

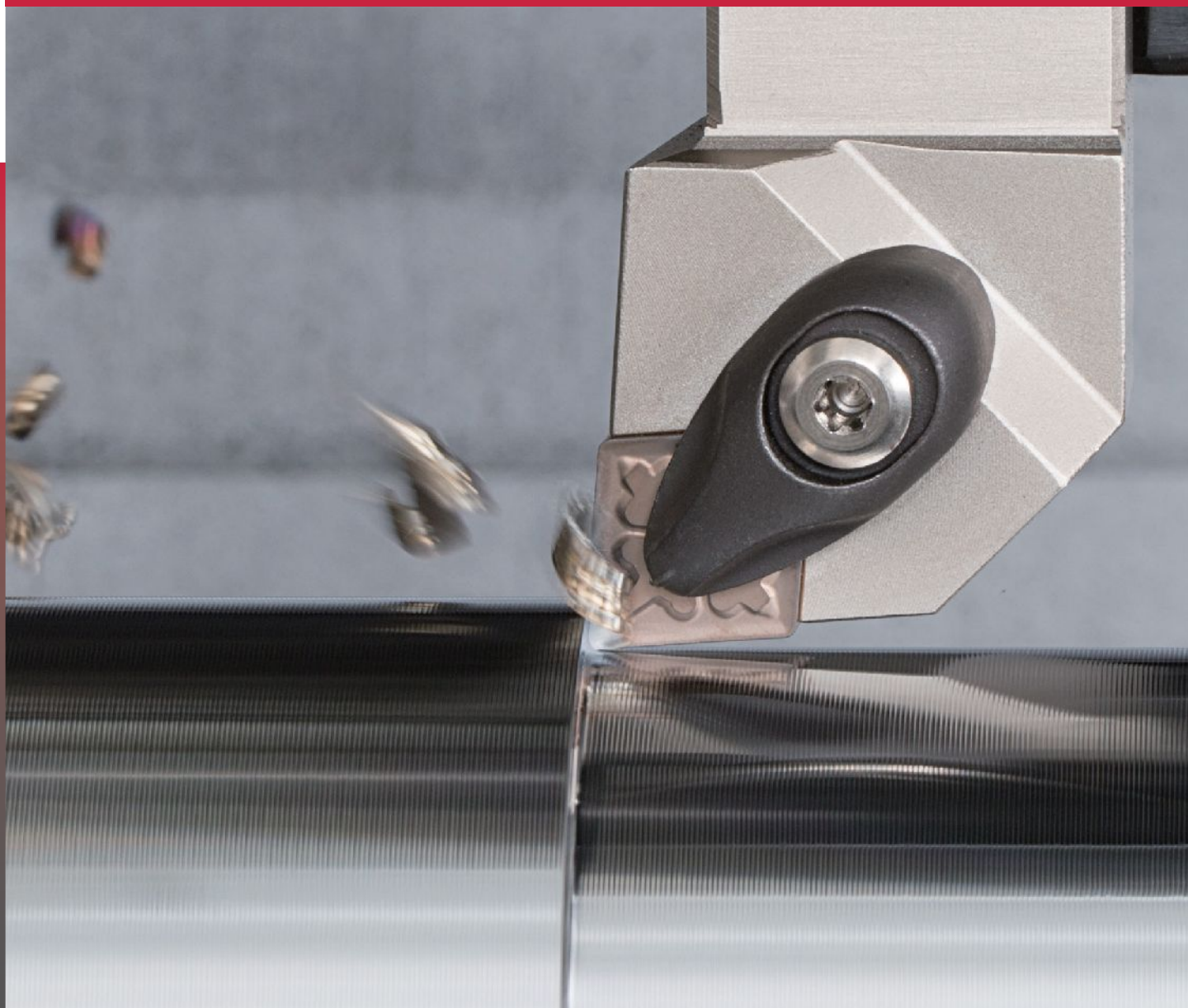


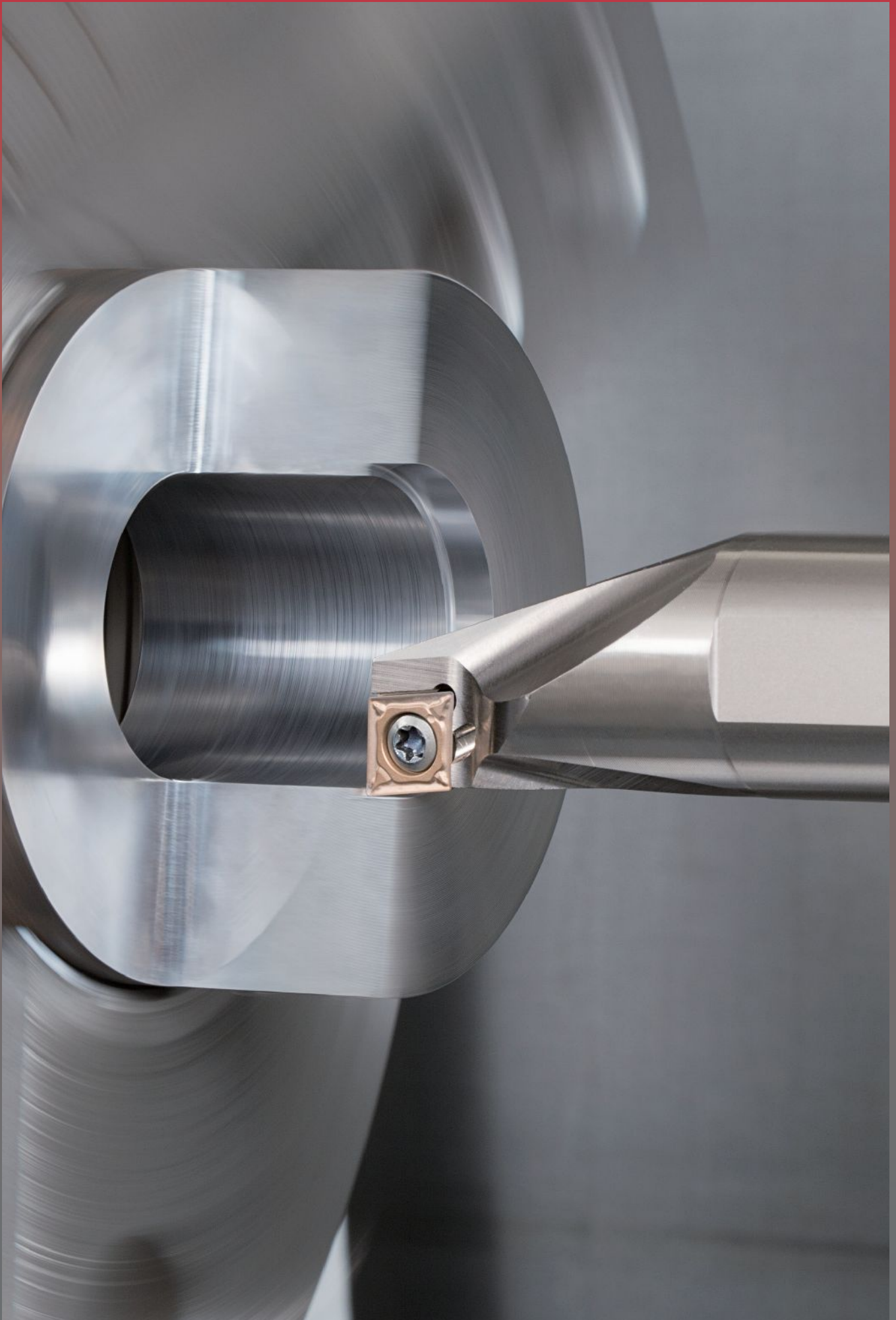
钢件加工材质

T9200 SERIES

Tungaloy Report No. 513-C

T9200 系列 - 新一代钢件车削 CVD 材质







T9200 SERIES



新一代 CVD 材质
适用于钢件车削的完整系列，性能出色，助力倍速加工

T9200 SERIES

T9200 系列现新增 T9205 与 T9235 型号，进一步完善了泰珂洛新一代 CVD 材质系列的产品线，可进一步提升您的加工效率。

PREMIUMTEC

TUNGALOY

采用新型表面处理技术，使 T9200 系列难以崩刃

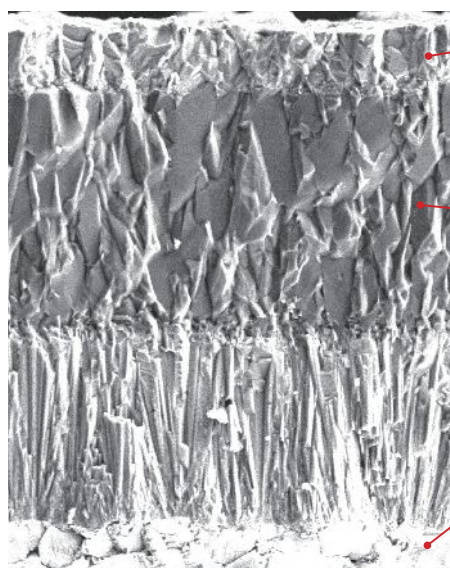
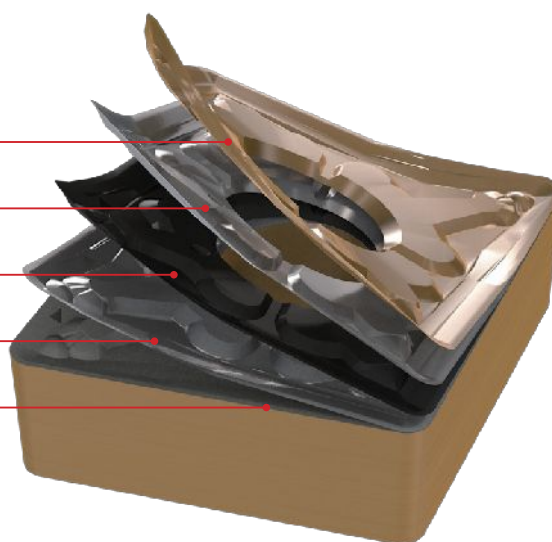
最外层

Ti-层

Al₂O₃

钛化合物

特殊设计的基体



硬质外层

新研发的高耐磨涂层，具有卓越的抗后刀面磨损能力。

厚氧化铝层，具备优异的耐高温和抗月牙洼磨损性能，尤其适用于高速加工。

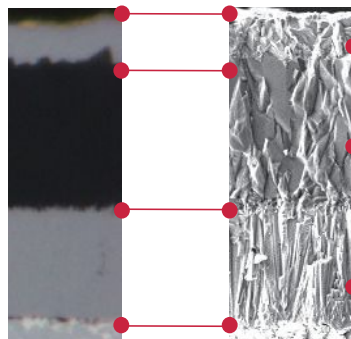
新型硬质合金基体

专为T9200系列设计，显著减少合金缺陷，从而大幅提升抗断裂能力

■ 优异的抗月牙洼磨损性能

耐磨性增强的 Al_2O_3 涂层

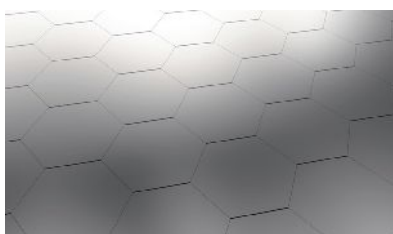
T9200 SERIES



Ti-层

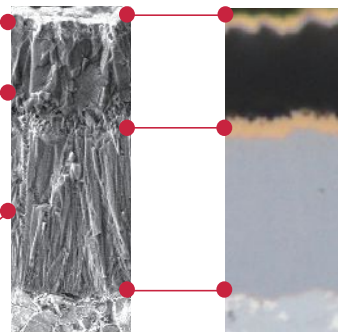
Al_2O_3

钛化合物



高度均匀的氧化铝结构

传统材质



氧化铝表面形貌

■ 出色的抗后刀面磨损性能

T9200 系列提供了出色的抗后刀面磨损性能!

T9200 SERIES



长刀具寿命与稳定的刀具寿命

延长刀具寿命，实现高速高进给下的稳定加工

减少机床停机时间，降低成本，提高生产率

现有



后刀面磨损加剧会导致微小崩刃和积屑瘤

断裂

T9200 SERIES

PREMIUMTEC

TUNGALOY

■ 出色的抗断裂性能，得益于新型改进的表面涂层处理技术

独特的强韧涂层处理技术，可在加工过程中防止裂纹产生，实现稳定加工

新技术的优势

新型改进表面处理技术的效果，可延长刀片的刀具寿命

T9200 SERIES

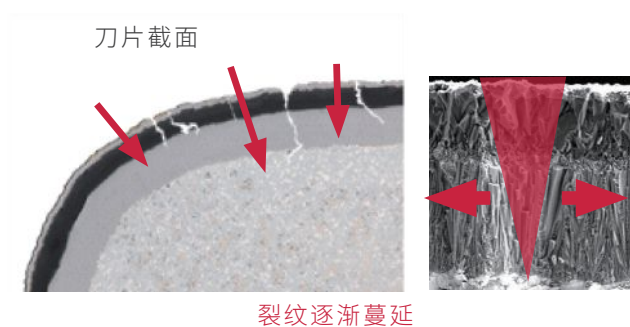
Vs.

