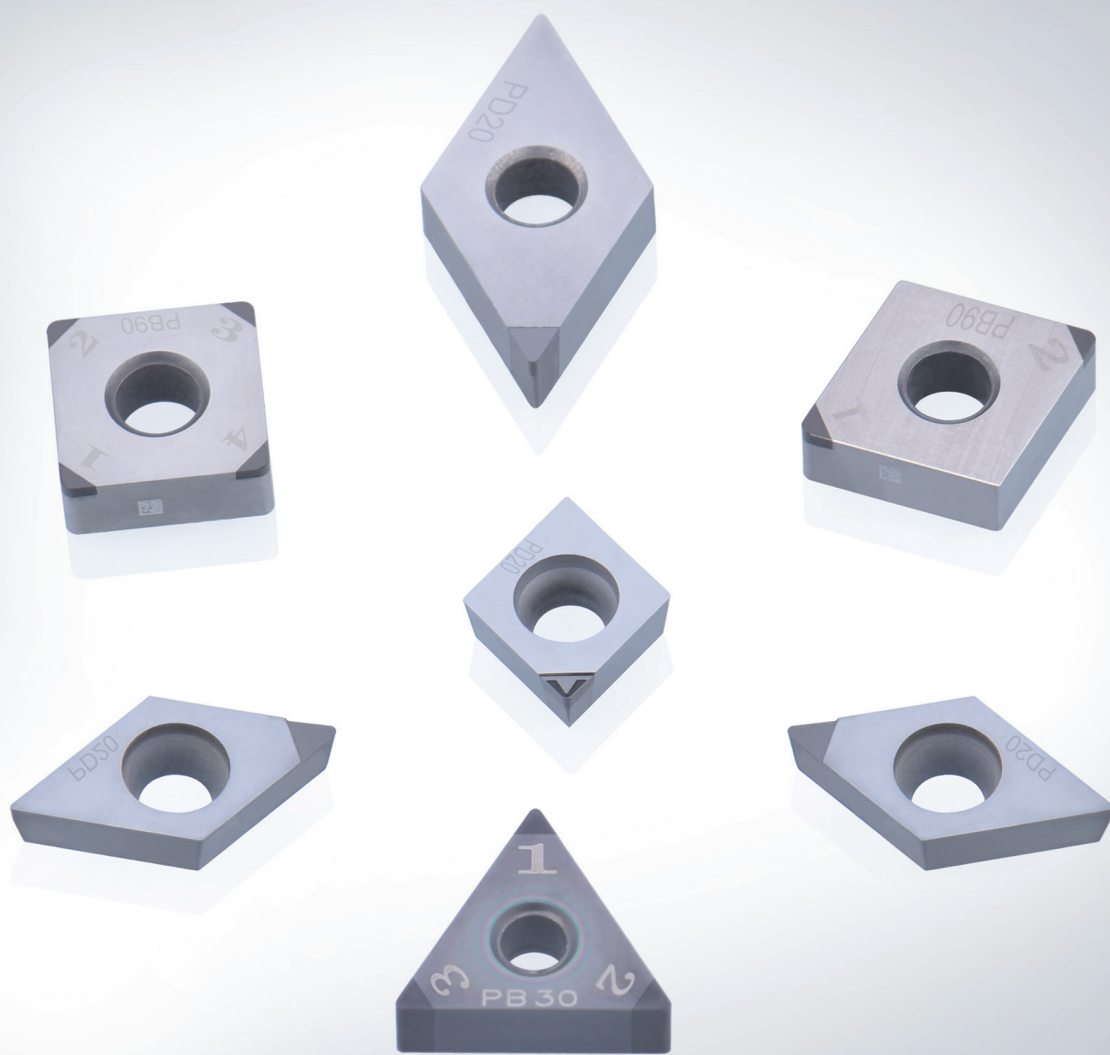


NEW
PRODUCT!

