p>
精加工 [$a_p \sim 0.5 \text{ mm}$]			

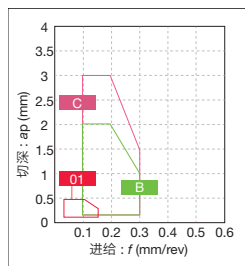
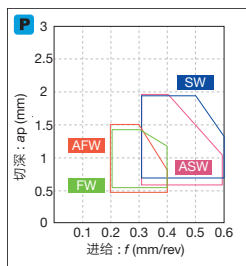
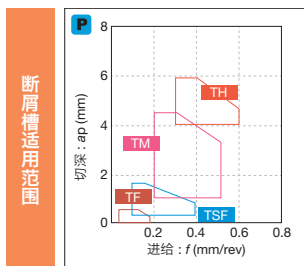
请在以下页面检查详细信息: B***/7°后角, B***/11°后角, B***/5°后角。

材质
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引



断屑槽概况

应用	负前角形式 带孔	C	D	S	T	V	W	Y
								
		80°	55°	90°	60°	35°	80°	25°
精密加工	TF  ap (mm) vs f (mm/rev) graph	 B054	 B065	 B075	 B084	 B094	 B099	
	01  ap (mm) vs f (mm/rev) graph	 B054	 B065	 B075	 B084	 B094	 B099	
	A~D  ap (mm) vs f (mm/rev) graph	 B054		 B075	 B084			
	W  ap (mm) vs f (mm/rev) graph				 B085			
精加工	TSF  ap (mm) vs f (mm/rev) graph	 B054	 B065	 B075	 B085	 B095	 B100	
	FW  ap (mm) vs f (mm/rev) graph	 B054	 B065		 B085		 B100	
精加工 (修光刃)	AFW  ap (mm) vs f (mm/rev) graph	 B054					 B100	



产品详情请见B***页。

断屑槽概况

材质

刀片

外圆刀杆

内孔刀杆

螺紋加工

槽加工

小零件刀具

铣刀








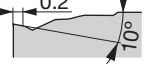






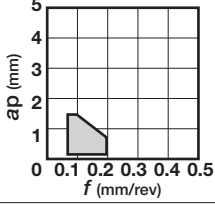







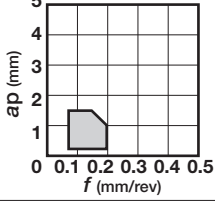






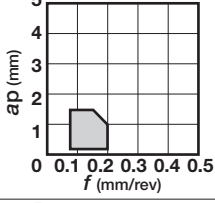







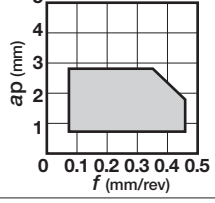
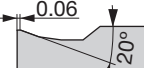






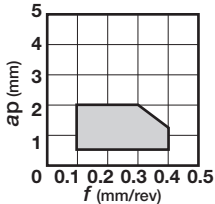







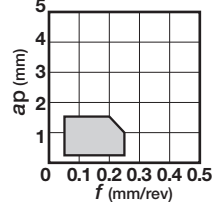







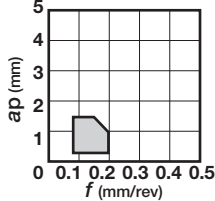
立铣刀

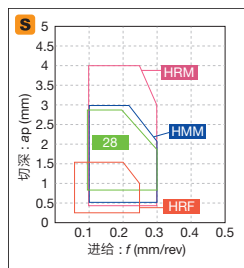
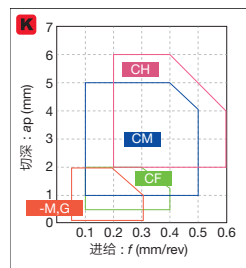
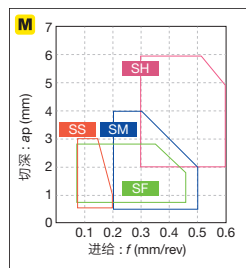
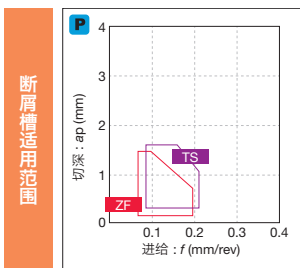
孔加工刀具

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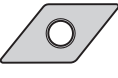


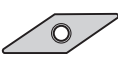


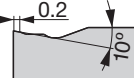
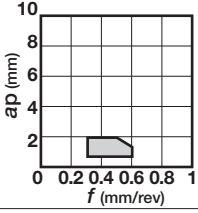




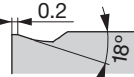
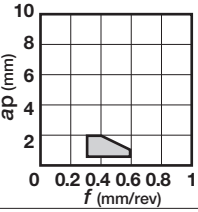


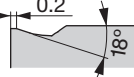
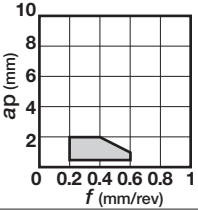






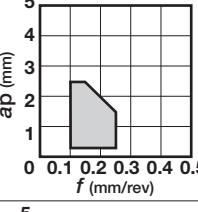

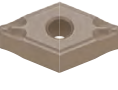


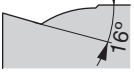
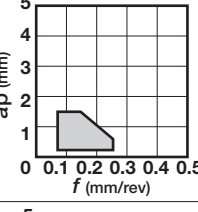






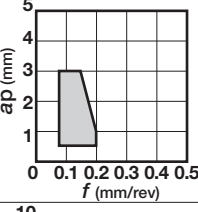






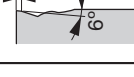
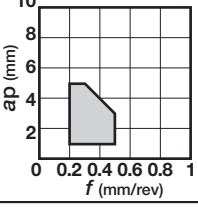

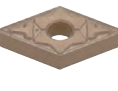




应用	负前角形式 带孔	C	D	S	T	V	W	Y
								
		80°	55°	90°	60°	35°	80°	25°
精加工	ZF 							
		B055	B066		B085	B095	B100	B107
精切削 (适用软钢)	11 							
		B055	B066	B076	B086	B095	B100	
精加工	17 							
		B055	B066	B076	B086		B100	
精加工	SF 							
		B055	B066	B076	B086	B095	B101	
精加工	CF 							
		B055	B066	B076	B086	B096	B101	
精加工	HRF 							
		B056	B066	B076	B086	B096	B101	
精加工	TS 							
		B056	B067	B076	B087	B096	B101	

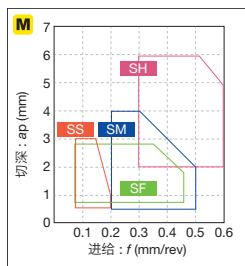
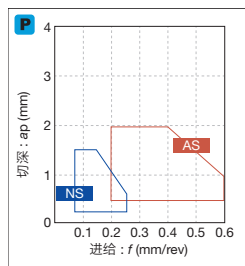
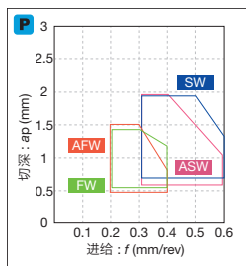
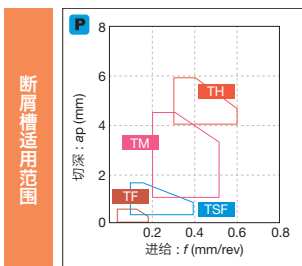


产品详情请见B***页。

*-M.G: 无断屑槽


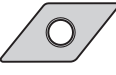


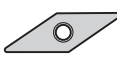


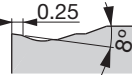
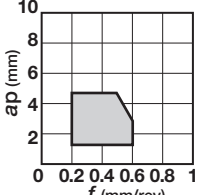

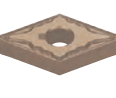



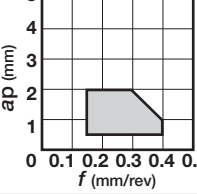




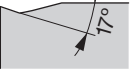
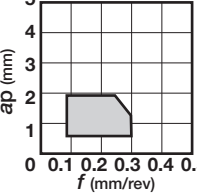






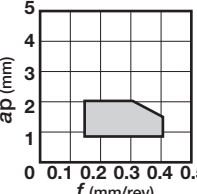
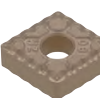
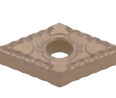





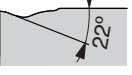
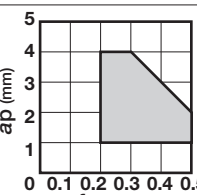




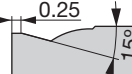
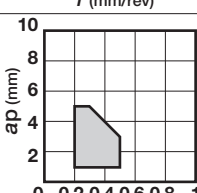





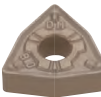
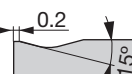
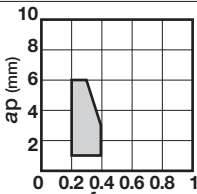

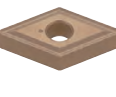




断屑槽概况

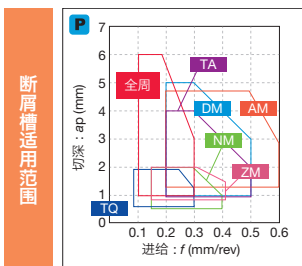
应用	负前角形式 带孔	C	D	S	T	V	W	Y
								
		80°	55°	90°	60°	35°	80°	25°
精加工到半精加工 (修光刃)	SW  							
	ASW  							
小切大深加工	AS  							
	CB  							
精加工	NS  							
	SS  							
半精加工	TM  							



产品详情请见B***页。

断屑槽概况

应用	负前角形式 带孔	C	D	S	T	V	W	Y
								
		80°	55°	90°	60°	35°	80°	25°
精加工到半精加工	AM  							
	B057	B068		B088		B103		
	NM  							
	B057	B068		B088		B103		
TQ  								
B058	B069		B088	B096	B103			
ZM  								
B058	B069	B077	B089	B097	B104	B107		
半精加工	TA  							
	B058		B077	B088	B103			
	DM  							
	B058	B069	B078	B089	B097	B104		
全周  								
B058	B069	B078	B089	B097	B104			



产品详情请见B***页。

材质

刀片

外圆刀杆

内孔刀杆

螺紋加工

槽加工

小零件刀具

铣刀

立铣刀


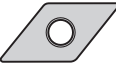


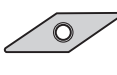


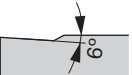
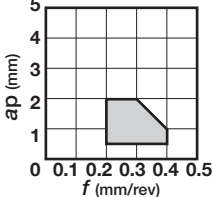
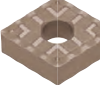





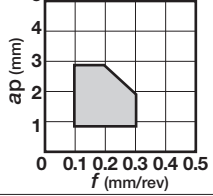
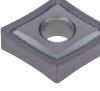
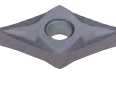


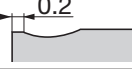
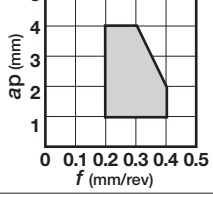

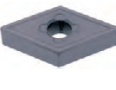





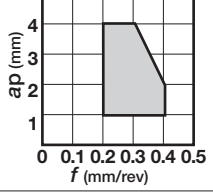
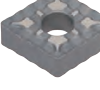
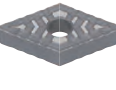



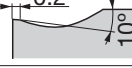
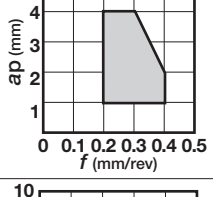



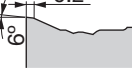
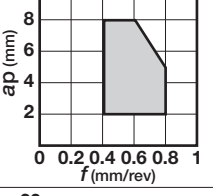
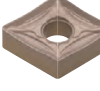



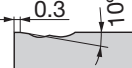
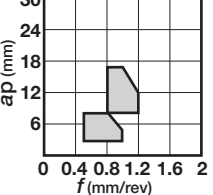


孔加工刀具

工具系统

用户指南

索引

断屑槽概况

应用	负前角形式 带孔	C	D	S	T	V	W	Y
								
		80°	55°	90°	60°	35°	80°	25°
精加工到半精加工	27  							
		B059	B069	B078	B089		B104	
	28  							
		B059	B070		B090	B097		
	33  							
		B059	B070	B078	B090	B097	B104	
	37  							
	B059	B070	B078	B090		B104		
38  								
	B059	B070		B090				
半精加工	57  							
		B061	B072	B081	B092			
	65  							
	B062		B081					

产品详情请见B***页。

断屑槽概况

材质

刀片

外圆刀杆

内孔刀杆

螺线加工

槽加工

小零件刀具

铣刀


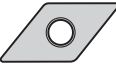



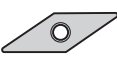

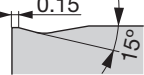
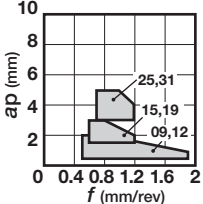

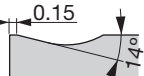
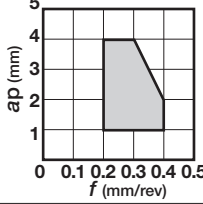
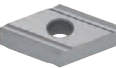
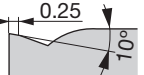
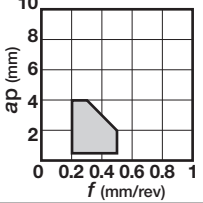






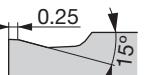
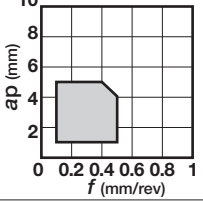
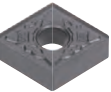


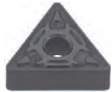
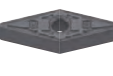
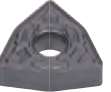

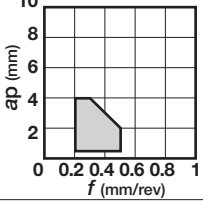
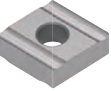
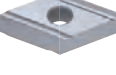

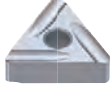
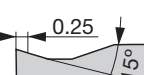
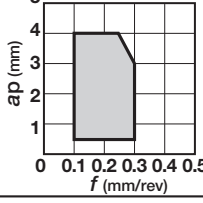
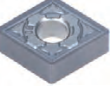
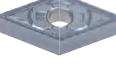


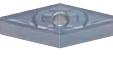
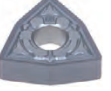
立铣刀

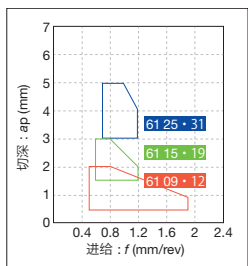
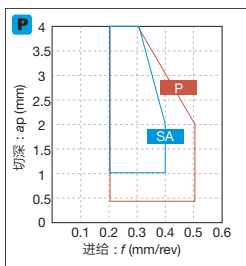
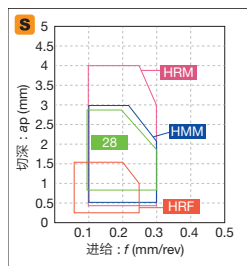
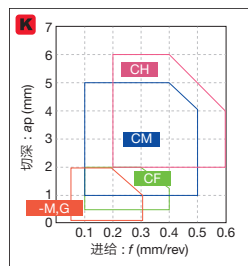
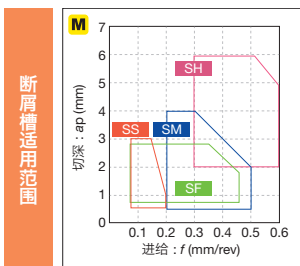
孔加工刀具

工具系统

用户指南

索引

应用	负前角形式 带孔	C	D	R	S	T	V	W
								
		80°	55°		90°	60°	35°	80°
重载加工	61  							
	平行  							
半精加工	SM  							
	CM  							
	P  							
	HRM  							

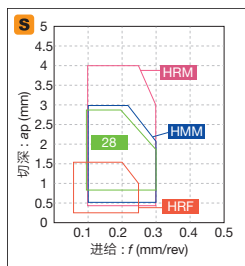
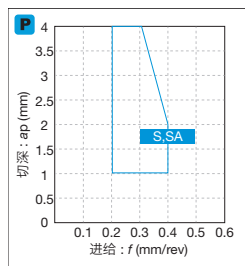
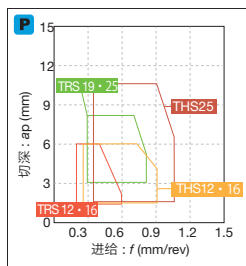
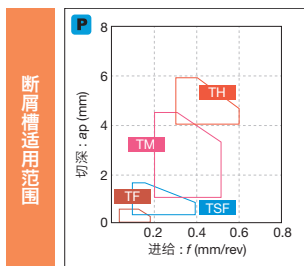


产品详情请见B***页。

*-M,G: 无断屑槽


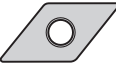



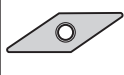

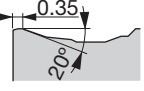
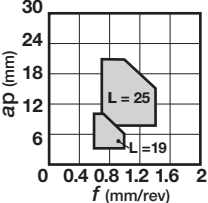


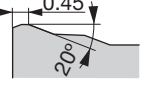
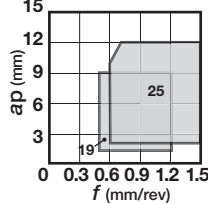


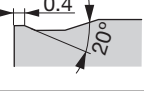
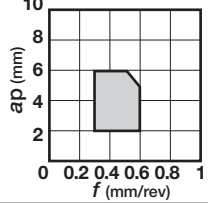
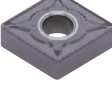
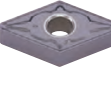


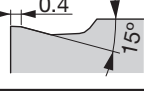
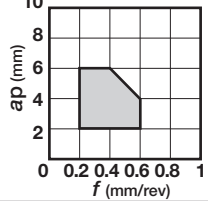
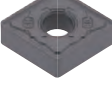
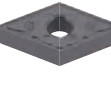



断屑槽概况

应用	负前角形式 带孔	C	D	R	S	T	V	W
		80°	55°		90°	60°	35°	80°
半精加工	HMM B060, B071, B079, B091, B098, B105							
	SA B060, B071, B079, B091, B105							
	S B060, B071, B080, B092							
中至重载加工	TH B061, B072, B080, B092, B106							
	THS B061, B072, B080, B092, B106							
半精强力切削 (单面)	TRS B062, B080							



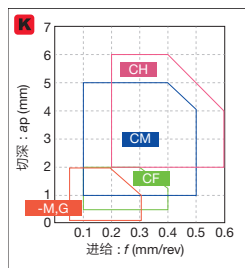
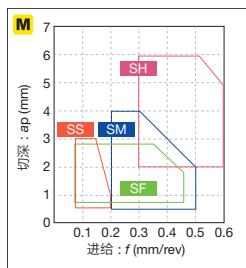
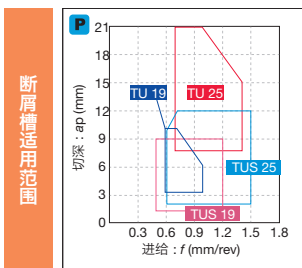
产品详情请见B***页。

断屑槽概况

应用	负前角形式 带孔	C	D	R	S	T	V	W
								
		80°	55°		90°	60°	35°	80°
强力切削 (单面)	TU  							
	TUS  							
中至重载加工	SH  							
	CH  							

材质
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系統
用户指南
索引

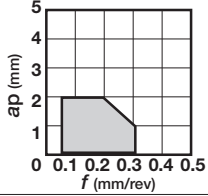
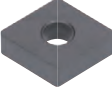
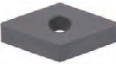


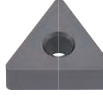
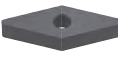

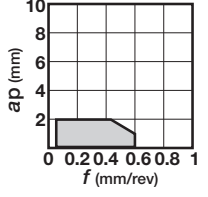
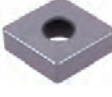
A
B
C
D
E
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M

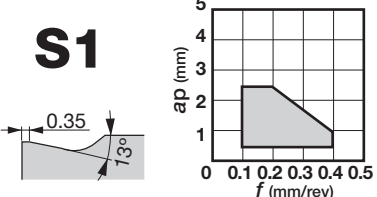



产品详情请见B***页。

*-M,G: 无断屑槽







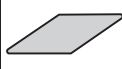
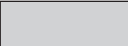
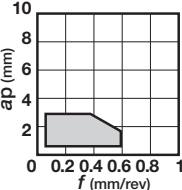




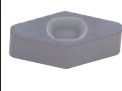

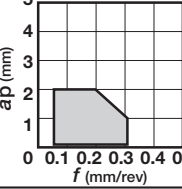





断屑槽概况

应用	负前角形式 带孔	C	D	R	S	T	V	W
		80°	55°		90°	60°	35°	80°
精加工到半精加工	M,G级 	 B063	 B072	 B074	 B082	 B093	 B098	 B106
	修光刃 M级 	 B063						

应用	负前角形式 带孔	C	D	KNMX	LNGN	R	S	T
		80°	55°	55°	90°		90°	60°
精加工	S1 			 B108				

产品详情请见B***页。

断屑槽概况

应用	负前角形式 不带孔	C	D	H	R	S	T	V
								
		80°	55°	120°		90°	60°	35°
精加工到半精加工	G级  	 B064	 B073	 B108		 B082		 B099
	M,G级  	 B064	 B073		 B074	 B082	 B094	

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

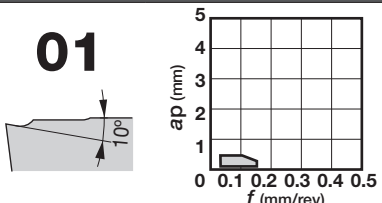



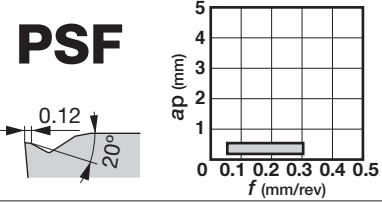
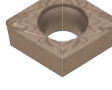
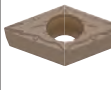


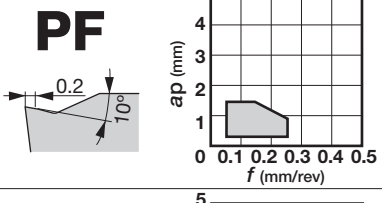
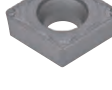


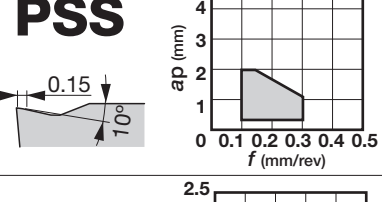




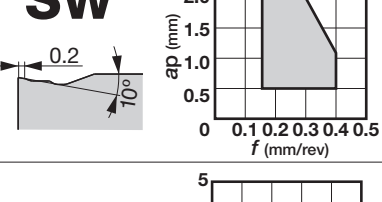

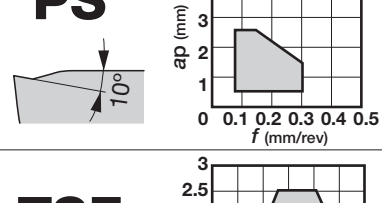



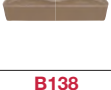

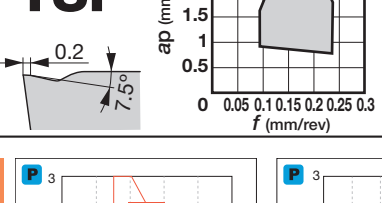

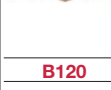
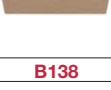

工具系统

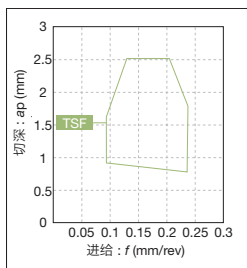
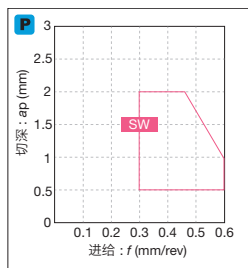
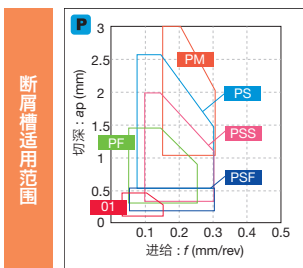
用户指南

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断屑槽概况

应用	7°正前角 带内冷孔	C	D	R	S	T	V	Y
		80°	55°		90°	60°	35°	25°
精密加工	01 	 B109	 B119			 B137		
	PSF 	 B109	 B119			 B137	 B153	
精加工	PF 	 B109	 B119				 B153	
	PSS 	 B110	 B120			 B137	 B153	
半精加工 (修光刃)	SW 	 B110						
精加工到半精加工	PS 	 B110	 B120		 B133	 B138	 B153	
	TSF 	 B110	 B120				 B138	 B153



产品详情请见B***页。

断屑槽概况

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

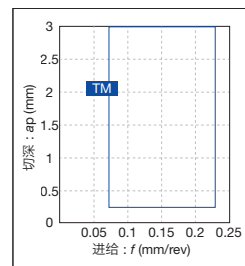
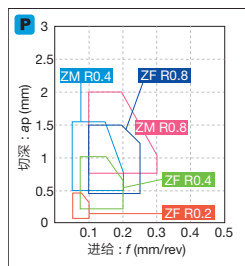
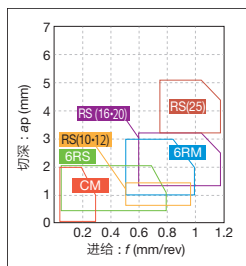
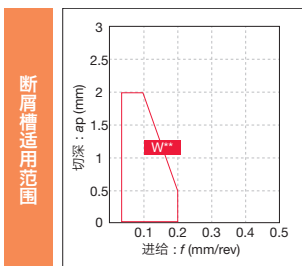
孔加工刀具

工具系统

用户指南






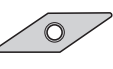
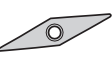

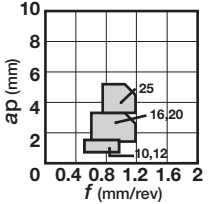

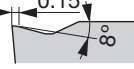
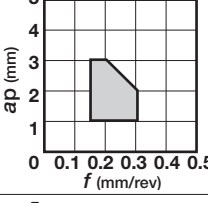





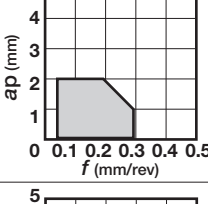
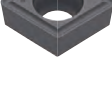






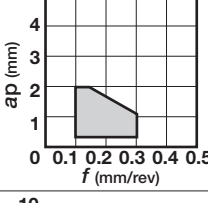
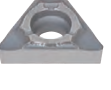
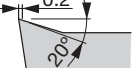
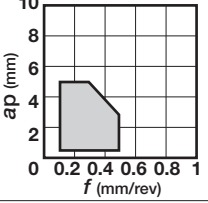
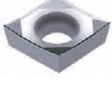



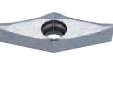

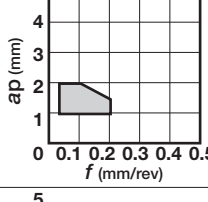
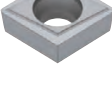
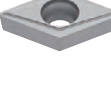

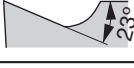
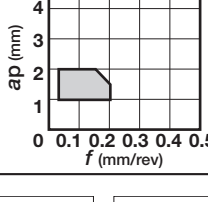


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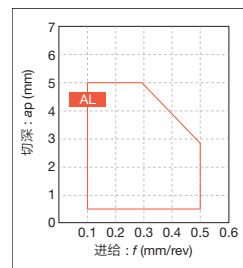
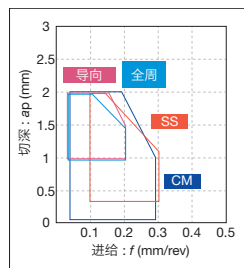
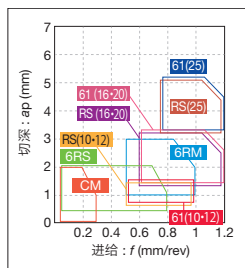
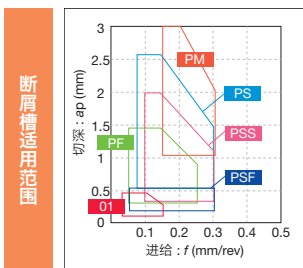
应用	7°正前角 带内冷孔	C	D	R	S	T	V	Y
		80°	55°		90°	60°	35°	25°
精加工到半精加工	TM B110, B120, B138, B153							
	ZF B160							
	ZM B160							
	23 B111, B120, B133, B138							
半精加工	24 B111, B120, B133, B138, B154							
	W** B111, B112, B121, B138							
精加工	RS B129							



产品详情请见B***页。

断屑槽概况

应用	7°正前角 带内冷孔	C	D	R	S	T	V	Y
								
		80°	55°		90°	60°	35°	25°
重载加工	61  							
				B130				
半精加工	PM  							
		B112	B121		B133	B139		
精加工到半精加工	CM  							
		B112	B121	B129	B133	B139	B154	
	SS  							
						B139		
	AL  							
		B113	B122	B129		B139	B154	
	全周  							
	B113	B122				B154		
导向  								
	B113	B122						



产品详情请见B***页。

断屑槽概况

材质

刀片

外圆刀杆

内孔刀杆

螺紋加工

槽加工

小零件刀具

铣刀

立铣刀

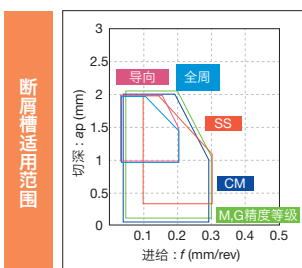
孔加工刀具

工具系统

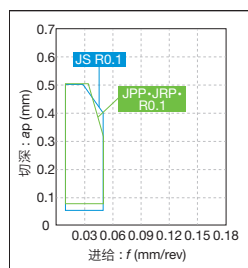
用户指南

索引

应用	7°正前角 带内冷孔	C	D	R	S	T	V	Y
		80°	55°		90°	60°	35°	25°
精加工到半精加工	M,G-等级 	 B113	 B122					
精加工 (带方向型)	 2.3°					 B140		
适用瑞士机床、走心机外圆车刀 锋利型刃口	JS 	 B114	 B123			 B140		
	JS 	 B114						
适用瑞士机床、走心机外圆车刀 锋利刃	JPP 		 B123					
	JRP 		 B124					


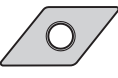



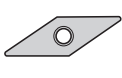

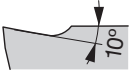
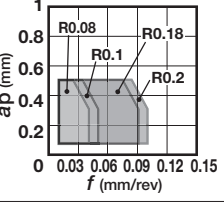
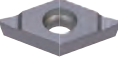
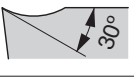
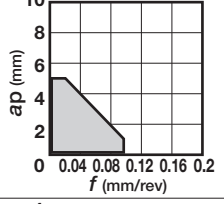



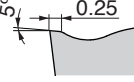
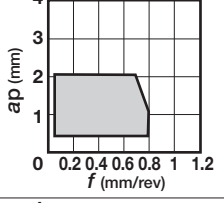

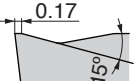
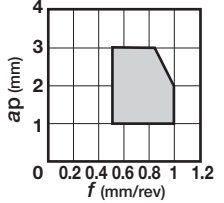



M,G精度等级, 无断屑槽
产品详情请见B***页。

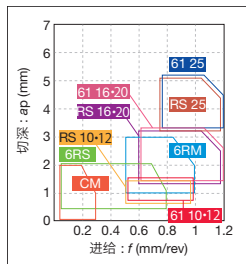
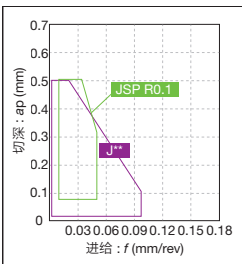


R0.1的槽型适用范围 (适用JPP,JS,JRP)

断屑槽概况

应用	7°正前角 带内冷孔	C	D	R	S	T	V	Y
		 80°	 55°		 90°	 60°	 35°	 25°
适用瑞士机床、走心机外圆车刀 (锋利刃)	JSP  		 B124					
	J**  	 B115	 B124			 B140, B141		
低切削力	6RS  			 B129				
半精加工	6RM  			 B129				

断屑槽适用范围



产品详情请见B***页。

断屑槽概况

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

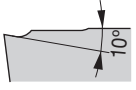
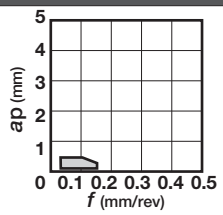

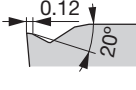
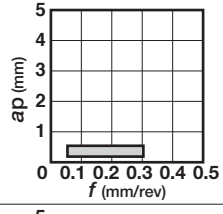
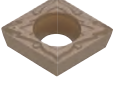

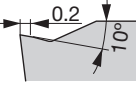
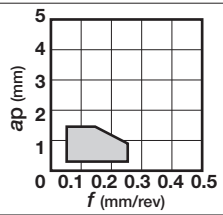
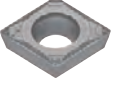

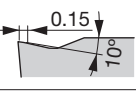
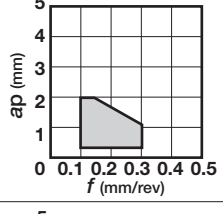


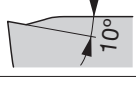
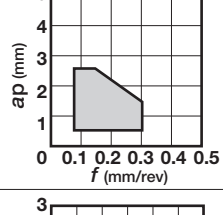



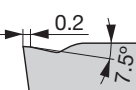
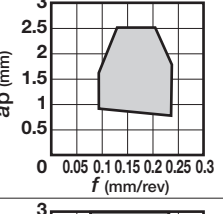


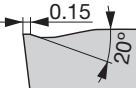
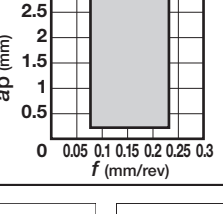


立铣刀

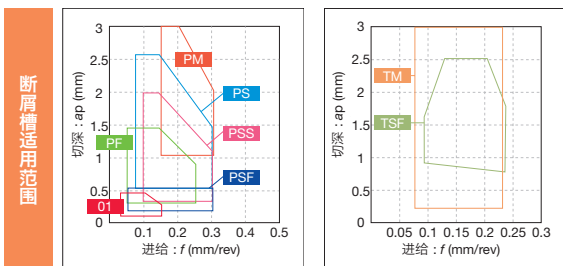
孔加工刀具

工具系统

用户指南


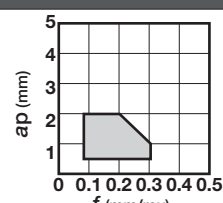


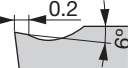
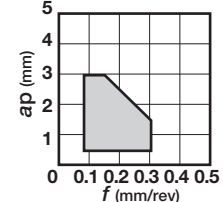



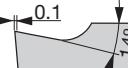
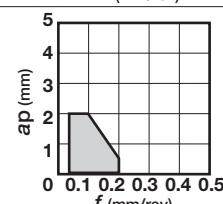
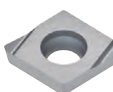


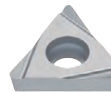
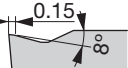
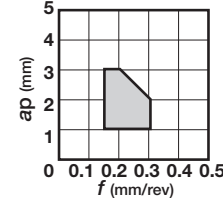
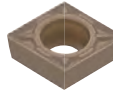

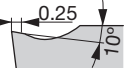
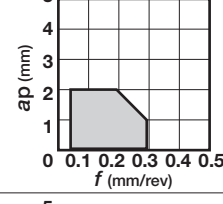




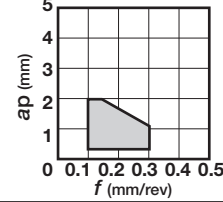
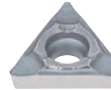
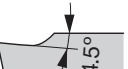
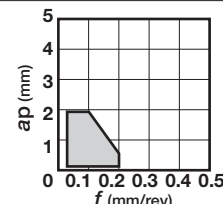
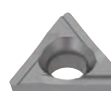
索引

应用	11°正前角 带内冷孔	C	E	S	T	V
		80°	75°	90°	60°	35°
精密加工	01  				 B142	
	PSF  	 B116			 B142	
精加工	PF  	 B116			 B142	
	PSS  	 B116			 B143	
精加工到轻切削	PS  	 B116		 B134	 B143	
	TSF  	 B116			 B143	
	TM  	 B116			 B144	

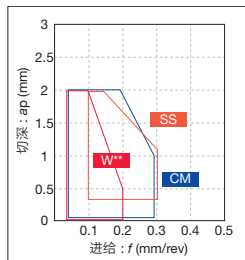
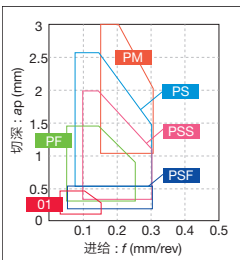


产品详情请见B***页。

断屑槽概况

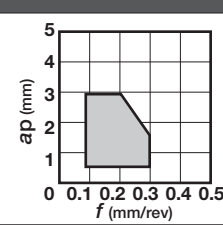
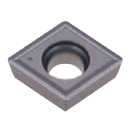
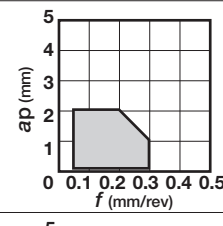



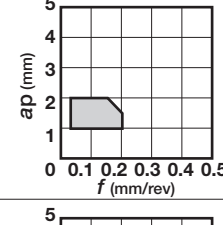
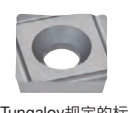
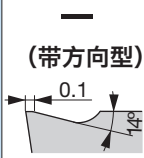
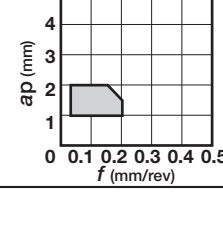
应用	11°正前角 带内冷孔	C	E	S	T	V
		80°	75°	90°	60°	35°
精加工到半精加工	23  			 B134	 B144	
半精加工	24  	 B117		 B134	 B144	
精加工	W**  	 B117	 B127	 B134	 B144, B145	
半精加工	PM  	 B118			 B146	
精加工到半精加工	CM  	 B118		 B135	 B146	
	SS  				 B146	
	H**  				 B146	

断屑槽适用范围



产品详情请见B***页。

断屑槽概况

应用	11°正前角 带内冷孔	C	E	S	T	V
		80°	75°	90°	60°	35°
半精加工	全周  	 B118				
精加工到半精加工	M,G-等级  	 B118		 B135	 B147, B148	
精加工到半精加工	(带方向型)  			 Tungaloy规定的标准孔 与ISO不同 B135		
	(带方向型)  				 Tungaloy规定的标准孔 与ISO不同 B147	

材质

刀片

外圆刀杆

内孔刀杆

螺紋加工

槽加工

小零件刀具

铣刀

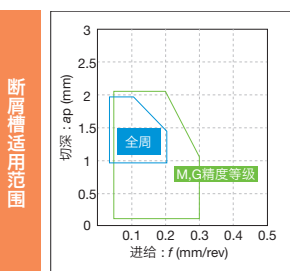
立铣刀

孔加工刀具

工具系统

用户指南

索引



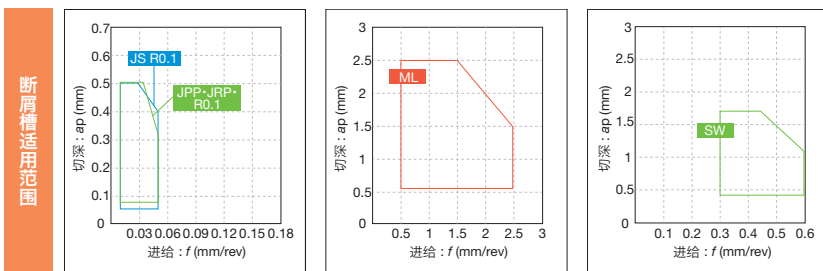
M,G精度等级, 无断屑槽
产品详情请见B***页。

断屑槽概况

应用		11°正前角 带内冷孔		C	E	S	T	V	
				80°	75°	90°	60°	35°	
适用瑞士机床、走心机内 圆车刀	JS								
					B128		B148		
	适用瑞士机床、走心机外圆车刀 (锋利刃)	JPP							
									B155
		JRP							
								B155	
	JSP								
								B156	
精加工	J08								
					B128				

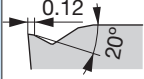


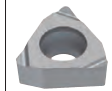
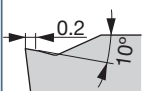

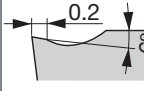

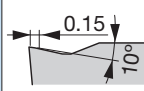

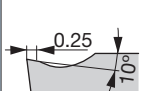

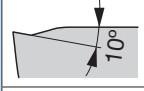

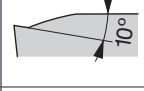

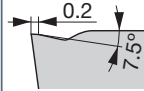

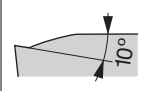
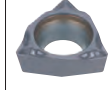
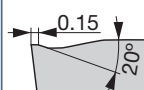

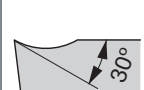

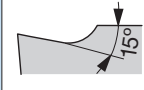
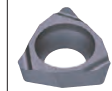
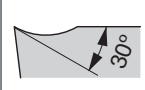

应用		11°正前角 带内冷孔		W
				80°
重载加工	ML			
				B156

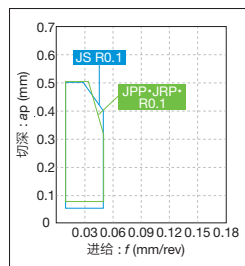
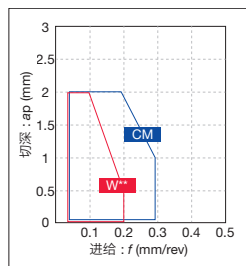
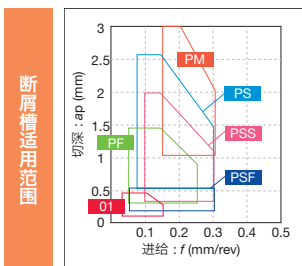
应用		7°正前角 带内冷孔		C
				80°
半精加工 (修光刃)	SW			
				B110