传统材质

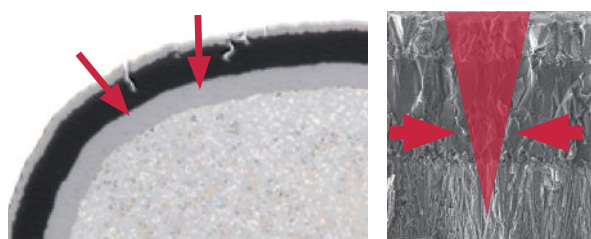
抑制裂纹的产生与发展



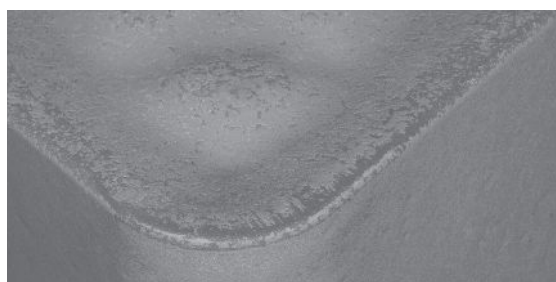
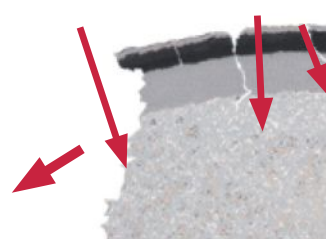
涂层中出现裂纹。裂纹扩展



抑制裂纹扩展



断裂



结果：加工稳定！

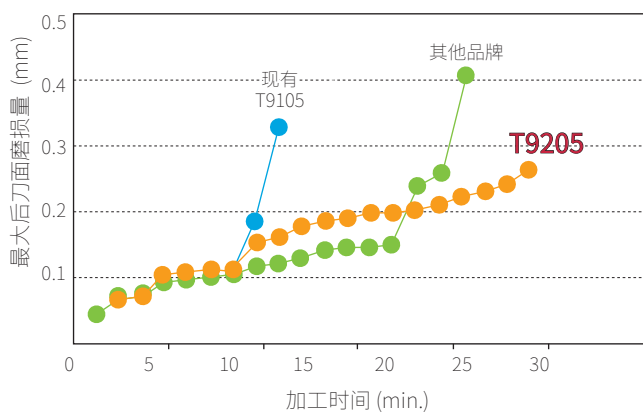


切削性能

T9205

P S45C / C45 (245HB)

T9205 凭借其耐磨性，提供比其他品牌材质更长的刀具寿命



T9205

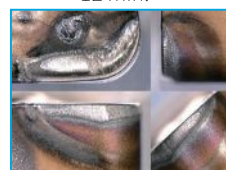
24 min.



其他品牌
18 min.



现有 T9105
12 min.

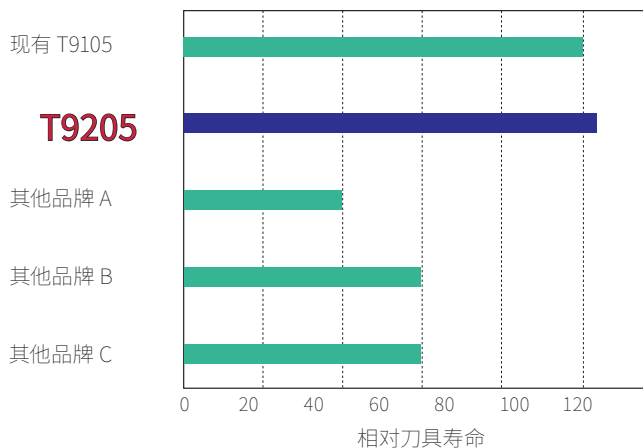


刀片
切削速度
进给
切削深度
应用
冷却

: CNMG120408-...
: $V_c = 300 \text{ m/min}$
: $f = 0.25 \text{ mm/rev}$
: $a_p = 2 \text{ mm}$
: 连续切削
: 湿式

P S45C / C45

T9205 提供优于竞品材质的抗断裂性



刀片
切削速度
进给
切削深度
应用
冷却

: CNMG120408-...
: $V_c = 150 \text{ m/min}$
: $f = 0.15 \text{ mm/rev}$
: $a_p = 2 \text{ mm}$
: 断续切削
: 湿式

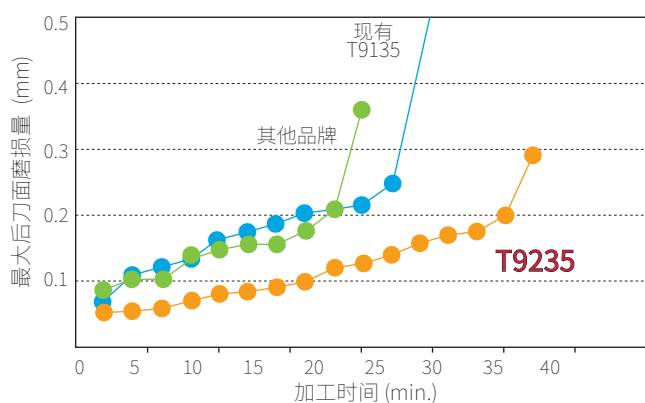
T9200 SERIES

切削性能

T9235

P S45C / C45 (245HB)

T9235 凭借卓越的耐磨性，提供了比竞品材质更长且更稳定的刀具寿命



T9235

32 min.



刀片
切削速度
进给
切削深度
应用
冷却

: CNMG120408-...
: $V_c = 250 \text{ m/min}$
: $f = 0.3 \text{ mm/rev}$
: $a_p = 2 \text{ mm}$
: 连续切削
: 湿式

其他品牌
20 min.

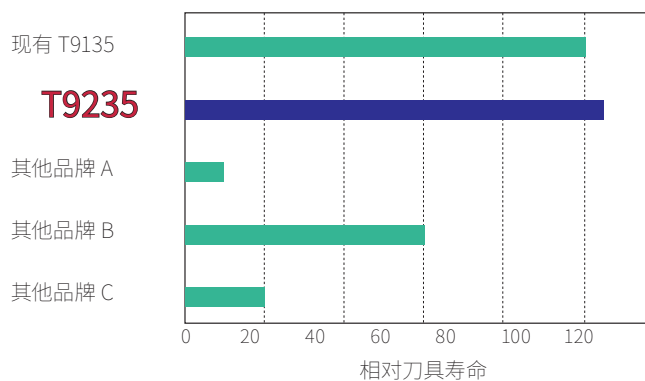


现有 T9135
24 min.



P S45C / C45

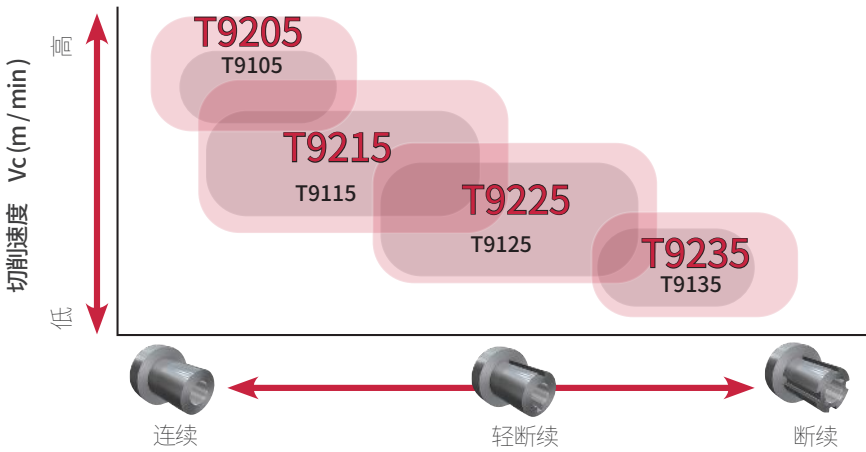
T9235 展现出优于竞品材质的抗断裂性能



刀片
切削速度
进给
切削深度
应用
冷却

: CNMG120408-...
: $V_c = 160 \text{ m/min}$
: $f = 0.2 \text{ mm/rev}$
: $a_p = 2.5 \text{ mm}$
: 断续切削
: 湿式

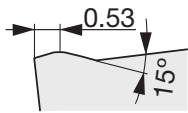
应用范围



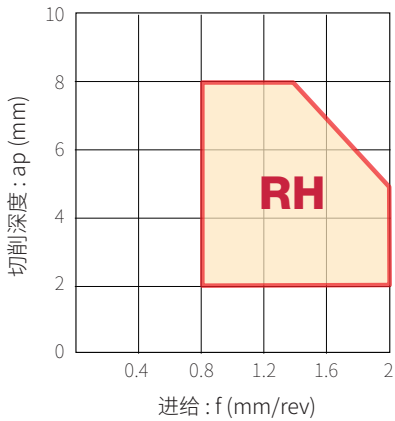
应用	材质	基体			涂层	
		比重	硬度 (HRA)	T.R.S. (GPa)	主要成分	厚度 (μm)
P	T9205	14.2	91.5	2.4	钛化合物 + Al_2O_3	18
	T9215	14.0	90.5	2.6	钛化合物 + Al_2O_3	18
	T9225	13.8	89.8	2.7	钛化合物 + Al_2O_3	18
	T9235	13.6	89	2.7	钛化合物 + Al_2O_3	18

■ 新型断屑槽几何形状，适用于铁路车轮和重型加工

新 RH 槽型适用于 RCMX3209M0 刀片



- 具有强化切削刃的断屑槽
- 坚固的切削刃设计带来高可靠性
- 即使在铁路车轮和重型加工条件下也无断裂



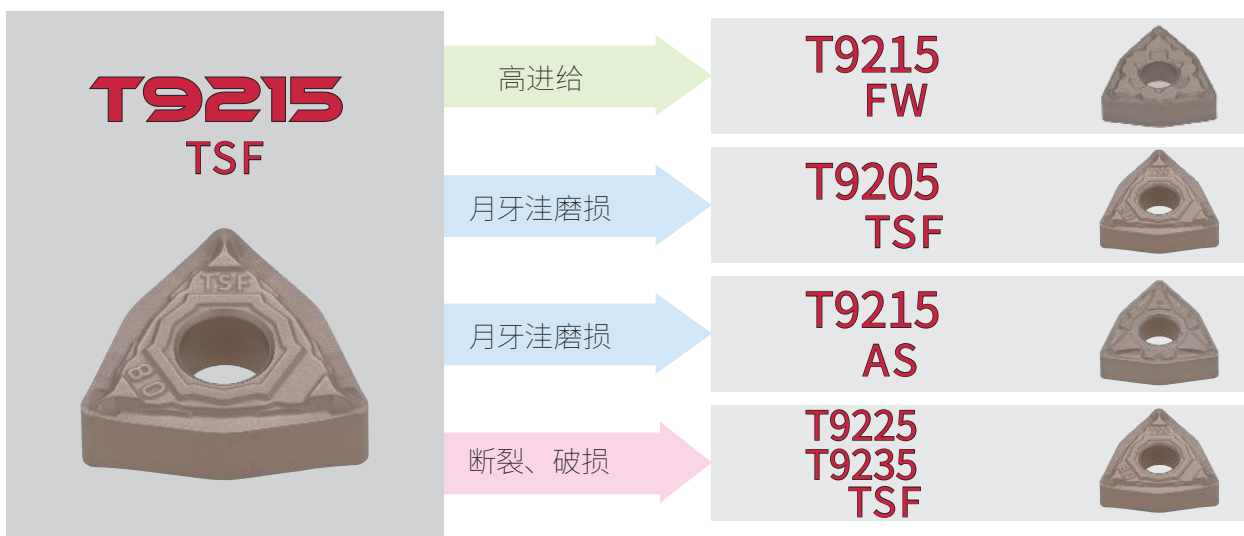
T9200 SERIES

选型指南

负角型

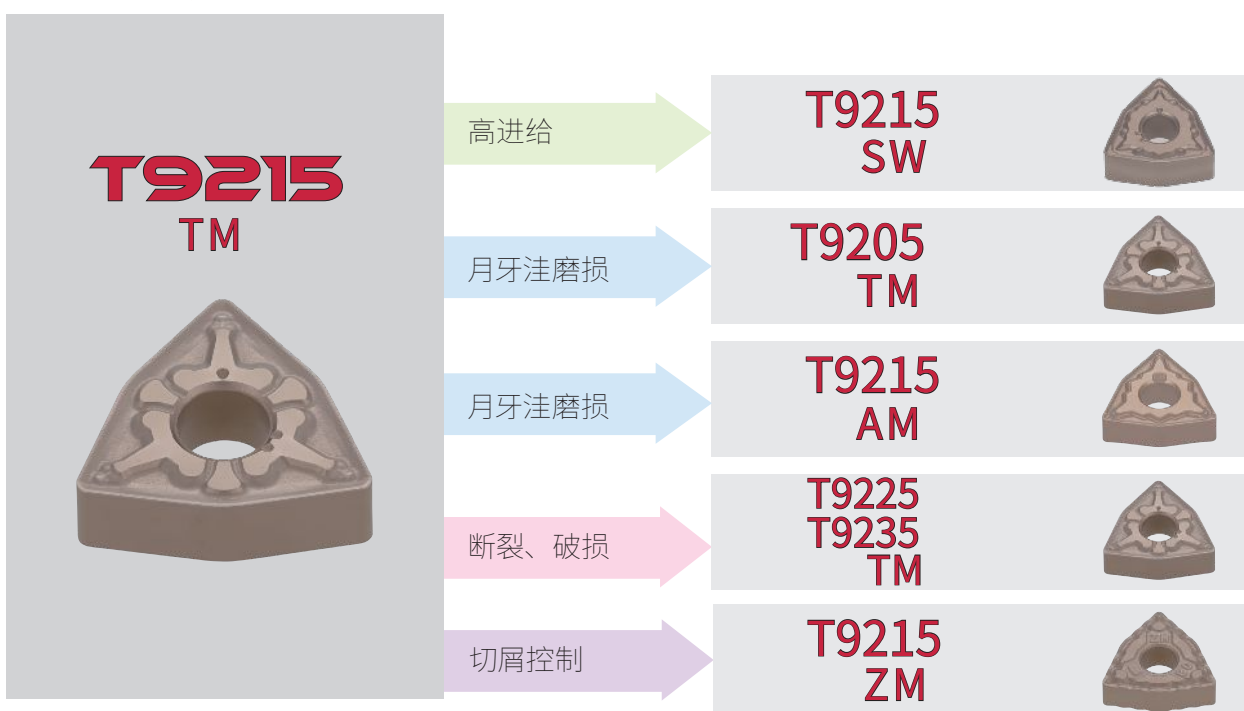
- 用于精加工 ($ap = 0.3 - 1.5 \text{ mm}$)