PCBN&PCD车削刀片

超硬车削刀片系列



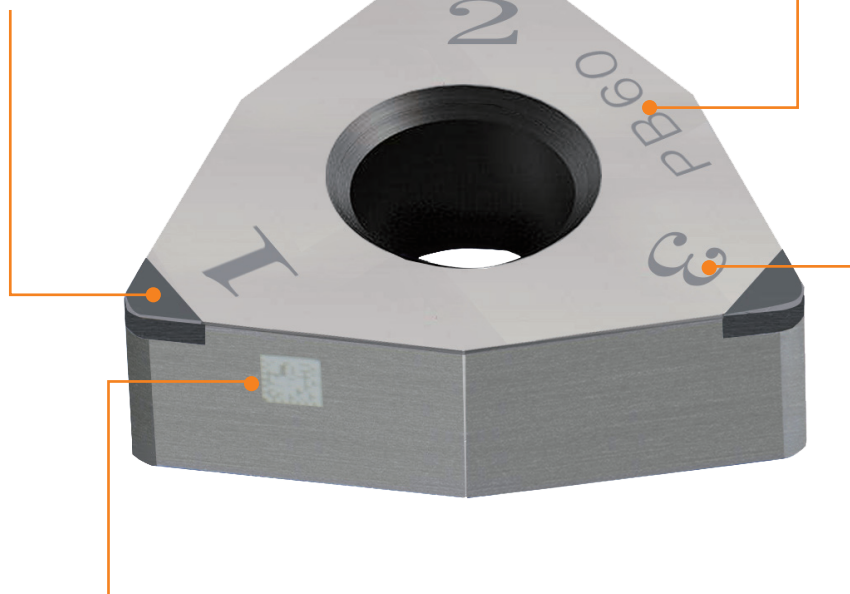
超硬材料刀具目前主要有单晶金刚石刀具,聚晶金刚石(PCD)刀具,聚晶立方氮化硼(PCBN)刀具等。它是加工铝合金材料以及高硬度材料的理想刀具;用超硬材料刀具替代普通刀具进行切削,在以车代磨、以铣代磨方面,实现了高效、低成本的效果;它适用于成形、仿形及定尺寸的精密加工,使质量得到显著的提高、效率得到数倍乃至数十倍的提高。目前已在汽车、航空、矿山、电子、玻璃等行业机械加工中得到广泛应用。

● 产品特征

- 具有很高的硬度和耐磨性
- 具有很高的热稳定性
- 具有较高的化学稳定性
- 具有良好的导热性
- 具有较低的摩擦系数

采用特种焊接工艺,焊接牢固

刀片牌号的标识,方便识别



二维码标识,便于追溯

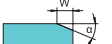
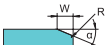
刀尖顺序标识,方便使用

PCBN刀片命名规则

C	N	G	A	12	04	08	-	S	010	20	-	SL	-	1	-	CB	PB30	A
1								2	3	4		5		6		7	8	9

1-标准ISO编号规则

2-主切削刃形状

E	钝化	
T	倒棱	
S	倒棱+钝化	
F	锋利	

3-倒棱宽度

005	0.05mm
010	0.10mm
015	0.15mm
020	0.20mm

4-倒棱角度

10	10°
15	15°
20	20°
25	25°

5-CBN 刀片结构形式

FT	整面复合片 
SD	整体 CBN 
SL	小尺寸CBN焊 
NL	正常尺寸CBN焊 (可重磨使用) 

6-切削刃数

1	1刃
2	2刃
3	3刃

7-刀口形式

CB	带断屑槽
WG	带修光刃
"-"	不带断屑槽

8-牌号

PB30	低含量CBN
PB60	高含量CBN
PB90	高含量CBN

9-涂层类型

A	A类型
B	B类型
C	C类型

PCD刀片命名规则

C	C	G	W	09	T3	04	-	2	-	NL	-	05	-	CB	PD20
1								2		3		4		5	6

1-标准ISO编号规则

2-刀片刃数

1	1刃
2	2刃
3	3刃

3-PCD刀片结构形式

NL	PCD复合片标准结构	
LL	PCD复合片整片	

4-刀片前角

00	0°
05	5°
10	10°

5-刀口形式

CB	带断屑槽
WG	带修光刃
"-"	不带断屑槽

6-牌号

PD01	细颗粒 PCD
PD10	中颗粒 PCD
PD20	粗颗粒 PCD

PCBN&PCD刀片牌号介绍

PCBN			
牌号	应用材质	牌号特点	主要应用
PB30	ISO:H	耐磨性与抗冲击性的完美组合	通用性较强, 适合淬火钢连续及轻微断续加工
PB60	ISO:H/K	优秀的韧性	主要应用淬火钢中度断续加工、粉末冶金断续及连续加工, 铸铁加工
PB90	ISO:K/H	耐磨性, 韧性好, 抗冲击	K-主要应用铸铁加工 H-淬火钢严重断续加工, 粉末冶金加工

PCD			
牌号	应用材质	牌号特点	主要应用
PD01	ISO:N	超细粒度PCD材料, 具有良好的抗冲击性	铝合金材料的粗加工, 断续加工。
PD10	ISO:N	通用牌号, 材料韧性和耐磨性兼顾	铝合金和非铁金属的一般加工。
PD20	ISO:N	首选牌号, 出色的耐磨韧性	铝合金材料通用加工首选