R0.1的槽型适用范围(适用JPP,JS,JRP)
产品详情请见B***页。

断屑槽概况

应用	5°正前角 带内冷孔	V	W	应用	5°正前角 带内冷孔	V	W
		35°	80°			35°	80°
精加工	PSF  ap (mm) vs f (mm/rev) graph B150			精加工	W11  ap (mm) vs f (mm/rev) graph B158		
	PF  ap (mm) vs f (mm/rev) graph B151				半精加工	24  ap (mm) vs f (mm/rev) graph B152	
精加工到轻切削	PSS  ap (mm) vs f (mm/rev) graph B151			精加工到半精加工		CM  ap (mm) vs f (mm/rev) graph B152	
	PS  ap (mm) vs f (mm/rev) graph B151				精加工到半精加工	JS  ap (mm) vs f (mm/rev) graph B152	
精加工到半精加工	TSF  ap (mm) vs f (mm/rev) graph B151			精加工到半精加工		JS  ap (mm) vs f (mm/rev) graph B158	
	TM  ap (mm) vs f (mm/rev) graph B151				精加工	J10  ap (mm) vs f (mm/rev) graph B152	
精加工	W08  ap (mm) vs f (mm/rev) graph B157			精加工		J10  ap (mm) vs f (mm/rev) graph B152	



产品详情请见B***页。

R0.1的槽型适用范围 (适用JPP, JS, JRP)

材质

刀片

外圆刀杆

内孔刀杆

螺紋加工

槽加工

小零件刀具

铣刀

立铣刀


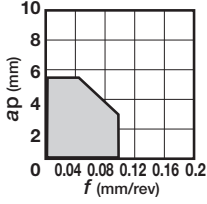

孔加工刀具


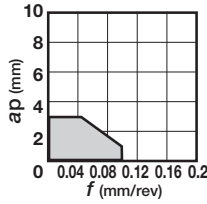

工具系统


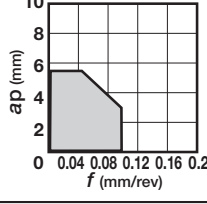

用户指南


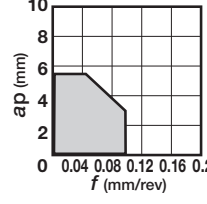

索引


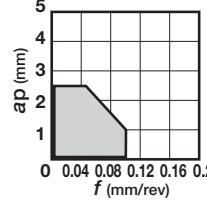

断屑槽概况


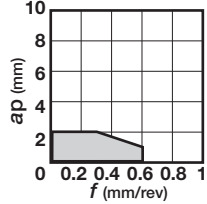

应用	正角型 带内冷孔	JXF 
前车刀片	— 	 B160

应用	正角型 带内冷孔	J10E 
背车刀片	— 	 B162, B163

应用	正角型 带内冷孔	JXB 
背车刀片	— 	 B161




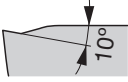
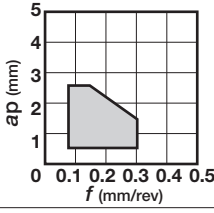


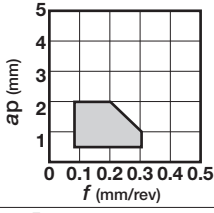


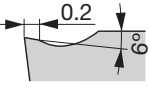
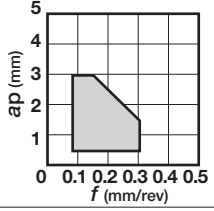

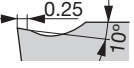
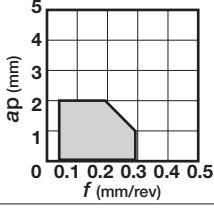


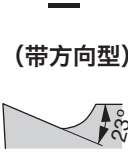
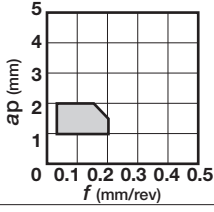
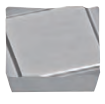


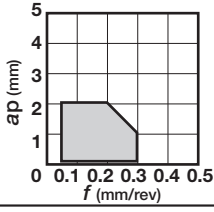


应用	正角型 带内冷孔	JXR 
反车刀片	— 	 B161

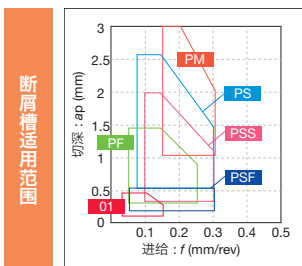
应用	正角型 带内冷孔	JTB 
背车刀片	— 	 B162

应用	圆形	RT 特殊圆刀片 
半精加工	— 	 B130

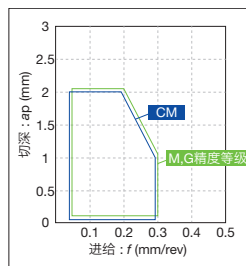
产品详情请见B***页。

断屑槽概况

应用	11°正前角 不带孔	R	S	T
				
			90°	60°
精加工到半精加工	PS  			 B149
	23  		 B136	 B149
半精加工	24  			 B149
精加工到半精加工	CM  		 B136	 B149
	 		 B136	 B150
	M,G-等级  		 B136	 B150



产品详情请见B***页。



M,G精度等级, 无断屑槽

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

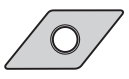
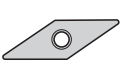


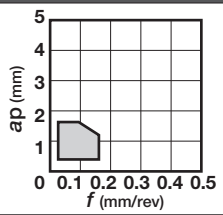


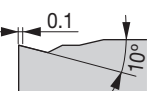
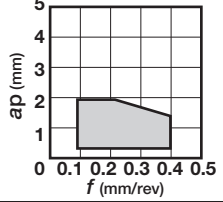

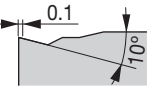
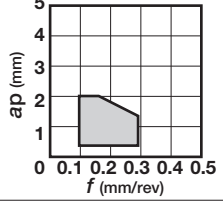



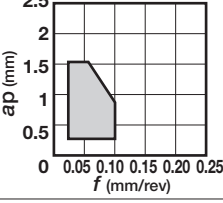



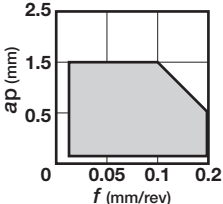



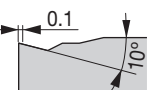
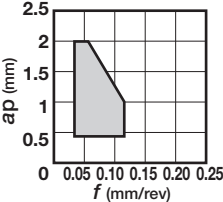



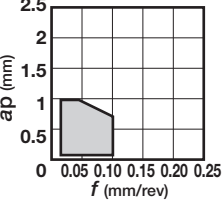
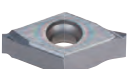

孔加工刀具

工具系统

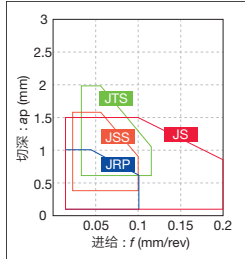
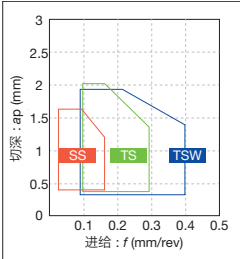
用户指南

索引

断屑槽概况

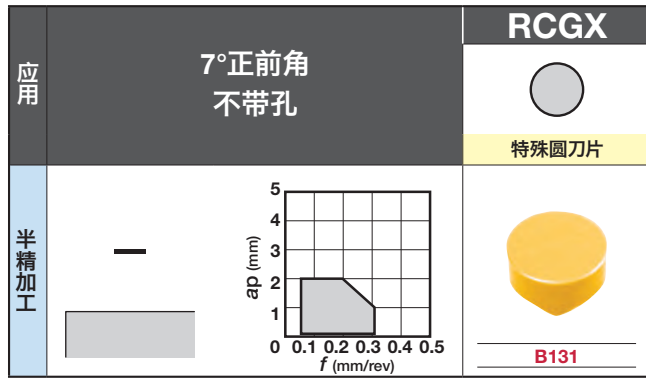
应用	正前角, 双面	D	V	W
		 55°	 35°	 80°
精加工 (低切削力)	SS  	 B126		 B159
精加工 (修光刃)	TSW  			 B159
精加工到半精加工	TS  	 B126		 B159
精加工 (锋利刃) (低切削力)	JSS  	 B126		 B159
精加工到半精加工 (锋利刃)	JS  	 B125	 B156	 B158
	JTS  	 B126		 B158
精加工 (锋利刃)	JRP  	 B125	 B156	

断屑槽适用范围



产品详情请见B***页。

断屑槽概况



材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

用户指南

索引



刀片 负前角

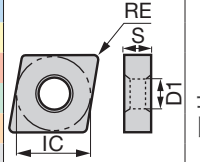
●: 连续切削
●: 轻断续切削
✱: 强断续切削

CN



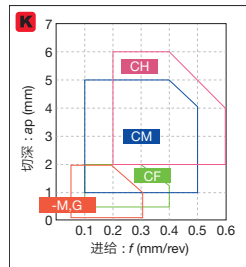
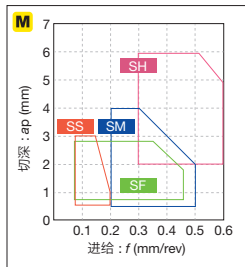
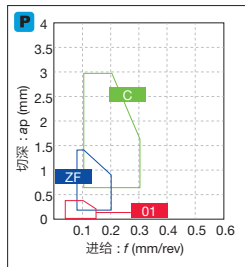
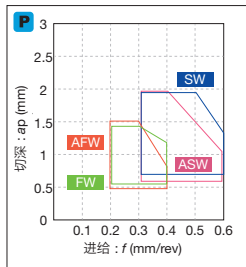
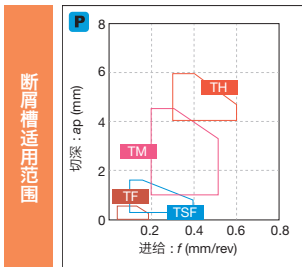
菱形, 80°
带内冷孔

材料	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料	涂层硬质合金	涂层金属陶瓷	金属陶瓷	不涂层硬质合金	尺寸 (mm)
应用	●●●●✱	●●	●●	●●	●●	●●	●●●●	●●●●	●●	●●	RE IC S D1



应用	断屑槽	型号	涂层硬质合金										涂层金属陶瓷		金属陶瓷	不涂层硬质合金	尺寸 (mm)						
			T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6120	T6130	AH630	T5105	T5115	GT9530	AT9530	GT720	NS9530	TH10	RE	IC	S	D1
精加工		ZF CNMG090404E-ZF	●	●	●	✱	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	9.525	4.76	3.81
		CNMG120404-ZF	●	●	●	✱	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	12.7	4.76	5.16
		CNMG120408-ZF	●	●	●	✱	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	12.7	4.76	5.16
精加工		11 CNMG120404-11												●	●	●	●	●	0.4	12.7	4.76	5.16	
		CNMG120408-11													●	●	●	●	●	0.8	12.7	4.76	5.16
低精碳加工		17 CNMG120404-17															●	●	0.4	12.7	4.76	5.16	
		CNMG120408-17																●	●	0.8	12.7	4.76	5.16
精加工		SF CNMG090304-SF								●	●	●								0.4	9.525	3.18	3.81
		CNMG090308-SF								●	●	●								0.8	9.525	3.18	3.81
		CNMG120404-SF								●	●	●								0.4	12.7	4.76	5.16
		CNMG120408-SF								●	●	●								0.8	12.7	4.76	5.16
		CNMG120412-SF								●	●	●								1.2	12.7	4.76	5.16
		CF CNMG120404-CF											●	●							0.4	12.7	4.76
		CNMG120408-CF									●	●							0.8	12.7	4.76	5.16	
		CNMG120412-CF									●	●							1.2	12.7	4.76	5.16	

●: 产品型号
▲: 停止生产



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C016 - 内孔刀杆 → D021 -
J系列刀杆 → G044 TungCap系列 → K008 -
PINZBOHR®系列 → K180 - 刀夹 → K199 -

刀片 负前角

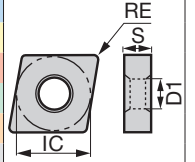
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●: 轻断续切削
✱: 强断续切削

CN



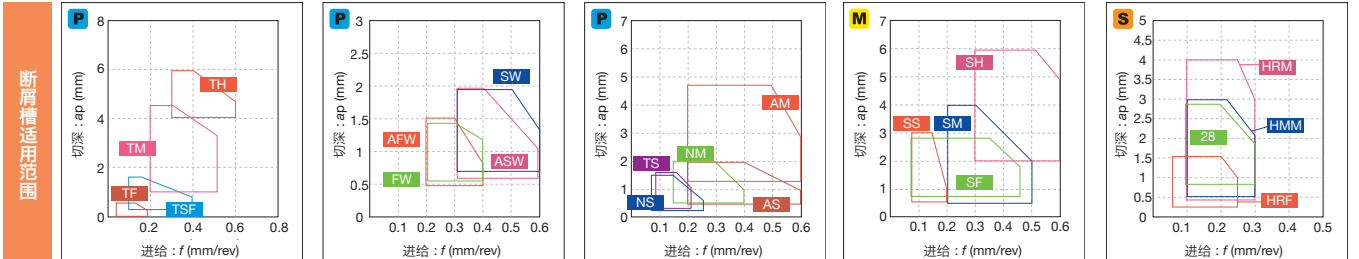
菱形, 80°
带内冷孔

材料	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	涂层硬质合金														金属陶瓷	尺寸 (mm)									
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	T515	AH110	AH120	AH725	AH8015	GH330	NS9530	RE	IC	S	D1		
精加工		SS CNMG090404E-SS																					0.4	9.525	4.76	3.81	
		CNMG090408E-SS																						0.8	9.525	4.76	3.81
		CNMG120404-SS										●	●	●	●			●						0.4	12.7	4.76	5.16
		CNMG120408-SS									●	●	●	●			●							0.8	12.7	4.76	5.16
		CNMG120412-SS									●	●	●	●			●							1.2	12.7	4.76	5.16
半精加工		TM CNMG090304-TM	●	●					▲	▲													0.4	9.525	3.18	3.81	
		CNMG090308-TM	●	●	●				▲	▲	▲													0.8	9.525	3.18	3.81
		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
		CNMG160612-TM	●	●	●	●			▲	▲	▲	▲					●							1.2	15.875	6.35	6.35
CNMG190608-TM	●	●	●	●			▲	▲	▲	▲					●							0.8	19.05	6.35	7.93		
CNMG190612-TM	●	●	●	●			▲	▲	▲	▲					●							1.2	19.05	6.35	7.93		
精加工到半精加工		AM CNMG120408-AM	●	●				▲	▲														0.8	12.7	4.76	5.16	
		CNMG120412-AM	●	●					▲	▲														1.2	12.7	4.76	5.16
		CNMG120416-AM	●	●					▲	▲														1.6	12.7	4.76	5.16
		NM CNMG120408-NM	●	●	●	●			▲	▲	▲	▲											●	0.8	12.7	4.76	5.16
CNMG120412-NM	●	●	●					▲	▲	▲													1.2	12.7	4.76	5.16	

●: 产品型号
▲: 停止生产



参考页: 外圆刀杆	→ C016 -	内孔刀杆	→ D021 -
J系列刀杆	→ G044	TungCap系列	→ K008 -
PINZBOHR®系列	→ K180 -	刀夹	→ K199 -

刀片 负前角

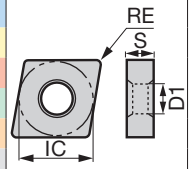
- : 连续切削
- ◐: 轻断续切削
- ✱: 强断续切削

CN



菱形, 80°
带内冷孔

材料	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料	涂层硬质合金	涂层金属陶瓷	金属陶瓷	不涂层硬质合金
●	●●●●✱	●●	●●	●●●●	●●●●	●●●●	●●●●●●	●●●●●●	●●●●	●●●●
◐										
✱										



应用	断屑槽	型号	涂层硬质合金												涂层金属陶瓷			金属陶瓷		不涂层硬质合金	尺寸 (mm)						
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T515	T5105	T5115	T5125	AH110	AH120	GT9530	AT9530	GT720	NS9530	NS520	TH10	RE	IC	S	D1	
精加工到半精加工	TQ 	CNMG120404-TQ	●	●												●	●		●			0.4	12.7	4.76	5.16		
		CNMG120408-TQ	●	●													●	●		●			0.8	12.7	4.76	5.16	
半精加工	TA 	CNMG120408-TA	●	●																		0.8	12.7	4.76	5.16		
		CNMG120412-TA	●	●																			1.2	12.7	4.76	5.16	
精加工到半精加工	ZM 	CNMG090408E-ZM	●	●			▲	▲											●			0.8	9.525	4.76	3.81		
		CNMG120408-ZM	●	●	●		▲	▲	▲							●			●				0.8	12.7	4.76	5.16	
		CNMG120412-ZM	●	●	●		▲	▲	▲							●								1.2	12.7	4.76	5.16
		CNMG120416-ZM	●	●			▲	▲																1.6	12.7	4.76	5.16
半精加工	DM 	CNMG120404-DM	●	●			▲	▲														0.4	12.7	4.76	5.16		
		CNMG120408-DM	●	●	●	●	▲	▲	▲	▲													0.8	12.7	4.76	5.16	
		CNMG120412-DM	●	●	●	●	▲	▲	▲	▲														1.2	12.7	4.76	5.16
	全周 	CNMG090304	●	●			▲	▲											●				0.4	9.525	3.18	3.81	
		CNMG090308	●	●	●	●	▲	▲	▲	▲							●		●					0.8	9.525	3.18	3.81
		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
		CNMG160608	●	●	●	●	▲	▲	▲	▲		●	●	●	●									0.8	15.875	6.35	6.35
CNMG160612	●	●	●	●	▲	▲	▲	▲	●	●	●	●	●		●							1.2	15.875	6.35	6.35		
CNMG160616	●	●	●	●	▲	▲	▲	▲	●	●	●	●	●									1.6	15.875	6.35	6.35		
		CNMG190608	●	●	●		▲	▲	▲														0.8	19.05	6.35	7.93	
		CNMG190612	●	●	●	●	▲	▲	▲	●	●	●	●		●								1.2	19.05	6.35	7.93	
		CNMG190616	●	●	●		▲	▲	▲	●	●	●	●		●								1.6	19.05	6.35	7.93	

●: 产品型号
▲: 停止生产

参考页: 外圆刀杆 → C016 - 内孔刀杆 → D021 -
J系列刀杆 → G044 TungCap系列 → K008 -
PINZBOHR®系列 → K180 - 刀夹 → K199 -

刀片 负前角

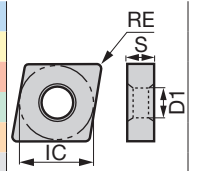
●：连续切削
●：轻断续切削
✱：强断续切削

CN



菱形, 80°
带内冷孔

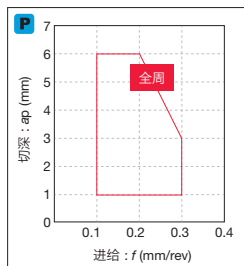
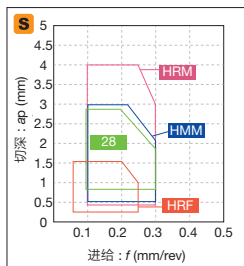
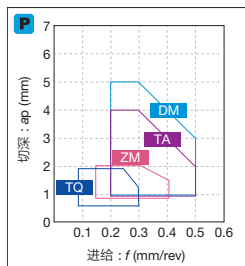
材料	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料	涂层硬质合金	涂层金属陶瓷	金属陶瓷	不涂层硬质合金
●	●	●	●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●	●	●	●
✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱



应用	断屑槽	型号	涂层硬质合金										涂层金属陶瓷	金属陶瓷	不涂层硬质合金	尺寸 (mm)					
			T9205	T9215	T9225	T9235	T9115	T9125	T9135	AH110	AH120	AH725	AH8005	AH8015	GH330	GT720	NS9530	TH10	RE	IC	S
精加工到半精加工		27 CNMG120404-27	●	●			▲	▲								●		0.4	12.7	4.76	5.16
		CNMG120408-27	●	●	●		▲	▲	▲							●		0.8	12.7	4.76	5.16
		CNMG120412-27			●			▲										1.2	12.7	4.76	5.16
半精加工		28 CNMG120404-28		●			▲		●	●		●	●					0.4	12.7	4.76	5.16
		CNMG120408-28							●	●		●	●					0.8	12.7	4.76	5.16
		CNMG120412-28										●	●					1.2	12.7	4.76	5.16
		33 CNMG120408-33							●						●			0.8	12.7	4.76	5.16
		CNMG120416-33		●			▲											1.6	12.7	4.76	5.16
半精加工		CNMG160612-33		●			▲										1.2	15.875	6.35	6.35	
		CNMG190612-33		●			▲										1.2	19.05	6.35	7.93	
		37 CNMG120404-37		●			▲								●			0.4	12.7	4.76	5.16
		CNMG120408-37		●			▲						●		●			0.8	12.7	4.76	5.16
半精加工		CNMG120412-37		●			▲										1.2	12.7	4.76	5.16	
		38 CNMG120404-38											●					0.4	12.7	4.76	5.16
半精加工		CNMG120408-38		●			▲			●		●					0.8	12.7	4.76	5.16	

●：产品型号
▲：停止生产

断屑槽适用范围



参考页: 外圆刀杆 → C016 - 内孔刀杆 → D023 -
J系列刀杆 → G044 TungCap系列 → K008 -
PINZBOHR®系列 → K180 - 刀夹 → K199 -

材质
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引

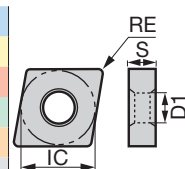
刀片 负前角

- : 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	断屑槽	型号	涂层硬质合金														尺寸 (mm)				
			T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6130	AH630	AH645	T515	T5105	T5115	T5125	RE	IC	S	D1	
半精强力切削 (单面)		CNMM120408-TRS	●	●	●	▲	▲	▲									0.8	12.7	4.76	5.16	
		CNMM120412-TRS	●	●	●	▲	▲	▲										1.2	12.7	4.76	5.16
		CNMM160612-TRS	●	●	●	▲	▲	▲										1.2	15.875	6.35	6.35
		CNMM160616-TRS	●	●	●	▲	▲	▲										1.6	15.875	6.35	6.35
		CNMM190616-TRS	●	●	●	▲	▲	▲										1.6	19.05	6.35	7.93
		CNMM190624-TRS	●	●	●	▲	▲	▲										2.4	19.05	6.35	7.93
		CNMM250924-TRS	●	●	●	▲	▲	▲										2.4	25.4	9.52	9.12
强切屑 (单面)		CNMM190612-TU		●	●		▲	▲									1.2	19.05	6.35	7.93	
		CNMM190616-TU		●	●		▲	▲										1.6	19.05	6.35	7.93
		CNMM190624-TU	●	●	●	▲	▲	▲										2.4	19.05	6.35	7.93
		CNMM250924-TU		●	●		▲	▲										2.4	25.4	9.52	9.12
强切屑 (单面)		CNMM190608-TUS	●	●		▲	▲										0.8	19.05	6.35	7.93	
		CNMM190612-TUS	●	●	●	▲	▲	▲										1.2	19.05	6.35	7.93
		CNMM190616-TUS	●	●	●	▲	▲	▲										1.6	19.05	6.35	7.93
		CNMM190624-TUS	●	●	●	▲	▲	▲										2.4	19.05	6.35	7.93
		CNMM190632-TUS	●	●		▲	▲											3.2	19.05	6.35	7.93
		CNMM250916-TUS	●	●	●	▲	▲	▲										1.6	25.4	9.52	9.12
		CNMM250924-TUS	●	●	●	▲	▲	▲										2.4	25.4	9.52	9.12
CNMM250932-TUS	●	●		▲	▲											3.2	25.4	9.52	9.12		
半精强力切削 (单面)		CNMM120412-65		●		▲											1.2	12.7	4.76	5.16	
中至重载加工		CNMG120408-SH							●	●	●						0.8	12.7	4.76	5.16	
		CNMG120412-SH							●	●	●							1.2	12.7	4.76	5.16
		CNMG120416-SH							●	●	●							1.6	12.7	4.76	5.16
		CNMG160612-SH							●	●	●							1.2	15.875	6.35	6.35
		CNMG160616-SH							●	●	●							1.6	15.875	6.35	6.35
		CNMG190612-SH							●	●	●							1.2	19.05	6.35	7.93
		CNMG190616-SH							●	●	●							1.6	19.05	6.35	7.93
中至重载加工		CNMG120404-CH									●	●	●				0.4	12.7	4.76	5.16	
		CNMG120408-CH									●	●	●	●				0.8	12.7	4.76	5.16
		CNMG120412-CH									●	●	●	●				1.2	12.7	4.76	5.16
		CNMG160612-CH										●	●	●	●			1.2	15.875	6.35	6.35
		CNMG160616-CH										●	●	●	●			1.6	15.875	6.35	6.35
		CNMG190612-CH										●	●	●	●			1.2	19.05	6.35	7.93
CNMG190616-CH										●	●	●	●			1.6	19.05	6.35	7.93		

●: 产品型号
▲: 停止生产

参考页: 外圆刀杆 → C018 - 内孔刀杆 → D023 -
 J系列刀杆 → G044 TungCap系列 → K008 -
 PINZBOHR®系列 → K180 - 刀夹 → K199 -

刀片 负前角

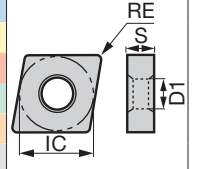
●: 连续切削
 ●: 轻断续切削
 ★: 强断续切削

CN



菱形, 80°
带内冷孔

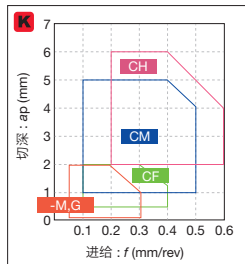
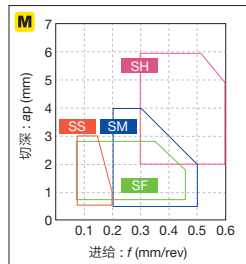
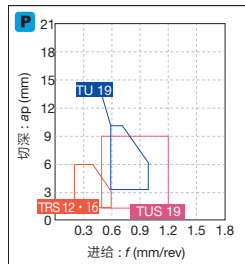
材料	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超合金	H 硬材料
●						
●						
★						



应用	断屑槽	型号	涂层硬质合金					金属陶瓷	不涂层硬质合金	陶瓷		尺寸 (mm)				
			T9205	T9105	T515	T5105	T5115	T5125	NS520	TH10	FX105	LX21	LX11	RE	IC	S
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
		CNMA120404				●	●	●		●			0.4	12.7	4.76	5.16
		CNMA120408	●	▲	●	●	●	●	●	●	●		0.8	12.7	4.76	5.16
		CNMA120412	●	▲	●	●	●	●		●			1.2	12.7	4.76	5.16
		CNMA120416	●	▲	●	●	●	●		●			1.6	12.7	4.76	5.16
		CNMA160608				●	●	●					0.8	15.875	6.35	6.35
		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
		修光刃	CNMA120408W								●		0.8	12.7	4.76	5.16
			CNMA120412W								●	●	1.2	12.7	4.76	5.16
			CNMA120416W								●		1.6	12.7	4.76	5.16
			- CNGA120404								●	●	0.4	12.7	4.76	5.16
			CNGA120408					●			●	●	0.8	12.7	4.76	5.16
			CNGA120412								●	●	1.2	12.7	4.76	5.16
			CNGA120416								●	●	1.6	12.7	4.76	5.16
			CNGA120420									●	2	12.7	4.76	5.16

●: 产品型号
 ▲: 停止生产

断屑槽适用范围



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C018 - 内孔刀杆 → D021 -
 J系列刀杆 → G044 TungCap系列 → K008 -
 PINZBOHR®系列 → K180 - 刀夹 → K199 -

刀片 负前角

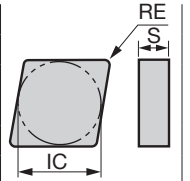
●: 连续切削
●: 轻断续切削
⊛: 强断续切削

CN



菱形, 80°
不带孔

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



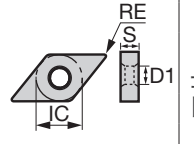
应用	断屑槽	型号	陶瓷				尺寸 (mm)			
			FX105	LX21	LX11	CX710	RE	IC	S	D1
- 	-	CNGD120712	●				1.2	12.7	7.94	-
	-	CNGD120716	●				1.6	12.7	7.94	-
- 	-	CNMN120408	●				0.8	12.7	4.76	-
	-	CNMN120412	●				1.2	12.7	4.76	-
- 	-	CNGN120404			●		0.4	12.7	4.76	-
	-	CNGN120408	●		●		0.8	12.7	4.76	-
	-	CNGN120412	●		●	●	1.2	12.7	4.76	-
	-	CNGN120416	●		●		1.6	12.7	4.76	-
	-	CNGN120420	●				2	12.7	4.76	-
	-	CNGN120708	●		●		0.8	12.7	7.94	-
	-	CNGN120712	●		●		1.2	12.7	7.94	-
	-	CNGN120716	●		●		1.6	12.7	7.94	-
	-	CNGN120720			●		2	12.7	7.94	-

●: 产品型号

DN

55°菱形
带内冷孔

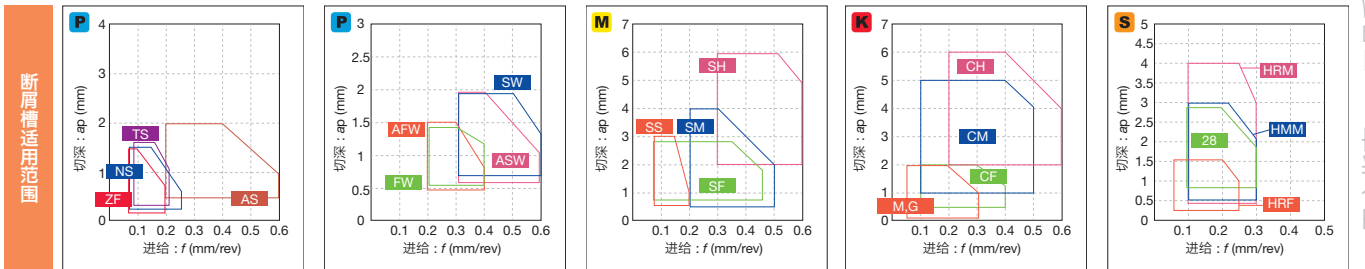
P	钢	●	●	●	●	✱	✱	●	●	●	●	✱	●	●	●	●	●	●	●	●
M	不锈钢	●	●																	
K	铸铁	●	●					●	●	●	●		●	●	●	●				
N	非铁金属																			
S	超级合金																			
H	硬材料																			



应用	断屑槽	型号	涂层硬质合金							涂层金属陶瓷		金属陶瓷		尺寸 (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	GT9530	AT9530	NS9530	NS520	RE	IC	S
精加工		TS DNMG150404-TS	●	●	●	●	▲	▲	▲	●	●	●	●	0.4	12.7	4.76	5.16
		DNMG150408-TS	●	●	●	●	▲	▲	▲	●	●	●	●	0.8	12.7	4.76	5.16
		DNMG150412-TS	●	●	●	●	▲	▲	▲					1.2	12.7	4.76	5.16
		DNMG150604-TS								●	●	●	●	0.4	12.7	6.35	5.16
		DNMG150608-TS	●	●			▲	▲		●	●	●	●	0.8	12.7	6.35	5.16
		DNMG150612-TS	●	●			▲	▲						1.2	12.7	6.35	5.16
精加工到半精加工 (修光刃)		SW DNMG110408E-SW	●				▲						0.8	9.525	4.76	3.81	
		DNMG110412E-SW	●				▲						1.2	9.525	4.76	3.81	
		DNMG150408-SW	●				▲						0.8	12.7	4.76	5.16	
		DNMG150412-SW	●				▲						1.2	12.7	4.76	5.16	
		DNMG150608-SW	●				▲						0.8	12.7	6.35	5.16	
		DNMG150612-SW	●				▲						1.2	12.7	6.35	5.16	
小切深加工 大进给		AS DNMG150404-AS	●		●		▲	▲			●		0.4	12.7	4.76	5.16	
		DNMG150408-AS	●	●	●		▲	▲	▲			●		0.8	12.7	4.76	5.16
		DNMG150412-AS	●	●	●		▲	▲	▲					1.2	12.7	4.76	5.16
		DNMG150604-AS								●		●		0.4	12.7	6.35	5.16
		DNMG150608-AS	●	●			▲	▲						0.8	12.7	6.35	5.16
		DNMG150612-AS	●				▲							1.2	12.7	6.35	5.16
双面孔 镗刀		CB DNMG110404-CB							●		●		0.4	9.525	4.76	3.81	
		DNMG110408-CB	●				▲			●		●	0.8	9.525	4.76	3.81	
精加工		NS DNMG150404-NS			●			▲			●		0.4	12.7	4.76	5.16	
		DNMG150408-NS	●	●	●		▲	▲	▲			●		0.8	12.7	4.76	5.16

请参考 L032-L036 页, 依据修光刃锥度和圆弧来调整程序
如有问题, 请联系我们的销售人员获取帮助

●: 产品型号
▲: 停止生产



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C037 - 内孔刀杆 → D052 -
J系列刀杆 → G046 TungCap系列 → C045, K012 -

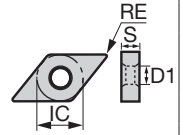
刀片 负前角

- : 连续切削
- ◐ : 轻断续切削
- ✳ : 强断续切削

DN

55°菱形带内冷孔

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



应用	断屑槽	型号	涂层硬质合金											涂层金属陶瓷	金属陶瓷	不涂层硬质合金	尺寸 (mm)									
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	AH110	AH120	GH330	GT9530	NS9530	KS20	RE	IC	S	D1		
精加工		SS DNMG110404E-SS																			●	0.4	9.525	4.76	3.81	
		DNMG110408E-SS																					0.8	9.525	4.76	3.81
		DNMG150404-SS									●	●	●	●			●						0.4	12.7	4.76	5.16
		DNMG150408-SS									●	●	●	●			●			●			0.8	12.7	4.76	5.16
		DNMG150412-SS									●	●	●	●									1.2	12.7	4.76	5.16
		DNMG150604-SS									●	●	●	●			●	●					0.4	12.7	6.35	5.16
		DNMG150608-SS									●	●	●	●			●	●					0.8	12.7	6.35	5.16
		DNMG150612-SS									●	●	●	●									1.2	12.7	6.35	5.16
半精加工		TM DNMG110404E-TM		●	●																	0.4	9.525	4.76	3.81	
		DNMG110408E-TM		●	●																		0.8	9.525	4.76	3.81
		DNMG110412E-TM		●	●																		1.2	9.525	4.76	3.81
		DNMG110404-TM		●	●	●																	0.4	9.525	4.76	3.81
		DNMG110408-TM		●	●	●																	0.8	9.525	4.76	3.81
		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
		DNMG150604-TM		●	●	●	●	▲	▲	▲	▲						●						0.4	12.7	6.35	5.16
		DNMG150608-TM		●	●	●	●	▲	▲	▲	▲						●						0.8	12.7	6.35	5.16
		DNMG150612-TM		●	●	●	●	▲	▲	▲	▲						●						1.2	12.7	6.35	5.16
DNMG150616-TM		●	●	●	●	▲	▲	▲	▲												1.6	12.7	6.35	5.16		
精加工到半精加工		AM DNMG150408-AM		●	●																	0.8	12.7	4.76	5.16	
		DNMG150412-AM		●	●																		1.2	12.7	4.76	5.16
		DNMG150416-AM		●	●																		1.6	12.7	4.76	5.16
		DNMG150608-AM		●	●																		0.8	12.7	6.35	5.16
		DNMG150612-AM		●	●																		1.2	12.7	6.35	5.16
		DNMG150616-AM		●	●																		1.6	12.7	6.35	5.16
其它		NM DNMG150408-NM		●	●	●				▲	▲	▲			●		●				0.8	12.7	4.76	5.16		
		DNMG150412-NM		●	●	●					▲	▲	▲									1.2	12.7	4.76	5.16	
		DNMG150608-NM														●		●				0.8	12.7	6.35	5.16	

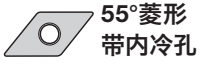
● : 产品型号
▲ : 停止生产

参考页: 外圆刀杆 → C037 - 内孔刀杆 → D052 -
J系列刀杆 → G046 TungCap系列 → C045, K012 -

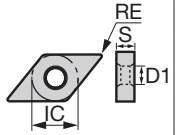
刀片 负前角

- : 连续切削
- ◐: 轻断续切削
- ✱: 强断续切削

DN



材料	钢	不锈钢	铸铁	非铁金属	超级合金	硬材料	涂层硬质合金	涂层金属陶瓷	金属陶瓷	不涂层硬质合金
P	●	●	●	●	●	●	●	●	●	●
M	●	●	●	●	●	●	●	●	●	●
K	●	●	●	●	●	●	●	●	●	●
N	●	●	●	●	●	●	●	●	●	●
S	●	●	●	●	●	●	●	●	●	●
H	●	●	●	●	●	●	●	●	●	●



应用	断屑槽	型号	涂层硬质合金													涂层金属陶瓷	金属陶瓷	不涂层硬质合金	尺寸 (mm)														
			T9215	T9115	T6120	T6130	T515	T5105	T5115	T5125	AH630	AH645	AH8005	AH8015	AH110	AH120	GH330	GT9530	NS9530	TH10	RE	IC	S	D1									
应用		DNMG150404-28											●	●							●	0.4	12.7	4.76	5.16								
		DNMG150408-28											●	●		●							●	0.8	12.7	4.76	5.16						
		DNMG150604-28											●	●										●	0.4	12.7	6.35	5.16					
		DNMG150608-28											●	●										●	0.8	12.7	6.35	5.16					
应用		DNMG150404-33																					●	0.4	12.7	4.76	5.16						
		DNMG150408-33																						●	0.8	12.7	4.76	5.16					
应用		DNMG150404-37																						●	0.4	12.7	4.76	5.16					
		DNMG150408-37																							●	0.8	12.7	4.76	5.16				
		DNMG150608-37	●	▲																							●	0.8	12.7	6.35	5.16		
应用		DNMG150412-38	●	▲																								1.2	12.7	4.76	5.16		
应用	平行	DNGG150404R																●								●	0.4	12.7	4.76	5.16			
		DNGG150404L																	●								●	0.4	12.7	4.76	5.16		
		DNGG150408R																		●							●	0.8	12.7	4.76	5.16		
		DNGG150408L																			●						●	0.8	12.7	4.76	5.16		
应用	SM	DNMG110404E-SM			●	●						●																	0.4	9.525	4.76	3.81	
		DNMG110408E-SM			●	●						●																		0.8	9.525	4.76	3.81
		DNMG150404-SM			●	●						●	●																	0.4	12.7	4.76	5.16
		DNMG150408-SM			●	●						●	●																	0.8	12.7	4.76	5.16
		DNMG150412-SM			●	●						●	●																	1.2	12.7	4.76	5.16
		DNMG150604-SM			●	●						●	●																	0.4	12.7	6.35	5.16
		DNMG150608-SM			●	●						●	●																	0.8	12.7	6.35	5.16
		DNMG150612-SM			●	●						●	●																	1.2	12.7	6.35	5.16
应用	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	
		DNMG150604-CM										●	●	●															0.4	12.7	6.35	5.16	
		DNMG150608-CM										●	●	●															0.8	12.7	6.35	5.16	
		DNMG150612-CM										●	●	●															1.2	12.7	6.35	5.16	

●: 产品型号
▲: 停止生产

参考页: 外圆刀杆 → C037 - 内孔刀杆 → D052 -
J系列刀杆 → G046 TungCap系列 → C045, K012 -

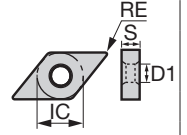
刀片 负前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

材质

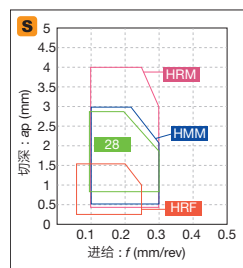
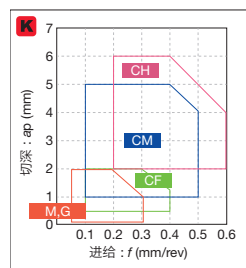
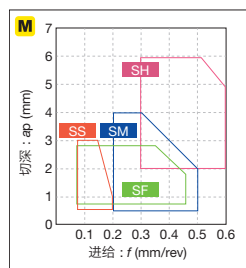
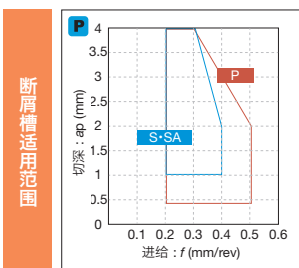
DN

55°菱形
带内冷孔



应用	断屑槽	型号	涂层硬质合金								金属陶瓷	不涂层硬质合金		尺寸 (mm)							
			T9225	T9235	T9125	T9135	T6130	AH630	AH645	AH120	AH8005	AH8015	AH905	GH110	GH330	NS9530	TH10	RE	IC	S	D1
半精加工		P DNGG150402R-P	●✱	✱	✱	✱	✱	✱	●	●	●	●	●	●	●	●	0.2	12.7	4.76	5.16	
		DNGG150402L-P							●	●	●	●	●	●	●	●	0.2	12.7	4.76	5.16	
		DNGG150404R-P										●	●	●	●	●	0.4	12.7	4.76	5.16	
		DNGG150404L-P										●	●	●	●	●	0.4	12.7	4.76	5.16	
		DNGG150408R-P															0.8	12.7	4.76	5.16	
		DNGG150408L-P															0.8	12.7	4.76	5.16	
精加工到半精加工		HRM DNMG150404-HRM							●	●							0.4	12.7	4.76	5.16	
		DNMG150408-HRM							●	●							0.8	12.7	4.76	5.16	
		DNMG150412-HRM								●	●						1.2	12.7	4.76	5.16	
		DNMG150604-HRM								●	●						0.4	12.7	6.35	5.16	
		DNMG150608-HRM								●	●						0.8	12.7	6.35	5.16	
		DNMG150612-HRM								●	●						1.2	12.7	6.35	5.16	
半精加工		HMM DNMG150404-HMM									●						0.4	12.7	4.76	5.16	
		DNMG150408-HMM									●						0.8	12.7	4.76	5.16	
		DNMG150412-HMM										●					1.2	12.7	4.76	5.16	
		SA DNMG150404-SA								●								0.4	12.7	4.76	5.16
		DNMG150408-SA								●								0.8	12.7	4.76	5.16
		DNMG150604-SA								●								0.4	12.7	6.35	5.16
半精加工		S DNMG150404R-S	●	●	▲	▲	●	●	●				●	●			0.4	12.7	4.76	5.16	
		DNMG150404L-S	●	●	▲	▲	●	●	●				●	●			0.4	12.7	4.76	5.16	
		DNMG150408R-S	●	●	▲	▲	●	●	●				●	●			0.8	12.7	4.76	5.16	
		DNMG150408L-S	●	●	▲	▲	●	●	●				●	●			0.8	12.7	4.76	5.16	
		DNMG150604R-S	●	●	▲	▲	●	●	●								0.4	12.7	6.35	5.16	
		DNMG150604L-S	●	●	▲	▲	●	●	●								0.4	12.7	6.35	5.16	
		DNMG150608R-S	●	●	▲	▲	●	●	●				●				0.8	12.7	6.35	5.16	
		DNMG150608L-S	●	●	▲	▲	●	●	●				●				0.8	12.7	6.35	5.16	