首选推荐



- 用于精加工到半精加工 ($ap = 1 - 4 \text{ mm}$)

首选推荐

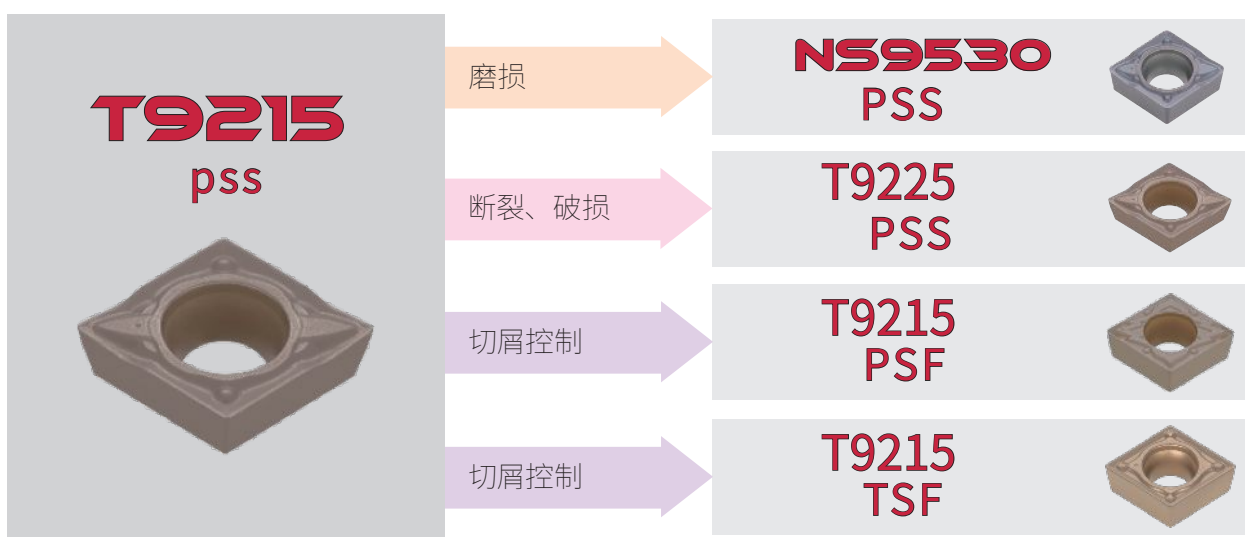


选型指南

正角型

- 用于精加工 ($a_p = 0.1 - 0.5 \text{ mm}$)

首选推荐



- 适用于精加工到半精加工 ($a_p = 0.5 - 2.5 \text{ mm}$)

首选推荐



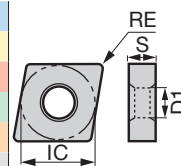
刀片 负角型

CN



菱形, 80°
有孔

P	钢	●	●●	●●	●●	●●		
M	不锈钢		●●					
K	铸铁	●●	●●					
N	非铁金属							
S	高温合金							
H	烧结合金							

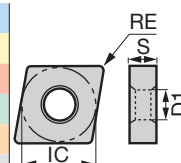
[illegible]

●:在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



菱形, 80°
有孔

[illegible]

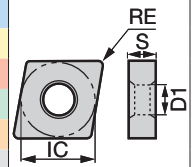
* 请参阅使用 SW/FW 进行圆弧或锥度加工的加工程序调整说明

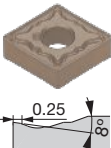
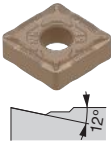
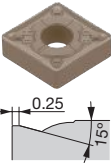
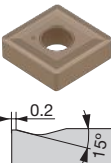
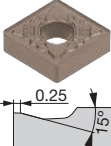
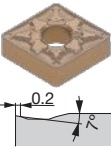


●:在庫

刀片 负角型

CN

[illegible]

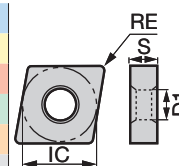
应用	断屑槽	型号	涂层																尺寸 (mm)			
			T9205	T9215	T9225	T9235													RE	IC	S	D1
半精加工	AM	CNMG120408-AM		●	●														0.8	12.7	4.76	5.16
		CNMG120412-AM		●	●														1.2	12.7	4.76	5.16
		CNMG120416-AM		●	●														1.6	12.7	4.76	5.16
	NM	CNMG120408-NM	●	●	●	●													0.8	12.7	4.76	5.16
		CNMG120412-NM		●	●	●													1.2	12.7	4.76	5.16
	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
		CNMG120416-DM		●	●														1.6	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
CM	CNMG120404-CM	●	●															0.4	12.7	4.76	5.16	
	CNMG120408-CM	●	●															0.8	12.7	4.76	5.16	
	CNMG120412-CM	●	●															1.2	12.7	4.76	5.16	
	CNMG160608-CM	●	●															0.8	15.875	6.35	6.35	
	CNMG160612-CM	●	●															1.2	15.875	6.35	6.35	
PM	CNMG120404-PM		●	●														0.4	12.7	4.76	5.16	
	CNMG120408-PM		●	●														0.8	12.7	4.76	5.16	
	CNMG120412-PM		●	●														1.2	12.7	4.76	5.16	
	CNMG120416-PM		●	●														1.6	12.7	4.76	5.16	

14

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



菱形, 80°
有孔

[illegible]

半精加工(修光刃)

半精加工

* 请参阅使用 SW/FW 进行圆弧或锥度加工的加工程序调整说明



●: 在庫

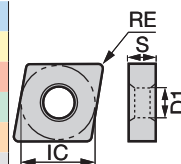
- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削

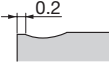
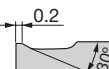
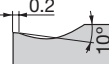
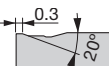
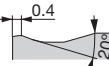
CN



菱形, 80°
有孔

P	钢	●	●●	●●	●●	●●		
M	不锈钢		●●					
K	铸铁	●●	●●					
N	非铁金属							
S	高温合金							
H	烧结合金							



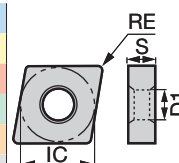
应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
半精加工	33	CNMG120416-33	●				1.6	12.7	4.76	5.16
		CNMG160612-33	●				1.2	15.875	6.35	6.35
		CNMG190612-33	●				1.2	19.05	6.35	7.93
	37	CNMG120404-37	●				0.4	12.7	4.76	5.16
		CNMG120408-37	● ●				0.8	12.7	4.76	5.16
		CNMG120412-37	●				1.2	12.7	4.76	5.16
										
	38	CNMG120408-38	●				0.8	12.7	4.76	5.16
										
半精加工至重载切削										
	TH	CNMG120408-TH	● ● ● ●				0.8	12.7	4.76	5.16
		CNMG120412-TH	● ● ● ●				1.2	12.7	4.76	5.16
		CNMG120416-TH	● ● ● ●				1.6	12.7	4.76	5.16
		CNMG160612-TH	● ● ● ●				1.2	15.875	6.35	6.35
		CNMG160616-TH	● ● ● ●				1.6	15.875	6.35	6.35
		CNMG190612-TH	● ● ● ●				1.2	19.05	6.35	7.93
		CNMG190616-TH	● ● ● ●				1.6	19.05	6.35	7.93
	THS	CNMG120408-THS	● ● ● ●				0.8	12.7	4.76	5.16
		CNMG120412-THS	● ● ● ●				1.2	12.7	4.76	5.16
		CNMG120416-THS	● ● ● ●				1.6	12.7	4.76	5.16
		CNMG160612-THS	● ● ● ●				1.2	15.875	6.35	6.35
		CNMG160616-THS	● ● ● ●				1.6	15.875	6.35	6.35
		CNMG190612-THS	● ● ● ●				1.2	19.05	6.35	7.93
		CNMG190616-THS	● ● ● ●				1.6	19.05	6.35	7.93
		CNMG190624-THS	● ● ● ●				2.4	19.05	6.35	7.93
		CNMG250924-THS	● ● ● ●				2.4	25.4	9.52	9.12

●:在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



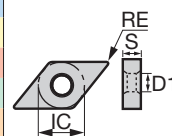
菱形, 80°
有孔

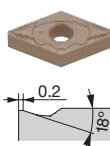
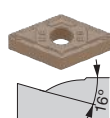
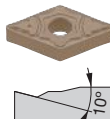
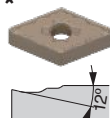
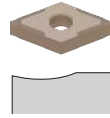
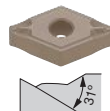
[illegible]

●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削

 菱形, 55°
有孔



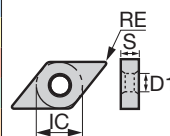
应用	断屑槽	型号	涂层																尺寸 (mm)			
			T9205	T9215	T9225	T9235													RE	IC	S	D1
精加工	AS	DNMG150404-AS	●		●														0.4	12.7	4.76	5.16
		DNMG150408-AS	●	●	●														0.8	12.7	4.76	5.16
		DNMG150412-AS	●	●	●														1.2	12.7	4.76	5.16
		DNMG150604-AS	●																0.4	12.7	6.35	5.16
		DNMG150608-AS	●	●															0.8	12.7	6.35	5.16
		DNMG150612-AS	●																1.2	12.7	6.35	5.16
	NS	DNMG150404-NS			●														0.4	12.7	4.76	5.16
		DNMG150408-NS	●	●	●														0.8	12.7	4.76	5.16
	TS	DNMG110402E-TS	●	●															0.2	9.525	4.76	3.81
		DNMG110404E-TS	●	●															0.4	9.525	4.76	3.81
		DNMG110408E-TS	●	●															0.8	9.525	4.76	3.81
		DNMG150402-TS	●	●															0.2	12.7	4.76	5.16
		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
DNMG150602-TS		●	●															0.2	12.7	6.35	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 (修光刃)	FW	DNMG110404E-FW	●															0.4	9.525	4.76	3.81	
		DNMG110408E-FW	●															0.8	9.525	4.76	3.81	
		DNMG150404-FW	●															0.4	12.7	4.76	5.16	
		DNMG150408-FW	●															0.8	12.7	4.76	5.16	
		DNMG150604-FW	●															0.4	12.7	6.35	5.16	
		DNMG150608-FW	●															0.8	12.7	6.35	5.16	
精加工	11	DNMG150408-11	●															0.8	12.7	4.76	5.16	
																						
镗孔 (双面)	CB	DNMG110408-CB	●															0.8	9.525	4.76	3.81	
																						

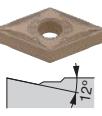
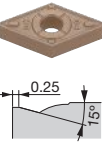
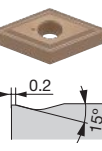
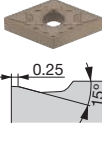
●: 在庫



- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削

 菱形, 55°
有孔



应用	断屑槽	型号	涂层																				尺寸 (mm)					
			T9205	T9215	T9225	T9235																			RE	IC	S	D1
半精加工		NM DNMG150408-NM	●	●	●	●																			0.8	12.7	4.76	5.16
		DNMG150412-NM	●	●	●	●																			1.2	12.7	4.76	5.16
		DM DNMG150404-DM		●	●																				0.4	12.7	4.76	5.16
		DNMG150408-DM		●	●	●																			0.8	12.7	4.76	5.16
		DNMG150412-DM	●	●	●	●																			1.2	12.7	4.76	5.16
		DNMG150416-DM		●	●																				1.6	12.7	4.76	5.16
		DNMG150604-DM		●	●																				0.4	12.7	6.35	5.16
		DNMG150608-DM		●	●	●																			0.8	12.7	6.35	5.16
		DNMG150612-DM	●	●	●	●																			1.2	12.7	6.35	5.16
		DNMG150616-DM	●	●	●																				1.6	12.7	6.35	5.16
精加工到半精加工		全周 DNMG110404		●	●																			0.4	9.525	4.76	3.81	
		DNMG110408	●	●	●	●																		0.8	9.525	4.76	3.81	
		DNMG150404		●	●	●																		0.4	12.7	4.76	5.16	
		DNMG150408	●	●	●	●																		0.8	12.7	4.76	5.16	
		DNMG150412	●	●	●	●																		1.2	12.7	4.76	5.16	
		DNMG150416		●	●																			1.6	12.7	4.76	5.16	
		DNMG150604		●	●																			0.4	12.7	6.35	5.16	
		DNMG150608	●	●	●	●																		0.8	12.7	6.35	5.16	
		DNMG150612	●	●	●	●																		1.2	12.7	6.35	5.16	
		DNMG150616		●	●																			1.6	12.7	6.35	5.16	
半精加工		CM DNMG150404-CM	●	●																			0.4	12.7	4.76	5.16		
		DNMG150408-CM	●	●																			0.8	12.7	4.76	5.16		
		DNMG150412-CM	●	●																								

●: 在庫

* 请参阅使用 SW/FW 进行圆弧或锥度加工的加工程序调整说明

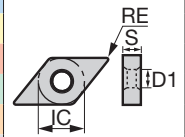


刀片 负角型

DN

 菱形, 55°
有孔

P	钢	●	●●	●●	✱		
M	不锈钢		●●				
K	铸铁	●●	●●				
N	非铁金属						
S	高温合金						
H	烧结合金						

[illegible]