加工案例

加工零件: 汽车发动机缸体

材料: HT250

硬度: HB200-220

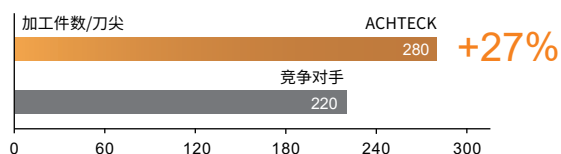
刀片: CCGW 09T304-S01020-SL-2 PB90

竞争对手: CCMW 09T304 S1225

切削参数: $V_c=570\text{m/min}$, $f=0.2\text{mm/r}$, $a_p=0.3\text{mm}$

干切

加工类型: 镗孔



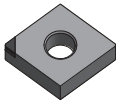
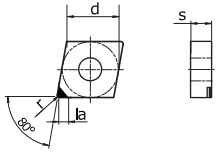
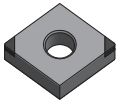
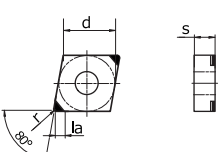
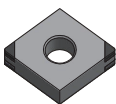
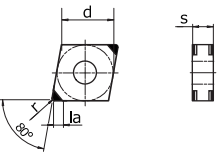
◆ 推荐的切削参数

PCBN					
牌号	工件材料	切削速度Vc (m/min)	进给f (mm/r)	切削深度ap (mm)	推荐应用工况
PB30	淬硬钢	150-250	0.03-0.2	0.05-0.3	连续
PB60	淬硬钢	50-150	0.03-0.2	0.05-0.5	断续
	铸铁	300-800	0.03-0.3	0.30-0.5	连续/断续
	粉末冶金	200-500	0.03-0.3	0.10-0.3	连续/断续
PB90	铸铁	300-800	0.03-0.3	0.30-0.5	连续/断续
	淬硬钢	50-150	0.03-0.2	0.05-0.5	强断续
	粉末冶金	300-800	0.03-0.3	0.10-0.3	连续/断续

PCD					
牌号	工件材料	切削速度Vc (m/min)	进给f (mm/r)	切削深度ap (mm)	推荐应用工况
PD01	高硅铝合金(Si>12%)	300-4000	0.03-0.3	0.05-0.5	连续/断续
PD10	中硅铝 (6%<Si<12%)	300-4000	0.03-0.3	0.05-0.5	连续/断续
PD20	低硅铝 (Si<6%)	300-4000	0.03-0.2	0.30-0.5	连续

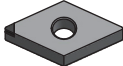
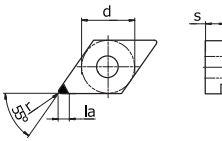
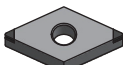
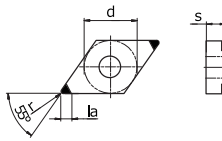
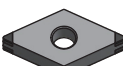
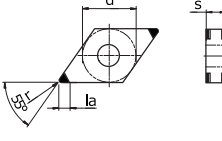
◆ 产品库存表-PCBN刀片

负型80°(CN)

刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	CNGA 120402-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	CNGA 120404-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	CNGA 120408-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	CNGA 120412-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	
	CNGA 120402-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	CNGA 120404-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	CNGA 120408-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	CNGA 120412-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	
	CNGA 120402-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	CNGA 120404-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	CNGA 120408-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	CNGA 120412-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	

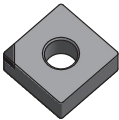
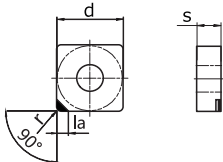
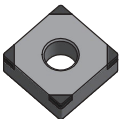
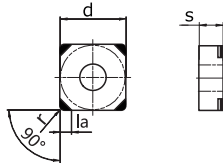
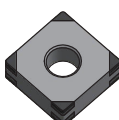
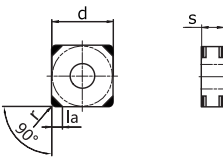
注：●代表有库存

负型55° (DN)