●: 产品型号
▲: 停止生产



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C042 - 内孔刀杆 → D052 -
J系列刀杆 → G046 TungCap系列 → C045, K012 -

刀片

外圆刀杆

内孔刀杆

螺紋加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系統

用戶指南

索引

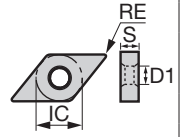
刀片 负前角

- : 连续切削
- : 轻断续切削
- : 强断续切削

DN

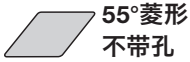


P	钢	●●	●																					
M	不锈钢		●																					
K	铸铁	●●	●	●●	●●	●●	●●																	
N	非铁金属		●																					
S	超级合金																							
H	硬材料									●														

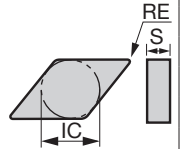


应用	断屑槽	型号	金属陶瓷		不涂层硬质合金			陶瓷			尺寸 (mm)			
			NS520	TH10				FX105	LX21	LX11	RE	IC	S	D1
精加工到半精加工	-	DNGA150404	●	●				●	●		0.4	12.7	4.76	5.16
		DNGA150408	●	●				●	●		0.8	12.7	4.76	5.16
		DNGA150412						●	●		1.2	12.7	4.76	5.16
		DNGA150416							●		1.6	12.7	4.76	5.16
		DNGA150604							●		-	-	-	-
		DNGA150608							●		0.8	12.7	6.35	5.16
		DNGA150612							●		1.2	12.7	6.35	5.16
		DNGA150616							●		1.6	12.7	6.35	5.16
	DNGA150620							●		2	12.7	6.35	5.16	

DN



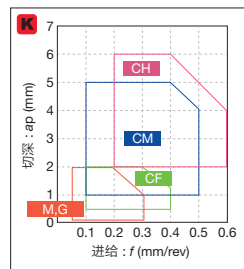
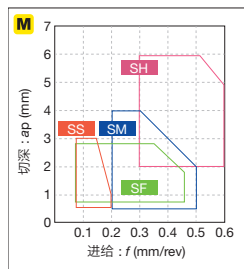
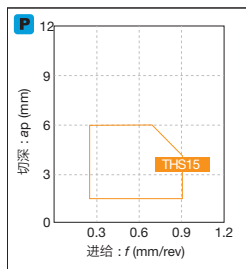
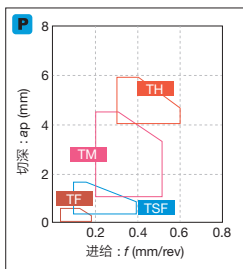
P	钢																							
M	不锈钢																							
K	铸铁	●●																						
N	非铁金属																							
S	超级合金																							
H	硬材料		●																					



应用	断屑槽	型号	陶瓷		尺寸 (mm)					
			FX105	LX11	RE	IC	S	D1		
精加工到半精加工	-	DNGD150708	●				0.8	12.7	7.94	-
		DNGD150712	●				1.2	12.7	7.94	-
		DNGD150716	●				1.6	12.7	7.94	-
	-	DNGN150404		●			0.4	12.7	4.76	-
		DNGN150408		●			0.8	12.7	4.76	-
		DNGN150412		●	●		1.2	12.7	4.76	-
		DNGN150416		●			1.6	12.7	4.76	-
		DNGN150708		●			0.8	12.7	7.94	-
		DNGN150712		●			1.2	12.7	7.94	-
		DNGN150716		●			1.6	12.7	7.94	-

●: 产品型号

断屑槽适用范围



M,G 精度等级: 无断屑槽

参考页: DNGA...: 外圆刀杆 → C042 -, 内孔刀杆 → D052 -, J系列刀杆 → G046, TungCap系列 → C045, K012 -
 DNGD...: 外圆刀杆 → C046 -

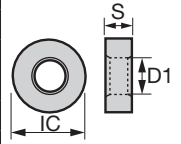
刀片 负前角

- : 连续切削
- : 轻断续切削
- *: 强断续切削

RN

圆形
带内冷孔

材料	P	M	K	N	S	H	涂层硬质合金								不涂层硬质合金			陶瓷									
钢	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
不锈钢		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
铸铁	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
非铁金属	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
超级合金	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
硬材料	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

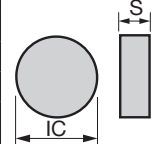


应用	断屑槽	型号	涂层硬质合金								不涂层硬质合金			陶瓷			尺寸 (mm)			
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH120	TH10	LX11				RE	IC	S	D1
重载加工 	-	RNMG090300-61	●	●												-	9.525	3.18	3.81	
		RNMG120400-61	●	●	●		▲	▲	▲	▲	●	●				-	12.7	4.76	5.16	
		RNMG150600-61	●	●			▲	▲								-	15.875	6.35	6.43	
		RNMG190600-61	●	●	●		▲	▲	▲							-	19.05	6.35	7.93	
		RNMG250900-61	●	●			▲	▲								-	25.4	9.52	9.22	
精加工到半精加工	-	RNGA120400										●			-	12.7	4.76	5.16		

RN

圆形
不带孔

材料	P	M	K	N	S	H	陶瓷								不涂层硬质合金			陶瓷									
钢	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
不锈钢		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
铸铁	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
非铁金属	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
超级合金	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
硬材料	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●



应用	断屑槽	型号	陶瓷			不涂层硬质合金								陶瓷			尺寸 (mm)			
			FX105	LX11	WG300													RE	IC	S
精加工到半精加工 	-	RNGN120400	●	●													-	12.7	4.76	-
		RNGN120700	●	●														-	12.7	7.94

- : 产品型号
- ▲: 停止生产

刀片 负前角

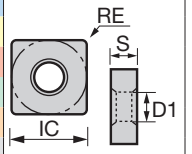
- : 连续切削
- : 轻断续切削
- *: 强断续切削

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	断屑槽	型号	涂层硬质合金															涂层金属陶瓷		金属陶瓷	不涂层硬质合金	尺寸 (mm)						
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	T5105	T5115	AH8005	AH8015	GT9530	AT9530	NS9530	TH10	RE	IC	S	D1			
精加工		11 SNMG120404-11																			●				0.4	12.7	4.76	5.16
		SNMG120408-11																				●	●			0.8	12.7	4.76
低精碳加工		17 SNMG120408-17																			●				0.8	12.7	4.76	5.16
		SF SNMG120404-SF									● ● ●															0.4	12.7	4.76
精加工		SNMG120408-SF								● ● ●															0.8	12.7	4.76	5.16
		CF SNMG120408-CF														● ●										0.8	12.7	4.76
精加工		SNMG120412-CF													● ●										1.2	12.7	4.76	5.16
		HRF SNMG120408-HRF																								0.8	12.7	4.76
精加工		SNMG120412-HRF																							1.2	12.7	4.76	5.16
		TS SNMG120404-TS		● ●			▲ ▲											● ●		●						0.4	12.7	4.76
精加工		SNMG120408-TS	● ● ● ● ● ▲ ▲ ▲ ▲ ▲														● ●		●						0.8	12.7	4.76	5.16
		SNMG120412-TS	● ● ● ● ● ▲ ▲ ▲ ▲ ▲																							1.2	12.7	4.76
小切大深加工		AS SNMG120404-AS		● ●			▲ ▲														●				0.4	12.7	4.76	5.16
		SNMG120408-AS	● ●				▲ ▲														●				0.8	12.7	4.76	5.16

●: 产品型号
▲: 停止生产

参考页: 外圆刀杆 → C093 - 内孔刀杆 → D040 -
刀夹系列 → K197

刀片 负前角

- : 连续切削
- (小) : 轻断续切削
- ▲ (小) : 强断续切削

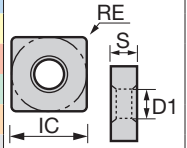
材质

SN



方形, 90°
带内冷孔

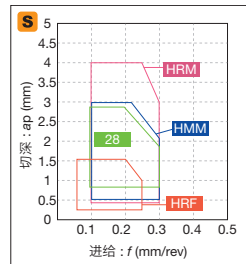
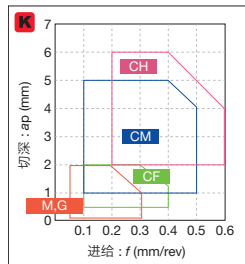
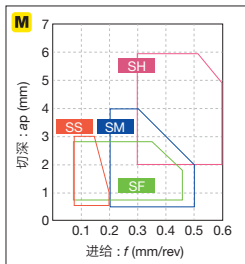
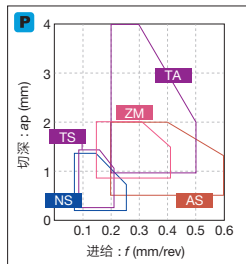
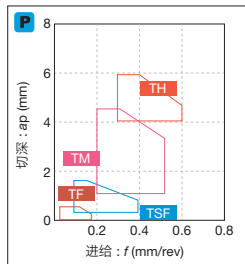
材质	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层	涂层
●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●



应用	断屑槽	型号	涂层硬质合金												尺寸 (mm)							
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	AH120	GH330	RE	IC	S	D1		
精加工		NS SNMG120408-NS	●	●														0.8	12.7	4.76	5.16	
			SS SNMG120404-SS																0.4	12.7	4.76	5.16
			SNMG120408-SS																0.8	12.7	4.76	5.16
SNMG120412-SS																	1.2	12.7	4.76	5.16		
半精加工		TM SNMG090304-TM	●	●	●				▲	▲	▲							0.4	9.525	3.18	3.81	
		SNMG090308-TM	●	●	●				▲	▲	▲							0.8	9.525	3.18	3.81	
		SNMG120404-TM	●	●					▲	▲	▲					●		0.4	12.7	4.76	5.16	
		SNMG120408-TM	●	●	●		▲	▲	▲	▲	▲					●		0.8	12.7	4.76	5.16	
		SNMG120412-TM	●	●	●		▲	▲	▲	▲	▲					●		1.2	12.7	4.76	5.16	
		SNMG120416-TM	●	●	●		▲	▲	▲	▲	▲					●		1.6	12.7	4.76	5.16	
		SNMG150608-TM	●						▲	▲	▲					●		0.8	15.875	6.35	6.35	
		SNMG150612-TM	●						▲	▲	▲					●		1.2	15.875	6.35	6.35	
		SNMG190608-TM	●						▲	▲	▲					●		0.8	19.05	6.35	7.93	
SNMG190612-TM	●						▲	▲	▲					●		1.2	19.05	6.35	7.93			
半精加工		TA SNMG120408-TA	●	●													0.8	12.7	4.76	5.16		
		SNMG120412-TA	●	●														1.2	12.7	4.76	5.16	
精加工到半精加工		ZM SNMG120408-ZM	●	●	●				▲	▲	▲						0.8	12.7	4.76	5.16		
		SNMG120412-ZM	●	●	●				▲	▲	▲						1.2	12.7	4.76	5.16		

● : 产品型号
▲ : 停止生产

断屑槽适用范围



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C093 - 内孔刀杆 → D040 -
刀夹系列 → K197

刀片

外圆刀杆

内孔刀杆

螺旋加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

用户指南

索引

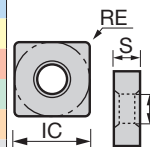
刀片 负前角

●: 连续切削
●: 轻断续切削
* : 强断续切削

SN

方形, 90°
带内冷孔

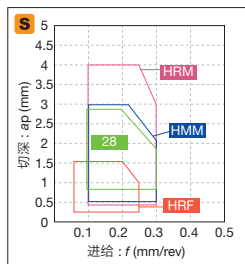
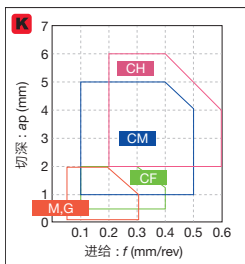
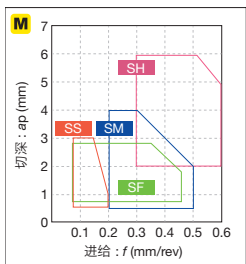
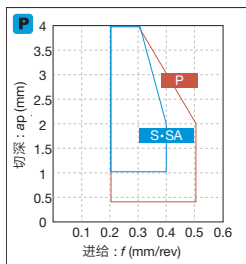
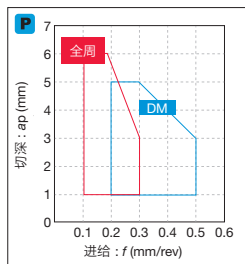
材料	P 钢	M 不锈钢	K 铸钢	N 非铁金属	S 超级合金	H 硬材料
涂层硬质合金	●	●	●	●	●	●
不涂层硬质合金	●	●	●	●	●	●



应用	断屑槽	型号	涂层硬质合金											不涂层硬质合金		尺寸 (mm)								
			T6120	T6130	AH630	AH645	AH120	T515	T5105	T5115	T5125	AH8005	AH8015	GH110	AH905	GH330	TH10	KS20	RE	IC	S	D1		
半精加工	CM	SNMG120408-CM						●	●	●	●								0.8	12.7	4.76	5.16		
		SNMG120412-CM						●	●	●	●								1.2	12.7	4.76	5.16		
	P	SNGG090304R-P																	●	0.4	9.525	3.18	3.81	
		SNGG090304L-P																		●	0.4	9.525	3.18	3.81
		SNGG090308R-P																		●	0.8	9.525	3.18	3.81
		SNGG090308L-P																		●	0.8	9.525	3.18	3.81
		SNGG120404R-P																		●	0.4	12.7	4.76	5.16
		SNGG120404L-P																		●	0.4	12.7	4.76	5.16
		SNGG120408R-P																		●	0.8	12.7	4.76	5.16
	SNGG120408L-P																		●	0.8	12.7	4.76	5.16	
	精加工到半精加工	HRM	SNMG120408-HRM													●	●			0.8	12.7	4.76	5.16	
SNMG120412-HRM															●	●			1.2	12.7	4.76	5.16		
SNMG150608-HRM															●	●			0.8	15.875	6.35	6.35		
SNMG150612-HRM															●	●			1.2	15.875	6.35	6.35		
SNMG190612-HRM															●	●			1.2	19.05	6.35	7.93		
半精加工	HMM	SNMG120408-HMM																	0.8	12.7	4.76	5.16		
		SNMG120412-HMM																	1.2	12.7	4.76	5.16		
		SA	SNMG120404-SA	●	●	●	●	●												0.4	12.7	4.76	5.16	
		SNMG120408-SA	●	●	●	●	●											●		0.8	12.7	4.76	5.16	
SNMG120412-SA	●	●	●	●	●													1.2	12.7	4.76	5.16			
SNMG190612-SA						●											●	1.2	19.05	6.35	7.93			

●: 产品型号

断屑槽适用范围



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C093 - 内孔刀杆 → D040 -
刀夹系列 → K197

材质
刀片
外圆刀杆
内孔刀杆
螺纹加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引

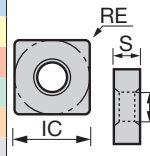
刀片 负前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

SN

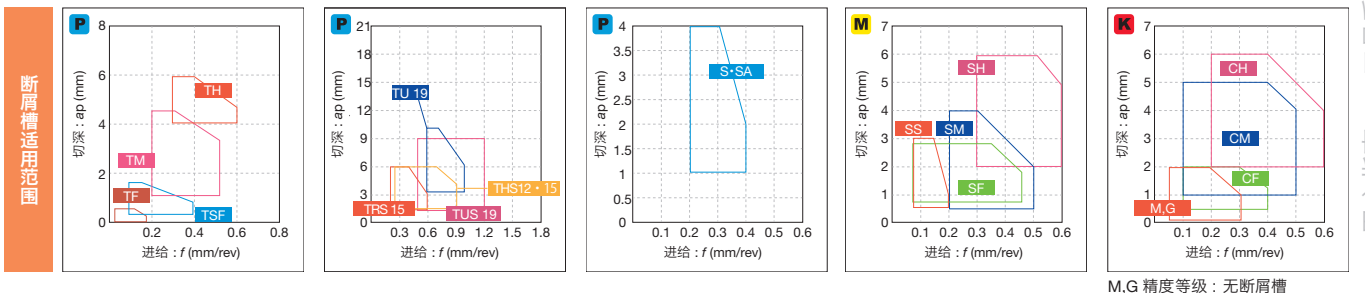
方形, 90°
带内冷孔

材料	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料	T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6130	AH630	AH645	T5105	T5115	T5125	
●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱



应用	断屑槽	型号	涂层硬质合金																	尺寸 (mm)									
			T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6130	AH630	AH645	T5105	T5115	T5125	RE	IC	S	D1										
重载加工 单面加工		TUS SNMM190612-TUS	●	●	●	●	▲	▲	▲														1.2	19.05	6.35	7.93			
		SNMM190616-TUS	●	●	●	●	▲	▲	▲															1.6	19.05	6.35	7.93		
		SNMM190624-TUS	●	●	●	●	▲	▲	▲																2.4	19.05	6.35	7.93	
		SNMM250724-TUS	●	●	●	●	▲	▲	▲																2.4	25.4	7.94	9.12	
		SNMM250732-TUS	●	●	●	●	▲	▲																	3.2	25.4	7.94	9.12	
		SNMM250924-TUS	●	●	●	●	▲	▲	▲																	2.4	25.4	9.52	9.12
		SNMM250932-TUS	●	●	●	●	▲	▲																		3.2	25.4	9.52	9.12
		57 SNMM120408-57	●	●	●	●	▲	▲																		0.8	12.7	4.76	5.16
半精加工 (单面)		SNMM150616-57		●																				1.6	15.875	6.35	6.35		
		SNMM190612-57		●																					1.2	19.05	6.35	7.93	
中至重载加工		SH SNMG120408-SH												●	●	●								0.8	12.7	4.76	5.16		
		SNMG120412-SH													●	●	●								1.2	12.7	4.76	5.16	
中至重载加工		SNMG150612-SH												●	●	●								1.2	15.875	6.35	6.35		
		SNMG150616-SH													●	●	●								1.6	15.875	6.35	6.35	
		SNMG190612-SH													●	●	●								1.2	19.05	6.35	7.93	
		SNMG190616-SH													●	●	●								1.6	19.05	6.35	7.93	
		CH SNMG120408-CH																	●	●	●					0.8	12.7	4.76	5.16
		SNMG120412-CH																	●	●	●					1.2	12.7	4.76	5.16
	SNMG120416-CH																●	●	●					1.6	12.7	4.76	5.16		

●: 产品型号
▲: 停止生产



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C093 - 内孔刀杆 → D040 -
刀夹系列 → K197

刀片 负前角

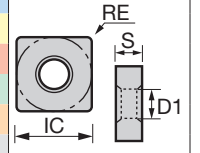
- : 连续切削
- : 轻断续切削
- : 强断续切削

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	断屑槽	型号	涂层硬质合金		涂层金属陶瓷	金属陶瓷	不涂层硬质合金	陶瓷	尺寸 (mm)							
			T515	T5105	T5115	T5125	GT720	NS520	TH10	FX105	LX21	LX11	RE	IC	S	D1
精加工到半精加工	-	SNMA090308	●									0.8	9.525	3.18	3.81	
	-	SNMA120404	●	●	●		●					0.4	12.7	4.76	5.16	
	-	SNMA120408	●	●	●	●		●				0.8	12.7	4.76	5.16	
	-	SNMA120412	●	●	●	●		●				1.2	12.7	4.76	5.16	
	-	SNMA120416		●	●	●						1.6	12.7	4.76	5.16	
	-	SNGA090304										0.4	9.525	3.18	3.81	
	-	SNGA120404					●					0.4	12.7	4.76	5.16	
	-	SNGA120408						●			●		0.8	12.7	4.76	5.16
	-	SNGA120412							●		●		1.2	12.7	4.76	5.16
	-	SNGA120416								●	●		1.6	12.7	4.76	5.16

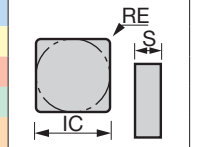
●: 产品型号

SN



方形, 90°
不带孔

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	不涂层硬质合金		陶瓷		尺寸 (mm)							
			TH10	FX105	LX21	LX11	RE	IC	S	D1				
精加工到半精加工	-	SNGD120712									1.2	12.7	7.94	-
	-	SNGD120716									1.6	12.7	7.94	-
	-	SNGN090308									0.8	9.525	3.18	-
	-	SNGN120304									0.4	12.7	3.18	-
	-	SNGN120312									1.2	12.7	3.18	-
	-	SNGN120404									0.4	12.7	4.76	-
	-	SNGN120408	●								0.8	12.7	4.76	-
	-	SNGN120412		●	●	●					1.2	12.7	4.76	-
	-	SNGN120416			●	●	●				1.6	12.7	4.76	-
	-	SNGN120420			●	●					2	12.7	4.76	-
	-	SNGN120424				●					2.4	12.7	4.76	-
	-	SNGN120708									0.8	12.7	7.94	-
	-	SNGN120712									1.2	12.7	7.94	-
	-	SNGN120716									1.6	12.7	7.94	-
	-	SNGN120720									2	12.7	7.94	-

●: 产品型号

参考页: 外圆刀杆 → C093 - 刀夹系列 → K197
SNGD...: 外圆刀杆 → C108

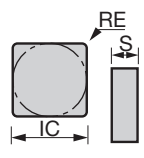
刀片 负前角

- : 连续切削
- ◐: 轻断续切削
- ⊛: 强断续切削

SN

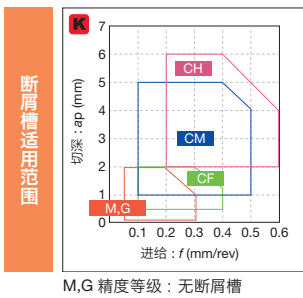
方形, 90°
不带孔

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	涂层硬质合金 / 不涂层硬质合金														尺寸 (mm)																								
			AH120															RE	IC	S	D1																				
精加工 到半精加工	-	SNMN120408																																							
		SNMN120412	●																																						

●: 产品型号



参考页: SNMN...: 外圆刀杆 → C093 -

材质
A
刀片
B
外圆刀杆
C
内孔刀杆
D
螺旋加工
E
槽加工
F
小零件刀具
G
铰刀
H
立铣刀
I
孔加工刀具
J
工具系统
K
用户指南
L
索引
M

刀片 负前角

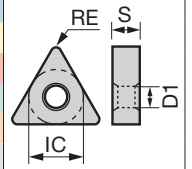
- : 连续切削
- ◐: 轻断续切削
- ◑: 强断续切削

TN



三角形, 60°
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	断屑槽	型号	涂层硬质合金		涂层金属陶瓷		金属陶瓷			不涂层硬质合金	尺寸 (mm)			
			GH110	GH330 SH725	GT9530 GT720	NS9530 NS520 X407	TH10	RE	IC	S	D1			
精密加工		TNMG160404-TF						●	●	●	0.4	9.525	4.76	3.81
		TNMG160408-TF						●	●		0.8	9.525	4.76	3.81
		TNGG110302-01						●			0.2	6.35	3.18	2.26
		TNGG110304-01						●			0.4	6.35	3.18	2.26
		TNGG110308-01						●	●		0.8	6.35	3.18	2.26
		TNGG160402-01	●					●	●	●	0.2	9.525	4.76	3.81
		TNGG160404-01	●					●	●	●	0.4	9.525	4.76	3.81
		TNGG160408-01	●					●	●		0.8	9.525	4.76	3.81
精密切屑 (锋利刀)		TNGG160412-01			●		●			1.2	9.525	4.76	3.81	
		TNGG160402F-01		●						0.2	9.525	4.76	3.81	
		TNGG160404F-01		●						0.4	9.525	4.76	3.81	
	精密加工		TNGG160408F-01		●						0.8	9.525	4.76	3.81
			TNGG110304R-A			●		●			0.4	6.35	3.18	2.26
			TNGG110304L-A			●		●			0.4	6.35	3.18	2.26
			TNGG110308R-A			●		●			0.8	6.35	3.18	2.26
			TNGG110308L-A			●		●			0.8	6.35	3.18	2.26
TNGG160304R-C							●	●		0.4	9.525	3.18	3.81	
TNGG160304L-C							●			0.4	9.525	3.18	3.81	
TNGG160308R-C							●			0.8	9.525	3.18	3.81	
TNGG160308L-C							●			0.8	9.525	3.18	3.81	
TNGG160400R-C							●			0.03	9.525	4.76	3.81	
TNGG160400L-C							●			0.03	9.525	4.76	3.81	
其它		TNGG160402R-C			●		●	●	●	0.2	9.525	4.76	3.81	
		TNGG160402L-C			●		●			0.2	9.525	4.76	3.81	
		TNGG160404R-C	●	●	●		●	●	●	●	0.4	9.525	4.76	3.81
		TNGG160404L-C	●	●	●		●	●	●	●	0.4	9.525	4.76	3.81
		TNGG160408R-C	●	●	●		●	●	●	●	0.8	9.525	4.76	3.81
		TNGG160408L-C	●	●	●		●	●	●	●	0.8	9.525	4.76	3.81
		TNGG220404R-D					●	●			0.4	12.7	4.76	5.16
TNGG220404L-D					●				0.4	12.7	4.76	5.16		
TNGG220408R-D					●	●			0.8	12.7	4.76	5.16		
TNGG220408L-D					●				0.8	12.7	4.76	5.16		

●: 产品型号

参考页: 外圆刀杆 → C027 - 内孔刀杆 → D046 -
J系列刀杆 → G045 - 刀夹系列 → K193 -

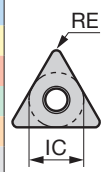
刀片 负前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

TN

三角形, 60°
带内冷孔

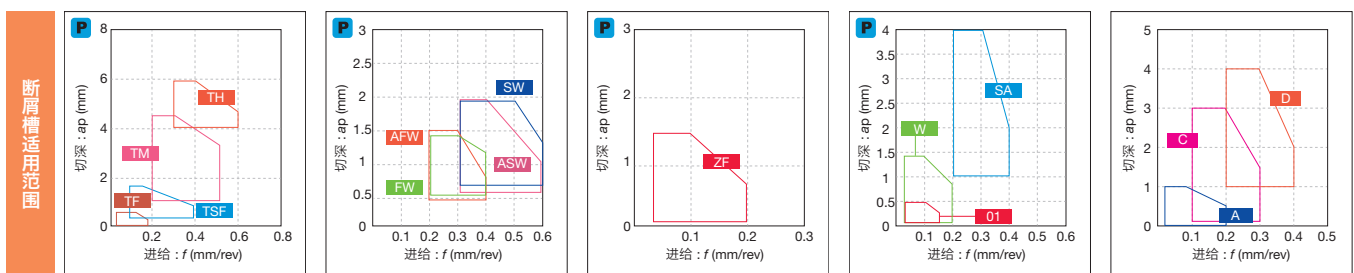
P	钢	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
M	不锈钢	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
K	铸铁	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
N	非铁金属	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
S	超级合金																			
H	硬材料																			



应用	断屑槽	型号	涂层硬质合金					涂层金属陶瓷		金属陶瓷	不涂层硬质合金	尺寸 (mm)								
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH120	SH725	GT9530	AT9530	NS9530	TH10	RE	IC	S	D1
精密加工		W TNGG160404R-W											●		●	0.4	9.525	4.76	3.81	
		TNGG160404L-W											●		●	0.4	9.525	4.76	3.81	
		TNGG160408R-W														●	0.8	9.525	4.76	3.81
		TNGG160408L-W														●	0.8	9.525	4.76	3.81
精密切屑 (锋利刃)		W TNGG160402FR-W														0.2	9.525	4.76	3.81	
		TNGG160402FL-W														0.2	9.525	4.76	3.81	
		TNGG160404FR-W														0.4	9.525	4.76	3.81	
		TNGG160404FL-W														0.4	9.525	4.76	3.81	
		TNGG160408FR-W														0.8	9.525	4.76	3.81	
		TNGG160408FL-W														0.8	9.525	4.76	3.81	
精加工		TSF TNMG110404E-TSF		●	●			▲	▲			●	●	●		0.4	6.35	4.76	2.26	
		TNMG110408E-TSF		●	●			▲	▲			●	●	●		0.8	6.35	4.76	2.26	
		TNMG160402-TSF									●		●	●		0.2	9.525	4.76	3.81	
		TNMG160404-TSF		●	●	●		▲	▲	▲	●		●	●		0.4	9.525	4.76	3.81	
		TNMG160408-TSF		●	●	●	●	▲	▲	▲	▲	●		●	●	0.8	9.525	4.76	3.81	
		TNMG160412-TSF		●	●	●			▲	▲	▲		●			1.2	9.525	4.76	3.81	
精加工 (修光刃)		FW TNMG110404E-FW		●				▲							0.4	6.35	4.76	2.26		
		TNMG110408E-FW		●				▲							0.8	6.35	4.76	2.26		
		TNMG160404-FW		●					▲						0.4	9.525	4.76	3.81		
		TNMG160408-FW		●					▲						0.8	9.525	4.76	3.81		
精加工		ZF TNMG160404-ZF		●	●	●		▲	▲	▲		●	●	●	0.4	9.525	4.76	3.81		
		TNMG160408-ZF		●	●	●		▲	▲	▲		●	●	●	0.8	9.525	4.76	3.81		
		TNMG160412-ZF		●					▲				●		1.2	9.525	4.76	3.81		

请参考 **L032-L036** 页, 依据修光刃锥度和圆弧来调整程序
如有问题, 可联系我们的销售人员获取帮助

●: 产品型号
▲: 停止生产



参考页: 外圆刀杆 → **C027** - 内孔刀杆 → **D046** -
J系列刀杆 → **G045** - 刀夹系列 → **K193** -

刀片 负前角

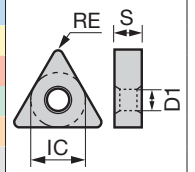
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- : 轻断续切削
- ★: 强断续切削


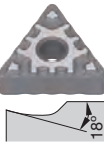
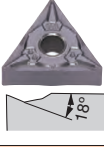
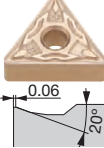
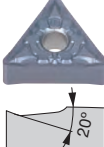
TN



三角形, 60°
带内冷孔

材料	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料	涂层硬质合金	涂层金属陶瓷	不涂层硬质合金	其它
●	●									
●										
●										
●										
●										
●										
●										
●										
●										
●										
●										
●										
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应用	断屑槽	型号	涂层硬质合金										涂层金属陶瓷		不涂层硬质合金		尺寸 (mm)				
			T9125	T9225	T6120	T6130	AH630	T5105	T5115	AH8005	AH8015	GH330	NS9530	TH10	RE	IC	S	D1			
精加工		11 TNMG110304-11											●				0.4	6.35	3.18	2.26	
		TNMG110308-11												●				0.8	6.35	3.18	2.26
		TNMG160402-11												●				0.2	9.525	4.76	3.81
		TNMG160404-11											●	●				0.4	9.525	4.76	3.81
		TNMG160408-11											●	●				0.8	9.525	4.76	3.81
		TNMG220404-11											●	●				0.4	12.7	4.76	5.16
		TNMG220408-11											●	●				0.8	12.7	4.76	5.16
低精碳加工		17 TNMG160404-17	▲	●									●				0.4	9.525	4.76	3.81	
		TNMG160408-17	▲	●									●				0.8	9.525	4.76	3.81	
精加工		SF TNMG160404-SF			●	●	●										0.4	9.525	4.76	3.81	
		TNMG160408-SF			●	●	●											0.8	9.525	4.76	3.81
		TNMG160412-SF			●	●	●											1.2	9.525	4.76	3.81
精加工		CF TNMG160404-CF						●	●								0.4	9.525	4.76	3.81	
		TNMG160408-CF						●	●									0.8	9.525	4.76	3.81
精加工		HRF TNMG160404-HRF									●	●					0.4	9.525	4.76	3.81	
		TNMG160408-HRF									●	●						0.8	9.525	4.76	3.81

- : 产品型号
- ▲: 停止生产

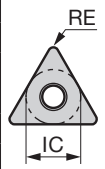
参考页: 外圆刀杆 → **C027** - 内孔刀杆 → **D046** -
J系列刀杆 → **G045** - 刀夹系列 → **K193** -

刀片 负前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

TN

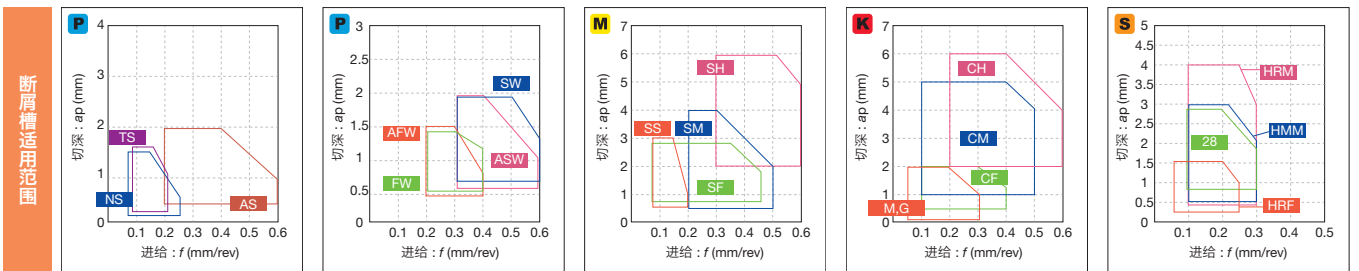
三角形, 60°
带内冷孔



应用	断屑槽	型号	涂层硬质合金							涂层金属陶瓷		金属陶瓷		尺寸 (mm)				
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	GT9530	AT9530	NS9530	NS520	RE	IC	S	D1
精加工		TS TNMG160404-TS	●	●	●	✱	●	●	●	✱					0.4	9.525	4.76	3.81
		TNMG160408-TS	●	●	●	●	▲	▲	▲	▲	●	●	●	●	0.8	9.525	4.76	3.81
		TNMG160412-TS	●	●	●	●	▲	▲	▲	▲					1.2	9.525	4.76	3.81
精加工 (修光刀)		SW TNMG110408E-SW	●					▲						0.8	6.35	4.76	2.26	
		TNMG110412E-SW	●					▲						1.2	6.35	4.76	2.26	
		TNMG160408-SW	●					▲						0.8	9.525	4.76	3.81	
		TNMG160412-SW	●					▲						1.2	9.525	4.76	3.81	
小切深, 高进给加工		AS TNMG160404-AS			●	●			▲	▲		●		0.4	9.525	4.76	3.81	
		TNMG160408-AS	●	●	●	●	▲	▲	▲	▲		●		0.8	9.525	4.76	3.81	
		TNMG160412-AS	●	●	●		▲	▲	▲					1.2	9.525	4.76	3.81	
双面刃		CB TNMG110304-CB	●					▲				●		0.4	6.35	3.18	2.26	
		TNMG110308-CB	●					▲				●		0.8	6.35	3.18	2.26	
精加工		NS TNMG160404-NS		●	●				▲	▲		●		0.4	9.525	4.76	3.81	
		TNMG160408-NS	●	●	●				▲	▲	▲	●		0.8	9.525	4.76	3.81	

请参考 L032-L036 页, 依据修光刀锥度和圆弧来调整程序
如有问题, 可联系我们的销售人员获取帮助

●: 产品型号
▲: 停止生产



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C027 - 内孔刀杆 → D046 -
J系列刀杆 → G045 - 刀夹系列 → K193 -

刀片 负前角

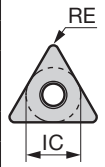
- : 连续切削
- ◐: 轻断续切削
- ✱: 强断续切削

TN



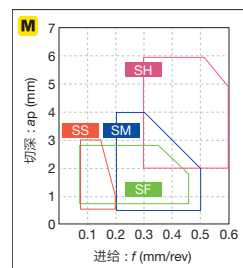
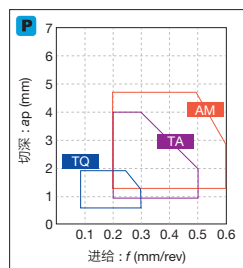
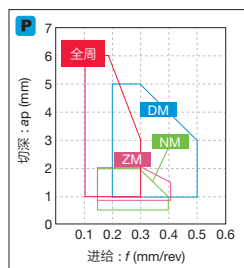
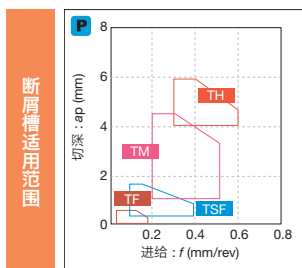
三角形, 60°
带内冷孔

材料	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料	涂层硬质合金	涂层金属陶瓷	金属陶瓷	不涂层硬质合金
●	●	●	●	●	●	●	●	●	●	●
◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐
✱	✱	✱	✱	✱	✱	✱	✱	✱	✱	✱



应用	断屑槽	型号	涂层硬质合金										涂层金属陶瓷		金属陶瓷	不涂层硬质合金	尺寸 (mm)									
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	AH630	T515	T5105	T5115	T5125	AH110	AH120	GT9530	GT720	NS9530	NS520	TH10	RE	IC	S	D1
精加工到半精加工		ZM TNMG160404-ZM	●	●	●	✱	●	●	●	✱	●	●	●	●	●	●	●	●	●	●	●	●	0.4	9.525	4.76	3.81
		TNMG160408-ZM	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	9.525	4.76	3.81
		TNMG160412-ZM	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.2	9.525	4.76	3.81
		TNMG220412-ZM	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.2	12.7	4.76	5.16
精加工到半精加工		DM TNMG160408-DM	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	9.525	4.76	3.81	
		TNMG160412-DM	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.2	9.525	4.76	3.81
半精加工		全周 TNMG110304	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	6.35	3.18	2.26
		TNMG110308	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	6.35	3.18	2.26
		TNMG160304	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	9.525	3.18	3.81
		TNMG160308	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	9.525	3.18	3.81
		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
		TNMG160416	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.6	9.525	4.76	3.81
		TNMG160420	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	2	9.525	4.76	3.81
		TNMG220408	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	12.7	4.76	5.16
		TNMG220412	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.2	12.7	4.76	5.16
		TNMG220416	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.6	12.7	4.76	5.16
		TNMG270608	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	15.875	6.35	6.35
TNMG270612	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.2	15.875	6.35	6.35		
TNMG270616	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.6	15.875	6.35	6.35		
精加工到半精加工		27 TNMG160404-27	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	9.525	4.76	3.81	
		TNMG160408-27	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	9.525	4.76	3.81	
		TNMG160412-27	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.2	9.525	4.76	3.81	
		TNMG220404-27	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	12.7	4.76	5.16
		TNMG220408-27	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	12.7	4.76	5.16
		TNMG220412-27	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.2	12.7	4.76	5.16

●: 产品型号
▲: 停止生产



参考页: 外圆刀杆 → C027 - 内孔刀杆 → D046 -
J系列刀杆 → G045 - 刀夹系列 → K193 -

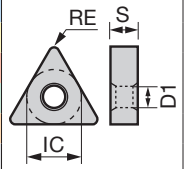
● : 连续切削
 ○ : 轻断续切削
 * : 强断续切削

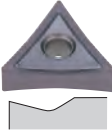
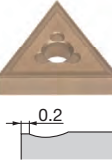
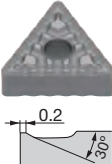
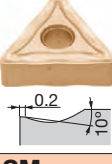
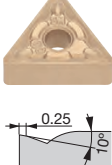
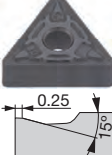
刀片 负前角

TN

三角形, 60°
带内冷孔

材料	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	涂层硬质合金															涂层金属陶瓷	金属陶瓷	不锈钢	尺寸 (mm)												
			T9205	T9215	T9225	T9235	T9115	T9125	T9135	T6120	T6130	AH630	AH645	AH8005	AH8015	T515	T5105				T5115	T5125	AH120	AH725	GH330	GT720	NS9530	TH10	RE	IC	S	D1	
28		TNMG160404-28																								●	0.4	9.525	4.76	3.81			
		TNMG160408-28											●	●							●						●	0.8	9.525	4.76	3.81		
		TNMG220404-28																				●						●	0.4	12.7	4.76	5.16	
		TNMG220408-28																				●						●	0.8	12.7	4.76	5.16	
33		TNMG160404-33																								●	0.4	9.525	4.76	3.81			
		TNMG160408-33																									●	0.8	9.525	4.76	3.81		
		TNMG160416-33			●			▲																					1.6	9.525	4.76	3.81	
		TNMG220404-33			●			▲															●						0.4	12.7	4.76	5.16	
		TNMG220412-33				●		▲																					1.2	12.7	4.76	5.16	
37		TNMG160404-37		●																	●			●				0.4	9.525	4.76	3.81		
TNMG160408-37			●																			●		●				0.8	9.525	4.76	3.81		
38		TNMG160404-38																										0.4	9.525	4.76	3.81		
		TNMG160408-38																											0.8	9.525	4.76	3.81	
SM		TNMG110404E-SM								●	●	●																	0.4	6.35	4.76	2.26	
		TNMG110408E-SM									●	●	●																	0.8	6.35	4.76	2.26
		TNMG160404-SM									●	●	●	●									●							0.4	9.525	4.76	3.81
		TNMG160408-SM									●	●	●	●										●						0.8	9.525	4.76	3.81
		TNMG160412-SM									●	●	●	●																1.2	9.525	4.76	3.81
		TNMG220408-SM									●	●	●	●																0.8	12.7	4.76	5.16
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	
TNMG220408-CM																													0.8	12.7	4.76	5.16	
TNMG220412-CM																													1.2	12.7	4.76	5.16	

● : 产品型号
 ▲ : 停止生产

参考页: 外圆刀杆 → C027 - 内孔刀杆 → D046 -
 J系列刀杆 → G045 - 刀夹系列 → K193 -

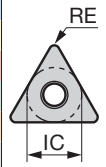
刀片 负前角

●: 连续切削
 ●: 轻断续切削
 * : 强断续切削

TN

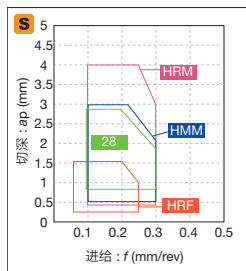
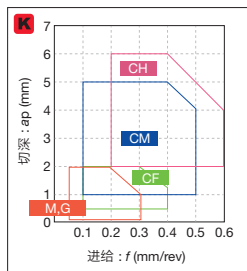
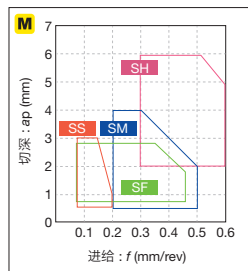
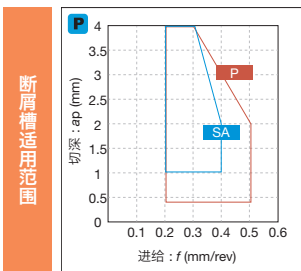