●: 在庫

- : 连续切削
- : 轻断续切削
- ✱: 强断续切削

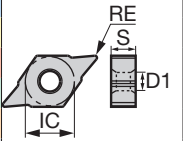
刀片 负角型

FN



菱形, 45°
有孔

P	钢	●	●●	●●	✱	
M	不锈钢		●●			
K	铸铁	●●	●●			
N	非铁金属					
S	高温合金					
H	烧结合金					



应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
精加工		TSF FNMG110402E-TSF	●	●			0.2	9.525	4.76	3.81
		FNMG110404E-TSF	●	●			0.4	9.525	4.76	3.81
		FNMG110408E-TSF	●	●			0.8	9.525	4.76	3.81
		FNMG110412E-TSF	●	●			1.2	9.525	4.76	3.81
半精加工		TM FNMG110404E-TM	●	●			0.4	9.525	4.76	3.81
		FNMG110408E-TM	●	●			0.8	9.525	4.76	3.81
		FNMG110412E-TM	●	●			1.2	9.525	4.76	3.81

确保在更换刀片后偏移切削刃位置。
请注意, 当使用 FNMG 刀片配合 Q 型刀杆对工件直径 50 毫米或更小的部位进行凹槽加工时, 刀片垫片可能会与工件发生干涉。

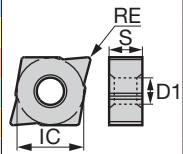
●: 在庫

GN



菱形, 70°
有孔

P	钢	●	●●	●●	✱	
M	不锈钢		●●			
K	铸铁	●●	●●			
N	非铁金属					
S	高温合金					
H	烧结合金					



应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
精加工		TSF GNMG090402E-TSF	●	●			0.2	9.525	4.76	3.81
		GNMG090404E-TSF	●	●			0.4	9.525	4.76	3.81
		GNMG090408E-TSF	●	●			0.8	9.525	4.76	3.81
半精加工		TM GNMG090404E-TM	●	●			0.4	9.525	4.76	3.81
		GNMG090408E-TM	●	●			0.8	9.525	4.76	3.81
		GNMG090412E-TM	●	●			1.2	9.525	4.76	3.81

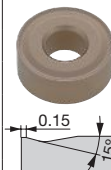
确保在更换刀片后偏移切削刃位置
请勿将 ISO-EcoTurn 刀头套件 (AD-CL-4/3-SET 或 -SET-S) 用于 CNMG09 规格的刀杆, 与 GNMG09 刀片配合使用
加工过程中刀片可能会发生移动。

●: 在庫

T9200 SERIES

刀片 负角型

●: 连续切削
●: 轻断续切削
✱: 强断续切削

应用		断屑槽	型号	涂层																尺寸 (mm)			
				T9205	T9215	T9225	T9235													RE	IC	S	D1
重载切削		61	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

●: 在庫

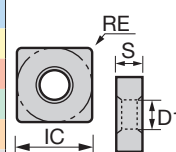
应用		断屑槽	型号	涂层																尺寸 (mm)			
				T9205	T9215	T9225	T9235													RE	IC	S	D1
精加工		TF	SNMG120402-TF	●	●															0.2	12.7	4.76	5.16
			SNMG120404-TF	●	●															0.4	12.7	4.76	5.16
			SNMG120408-TF	●	●															0.8	12.7	4.76	5.16
		TSF	SNMG120402-TSF	●	●															0.2	12.7	4.76	5.16
			SNMG120404-TSF	●	●															0.4	12.7	4.76	5.16
			SNMG120408-TSF	●	●															0.8	12.7	4.76	5.16
			SNMG120412-TSF	●	●															1.2	12.7	4.76	5.16

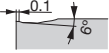
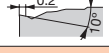
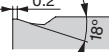
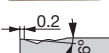
●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



方形
有孔

[illegible]

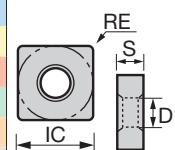
应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
精加工	PS	SNMG120402-PS	●	●			0.2	12.7	4.76	5.16
		SNMG120404-PS	●	●			0.4	12.7	4.76	5.16
		SNMG120408-PS	●	●			0.8	12.7	4.76	5.16
		SNMG120412-PS	●	●			1.2	12.7	4.76	5.16
										
低碳钢精加工	ZF	SNMG120402-ZF	●	●			0.2	12.7	4.76	5.16
		SNMG120404-ZF	●	●			0.4	12.7	4.76	5.16
		SNMG120408-ZF	●	●			0.8	12.7	4.76	5.16
		SNMG120412-ZF	●	●			1.2	12.7	4.76	5.16
										
精加工	AS	SNMG120408-AS	●	●			0.8	12.7	4.76	5.16
										
										
	NS	SNMG120408-NS	●	●			0.8	12.7	4.76	5.16
										
										
	TS	SNMG120402-TS	●	●			0.2	12.7	4.76	5.16
		SNMG120404-TS	●	●			0.4	12.7	4.76	5.16
	SNMG120408-TS	●	●	●	●	0.8	12.7	4.76	5.16	
	SNMG120412-TS	●	●	●		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

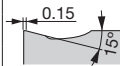
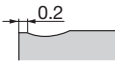
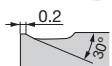
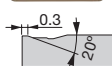
●:在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



方形
有孔



应用	断屑槽	型号	涂层																				尺寸 (mm)						
			T9205	T9215	T9225	T9235																			RE	IC	S	D1	
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	
																													
	S	SNMG120404R-S		●	●																				0.4	12.7	4.76	5.16	
		SNMG120404L-S		●	●																				0.4	12.7	4.76	5.16	
		SNMG120408R-S		●	●																				0.8	12.7	4.76	5.16	
		SNMG120408L-S		●	●																				0.8	12.7	4.76	5.16	
																													
	27	SNMG120408-27		●																						0.8	12.7	4.76	5.16
		SNMG120412-27		●																						1.2	12.7	4.76	5.16
																													
	33	SNMG120408-33		●	●																					0.8	12.7	4.76	5.16
	SNMG120412-33			●																					1.2	12.7	4.76	5.16	
	SNMG150612-33		●	●																					1.2	15.875	6.35	6.35	
	SNMG190616-33			●	●																				1.6	19.05	6.35	7.93	
																													
37	SNMG120408-37		●																						0.8	12.7	4.76	5.16	
	SNMG120412-37		●																						1.2	12.7	4.76	5.16	
																													
半精加工至重载切削	TH	SNMG120408-TH		●	●	●																			0.8	12.7	4.76	5.16	
		SNMG120412-TH		●	●	●																			1.2	12.7	4.76	5.16	
		SNMG150612-TH	●	●	●																				1.2	15.875	6.35	6.35	
		SNMG150616-TH	●	●	●																				1.6	15.875	6.35	6.35	
		SNMG190612-TH	●	●	●	●																			1.2	19.05	6.35	7.93	
		SNMG190616-TH	●	●	●	●																			1.6	19.05	6.35	7.93	

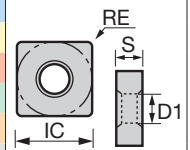
●:在庫

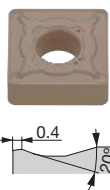
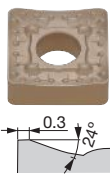
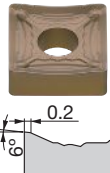
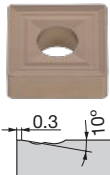
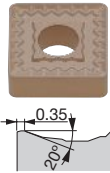
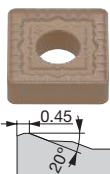
- : 连续切削
- ◐: 轻断续切削
- ⊗: 强断续切削

SN



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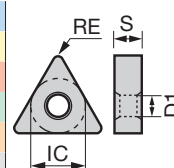
应用	断屑槽	型号	涂层				尺寸 (mm)							
			T9205	T9215	T9225	T9235	RE	IC	S	D1				
半精加工至重载切削	THS	SNMG120408-THS	●	●	●					0.8	12.7	4.76	5.16	
		SNMG120412-THS	●	●	●					1.2	12.7	4.76	5.16	
		SNMG150612-THS	●	●						1.2	15.875	6.35	6.35	
		SNMG150616-THS	●	●						1.6	15.875	6.35	6.35	
		SNMG190608-THS	●	●	●					0.8	19.05	6.35	7.93	
		SNMG190612-THS	●	●	●					1.2	19.05	6.35	7.93	
		SNMG190616-THS	●	●	●					1.6	19.05	6.35	7.93	
		SNMG190624-THS	●	●	●					2.4	19.05	6.35	7.93	
		SNMG250716-THS	●	●	●					1.6	25.4	7.94	9.12	
		SNMG250724-THS	●	●	●					2.4	25.4	7.94	9.12	
半精加工至重载切削 (单面)	TRS	SNMM150612-TRS	●	●	●					1.2	15.875	6.35	6.35	
		SNMM150616-TRS	●	●	●					1.6	15.875	6.35	6.35	
		SNMM190616-TRS	●	●	●					1.6	19.05	6.35	7.93	
		SNMM190624-TRS	●	●	●					2.4	19.05	6.35	7.93	
		SNMM250924-TRS	●	●	●					2.4	25.4	9.52	9.12	
半精加工至重载切削 (单面)	57	SNMM120408-57	●	●						0.8	12.7	4.76	5.16	
		SNMM150616-57		●						1.6	15.875	6.35	6.35	
		SNMM190612-57		●						1.2	19.05	6.35	7.93	
		65	SNMM190612-65		●					1.2	19.05	6.35	7.93	
		SNMM190624-65		●						2.4	19.05	6.35	7.93	
SNMM310924-65			●						2.4	31.75	9.52	8.8		
中等至重载切削 (单面)	TU	SNMM190616-TU			●					1.6	19.05	6.35	7.93	
		SNMM190624-TU		●	●					2.4	19.05	6.35	7.93	
		SNMM250724-TU		●	●					2.4	25.4	7.94	9.12	
		SNMM250924-TU	●	●						2.4	25.4	9.52	9.12	
		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		

●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



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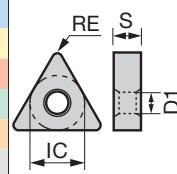
刀片 负角型

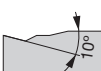
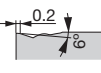
- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



三角形
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P	钢	●	●	●	✱	✱		
M	不锈钢		●	●				
K	铸铁	●	●	●				
N	非铁金属							
S	高温合金							
H	烧结合金							



应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
精加工	TS	TNMG110402E-TS	●	●			0.2	6.35	4.76	2.26
		TNMG110404E-TS	●	●			0.4	6.35	4.76	2.26
		TNMG110408E-TS	●	●			0.8	6.35	4.76	2.26
		TNMG160402-TS	●	●			0.2	9.525	4.76	3.81
		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
										
低碳钢精加工	17	TNMG160404-17		●			0.4	9.525	4.76	3.81
		TNMG160408-17		●			0.8	9.525	4.76	3.81
										
镗孔 (双面)	CB	TNMG110304-CB	●				0.4	6.35	3.18	2.26
		TNMG110308-CB	●				0.8	6.35	3.18	2.26
										
半精加工	TM	TNMG110304-TM	●	●	●	●	0.4	6.35	3.18	2.26
		TNMG110308-TM	●	●	●	●	0.8	6.35	3.18	2.26
		TNMG110404E-TM	●	●			0.4	6.35	4.76	2.26
		TNMG110408E-TM	●	●			0.8	6.35	4.76	2.26
		TNMG110412E-TM	●	●			1.2	6.35	4.76	2.26
		TNMG160404-TM	●	●	●		0.4	9.525	4.76	3.81
		TNMG160408-TM	●	●	●	●	0.8	9.525	4.76	3.81
		TNMG160412-TM	●	●	●	●	1.2	9.525	4.76	3.81
		TNMG160416-TM	●	●			1.6	9.525	4.76	3.81
		TNMG220404-TM	●	●			0.4	12.7	4.76	5.16
		TNMG220408-TM	●	●	●	●	0.8	12.7	4.76	5.16
		TNMG220412-TM	●	●	●	●	1.2	12.7	4.76	5.16
		TNMG220416-TM	●	●			1.6	12.7	4.76	5.16

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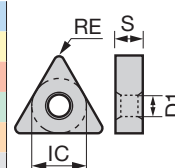
* 请参阅使用 SW/FW 进行圆弧或锥度加工的加工程序调整说明

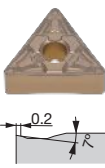
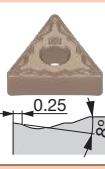
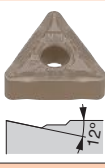
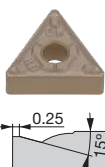


- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



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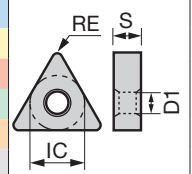
应用	断屑槽	型号	涂层																				尺寸 (mm)			
			T9205	T9215	T9225	T9235																RE	IC	S	D1	
半精加工	PM	TNMG110404E-PM	●	●																		0.4	6.35	4.76	2.26	
		TNMG110408E-PM	●	●																		0.8	6.35	4.76	2.26	
		TNMG110412E-PM	●	●																		1.2	6.35	4.76	2.26	
		TNMG160404-PM	●	●																		0.4	9.525	4.76	3.81	
		TNMG160408-PM	●	●																		0.8	9.525	4.76	3.81	
		TNMG160412-PM	●	●																		1.2	9.525	4.76	3.81	
		TNMG160416-PM	●	●																		1.6	9.525	4.76	3.81	
低碳钢半精加工	ZM	TNMG110404E-ZM	●	●																		0.4	6.35	4.76	2.26	
		TNMG110408E-ZM	●	●																		0.8	6.35	4.76	2.26	
		TNMG110412E-ZM	●	●																		1.2	6.35	4.76	2.26	
		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	
		TNMG160416-ZM	●	●																		1.6	9.525	4.76	3.81	
		TNMG220412-ZM		●																		1.2	12.7	4.76	5.16	
半精加工	AM	TNMG160408-AM	●	●																		0.8	9.525	4.76	3.81	
		TNMG160412-AM	●	●																		1.2	9.525	4.76	3.81	
	NM	TNMG160408-NM		●																		0.8	9.525	4.76	3.81	
		TNMG160412-NM		●	●																	1.2	9.525	4.76	3.81	
																										