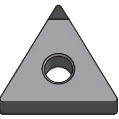
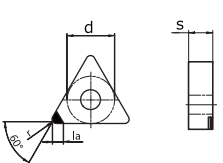
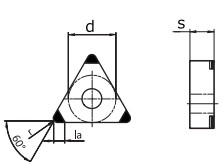
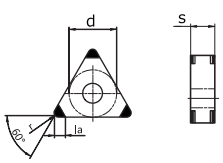
刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	DNGA 150402-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	DNGA 150404-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	DNGA 150408-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	DNGA 150412-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	
	DNGA 150602-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	6.35	0.2	●	●	●	
	DNGA 150604-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	6.35	0.4	●	●	●	
	DNGA 150608-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	6.35	0.8	●	●	●	
	DNGA 150612-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	6.35	1.2	●	●	●	
	DNGA 150402-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	DNGA 150404-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	DNGA 150408-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	DNGA 150412-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	
	DNGA 150602-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	6.35	0.2	●	●	●	
	DNGA 150604-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	6.35	0.4	●	●	●	
	DNGA 150608-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	6.35	0.8	●	●	●	
	DNGA 150612-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	6.35	1.2	●	●	●	
	DNGA 150402-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	DNGA 150404-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	DNGA 150408-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	DNGA 150412-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	
	DNGA 150602-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	6.35	0.2	●	●	●	
	DNGA 150604-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	6.35	0.4	●	●	●	
	DNGA 150608-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	6.35	0.8	●	●	●	
	DNGA 150612-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	6.35	1.2	●	●	●	

注：●代表有库存

负型90° (SN)

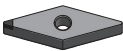
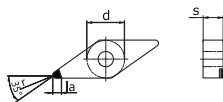
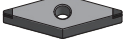
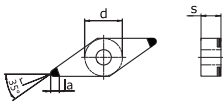
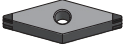
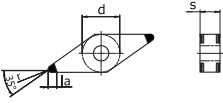
刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	SNGA 120402-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	SNGA 120404-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	SNGA 120408-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	SNGA 120412-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	
	SNGA 120402-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	SNGA 120404-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	SNGA 120408-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	SNGA 120412-S01020-SL-4	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	
	SNGA 120402-S01020-SL-8	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	SNGA 120404-S01020-SL-8	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	SNGA 120408-S01020-SL-8	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	SNGA 120412-S01020-SL-8	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	

负型60° (TN)

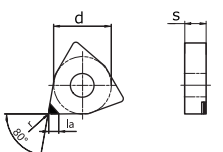
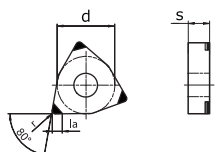
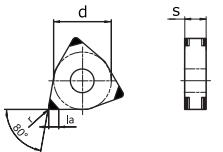
刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	TNGA 160402-S01020-SL-1	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.2	●	●	●	
	TNGA 160404-S01020-SL-1	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.4	●	●	●	
	TNGA 160408-S01020-SL-1	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.8	●	●	●	
	TNGA 160412-S01020-SL-1	0.03-0.3	0.05-0.5	9.53	2.2	4.76	1.2	●	●	●	
	TNGA 160402-S01020-SL-3	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.2	●	●	●	
	TNGA 160404-S01020-SL-3	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.4	●	●	●	
	TNGA 160408-S01020-SL-3	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.8	●	●	●	
	TNGA 160412-S01020-SL-3	0.03-0.3	0.05-0.5	9.53	2.2	4.76	1.2	●	●	●	
	TNGA 160402-S01020-SL-6	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.2	●	●	●	
	TNGA 160404-S01020-SL-6	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.4	●	●	●	
	TNGA 160408-S01020-SL-6	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.8	●	●	●	
	TNGA 160412-S01020-SL-6	0.03-0.3	0.05-0.5	9.53	2.2	4.76	1.2	●	●	●	

注：●代表有库存

负型35° (VN)

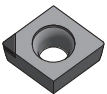
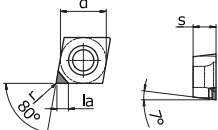
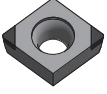
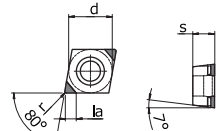
刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	VNGA 160402-S01020-SL-1	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.2	●	●	●	
	VNGA 160404-S01020-SL-1	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.4	●	●	●	
	VNGA 160408-S01020-SL-1	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.8	●	●	●	
	VNGA 160412-S01020-SL-1	0.03-0.3	0.05-0.5	9.53	2.2	4.76	1.2	●	●	●	
	VNGA 160402-S01020-SL-2	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.2	●	●	●	
	VNGA 160404-S01020-SL-2	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.4	●	●	●	
	VNGA 160408-S01020-SL-2	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.8	●	●	●	
	VNGA 160412-S01020-SL-2	0.03-0.3	0.05-0.5	9.53	2.2	4.76	1.2	●	●	●	
	VNGA 160402-S01020-SL-4	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.2	●	●	●	
	VNGA 160404-S01020-SL-4	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.4	●	●	●	
	VNGA 160408-S01020-SL-4	0.03-0.3	0.05-0.5	9.53	2.2	4.76	0.8	●	●	●	
	VNGA 160412-S01020-SL-4	0.03-0.3	0.05-0.5	9.53	2.2	4.76	1.2	●	●	●	