三角形, 60°
带内冷孔



应用	断屑槽	型号	涂层硬质合金											金属陶瓷	不涂层硬质合金		尺寸 (mm)				
			T6120	T6130	AH630	AH645	AH120	AH8005	AH8015	AH905	GH110	GH330	SH725	NS9530	TH10	KS20	RE	IC	S	D1	
半精加工 		P TNGG160402R-P												●	●		0.2	9.525	4.76	3.81	
		TNGG160402L-P												●	●		0.2	9.525	4.76	3.81	
		TNGG160404R-P												●	●		0.4	9.525	4.76	3.81	
		TNGG160404L-P												●	●		0.4	9.525	4.76	3.81	
		TNGG160408R-P												●	●		0.8	9.525	4.76	3.81	
		TNGG160408L-P												●	●		0.8	9.525	4.76	3.81	
半精加工 (锋利刃) 		P TNGG160402FR-P														●	0.2	9.525	4.76	3.81	
		TNGG160402FL-P															●	0.2	9.525	4.76	3.81
		TNGG160404FR-P															●	0.4	9.525	4.76	3.81
		TNGG160404FL-P															●	0.4	9.525	4.76	3.81
		TNGG160408FR-P															●	0.8	9.525	4.76	3.81
精加工到半精加工 		HRM TNMG160404-HRM												●			0.4	9.525	4.76	3.81	
		TNMG160408-HRM												●			0.8	9.525	4.76	3.81	
		TNMG160412-HRM												●			1.2	9.525	4.76	3.81	
半精加工 		HMM TNMG160404-HMM													●		0.4	9.525	4.76	3.81	
		TNMG160408-HMM													●		0.8	9.525	4.76	3.81	
		TNMG160412-HMM													●		1.2	9.525	4.76	3.81	
		SA TNMG160404-SA	●	●	●	●	●											0.4	9.525	4.76	3.81
		TNMG160408-SA	●	●	●	●	●									●		0.8	9.525	4.76	3.81
立铣刀 		TNMG160412-SA	●	●	●	●	●							●		1.2	9.525	4.76	3.81		
		TNMG220408-SA	●	●	●	●	●								●		0.8	12.7	4.76	5.16	
		TNMG220412-SA	●	●	●	●	●										1.2	12.7	4.76	5.16	

●: 产品型号



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C027 - 内孔刀杆 → D046 -
 J系列刀杆 → G045 - 刀夹系列 → K193 -

材质 刀片 外圆刀杆 内孔刀杆 螺纹加工 槽加工 小零件刀具 铣刀 立铣刀 孔加工刀具 工具系统 用户指南 索引



刀片 负前角

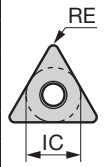
- : 连续切削
- ◐: 轻断续切削
- ◑: 强断续切削

TN



三角形, 60°
带内冷孔

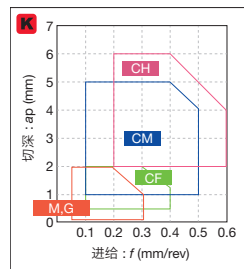
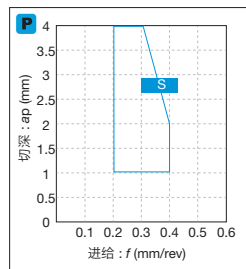
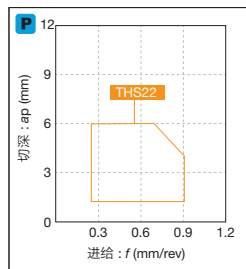
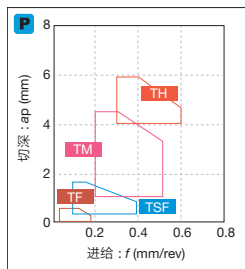
P	钢				●				●●							●	●							
M	不锈钢				●				●●							●	●							
K	铸铁	●●	●	●	●	●	●●	●●	●●						●●	●								
N	非铁金属															●								
S	超级合金															●								
H	硬材料																						●	



应用	断屑槽	型号	涂层硬质合金					涂层金属陶瓷	金属陶瓷	不涂层硬质合金		陶瓷		尺寸 (mm)				
			T515	T5105	T5115	T5125	GH110	GT720	NS520	TH03	TH10	FX105	LX21	LX11	RE	IC	S	D1
精加工到半精加工		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	
		TNMA160416		●	●	●								1.6	9.525	4.76	3.81	
		TNMA160420		●	●	●								2	9.525	4.76	3.81	
		TNMA220404		●	●	●								0.4	12.7	4.76	5.16	
		TNMA220408		●	●	●								0.8	12.7	4.76	5.16	
		TNMA220412		●	●	●								1.2	12.7	4.76	5.16	
		TNMA220416		●	●	●								1.6	12.7	4.76	5.16	
		精加工到半精加工		TNGA110304								●			0.4	6.35	3.18	2.26
				TNGA110308								●			0.8	6.35	3.18	2.26
				TNGA160304								●			0.4	9.525	3.18	3.81
TNGA160308										●			0.8	9.525	3.18	3.81		
TNGA160402												●	0.2	9.525	4.76	3.81		
TNGA160404							●		●	●		●	●	0.4	9.525	4.76	3.81	
TNGA160408							●		●	●		●	●	0.8	9.525	4.76	3.81	
TNGA160412									●	●		●	●	1.2	9.525	4.76	3.81	
TNGA160416										●		●	●	1.6	9.525	4.76	3.81	
TNGA220408										●				0.8	12.7	4.76	5.16	

●: 产品型号

断屑槽适用范围



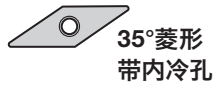
M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C027 - 内孔刀杆 → D046 -
J系列刀杆 → G045 - 刀夹系列 → K193 -

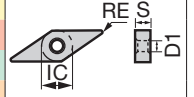
刀片 负前角

●: 连续切削
●: 轻断续切削
✳: 强断续切削

VN



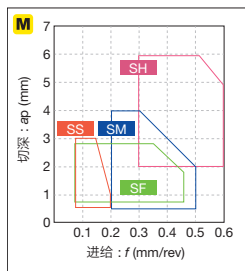
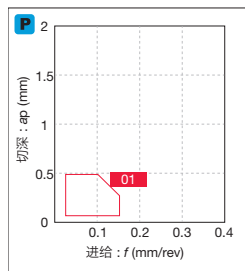
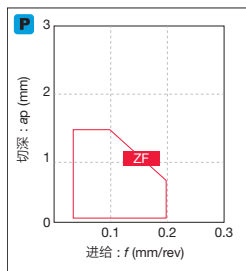
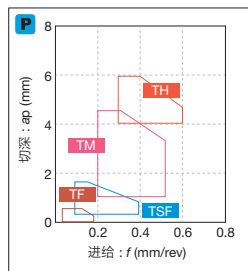
P	M	K	N	S	H
●●●●✳●●●●✳●●●●✳	●●●●●●●●●●●●	●●●●●●●●●●●●	●●●●●●●●●●●●	●●●●●●●●●●●●	●●●●●●●●●●●●



应用	断屑槽	型号	涂层硬质合金										涂层金属陶瓷		金属陶瓷	不涂层硬质合金	尺寸 (mm)								
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH120	GH330	GT9530	AT9530	NS9530	TH10	RE	IC	S	D1		
精加工		TSF VNMG120402E-TSF	●	●				▲	▲							●	●				0.2	7.15	4.76	3.81	
		VNMG120404E-TSF	●	●				▲	▲							●	●				0.4	7.15	4.76	3.81	
		VNMG120408E-TSF	●	●				▲	▲							●	●				0.8	7.15	4.76	3.81	
		VNMG160402-TSF													●		●	●				0.2	9.525	4.76	3.81
		VNMG160404-TSF	●	●	●	●	▲	▲	▲	▲					●		●	●				0.4	9.525	4.76	3.81
		VNMG160408-TSF	●	●	●	●	▲	▲	▲	▲					●		●	●				0.8	9.525	4.76	3.81
		VNMG160412-TSF	●	●	●	●	▲	▲	▲	▲												1.2	9.525	4.76	3.81
		ZF VNMG160404-ZF	●	●	●		▲	▲	▲						●	●				0.4	9.525	4.76	3.81		
		VNMG160408-ZF	●	●	●		▲	▲	▲							●	●				0.8	9.525	4.76	3.81	
		VNMG160412-ZF	●	●	●		▲	▲	▲												1.2	9.525	4.76	3.81	
		11 VNMG160404-11												●			●			0.4	9.525	4.76	3.81		
		VNMG160408-11														●					0.8	9.525	4.76	3.81	
		VNMG160412-11														●					1.2	9.525	4.76	3.81	
		SF VNMG160404-SF								●	●	●								0.4	9.525	4.76	3.81		
		VNMG160408-SF									●	●	●								0.8	9.525	4.76	3.81	

●: 产品型号
▲: 停止生产

断屑槽适用范围



参考页: 外圆刀杆 → C054 - 内孔刀杆 → D070 -
TungCap系列 → C061, K015 -

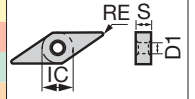
刀片 负前角

●: 连续切削
●: 轻断续切削
★: 强断续切削

VN

35°菱形带内冷孔

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	断屑槽	型号	涂层硬质合金																涂层金属陶瓷		金属陶瓷		尺寸 (mm)								
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6120	T6130	AH630	AH645	T5105	T5115	AH110	AH120	AH8005	AH8015	GH330	GT9530	AT9530	NS9530	NS520	RE	IC	S	D1		
应用	CF	VNMG160404-CF												●	●											0.4	9.525	4.76	3.81		
		VNMG160408-CF												●	●												0.8	9.525	4.76	3.81	
	HRF	VNMG160404-HRF																	●	●							0.4	9.525	4.76	3.81	
		VNMG160408-HRF																	●	●							0.8	9.525	4.76	3.81	
精加工	TS	VNMG160404-TS		●	●	●		▲	▲	▲												●	●		●	●	0.4	9.525	4.76	3.81	
		VNMG160408-TS		●	●	●		▲	▲	▲													●	●		●	●	0.8	9.525	4.76	3.81
		VNMG160412-TS		●	●	●		▲	▲	▲																		1.2	9.525	4.76	3.81
应用	SS	VNMG120404E-SS									●	●	●	●													0.4	7.15	4.76	3.81	
		VNMG120408E-SS								●	●	●	●														0.8	7.15	4.76	3.81	
		VNMG160404-SS									●	●	●	●						●					●		0.4	9.525	4.76	3.81	
		VNMG160408-SS									●	●	●	●						●					●		0.8	9.525	4.76	3.81	
		VNMG160412-SS									●	●	●	●							●				●		1.2	9.525	4.76	3.81	
半精加工	TM	VNMG120404E-TM		●	●			▲	▲																		0.4	7.15	4.76	3.81	
		VNMG120408E-TM		●	●			▲	▲																			0.8	7.15	4.76	3.81
		VNMG160404-TM		●	●	●	●	▲	▲	▲	▲	●							●								0.4	9.525	4.76	3.81	
		VNMG160408-TM		●	●	●	●	▲	▲	▲	▲							●	●									0.8	9.525	4.76	3.81
		VNMG160412-TM		●	●	●	●	▲	▲	▲	▲							●										1.2	9.525	4.76	3.81
精加工到半精加工	TQ	VNMG160404-TQ		●	●																	●	●		●		0.4	9.525	4.76	3.81	
		VNMG160408-TQ		●	●																		●	●		●		0.8	9.525	4.76	3.81

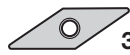
●: 产品型号
▲: 停止生产

参考页: 外圆刀杆 → C054 - 内孔刀杆 → D070 -
 TungCap系列 → C061, K015 -

刀片 负前角

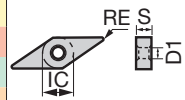
- : 连续切削
- ◐ : 轻断续切削
- ※ : 强断续切削

VN



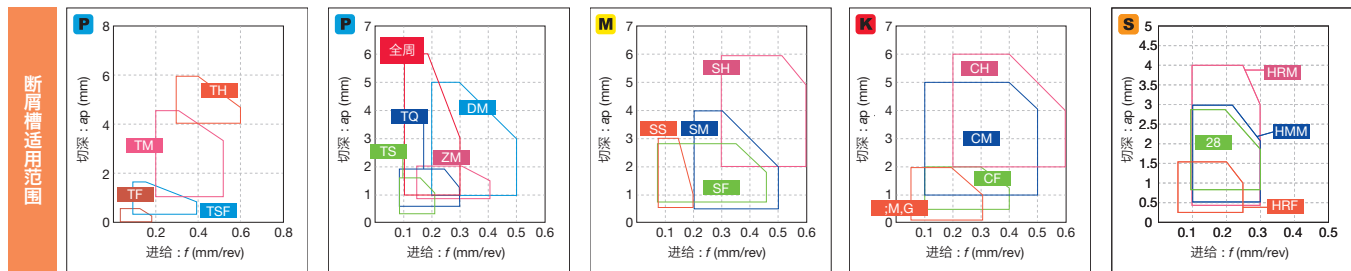
35°菱形
带内冷孔

材料	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	涂层硬质合金																金属陶瓷	不涂层硬质合金	尺寸 (mm)					
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T515	T5105	T5115	T5125	AH110	AH120	AH8005	AH8015	NS9530	TH10	RE	IC	S	D1		
精加工到半精加工	ZM	VNMG160408-ZM	●	●	●	●	▲	▲	▲												●		0.8	9.525	4.76	3.81
		VNMG160412-ZM	●	●	●		▲	▲	▲												●		1.2	9.525	4.76	3.81
	DM	VNMG160408-DM	●	●	●	●	▲	▲	▲	▲											●		0.8	9.525	4.76	3.81
		VNMG160412-DM	●	●	●		▲	▲	▲												●		1.2	9.525	4.76	3.81
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
	28	VNMG160404-28																●	●	●			0.4	9.525	4.76	3.81
		VNMG160408-28																●	●	●			0.8	9.525	4.76	3.81
33	VNMG160404-33		●				▲						●							●		0.4	9.525	4.76	3.81	
	VNMG160408-33		●	●			▲	▲												●		0.8	9.525	4.76	3.81	

● : 产品型号
▲ : 停止生产



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C059 - 内孔刀杆 → D070 - TungCap系列 → C061, K015 -

刀片 负前角

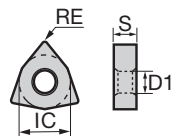
●: 连续切削
●: 轻断续切削
✳: 强断续切削

WN



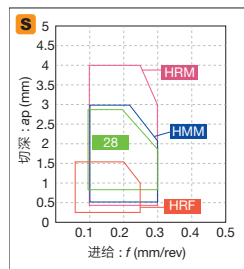
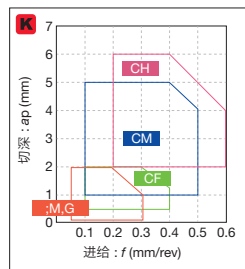
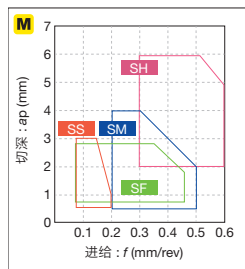
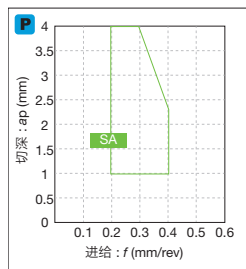
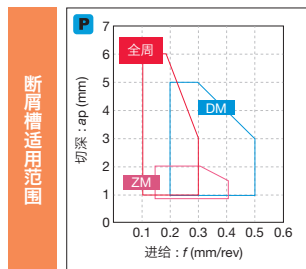
凸三角形, 80°
带内冷孔

	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	断屑槽	型号	涂层硬质合金							不涂层硬质合金			尺寸 (mm)						
			T6120	T6130	AH630	AH645	T515	T5105	T5115	T5125	AH120	AH725	AH8005	AH8015	AH905	KS20	RE	IC	S
半精加工		SM WNMG060404E-SM	●	●	●											0.4	9.525	4.76	3.81
		WNMG060408E-SM	●	●	●											0.8	9.525	4.76	3.81
		WNMG060412E-SM	●	●	●											1.2	9.525	4.76	3.81
		WNMG060408-SM								●						0.8	9.525	4.76	3.81
		WNMG080404-SM	●	●	●	●										0.4	12.7	4.76	5.16
		WNMG080408-SM	●	●	●	●					●					0.8	12.7	4.76	5.16
		WNMG080412-SM	●	●	●	●					●					1.2	12.7	4.76	5.16
半精加工		CM WNMG080404-CM						●							0.4	12.7	4.76	5.16	
		WNMG080408-CM				●	●	●	●						0.8	12.7	4.76	5.16	
		WNMG080412-CM				●	●	●	●						1.2	12.7	4.76	5.16	
精加工到半精加工		HRM WNMG080404-HRM								●	●				0.4	12.7	4.76	5.16	
		WNMG080408-HRM								●	●				0.8	12.7	4.76	5.16	
		WNMG080412-HRM								●	●				1.2	12.7	4.76	5.16	
半精加工		HMM WNMG080404-HMM										●			0.4	12.7	4.76	5.16	
		WNMG080408-HMM										●			0.8	12.7	4.76	5.16	
		WNMG080412-HMM										●			1.2	12.7	4.76	5.16	
		SA WNMG080408-SA	●	●	●	●					●	●		●		0.8	12.7	4.76	5.16
	WNMG080412-SA	●	●	●	●					●				1.2	12.7	4.76	5.16		

●: 产品型号



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C029 - 内孔刀杆 → D029 -
TungCap系列 → C035 -, K011 -

刀片 负前角

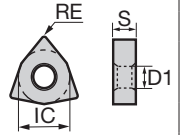
- : 连续切削
- ◐ : 轻断续切削
- ✱ : 强断续切削

WN



凸三角形, 80°
带内冷孔

材料	T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6130	AH630	AH645	T515	T5105	T5115	T5125	AH120	NS520	金属陶瓷	不涂层硬质合金	陶瓷	
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	涂层硬质合金																金属陶瓷	不涂层硬质合金	陶瓷	尺寸 (mm)					
			T9205	T9215	T9225	T9235	T9105	T9115	T9125	T9135	T6130	AH630	AH645	T515	T5105	T5115	T5125	AH120	NS520	TH10	LX11	RE	IC	S	D1		
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
		WNMG100612-TH		●	●			▲	▲															1.2	15.875	6.35	6.35
		WNMG100616-TH		●	●			▲	▲															1.6	15.875	6.35	6.35
		THS WNMG080408-THS	●	●	●	●	▲	▲	▲	▲													0.8	12.7	4.76	5.16	
		WNMG080412-THS	●	●	●	●	▲	▲	▲	▲														1.2	12.7	4.76	5.16
		WNMG080416-THS		●	●			▲	▲															1.6	12.7	4.76	5.16
		WNMG100612-THS		●	●	●		▲	▲	▲														1.2	15.875	6.35	6.35
		WNMG100616-THS		●	●	●		▲	▲	▲														1.6	15.875	6.35	6.35
	SH WNMG080408-SH									●	●	●										0.8	12.7	4.76	5.16		
	WNMG080412-SH									●	●	●											1.2	12.7	4.76	5.16	
	CH WNMG080408-CH												●	●	●							0.8	12.7	4.76	5.16		
	WNMG080412-CH												●	●	●								1.2	12.7	4.76	5.16	
精加工到半精加工		- 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	
		WNMA080404												●	●	●					●		0.4	12.7	4.76	5.16	
		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	
		WNGA080404																				●	0.4	12.7	4.76	5.16	
		WNGA080408																				●	0.8	12.7	4.76	5.16	
		WNGA080412																				●	1.2	12.7	4.76	5.16	

● : 产品型号
▲ : 停止生产

参考页: 外圆刀杆 → C029 - 内孔刀杆 → D029 -
TungCap系列 → C035 -, K011 -

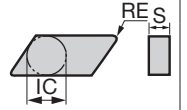
刀片 负前角

●: 连续切削
 ●: 轻断续切削
 * : 强断续切削

KN

平行四边形, 55°
不带孔

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

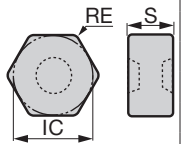


应用	断屑槽	型号	涂层硬质合金							尺寸 (mm)								
			GH330							RE	IC	S	D1					
精加工		S1	●												0.5	9.525	4.76	-
			●													0.5	9.525	4.76

HN

六边形, 120°
不带孔

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	陶瓷							尺寸 (mm)								
			FX105							RE	IC	S	D1					
精加工到半精加工		-	●												1.2	12.7	7.94	-
			●													1.6	12.7	7.94

●: 产品型号

参考页: HNGD...: 外圆刀杆 → C105

刀片 正前角

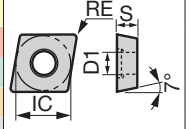
●: 连续切削
●: 轻断续切削
✱: 强断续切削

CC



菱形, 80°
带内冷孔
7°正前角

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

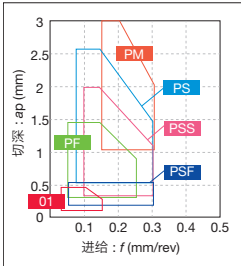


应用	断屑槽	型号	涂层硬质合金							涂层金属陶瓷	金属陶瓷	尺寸 (mm)						
			T9215	T9225	T9115	T9125	T6130	AH725	AH8005	AH8015	GH730	SH725	J740	GT9530	NS9530	RE	IC	S
精密加工		01 CCGT060202-01									●			0.2	6.35	2.38	2.8	
		CCGT09T302-01									●			0.2	9.525	3.97	4.4	
(精密加工) 锋利刃		01 CCGT060202F-01									●			<0.2	6.35	2.38	2.8	
		CCGT060204F-01									●			<0.4	6.35	2.38	2.8	
		CCGT09T302F-01										●			<0.2	9.525	3.97	4.4
		CCGT09T304F-01										●			<0.4	9.525	3.97	4.4
精加工		PSF CCMT060202-PSF									●		●	0.2	6.35	2.38	2.8	
		CCMT060204-PSF	●	●	▲	▲		●	●	●			●	●	0.4	6.35	2.38	2.8
		CCMT09T302-PSF						●						●	0.2	9.525	3.97	4.4
		CCMT09T304-PSF	●	●	▲	▲		●	●	●				●	●	0.4	9.525	3.97
	CCMT09T308-PSF	●	●	▲	▲		●						●	●	0.8	9.525	3.97	4.4
		PF CCMT060202-PF									●		●	●	0.2	6.35	2.38	2.8
		CCMT060204-PF					●			●			●	●	0.4	6.35	2.38	2.8
		CCMT060208-PF									●		●	●	0.8	6.35	2.38	2.8
CCMT09T302-PF										●			●	0.2	9.525	3.97	4.4	
CCMT09T304-PF									●			●	0.4	9.525	3.97	4.4		
CCMT09T308-PF	●		▲							●		●	0.8	9.525	3.97	4.4		

刀片 R 为负公差

●: 产品型号
▲: 停止生产

断屑槽适用范围



参考页: 外圆刀杆 → C024 - 内孔刀杆 → D014 -
J系列刀杆 → G019 - PINZBOHR®系列 → K180 -

材质
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系統
用戶指南
索引

刀片 正前角

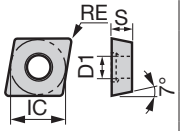
- : 连续切削
- : 轻断续切削
- ※: 强断续切削

CC



菱形, 80°
带内冷孔
7°正前角

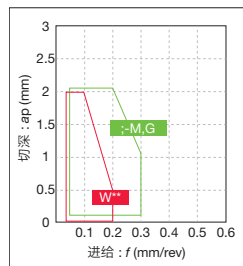
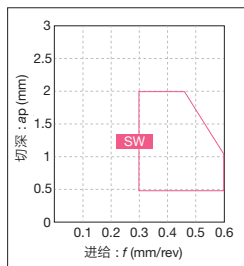
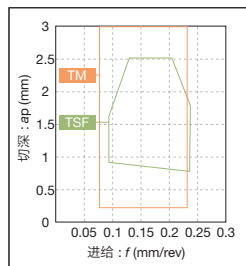
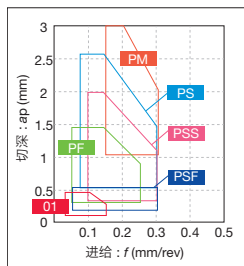
	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料	涂层硬质合金	金属陶瓷	不涂层硬质合金
●	●	●	●	●	●	●	●	●	●
●	●	●	●	●	●	●	●	●	●
※	●	●	●	●	●	●	●	●	●



应用	断屑槽	型号	涂层硬质合金							金属陶瓷	不涂层硬质合金	尺寸 (mm)				
			T9215	T9225	T9115	T9125	T6130	AH120	SH730	NS9530	TH10	RE	IC	S	D1	
精加工到半精加工		23 CCMT060202-23								●		0.2	6.35	2.38	2.8	
		CCMT060204-23		●		▲				●		0.4	6.35	2.38	2.8	
		CCMT060208-23		●		▲						0.8	6.35	2.38	2.8	
		CCMT09T304-23		●		▲				●		0.4	9.525	3.97	4.4	
		CCMT09T308-23		●		▲				●		0.8	9.525	3.97	4.4	
半精加工		24 CCMT060202-24		●		▲				●		0.2	6.35	2.38	2.8	
		CCMT060204-24		●	●	▲	▲		●	●		0.4	6.35	2.38	2.8	
		CCMT060208-24		●	●	●	▲	▲	●	●	●		0.8	6.35	2.38	2.8
		CCMT09T302-24		●		●	▲			●		0.2	9.525	3.97	4.4	
		CCMT09T304-24		●	●	●	▲	▲		●		0.4	9.525	3.97	4.4	
		CCMT09T308-24		●	●	●	▲	▲	●	●		0.8	9.525	3.97	4.4	
		CCMT120408-24		●	●	▲	▲		●	●		0.8	12.7	4.76	5.5	
精加工		W08 CCGT03X100R-W08							●		●	0.03	3.57	1.39	1.9	
		CCGT03X100L-W08							●		●	0.03	3.57	1.39	1.9	
		CCGT03X101R-W08							●		●	0.1	3.57	1.39	1.9	
		CCGT03X101L-W08							●		●	0.1	3.57	1.39	1.9	
		CCGT03X102R-W08							●		●	0.2	3.57	1.39	1.9	
		CCGT03X102L-W08							●		●	0.2	3.57	1.39	1.9	
		CCGT03X104R-W08							●		●	0.4	3.57	1.39	1.9	
		CCGT03X104L-W08							●		●	0.4	3.57	1.39	1.9	
		CCGT04T100R-W08							●		●	0.03	4.37	1.79	2.2	
		CCGT04T100L-W08							●		●	0.03	4.37	1.79	2.2	
		CCGT04T101R-W08							●		●	0.1	4.37	1.79	2.2	
		CCGT04T101L-W08							●		●	0.1	4.37	1.79	2.2	
		CCGT04T102R-W08							●		●	0.2	4.37	1.79	2.2	
		CCGT04T102L-W08							●		●	0.2	4.37	1.79	2.2	
		CCGT04T104R-W08							●		●	0.4	4.37	1.79	2.2	
CCGT04T104L-W08							●		●	0.4	4.37	1.79	2.2			

●: 产品型号
▲: 停止生产

断屑槽适用范围



*-M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C024 - 内孔刀杆 → D014 -
J系列刀杆 → G019 - PINZBOHR®系列 → K180 -

刀片 正前角

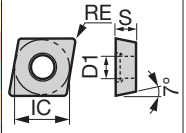
- : 连续切削
- ◐ : 轻断续切削
- ◑ : 强断续切削

CC



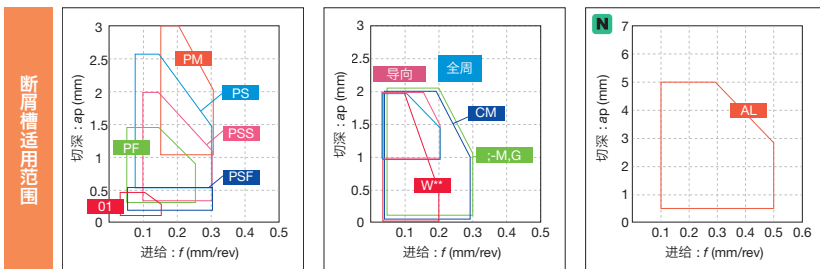
菱形, 80°
带内冷孔
7°正前角

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	涂层硬质合金		金属陶瓷	不涂层硬质合金		尺寸 (mm)				
			T5115 GH110		NS9530	TH10 KS05F		RE	IC	S	D1	
精加工到半精加工	AL	CCGT060202-AL					●		0.2	6.35	2.38	2.8
		CCGT060204-AL					●		0.4	6.35	2.38	2.8
		CCGT09T302-AL					●		0.2	9.525	3.97	4.4
		CCGT09T304-AL					●		0.4	9.525	3.97	4.4
		CCGT09T308-AL					●		0.8	9.525	3.97	4.4
		CCGT120402-AL					●		0.2	12.7	4.76	5.5
		CCGT120404-AL					●		0.4	12.7	4.76	5.5
		CCGT120408-AL					●		0.8	12.7	4.76	5.5
	全周	CCGT060202			●				0.2	6.35	2.38	2.8
		CCGT060204			●				0.4	6.35	2.38	2.8
		CCGT09T302			●				0.2	9.525	3.97	4.4
		CCGT09T304			●				0.4	9.525	3.97	4.4
		CCGT09T308			●				0.8	9.525	3.97	4.4
	导向	CCGT060200R					●		0.03	6.35	2.38	2.8
		CCGT060202R					●		0.2	6.35	2.38	2.8
		CCGT060202L					●		0.2	6.35	2.38	2.8
		CCGT060204L					●		0.4	6.35	2.38	2.8
		CCGT09T302R					●		0.2	9.525	3.97	4.4
		CCGT09T302L					●		0.2	9.525	3.97	4.4
		CCGT09T304R					●		0.4	9.525	3.97	4.4
		CCGT09T304L					●		0.4	9.525	3.97	4.4
	-	CCMW060204		●					0.4	6.35	2.38	2.8
		CCMW060208		●					0.8	6.35	2.38	2.8
		CCMW09T304		●					0.4	9.525	3.97	4.4
		CCMW09T308		●					0.8	9.525	3.97	4.4
	-	CCGW060202					●		0.2	6.35	2.38	2.8
		CCGW060204					●		0.4	6.35	2.38	2.8
		CCGW09T304		●			●		0.4	9.525	3.97	4.4

● : 产品型号



*-M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C024 - 内孔刀杆 → D016 -
J系列刀杆 → G019 - PINZBOHR®系列 → K180 -

刀片 正前角

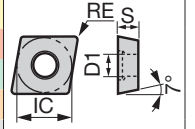
- : 连续切削
- : 轻断续切削
- ⊛ : 强断续切削

CC



菱形, 80°
带内冷孔
7°正前角

	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	涂层硬质合金												尺寸 (mm)						
			AH725	SH725	SH730										RE	IC	S	D1			
用于小型机床上车内孔		JS CCGT03X101-JS		●													<0.1	3.57	1.39	1.9	
		CCGT03X102-JS		●														<0.2	3.57	1.39	1.9
		CCGT03X104-JS		●														<0.4	3.57	1.39	1.9
		CCGT04T101-JS		●														<0.1	4.37	1.79	2.2
		CCGT04T102-JS		●														<0.2	4.37	1.79	2.2
		CCGT04T104-JS		●														<0.4	4.37	1.79	2.2
用于小型机床上车内孔 (锋利型)		JS CCGT03X101F-JS		●													<0.1	3.57	1.39	1.9	
		CCGT03X102F-JS		●														<0.2	3.57	1.39	1.9
		CCGT03X104F-JS		●														<0.4	3.57	1.39	1.9
		CCGT04T101F-JS		●														<0.1	4.37	1.79	2.2
		CCGT04T102F-JS		●														<0.2	4.37	1.79	2.2
		CCGT04T104F-JS		●														<0.4	4.37	1.79	2.2
用于小型机床上车外圆		JS CCGT060201N-JS	●														0.1	6.35	2.38	2.8	
		CCGT060202N-JS	●															0.2	6.35	2.38	2.8
		CCGT060204N-JS	●															0.4	6.35	2.38	2.8
		CCGT09T301N-JS	●															0.1	9.525	3.97	4.4
		CCGT09T302N-JS	●															0.2	9.525	3.97	4.4
		CCGT09T304N-JS	●															0.4	9.525	3.97	4.4
用于小型机床上车外圆 (锋利型)		JS CCGT060200FN-JS		●	●												0.03	6.35	2.38	2.8	
		CCGT060201FN-JS		●	●													<0.1	6.35	2.38	2.8
		CCGT060202FN-JS		●	●													<0.2	6.35	2.38	2.8
		CCGT060204FN-JS		●	●													<0.4	6.35	2.38	2.8
		CCGT09T300FN-JS		●	●													0.03	9.525	3.97	4.4
		CCGT09T301FN-JS		●	●													<0.1	9.525	3.97	4.4
		CCGT09T302FN-JS		●	●													<0.2	9.525	3.97	4.4
		CCGT09T304FN-JS		●	●													<0.4	9.525	3.97	4.4

刀尖 R 为负公差

● : 产品型号

参考页: 外圆刀杆 → C024 - 内孔刀杆 → D016 -
J系列刀杆 → G019 - PINZBOHR®系列 → K180 -

刀片 正前角

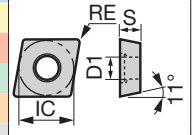
- : 连续切削
- : 轻断续切削
- : 强断续切削

CP



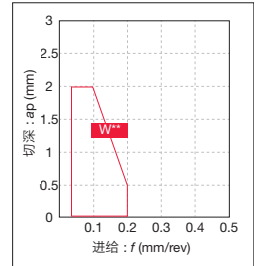
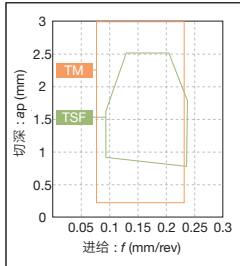
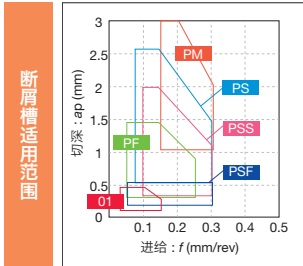
菱形, 80°
带内冷孔
11°正前角

	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	涂层硬质合金				金属陶瓷	不涂层硬质合金		尺寸 (mm)			
			T9215	T9225	T9115	T9125	NS9530	TH10			RE	IC	S
半精加工		24 CPMT080204-24	●	▲	▲					0.4	7.94	2.38	3.4
		CPMT120408-24	●				●			0.8	12.7	4.76	5.5
		CPMT160508-24	●		▲		●			0.8	15.875	5.56	5.5
		CPMT160512-24	●				●			1.2	15.875	5.56	5.5
		W15 CPGT050202L-W15					●			0.2	5.56	2.35	2.5
精加工	W15	CPGT050204L-W15					●			0.4	5.56	2.35	2.5
		CPGT080202R-W15						●		0.2	7.94	2.38	3.4
	CPGT080202L-W15					●	●		0.2	7.94	2.38	3.4	
	CPGT080204R-W15					●	●		0.4	7.94	2.38	3.4	
	CPGT080204L-W15					●	●		0.4	7.94	2.38	3.4	
	W20	CPGT090302R-W20					●	●		0.2	9.525	3.18	4.4
		CPGT090302L-W20					●	●		0.2	9.525	3.18	4.4
		CPGT090304R-W20					●	●		0.4	9.525	3.18	4.4
		CPGT090304L-W20					●	●		0.4	9.525	3.18	4.4

●: 产品型号
▲: 停止生产



参考页: 内孔刀杆 → D019 - 镗杆刀具 → K194 -
镗孔刀杆 → K209 -

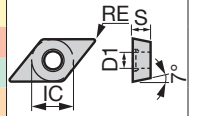
材质
刀片
外圆刀杆
内孔刀杆
螺旋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引

刀片 正前角

●: 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

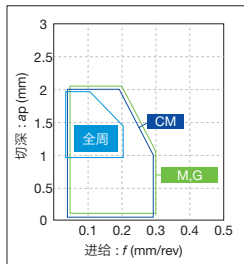
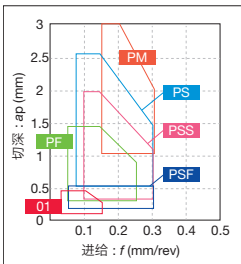


应用	断屑槽	型号	涂层硬质合金										涂层金属陶瓷		金属陶瓷	尺寸 (mm)					
			T9215	T9225	T9115	T9125	AH725	AH8005	AH8015	AH905	GH730	SH725	J740	GT9530	J9530	NS9530	RE	IC	S	D1	
精密加工		01 DCGT070202-01															0.2	6.35	2.38	2.8	
		DCGT11T302-01																0.2	9.525	3.97	4.4
(精密加工) 锋利刃		01 DCGT070202F-01															<0.2	6.35	2.38	2.8	
		DCGT070204F-01																<0.4	6.35	2.38	2.8
		DCGT11T302F-01																<0.2	9.525	3.97	4.4
		DCGT11T304F-01																<0.4	9.525	3.97	4.4
精加工		PSF DCMT070202-PSF															0.2	6.35	2.38	2.8	
		DCMT070204-PSF	●	●	▲	▲	●							●		●	0.4	6.35	2.38	2.8	
		DCMT11T302-PSF					●							●		●	0.2	9.525	3.97	4.4	
		DCMT11T304-PSF	●	●	▲	▲	●	●	●	●				●		●	0.4	9.525	3.97	4.4	
		DCMT11T308-PSF	●	●	▲	▲	●	●	●	●							0.8	9.525	3.97	4.4	
		PF DCMT070202-PF															0.2	6.35	2.38	2.8	
		DCMT070204-PF															0.4	6.35	2.38	2.8	
		DCMT070208-PF															0.8	6.35	2.38	2.8	
		DCMT11T302-PF														0.2	9.525	3.97	4.4		
		DCMT11T304-PF														0.4	9.525	3.97	4.4		
		DCMT11T308-PF														0.8	9.525	3.97	4.4		

刀尖 R 为负公差

●: 产品型号
▲: 停止生产

断屑槽适用范围



M,G 精度等级: 无断屑槽

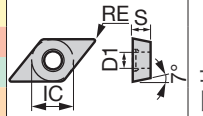
参考页: 外圆刀杆 → C048 - 内孔刀杆 → D048 -
J系列刀杆 → G026 - PINZBOHR®系列 → K184 -

刀片 正前角

- : 连续切削
- : 轻断续切削
- ✱: 强断续切削

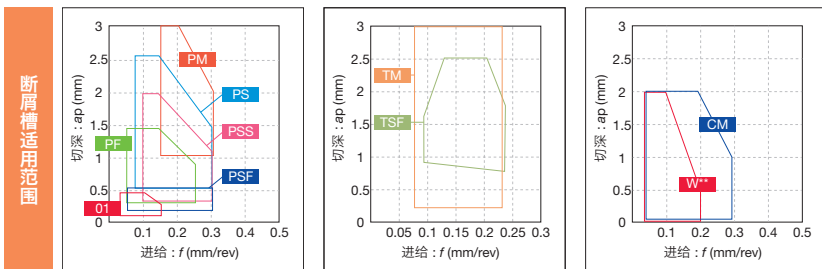
DC

55°菱形
带内冷孔
7°正前角



应用	断屑槽	型号	涂层硬质合金										涂层金属陶瓷	金属陶瓷	不涂层硬质合金		尺寸 (mm)								
			T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH120	AH725	GH330	GH730	GT9530	NS9530	TH10	RE	IC	S	D1		
精加工	W10	DCGT070200R-W10	●	●	✱	●	✱	●	✱	●	●	●	●	●	●	●	●	●	●	●	●	0.03	6.35	2.38	2.8
		DCGT070200L-W10	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.03	6.35	2.38	2.8
		DCGT070202R-W10	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.2	6.35	2.38	2.8
		DCGT070202L-W10	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.2	6.35	2.38	2.8
		DCGT070204R-W10	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	6.35	2.38	2.8
		DCGT070204L-W10	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	6.35	2.38	2.8
	W15	DCGT11T302R-W15	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.2	9.525	3.97	4.4
		DCGT11T302L-W15	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.2	9.525	3.97	4.4
		DCGT11T304R-W15	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	9.525	3.97	4.4
		DCGT11T304L-W15	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	9.525	3.97	4.4
PM	DCMT070204-PM	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	6.35	2.38	2.8	
	DCMT070208-PM	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	6.35	2.38	2.8	
	DCMT11T304-PM	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	9.525	3.97	4.4	
	DCMT11T308-PM	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	9.525	3.97	4.4	
精加工到半精加工	CM	DCMT070204-CM	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	6.35	2.38	2.8	
		DCMT070208-CM	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	6.35	2.38	2.8	
		DCMT11T304-CM	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.4	9.525	3.97	4.4	
		DCMT11T308-CM	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	0.8	9.525	3.97	4.4	
		DCMT11T312-CM	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	1.2	9.525	3.97	4.4	

●: 产品型号
▲: 停止生产



参考页: 外圆刀杆 → C048 - 内孔刀杆 → D048 -
J系列刀杆 → G026 - PINZBOHR®系列 → K184 -

刀片 正前角

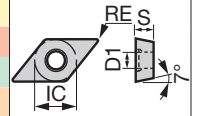
●: 连续切削
●: 轻断续切削
●: 强断续切削

DC



55°菱形
带内冷孔
7°正前角

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



应用	断屑槽	型号	涂层硬质合金			金属陶瓷		不涂层硬质合金				尺寸 (mm)				
			T9105	T5115	GH110	NS9530	TH10	KS05F	RE	IC	S	D1				
AL		DCGT070202-AL						●				0.2	6.35	2.38	2.8	
		DCGT070204-AL						●				0.4	6.35	2.38	2.8	
		DCGT11T302-AL						●				0.2	9.525	3.97	4.4	
		DCGT11T304-AL						●				0.4	9.525	3.97	4.4	
		DCGT11T308-AL						●				0.8	9.525	3.97	4.4	
		全周	DCGT070202				●						0.2	6.35	2.38	2.8
精加工到半精加工		DCGT070204				●					0.4	6.35	2.38	2.8		
		DCGT11T302				●					0.2	9.525	3.97	4.4		
		DCGT11T304				●					0.4	9.525	3.97	4.4		
		DCGT11T308				●					0.8	9.525	3.97	4.4		
		导向	DCGT070202R						●				0.2	6.35	2.38	2.8
		DCGT070202L						●				0.2	6.35	2.38	2.8	
半精加工		DCGT070204R						●			0.4	6.35	2.38	2.8		
		DCGT070204L						●			0.4	6.35	2.38	2.8		
		DCGT11T302R						●			0.2	9.525	3.97	4.4		
		DCGT11T302L						●			0.2	9.525	3.97	4.4		
		DCGT11T304R						●			0.4	9.525	3.97	4.4		
		DCGT11T304L						●			0.4	9.525	3.97	4.4		
-		DCMW070204	▲	●							0.4	6.35	2.38	2.8		
		DCMW070208		●							0.8	6.35	2.38	2.8		
		DCMW11T304	▲	●							0.4	9.525	3.97	4.4		
		DCMW11T308		●							0.8	9.525	3.97	4.4		
		DCGW070202						●				0.2	6.35	2.38	2.8	
		DCGW070204			●			●				0.4	6.35	2.38	2.8	
-		DCGW11T304					●			0.4	9.525	3.97	4.4			
		DCGW11T308					●			0.8	9.525	3.97	4.4			