		DM	TNMG160404-DM		●	●																	0.4	9.525	4.76	3.81
		TNMG160408-DM	●	●	●	●																0.8	9.525	4.76	3.81	
TNMG160412-DM			●	●																	1.2	9.525	4.76	3.81		
TNMG160416-DM			●	●																	1.6	9.525	4.76	3.81		

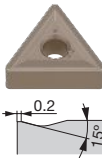
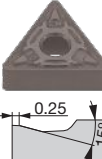
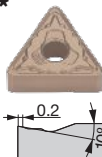
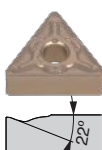
●:在庫

刀片 负角型

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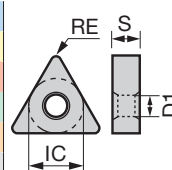
应用	断屑槽	型号	涂层				尺寸 (mm)				
			T9205	T9215	T9225	T9235	RE	IC	S	D1	
半精加工	全周	TNMG110304		●	●			0.4	6.35	3.18	2.26
		TNMG110308		●	●			0.8	6.35	3.18	2.26
		TNMG160404	●	●	●	●		0.4	9.525	4.76	3.81
		TNMG160408	●	●	●	●		0.8	9.525	4.76	3.81
		TNMG160412	●	●	●	●		1.2	9.525	4.76	3.81
		TNMG160416		●	●	●		1.6	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
	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	
半精加工 (修光刃)	* 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
半精加工	TQ	TNMG160404-TQ		●	●			0.4	9.525	4.76	3.81
		TNMG160408-TQ		●	●			0.8	9.525	4.76	3.81
											
	TA	TNMG160404-TA		●	●			0.4	9.525	4.76	3.81
			TNMG160408-TA		●	●			0.8	9.525	4.76
		TNMG160412-TA		●	●			1.2	9.525	4.76	3.81

●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊗: 强断续切削



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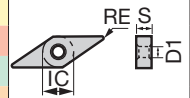
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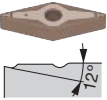
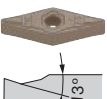
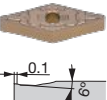
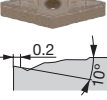
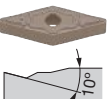
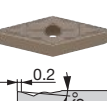
刀片 负角型

VN

菱形, 35°
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	P	M	K	N	S	H
钢	● ● ● ● ✖					
不锈钢		● ●				
铸铁	● ● ● ●					
非铁金属						
高温合金						
烧结合金						



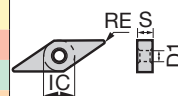
应用	断屑槽	型号	涂层																				尺寸 (mm)			
			T9205	T9215	T9225	T9235																RE	IC	S	D1	
精加工	TF	VNMG120402E-TF		●	●																	0.2	7.15	4.76	3.81	
		VNMG120404E-TF		●	●																	0.4	7.15	4.76	3.81	
		VNMG120408E-TF		●	●																	0.8	7.15	4.76	3.81	
		VNMG160402-TF		●	●																	0.2	9.525	4.76	3.81	
		VNMG160404-TF		●	●																	0.4	9.525	4.76	3.81	
		VNMG160408-TF		●	●																	0.8	9.525	4.76	3.81	
	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	
	PS	VNMG120402E-PS		●	●																	0.2	7.15	4.76	3.81	
		VNMG120404E-PS		●	●																	0.4	7.15	4.76	3.81	
		VNMG120408E-PS		●	●																	0.8	7.15	4.76	3.81	
VNMG160402-PS			●	●																	0.2	9.525	4.76	3.81		
VNMG160404-PS			●	●																	0.4	9.525	4.76	3.81		
VNMG160408-PS			●	●																	0.8	9.525	4.76	3.81		
VNMG160412-PS			●	●																	1.2	9.525	4.76	3.81		
低碳钢精加工	ZF	VNMG120402E-ZF		●	●																	0.2	7.15	4.76	3.81	
		VNMG120404E-ZF		●	●																	0.4	7.15	4.76	3.81	
		VNMG120408E-ZF		●	●																	0.8	7.15	4.76	3.81	
		VNMG160402-ZF		●	●																	0.25	9.525	4.76	3.81	
		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	
精加工	TS	VNMG120402E-TS		●	●																	0.2	7.15	4.76	3.81	
		VNMG120404E-TS		●	●																	0.4	7.15	4.76	3.81	
		VNMG120408E-TS		●	●																	0.8	7.15	4.76	3.81	
		VNMG160402-TS		●	●																	0.2	9.525	4.76	3.81	
		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	
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	
		VNMG120412E-TM		●	●																	1.2	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	

●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



菱形, 35°
有孔

[illegible]

●: 在庫

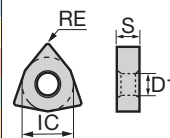
刀片 负角型

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



凸三角形, 80°
有孔

P	钢	●	●●	●●	●●	●●		
M	不锈钢		●●					
K	铸铁	●●	●●					
N	非铁金属							
S	高温合金							
H	烧结合金							



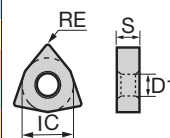
●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



凸三角形, 80°
有孔

P	钢		●	●●	C	*				
M	不锈钢			●●						
K	铸铁		●●	●●						
N	非铁金属									
S	高温合金									
H	烧结合金									



●: 在庫



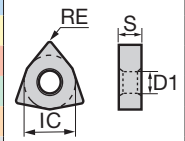
刀片 负角型

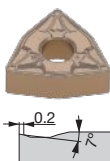
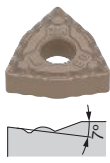
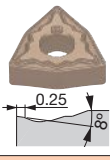
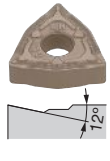
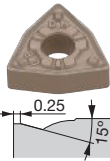
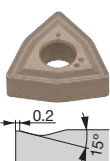
WN



凸三角形, 80°
有孔

P	钢	●	●	●	✱				
M	不锈钢		●	●					
K	铸铁	●	●	●					
N	非铁金属								
S	高温合金								
H	烧结合金								



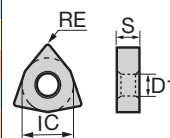
应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
半精加工	PM	WNMG060404E-PM	●	●			0.4	9.525	4.76	3.81
		WNMG060408E-PM	●	●			0.8	9.525	4.76	3.81
		WNMG060412E-PM	●	●			1.2	9.525	4.76	3.81
		WNMG080404-PM	●	●			0.4	12.7	4.76	5.16
		WNMG080408-PM	●	●			0.8	12.7	4.76	5.16
		WNMG080412-PM	●	●			1.2	12.7	4.76	5.16
		WNMG080416-PM	●	●			1.6	12.7	4.76	5.16
半精加工 用于低碳钢	ZM	WNMG060404E-ZM	●	●			0.4	9.525	4.76	3.81
		WNMG060408E-ZM	●	●			0.8	9.525	4.76	3.81
		WNMG060412E-ZM	●	●			1.2	9.525	4.76	3.81
		WNMG060408-ZM	●	●	●		0.8	9.525	4.76	3.81
		WNMG060412-ZM	●	●	●		1.2	9.525	4.76	3.81
		WNMG080404-ZM	●	●			0.4	12.7	4.76	5.16
		WNMG080408-ZM	●	●			0.8	12.7	4.76	5.16
		WNMG080412-ZM	●	●	●		1.2	12.7	4.76	5.16
		WNMG080416-ZM	●	●			1.6	12.7	4.76	5.16
AM	WNMG080408-AM	●	●			0.8	12.7	4.76	5.16	
		WNMG080412-AM	●	●			1.2	12.7	4.76	5.16
		WNMG080416-AM	●	●			1.6	12.7	4.76	5.16
NM	WNMG060412E-NM		●			1.2	9.525	4.76	3.81	
		WNMG080408-NM	●	●	●		0.8	12.7	4.76	5.16
		WNMG080412-NM	●	●	●	●	1.2	12.7	4.76	5.16
DM	WNMG080404-DM	●	●			0.4	12.7	4.76	5.16	
		WNMG080408-DM	●	●	●	●	0.8	12.7	4.76	5.16
		WNMG080412-DM	●	●	●	●	1.2	12.7	4.76	5.16
		WNMG080416-DM	●	●			1.6	12.7	4.76	5.16
全周	WNMG060404	●	●			0.4	9.525	4.76	3.81	
		WNMG060408	●	●			0.8	9.525	4.76	3.81
		WNMG080404	●	●	●	●	0.4	12.7	4.76	5.16
		WNMG080408	●	●	●	●	0.8	12.7	4.76	5.16
		WNMG080412	●	●	●	●	1.2	12.7	4.76	5.16
		WNMG080416	●	●	●	●	1.6	12.7	4.76	5.16

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



凸三角形, 80°
有孔

P	钢	●	●C	C※	※		
M	不锈钢		●C				
K	铸铁	●C	●C				
N	非铁金属						
S	高温合金						
H	烧结合金						

[illegible]

●: 在庫

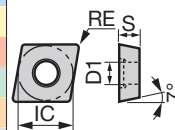
* 请参阅使用 SW/FW 进行圆弧或锥度加工的加工程序调整说明

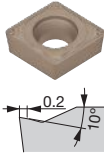
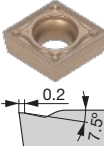
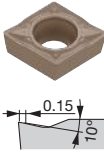
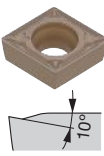
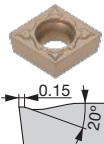


- : 连续切削
- ◐: 轻断续切削
- ⊗: 强断续切削

菱形, 80°
有孔
正 7°

P	钢	●	●	●	C※	※
M	不锈钢		●	●		
K	铸铁	●	●	●		
N	非铁金属					
S	高温合金					
H	烧结合金					

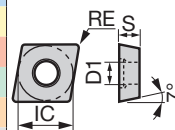


应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
精加工	PSF	CCMT060204-PSF	●	●			0.4	6.35	2.38	2.8
		CCMT09T304-PSF	●	●			0.4	9.525	3.97	4.4
		CCMT09T308-PSF	●	●			0.8	9.525	3.97	4.4
	PF	CCMT09T308-PF		●			0.8	9.525	3.97	4.4
										
	TSF	CCMT060202-TSF	●	●			0.2	6.35	2.38	2.8
		CCMT060204-TSF	●	●			0.4	6.35	2.38	2.8
CCMT060208-TSF		●	●			0.8	6.35	2.38	2.8	
CCMT09T302-TSF		●	●			0.2	9.525	3.97	4.4	
CCMT09T304-TSF		●	●			0.4	9.525	3.97	4.4	
CCMT09T308-TSF		●	●			0.8	9.525	3.97	4.4	
PSS	CCMT060204-PSS	●	●			0.4	6.35	2.38	2.8	
	CCMT060208-PSS	●	●			0.8	6.35	2.38	2.8	
	CCMT09T304-PSS	●	●			0.4	9.525	3.97	4.4	
	CCMT09T308-PSS	●	●			0.8	9.525	3.97	4.4	
	CCMT120404-PSS	●	●			0.4	12.7	4.76	5.5	
	CCMT120408-PSS	●	●			0.8	12.7	4.76	5.5	
	CCMT120412-PSS	●	●			1.2	12.7	4.76	5.5	
PS	CCMT060202-PS	●	●			0.2	6.35	2.38	2.8	
	CCMT060204-PS	●	●			0.4	6.35	2.38	2.8	
	CCMT060208-PS	●	●			0.8	6.35	2.38	2.8	
	CCMT09T302-PS	●	●			0.2	9.525	3.97	4.4	
	CCMT09T304-PS	●	●			0.4	9.525	3.97	4.4	
	CCMT09T308-PS	●	●			0.8	9.525	3.97	4.4	
	CCMT120404-PS	●	●			0.4	12.7	4.76	5.5	
	CCMT120408-PS	●	●			0.8	12.7	4.76	5.5	
	CCMT120412-PS	●	●			1.2	12.7	4.76	5.5	
TM	CCMT060202-TM	●	●			0.2	6.35	2.38	2.8	
	CCMT060204-TM	●	●			0.4	6.35	2.38	2.8	
	CCMT060208-TM	●	●			0.8	6.35	2.38	2.8	
	CCMT09T302-TM	●	●			0.2	9.525	3.97	4.4	
	CCMT09T304-TM	●	●			0.4	9.525	3.97	4.4	
	CCMT09T308-TM	●	●			0.8	9.525	3.97	4.4	

●:在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削

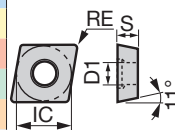
菱形, 80°
有孔
正 7°

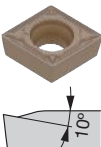
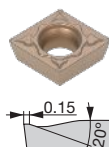
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应用	断屑槽	型号	涂层								尺寸 (mm)					
			T9205	T9215	T9225	T9235							RE	IC	S	D
精加工到半精加工	PSS	CPMT060204-PSS	●	●									0.4	6.35	2.38	2.8
		CPMT080204-PSS	●	●									0.4	7.94	2.38	3.4
		CPMT080208-PSS	●	●									0.8	7.94	2.38	3.4
		CPMT090304-PSS	●	●									0.4	9.525	3.18	4.4
		CPMT090308-PSS	●	●									0.8	9.525	3.18	4.4
		CPMT09T304-PSS	●	●									0.4	9.525	3.97	4.4
		CPMT09T308-PSS	●	●									0.8	9.525	3.97	4.4

●: 在庫

菱形, 80°
有孔
正 11°

[illegible]