负型80° (WN)

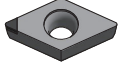
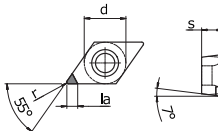
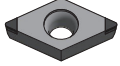
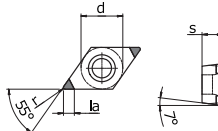
刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	WNGA 080402-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	WNGA 080404-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	WNGA 080408-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	WNGA 080412-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	
	WNGA 080402-S01020-SL-3	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	WNGA 080404-S01020-SL-3	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	WNGA 080408-S01020-SL-3	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	WNGA 080412-S01020-SL-3	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	
	WNGA 080402-S01020-SL-6	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	WNGA 080404-S01020-SL-6	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	WNGA 080408-S01020-SL-6	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	WNGA 080412-S01020-SL-6	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	

注：●代表有库存

正型80°(CC)

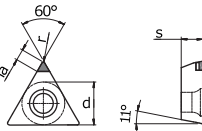
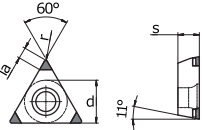
刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	CCGW 060202-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.2	●	●	●	
	CCGW 060204-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.4	●	●	●	
	CCGW 060208-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.8	●	●	●	
	CCGW 09T302-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.2	●	●	●	
	CCGW 09T304-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.4	●	●	●	
	CCGW 09T308-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.8	●	●	●	
	CCGW 120402-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	CCGW 120404-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	CCGW 120408-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	CCGW 120412-S01020-SL-1	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	
	CCGW 060202-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.2	●	●	●	
	CCGW 060204-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.4	●	●	●	
	CCGW 060208-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.8	●	●	●	
	CCGW 09T302-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.2	●	●	●	
	CCGW 09T304-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.4	●	●	●	
	CCGW 09T308-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.8	●	●	●	
	CCGW 120402-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.2	●	●	●	
	CCGW 120404-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.4	●	●	●	
	CCGW 120408-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	0.8	●	●	●	
	CCGW 120412-S01020-SL-2	0.03-0.3	0.05-0.5	12.7	2.2	4.76	1.2	●	●	●	

正型55°(DC)

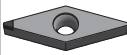
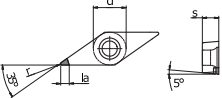
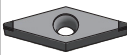
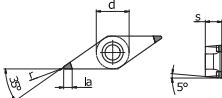
刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	DCGW 070202-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.2	●	●	●	
	DCGW 070204-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.4	●	●	●	
	DCGW 070208-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.8	●	●	●	
	DCGW 11T302-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.2	●	●	●	
	DCGW 11T304-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.4	●	●	●	
	DCGW 11T308-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.8	●	●	●	
	DCGW 11T312-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	3.97	1.2	●	●	●	
	DCGW 070202-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.2	●	●	●	
	DCGW 070204-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.4	●	●	●	
	DCGW 070208-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	2.38	0.8	●	●	●	
	DCGW 11T302-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.2	●	●	●	
	DCGW 11T304-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.4	●	●	●	
	DCGW 11T308-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	3.97	0.8	●	●	●	
	DCGW 11T312-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	3.97	1.2	●	●	●	

注：●代表有库存

正型60°(TP)