●: 产品型号
▲: 停止生产

参考页: 外圆刀杆 → C048 - 内孔刀杆 → D048 -
J系列刀杆 → G026 - PINZBOHR®系列 → K184 -

刀片 正前角

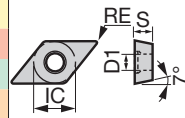
- : 连续切削
- ◐: 轻断续切削
- ◑: 强断续切削

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	断屑槽	型号	涂层/陶瓷						尺寸 (mm)						
			涂层硬质合金			涂层金属陶瓷	金属陶瓷	不涂层硬质合金	RE	IC	S	D1			
			SH725	SH730	J740	J9530	NS9530								
 用于小型机床上车外圆 (锋利型)	JRP	DCET0702008MFR-JRP	●	●							<0.08	6.35	2.38	2.8	
		DCET0702008MFL-JRP	●	●							<0.08	6.35	2.38	2.8	
		DCET070201MFR-JRP	●	●							<0.1	6.35	2.38	2.8	
		DCET070201MFL-JRP	●	●							<0.1	6.35	2.38	2.8	
		DCET0702018MFR-JRP	●	●							<0.18	6.35	2.38	2.8	
		DCET0702018MFL-JRP	●	●							<0.18	6.35	2.38	2.8	
		DCET070202MFR-JRP	●	●							<0.2	6.35	2.38	2.8	
		DCET070202MFL-JRP	●	●							<0.2	6.35	2.38	2.8	
		DCET11T3008MFR-JRP	●	●							<0.08	9.525	3.97	4.4	
		DCET11T3008MFL-JRP	●	●							<0.08	9.525	3.97	4.4	
		DCET11T301MFR-JRP	●	●							<0.1	9.525	3.97	4.4	
		DCET11T301MFL-JRP	●	●							<0.1	9.525	3.97	4.4	
		DCET11T3018MFR-JRP	●	●							<0.18	9.525	3.97	4.4	
		DCET11T3018MFL-JRP	●	●							<0.18	9.525	3.97	4.4	
		DCET11T302MFR-JRP	●	●							<0.2	9.525	3.97	4.4	
	DCET11T302MFL-JRP	●	●							<0.2	9.525	3.97	4.4		
 用于小型机床上车外圆 (锋利型)	JSP	DCET0702008MFN-JSP	●	●							<0.08	6.35	2.38	2.8	
		DCET070201MFN-JSP	●	●							<0.1	6.35	2.38	2.8	
		DCET0702018MFN-JSP	●	●							<0.18	6.35	2.38	2.8	
		DCET070202MFN-JSP	●	●							<0.2	6.35	2.38	2.8	
		DCET11T3008MFN-JSP	●	●							<0.08	9.525	3.97	4.4	
		DCET11T301MFN-JSP	●	●							<0.1	9.525	3.97	4.4	
		DCET11T3018MFN-JSP	●	●							<0.18	9.525	3.97	4.4	
		DCET11T302MFN-JSP	●	●							<0.2	9.525	3.97	4.4	
	 适用于瑞士机床、走心机外 圆车刀(磨削刃口)	J10	DCGT070200FR-J10	●	●							0.03	6.35	2.38	2.8
			DCGT070200FL-J10	●	●							0.03	6.35	2.38	2.8
			DCGT070201FR-J10	●	●			●				0.1	6.35	2.38	2.8
			DCGT070201FL-J10	●	●			●				0.1	6.35	2.38	2.8
			DCGT070202FR-J10	●	●			●				0.2	6.35	2.38	2.8
			DCGT070202FL-J10	●	●			●				0.2	6.35	2.38	2.8
		DCGT070204FR-J10	●	●							0.4	6.35	2.38	2.8	
		DCGT070204FL-J10	●	●							0.4	6.35	2.38	2.8	
		DCGT11T300FR-J10	●	●							0.03	9.525	3.97	4.4	
		DCGT11T300FL-J10	●	●							0.03	9.525	3.97	4.4	
		DCGT11T301FR-J10	●	●			●				0.1	9.525	3.97	4.4	
		DCGT11T301FL-J10	●	●			●				0.1	9.525	3.97	4.4	
	DCGT11T302FR-J10	●	●			●				0.2	9.525	3.97	4.4		
	DCGT11T302FL-J10	●	●			●				0.2	9.525	3.97	4.4		
 适用于瑞士机床、走心机外 圆车刀(磨削刃口)	J10	DCGT070202R-J10				●					0.2	6.35	2.38	2.8	
		DCGT11T302R-J10				●					0.2	9.525	3.97	4.4	

刀片 R 为负公差 ●: 产品型号

参考页: 外圆刀杆 → C049 - 内孔刀杆 → D048 -
J系列刀杆 → G026 - PINZBOHR®系列 → K184 -

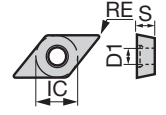
刀片 正前角双面

- : 连续切削
- : 轻断续切削
- ✱: 强断续切削

DX

55°菱形
带内冷孔

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



应用	断屑槽	型号	涂层硬质合金		涂层金属陶瓷		金属陶瓷		不涂层硬质合金		尺寸 (mm)			
			AH725 AH8015 SH725	GT9530	NS9530		KS05F			RE	IC	S	D1	
精加工到半精加工 (锋利刃)		JTS DXGU070301MFR-JTS		●							<0.1	6.35	3.18	2.7
		DXGU070301MFL-JTS		●							<0.1	6.35	3.18	2.7
		DXGU070302MFR-JTS		●							<0.2	6.35	3.18	2.7
		DXGU070302MFL-JTS		●							<0.2	6.35	3.18	2.7
精加工到半精加工		JTS DXGU070301MR-JTS	●								<0.1	6.35	3.18	2.7
		DXGU070301ML-JTS	●								<0.1	6.35	3.18	2.7
		DXGU070302MR-JTS	●								<0.2	6.35	3.18	2.7
		DXGU070302ML-JTS	●								<0.2	6.35	3.18	2.7
精加工 (低切削力)		JSS DXGU070301MFR-JSS		●							<0.1	6.35	3.18	2.7
		DXGU070301MFL-JSS		●							<0.1	6.35	3.18	2.7
		DXGU070302MFR-JSS		●							<0.2	6.35	3.18	2.7
		DXGU070302MFL-JSS		●							<0.2	6.35	3.18	2.7
精加工 (低切削力)		JSS DXGU070301MR-JSS	●								<0.1	6.35	3.18	2.7
		DXGU070301ML-JSS	●								<0.1	6.35	3.18	2.7
		DXGU070302MR-JSS	●								<0.2	6.35	3.18	2.7
		DXGU070302ML-JSS	●								<0.2	6.35	3.18	2.7
精加工到半精加工		TS DXGU070302R-TS	●	●		●	●	●	●		0.2	6.35	3.18	2.7
		DXGU070302L-TS	●	●		●	●	●	●		0.2	6.35	3.18	2.7
		DXGU070304R-TS	●	●		●	●	●	●		0.4	6.35	3.18	2.7
		DXGU070304L-TS	●	●		●	●	●	●		0.4	6.35	3.18	2.7
		DXGU070308R-TS	●	●		●	●	●	●		0.8	6.35	3.18	2.7
		DXGU070308L-TS	●	●		●	●	●	●		0.8	6.35	3.18	2.7
精加工 (低切削力)		SS DXGU070302R-SS	●	●		●	●	●	●		0.2	6.35	3.18	2.7
		DXGU070302L-SS	●	●		●	●	●	●		0.2	6.35	3.18	2.7
		DXGU070304R-SS	●	●		●	●	●	●		0.4	6.35	3.18	2.7
		DXGU070304L-SS	●	●		●	●	●	●		0.4	6.35	3.18	2.7

刀片 R 为负公差

●: 产品型号

参考页: 外圆刀杆 → C039 - 内孔刀杆 → D035 -

刀片 正前角

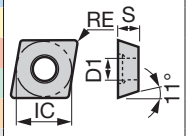
●: 连续切削
●: 轻断续切削
●: 强断续切削

EP



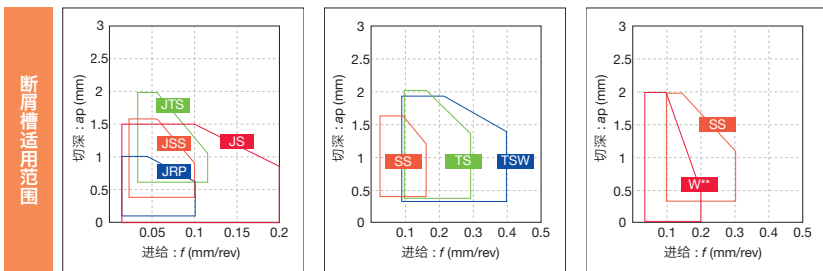
菱形, 75°
带内冷孔
11°正前角

	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料	涂层硬质合金	涂层金属陶瓷	金属陶瓷	不涂层硬质合金
●	●●●●	●●●●	●	●	●	●	●	●	●	●
●	●●●●	●●●●	●	●	●	●	●	●	●	●
●	●●●●	●●●●	●	●	●	●	●	●	●	●
●	●●●●	●●●●	●	●	●	●	●	●	●	●
●	●●●●	●●●●	●	●	●	●	●	●	●	●
●	●●●●	●●●●	●	●	●	●	●	●	●	●
●	●●●●	●●●●	●	●	●	●	●	●	●	●
●	●●●●	●●●●	●	●	●	●	●	●	●	●
●	●●●●	●●●●	●	●	●	●	●	●	●	●



应用	断屑槽	型号	涂层硬质合金				涂层金属陶瓷		金属陶瓷		不涂层硬质合金		尺寸 (mm)			
			GH110	SH725	SH730	GT9530	NS9530	TH10	UX30	RE	IC	S	D1			
精加工		W08 EPGT03X100R-W08		●						●		0.03	3.57	1.39	1.9	
		EPGT03X100L-W08		●						●		0.03	3.57	1.39	1.9	
		EPGT03X101R-W08		●						●		0.1	3.57	1.39	1.9	
		EPGT03X101L-W08		●						●		0.1	3.57	1.39	1.9	
		EPGT03X102R-W08		●						●		0.2	3.57	1.39	1.9	
		EPGT03X102L-W08		●						●		0.2	3.57	1.39	1.9	
		EPGT03X104R-W08		●						●		0.4	3.57	1.39	1.9	
		EPGT03X104L-W08		●						●		0.4	3.57	1.39	1.9	
		EPGT040100R-W08		●						●		0.03	3.97	1.59	2.3	
		EPGT040100L-W08	●	●				●		●		0.03	3.97	1.59	2.3	
		EPGT040101R-W08		●						●		0.1	3.97	1.59	2.3	
		EPGT040101L-W08		●						●		0.1	3.97	1.59	2.3	
		EPGT040102R-W08	●	●						●		0.2	3.97	1.59	2.3	
		EPGT040102L-W08	●	●				●		●	●	0.2	3.97	1.59	2.3	
		EPGT040104R-W08	●	●						●		0.4	3.97	1.59	2.3	
EPGT040104L-W08	●	●				●		●	●	0.4	3.97	1.59	2.3			
精加工 (锋利刃)		W08 EPGT03X100FL-W08		●								0.03	3.57	1.39	1.9	
		EPGT03X100FR-W08		●								0.03	3.57	1.39	1.9	
		EPGT03X101FL-W08		●								0.1	3.57	1.39	1.9	
		EPGT03X101FR-W08		●								0.1	3.57	1.39	1.9	
		EPGT03X102FL-W08		●								0.2	3.57	1.39	1.9	
		EPGT03X102FR-W08		●								0.2	3.57	1.39	1.9	
		EPGT03X104FL-W08		●								0.4	3.57	1.39	1.9	
		EPGT03X104FR-W08		●								0.4	3.57	1.39	1.9	
		EPGT040100FL-W08		●								0.03	3.97	1.59	2.3	
		EPGT040100FR-W08		●								0.03	3.97	1.59	2.3	
		EPGT040101FL-W08		●								0.1	3.97	1.59	2.3	
		EPGT040101FR-W08		●								0.1	3.97	1.59	2.3	
		EPGT040102FL-W08		●								0.2	3.97	1.59	2.3	
		EPGT040102FR-W08		●								0.2	3.97	1.59	2.3	
		EPGT040104FL-W08		●								0.4	3.97	1.59	2.3	
EPGT040104FR-W08		●								0.4	3.97	1.59	2.3			

●: 产品型号
▲: 停止生产



参考页: 内孔刀杆 → **D033** - 镗孔刀杆 → **K211** -
镗杆刀具 → **K213**

材质
刀片
外圆刀杆
内孔刀杆
螺旋加工
槽加工
刀具
小零件刀具
立铣刀
孔加工刀具
工具系统
用户指南
索引

刀片 正前角

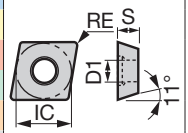
- : 连续切削
- : 轻断续切削
- ★: 强断续切削

EP



菱形, 75°
带内冷孔
11°正前角

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



应用	断屑槽	型号	涂层硬质合金				尺寸 (mm)			
			SH725	SH730	J740		RE	IC	S	D1
用于小型机床上车内孔		JS EPGT03X101-JS	●	●			<0.1	3.57	1.39	1.9
		EPGT03X102-JS	●	●			<0.2	3.57	1.39	1.9
		EPGT03X104-JS	●	●			<0.4	3.57	1.39	1.9
		EPGT040101-JS	●	●			<0.1	3.97	1.59	2.3
		EPGT040102-JS	●	●			<0.2	3.97	1.59	2.3
		EPGT040104-JS	●	●			<0.4	3.97	1.59	2.3
用于小型机床上车内孔 (锋利型)		JS EPGT03X101F-JS	●				<0.1	3.57	1.39	1.9
		EPGT03X102F-JS	●				<0.2	3.57	1.39	1.9
		EPGT03X104F-JS	●				<0.4	3.57	1.39	1.9
		EPGT040101F-JS	●				<0.1	3.97	1.59	2.3
		EPGT040102F-JS	●				<0.2	3.97	1.59	2.3
		EPGT040104F-JS	●				<0.4	3.97	1.59	2.3
精加工		J08 EPGT040100L-J08	●	●			0.03	3.97	1.59	2.3
		EPGT040102L-J08	●	●			0.2	3.97	1.59	2.3
		EPGT040104L-J08	●	●			0.4	3.97	1.59	2.3
精加工 (锋利加工)		J08 EPGT040100FL-J08	●				0.03	3.97	1.59	2.3
		EPGT040102FL-J08	●				0.2	3.97	1.59	2.3
		EPGT040104FL-J08	●				0.4	3.97	1.59	2.3

刀尖 R 为负公差

- : 产品型号
- ▲: 停止生产

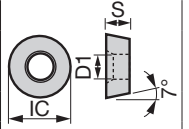
参考页: 内孔刀杆 → D033 - 镗孔刀杆 → K211 - 镗杆刀具 → K213

刀片 正前角

●：连续切削
 ●：轻断续切削
 *：强断续切削

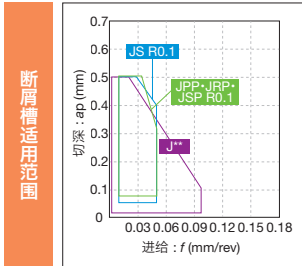
RC

圆形
带内冷孔
7°正前角

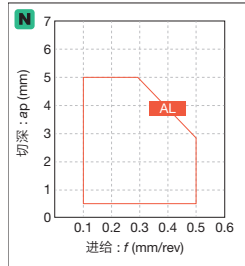
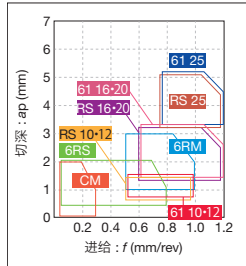


应用	断屑槽	型号	涂层硬质合金								不涂层硬质合金			尺寸 (mm)			
			T9215	T9225	T9115	T9125	T5115	AH120	AH8005	AH8015	AH905	KS05F	RE	IC	S	D1	
精加工到半精加工		RS RCMT10T3M0-RS	●	●	▲	▲		●	●	●			-	10	3.97	4.4	
		RCMT1204M0-RS	●	●	▲	▲		●	●	●			-	12	4.76	4.4	
		RCMT1606M0-RS	●	●	▲	▲	●						-	16	6.35	5.5	
		RCMT2006M0-RS		●		▲							-	20	6.35	6.5	
		RCMT2507M0-RS		●		▲							-	25	7.94	7.6	
		CM RCMT0502M0-CM						●					-	5	2.38	2.5	
		RCMT0602M0-CM						●					-	6	2.38	2.8	
		RCMT0803M0-CM						●					-	8	3.18	3.4	
		AL RCGT0602M0-AL									●		-	6	2.38	2.8	
		RCGT0803M0-AL									●		-	8	3.18	3.4	
		RCGT1003M0-AL									●		-	10	3.18	4.4	
	(低精加工)		6RS RCMT1204M0-6RS	●	●	▲	▲							-	12	4.76	4.4
6RM RCMT1204M0-6RM			●	●	▲	▲							-	12	4.76	4.4	

●：产品型号
 ▲：停止生产



R0.1的槽型适用范围

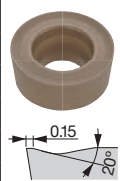
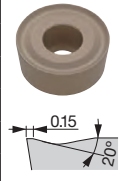


刀片 正前角

●: 连续切削
●: 轻断续切削
* : 强断续切削

RC

圆形
带内冷孔
7°正前角

应用	断屑槽	型号	涂层硬质合金						金属陶瓷	不涂层硬质合金			尺寸 (mm)			
			T9215	T9225	T9115	T9125	AH8005	AH8015	AH905	NS9530	TH10	RE	IC	S	D1	
重载加工		61 RCMT0502M0-61	●	●	▲	▲			●		●	-	5	2.38	2.5	
		RCMT0602M0-61	●	●	▲	▲			●		●	-	6	2.38	2.8	
		RCMT0803M0-61	●	●	▲	▲			●		●	-	8	3.18	3.4	
		61 RCMM1003M0-61	●	●	▲	▲	●	●	●		●	-	10	3.18	3.6	
		RCMM1204M0-61	●	●	▲	▲	●	●	●		●	-	12	4.76	4.2	
		RCMM1606M0-61	●	●	▲	▲					●	-	16	6.35	5.2	
		RCMM2006M0-61		●	▲						●	-	20	6.35	6.5	
	RCMM2507M0-61		●	▲							-	25	7.94	7.2		

D1 (mm)	型号	0502M0	0602M0	0803M0	1003M0	1204M0	1606M0	2006M0	2507M0
	RC*T		2.5	2.8	3.4	4.4	4.4	5.5	6.5
RCMM		-	-	-	3.6	4.2	5.2	6.5	7.2

RT

特殊圆刀片

应用	断屑槽	型号	不涂层硬质合金						尺寸 (mm)								
			TH10	KS20					RE	IC	S	S1					
半精加工		- RT05	●										-	5	2.5	6.5	
		RT06	●	●										-	6	3	7.7
		RT08	●												-	8	4.2

●: 产品型号
▲: 停止生产

参考页: RC...: 外圆刀杆 → **C074** -

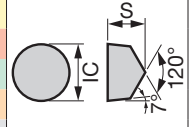
刀片 正前角

- : 连续切削
- : 轻断续切削
- ✳: 强断续切削

RC

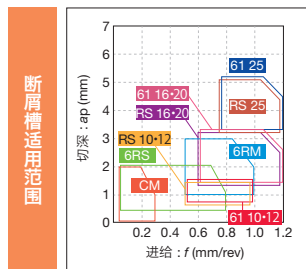
圆形
不带孔
7°正前角

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	陶瓷															尺寸 (mm)					
			LX11																RE	IC	S	D1	
半精加工		-																		-	9.525	8	-
		RCGX090800	●																		-	12.7	8
		RCGX120800	●																				

●: 产品型号



- A 材质
- B 刀片
- C 外圆刀杆
- D 内孔刀杆
- E 螺纹加工
- F 槽加工
- G 小零件刀具
- H 铣刀
- I 立铣刀
- J 孔加工刀具
- K 工具系统
- L 用户指南
- M 索引

刀片 正前角

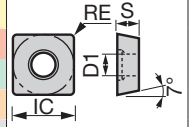
- : 连续切削
- ◐: 轻断续切削
- ✱: 强断续切削

SC

方形, 90°
带内冷孔
7°正前角



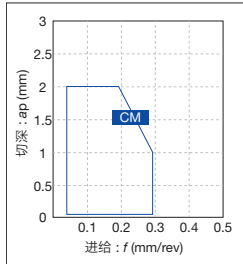
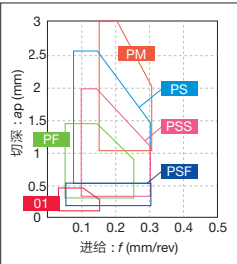
P	钢	●	●	●	✱	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
M	不锈钢	●	●			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
K	铸铁	●	●	●	●					●	●	●	●	●	●	●	●	●	●	●	●
N	非铁金属					●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
S	超级合金									●	●										
H	硬材料																				



应用	断屑槽	型号	涂层硬质合金												涂层金属陶瓷		金属陶瓷	尺寸 (mm)			
			T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH120	AH725	GT9530	AT9530	NS9530	RE	IC	S	D1
精加工到半精加工		PS SCMT09T304-PS	●	●	▲	▲	●	●	●					●	●	●	0.4	9.525	3.97	4.4	
		SCMT09T308-PS	●	●	▲	▲	●	●	●					●	●	●	0.8	9.525	3.97	4.4	
		SCMT120404-PS	●	●	▲	▲	●	●	●					●	●	●	0.4	12.7	4.76	5.5	
		SCMT120408-PS	●	●	▲	▲	●	●	●					●	●	●	0.8	12.7	4.76	5.5	
		23 SCMT09T302-23														●		0.2	9.525	3.97	4.4
SCMT09T308-23		●		▲							●					0.8	9.525	3.97	4.4		
SCMT120408-23		●		▲						●	●					0.8	12.7	4.76	5.5		
半精加工		24 SCMT070204-24		●		▲										●	0.4	7.94	2.38	3.4	
		SCMT09T302-24		●												●	0.2	9.525	3.97	4.4	
		SCMT09T304-24		●		▲										●	0.4	9.525	3.97	4.4	
		SCMT09T308-24	●	●	▲	▲										●	0.8	9.525	3.97	4.4	
		SCMT120404-24		●		▲										●	0.4	12.7	4.76	5.5	
		SCMT120408-24		●		▲										●	0.8	12.7	4.76	5.5	
		PM SCMT09T304-PM	●	●	▲	▲	●	●	●	●			●			●	0.4	9.525	3.97	4.4	
SCMT09T308-PM	●	●	▲	▲	●	●	●	●			●			●	0.8	9.525	3.97	4.4			
SCMT120408-PM	●	●	▲	▲	●	●	●	●			●			●	0.8	12.7	4.76	5.5			
SCMT120412-PM		●		▲	●	●	●	●			●			●	1.2	12.7	4.76	5.5			
精加工到半精加工		CM SCMT09T304-CM								●	●					0.4	9.525	3.97	4.4		
		SCMT09T308-CM								●	●					0.8	9.525	3.97	4.4		
		SCMT09T312-CM									●					1.2	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		

●: 产品型号
▲: 停止生产

断屑槽适用范围



刀片 正前角

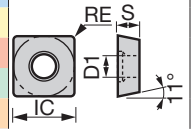
●: 连续切削
 ●: 轻断续切削
 * : 强断续切削

SP



方形, 90°
带内冷孔
11°正前角

	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料	涂层硬质合金												涂层金属陶瓷		金属陶瓷	不涂层硬质合金				
	●	●	●	●	●	●	T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	AH120	AH725	GT9530	AT9530	NS9530	TH10	RE	IC	S	D1		
应用	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
精加工到半精加工	断屑槽																									
	型号																									
	PS	SPMT090304-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
		SPMT090308-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
		SPMT120404-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
	SPMT120408-PS	●	●	▲	▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
半精加工	23	SPMT090304-23		●		▲													●							
		SPMT090308-23		●		▲													●							
	24	SPMT090304-24		●		▲													●							
		SPMT090308-24		●		▲							●						●							
		SPMT120404-24																	●							
精加工	W15	SPGT090302L-W15																	●							
		SPGT090304L-W15																	●		●					
		SPGT090308R-W15																		●		●				
		SPGT090308L-W15																		●		●				
		W20	SPGT120404L-W20																	●						



●: 产品型号
 ▲: 停止生产

参考页: 内孔刀杆 → [D038](#) - 刀夹 → [K197](#) -

刀片 正前角

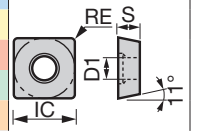
- : 连续切削
- ◐: 轻断续切削
- ◑: 强断续切削

SP



方形, 90°
带内冷孔
11°正前角

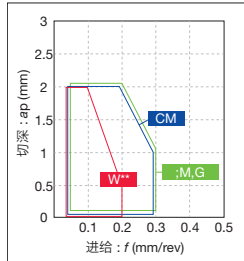
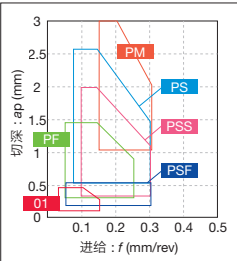
P	钢																					●	◐	◑				
M	不锈钢																							●	◐	◑		
K	铸铁	●	◐	◑																		●	◐	◑				
N	非铁金属																							●	◐	◑		
S	超级合金																								●	◐	◑	
H	硬材料																									●	◐	◑



应用	断屑槽	型号	涂层硬质合金			金属陶瓷		不涂层硬质合金			尺寸 (mm)					
			T515	T5115		NS9530		TH10				RE	IC	S	D1	
精加工到平精加工	 0.25 10°	CM SPMT090304-CM	●									0.4	9.525	3.18	4.4	
		SPMT090308-CM	●									0.8	9.525	3.18	4.4	
		SPMT120404-CM	●	●									0.4	12.7	4.76	5.5
		SPMT120408-CM	●	●									0.8	12.7	4.76	5.5
	泰珂洛标准安装孔规格	- SPGM090304L					●						0.4	9.525	3.18	4.4
		SPGM120304L					●						0.4	12.7	3.18	5
		SPGM120308L					●						0.8	12.7	3.18	5
	 2.36°	- SPMW090304		●									0.4	9.525	3.18	4.4
		SPMW090308		●									0.8	9.525	3.18	4.4
		SPMW120404		●									0.4	12.7	4.76	5.5
		SPMW120408		●									0.8	12.7	4.76	5.5
		- SPGW090302							●				0.2	9.525	3.18	4.4
SPGW090304								●				0.4	9.525	3.18	4.4	
SPGW120404								●				0.4	12.7	4.76	5.5	
- SPGA090304	泰珂洛标准安装孔规格					●						0.4	9.525	3.18	4.4	

●: 产品型号

断屑槽适用范围



M,G 精度等级: 无断屑槽

参考页: 内孔刀杆 → D038 - 刀夹 → K197 -

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

槽加工

小零件刀具

刀具

立铣刀

孔加工刀具

工具系统

用户指南

索引

刀片 正前角

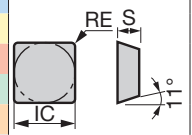
- : 连续切削
- ◐ : 轻断续切削
- ◑ : 强断续切削

SP



方形, 90°
不带孔
11°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	涂层硬质合金				金属陶瓷			不涂层硬质合金		陶瓷		尺寸 (mm)				
			T9225	T9125	T5115		NS9530			TH10	UX30	LX11	WG300	RE	IC	S	D1	
精加工到半精加工	23	SPMR090304-23					●							0.4	9.525	3.18	-	
		SPMR090308-23	● ▲				●								0.8	9.525	3.18	-
	SPMR120304-23	● ▲				●								0.4	12.7	3.18	-	
	SPMR120308-23	● ▲				●								0.8	12.7	3.18	-	
	CM	SPMR090304-CM		●											0.4	9.525	3.18	-
		SPMR090308-CM		●											0.8	9.525	3.18	-
		SPMR120304-CM		●											0.4	12.7	3.18	-
		SPMR120308-CM		●											0.8	12.7	3.18	-
		SPMR120312-CM		●											1.2	12.7	3.18	-
	-		SPGR090304L					●							0.4	9.525	3.18	-
S	-	SPGN090304							●		●			0.4	9.525	3.18	-	
		SPGN090308							●		●			0.8	9.525	3.18	-	
	SPGN120304							●		●			0.4	12.7	3.18	-		
	SPGN120308							●		●			0.8	12.7	3.18	-		
	SPGN120312					●				●			1.2	12.7	3.18	-		
	SPGN120408							●					0.8	12.7	4.76	-		
	V	-	SPMN090304		●										0.4	9.525	3.18	-
			SPMN090308		●										0.8	9.525	3.18	-
SPMN120304			●										0.4	12.7	3.18	-		
SPMN120308			●			●		● ●					0.8	12.7	3.18	-		
SPMN120312			●					● ●					1.2	12.7	3.18	-		
SPMN120408			●					●					0.8	12.7	4.76	-		
		SPMN120412		●									1.2	12.7	4.76	-		

● : 产品型号
▲ : 停止生产

参考页: 内孔刀杆 → D038 - 刀夹 → K197 -

刀片 正前角

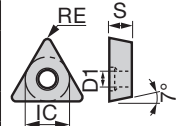
- : 连续切削
- : 轻断续切削
- ※ : 强断续切削

TC



三角形, 60°
带内冷孔
7°正前角

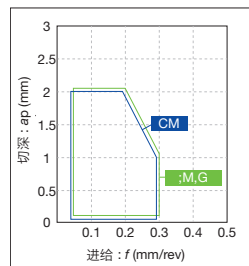
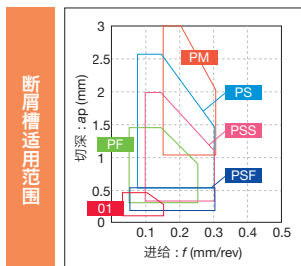
P	钢	●●●○	○●○●	●●●●		○●		○●○●		●								
M	不锈钢	●●			●	○●○●				●								
K	铸铁	●●	○●	●		○●		○●○●		●								
N	非金属材料									●								
S	超级合金				●													
H	硬材料																	



应用	断屑槽	型号	涂层硬质合金							涂层金属陶瓷		金属陶瓷		不涂层硬质合金	尺寸 (mm)			
			T9215	T9225	T9115	T9125	AH725	SH725	J740	GT9530		NS9530	NS520		TH10	RE	IC	S
精密加工	01	TCGT090204-01									●				0.4	5.56	2.38	2.5
		TCGT110202-01					●								0.2	6.35	2.38	2.8
		TCGT110204-01						●			●	●		●	0.4	6.35	2.38	2.8
		TCGT110208-01									●				0.8	6.35	2.38	2.8
		TCGT16T304-01												●	0.4	9.525	3.97	4.4
	TCGT16T308-01										●		●	0.8	9.525	3.97	4.4	
精密加工 (锋利型)	01	TCGT110202F-01					●								<0.2	6.35	2.38	2.8
		TCGT110204F-01					●								<0.4	6.35	2.38	2.8
精加工	PSF	TCMT090202-PSF					●								0.2	5.56	2.38	2.5
		TCMT090204-PSF	●	●	▲	▲	●								0.4	5.56	2.38	2.5
		TCMT110202-PSF					●								0.2	6.35	2.38	2.8
		TCMT110204-PSF	●	●	▲	▲	●								0.4	6.35	2.38	2.8
		TCMT110302-PSF					●								0.2	6.35	3.18	2.8
		TCMT110304-PSF	●	●	▲	▲	●								0.4	6.35	3.18	2.8
	TCMT16T304-PSF	●	●	▲	▲	●								0.4	9.525	3.97	4.4	
精加工到轻切削	PSS	TCMT090204-PSS	●	●	▲	▲	●								0.4	5.56	2.38	2.5
		TCMT090208-PSS	●	●	▲	▲	●								0.8	5.56	2.38	2.5
		TCMT110204-PSS	●	●	▲	▲	●								0.4	6.35	2.38	2.8
		TCMT110208-PSS	●	●	▲	▲	●								0.8	6.35	2.38	2.8
		TCMT110304-PSS	●	●	▲	▲	●								0.4	6.35	3.18	2.8
		TCMT110308-PSS	●	●	▲	▲	●								0.8	6.35	3.18	2.8
		TCMT16T304-PSS	●	●	▲	▲	●								0.4	9.525	3.97	4.4
		TCMT16T308-PSS	●	●	▲	▲	●								0.8	9.525	3.97	4.4
	TCMT16T312-PSS	●	●	▲	▲	●								1.2	9.525	3.97	4.4	

刀尖 R 为负公差

● : 产品型号
▲ : 停止生产



参考页: 外圆刀杆 → C076 - 内孔刀杆 → D042
 J系列刀杆 → G039 - PINZBOHR®系列 → K180 -

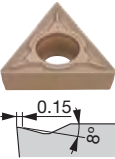
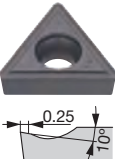
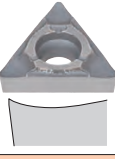
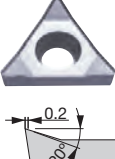
材质: A
刀片: B
外圆刀杆: C
内孔刀杆: D
螺纹加工: E
槽加工: F
小零件刀具: G
铣刀: H
立铣刀: I
孔加工刀具: J
工具系统: K
用户指南: L
索引: M

刀片 正前角

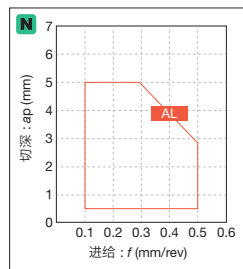
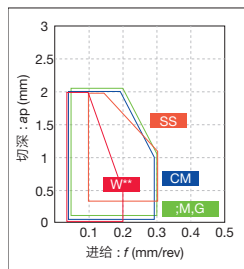
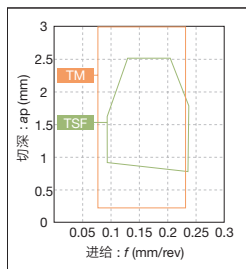
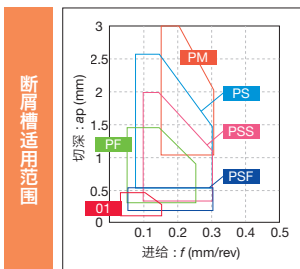
- : 连续切削
- ◐ : 轻断续切削
- ✱ : 强断续切削

TC

三角形, 60°
带内冷孔
7°正前角

应用	断屑槽	型号	涂层硬质合金												金属陶瓷	不涂层硬质合金	尺寸 (mm)			
			T9215	T9225	T9115	T9125	T6120	T6130	AH630	AH645	T515	T5115	AH725	NS9530	KS05F	RE	IC	S	D1	
半精加工		PM TCMT110202-PM					●	●	●	●		●				0.2	6.35	2.38	2.8	
		TCMT110204-PM	●	●	▲	▲	●	●	●	●		●	●				0.4	6.35	2.38	2.8
		TCMT110208-PM	●	●	▲	▲	●	●	●	●		●	●				0.8	6.35	2.38	2.8
		TCMT110302-PM					●	●	●	●							0.2	6.35	3.18	2.8
		TCMT110304-PM					●	●	●	●							0.4	6.35	3.18	2.8
		TCMT110308-PM					●	●	●	●							0.8	6.35	3.18	2.8
		TCMT16T304-PM			▲	▲	●	●	●	●		●	●	●			0.4	9.525	3.97	4.4
		TCMT16T308-PM			▲	▲	●	●	●	●		●	●	●	●		0.8	9.525	3.97	4.4
		TCMT16T312-PM			▲	▲	●	●	●	●		●	●	●	●		1.2	9.525	3.97	4.4
精加工到半精加工		CM TCMT090204-CM									●					0.4	5.56	2.38	2.5	
		TCMT090208-CM									●						0.8	5.56	2.38	2.5
		TCMT110204-CM									●						0.4	6.35	2.38	2.8
		TCMT110208-CM									●						0.8	6.35	2.38	2.8
		TCMT110304-CM									●						0.4	6.35	3.18	2.8
		TCMT110308-CM									●						0.8	6.35	3.18	2.8
		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
精加工到半精加工		SS TCGT110202-SS											●			0.2	6.35	2.38	2.8	
		TCGT110204-SS											●				0.4	6.35	2.38	2.8
		TCGT110208-SS											●				0.8	6.35	2.38	2.8
		TCGT16T304-SS											●				0.4	9.525	3.97	4.4
精加工到半精加工		AL TCGT110202-AL												●		0.2	6.35	2.38	2.8	
		TCGT110204-AL												●			0.4	6.35	2.38	2.8
		TCGT16T302-AL													●		0.2	9.525	3.97	4.4
		TCGT16T304-AL													●		0.4	9.525	3.97	4.4
		TCGT16T308-AL													●		0.8	9.525	3.97	4.4

● : 产品型号
▲ : 停止生产



M,G 精度等级: 无断屑槽

参考页: 外圆刀杆 → C076 - 内孔刀杆 → D042
J系列刀杆 → G039 - PINZBOHR®系列 → K180 -

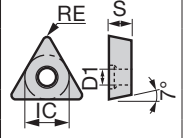
刀片 正前角

TC



三角形, 60°
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	涂层硬质合金				金属陶瓷		不涂层硬质合金				尺寸 (mm)						
			AH725	SH725	SH730	J740	NS9530	TH10					RE	IC	S	D1			
精加工 用于小型机床上车内孔 (锋利型)	-	TCGT080102R					●		●							0.2	4.76	1.59	2.7
	 适用于瑞士机床、走心机外圆 (磨削刃口)	JS	TCGT110200FN-JS	●	●											0.03	6.35	2.38	2.8
			TCGT110201FN-JS	●	●											<0.1	6.35	2.38	2.8
			TCGT110202FN-JS	●	●											<0.2	6.35	2.38	2.8
			TCGT110204FN-JS	●	●											<0.4	6.35	2.38	2.8
适用于瑞士机床、走心机外圆 (磨削刃口)	JS	TCGT110201N-JS	●												0.1	6.35	2.38	2.8	
		TCGT110202N-JS	●												0.2	6.35	2.38	2.8	
		TCGT110204N-JS	●												0.4	6.35	2.38	2.8	
用于小型机床上车内孔 (锋利型)	J08	TCGT080200FR-J08	●	●					●						0.03	4.76	2.38	2.3	
		TCGT080200FL-J08	●	●					●						0.03	4.76	2.38	2.3	
		TCGT080201FR-J08	●	●					●						0.1	4.76	2.38	2.3	
		TCGT080201FL-J08	●	●					●						0.1	4.76	2.38	2.3	
		TCGT080202FR-J08	●	●					●						0.2	4.76	2.38	2.3	
		TCGT080202FL-J08	●	●					●						0.2	4.76	2.38	2.3	
		TCGT080204FR-J08	●						●						0.4	4.76	2.38	2.3	

刀尖 R 为负公差

●: 产品型号

刀片 正前角

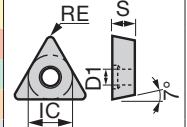
- : 连续切削
- : 轻断续切削
- : 强断续切削

TC



三角形, 60°
带内冷孔
7°正前角

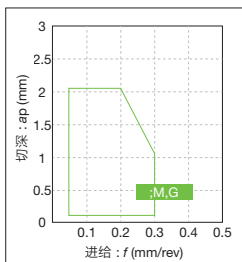
材料	涂层硬质合金	涂层金属陶瓷	金属陶瓷	不涂层硬质合金
P 钢	●●●●	●●	●●	●
M 不锈钢	●●●●			●
K 铸铁		●●	●●	●
N 非铁金属				●
S 超级合金				
H 硬材料				



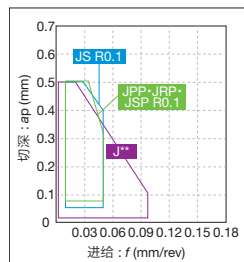
应用	断屑槽	型号	涂层硬质合金				涂层金属陶瓷				金属陶瓷				不涂层硬质合金				尺寸 (mm)			
			SH725	J740	J9530	NS9530	TH10	SH725	J740	J9530	NS9530	TH10	SH725	J740	J9530	NS9530	TH10	RE	IC	S	D1	
用于小型机床上车内孔 (锋利刀)		J10 TCGT110200FR-J10	●	●							●						0.03	6.35	2.38	2.8		
		TCGT110200FL-J10	●	●							●						0.03	6.35	2.38	2.8		
		TCGT110201FR-J10	●	●							●						0.1	6.35	2.38	2.8		
		TCGT110201FL-J10	●	●							●						0.1	6.35	2.38	2.8		
		TCGT110202FR-J10	●	●						●	●						0.2	6.35	2.38	2.8		
		TCGT110202FL-J10	●	●						●	●						0.2	6.35	2.38	2.8		
		TCGT110204FR-J10	●														0.4	6.35	2.38	2.8		
		TCGT110300FR-J10	●	●								●					0.03	6.35	3.18	2.8		
		TCGT110300FL-J10	●	●								●					0.03	6.35	3.18	2.8		
		TCGT110301FR-J10	●	●								●					0.1	6.35	3.18	2.8		
		TCGT110301FL-J10	●	●								●					0.1	6.35	3.18	2.8		
		TCGT110302FR-J10	●	●							●	●					0.2	6.35	3.18	2.8		
		TCGT110302FL-J10	●	●							●	●					0.2	6.35	3.18	2.8		
适用瑞士机床、走心机外圆车刀(磨削刃口)		J10 TCGT110302R-J10			●											0.2	6.35	3.18	2.8			
		TCGT110302L-J10			●												0.2	6.35	3.18	2.8		