应用	断屑槽	型号	涂层																尺寸 (mm)			
			T9205	T9215	T9225	T9235													RE	IC	S	DI
精加工到半精加工		PS CPMT060202-PS	●	●														0.2	6.35	2.38	2.8	
		CPMT060204-PS	●	●														0.4	6.35	2.38	2.8	
		CPMT060208-PS	●	●														0.8	6.35	2.38	2.8	
		CPMT080202-PS	●	●														0.2	7.94	2.38	3.4	
		CPMT080204-PS	●	●														0.4	7.94	2.38	3.4	
		CPMT080208-PS	●	●														0.8	7.94	2.38	3.4	
		CPMT090304-PS	●	●														0.4	9.525	3.18	4.4	
		CPMT090308-PS	●	●														0.8	9.525	3.18	4.4	
		CPMT09T302-PS	●	●														0.2	9.525	3.97	4.4	
		CPMT09T304-PS	●	●														0.4	9.525	3.97	4.4	
	CPMT09T308-PS	●	●														0.8	9.525	3.97	4.4		
		TM CPMT060202-TM	●	●														0.2	6.35	2.38	2.8	
		CPMT060204-TM	●	●														0.4	6.35	2.38	2.8	
		CPMT060208-TM	●	●														0.8	6.35	2.38	2.8	
CPMT09T302-TM		●	●														0.2	9.525	3.97	4.4		
CPMT09T304-TM		●	●														0.4	9.525	3.97	4.4		
CPMT09T308-TM		●	●														0.8	9.525	3.97	4.4		

●: 在庫

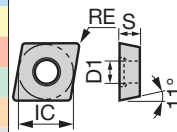
- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削

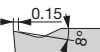
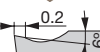
CP

菱形, 80°
有孔
正 11°



P	钢	●	●●	●●	●●	●●		
M	不锈钢		●●					
K	铸铁	●●	●●					
N	非铁金属							
S	高温合金							
H	烧结合金							

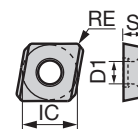


应用	断屑槽 型号	涂层												尺寸 (mm)			
		T9205	T9215	T9225	T9235									RE	IC	S	D ₁
半精加工	PM	CPMT060208-PM	●											0.8	6.35	2.38	2.8
		CPMT090304-PM	●											0.4	9.525	3.18	4.4
		CPMT090308-PM	●											0.8	9.525	3.18	4.4
																	
	24	CPMT080204-24	●											0.4	7.94	2.38	3.4
		CPMT080208-24	●											0.8	7.94	2.38	3.4
		CPMT090308-24	●											0.8	9.525	3.18	4.4
		CPMT160508-24	●											0.8	15.875	5.56	5.5

●: 在庫

CX

菱形, 80°
有孔

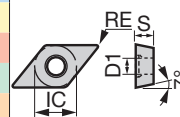
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应用	断屑槽	型号	涂层												尺寸 (mm)					
			T9205	T9215	T9225	T9235											RE	IC	S	D1
精加工到半精加工	TS	CXMU060302R-TS	●	●													0.2	6.35	3.18	2.7
		CXMU060302L-TS	●	●													0.2	6.35	3.18	2.7
		CXMU060304R-TS	●	●													0.4	6.35	3.18	2.7
		CXMU060304L-TS	●	●													0.4	6.35	3.18	2.7
		CXMU060308R-TS	●	●													0.8	6.35	3.18	2.7
		CXMU060308L-TS	●	●													0.8	6.35	3.18	2.7

●:在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削

菱形, 55°
有孔
正 7°

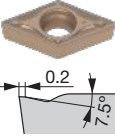
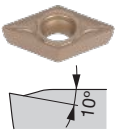
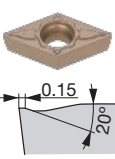
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●:在庫

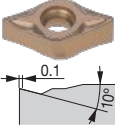
T9200 SERIES

刀片 正角型

- : 连续切削
- ◐: 轻断续切削
- ✱: 强断续切削

DP		P 钢	M 不锈钢	K 铸铁	N 非铁金属	S 高温合金	H 烧结合金																			尺寸 (mm)			
应用		断屑槽	型号	T9205	T9215	T9225	T9235																			RE	IC	S	D1
精加工	TSF		DPMT070202-TSF	●	●																					0.2	6.35	2.38	2.8
			DPMT070204-TSF	●	●																					0.4	6.35	2.38	2.8
			DPMT070208-TSF	●	●																					0.8	6.35	2.38	2.8
			DPMT11T302-TSF	●	●																					0.2	9.525	3.97	4.4
			DPMT11T304-TSF	●	●																					0.4	9.525	3.97	4.4
			DPMT11T308-TSF	●	●																					0.8	9.525	3.97	4.4
精加工到半精加工	PS		DPMT070202-PS	●	●																					0.2	6.35	2.38	2.8
			DPMT070204-PS	●	●																					0.4	6.35	2.38	2.8
			DPMT070208-PS	●	●																					0.8	6.35	2.38	2.8
			DPMT11T302-PS	●	●																					0.2	9.525	3.97	4.4
			DPMT11T304-PS	●	●																					0.4	9.525	3.97	4.4
			DPMT11T308-PS	●	●																					0.8	9.525	3.97	4.4
	TM		DPMT070202-TM	●	●																					0.2	6.35	2.38	2.8
			DPMT070204-TM	●	●																					0.4	6.35	2.38	2.8
			DPMT070208-TM	●	●																					0.8	6.35	2.38	2.8
			DPMT11T302-TM	●	●																					0.2	9.525	3.97	4.4
			DPMT11T304-TM	●	●																					0.4	9.525	3.97	4.4
			DPMT11T308-TM	●	●																					0.8	9.525	3.97	4.4

●: 在库

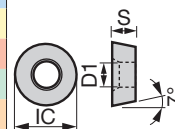
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应用		断屑槽	型号	T9205	T9215	T9225	T9235																			RE	IC	S	D1
精加工到半精加工	TS		DXMU070302R-TS	●	●																					0.2	6.35	3.18	2.7
			DXMU070302L-TS	●	●																					0.2	6.35	3.18	2.7
			DXMU070304R-TS	●	●																					0.4	6.35	3.18	2.7
			DXMU070304L-TS	●	●																					0.4	6.35	3.18	2.7
			DXMU070308R-TS	●	●																					0.8	6.35	3.18	2.7
			DXMU070308L-TS	●	●																					0.8	6.35	3.18	2.7

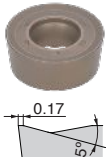
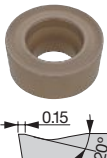
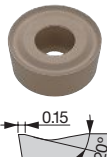
●: 在库

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



圓形，
有孔
正 7°

[illegible]

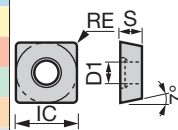
应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
精加工	RS	RCMT10T3M0-RS	●	●			-	10	3.97	4.4
		RCMT1204M0-RS	●	●			-	12	4.76	4.4
		RCMT1606M0-RS	●	●			-	16	6.35	5.5
		RCMT2006M0-RS		●			-	20	6.35	6.5
		RCMT2507M0-RS		●			-	25	7.94	7.6
6RS	RCMT1204M0-6RS	●	●			-	12	4.76	4.4	
										
精加工到半精加工	6RM	RCMT1204M0-6RM	●	●			-	12	4.76	4.4
										
61		RCMT0502M0-61	●	●			-	5	2.38	2.5
重载切削		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
	新	RH	RCMX3209M0-RH	●				-	32	9.52
										

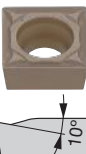
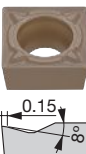
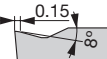
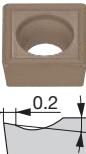
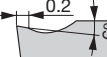
●:新产品
●:在庫

刀片 正角型

SC

方形
有孔
正 7°



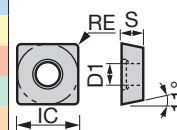
应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
精加工到半精加工		PS SCMT09T304-PS	●	●			0.4	9.525	3.97	4.4
		SCMT09T308-PS	●	●			0.8	9.525	3.97	4.4
		SCMT120404-PS	●	●			0.4	12.7	4.76	5.5
		SCMT120408-PS	●	●			0.8	12.7	4.76	5.5
										
		23 SCMT09T308-23		●			0.8	9.525	3.97	4.4
		SCMT120408-23		●			0.8	12.7	4.76	5.5
										
		半精加工		PM SCMT09T304-PM	●	●			0.4	9.525
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
										
	24 SCMT070204-24			●			0.4	7.94	2.38	3.4
	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
										

●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



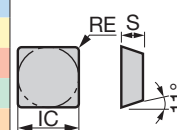
方形
有孔
正 11°

[illegible][illegible]

●: 在庫

方形
无孔
正 11°

P	钢		●	●●	●●	✱		
M	不锈钢			●●				
K	铸铁		●●	●●				
N	非铁金属							
S	高温合金							
H	烧结合金							

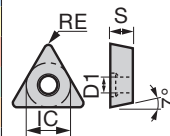


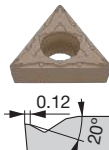
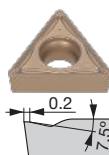
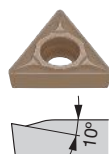
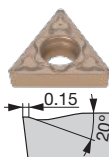
应用	断屑槽	型号	涂层												尺寸 (mm)				
			T9205	T9215	T9225	T9235											RE	IC	S
精加工到半精加工	23	SPMR090308-23		●												0.8	9.525	3.18	-
		SPMR120304-23		●												0.4	12.7	3.18	-
		SPMR120308-23		●												0.8	12.7	3.18	-
																			

●:在庫

刀片 正角型

TC
 三角形
 有孔
 正 7°

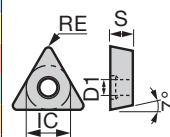


应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
精加工	PSF	TCMT090204-PSF	●	●			0.4	5.56	2.38	2.5
		TCMT110204-PSF	●	●			0.4	6.35	2.38	2.8
		TCMT110304-PSF	●	●			0.4	6.35	3.18	2.8
		TCMT16T304-PSF	●	●			0.4	9.525	3.97	4.4
	TSF	TCMT110204-TSF	●	●			0.4	6.35	2.38	2.8
		TCMT110208-TSF	●	●			0.8	6.35	2.38	2.8
		TCMT110302-TSF	●	●			0.2	6.35	3.18	2.8
		TCMT110304-TSF	●	●			0.4	6.35	3.18	2.8
		TCMT110308-TSF	●	●			0.8	6.35	3.18	2.8
		TCMT16T304-TSF	●	●			0.4	9.525	3.97	4.4
		TCMT16T308-TSF	●	●			0.8	9.525	3.97	4.4
	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	
PS	TCMT110202-PS	●	●			0.2	6.35	2.38	2.8	
	TCMT110204-PS	●	●			0.4	6.35	2.38	2.8	
	TCMT110208-PS	●	●			0.8	6.35	2.38	2.8	
	TCMT110302-PS	●	●			0.2	6.35	3.18	2.8	
	TCMT110304-PS	●	●			0.4	6.35	3.18	2.8	
	TCMT110308-PS	●	●			0.8	6.35	3.18	2.8	
	TCMT16T302-PS	●	●			0.2	9.525	3.97	4.4	
	TCMT16T304-PS	●	●			0.4	9.525	3.97	4.4	
	TCMT16T308-PS	●	●			0.8	9.525	3.97	4.4	
TM	TCMT110204-TM	●	●			0.4	6.35	2.38	2.8	
	TCMT110208-TM	●	●			0.8	6.35	2.38	2.8	
	TCMT110302-TM	●	●			0.2	6.35	3.18	2.8	
	TCMT110304-TM	●	●			0.4	6.35	3.18	2.8	
	TCMT110308-TM	●	●			0.8	6.35	3.18	2.8	
	TCMT16T304-TM	●	●			0.4	9.525	3.97	4.4	
	TCMT16T308-TM	●	●			0.8	9.525	3.97	4.4	

●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削

TC
 三角形
 有孔
 正 7°

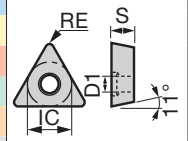
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●: 在庫

刀片 正角型

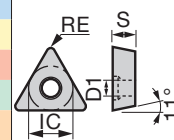
TP

三角形
有孔
正 11°

[illegible]

●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削

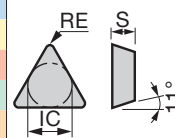
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应用	断屑槽	型号	涂层				尺寸 (mm)			
			T9205	T9215	T9225	T9235	RE	IC	S	D1
精加工到半精加工		TM TPMT110204-TM	●	●			0.4	6.35	2.38	2.8
		TPMT110208-TM	●	●			0.8	6.35	2.38	2.8
		TPMT110302-TM	●	●			0.2	6.35	3.18	3.4
		TPMT110304-TM	●	●			0.4	6.35	3.18	3.4
		TPMT110308-TM	●	●			0.8	6.35	3.18	3.4
		TPMT16T304-TM	●	●			0.4	9.525	3.97	4.4
		TPMT16T308-TM	●	●			0.8	9.525	3.97	4.4
		23 TPMT090204-23		●			0.4	5.56	2.38	2.5
		TPMT110204-23		●			0.4	6.35	2.38	2.8
		TPMT130304-23		●			0.4	7.94	3.18	3.4
		TPMT130308-23		●			0.8	7.94	3.18	3.4
		TPMT16T308-23		●			0.8	9.525	3.97	4.4
半精加工		PM TPMT110204-PM	●	●			0.4	6.35	2.38	2.8
		TPMT110208-PM	●	●			0.8	6.35	2.38	2.8
		TPMT110304-PM	●	●			0.4	6.35	3.18	3.4
		TPMT110308-PM	●	●			0.8	6.35	3.18	3.4
		TPMT130304-PM		●			0.4	7.94	3.18	3.4
		TPMT130308-PM		●			0.8	7.94	3.18	3.4
		TPMT16T304-PM		●			0.4	9.525	3.97	4.4
		TPMT16T308-PM		●			0.8	9.525	3.97	4.4
		TPMT16T312-PM		●			1.2	9.525	3.97	4.4
		24 TPMT090204-24		●			0.4	5.56	2.38	2.5
		TPMT110204-24		●			0.4	6.35	2.38	2.8
		TPMT130304-24		●			0.4	7.94	3.18	3.4
		TPMT130308-24		●			0.8	7.94	3.18	3.4
		TPMT16T304-24		●			0.4	9.525	3.97	4.4
		TPMT16T308-24		●			0.8	9.525	3.97	4.4