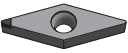
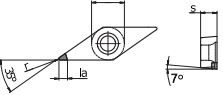
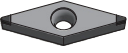
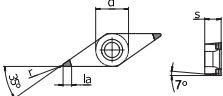
刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	TPGW 080202-S01020-SL-1	0.03-0.3	0.05-0.5	4.76	2.2	2.38	0.2	●	●	●	
	TPGW 080204-S01020-SL-1	0.03-0.3	0.05-0.5	4.76	2.2	2.38	0.4	●	●	●	
	TPGW 090202-S01020-SL-1	0.03-0.3	0.05-0.5	5.56	2.2	2.38	0.2	●	●	●	
	TPGW 090204-S01020-SL-1	0.03-0.3	0.05-0.5	5.56	2.2	2.38	0.4	●	●	●	
	TPGW 090208-S01020-SL-1	0.03-0.3	0.05-0.5	5.56	2.2	2.38	0.8	●	●	●	
	TPGW 110302-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.2	●	●	●	
	TPGW 110304-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.4	●	●	●	
	TPGW 160402-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.2	●	●	●	
	TPGW 160404-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.4	●	●	●	
	TPGW 160408-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.8	●	●	●	
	TPGW 080202-S01020-SL-3	0.03-0.3	0.05-0.5	4.76	2.2	2.38	0.2	●	●	●	
	TPGW 080204-S01020-SL-3	0.03-0.3	0.05-0.5	4.76	2.2	2.38	0.4	●	●	●	
	TPGW 090202-S01020-SL-3	0.03-0.3	0.05-0.5	5.56	2.2	2.38	0.2	●	●	●	
	TPGW 090204-S01020-SL-3	0.03-0.3	0.05-0.5	5.56	2.2	2.38	0.4	●	●	●	
	TPGW 090208-S01020-SL-3	0.03-0.3	0.05-0.5	5.56	2.2	2.38	0.8	●	●	●	
	TPGW 110302-S01020-SL-3	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.2	●	●	●	
	TPGW 110304-S01020-SL-3	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.4	●	●	●	
	TPGW 160402-S01020-SL-3	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.2	●	●	●	
	TPGW 160404-S01020-SL-3	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.4	●	●	●	
	TPGW 160408-S01020-SL-3	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.8	●	●	●	

正型35°(VB)

刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	VBGW 110302-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.2	●	●	●	
	VBGW 110304-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.4	●	●	●	
	VBGW 110308-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.8	●	●	●	
	VBGW 160402-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.2	●	●	●	
	VBGW 160404-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.4	●	●	●	
	VBGW 160408-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.8	●	●	●	
	VBGW 110302-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.2	●	●	●	
	VBGW 110304-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.4	●	●	●	
	VBGW 110308-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.8	●	●	●	
	VBGW 160402-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.2	●	●	●	
	VBGW 160404-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.4	●	●	●	
	VBGW 160408-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.8	●	●	●	

注：●代表有库存

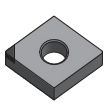
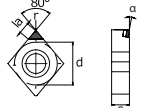
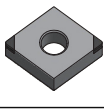
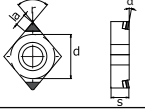
正型35° (VC)

刀片	型号	推荐参数		尺寸(mm)				牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	PB30	PB60	PB90	
	VCGW 110302-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.2	●	●	●	
	VCGW 110304-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.4	●	●	●	
	VCGW 110308-S01020-SL-1	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.8	●	●	●	
	VCGW 160402-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.2	●	●	●	
	VCGW 160404-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.4	●	●	●	
	VCGW 160408-S01020-SL-1	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.8	●	●	●	
	VCGW 110302-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.2	●	●	●	
	VCGW 110304-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.4	●	●	●	
	VCGW 110308-S01020-SL-2	0.03-0.3	0.05-0.5	6.35	2.2	3.18	0.8	●	●	●	
	VCGW 160402-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.2	●	●	●	
	VCGW 160404-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.4	●	●	●	
	VCGW 160408-S01020-SL-2	0.03-0.3	0.05-0.5	9.525	2.2	4.76	0.8	●	●	●	

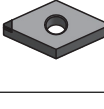
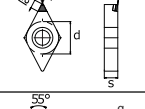
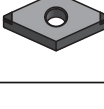
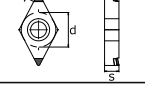
注：●代表有库存

● 产品库存表-PCD刀片

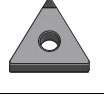
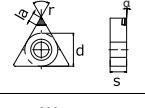
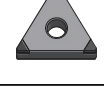
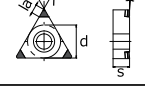
负型80°(CN)

刀片	型号	推荐参数		尺寸(mm)					牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	α	PD01	PD10	PD20	
	CNGA 120402-1-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.2	0°	●	●	●	
	CNGA 120404-1-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.4	0°	●	●	●	
	CNGA 120408-1-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.8	0°	●	●	●	
	CNGA 120402-2-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.2	0°	●	●	●	
	CNGA 120404-2-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.4	0°	●	●	●	
	CNGA 120408-2-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.8	0°	●	●	●	

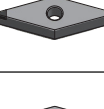
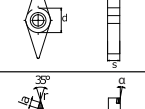
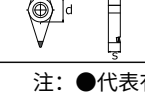
负型55°(DN)

刀片	型号	推荐参数		尺寸(mm)					牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	α	PD01	PD10	PD20	
	DNGA 150402-1-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.2	0°	●	●	●	
	DNGA 150404-1-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.4	0°	●	●	●	
	DNGA 150408-1-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.8	0°	●	●	●	
	DNGA 150402-2-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.2	0°	●	●	●	
	DNGA 150404-2-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.4	0°	●	●	●	
	DNGA 150408-2-NL-00	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.8	0°	●	●	●	