●: 产品型号

断屑槽适用范围



M,G 精度等级: 无断屑槽



R0.1 的槽型适用范围

参考页: 内孔刀杆 → **D042** J系列刀杆 → **G039**

负前角

正前角

PCD/CBN

C

D

G

R

S

T

V

W

Y

其它

刀片 正前角

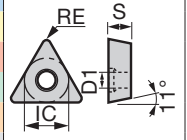
- : 连续切削
- ◐: 轻断续切削
- ✱: 强断续切削

TP



三角形, 60°
带内冷孔
11°正前角

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



应用	断屑槽	型号	涂层硬质合金						涂层金属陶瓷		金属陶瓷		不涂层硬质合金	尺寸 (mm)				
			T9215	T9225	T9115	T9125	AH725	GH730	GT9530	GT720	NS9530	NS520	TH10	RE	IC	S	D1	
精密加工		01	TPGT090202-01						●		●			0.2	5.56	2.38	2.5	
		TPGT090204-01							●		●	●	●	0.4	5.56	2.38	2.5	
		TPGT110202-01							●		●			0.2	6.35	2.38	2.8	
		TPGT110204-01							●		●	●	●	0.4	6.35	2.38	2.8	
		TPGT110208-01									●			0.8	6.35	2.38	2.8	
		TPGT130302-01								●		●		0.2	7.94	3.18	3.4	
		TPGT130304-01								●		●	●	●	0.4	7.94	3.18	3.4
		TPGT130308-01										●	●		0.8	7.94	3.18	3.4
		TPGT16T304-01									●		●	●	0.4	9.525	3.97	4.4
		TPGT16T308-01										●	●		0.8	9.525	3.97	4.4
精加工		PSF	TPMT090202-PSF											0.2	5.56	2.38	2.5	
		TPMT090204-PSF	●	●	▲	▲	●		●		●		0.4	5.56	2.38	2.5		
		TPMT110202-PSF								●		●		0.2	6.35	2.38	2.8	
		TPMT110204-PSF	●	●	▲	▲	●		●		●		0.4	6.35	2.38	2.8		
		TPMT110302-PSF										●		0.2	6.35	3.18	3.4	
		TPMT110304-PSF	●	●	▲	▲	●		●		●		0.4	6.35	3.18	3.4		
		TPMT130304-PSF	●	●	▲	▲	●						0.4	7.94	3.18	3.4		
		TPMT16T304-PSF	●	●	▲	▲	●						0.4	9.525	3.97	4.4		
	PF	TPMT110204-PF					●		●		●		0.4	6.35	2.38	2.8		
		TPMT110208-PF							●		●		0.8	6.35	2.38	2.8		
	TPMT110302-PF							●		●		0.2	6.35	3.18	3.4			
	TPMT110304-PF							●		●		0.4	6.35	3.18	3.4			
	TPMT130304-PF								●		●		0.4	7.94	3.18	3.4		
	TPMT130308-PF										●		0.8	7.94	3.18	3.4		
TPMT16T304-PF									●		●		0.4	9.525	3.97	4.4		

- : 产品型号
- ▲: 停止生产

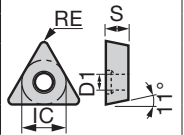
参考页: 安装孔规格 → B147
 内孔刀杆 → D043 - 刀夹 → K193 -
 镗孔刀杆 → K209 - 镗杆刀具 → K213

TP



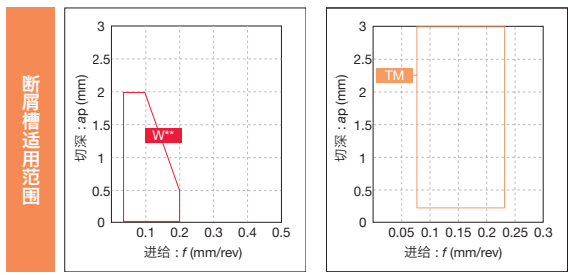
三角形, 60°
 带内冷孔
 11°正前角

	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	涂层硬质合金		涂层金属陶瓷	金属陶瓷	不涂层硬质合金	尺寸 (mm)			
			GH110 GH330		GT9530	NS9530	TH10 UX30	RE	IC	S	D1
精加工	W10	TPGH080202L-W10			●	●		0.2	4.76	2.38	2.3
		TPGH080204L-W10			●	●		0.4	4.76	2.38	2.3
		TPGH090204L-W10			●	●		0.4	5.56	2.38	3
	W13	TPGH110204L-W13			●	●		0.4	6.35	2.38	3.4
		TPGH110302L-W13			●	●		0.2	6.35	3.18	3.4
		TPGH110304L-W13			●	●		0.4	6.35	3.18	3.4
	W15	TPGT090202R-W15				●		0.2	5.56	2.38	2.5
		TPGT090202L-W15			●	●	●	0.2	5.56	2.38	2.5
		TPGT090204R-W15				●		0.4	5.56	2.38	2.5
		TPGT090204L-W15	● ●		●	●	● ●	0.4	5.56	2.38	2.5
		TPGT110202R-W15				●		0.2	6.35	2.38	2.8
		TPGT110202L-W15			●	●	●	0.2	6.35	2.38	2.8
		TPGT110204L-W15	● ●		●	●	● ●	0.4	6.35	2.38	2.8
		TPGT110208R-W15				●		0.8	6.35	2.38	2.8
		TPGT110208L-W15					●	0.8	6.35	2.38	2.8
		TPGT110302L-W15				●		0.2	6.35	3.18	3.4
		TPGT110304R-W15				●		0.4	6.35	3.18	3.4
		TPGT110304L-W15				●		0.4	6.35	3.18	3.4
		TPGT110308L-W15				●		0.8	6.35	3.18	3.4
		TPGT130302R-W15				●		0.2	7.94	3.18	3.4
		TPGT130302L-W15			●	●	●	0.2	7.94	3.18	3.4
		TPGT130304R-W15	●			●		0.4	7.94	3.18	3.4
		TPGT130304L-W15	● ●		●	●	● ●	0.4	7.94	3.18	3.4
	TPGT130308L-W15				●		0.8	7.94	3.18	3.4	
	TPGT16T302R-W15				●		0.2	9.525	3.97	4.4	
	TPGT16T302L-W15			●	●	●	0.2	9.525	3.97	4.4	
	TPGT16T304R-W15				●		0.4	9.525	3.97	4.4	
	TPGT16T304L-W15	● ●		●	●	● ●	0.4	9.525	3.97	4.4	
	TPGT16T308L-W15				●		0.8	9.525	3.97	4.4	

● : 产品型号



参考页: 安装孔规格 → B147
 内孔刀杆 → D043 - 刀夹 → K193 -
 镗杆刀具 → K213

刀片 正前角

- : 连续切削
- ◐: 轻断续切削
- ◑: 强断续切削

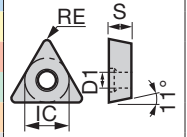
材质

TP



三角形, 60°
带内冷孔
11°正前角

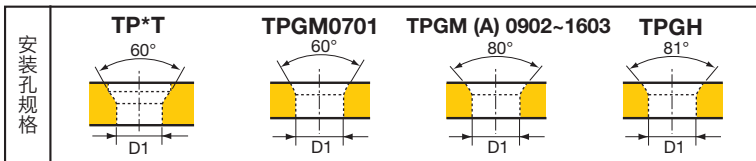
材料	P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 超级合金	H 硬材料
涂层硬质合金	●	●	●	●	●	●
金属陶瓷	●	●	●	●	●	●
不涂层硬质合金	●	●	●	●	●	●



刀片

应用	断屑槽	型号	涂层硬质合金			金属陶瓷			不涂层硬质合金			尺寸 (mm)			
			T5115	NS9530				TH10 UX30				RE	IC	S	D1
精加工到半精加工	泰珂洛标准安装孔规格与ISO不同	- TPGM070102R		●								0.2	4.37	1.59	2.7
		TPGM070102L		●								0.2	4.37	1.59	2.7
		TPGM070104R		●								0.4	4.37	1.59	2.7
		TPGM070104L		●								0.4	4.37	1.59	2.7
		TPGM090202R		●								0.2	5.56	2.38	3.2
		TPGM090202L		●								0.2	5.56	2.38	3.2
		TPGM090204L		●								0.4	5.56	2.38	3.2
		TPGM110202R		●								0.2	6.35	2.38	3
		TPGM110202L		●				●				0.2	6.35	2.38	3
		TPGM110204R		●				●				0.4	6.35	2.38	3
		TPGM110204L		●				●				0.4	6.35	2.38	3
		TPGM110302R		●								0.2	6.35	3.18	3
		TPGM110302L		●								0.2	6.35	3.18	3
		TPGM110302L-2						●				0.2	6.35	3.18	3
		TPGM110304R		●								0.4	6.35	3.18	3
		TPGM110304L		●				●				0.4	6.35	3.18	3
		TPGM110304L-2						●				0.4	6.35	3.18	3
		TPGM160302L		●								0.2	9.525	3.18	4
	TPGM160304R		●								0.4	9.525	3.18	4	
	TPGM160304L		●				●				0.4	9.525	3.18	4	
TPGM160304L-2						●				0.4	9.525	3.18	4		
精加工到半精加工	TPGM...R/L	- TPMW110204	●								0.4	6.35	2.38	2.8	
		TPMW110208	●								0.8	6.35	2.38	2.8	
		TPMW130304	●								0.4	7.94	3.18	3.4	
		TPMW130308	●								0.8	7.94	3.18	3.4	
		TPMW16T304	●								0.4	9.525	3.97	4.4	
		TPMW16T308	●								0.8	9.525	3.97	4.4	

●: 产品型号



D1 (mm)	产品型号							
	0701**	0802**	0902**	1102**	1103**	1303**	1603**	16T3**
TP*T(W)	-	2.3	2.5	2.8	3.4	3.4	-	4.4
TPGM(A)	2.7	-	3.2	3.0	3.0	-	4.0	-
TPGH	-	2.3	3.0	3.4	3.4	-	4.5	-

外圆刀杆

内孔刀杆

螺紋加工

槽加工

小零件刀具

铣刀

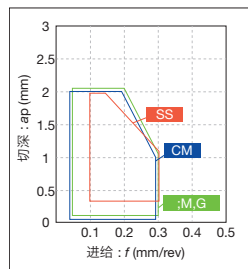
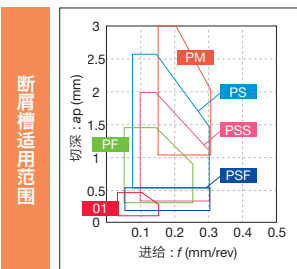
立铣刀

孔加工刀具

工具系统

用户指南

索引



M,G 精度等级: 无断屑槽

参考页: 内孔刀杆 → **D043** - 刀夹 → **K193** -
镗孔刀杆 → **K209** -

刀片 正前角

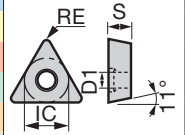
●: 连续切削
●: 轻断续切削
●: 强断续切削

TP



三角形, 60°
带内冷孔
11°正前角

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



应用	断屑槽	型号	涂层硬质合金				金属陶瓷				不涂层硬质合金				尺寸 (mm)					
			GH110	SH725	SH730	NS9530					TH10					RE	IC	S	D1	
精加工到半精加工	-	TPGA090204															0.4	5.56	2.38	3.2
		TPGA110202				●											0.2	6.35	2.38	3
		TPGA110204															0.4	6.35	2.38	3
		TPGA110302				●											0.2	6.35	3.18	3
		TPGA110304															0.4	6.35	3.18	3
		TPGA160304				●											0.4	9.525	3.18	4
		TPGA160308															0.8	9.525	3.18	4
		TPGW090202															0.2	5.56	2.38	2.5
		TPGW090204															0.4	5.56	2.38	2.5
		TPGW110202															0.2	6.35	2.38	2.8
		TPGW110204	●														0.4	6.35	2.38	2.8
		TPGW110304															0.4	6.35	3.18	3.4
		TPGW130304															0.4	7.94	3.18	3.4
		TPGW16T304	●														0.4	9.525	3.97	4.4
		TPGW16T308															0.8	9.525	3.97	4.4
用于小型机床上车 内孔	JS	TPGT070101-JS		●												<0.1	4.37	1.59	2.58	
		TPGT070102-JS		●												<0.2	4.37	1.59	2.58	
		TPGT070104-JS		●												<0.4	4.37	1.59	2.58	
用于小型机床上车内孔 (锋利型)	JS	TPGT070101F-JS	●													<0.1	4.37	1.59	2.58	
		TPGT070102F-JS	●													<0.2	4.37	1.59	2.58	
		TPGT070104F-JS	●													<0.4	4.37	1.59	2.58	

刀尖 R 为负公差

●: 产品型号

参考页: 内孔刀杆 → D043 - 刀夹 → K193 -
镗孔刀杆 → K209 -

刀片 正前角

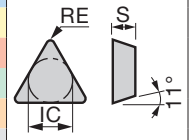
- : 连续切削
- : 轻断续切削
- : 强断续切削

TP

三角形, 60°
不带孔
11°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
涂层硬质合金	●●●	●●●	●●●	●●●	●●●	●●●
金属陶瓷	●●●	●●●	●●●	●●●	●●●	●●●
不涂层硬质合金	●●●	●●●	●●●	●●●	●●●	●●●
陶瓷	●●●	●●●	●●●	●●●	●●●	●●●



应用	断屑槽	型号	涂层硬质合金		金属陶瓷	不涂层硬质合金		陶瓷		尺寸 (mm)							
			T5115	GH110	AH120	NS9530	TH10	UX30	LX21	LX11	RE	IC	S	D1			
精加工到半精加工	-	TPGR110302L				●								0.2	6.35	3.18	-
		TPGR110304L				●								0.4	6.35	3.18	-
		TPGR160304R				●								0.4	9.525	3.18	-
		TPGR160304L				●								0.4	9.525	3.18	-
		TPGR160308L				●								0.8	9.525	3.18	-
		TPMN110304	●				●							0.4	6.35	3.18	-
		TPMN110308	●											0.8	6.35	3.18	-
		TPMN160304	●	●			●	●						0.4	9.525	3.18	-
		TPMN160308	●	●			●	●						0.8	9.525	3.18	-
		TPMN160312	●											1.2	9.525	3.18	-
		TPMN220408						●						0.8	12.7	4.76	-
		TPMN220412							●					1.2	12.7	4.76	-
		TPGN110302					●							0.2	6.35	3.18	-
		TPGN110304	●				●		●	●				0.4	6.35	3.18	-
		TPGN110308					●			●				0.8	6.35	3.18	-
		TPGN160302					●							0.2	9.525	3.18	-
		TPGN160304	●			●	●			●				0.4	9.525	3.18	-
		TPGN160308	●			●	●			●				0.8	9.525	3.18	-
		TPGN160312									●			1.2	9.525	3.18	-
		TPGN220404						●						0.4	12.7	4.76	-

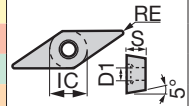
●: 产品型号

VB

35°菱形
带内冷孔
5°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
涂层硬质合金	●●●	●●●	●●●	●●●	●●●	●●●
涂层金属陶瓷	●●●	●●●	●●●	●●●	●●●	●●●
金属陶瓷	●●●	●●●	●●●	●●●	●●●	●●●



应用	断屑槽	型号	涂层硬质合金		涂层金属陶瓷	金属陶瓷		尺寸 (mm)									
			T9215	T9225	T9115	T9125	AH725	GT9530	NS9530	RE	IC	S	D1				
精加工	PSF	VBMT110302-PSF				●								0.2	6.35	3.18	2.8
		VBMT110304-PSF	●	●	▲	▲	●	●						0.4	6.35	3.18	2.8
		VBMT160402-PSF	●	●	▲	▲	●	●						0.2	9.525	4.76	4.4
		VBMT160404-PSF	●	●	▲	▲	●	●	●					0.4	9.525	4.76	4.4

●: 产品型号
▲: 停止生产

参考页: VBMT...: 外圆刀杆 → C062
内孔刀杆 → D044- 刀夹 → K193 -

刀片 正前角

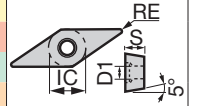
- : 连续切削
- : 轻断续切削
- ▲ : 强断续切削

VB

35°菱形
带内冷孔
5°正前角



材料	钢	不锈钢	铸铁	非铁金属	超级合金	硬材料	涂层硬质合金												涂层金属陶瓷			金属陶瓷		不涂层硬质合金		
应用	T9215	T9225	T9115	T9125	T515	T5115	AH725	SH725	SH730	J740													J9530	NS9530		TH10
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	涂层硬质合金										涂层金属陶瓷			金属陶瓷		不涂层硬质合金	尺寸 (mm)			
			T9215	T9225	T9115	T9125	T515	T5115	AH725	SH725	SH730	J740	J9530	NS9530		TH10	RE	IC	S	D1		
半精加工		24 VBMT160404-24	●	●	▲	▲									●			0.4	9.525	4.76	4.4	
		VBMT160408-24	●	●	▲	▲									●			0.8	9.525	4.76	4.4	
精加工到半精加工		CM VBMT110304-CM									●							0.4	6.35	3.18	2.8	
		VBMT110308-CM									●							0.8	6.35	3.18	2.8	
		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	
用于小型机床上车内孔 (锋利型)		JS VBGT110300FN-JS									●	●						0.03	6.35	3.18	2.8	
		VBGT110301FN-JS									●	●						<0.1	6.35	3.18	2.8	
		VBGT110302FN-JS									●	●						<0.2	6.35	3.18	2.8	
		VBGT110304FN-JS									●	●						<0.4	6.35	3.18	2.8	
用于小型机床上车内孔		JS VBGT110301N-JS								●								0.1	6.35	3.18	2.8	
		VBGT110302N-JS								●								0.2	6.35	3.18	2.8	
		VBGT110304N-JS								●								0.4	6.35	3.18	2.8	
用于小型机床上车内孔 (锋利型)		J10 VBGT110300FR-J10									●	●						0.03	6.35	3.18	2.8	
		VBGT110300FL-J10									●	●						0.03	6.35	3.18	2.8	
		VBGT110301FR-J10									●	●		●				0.1	6.35	3.18	2.8	
		VBGT110301FL-J10									●	●		●				0.1	6.35	3.18	2.8	
		VBGT110302FR-J10									●	●		●				0.2	6.35	3.18	2.8	
		VBGT110302FL-J10									●	●		●				0.2	6.35	3.18	2.8	
		VBGT110304FR-J10									●	●		●				0.4	6.35	3.18	2.8	
		VBGT110304FL-J10									●	●		●				0.4	6.35	3.18	2.8	
适用瑞士机床、走心机外圆车刀 (磨削刃口)		J10 VBGT110302R-J10													●			0.2	6.35	3.18	2.8	
		VBGT110302L-J10													●			0.2	6.35	3.18	2.8	
		VBGT110304R-J10													●			0.4	6.35	3.18	2.8	
		VBGT110304L-J10													●			0.4	6.35	3.18	2.8	

刀片 R 为负公差

- : 产品型号
- ▲ : 停止生产

参考页: 外圆刀杆 → C062 内孔刀杆 → D036 -
J系列刀杆 → G033 -

刀片 正前角

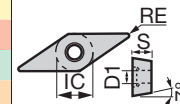
●: 连续切削
 ●: 轻断续切削
 ▲: 强断续切削

VC

35°菱形
带内冷孔
7°正前角



	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	涂层硬质合金									金属陶瓷		不涂层硬质合金		尺寸 (mm)			
			T9215	T9225	T9115	T9125	T515	T5115	AH8005	AH8015	AH905	NS9530	KS05F	RE	IC	S	D1		
精加工到半精加工		VCMT160404-24	●	●	▲	▲						●		0.4	9.525	4.76	4.4		
		VCMT160408-24	●	●	▲	▲					●			0.8	9.525	4.76	4.4		
		VCMT080204-CM						●						0.4	4.76	2.38	2.3		
		VCMT160404-CM					●	●						0.4	9.525	4.76	4.4		
		VCMT160408-CM					●	●						0.8	9.525	4.76	4.4		
		VCMT160412-CM						●						1.2	9.525	4.76	4.4		
半精加工		VCMT160404							●	●	●			0.4	9.525	4.76	4.4		
		VCMT160408								●	●	●			0.8	9.525	4.76	4.4	
		VCMT160412								●	●	●			1.2	9.525	4.76	4.4	
精加工到半精加工		VCGT160404-AL											●	0.4	9.525	4.76	4.4		
		VCGT160408-AL											●	0.8	9.525	4.76	4.4		
		VCGT160412-AL											●	1.2	9.525	4.76	4.4		
		VCGT220520-AL											●	2	12.7	5.56	5.5		
		VCGT220530-AL											●	3	12.7	5.56	5.5		

●: 产品型号
 ▲: 停止生产

刀片 正前角

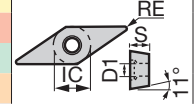
- : 连续切削
- ◐ : 轻断续切削
- ◑ : 强断续切削

VP

35°菱形
带内冷孔
11°正前角



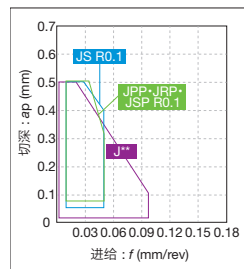
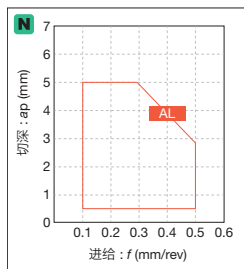
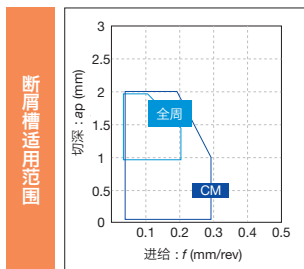
P	钢	●●●																		
M	不锈钢	●●●																		
K	铸铁																			
N	非铁金属																			
S	超级合金	●●																		
H	硬材料																			



应用	断屑槽	型号	涂层硬质合金		尺寸 (mm)						
			SH725	SH730	RE	IC	S	D1			
									●	◐	◑
用于小型机床上车内孔 (锋利刃)	JPP	VPET0802008MFR-JPP	●	●	●	●	<0.08	4.76	2.38	2.3	
		VPET0802008MFL-JPP	●	●	●	●	<0.08	4.76	2.38	2.3	
		VPET080201MFR-JPP	●	●	●	●	<0.1	4.76	2.38	2.3	
		VPET080201MFL-JPP	●	●	●	●	<0.1	4.76	2.38	2.3	
		VPET0802018MFR-JPP	●	●	●	●	<0.18	4.76	2.38	2.3	
		VPET0802018MFL-JPP	●	●	●	●	<0.18	4.76	2.38	2.3	
		VPET080202MFR-JPP	●	●	●	●	<0.2	4.76	2.38	2.3	
		VPET080202MFL-JPP	●	●	●	●	<0.2	4.76	2.38	2.3	
		VPET1103008MFR-JPP	●	●	●	●	<0.08	6.35	3.18	2.8	
		VPET1103008MFL-JPP	●	●	●	●	<0.08	6.35	3.18	2.8	
		VPET110301MFR-JPP	●	●	●	●	<0.1	6.35	3.18	2.8	
		VPET110301MFL-JPP	●	●	●	●	<0.1	6.35	3.18	2.8	
		VPET1103018MFR-JPP	●	●	●	●	<0.18	6.35	3.18	2.8	
		VPET1103018MFL-JPP	●	●	●	●	<0.18	6.35	3.18	2.8	
		VPET110302MFR-JPP	●	●	●	●	<0.2	6.35	3.18	2.8	
		VPET110302MFL-JPP	●	●	●	●	<0.2	6.35	3.18	2.8	
		JRP	VPET0802008MFR-JRP	●	●	●	●	<0.08	4.76	2.38	2.3
			VPET0802008MFL-JRP	●	●	●	●	<0.08	4.76	2.38	2.3
	VPET080201MFR-JRP		●	●	●	●	<0.1	4.76	2.38	2.3	
	VPET080201MFL-JRP		●	●	●	●	<0.1	4.76	2.38	2.3	
	VPET0802018MFR-JRP		●	●	●	●	<0.18	4.76	2.38	2.3	
	VPET0802018MFL-JRP		●	●	●	●	<0.18	4.76	2.38	2.3	
	VPET080202MFR-JRP	VPET080202MFL-JRP	●	●	●	●	<0.2	4.76	2.38	2.3	
		VPET080202MFL-JRP	●	●	●	●	<0.2	4.76	2.38	2.3	
VPET1103008MFR-JRP		●	●	●	●	<0.08	6.35	3.18	2.8		
VPET1103008MFL-JRP		●	●	●	●	<0.08	6.35	3.18	2.8		
VPET110301MFR-JRP		●	●	●	●	<0.1	6.35	3.18	2.8		
VPET110301MFL-JRP		●	●	●	●	<0.1	6.35	3.18	2.8		
VPET1103018MFR-JRP	VPET1103018MFL-JRP	●	●	●	●	<0.18	6.35	3.18	2.8		
	VPET1103018MFL-JRP	●	●	●	●	<0.18	6.35	3.18	2.8		
	VPET110302MFR-JRP	●	●	●	●	<0.2	6.35	3.18	2.8		
	VPET110302MFL-JRP	●	●	●	●	<0.2	6.35	3.18	2.8		

刀片 R 为负公差

● : 产品型号



R0.1 的槽型适用范围

参考页: VPET...: J系列刀杆 → G022 -

刀片 正前角

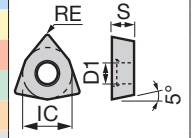
- : 连续切削
- : 轻断续切削
- : 强断续切削

WB



凸三角形, 80°
带内冷孔
5°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	涂层硬质合金		金属陶瓷		尺寸 (mm)			
			GH110	SH725 SH730	NS9530	RE	IC	S	D1	
(精加工) 刃工		W11 WBGT060102L-W11	●		●	0.2	3.97	1.59	2.3	
		WBGT060104L-W11			●	0.4	3.97	1.59	2.3	
		WBGT080202L-W11			●	0.2	4.76	2.38	2.3	
		WBGT080204L-W11			●	0.4	4.76	2.38	2.3	
用于小型机床上车		JS WBGT030101R-JS		●		<0.1	3.97	1.59	2.3	
		WBGT030101L-JS		●		<0.1	3.97	1.59	2.3	
		WBGT030102R-JS		●		<0.2	3.97	1.59	2.3	
		WBGT030102L-JS		●		<0.2	3.97	1.59	2.3	
		WBGT030104R-JS		●		<0.4	3.97	1.59	2.3	
		WBGT030104L-JS		●		<0.4	3.97	1.59	2.3	
用于小型机床上车内孔 (锋利型)		JS WBGT030101FL-JS	●			<0.1	3.97	1.59	2.3	
		WBGT030101FR-JS	●			<0.1	3.97	1.59	2.3	
		WBGT030102FL-JS	●			<0.2	3.97	1.59	2.3	
		WBGT030102FR-JS	●			<0.2	3.97	1.59	2.3	
		WBGT030104FL-JS	●			<0.4	3.97	1.59	2.3	
		WBGT030104FR-JS	●			<0.4	3.97	1.59	2.3	

刀尖 R 为负公差

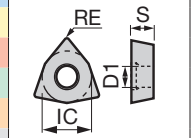
刀片 正前角双面

WX



凸三角形, 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	断屑槽	型号	涂层硬质合金		尺寸 (mm)			
			AH725	SH725	RE	IC	S	D1
精加工到半精加工 (锋利刃)		JS WXGU040301MFR-JS ⁽¹⁾	●		<0.1	6.35	3.18	2.7
		WXGU040301MFL-JS ⁽¹⁾	●		<0.1	6.35	3.18	2.7
		WXGU040302MFR-JS ⁽¹⁾	●		<0.2	6.35	3.18	2.7
		WXGU040302MFL-JS ⁽¹⁾	●		<0.2	6.35	3.18	2.7
		WXGU040304MFR-JS ⁽¹⁾	●		<0.4	6.35	3.18	2.7
		WXGU040304MFL-JS ⁽¹⁾	●		<0.4	6.35	3.18	2.7
精加工到半精加工		JTS WXGU040301MFR-JTS	●		<0.1	6.35	3.18	2.7
		WXGU040301MFL-JTS	●		<0.1	6.35	3.18	2.7
		WXGU040302MFR-JTS	●		<0.2	6.35	3.18	2.7
		WXGU040302MFL-JTS	●		<0.2	6.35	3.18	2.7
精加工到半精加工		JTS WXGU040301MR-JTS	●		<0.1	6.35	3.18	2.7
		WXGU040301ML-JTS	●		<0.1	6.35	3.18	2.7
		WXGU040302MR-JTS	●		<0.2	6.35	3.18	2.7
		WXGU040302ML-JTS	●		<0.2	6.35	3.18	2.7

刀尖 R 为负公差。(1) 因为断屑槽形状, 端面或内孔车削的最大切深是 1 mm。

● : 产品型号

参考页: WBGT...: 内孔刀杆 → **D075**
WXGU...: 外圆刀杆 → **C031-**, 内孔刀杆 → **D028**

刀片 正前角

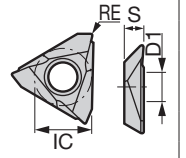
- : 连续切削
- ◐: 轻断续切削
- ◑: 强断续切削

JTB*



背车刀片

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



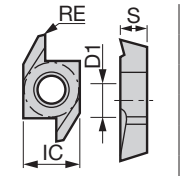
应用	断屑槽	型号	涂层				尺寸 (mm)					
			涂层硬质合金	涂层金属陶瓷	金属陶瓷	不涂层硬质合金	RE	IC	S	D1		
背车刀片			SH725	J740	J9530	NS9530	TH10					
		-	JTBR3000F	●	●			●	0.03	9.5	3.18	4.4
			JTBL3000F	●	●			●	0.03	9.5	3.18	4.4
			JTBR3005F	●	●			●	0.05	9.5	3.18	4.4
			JTBL3005F	●	●			●	0.05	9.5	3.18	4.4
			JTBR3005		●				0.05	9.5	3.18	4.4
			JTBL3005		●				0.05	9.5	3.18	4.4
			JTBR3010F	●	●		●	●	0.10	9.5	3.18	4.4
			JTBL3010F	●	●		●	●	0.10	9.5	3.18	4.4
			JTBR3010		●				0.10	9.5	3.18	4.4
			JTBL3010		●				0.10	9.5	3.18	4.4
			JTBR3015F	●	●				0.15	9.5	3.18	4.4
			JTBL3015F	●					0.15	9.5	3.18	4.4

J10E*



背车刀片

	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				尺寸 (mm)					
			涂层硬质合金	涂层金属陶瓷	金属陶瓷	不涂层硬质合金	RE	IC	S	D1		
背车刀片			SH725	J740	J9530	NS9530	TH10					
		-	J10ER005BF	●	●		●	●	0.05	6.35	3.18	3.0
			J10EL005BF	●	●			●	0.05	6.35	3.18	3.0
			J10ER005B		●				0.05	6.35	3.18	3.0
			J10EL005B		●				0.05	6.35	3.18	3.0
			J10ER010BF	●	●		●	●	0.10	6.35	3.18	3.0
			J10EL010BF	●	●			●	0.10	6.35	3.18	3.0
			J10ER010B		●				0.10	6.35	3.18	3.0
			J10EL010B		●				0.10	6.35	3.18	3.0
			J10EL015BF	●					0.15	6.35	3.18	3.0
	J10ER015BF	●					0.15	6.35	3.18	3.0		

●: 产品型号

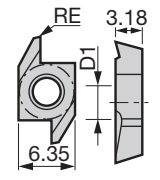
参考页: JTB...: J系列刀杆 → G048 J10E...: J系列刀杆 → G050

刀片 正前角

- : 连续切削
- : 轻断续切削
- *: 强断续切削

10E*
背车刀片

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

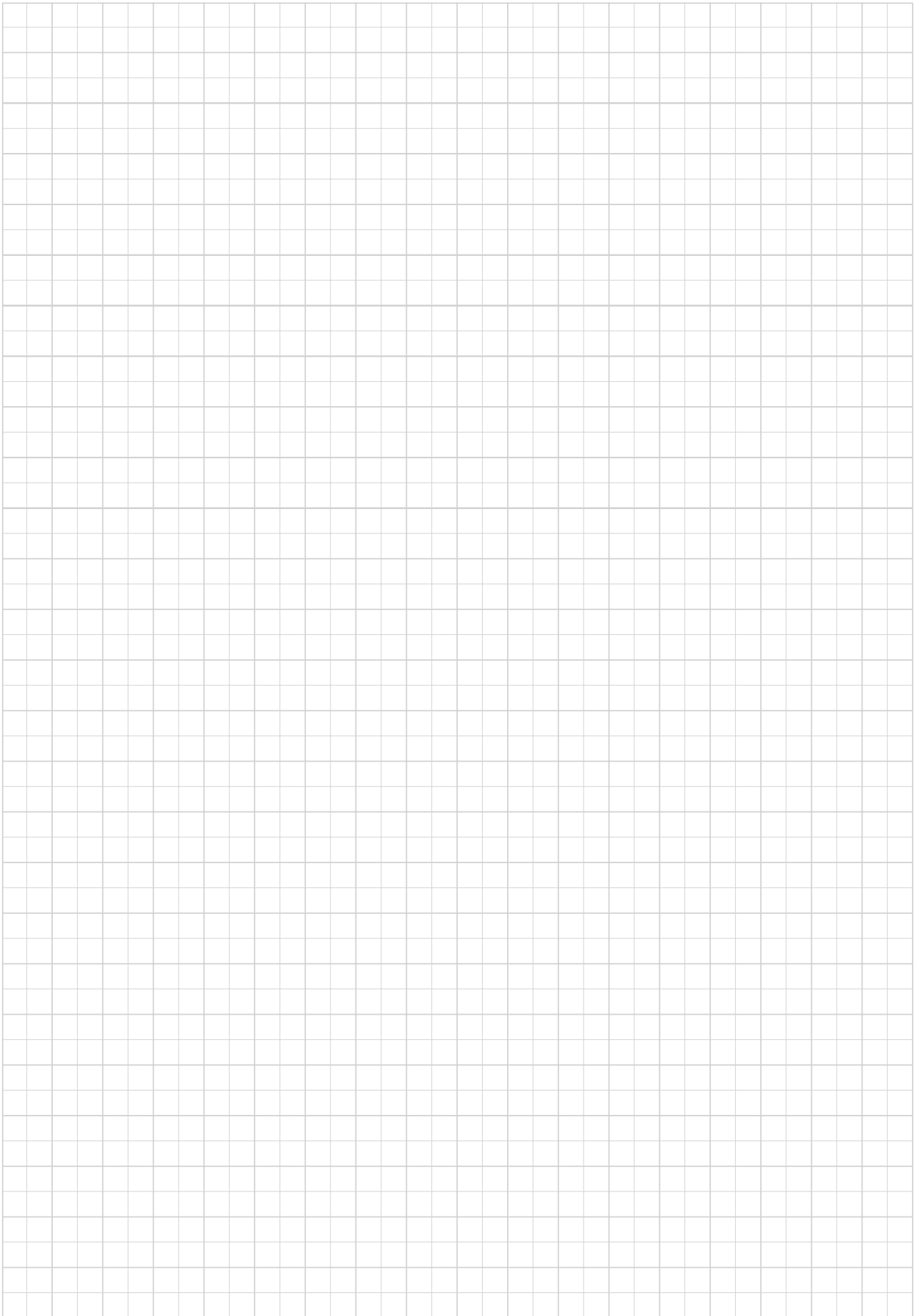


应用	断屑槽	型号	不涂层硬质合金															尺寸 (mm)			
			TH10																RE	IC	S
背车刀片	-	10ER100B	●															0.03	6.35	3.18	3.0
		10EL100B	●															0.03	6.35	3.18	3.0
		10ER150B	●															0.03	6.35	3.18	3.0
		10EL150B	●															0.03	6.35	3.18	3.0
		10ER300	●															-	6.35	3.18	3.0
		10EL300	●															-	6.35	3.18	3.0

●: 产品型号

- Grade A
- Insert B
- Toolholder C
- Toolholder D
- Threading E
- Grooving F
- Miniature tool G
- Milling cutter H
- Endmill I
- Drilling tool J
- Tooling System K
- User's Guide L
- Index M

备忘



BXA20

用于加工淬火钢的涂层CBN



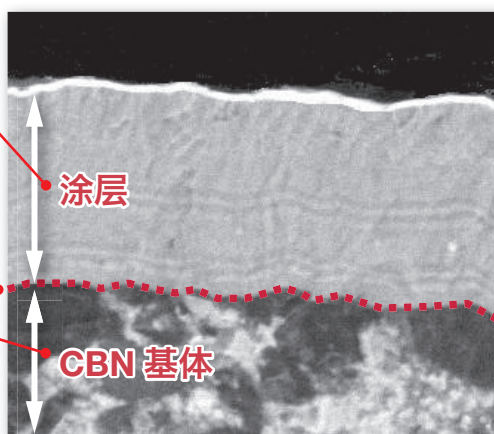
在淬火钢的加工中，有很高的可靠性

适用于低速和中速切削
覆盖宽广的加工范围，从连续切削到强断续加工均可使用。

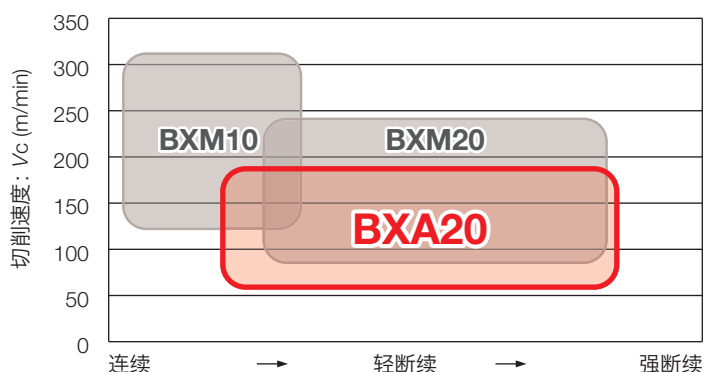
多层涂层
比普通涂层厚 2 倍
拥有非常好的耐磨性

提高粘附强度
该涂层有非常好的抗剥落性，
可达到非常高的表面精度

**新开发的 CBN 基体，
具有独特的粘接力**
经优化的 CBN 材质拥有非常高的
耐磨性和非常好的韧性



应用领域



BXM10
适用于高速加工状态下的连续加工和轻断续加工

BXM20
广泛适用在中、高速加工中

BXA20
在中低速加工中极佳的稳定性

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

孔加工刀具

工具系统

用户指南

索引

T-CBN SERIES

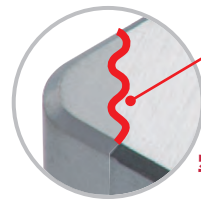
波状焊接



用于高效淬火钢加工

提高加工效率的钎焊新技术 – “波状焊接”

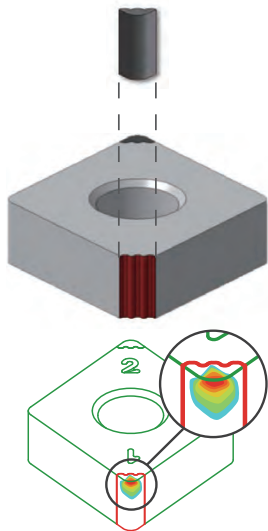
最大切割深度可达 0.8 mm 减少切削次数，以提高生产率



“波状”的接触面提高了钎焊强度。

牢固连接

WavyJoint BXA20



Vs.