●:在庫

刀片 正角型

TP
 三角形
 无孔
 正 11°

[illegible]

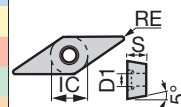
●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削

菱形, 35°
有孔
正 5°



P	钢	●	●	●	✱	✱		
M	不锈钢		●	●				
K	铸铁	●	●	●				
N	非铁金属							
S	高温合金							
H	烧结合金							

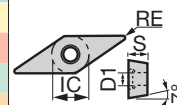


●: 在庫

刀片 正角型

VC

菱形, 35°
有孔
正 7°

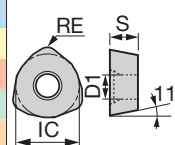
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●: 在庫

- : 连续切削
- ◐: 轻断续切削
- ⊕: 强断续切削



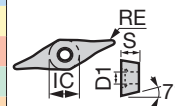
凸三角形, 80°
有孔
正 11°

[illegible][illegible]

●: 在庫



菱形, 25°
有孔
正 7°

[illegible][illegible]

●: 在庫

T9200 SERIES

标准切削条件

负角型刀片

ISO	加工方式	断屑槽	材质	切削深度 ap (mm)	进给 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	精加工	TSF	T9205	0.2 - 1.5	0.08 - 0.4	180 - 400	180 - 400	150 - 350
			T9215			150 - 400	150 - 400	120 - 300
			T9225			120 - 300	120 - 300	100 - 250
			T9235			50 - 200	50 - 200	50 - 150
		AS	T9205	0.2 - 1.5	0.08 - 0.4	180 - 400	180 - 400	150 - 350
			T9215			150 - 400	150 - 400	120 - 300
			T9225			120 - 300	120 - 300	100 - 250
			T9235			50 - 200	50 - 200	50 - 150
		FW	T9205	0.2 - 1.5	0.08 - 0.4	180 - 400	180 - 400	150 - 350
			T9215			150 - 400	150 - 400	120 - 300
			T9225			120 - 300	120 - 300	100 - 250
			T9235			50 - 200	50 - 200	50 - 150
		PS	T9215	0.3 - 1.5	0.1 - 0.4	150 - 400	150 - 400	120 - 300
			T9225			120 - 300	120 - 300	100 - 250
	半精加工	TM	T9205	1 - 5	0.2 - 0.5	180 - 400	180 - 400	150 - 350
			T9215			150 - 400	150 - 400	120 - 300
			T9225			120 - 300	120 - 300	100 - 250
			T9235			50 - 200	50 - 200	50 - 150
		AM	T9205	1.5 - 4.5	0.2 - 0.6	180 - 400	180 - 400	150 - 350
			T9215			150 - 400	150 - 400	120 - 300
			T9225			120 - 300	120 - 300	100 - 250
			T9235			50 - 200	50 - 200	50 - 150
		SW	T9205	0.5 - 2	0.3 - 0.6	180 - 400	180 - 400	150 - 350
			T9215			150 - 400	150 - 400	120 - 300
			T9225			120 - 300	120 - 300	100 - 250
			T9235			50 - 200	50 - 200	50 - 150
		PM	T9215	0.5 - 5.5	0.15 - 0.5	150 - 400	150 - 400	120 - 300
			T9225	0.5 - 5.5	0.15 - 0.5	120 - 300	120 - 300	100 - 250
	半精加工至重载 切削	TH	T9205	3 - 6	0.3 - 0.6	180 - 400	180 - 400	150 - 350
			T9215			150 - 400	150 - 400	120 - 300
			T9225			120 - 300	120 - 300	100 - 250
			T9235			50 - 200	50 - 200	50 - 150
不锈钢								
M	精加工	TSF	T9215	0.2 - 1.5	0.08 - 0.4	100 - 250		
			T9225					
	半精加工	TM	T9215	1 - 5	0.2 - 0.5	100 - 250		
			T9225					
铸铁								
K	精加工	TSF	T9215	0.2 - 1.5	0.08 - 0.4	140 - 500		
			T9225					
	半精加工	TM	T9215	1 - 5	0.2 - 0.5	140 - 500		
			T9225					

正角型刀片

ISO	加工方式	断屑槽	材质	切削深度 ap (mm)	进给 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	精加工	PSF	T9215	0.1 - 0.5	0.05 - 0.3	120 - 350	100 - 350	80 - 250
			T9225			100 - 300	80 - 300	80 - 250
	半精加工	TSF	T9215	0.5 - 2.5	0.1 - 0.25	120 - 350	100-350	80-250
			T9225			100 - 300	80 - 300	80 - 250
		TM	T9215	0.25 - 3	0.06 - 0.26	120 - 350	100 - 350	80 - 250
			T9225			100 - 300	80 - 300	80 - 250
	半精加工	PS	T9215	0.5 - 2.5	0.08 - 0.3	120 - 300	100 - 300	80 - 250
			T9225			100 - 300	80 - 250	80 - 200
		SW	T9215	0.5 - 2	0.15 - 0.4	150 - 350	150 - 350	120 - 300
			T9225			100 - 300	100 - 300	80 - 250
	半精加工至重载 切削	PM	T9215	1 - 3	0.15 - 0.3	120 - 300	100 - 300	80 - 200
			T9225			100 - 300	80 - 300	80 - 200
新	重载切削	RH	T9205	2 - 8	0.8 - 2	180 - 400	180 - 400	150 - 350
不锈钢								
M	精加工	PSF	T9215	0.1 - 0.5	0.05 - 0.3	50 - 200		
			T9225					
	半精加工	PS	T9215	0.5 - 2.5	0.08 - 0.3	50 - 200		
			T9225					
铸铁								
K	精加工	PSF	T9215	0.1 - 0.5	0.05 - 0.3	100 - 350		
			T9225					
	半精加工	PS	T9215	0.5 - 2.5	0.08 - 0.3	100 - 350		
			T9225					

T9200 SERIES

其他

ADD^{ULTI}TURN



六刀尖刀片，实现高通用性、经济性和生产率

MINI^{FO}TURN



经济型双面正角刀片

TURN^{T^{FEED}}



ISO^{E^{FO}}TURN



高性价比：切削性能相同，尺寸更小

FIX^RTURN



圆刀片及配备精密分度系统的刀杆

Y-PRO

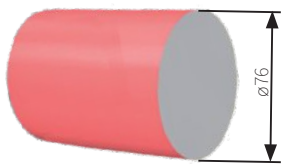
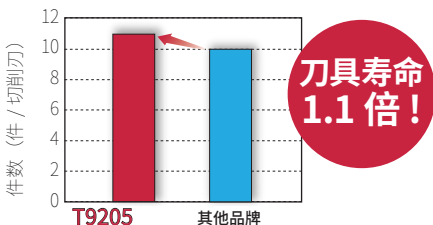
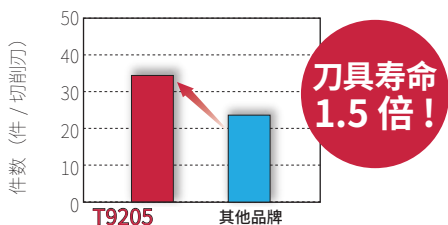
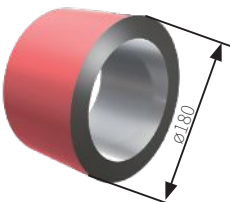
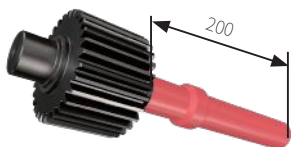
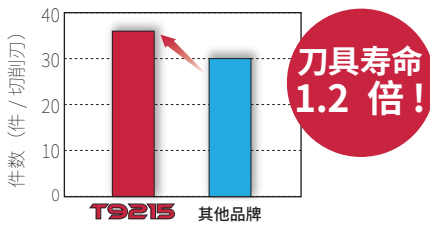
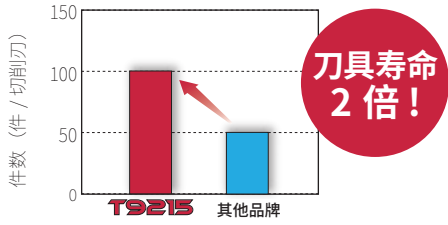


25°刀尖角刀片，适用于仿形加工

TUNG^{CUT}

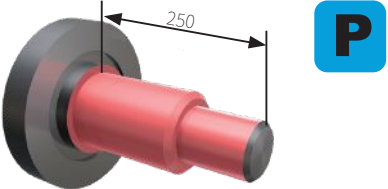
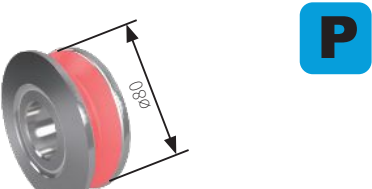
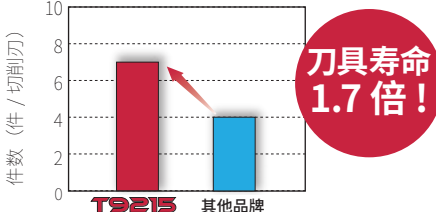
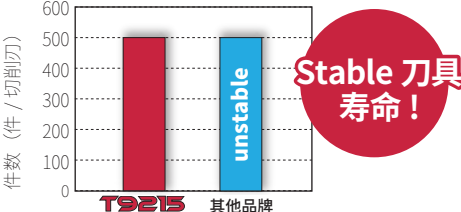
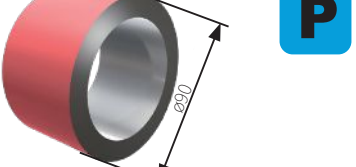
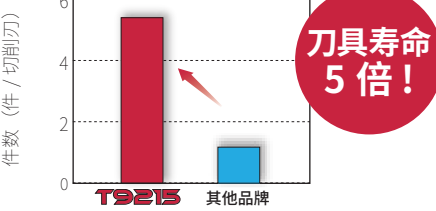
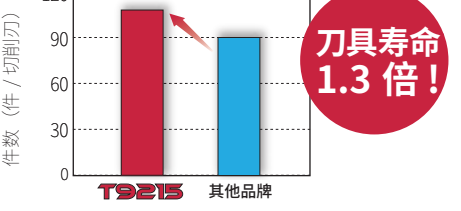


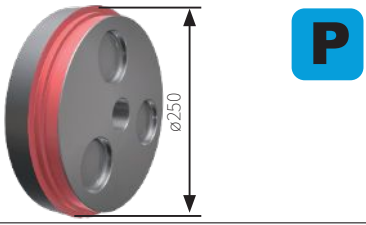
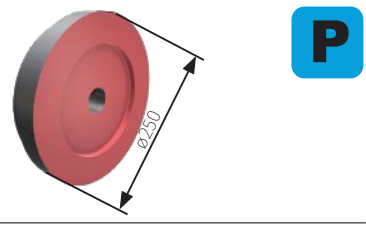
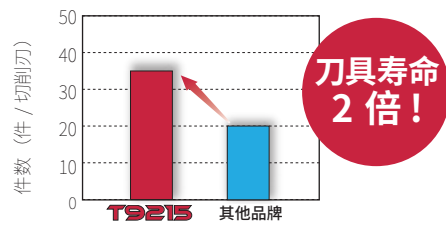
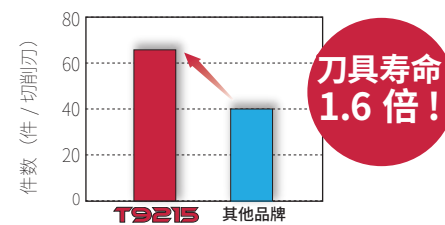
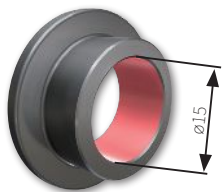
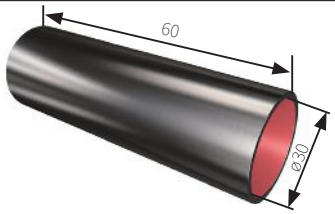
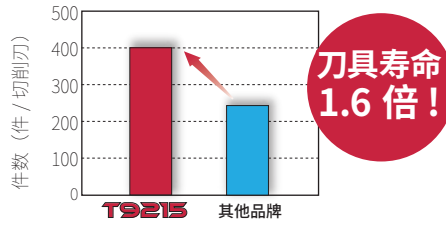
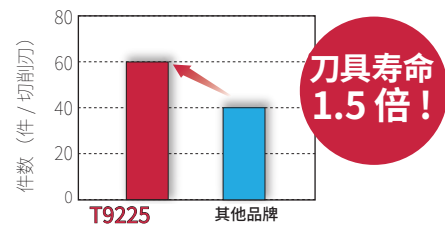
实际案例

工件类型		铁路车轮	机械零件
刀片		新 RCMX3209M0-RH	CNMG120408-TM
材质		T9205	T9205
工件材料		铁路车轮钢	合金钢
		 P	 P
切削条件	切削速度: Vc (m/min)	90 - 120	170
	进给 : f (mm/rev)	1.3 - 2	0.35 → 0.45
	切削深度 : ap (mm)	2 - 8	2
	冷却	湿式	湿式
结果		 刀具寿命 1.1 倍! 采用新型 RH 断屑槽的 T9205 材质, 凭借均衡的耐磨性和抗断裂性, 将刀具寿命提高了 1.1 倍。	 刀具寿命 1.5 倍! T9205 材质允许采用更高的进给率, 相比传统材质刀具寿命延长了 1.5 倍。
工件类型		载具	顶轴
刀片		WNMG080408-SW	CNMG120408-AM
材质		T9215	T9215
工件材料		S45C / C45	合金钢
		 P	 P
切削条件	切削速度: Vc (m/min)	300	250
	进给 : f (mm/rev)	0.4	0.25 - 0.35
	切削深度 : ap (mm)	1	2
	冷却	湿式	湿式
结果		 刀具寿命 1.2 倍! T9215 材质与最新的修光刃系列结合, 提供了更高的稳定性, 实现了比当前产品长约 1.2 倍的刀具寿命。	 刀具寿命 2 倍! T9215 材质在耐磨性和抗断裂性方面均更优异, 提供了两倍于当前产品的稳定长寿命!