负型60°(TN)

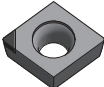
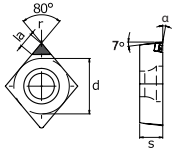
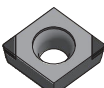
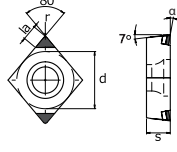
刀片	型号	推荐参数		尺寸(mm)					牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	α	PD01	PD10	PD20	
	TNGA 160402-1-NL-00	0.03-0.2	0.05-0.5	9.525	2.5	4.76	0.2	0°	●	●	●	
	TNGA 160404-1-NL-00	0.03-0.2	0.05-0.5	9.525	2.5	4.76	0.4	0°	●	●	●	
	TNGA 160408-1-NL-00	0.03-0.2	0.05-0.5	9.525	2.5	4.76	0.8	0°	●	●	●	
	TNGA 160402-3-NL-00	0.03-0.2	0.05-0.5	9.525	2.5	4.76	0.2	0°	●	●	●	
	TNGA 160404-3-NL-00	0.03-0.2	0.05-0.5	9.525	2.5	4.76	0.4	0°	●	●	●	
	TNGA 160408-3-NL-00	0.03-0.2	0.05-0.5	9.525	2.5	4.76	0.8	0°	●	●	●	

负型35°(VN)

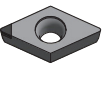
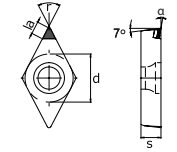
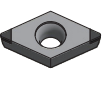
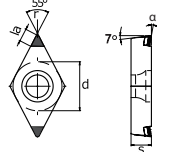
刀片	型号	推荐参数		尺寸(mm)					牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	α	PD01	PD10	PD20	
	VNGA 160402-1-NL-00	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.2	0°	●	●	●	
	VNGA 160404-1-NL-00	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.4	0°	●	●	●	
	VNGA 160408-1-NL-00	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.8	0°	●	●	●	
	VNGA 160402-2-NL-00	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.2	0°	●	●	●	
	VNGA 160404-2-NL-00	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.4	0°	●	●	●	
	VNGA 160408-2-NL-00	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.8	0°	●	●	●	

注：●代表有库存

正型80° (CC)

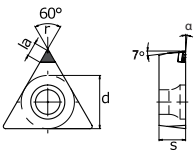
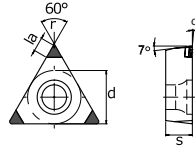
刀片	型号	推荐参数		尺寸(mm)					牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	α	PD01	PD10	PD20	
	CCGW 060202-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.2	5°	●	●	●	
	CCGW 060204-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.4	5°	●	●	●	
	CCGW 060208-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.8	5°	●	●	●	
	CCGW 09T302-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.2	5°	●	●	●	
	CCGW 09T304-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.4	5°	●	●	●	
	CCGW 09T308-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.8	5°	●	●	●	
	CCGW 120402-1-NL-05	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.2	5°	●	●	●	
	CCGW 120404-1-NL-05	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.4	5°	●	●	●	
	CCGW 120408-1-NL-05	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.8	5°	●	●	●	
	CCGW 060202-2-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.2	5°	●	●	●	
	CCGW 060204-2-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.4	5°	●	●	●	
	CCGW 060208-2-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.8	5°	●	●	●	
	CCGW 09T302-2-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.2	5°	●	●	●	
	CCGW 09T304-2-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.4	5°	●	●	●	
	CCGW 09T308-2-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.8	5°	●	●	●	
	CCGW 120402-2-NL-05	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.2	5°	●	●	●	
	CCGW 120404-2-NL-05	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.4	5°	●	●	●	
	CCGW 120408-2-NL-05	0.03-0.2	0.05-0.5	12.7	3.0	4.76	0.8	5°	●	●	●	

正型55° (DC)

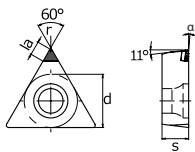
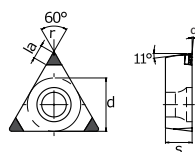
刀片	型号	推荐参数		尺寸(mm)					牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	α	PD01	PD10	PD20	
	DCGW 070202-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.2	5°	●	●	●	
	DCGW 070204-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.4	5°	●	●	●	
	DCGW 070208-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.8	5°	●	●	●	
	DCGW 11T302-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.2	5°	●	●	●	
	DCGW 11T304-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.4	5°	●	●	●	
	DCGW 11T308-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.8	5°	●	●	●	
	DCGW 070202-2-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.2	5°	●	●	●	
	DCGW 070204-2-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.4	5°	●	●	●	
	DCGW 070208-2-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	2.38	0.8	5°	●	●	●	
	DCGW 11T302-2-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.2	5°	●	●	●	
	DCGW 11T304-2-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.4	5°	●	●	●	
	DCGW 11T308-2-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	3.97	0.8	5°	●	●	●	