CBN 刀尖尺寸：

使用含量高达 **200%** 的立方氮化硼刀尖，可以增加导热系数，并有助于降低切削温度。

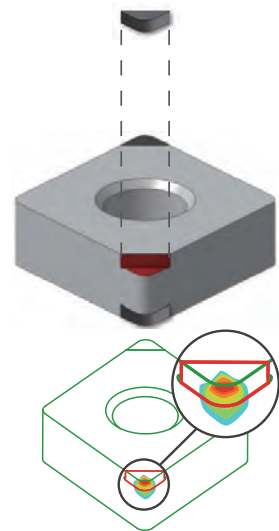
钎焊面积：

提高 **160%** 的钎焊强度

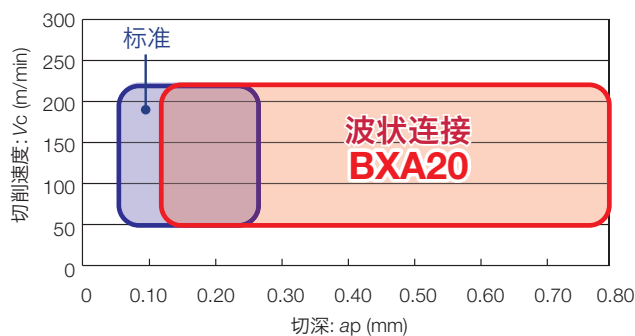
加工时温度集中在 CBN 刀尖位置，减少了钎焊区域温度的问题。

工件材料 : SCM420 / 20CrMo4 (60HRC)
切削速度 : $V_c = 150$ m/min
进给量 : $f_z = 0.20$ mm/rev
切深 : $a_p = 0.75$ mm
冷却方式 : 干式

标准



应用领域 硬车



H

WavyJoint BXA20

在低速到中等速度的连续切削到重型断续切削中拥有强大的性能。

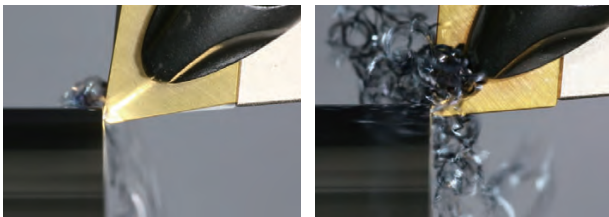
T-CBN SERIES - GNGA 类型 CBN



用于淬火钢、铸铁和烧结金属的高效加工

■ 端面车削的有效切屑控制

连续切削



GNGA 类型
夹角：70°

CNGA 类型
夹角：80°

由于 GNGA 型刀片有足够的空间供切屑流动，不会发生切屑堆积，提高了表面光洁度，防止了切削过程中的切屑堆积。可使用 CNGA1204 现有标准刀柄。

断续切削



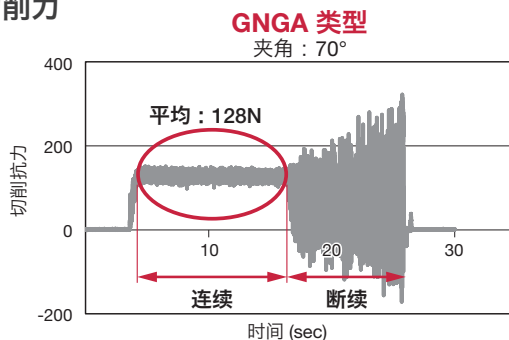
GNGA 类型
夹角：70°

CNGA 类型
夹角：80°

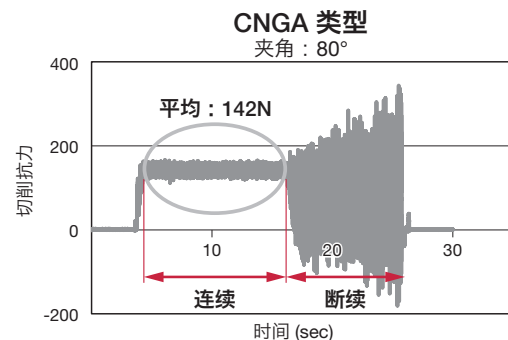
H 刀杆 : ACLNL2525M12-A
刀片 : 2QP-GNGA120408 BXM20
2QP-CNGA120408 BXM20
工件材料 : SCM420 / 18CrMo4 (60HRC)
切削速度 : $V_c = 150$ m/min
进给量 : $f = 0.10$ mm/rev
切深 : $a_p = 0.125$ mm
加工 : 端面切削
冷却方式 : 干式

■ 切削性能

切削力



GNGA 型与常规 CNGA 型相比，间隙大，切削力小。



H 刀杆 : ACLNL2525M12-A
刀片 : 2QP-GNGA120408 BXM20
2QP-CNGA120408 BXM20
工件材料 : SCM420 / 18CrMo4 (59HRC)
切削速度 : $V_c = 150$ m/min
进给量 : $f = 0.15$ mm/rev
切深 : $a_p = 0.125$ mm
加工 : 端面切削
冷却方式 : 干式

材质

刀片

外圆刀杆

内孔刀杆

螺纹加工

槽加工

小零件刀具

铣刀

立铣刀

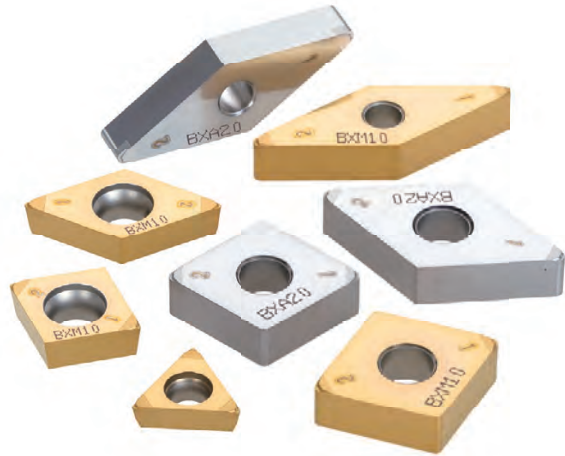
孔加工刀具

工具系统

用户指南

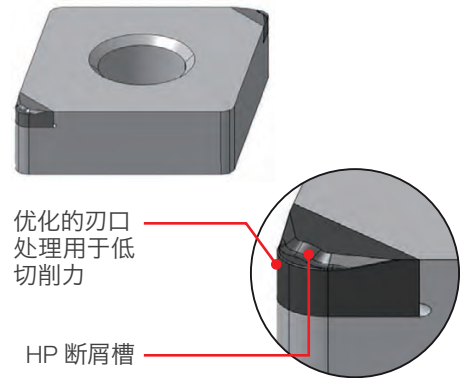
索引

HARDBREAKER HP



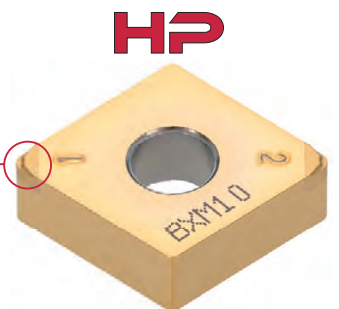
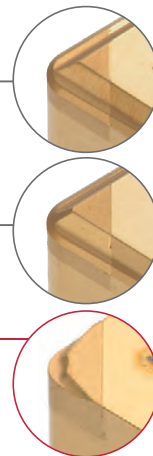
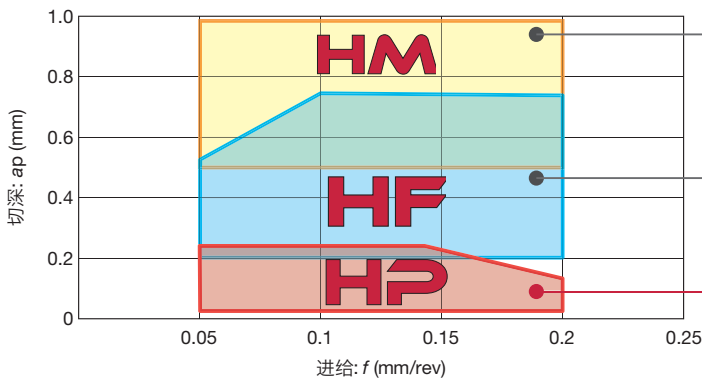
新型 HP 断屑槽 用于淬火钢精加工

- 1 通过把断屑槽和刀尖分离，大幅减少了加工时施加在刀尖上的切削力，从而延长了刀具寿命。
- 2 刃口处理的设计确保低切削力下轻松切削，同时保证较小的公差范围。
- 3 HP 型断屑槽结合修光刃设计，实现优异的表面质量和良好的切屑控制。

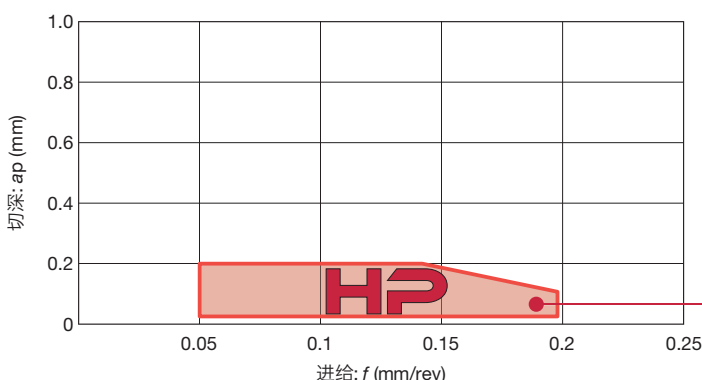


应用领域

对于负角刀片



对于正角刀片



T-CBN (PCBN) 刀片表示规则

多刀尖型

2 **QP** - **CNGA120404** **-L**

1 刀尖数	2 型	3 ISO标准	4 特殊功能及断屑器	
	QP CBN刀片		无	标准刃口处理
	QS 波状焊接		F	锋利刃
			-L	较小的钝化角度, 重视耐磨性
			-LF	后刀面耐磨性优先
			-LC	前刀面耐磨性优先
			-H	注重抗崩损性
			W	带修光刃
			W□	弧形修光刃刀片
			-HF	带断屑槽
			-HM	带断屑槽
			-HP	带断屑槽

多刀尖型10片包装

T **2** **QP** - **CNGA120408**

1 “T”是指每包10件

一般车削

TNGA160402 - **QBN**

1 ISO标准

2 CBN刀片

T-CBN (PCBN) 刀片是切槽刀片

XG **R** **63** **10** **S** - **QBN**

1 切槽刀具 GX-类型	2 刀片方向	3 切槽宽度 (mm)	4 刀尖R RE (mm)	5 CBN刀片
	L 左手	10 1.0	S 0.2	
	R 右手	15 1.5		

用于 TUNG CUT

S **G** **N** **200** - **020**

1 刀尖数	2 应用	3 特定设计	4 切槽宽度 (mm)	5 刀尖R RE (mm)
S 单一刀头	G 切槽	N 没有断屑槽	200 2.0	020 0.2

T-DIA (PCD) 刀片表示规则

车削刀片

TPGW110204 - **DIA**

1 ISO标准

2 PCD镶嵌

材质
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引



CBN 刀片 负前角

- : 连续切削
- : 轻断续切削
- *: 强断续切削

形状	型号	尺寸 (mm)									研磨					修光刃	断屑槽								
		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX380	BX470	BX480	BX930	刀尖数量	LE	RE	IC			S	D1	标准	锋利刃	L	LF	LC	H
		P		M		K		N		S		H		其它				其它		其它		其它		其它	
	2QP-CNGA	2QP-CNGA120404	●	●	●	●	●	●	●	●	●	2	2.3	0.4	12.7	4.76	5.16	○							
		2QP-CNGA120408	●	●	●	●	●	●	●	●	●	2	2.2	0.8	12.7	4.76	5.16	○							
		2QP-CNGA120412	●	●	●	●	●	●	●	●	●	2	2.4	1.2	12.7	4.76	5.16	○							
		2QP-CNGA120416		●								2	3.3	1.6	12.7	4.76	5.16	○							
		2QP-CNGA120420		●								2	3.2	2.0	12.7	4.76	5.16	○							
		2QP-CNGA120424		●								2	3.1	2.4	12.7	4.76	5.16	○							
	T2QP-CNGA	T2QP-CNGA120404								●	2	2.3	0.4	12.7	4.76	5.16	○								
		T2QP-CNGA120408								●	2	2.2	0.8	12.7	4.76	5.16	○								
	2QP-CNGA**F	2QP-CNGA120404F									●	2	2.3	0.4	12.7	4.76	5.16	○							
		2QP-CNGA120408F									●	2	2.2	0.8	12.7	4.76	5.16	○							
	2QP-CNGA**-L	2QP-CNGA120404-L	●	●	●		●				2	2.3	0.4	12.7	4.76	5.16		○							
		2QP-CNGA120408-L	●	●	●		●				2	2.2	0.8	12.7	4.76	5.16		○							
		2QP-CNGA120412-L	●	●	●		●				2	2.4	1.2	12.7	4.76	5.16		○							
	2QP-CNGA**-LF	2QP-CNGA120404-LF			●						2	2.3	0.4	12.7	4.76	5.16				○					
		2QP-CNGA120408-LF			●						2	2.2	0.8	12.7	4.76	5.16				○					
		2QP-CNGA120412-LF			●						2	2.4	1.2	12.7	4.76	5.16				○					
	2QP-CNGA**-LC	2QP-CNGA120404-LC			●						2	2.3	0.4	12.7	4.76	5.16					○				
		2QP-CNGA120408-LC			●						2	2.2	0.8	12.7	4.76	5.16					○				
		2QP-CNGA120412-LC			●						2	2.4	1.2	12.7	4.76	5.16					○				
	2QP-CNGA**-H	2QP-CNGA120404-H		●	●		●	●			2	2.3	0.4	12.7	4.76	5.16							○		
		2QP-CNGA120408-H		●	●		●	●			2	2.2	0.8	12.7	4.76	5.16							○		
		2QP-CNGA120412-H		●	●		●	●			2	2.4	1.2	12.7	4.76	5.16							○		
	2QP-CNGA**WL	2QP-CNGA120404WL	●	●	●						2	2.3	0.4	12.7	4.76	5.16								○	
		2QP-CNGA120408WL	●	●	●						2	2.2	0.8	12.7	4.76	5.16								○	
		2QP-CNGA120412WL	●	●	●						2	2.4	1.2	12.7	4.76	5.16								○	
	2QP-CNMA**W	2QP-CNMA120404W						●			2	2.3	0.4	12.7	4.76	5.16								○	
		2QP-CNMA120408W						●			2	2.2	0.8	12.7	4.76	5.16								○	
		2QP-CNMA120412W						●			2	2.4	1.2	12.7	4.76	5.16								○	

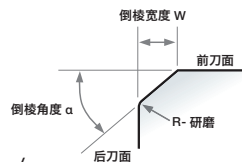
修光刃刀具请参阅 B199

在刀片型号结尾插入 W、WL、WJ 的名称。

●: 产品型号

研磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-



S 0 1 3 2 5

形状: T... 倒角倒棱, S... 倒角+R-研磨, E... 仅R-研磨, F... 锋利刃










研磨宽度: 3 2 5

研磨角度: a

CBN 刀片 负前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

材质
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引

形状	型号	材料						尺寸 (mm)					刃磨					修光刃	断屑槽			
		P	M	K	N	S	H	刀尖数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF			LC	H	
	2QP-CNGM120408-HF							2	2.2	0.8	12.7	4.76	5.16								○	
	2QP-CNGM120412-HF							2	2.4	1.2	12.7	4.76	5.16								○	
	2QP-CNGM120408-HM						●	2	2.2	0.8	12.7	4.76	5.16								○	
	2QP-CNGM120412-HM						●	2	2.4	1.2	12.7	4.76	5.16								○	
	2QP-CNGM120404-HP						●	2	2.3	0.4	12.7	4.76	5.16								○	
	2QP-CNGM120408-HP						●	2	2.2	0.8	12.7	4.76	5.16									○
	2QP-CNGM120412-HP						●	2	2.4	1.2	12.7	4.76	5.16									○
	2QP-CNGM120408WL-HP						●	2	2.2	0.8	12.7	4.76	5.16								○	
	4QP-CNGA120404						●	4	2.3	0.4	12.7	4.76	5.16	○								
	4QP-CNGA120408						●	4	2.2	0.8	12.7	4.76	5.16	○								
	4QP-CNGA120412						●	4	2.4	1.2	12.7	4.76	5.16	○								
	4QP-CNMA120404W						●	4	2.3	0.4	12.7	4.76	5.16								○	
	4QP-CNMA120408W						●	4	2.2	0.8	12.7	4.76	5.16								○	
	4QP-CNMA120412W						●	4	2.4	1.2	12.7	4.76	5.16								○	
	4QS-CNGA120408						●	4	2.2	0.8	12.7	4.76	5.16	○								
	4QS-CNGA120412						●	4	2.4	1.2	12.7	4.76	5.16	○								
	4QS-CNGA120408-H						●	4	1.5	0.8	12.7	4.76	5.16								○	
	4QS-CNGA120412-H						●	4	1.7	1.2	12.7	4.76	5.16								○	
	4QS-CNGG120408-HM						●	4	1.5	0.8	12.7	4.76	5.16								○	
	4QS-CNGG120412-HM						●	4	1.7	1.2	12.7	4.76	5.16								○	
	CNGA120402-QBN						●	1	4.1	0.2	12.7	4.76	5.16	○								
	CNGA120404-QBN						●	1	4.0	0.4	12.7	4.76	5.16	○								
	CNGA120408-QBN						●	1	3.9	0.8	12.7	4.76	5.16	○								
	CNGA120412-QBN						●	1	3.9	1.2	12.7	4.76	5.16	○								
	S-CNGN090308						●	4	-	0.8	9.525	3.18	-	○								
	S-CNGN090312						●	4	-	1.2	9.525	3.18	-	○								
	S-CNGN120408						●	4	-	0.8	12.7	4.76	-	○								
	S-CNGN120412						●	4	-	1.2	12.7	4.76	-	○								

请参阅 B199 页, 关于 W, WL, WJ 的使用

●: 产品型号

参考页: 外圆刀杆 → C018 - 内孔刀杆 → D023 -
 J系列刀杆 → G044 TungCap系列 → K008 -
 PINZBOHR®系列 → K180 - 刀夹 → K199 -

CBN 刀片 负前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

材质
刀片
外圆刀杆
内孔刀杆
螺旋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引

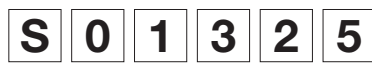
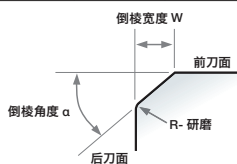
形状	型号	材料适用性					尺寸 (mm)					刃磨										
		P	M	K	N	S	H	刀片数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC	H	修光刃	断屑槽	
	2QP-DNGM**-* 2QP-DNGM150408-HF	●	●	●	●	●	●	2	2.1	0.8	12.7	4.76	5.16								○	
	2QP-DNGM150412-HF	●	●	●	●	●	●	2	2.0	1.2	12.7	4.76	5.16								○	
	2QP-DNGM150408-HM	●	●	●	●	●	●	2	2.1	0.8	12.7	4.76	5.16								○	
	2QP-DNGM150412-HM	●	●	●	●	●	●	2	2.0	1.2	12.7	4.76	5.16								○	
	2QP-DNGM150404-HP	●	●	●	●	●	●	2	2.5	0.4	12.7	4.76	5.16								○	
	2QP-DNGM150408-HP	●	●	●	●	●	●	2	2.1	0.8	12.7	4.76	5.16									○
	2QP-DNGM150608-HP	●	●	●	●	●	●	2	2.1	0.8	12.7	6.35	5.16									○
	4QP-DNGA 4QP-DNGA150404							4	2.5	0.4	12.7	4.76	5.16	○								
	4QP-DNGA150408							4	2.1	0.8	12.7	4.76	5.16	○								
	4QP-DNGA150412							4	2.0	1.2	12.7	4.76	5.16	○								
	4QS-DNGA 4QS-DNGA150408			●				4	2.1	0.8	12.7	4.76	5.16	○								
	4QS-DNGA150412			●				4	2.0	1.2	12.7	4.76	5.16	○								
	4QS-DNGA**-* 4QS-DNGA150408-H			●				4	1.6	0.8	12.7	4.76	5.16								○	
	4QS-DNGA150412-H			●				4	1.6	1.2	12.7	4.76	5.16								○	
	4QS-DNGG**-* 4QS-DNGG150408-HM			●				4	1.6	0.8	12.7	4.76	5.16								○	
	DNGA**-* DNGA150402-QBN							1	4.3	0.2	12.7	4.76	5.16	○								
	DNGA150404-QBN							1	4.1	0.4	12.7	4.76	5.16	○								
	DNGA150408-QBN							1	3.8	0.8	12.7	4.76	5.16	○								
	DNGA150412-QBN							1	3.4	1.2	12.7	4.76	5.16	○								

请参阅 B195 页关于 W, WL 使用

●: 产品型号

刃磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-



形状
T ... 倒角倒棱
S ... 倒角 + R-研磨
E ... 仅 R-研磨
F ... 锋利刃

参考页: 内孔刀杆 → D052 -

CBN 刀片 负前角

●: 连续切削
●: 轻断续切削
* : 强断续切削

形状	型号	尺寸 (mm)						珩磨					修光刃	断屑槽							
		BXM10	BXM20	BXA20	BX360	BX470	BX930	刀尖数量	LE	RE	IC	S			D1	标准	锋利刃	L	LF	LC	H
	*2QP-GNGA120404	●	●	●	●	●	2	2.1	0.4	12.7	4.76	5.16	○								
	*2QP-GNGA120408	●	●	●	●	●	2	2.1	0.8	12.7	4.76	5.16	○								
	*2QP-GNGA120412	●	●	●	●	●	2	2.2	1.2	12.7	4.76	5.16	○								
	*2QP-GNGA120404-L		●				2	2.1	0.4	12.7	4.76	5.16		○							
	*2QP-GNGA120408-L		●				2	2.1	0.8	12.7	4.76	5.16		○							
	*2QP-GNGA120412-L		●				2	2.2	1.2	12.7	4.76	5.16		○							
	*2QP-GNGA120404-LF		●				2	2.1	0.4	12.7	4.76	5.16			○						
	*2QP-GNGA120408-LF		●				2	2.1	0.8	12.7	4.76	5.16			○						
	*2QP-GNGA120412-LF		●				2	2.2	1.2	12.7	4.76	5.16			○						
	*2QP-GNGA120404-LC		●				2	2.1	0.4	12.7	4.76	5.16					○				
	*2QP-GNGA120408-LC		●				2	2.1	0.8	12.7	4.76	5.16					○				
	*2QP-GNGA120412-LC		●				2	2.2	1.2	12.7	4.76	5.16					○				
	*2QP-GNGA120404-H		●				2	2.1	0.4	12.7	4.76	5.16							○		
	*2QP-GNGA120408-H		●				2	2.1	0.8	12.7	4.76	5.16							○		
	*2QP-GNGA120412-H		●				2	2.2	1.2	12.7	4.76	5.16							○		
	*2QP-GNGG120404-HP	●	●				2	2.1	0.4	12.7	4.76	5.16								○	
	*2QP-GNGG120408-HP	●	●				2	2.1	0.8	12.7	4.76	5.16								○	
	*2QP-GNGG120412-HP	●	●				2	2.2	1.2	12.7	4.76	5.16								○	

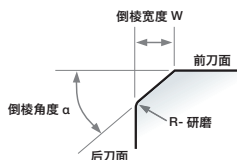
*泰珂洛标准

形状	型号	尺寸 (mm)						珩磨					修光刃	断屑槽					
		BXC90	刀尖数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF			LC	H			
																	LE	RE	IC
	S-RNGN090300	●	-	-	-	9.525	3.18	-	○										
	S-RNGN120400	●	-	-	-	12.7	4.76	-	○										

●: 产品型号

珩磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-










形状
T... 倒角倒棱
S... 倒角+R-珩磨
E... 仅R-珩磨
F... 锋利刃

CBN 刀片 负前角

●: 连续切削
●: 轻断续切削
* : 强断续切削

材质
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引

形状	型号	材料										尺寸 (mm)					珩磨					修光刃	断屑槽			
		P	M	K	N	S	H	●	●	●	●	●	刀尖数量	LE	RE	IC	S	D1	标准	锋利刃	L			LF	LC	H
		●	●	●	●	●	●	●	●	●	●	●														
	2QP-SNGA 2QP-SNGA120404	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	○								
	2QP-SNGA120408	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	○								
	2QP-SNGA120412	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	○								
	2QP-SNGA**-L 2QP-SNGA120404-L				●													○								
	2QP-SNGA120408-L	●	●		●													○								
	2QP-SNGA120412-L	●	●		●													○								
2QP-SNGA**-LF	2QP-SNGA120408-LF		●																○							
	2QP-SNGA120412-LF		●																○							
	2QP-SNGA**-H 2QP-SNGA120404-H					●	●																○			
	2QP-SNGA120408-H	●	●		●	●																	○			
	2QP-SNGA120412-H	●	●		●	●																	○			
	4QP-SNGA 4QP-SNGA120404			●														○								
	4QP-SNGA120408			●															○							
	4QP-SNGA120412			●															○							
	SNGA**-QBN SNGA120402-QBN					●												○								
	SNGA120404-QBN					●													○							
	SNGA120408-QBN					●													○							
	SNGA120412-QBN					●													○							
	2QP-SNGN 2QP-SNGN090308												●					○								
	2QP-SNGN090312												●						○							
	S-SNGN S-SNGN090308												●					○								
	S-SNGN090312												●						○							
	S-SNGN120308												●						○							
	S-SNGN120312												●						○							
	S-SNGN120408												●						○							
	S-SNGN120412											●						○								

●: 产品型号

参考页: 外圆刀杆 → C093 - 内孔刀杆 → D040 -
刀夹 → K197 -

CBN 刀片 负前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

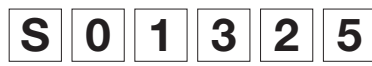
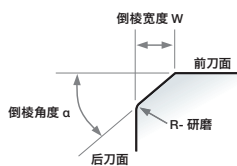
材质
刀片
外圆刀杆
内孔刀杆
螺旋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引

形状	型号	材料适用性				尺寸 (mm)						研磨									
		P	M	K	N	S	H	刀尖数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC	H	修光刃	断屑槽
	6QP-TNGA160404							6	2.2	0.4	9.525	4.76	3.81	○							
	6QP-TNGA160408							6	1.9	0.8	9.525	4.76	3.81	○							
	6QP-TNGA160412							6	2.4	1.2	9.525	4.76	3.81	○							
	6QS-TNGA160408							6	1.9	0.8	9.525	4.76	3.81	○							
	6QS-TNGA160412							6	2.4	1.2	9.525	4.76	3.81	○							
	6QS-TNGA160408-H							6	1.6	0.8	9.525	4.76	3.81							○	
	6QS-TNGA160412-H							6	1.8	1.2	9.525	4.76	3.81							○	
	6QS-TNGG160408-HM							6	1.6	0.8	9.525	4.76	3.81								○
	6QS-TNGG160412-HM							6	1.8	1.2	9.525	4.76	3.81								○
	TNGA160402-QBN							1	4.4	0.2	9.525	4.76	3.81	○							
	TNGA160404-QBN							1	4.2	0.4	9.525	4.76	3.81	○							
	TNGA160408-QBN							1	4.0	0.8	9.525	4.76	3.81	○							
	TNGA160412-QBN							1	3.7	1.2	9.525	4.76	3.81	○							
	S-TNGN110308							6	-	0.8	6.35	3.18	-	○							
	S-TNGN110312							6	-	1.2	6.35	3.18	-	○							
	S-TNGN160408							6	-	0.8	9.525	4.76	-	○							
	S-TNGN160412							6	-	1.2	9.525	4.76	-	○							

●: 产品型号

研磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-



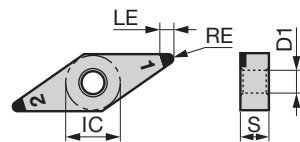
形状
T... 倒角倒棱
S... 倒角+R-研磨
E... 仅R-研磨
F... 锋利刃










参考页: 外圆刀杆 → C115 - 内孔刀杆 → D046 -
J系列刀杆 → G047 - TungCap系列 → K014 -
刀夹 → K193 -

CBN 刀片 负前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

P	钢																			
M	不锈钢																			
K	铸铁														●	●	●			
N	非铁金属																			
S	超级合金																			
H	硬材料	●	●	●	●	✱	●	●	●	●	✱									
	烧结金属														●	●	●	✱		



形状	型号	尺寸 (mm)											研磨					修光刃	断屑槽						
		BXM10	BXM20	BXA20	BXC50	BX310	BX330	BX360	BX380	BX470	BX480	BX930	刀尖数量	LE	RE	IC	S			D1	标准	锋利刃	L	LF	LC
	2QP-VNGA 2QP-VNGA160404	●	●	●		●	●	●	●	●	●		2	3.1	0.4	9.525	4.76	3.81	○						
	2QP-VNGA160408	●	●	●		●	●	●	●	●	●		2	2.2	0.8	9.525	4.76	3.81	○						
	2QP-VNGA160412			●									2	3.0	1.2	9.525	4.76	3.81	○						
	2QP-VNGA**-L 2QP-VNGA160404-L	●	●	●			●					2	3.1	0.4	9.525	4.76	3.81		○						
	2QP-VNGA160408-L	●	●	●			●					2	2.2	0.8	9.525	4.76	3.81		○						
	2QP-VNGA160412-L			●								2	3.0	1.2	9.525	4.76	3.81		○						
	2QP-VNGA**-LF 2QP-VNGA160404-LF			●								2	3.1	0.4	9.525	4.76	3.81			○					
	2QP-VNGA160408-LF			●								2	2.2	0.8	9.525	4.76	3.81			○					
	2QP-VNGA160412-LF			●								2	3.0	1.2	9.525	4.76	3.81			○					
	2QP-VNGA**-LC 2QP-VNGA160404-LC			●								2	3.1	0.4	9.525	4.76	3.81				○				
	2QP-VNGA160408-LC			●								2	2.2	0.8	9.525	4.76	3.81				○				
	2QP-VNGA160412-LC			●								2	3.0	1.2	9.525	4.76	3.81				○				
	2QP-VNGA**-H 2QP-VNGA160404-H		●	●				●	●			2	3.1	0.4	9.525	4.76	3.81					○			
	2QP-VNGA160408-H		●	●				●	●			2	2.2	0.8	9.525	4.76	3.81					○			
	2QP-VNGA160412-H			●								2	3.0	1.2	9.525	4.76	3.81					○			
	2QP-VNGM**-H* 2QP-VNGM160408-HF		●									2	2.2	0.8	9.525	4.76	3.81							○	
	2QP-VNGM160408-HM		●									2	2.4	0.8	9.525	4.76	3.81							○	
	2QP-VNGM160408-HP	●	●									2	2.2	0.8	9.525	4.76	3.81							○	
	4QP-VNGA 4QP-VNGA160404				●							4	3.1	0.4	9.525	4.76	3.81	○							
	4QP-VNGA160408				●							4	2.2	0.8	9.525	4.76	3.81	○							
	4QS-VNGA 4QS-VNGA160408			●								4	1.7	0.8	9.525	4.76	3.81	○							
	4QS-VNGA**-H 4QS-VNGA160408-H			●								4	1.7	0.8	9.525	4.76	3.81					○			
	4QS-VNGG**-HM 4QS-VNGG160408-HM			●								4	1.7	0.8	9.525	4.76	3.81							○	

●: 产品型号

参考页: 外圆刀杆 → C059 - 内孔刀杆 → D070 -
TungCap系列 → K015 -

CBN 刀片 负前角

- : 连续切削
- : 轻断续切削
- ✱: 强断续切削

材质
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系統
用戶指南
索引

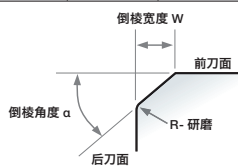
形状	型号	尺寸 (mm)								珩磨																
		BXM10	BXM20	BXA20	BXC50	BX310	BX330	BX360	BX380	BX480	BX930	刀片数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC	H	修光刃	断屑槽	
	3QP-WNGA080404			●							3	2.3	0.4	12.7	4.76	5.16	○									
	3QP-WNGA080408	●	●	●		●	●	●	●	●	3	2.2	0.8	12.7	4.76	5.16	○									
	3QP-WNGA080412			●							3	2.4	1.2	12.7	4.76	5.16	○									
	3QP-WNGA080408-L			●							3	2.2	0.8	12.7	4.76	5.16		○								
	3QP-WNGA080408-LF			●							3	2.2	0.8	12.7	4.76	5.16			○							
	3QP-WNGA080408-H			●							3	2.2	0.8	12.7	4.76	5.16								○		
	3QP-WNGA080408WL	●	●	●							3	2.2	0.8	12.7	4.76	5.16	○									○
	6QP-WNGA080404				●						6	2.3	0.4	12.7	4.76	5.16	○									
	6QP-WNGA080408			●							6	2.2	0.8	12.7	4.76	5.16	○									
	6QS-WNGA080408			●							6	1.5	0.8	12.7	4.76	5.16	○									
	6QS-WNGA080408-H			●							6	1.5	0.8	12.7	4.76	5.16								○		

请参阅 B199 页关于使用 WL 使用

●: 产品型号

珩磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-











S	0	1	3	2	5
形状		珩磨宽度		珩磨角度: a	
T... 倒角倒棱 S... 倒角+R-研磨 E... 仅R-研磨 F... 锋利刃					

参考页: 外圆刀杆 → C034 - 内孔刀杆 → D031 -
TungCap系列 → C035 -, K011 -

CBN 刀片 正前角

●: 连续切削
●: 轻断续切削
* : 强断续切削

形状	型号	材料								尺寸 (mm)					刃磨					修光刃	断屑槽						
		P	M	K	N	S	H	其它	其它	其它	其它	其它	其它	其它	其它	其它	其它	其它	其它								
		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX930	刀尖数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC	H					
	2QP-CCGW 2QP-CCGW060202	●	●					●	●		2	2.3	0.2	6.35	2.38	2.8	○										
	2QP-CCGW060204	●	●	●				●	●		2	2.3	0.4	6.35	2.38	2.8	○										
	2QP-CCGW060208			●							2	2.2	0.8	6.35	2.38	2.8	○										
	2QP-CCGW09T304	●	●	●				●	●		2	2.3	0.4	9.525	3.97	4.4	○										
	2QP-CCGW09T308	●	●	●				●			2	2.2	0.8	9.525	3.97	4.4	○										
	2QP-CCGW**-L 2QP-CCGW060204-L			●							2	2.3	0.4	6.35	2.38	2.8			○								
	2QP-CCGW060208-L			●							2	2.2	0.8	6.35	2.38	2.8			○								
	2QP-CCGW09T304-L			●							2	2.3	0.4	9.525	3.97	4.4			○								
	2QP-CCGW09T308-L			●							2	2.2	0.8	9.525	3.97	4.4			○								
	2QP-CCGW**-LF 2QP-CCGW060204-LF			●							2	2.3	0.4	6.35	2.38	2.8				○							
	2QP-CCGW060208-LF			●							2	2.2	0.8	6.35	2.38	2.8				○							
	2QP-CCGW09T304-LF			●							2	2.3	0.4	9.525	3.97	4.4				○							
	2QP-CCGW09T308-LF			●							2	2.2	0.8	9.525	3.97	4.4				○							
	2QP-CCGW**-LC 2QP-CCGW060204-LC			●							2	2.3	0.4	6.35	2.38	2.8					○						
	2QP-CCGW060208-LC			●							2	2.2	0.8	6.35	2.38	2.8					○						
	2QP-CCGW09T304-LC			●							2	2.3	0.4	9.525	3.97	4.4					○						
	2QP-CCGW09T308-LC			●							2	2.2	0.8	9.525	3.97	4.4					○						
	2QP-CCGW**-H 2QP-CCGW09T304-H			●							2	2.3	0.4	9.525	3.97	4.4										○	
	2QP-CCGW09T308-H			●							2	2.2	0.8	9.525	3.97	4.4										○	
	2QP-CCGW**WL 2QP-CCGW09T304WL			●							2	2.3	0.4	9.525	3.97	4.4	○									○	
	2QP-CCGW09T308WL			●							2	2.2	0.8	9.525	3.97	4.4	○									○	
	2QP-CCGT**-HP 2QP-CCGT060204-HP	●	●								2	2.3	0.4	6.35	2.38	2.8											○
	2QP-CCGT09T304-HP	●	●								2	2.3	0.4	9.525	3.97	4.4											○
	2QP-CCGT09T308-HP	●	●								2	2.2	0.8	9.525	3.97	4.4											○
	2QP-CCGT**WL-HP 2QP-CCGT09T304WL-HP	●									2	2.3	0.4	9.525	3.97	4.4										○	○
	2QP-CCGT09T308WL-HP	●									2	2.2	0.8	9.525	3.97	4.4										○	○

● : 产品型号

参考页: 外圆刀杆 → C024 - 内孔刀杆 → D014 -
J系列刀杆 → G019 - PINZBOHR®系列 → K180 -

CBN 刀片 正前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

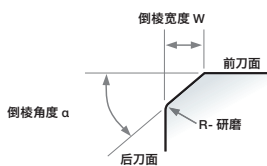
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		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX930	刀尖数量	LE	RE			IC	S	D1	标准	锋利刃	L	LF	LC	H
	2QP-CCMW060202				●	●	●				2	2.3	0.2	6.35	2.38	2.8	○							
	2QP-CCMW060204				●	●	●		●		2	2.3	0.4	6.35	2.38	2.8	○							
	2QP-CCMW09T304				●	●	●			●	2	2.3	0.4	9.525	3.97	4.4	○							
	2QP-CCMW09T308				●	●	●				2	2.2	0.8	9.525	3.97	4.4	○							
	Q-CCMW060204					●					1	2.5	0.4	6.35	2.38	2.8	○							
	Q-CCMW09T304					●					1	2.5	0.4	9.525	3.97	4.4	○							
	1QP-CCGW03X102				●			●			1	1.4	0.2	3.57	1.39	1.9	○							
	1QP-CCGW03X104				●			●			1	1.3	0.4	3.57	1.39	1.9	○							
	1QP-CCGW04T102				●			●			1	1.9	0.2	4.37	1.79	2.3	○							
	1QP-CCGW04T104				●			●			1	1.8	0.4	4.37	1.79	2.3	○							
	2QP-CPGW080204		●								2	2.3	0.4	7.94	2.38	3.4	○							
	2QP-CPGW080208		●								2	2.2	0.8	7.94	2.38	3.4	○							
	2QP-CPGW090304		●								2	2.3	0.4	9.525	3.18	4.4	○							
	2QP-CPGW090308		●								2	2.2	0.8	9.525	3.18	4.4	○							
	CPGA090204-QBN						●				1	4.0	0.4	9.525	2.38	4.0	○							
	CPGA090208-QBN						●				1	3.8	0.8	9.525	2.38	4.0	○							

Q-CCMW: 2片包装

●: 产品型号

珩磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
形状	珩磨宽度 (W) (mm)			珩磨角度: a	
T... 倒角倒棱					
S... 倒角+R-研磨					
E... 仅R-研磨					
F... 锋利刃					

参考页: 外圆刀杆 → C024 - 内孔刀杆 → D014 -
J系列刀杆 → G019 - PINZBOHR®系列 → K180 -

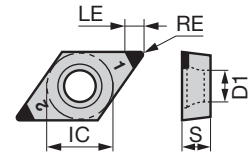
材质
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引

A
B
C
D
E
F
G
H
I
J
K
L
M

CBN 刀片 正前角

- : 连续切削
- : 轻断续切削
- ✱ : 强断续切削

P	钢																				
M	不锈钢																				
K	铸铁											●	●	●	●						
N	非铁金属																				
S	超级合金																				
H	硬材料	●	●	●	●	●	●	●	●												
	烧结金属											●	●	●	●	✱					






形状	型号	尺寸 (mm)									刃磨					修光刃	断屑槽								
		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX930	刀尖数量	LE	RE	IC	S			D1	标准	锋利刃	L	LF	LC	H	
	2QP-DCGW 2QP-DCGW070202	●	●	●							2	2.7	0.2	6.35	2.38	2.8	○								
	2QP-DCGW070204	●	●	●				●	●		2	2.5	0.4	6.35	2.38	2.8	○								
	2QP-DCGW070208			●				●			2	2.5	0.8	6.35	2.38	2.8	○								
	2QP-DCGW11T302	●	●	●							2	2.7	0.2	9.525	3.97	4.4	○								
	2QP-DCGW11T304	●	●	●				●	●		2	2.5	0.4	9.525	3.97	4.4	○								
	2QP-DCGW11T308	●	●	●				●			2	2.1	0.8	9.525	3.97	4.4	○								
	2QP-DCGW**-L 2QP-DCGW070204-L			●							2	2.5	0.4	6.35	2.38	2.8			○						
	2QP-DCGW070208-L			●							2	2.5	0.8	6.35	2.38	2.8			○						
	2QP-DCGW11T304-L			●							2	2.5	0.4	9.525	3.97	4.4			○						
	2QP-DCGW11T308-L			●							2	2.1	0.8	9.525	3.97	4.4			○						
	2QP-DCGW**-LF 2QP-DCGW070204-LF			●							2	2.5	0.4	6.35	2.38	2.8				○					
	2QP-DCGW070208-LF			●							2	2.5	0.8	6.35	2.38	2.8				○					
	2QP-DCGW11T304-LF			●							2	2.5	0.4	9.525	3.97	4.4				○					
	2QP-DCGW11T308-LF			●							2	2.1	0.8	9.525	3.97	4.4				○					
	2QP-DCGW**-LC 2QP-DCGW070204-LC			●							2	2.5	0.4	6.35	2.38	2.8					○				
	2QP-DCGW070208-LC			●							2	2.5	0.8	6.35	2.38	2.8					○				
	2QP-DCGW11T304-LC			●							2	2.5	0.4	9.525	3.97	4.4					○				
	2QP-DCGW11T308-LC			●							2	2.1	0.8	9.525	3.97	4.4					○				
	2QP-DCGW**-H 2QP-DCGW11T304-H			●							2	2.5	0.4	9.525	3.97	4.4							○		
	2QP-DCGW11T308-H			●							2	2.1	0.8	9.525	3.97	4.4							○		
	2QP-DCGT**-HP 2QP-DCGT070204-HP	●	●								2	2.5	0.4	6.35	2.38	2.8									○
	2QP-DCGT11T304-HP	●	●								2	2.5	0.4	9.525	3.97	4.4									○
	2QP-DCGT11T308-HP	●	●								2	2.1	0.8	9.525	3.97	4.4									○

● : 产品型号

参考页: 外圆刀杆 → C048 - 内孔刀杆 → D048 -
J系列刀杆 → G026 - PINZBOHR®系列 → K184 -

CBN 刀片 正前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

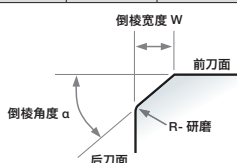
形状	型号	材料							尺寸 (mm)					刃磨								
		P	M	K	N	S	H	烧结金属	刀尖数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC	H	修光刃	断屑槽
	2QP-DCMW070202								2	2.7	0.2	6.35	2.38	2.8	○							
	2QP-DCMW070204								2	2.5	0.4	6.35	2.38	2.8	○							
	2QP-DCMW11T302								2	2.7	0.2	9.525	3.97	4.4	○							
	2QP-DCMW11T304								2	2.5	0.4	9.525	3.97	4.4	○							
	2QP-DCMW11T308								2	2.1	0.8	9.525	3.97	4.4	○							
	2QP-DCGW11T302F								2	2.7	0.2	9.525	3.97	4.4	○							
	2QP-DCGW11T304F								2	2.5	0.4	9.525	3.97	4.4	○							
	Q-DCMW070204								1	2.1	0.4	6.35	2.38	2.8	○							
	Q-DCMW11T304								1	2.1	0.4	9.525	3.97	4.4	○							

Q-DCMW: 2片包装

●: 产品型号

刃磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-



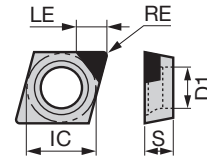
形状
T... 倒角倒棱
S... 倒角+R-研磨
E... 仅R-研磨
F... 锋利刃

参考页: 外圆刀杆 → C048 - 内孔刀杆 → D048 -
J系列刀杆 → G026 - PINZBOHR®系列 → K184 -

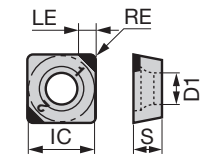
CBN 刀片 正前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

形状	型号	尺寸 (mm)						珩磨											
		BX310	BX470	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC	H	修光刃	断屑槽			
	1QP-EPGW 1QP-EPGW03X102	●	●					1	1.4	0.2	3.57	1.39	1.9	○					
	1QP-EPGW03X104	●	●					1	1.3	0.4	3.57	1.39	1.9	○					
	1QP-EPGW040102	●	●					1	1.7	0.2	3.97	1.59	2.3	○					
	1QP-EPGW040104	●	●					1	1.6	0.4	3.97	1.59	2.3	○					



形状	型号	尺寸 (mm)									珩磨													
		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX910	BX930	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC	H	修光刃	断屑槽
	2QP-SPGN 2QP-SPGN090308								●		2	2.4	0.8	9.525	3.18	-	○							
	2QP-SPGN090312									●	2	2.4	1.2	9.525	3.18	-	○							
	2QP-SPMN 2QP-SPMN090304					●	●				2	2.4	0.4	9.525	3.18	-	○							
	2QP-SPMN090308					●	●			●	2	2.4	0.8	9.525	3.18	-	○							
	Q-SPGN Q-SPGN090304					●					1	2.8	0.4	9.525	3.18	-	○							
	Q-SPGN090308					●					1	2.8	0.8	9.525	3.18	-	○							
	SPGN**-QBN SPGN090304-QBN							●			1	4.1	0.4	9.525	3.18	-	○							
	SPGN090308-QBN							●			1	4.1	0.8	9.525	3.18	-	○							
	SPGN090312-QBN							●			1	4.1	1.2	9.525	3.18	-	○							
	SPGN120308-QBN							●			1	4.1	0.8	12.7	3.18	-	○							
	SPGN120312-QBN							●			1	4.1	1.2	12.7	3.18	-	○							
	2QP-SPGW 2QP-SPGW09T308									●	2	2.4	0.8	9.525	3.97	4.4	○							
	2QP-SPGW09T312									●	2	2.4	1.2	9.525	3.97	4.4	○							
	2QP-SPGW120408									●	2	2.4	0.8	12.7	4.76	5.5	○							
	2QP-SPGW120412									●	2	2.4	1.2	12.7	4.76	5.5	○							
	2QP-SPGW120416									●	2	2.4	1.6	12.7	4.76	5.5	○							