T9200 SERIES

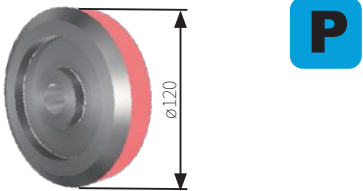
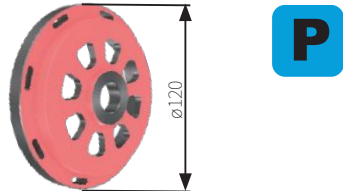
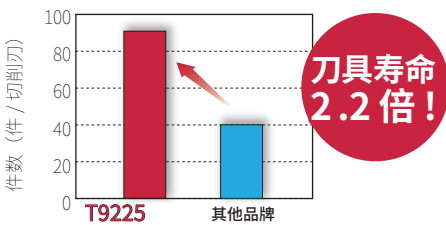
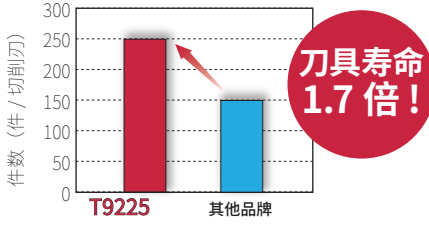
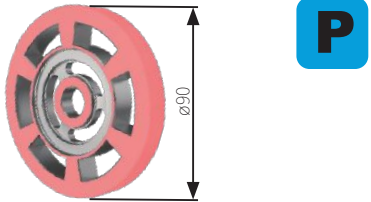
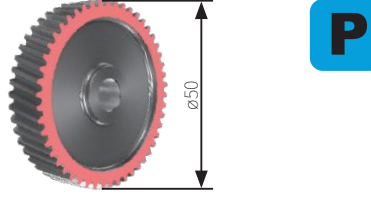
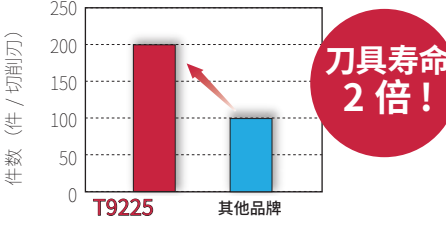
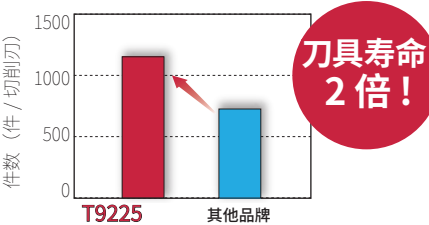
实际案例

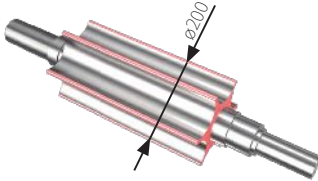
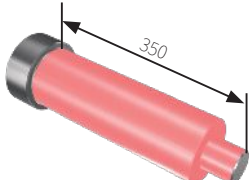
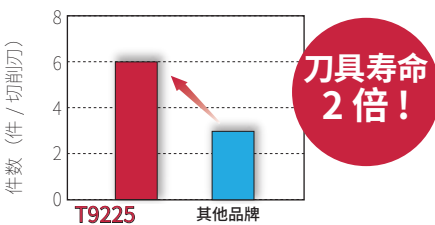
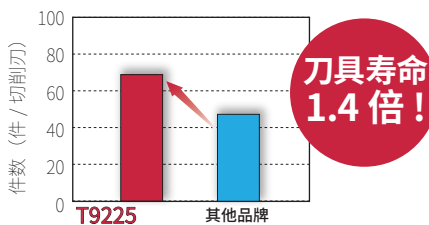
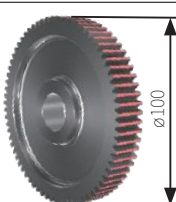
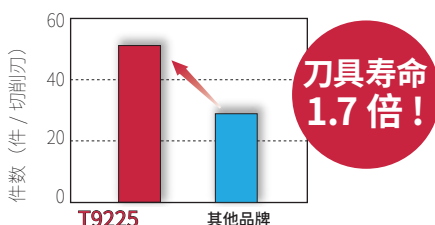
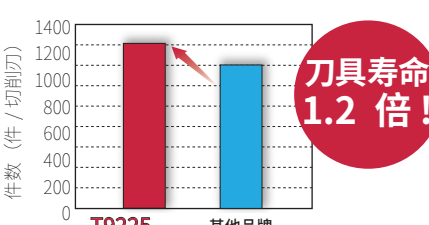
工件类型		轴	轴承零件
刀片		CNMG120408-TM	DNMG150408-AM
材质		T9215	T9215
工件材料		SCM440 / 42CrMo4	SUJ2 / B1
			
切削条件	切削速度: Vc (m/min)	250	250
	进给 : f (mm/rev)	0.3	0.25 - 0.35
	切削深度 : ap (mm)	3.5	0.25
	冷却	湿式	湿式
结果		 刀具寿命 1.7 倍! T9215 材质在耐磨性和抗崩损性之间取得了优异平衡, 实现了约为当前产品 1.7 倍的稳定长寿命!	 Stable 刀具寿命! T9215 材质减少了突然断裂的发生, 实现了稳定加工!
工件类型		轴	管道
刀片		DNMG150412-TM	DNMG150608-TM
材质		T9215	T9215
工件材料		SCM440 / 42CrMo4	SM490 / E355D
			
切削条件	切削速度: Vc (m/min)	140	200
	进给 : f (mm/rev)	0.38	0.35
	切削深度 : ap (mm)	4mm x 6 刀	3
	冷却	湿式	湿式
结果		 刀具寿命 5 倍! T9215 材质展现出卓越的耐磨性, 结合刀具路径的优化, 实现了约为当前产品 5 倍的稳定长寿命!	 刀具寿命 1.3 倍! 凭借出色的耐磨性和加工条件的优化, T9215 材质实现了比当前产品长约 1.3 倍的刀具寿命!此外, 我们成功大幅缩短了加工时间!

工件类型		汽车零部件	汽车零部件
刀片		WNMG080408-AM	WNMG080408-AM
材质		T9215	T9215
工件材料		S55C / C55	S55C / C55
			
切削条件	切削速度: Vc (m/min)	300	300
	进给 : f (mm/rev)	0.25	0.3
	切削深度 : ap (mm)	1.5	1
	冷却	湿式	湿式
结果		 我们的最新材质 T9215 具有出色的耐磨性, 并将刀具寿命延长了 2 倍。	 我们的最新材质 T9215 具有出色的耐磨性, 并将刀具寿命延长了 1.6 倍。
工件类型		机械零件	机械零件
刀片		CCMT060204-PS	CPMT090308-PS
材质		T9215	T9225
工件材料		SCM415	S20C
			
切削条件	切削速度: Vc (m/min)	150	100
	进给 : f (mm/rev)	0.2	0.2
	切削深度 : ap (mm)	1.5	1
	冷却	湿式	湿式
结果		 T9225 材质提供了优于竞品的耐磨性、抗断裂性和稳定性, 将刀具寿命提高了 1.5 倍。	 T9225 材质提供了优于竞品的耐磨性、抗断裂性和稳定性, 将刀具寿命提高了 2.2 倍。

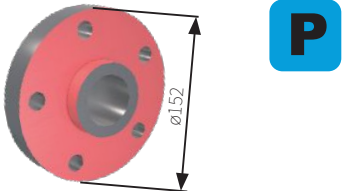
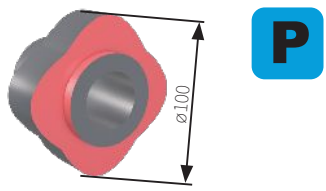
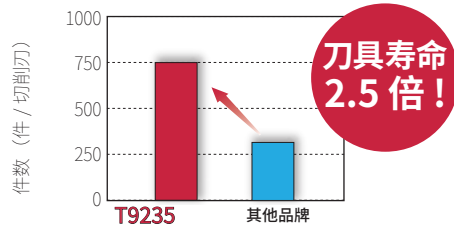
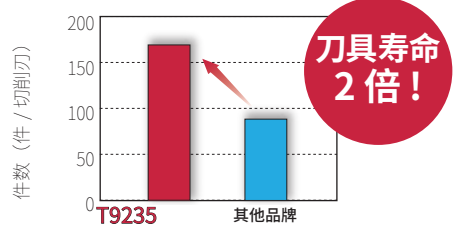
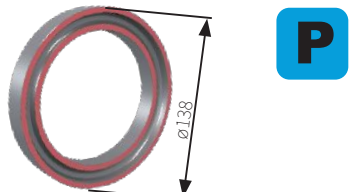
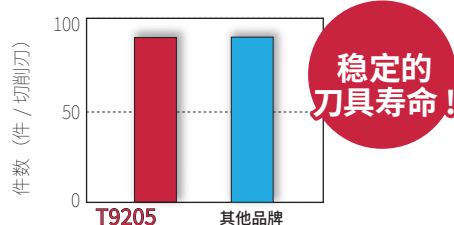
T9200 SERIES

实际案例

工件类型		滑轮部件	离合器部件
刀片		WNMG080408-TM	WNMG080412-TM
材质		T9225	T9225
工件材料		SCM415	SCM420
			
切削条件	切削速度: Vc (m/min)	210	220
	进给 : f (mm/rev)	0.25	0.3
	切削深度 : ap (mm)	1.5	1
	冷却	湿式	湿式
结果		 T9225 材质提供了优于竞品的耐磨性、抗断裂性和稳定性，将刀具寿命提高了 2.2 倍。	 凭借其优异的断裂韧性，T9225 材质将刀具寿命提高了 1.7 倍，并提供了优于竞品的稳定性。
工件类型		转子部件	环齿轮部件
刀片		WNMG080412-TM	WNMG080408-TM
材质		T9225	T9225
工件材料		S10C	SCr420
			
切削条件	切削速度: Vc (m/min)	400	280
	进给 : f (mm/rev)	0.45	0.25
	切削深度 : ap (mm)	1.5	1
	冷却	湿式	湿式
结果		 凭借其优异的断裂韧性，T9225 材质提供了优于竞品的出色稳定性，使刀具寿命翻倍。	 T9225 材质提供了优于竞品的耐磨性、抗断裂性和稳定性，使刀具寿命翻倍。

工件类型		机械零件	轴零件
刀片		CNMG120408-TM	DNMG150408-AM
材质		T9225	T9225
工件材料		S35C	SCM440
			
切削条件	切削速度: V_c (m/min)	150	180
	进给 : f (mm/rev)	0.25 - 0.4	0.3
	切削深度 : a_p (mm)	0.5 - 1.5	1
	冷却	湿式	湿式
结果		 凭借其优异的断裂韧性, T9225 材质在重载断续切削过程中使刀具寿命翻倍, 并提供了优于竞品的稳定性。	 T9225 材质提供了优于竞品的耐磨性、抗断裂性和稳定性, 将刀具寿命提高了 1.4 倍。
工件类型		齿轮部件	汽车零部件
刀片		VNMG160408-TM	CCMT09T304-PS
材质		T9225	T9225
工件材料		SCM415	SCr420H
			
切削条件	切削速度: V_c (m/min)	300	150
	进给 : f (mm/rev)	0.3	0.2 - 0.3
	切削深度 : a_p (mm)	1.5	1 - 2.5
	冷却	湿式	湿式
结果		 凭借其优异的断裂韧性, T9225 材质将刀具寿命提高了 1.7 倍, 并提供了优于竞品的稳定性。	 T9225 材质提供了更好的稳定性, 以及优于竞品的耐磨性和抗断裂性, 将刀具寿命提高了 1.2 倍。

T9200 SERIES

工件类型		轮毂部件	汽车零部件
刀片		DNMG150412-TSF	DNMG150412-DM
材质		T9235	T9235
工件材料		S53C / C53	S53C / C53
			
切削条件	切削速度: Vc (m/min)	220	220
	进给 : f (mm/rev)	0.4	0.4
	切削深度 : ap (mm)	0.5	1
	冷却	湿式	湿式
结果		 T9235 材质将刀具寿命延长了 2.5 倍, 同时提供了更高的刀具寿命和加工稳定性。	 T9235 材质使刀具寿命翻倍, 此外还增强了刀具稳定性。
工件类型		汽车零部件	
刀片		DNMG150412-DM	
材质		T9205	
工件材料		S45C / C45	
			
切削条件	切削速度: Vc (m/min)	250	
	进给 : f (mm/rev)	0.3	
	切削深度 : ap (mm)	1	
	冷却	湿式	
结果		 过早的刀片失效和由月牙洼磨损过度发展引起的断裂是传统材质存在的问题。T9205 材质消除了这些问题, 提供了稳定性。	

MEMO

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