注：●代表有库存

正型60° (TC)

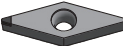
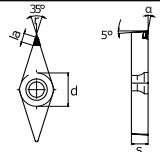
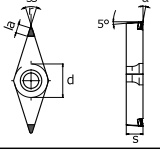
刀片	型号	推荐参数		尺寸(mm)					牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	α	PD01	PD10	PD20	
	TCGW 080202-1-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.2	5°	●	●	●	
	TCGW 080204-1-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.4	5°	●	●	●	
	TCGW 080208-1-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.8	5°	●	●	●	
	TCGW 110302-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.2	5°	●	●	●	
	TCGW 110304-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.4	5°	●	●	●	
	TCGW 110308-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.8	5°	●	●	●	
	TCGW 160402-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.2	5°	●	●	●	
	TCGW 160404-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.4	5°	●	●	●	
	TCGW 160408-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.8	5°	●	●	●	
	TCGW 080202-3-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.2	5°	●	●	●	
	TCGW 080204-3-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.4	5°	●	●	●	
	TCGW 080208-3-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.8	5°	●	●	●	
	TCGW 110302-3-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.2	5°	●	●	●	
	TCGW 110304-3-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.4	5°	●	●	●	
	TCGW 110308-3-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.8	5°	●	●	●	
	TCGW 160302-3-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.2	5°	●	●	●	
	TCGW 160304-3-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.4	5°	●	●	●	
	TCGW 160308-3-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.8	5°	●	●	●	

正型60° (TP)

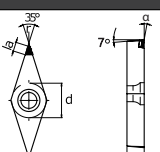
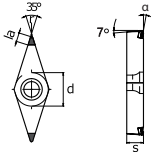
刀片	型号	推荐参数		尺寸(mm)					牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	α	PD01	PD10	PD20	
	TPGW 080202-1-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.2	5°	●	●	●	
	TPGW 080204-1-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.4	5°	●	●	●	
	TPGW 080208-1-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.8	5°	●	●	●	
	TPGW 080202-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.2	5°	●	●	●	
	TPGW 080204-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.4	5°	●	●	●	
	TPGW 080208-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.8	5°	●	●	●	
	TPGW 080202-3-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.2	5°	●	●	●	
	TPGW 080204-3-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.4	5°	●	●	●	
	TPGW 080208-3-NL-05	0.03-0.2	0.05-0.5	4.76	3.0	2.38	0.8	5°	●	●	●	
	TPGW 160402-3-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.2	5°	●	●	●	
	TPGW 160404-3-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.4	5°	●	●	●	
	TPGW 160408-3-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.8	5°	●	●	●	

注：●代表有库存

正型35° (VB)

刀片	型号	推荐参数		尺寸(mm)					牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	α	PD01	PD10	PD20	
	VBGW 110302-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.2	5°	●	●	●	
	VBGW 110304-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.4	5°	●	●	●	
	VBGW 160402-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.2	5°	●	●	●	
	VBGW 160404-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.4	5°	●	●	●	
	VBGW 110302-2-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.2	5°	●	●	●	
	VBGW 110304-2-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.4	5°	●	●	●	
	VBGW 160402-2-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.2	5°	●	●	●	
	VBGW 160404-2-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.4	5°	●	●	●	

正型35° (VC)

刀片	型号	推荐参数		尺寸(mm)					牌号			几何形状
		进给 (mm/rev)	切深 (mm)	d	la	s	r	α	PD01	PD10	PD20	
	VCGW 110302-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.2	5°	●	●	●	
	VCGW 110304-1-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.4	5°	●	●	●	
	VCGW 160402-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.2	5°	●	●	●	
	VCGW 160404-1-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.4	5°	●	●	●	
	VCGW 110302-2-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.2	5°	●	●	●	
	VCGW 110304-2-NL-05	0.03-0.2	0.05-0.5	6.35	3.0	3.18	0.4	5°	●	●	●	
	VCGW 110302-2-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.2	5°	●	●	●	
	VCGW 110304-2-NL-05	0.03-0.2	0.05-0.5	9.525	3.0	4.76	0.4	5°	●	●	●	

注：●代表有库存