Q-SPGN: 2片包装

●: 产品型号

参考页: 内孔刀杆 → D033 - PINZBOHR®系列 → K197 -

CBN 刀片 正前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

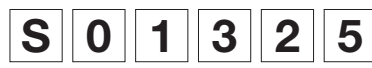
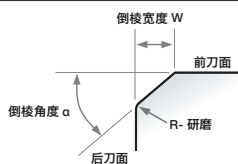
形状	型号	尺寸 (mm)								刃磨																
		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX910	BX930	刀尖数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC	H	修光刃	断屑槽	
	3QP-TPGN110302							●			3	2.3	0.2	6.35	3.18	-	○									
	3QP-TPGN110304							●			3	2.2	0.4	6.35	3.18	-	○									
	3QP-TPGN110308							●	●		3	2.2	0.8	6.35	3.18	-	○									
	3QP-TPGN110312							●		●	3	2.4	1.2	6.35	3.18	-	○									
	3QP-TPGN160304							●			3	2.2	0.4	9.525	4.76	-	○									
	3QP-TPGN160308							●			3	1.9	0.8	9.525	4.76	-	○									
	3QP-TPMN110302					●	●			●	3	2.3	0.2	6.35	3.18	-	○									
	3QP-TPMN110304					●	●			●	3	2.2	0.4	6.35	3.18	-	○									
	3QP-TPMN110308					●	●			●	3	1.9	0.8	6.35	3.18	-	○									
	3QP-TPMN160304					●	●			●	3	2.2	0.4	9.525	3.18	-	○									
	3QP-TPMN160308					●	●			●	3	1.9	0.8	9.525	3.18	-	○									
	Q-TPGN110304					●					1	2.2	0.4	6.35	3.18	-	○									
	Q-TPGN110308					●					1	2.2	0.8	6.35	3.18	-	○									
	Q-TPGN160304					●					1	2.3	0.4	9.525	3.18	-	○									
	Q-TPGN160308					●					1	1.9	0.8	9.525	3.18	-	○									
	TPGN110304-QBN							●			1	3.7	0.4	6.35	3.18	-	○									
	TPGN110308-QBN							●			1	3.5	0.8	6.35	3.18	-	○									
	TPGN160304-QBN							●			1	4.2	0.4	9.525	3.18	-	○									
	TPGN160308-QBN							●			1	4.0	0.8	9.525	3.18	-	○									
	TBGN060104-15-QBN							●			3	-	0.4	3.97	1.59	-	○									
	TBGN060108-15-QBN							●			3	-	0.8	3.97	1.59	-	○									

Q-TPGN: 2片包装

●: 产品型号

刃磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-



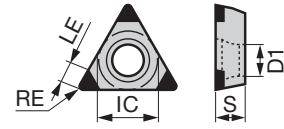
形状
T ... 倒角倒棱
S ... 倒角 + R-研磨
E ... 仅 R-研磨
F ... 锋利刃

参考页: 内孔刀杆 → D044 - 刀夹 → K193 -
镗孔刀杆 → K209 - 镗杆刀具 → K213

CBN 刀片 正前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

P	钢																		
M	不锈钢																		
K	铸铁							●	●	✱		●	●						
N	非铁金属																		
S	超级合金																		
H	硬材料	●	●	●	●	●	●	●	●	●									
	烧结金属							●	●	●	✱								



形状	型号	BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX910	BX930	尺寸 (mm)					刃磨					修光刃	断屑槽							
												刀尖数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF			LC	H					
	3QP-TPGW 3QP-TPGW080204	●	●	●									3	2.2	0.4	4.76	2.38	2.3	○											
	3QP-TPGW080208			●									3	2.2	0.8	4.76	2.38	2.3	○											
	3QP-TPGW090204	●	●	●									3	2.2	0.4	5.56	2.38	2.5	○											
	3QP-TPGW090208			●									3	2.2	0.8	5.56	2.38	2.5	○											
	3QP-TPGW110202		●										3	2.3	0.2	6.35	2.38	2.8	○											
	3QP-TPGW110204	●	●	●					●				3	2.2	0.4	6.35	2.38	2.8	○											
	3QP-TPGW110208			●					●				3	2.2	0.8	6.35	2.38	2.8	○											
	3QP-TPGW110302		●	●						●			3	2.3	0.2	6.35	3.18	3.4	○											
	3QP-TPGW110304	●	●	●					●	●			3	2.2	0.4	6.35	3.18	3.4	○											
	3QP-TPGW110308	●	●	●					●	●	●		3	2.2	0.8	6.35	3.18	3.4	○											
	3QP-TPGW130302		●							●			3	2.3	0.2	7.94	3.18	3.4	○											
	3QP-TPGW130304	●	●	●						●			3	2.2	0.4	7.94	3.18	3.4	○											
	3QP-TPGW130308		●		●					●			3	2.2	0.8	7.94	3.18	3.4	○											
	3QP-TPGW16T304	●	●	●									3	2.2	0.4	9.525	3.97	4.4	○											
3QP-TPGW16T308	●	●	●									3	1.9	0.8	9.525	3.97	4.4	○												
3QP-TPGW160404	●	●	●									3	2.2	0.4	9.525	4.76	4.4	○												
3QP-TPGW160408		●	●									3	1.9	0.8	9.525	4.76	4.4	○												
3QP-TPGW**F	3QP-TPGW110304F							●				3	2.2	0.4	6.35	3.18	3.4	○												
	3QP-TPGW110308F							●				3	1.9	0.8	6.35	3.18	3.4	○												
3QP-TPGW**-L	3QP-TPGW110304-L		●									3	2.2	0.4	6.35	3.18	3.4		○											
	3QP-TPGW110308-L		●									3	2.2	0.8	6.35	3.18	3.4		○											
3QP-TPGW**-LF	3QP-TPGW110304-LF		●									3	2.2	0.4	6.35	3.18	3.4			○										
	3QP-TPGW110308-LF		●									3	2.2	0.8	6.35	3.18	3.4			○										
3QP-TPGW**-LC	3QP-TPGW110304-LC		●									3	2.2	0.4	6.35	3.18	3.4				○									
	3QP-TPGW110308-LC		●									3	2.2	0.8	6.35	3.18	3.4				○									
3QP-TPGW**-H	3QP-TPGW110304-H		●									3	2.2	0.4	6.35	3.18	3.4					○								
	3QP-TPGW110308-H		●									3	2.2	0.8	6.35	3.18	3.4					○								
	3QP-TPGW160404-H		●									3	2.2	0.4	9.525	4.76	4.4					○								
	3QP-TPGW160408-H		●									3	1.9	0.8	9.525	4.76	4.4					○								

●: 产品型号

参考页: 内孔刀杆 → **D043 -** 刀夹 → **K193 -**
镗孔刀杆 → **K209 -**

CBN 刀片 正前角

●: 连续切削
●: 轻断续切削
✱: 强断续切削

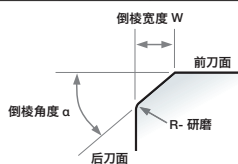
材质
刀片
外圆刀杆
内孔刀杆
螺纹加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引

形状	型号	尺寸 (mm)								刃磨																
		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX470	BX480	BX910	BX930	刀片数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC	H	修光刃	断屑槽	
	3QP-TPGT110304-HP	●	●								3	2.2	0.4	6.35	3.18	3.4									○	
	3QP-TPGT110308-HP	●	●								3	1.9	0.8	6.35	3.18	3.4									○	
	3QP-TPMW080204				●	●	●				3	2.2	0.4	4.76	2.38	2.3	○									
	3QP-TPMW090202					●	●				3	2.3	0.2	5.56	2.38	2.5	○									
	3QP-TPMW090204				●	●	●				3	2.2	0.4	5.56	2.38	2.5	○									
	3QP-TPMW110202				●	●	●				3	2.3	0.2	6.35	2.38	2.8	○									
	3QP-TPMW110204				●	●	●				3	2.2	0.4	6.35	2.38	2.8	○									
	3QP-TPMW110302				●	●	●				3	2.3	0.2	6.35	3.18	3.4	○									
	3QP-TPMW110304				●	●	●				3	2.2	0.4	6.35	3.18	3.4	○									
	3QP-TPMW110308				●	●	●				3	1.9	0.8	6.35	3.18	3.4	○									
	3QP-TPMW130302				●	●	●				3	2.4	0.2	7.94	3.18	3.4	○									
	3QP-TPMW130304				●	●	●				3	2.2	0.4	7.94	3.18	3.4	○									
	3QP-TPMW16T304				●	●	●				3	2.2	0.4	9.525	3.97	4.4	○									
	3QP-TPMW16T308				●						3	1.9	0.8	9.525	3.97	4.4	○									
	3QP-TPMW160404				●	●	●				3	2.2	0.4	9.525	4.76	4.4	○									
3QP-TPMW160408				●	●	●				3	1.9	0.8	9.525	4.76	4.4	○										
	3QP-TCGW090204		●								3	2.2	0.4	5.56	2.38	2.5	○									
	3QP-TCGW090208		●								3	1.9	0.8	5.56	2.38	2.5	○									
	3QP-TCGW110204		●								3	2.2	0.4	6.35	2.38	2.8	○									
	3QP-TCGW110208		●								3	1.9	0.8	6.35	2.38	2.8	○									
	3QP-TCGW16T304		●								3	2.2	0.4	9.525	3.97	4.3	○									
3QP-TCGW16T308		●								3	1.9	0.8	9.525	3.97	4.3	○										

●: 产品型号

刃磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-



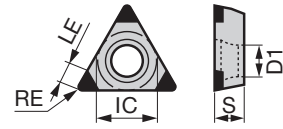
形状
T ... 倒角倒棱
S ... 倒角 + R-研磨
E ... 仅 R-研磨
F ... 锋利刃

参考页: 内孔刀杆 → D043 - 刀夹 → K193 -
镗孔刀杆 → K209 -

CBN 刀片 正前角

●: 连续切削
 ●: 轻断续切削
 ☆: 强断续切削

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



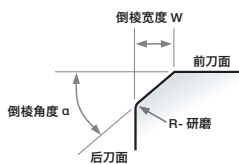
形状	型号	尺寸 (mm)							珩磨						修光刃	断屑槽		
		BX330	BX360	刀片数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC			H	
	Q-TPMW080204	●		1	2.2	0.4	4.76	2.38	2.3	○								
	Q-TPMW090202	●		1	2.4	0.2	5.56	2.38	2.5	○								
	Q-TPMW090204	●		1	2.3	0.4	5.56	2.38	2.5	○								
	Q-TPMW110202	●		1	2.4	0.2	6.35	2.38	2.8	○								
	Q-TPMW110204	●		1	2.2	0.4	6.35	2.38	2.8	○								
	Q-TPMW110304	●		1	2.3	0.4	6.35	3.18	3.4	○								
	Q-TPMW110308	●		1	2.2	0.8	6.35	3.18	3.4	○								
	Q-TPMW130302	●		1	2.4	0.2	7.94	3.18	3.4	○								
	Q-TPMW130304	●		1	2.3	0.4	7.94	3.18	3.4	○								
	Q-TPMW16T304	●		1	2.3	0.4	9.525	3.97	4.4	○								
	Q-TPMW160404	●		1	2.3	0.4	9.525	4.76	4.4	○								
	Q-TPMW160408	●		1	1.9	0.8	9.525	4.76	4.4	○								
	TPGW090202-QBN	●		1	3.3	0.2	5.56	2.38	2.5	○								
	TPGW090204-QBN	●		1	3.2	0.4	5.56	2.38	2.5	○								
	TPGW110202-QBN	●		1	3.9	0.2	6.35	2.38	2.8	○								
	TPGW110204-QBN	●		1	3.7	0.4	6.35	2.38	2.8	○								
	TPGW130302-QBN	●		1	3.9	0.2	7.94	3.18	3.4	○								
	TPGW130304-QBN	●		1	3.7	0.4	7.94	3.18	3.4	○								
	TPGW16T302-QBN	●		1	4.4	0.2	9.525	3.97	4.4	○								
	TPGW16T304-QBN	●		1	4.2	0.4	9.525	3.97	4.4	○								
	TPGW16T308-QBN	●		1	4.0	0.8	9.525	3.97	4.4	○								
	TPGA090202-QBN	●		1	3.1	0.2	5.56	2.38	3.2	○								
	TPGA090204-QBN	●		1	2.9	0.4	5.56	2.38	3.2	○								
	TPGA110202-QBN	●		1	3.9	0.2	6.35	2.38	3.0	○								
	TPGA110204-QBN	●		1	3.7	0.4	6.35	2.38	3.0	○								
	TPGA110302-QBN	●		1	3.9	0.2	6.35	3.18	3.0	○								
	TPGA110304-QBN	●		1	3.7	0.4	6.35	3.18	3.0	○								
	TPGA160302-QBN	●		1	4.4	0.2	9.525	3.18	4.0	○								
	TPGA160304-QBN	●		1	4.2	0.4	9.525	3.18	4.0	○								
TPGA160308-QBN	●		1	4.0	0.8	9.525	3.18	4.0	○									

Q-TPMW: 2片包装

●: 产品型号

珩磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-



S	0	1	3	2	5
----------	----------	----------	----------	----------	----------

形状: T... 倒角倒棱, S... 倒角+R-研磨, E... 仅R-研磨, F... 锋利刃
 珩磨宽度 (W) (mm):
 珩磨角度: a

参考页: 内孔刀杆 → D043 - 刀夹 → K193 -
 镗孔刀杆 → K209 -

CBN 刀片 正前角

●: 连续切削
●: 轻断续切削
●: 强断续切削

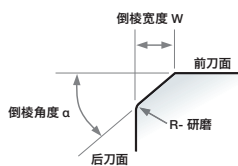
材质
刀片
外圆刀杆
内孔刀杆
外圆加工
内孔加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系统
用户指南
索引

形状	型号	尺寸 (mm)						刃磨															
		BXM10	BXM20	BXA20	BX310	BX330	BX360	BX930	刀尖数量	LE	RE	IC	S	D1	标准	锋利刃	L	LF	LC	H	修光刃	断屑槽	
	2QP-VBGW110204			●				2	3.1	0.4	6.35	2.38	2.8	○									
	2QP-VBGW110208			●				2	2.2	0.8	6.35	2.38	2.8	○									
	2QP-VBGW110304	●	●	●				2	3.1	0.4	6.35	3.18	2.8	○									
	2QP-VBGW110308	●	●	●				2	2.2	0.8	6.35	3.18	2.8	○									
	2QP-VBGW160404	●	●	●				2	3.1	0.4	9.525	4.76	4.4	○									
	2QP-VBGW160408	●	●	●				2	2.2	0.8	9.525	4.76	4.4	○									
	2QP-VBGW160412			●				2	3.0	1.2	9.525	4.76	4.4	○									
	2QP-VBGW**-L 2QP-VBGW110304-L			●				2	3.1	0.4	6.35	3.18	2.8		○								
	2QP-VBGW110308-L			●				2	2.2	0.8	6.35	3.18	2.8		○								
	2QP-VBGW160404-L			●				2	3.1	0.4	9.525	4.76	4.4		○								
	2QP-VBGW160408-L			●				2	2.2	0.8	9.525	4.76	4.4		○								
	2QP-VBGW** -LF 2QP-VBGW110304-LF			●				2	3.1	0.4	6.35	3.18	2.8			○							
	2QP-VBGW110308-LF			●				2	2.2	0.8	6.35	3.18	2.8			○							
	2QP-VBGW160404-LF			●				2	3.1	0.4	9.525	4.76	4.4			○							
	2QP-VBGW160408-LF			●				2	2.2	0.8	9.525	4.76	4.4			○							
	2QP-VBGW** -LC 2QP-VBGW110304-LC			●				2	3.1	0.4	6.35	3.18	2.8				○						
	2QP-VBGW110308-LC			●				2	2.2	0.8	6.35	3.18	2.8				○						
	2QP-VBGW160404-LC			●				2	3.1	0.4	9.525	4.76	4.4				○						
	2QP-VBGW160408-LC			●				2	2.2	0.8	9.525	4.76	4.4				○						
	2QP-VBGW** -H 2QP-VBGW160404-H			●				2	3.1	0.4	9.525	4.76	4.4								○		
	2QP-VBGW160408-H			●				2	2.2	0.8	9.525	4.76	4.4								○		

●: 产品型号

刃磨规格

	BXM10 BX310 BX330 BX480	BXA20	BXM20	BX360 BX380	BX470	BX910 BX930 BXC50	BXC90
标准	S01325	S01325	S01325	S01325	T01315	S01325	T02020
锋利刃	-	-	-	-	F	-	-
-L	S01315	S01315	S01315	-	-	-	-
-LF	-	S00515	-	-	-	-	-
-LC	-	S00535	-	-	-	-	-
-H	-	S01835	S01835	S01335	-	-	-
修光刃	S01315	S01315	S01315	-	-	-	-



S 0 1 3 2 5

形状
T... 倒角倒棱
S... 倒角+R-研磨
E... 仅R-研磨
F... 锋利刃


刃磨宽度 (W) (mm)
刃磨角度: α

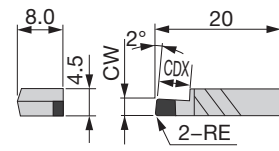
参考页: 外圆刀杆 → C062 - 内孔刀杆 → D036 -
J系列刀杆 → G033 - TungCap系列 → K022

CBN 刀片 负前角


- : 连续切削
- : 轻断续切削
- ✳: 强断续切削

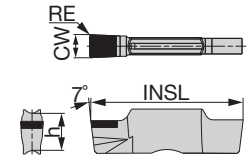
关于 GX-RE

形状	型号	BX360	材料适用性							尺寸 (mm)		
			P	M	K	N	S	H	CW±0.05	RE	CDX	
	XGR6310S-QBN	●●								-	-	-
	XGR6315S-QBN	●								1.5	0.2	2.3
	XGR6320S-QBN	●								2	0.2	3
	XGR6325S-QBN	●								2.5	0.2	3.8
	XGR6330S-QBN	●								3	0.2	4.5
	XGR6335S-QBN	●								3.5	0.2	5.3
	XGR6340S-QBN	●								4	0.2	6
	XGR6345S-QBN	●								4.5	0.2	6



关于 TungCut

形状	型号	BX360	材料适用性							尺寸 (mm)				
			P	M	K	N	S	H	刀座尺寸	CW±0.025	RE	INSL	h	
	SGN200-020	●								2	2	0.2	20	5
	SGN300-020	●								3	3	0.2	20	5
	SGN400-020	●								4	4	0.2	20	5



●: 产品型号

材料
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系統
用戶指南
索引

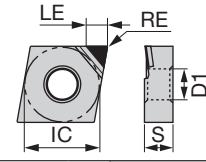


PCD 刀片

●: 连续切削
 ●: 轻断续切削
 ☆: 强断续切削

负前角

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



形状	型号	DX110	DX120	尺寸 (mm)					珩磨				角	
				刀尖数量	LE	RE	IC	S	D1	锋利刃				
	CNMM**-DIA CNMM120402-DIA		●	1	3.5	0.2	12.7	4.76	5.16	○				○
	CNMM120404-DIA		●	1	3.5	0.4	12.7	4.76	5.16	○				○
	1QP-CNMM120402	●		1	3.5	0.2	12.7	4.76	5.16	○				○
	1QP-CNMM120404	●		1	3.5	0.4	12.7	4.76	5.16	○				○
	DNMM**-DIA DNMM150402-DIA		●	1	3.3	0.2	12.7	4.76	5.16	○				○
	DNMM150404-DIA		●	1	3.1	0.4	12.7	4.76	5.16	○				○
	TNMM**-DIA TNMM160402-DIA		●	1	3.3	0.2	9.528	4.76	3.81	○				○
	TNMM160404-DIA		●	1	3.2	0.4	9.528	4.76	3.81	○				○
	1QP-TNMM160402	●		1	3.3	0.2	9.528	4.76	3.81	○				○
	1QP-TNMM160404	●		1	3.2	0.4	9.528	4.76	3.81	○				○
	VNMM**-DIA VNMM160402-DIA		●	1	4.8	0.2	9.528	4.76	3.81	○				○
	VNMM160404-DIA		●	1	4.4	0.4	9.528	4.76	3.81	○				○
	VNMM160408-DIA		●	1	3.6	0.8	9.528	4.76	3.81	○				○

●: 产品型号

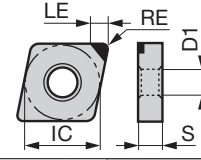
参考页: 外圆刀杆 → C016 - 内孔刀杆 → D021 -
 J系列刀杆 → G044 TungCap系列 → K008 -
 PINZBOHR®系列 → K180 - 刀夹 → K199 -

PCD 刀片

●: 连续切削
●: 轻断续切削
✱: 强断续切削

负前角

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



形状	型号	DX140	DX160	尺寸 (mm)					珩磨					
				刀尖数量	LE	RE	IC	S	D1	锋利刃				
	CNGA**-DIA CNGA120404-DIA	●		1	3.5	0.4	12.7	4.76	5.16	○				
	CNGA120408-DIA	●		1	2.8	0.8	12.7	4.76	5.16	○				
	DNGA**-DIA DNGA150404-DIA	●	●	1	3.1	0.4	12.7	4.76	5.16	○				
	DNGA150408-DIA	●		1	2.8	0.8	12.7	4.76	5.16	○				
	SNGA**-DIA SNGA120404-DIA	●		1	3.6	0.4	12.7	4.76	5.16	○				
	SNGA120408-DIA	●		1	3.6	0.8	12.7	4.76	5.16	○				
	SNGN**-DIA SNGN120408-DIA	●		1	3.6	0.8	12.7	4.76		○				
	TNGA**-DIA TNGA160404-DIA	●	●	1	3.2	0.4	9.525	4.76	3.81	○				
	TNGA160408-DIA	●	●	1	2.9	0.8	9.525	4.76	3.81	○				

●: 产品型号

参考页: 外圆刀杆 → C016 - 内孔刀杆 → D021 -
J系列刀杆 → G044 - TungCap系列 → K008 -
刀夹 → K193 -

材质
刀片
外圆刀杆
内孔刀杆
螺紋加工
槽加工
小零件刀具
铣刀
立铣刀
孔加工刀具
工具系統
用户指南
索引



H 用于淬火钢和硬材料切削的 T-CBN 刀片

应用领域

工件硬度 (HRC)

连续 → 轻型断续 → 重型断续

切削方式

选择 PCBN 材质的必要性

切削工件所需的条件

材料为：
刀具硬度 ≥ 工件硬度 X 3

- 淬火钢 (60HRC) → 700 Hv
- 硬质合金 → 1600 Hv
- PCBN (BX360) → 3300 Hv

CBN 晶粒大小对表面粗糙度和切削速度的影响

[微粒 CBN]

微粒 PCBN：拥有锋利的刃口。
良好的表面粗糙度

[粗粒 CBN]

粗粒 PCBN：CBN 颗粒牢固的结合。
允许高速加工

用于加工淬火钢和其他高硬度材料的 CBN 材质的特性

增加

抗崩损性

耐磨性

CBN 含量

100

更低的 CBN 含量 ⇨ 提高了耐磨性
更高的 CBN 含量 ⇨ 提高了抗崩损性

加工淬火钢和高硬度材料时选择 T-CBN 材质的基本指南

● 涂层硬质合金 T-CBN 材质

- BXM10** 高速切削用
- BXM20** 通用切削用, Vc 超过 180 m/min
- BXA20** 通用切削用, Vc 低于 180 m/min

● 不涂层硬质合金 T-CBN 材质

- BX310** 高速切削用 / 重视连续切削时的耐磨性
- BX330** 中速切削用 / 重视加工面品质
- BX360** 低速 ~ 中速切削用 / 采用通用材质, 具有出众的抗崩损性
- BX380** 低速 ~ 中速切削用 / 重视强断续切削时的抗崩损性

涂层硬质合金 T-CBN 材质的应用领域

● 连续切削

切削速度 Vc (m/min)

进给量 (mm/rev)

连续切削

● 断续切削

切削速度 Vc (m/min)

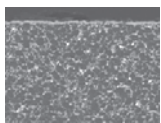
进给量 (mm/rev)

弱断续

断续

轻型 ← 断续 → 重型

涂层硬质合金 T-CBN 材质的作用



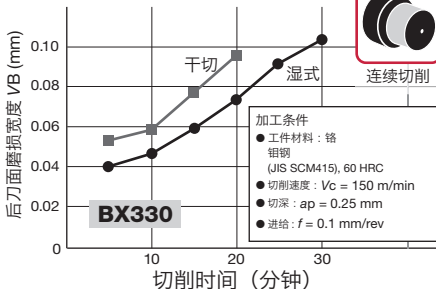
在坚硬的 CBN 上施加涂层
硬度：
CBN > 涂层硬质合金

- 防止 CBN 出现氧化磨损
涂层有助于隔绝空气, 可防止 CBN 发生氧化磨损
- 防止涂层剥落
硬度高且抗变形的 CBN 是一种性能优异的基体材料。

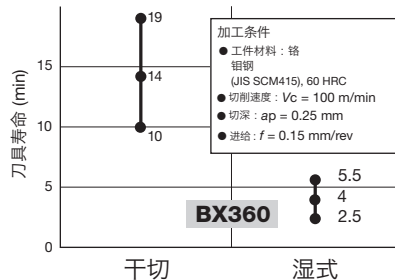
提高了后刀面的
耐磨性

加工淬火钢时冷却液的作用

● 连续切削



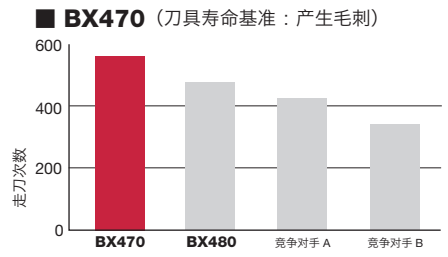
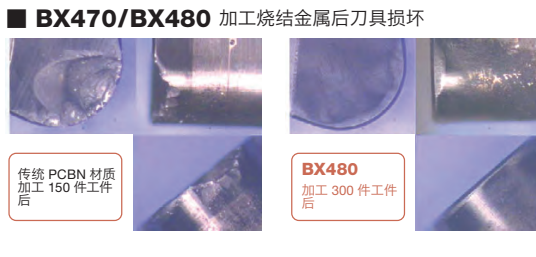
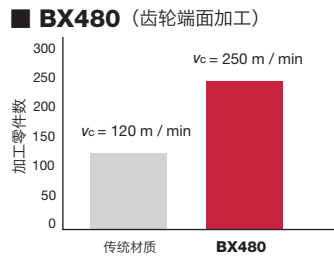
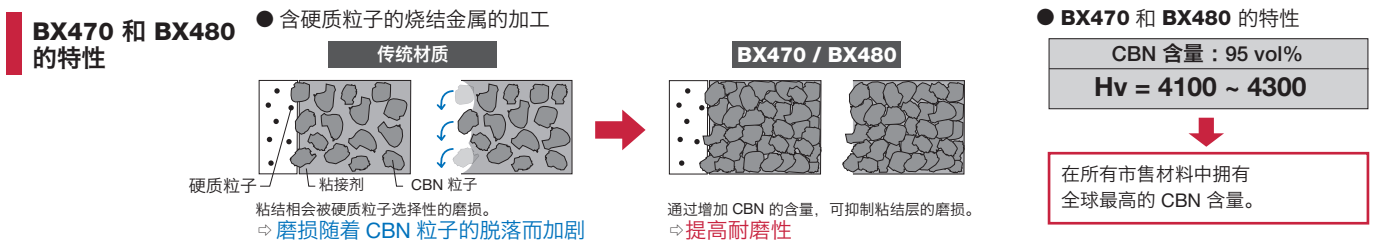
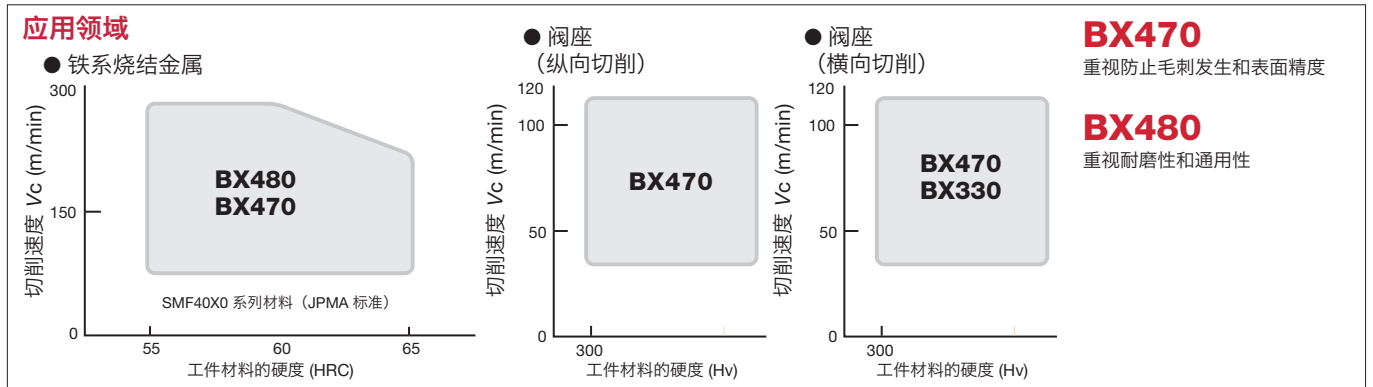
● 断续切削



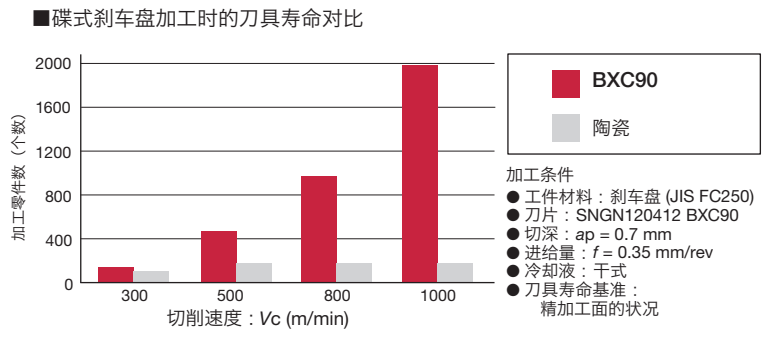
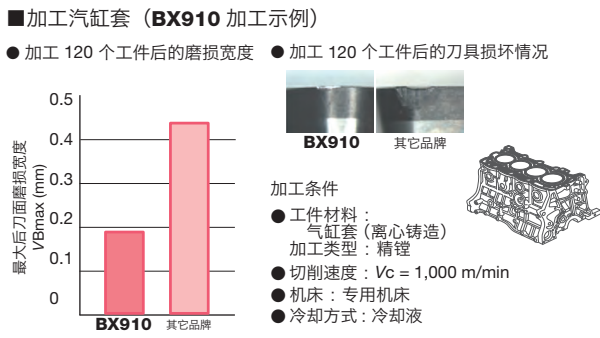
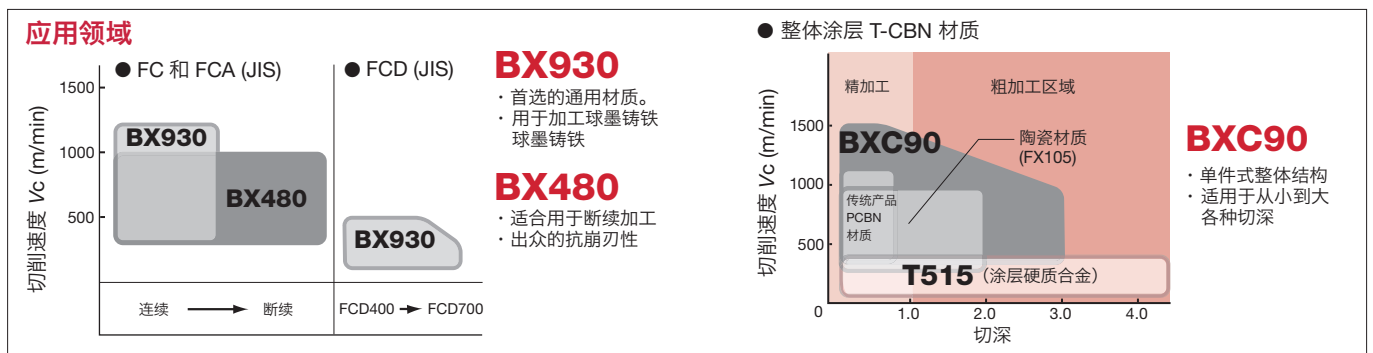
- 连续切削时, 湿式切削与干式切削相比更有利于提高刀具使用寿命, 减少磨损。
- 断续切削时, 干式切削与湿式切削相比更有利于提高刀具使用寿命, 崩损

技术指南

用于加工烧结金属的 T-CBN 系列



K 用于加工灰口铸铁和球墨铸铁的 T-CBN 系列



BX910 用于加工汽缸套

T-CBN 系列

钝化规格

● 具有特殊钝化规格的 T-CBN 刀片可根据订单生产。请参阅以下说明。

倒棱命名系统

例如：
钝化宽度：0.15 mm
钝化角度：-30°
含 R 钝化

S

0

1

3

2

5

形状

T... 倒角倒棱
S... 倒角 + R- 研磨
E... 仅 R- 研磨
F... 锋利刀

倒棱宽度 (W)

● 代号

W	钝化量 (mm)
005	0.05
010	0.10
013	0.13
015	0.15
018	0.18

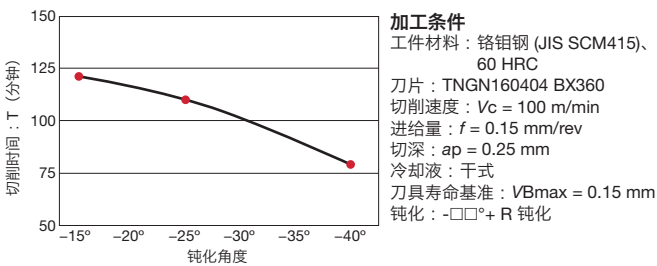
倒棱角度 (α)

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

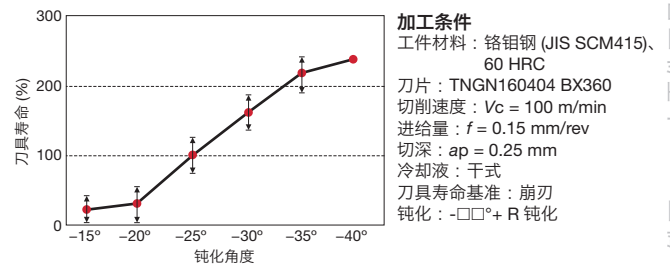
倒棱宽度 W
前刀面
后刀面
倒棱角度 α
R- 研磨

● 钝化规格可与此处所述项目一起选择。
● 可供应只进行了 R 钝化的刀片。

● 连续车削时钝化角度和刀具使用寿命之间的关系



● 断续车削时钝化角度和刀具使用寿命之间的关系



- 连续切削时，较小的钝化角度一般来说更有利于最大限度减少磨损。
- 断续切削时，较大的钝化角度一般来说更有利于最大限度减少崩刃。

● 标准钝化规格

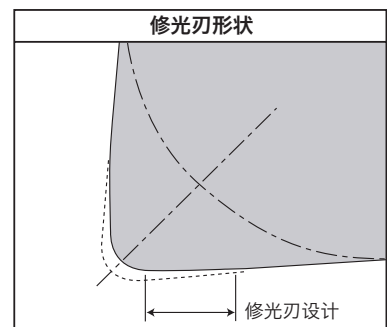
材质	BXM10	BXM20	BXA20	BXC50	BX310	BX330	BX360	BX380	BX470	BX480	BX910	BX930
负角刀片	S01325	S01325	S01325	S01325	S01325	S01325	S01325	S01325	S01325	S01325	S01315	S01315
正角刀片	S01325	S01325	S01325	-	S00515	S00515	S00515	-	T01315	S00515	S01315	S00515

修光刃

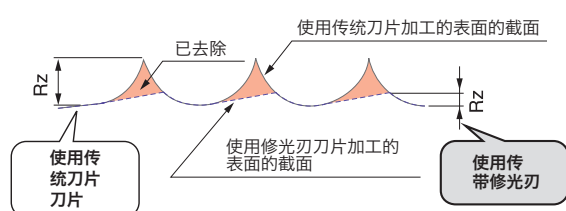
- 精切刃（修光刃）形成于刀尖圆弧半径与直切刃的交汇处。

■ 修光刃的作用

- 将加工效率提高一倍 → 缩短加工时间
修光刃可以将进给速率提升一倍，同时不会降低表面粗糙度。（注：进给速率：*f < 0.3 mm/rev）
- 良好的表面粗糙度 → 通过将粗加工和精加工整合到一步工序中，可以提高生产效率。
对比只有刀尖圆弧的传统刀片，使用修光刃可以提高表面粗糙度。



■ 表面粗糙度轮廓

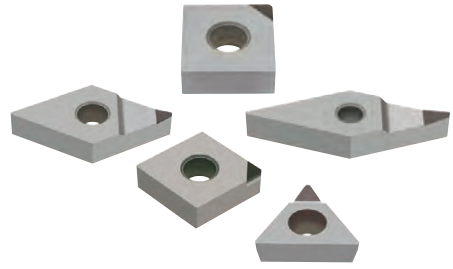


■ 修光刃刀片建议使用的刀杆

	2QP-CNGA1204**WL	3QP-WNGA080408WL	2QP-DNGA1504**WJ	3QP-TNGA1604**WG
副偏角	95°			
外圆刀杆	ACLNR/L**12-A	AWLNR/L**08-A	ADJNR/L**15-A	ATGNR/L**16-A ATFNR/L**16-A
	DCLNR/L**12	DWLNR/L**08	DDJNR/L**15	DTGNR/L**16 DTFNR/L**16
内螺纹刀杆	A**-ACLNR/L12-D...	A**-AWLNR/L08-D...	A**-ADJNR/L15-D...	A**-ATFNR/L16-D...

PCD 材质、T-DIA 系列

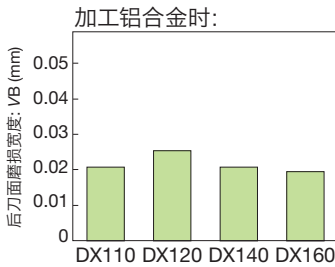
T-DIA 刀具的产品系列非常丰富，可用于加工众多工件材料并适应众多切削环境。



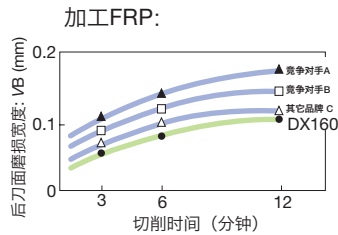
特性和应用 (物理和机械特性)

	DX110	DX120	DX140	DX160
材质				
特性	重视加工面 用超细微粒材质	用微粒材质 用超细微粒材质	通用材质	适合切削高硬度材料 硬材料
金刚石的大致晶粒大小 (μm)	< 1	5	13	28
硬度 (Hv)	8500	→		10000 (硬度更高)
耐磨性	→			更高
易磨性 (切削刃锋利度)	更好	←		

切削性能 (耐磨性)

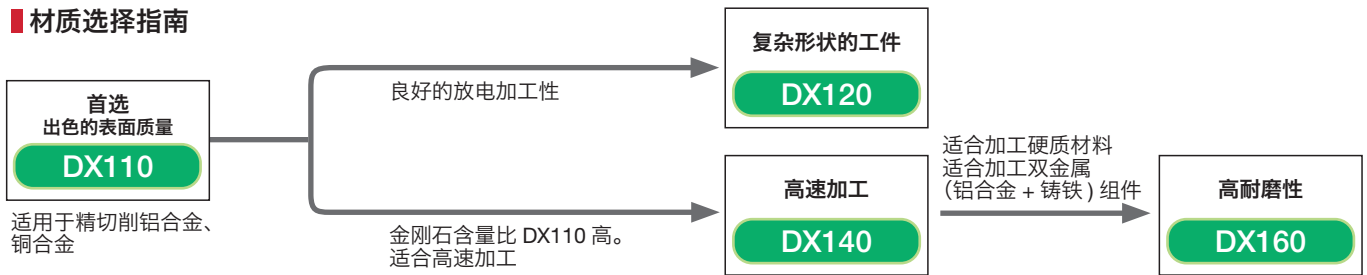


- 连续车外圆**
- 工件材料: 10 % Si、铝合金
 - 刀片: SPGN120308-DIA
 - 刀杆: CSBPR2525M4
 - 切削速度: $V_c = 500$ m/min
 - 进给: $f = 0.1$ mm/rev
 - 切深: $ap = 0.5$ mm
 - 冷却液: 干式切削
 - 切削时间: 30 min



- 平面铣削**
- 工件材料: 纤维增强塑料 (FRP)
 - 刀片: SPCN42ZFR-DIA
 - 铣刀: TPG4208R-A
 - 切削速度: $V_c = 942$ m/min
 - 进给: $f = 0.1$ mm/rev
 - 切深: $ap = 1.5$ mm
 - 冷却液: 干式切削

材质选择指南



标准加工参数

ISO	工件材料	材质				切削速度 V_c (m/min)	切深 ap (mm)	进给量 f (mm/rev)
		DX110	DX120	DX140	DX160			
N	铝合金 (Si < 12 %)	◎	○	○		1500 (1000 - 2500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	铝合金 (Si ≥ 12 %)	◎	○	○	○	600 (400 - 800)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	铜、黄铜	◎	○	○		800 (500 - 1500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	磷青铜	◎	○	○		400 (300 - 500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	碳、石墨		○	○	◎	400 (300 - 500)	0.5 (0.05 - 2.0)	0.1 (0.05 - 0.2)
	FRP		○	○	◎	700 (500 - 1000)	0.2 (0.05 - 0.5)	0.05 (0.03 - 0.1)
	塑料	◎	○	○		700 (500 - 1000)	0.2 (0.05 - 0.5)	0.03 (0.01 - 0.05)
	硬质合金			○	◎	15 (10 - 20)	0.1 (0.05 - 0.2)	0.03 (0.01 - 0.05)
	半烧结陶瓷			○	◎	130 (100 - 150)	0.5 (0.05 - 2.0)	0.05 (0.03 - 0.1)

◎: 第一推荐 ○: 第二推荐