

PCBN PCD 刀具

PCBN PCD cutting tools

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成都戴梦迪超硬工具有限责任公司  
CHENGDU DIAMOND TOOLS CO.,LTD



## COMPANY 公司简介 introduction



成都戴梦迪超硬工具有限责任公司是专业生产PCBN/PCD金属切削刀具、PCD螺旋立铣刀、PCBN/PCD轧辊刀具、PCD木工刀具、PCD石材刀具、硬质合金螺纹刀具、硬质合金成形刀片的民营企业。

公司制造设备先进，技术力量雄厚。公司的宗旨是“满足用户需求，与用户共同成长”。

公司生产的刀具产品在替代进口刀具；高速切削；高稳定性加工；以车代磨；硬态加工等方面效果显著。

尤其适合于汽车、电子行业的规模化生产。公司目前已成为国内众多汽车及零部件制造厂的指定供应商，知名企业上海大众、潍柴集团、富士康等都是公司的大用户，

《戴梦迪》刀具产品远销欧美市场。

公司已通过ISO9001-2008质量管理体系认证、德国TUV认证、瑞士SGS认证。

Chengdu Diamond Tools Co., Ltd is a leading and professional manufacturer of PCBN/PCD Cutting Tools, PCD End Mills, PCBN/PCD Roller Cutting Tools, PCD Woodworking Tools, PCD Stone Engraving Tools, Carbide Threading Tools and Carbide Forming Tools. We possess advanced equipments and outstanding experts.

Our aim: Try our best to meet customers' need and Grow up together!

Our cutting tools are featured as high-speed cutting, high stability machining, replacement of grinding with turning.

Therefore they are ideal alternative solutions for imported ones.

These products are suitable for the mass production in automobile and electronic industry.

We have been certified supplier of main cutting tools for many automobiles and spare parts factories in China, including the famous corporations- Shanghai Volkswagen, Weichai Group, Foxconn, etc. Meanwhile,

Our DIAMOND branded tools are exported to dozens of countries all over the world.

We are granted ISO9001-2008 certificate,

TUV certification and SGS certification.



# 企业展示

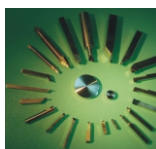


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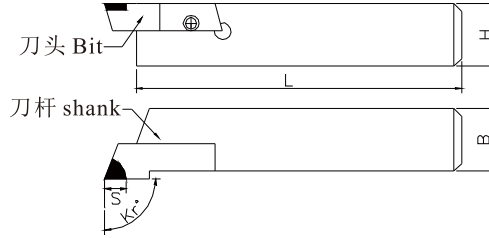
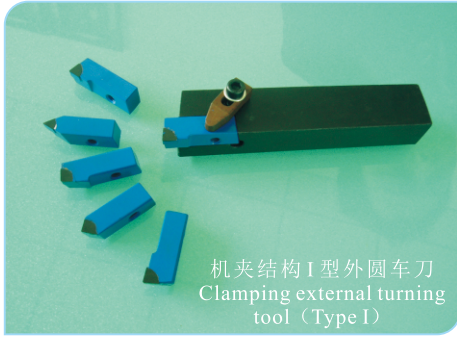


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# PCBN车刀

## 1-1. PCBN机夹结构车刀 PCBN clamping system external turning tools

### 1-1.1 PCBN机夹结构外圆车刀 (I型) PCBN clamping system external turning tools (Type I)



订货代号 Order code	主偏角 Entering angle (Kr°)					刀杆尺寸 (mm) Shank dimension			备注 Remark
	90	75	60	45	切槽 Groove	H	B	L	
PCBN刀头 I型Kr° (s=) 刀杆 I型H×B×L  PCBN tool bit Type I:Kr° (s=) Type I shank H×B×L	★	★	★	★	★	16	16	110	材质分进口与国产, 备有左结构刀  PCBN blank made in China or imported. Providing left style.
	★	★	★	★	★	20	25	125	
	★	★	★	★	★	25	25	150	
	★	★	★	★	★	32	32	170	

▲ 订货举例: PCBN I型刀头90° (S=5) 进口坯10个, 机夹刀杆I型20×25×125 1套  
Example: PCBN tool bit Type I 90° (S=5) imported blank 10PCS, Type I shank 20×25×125 1PC

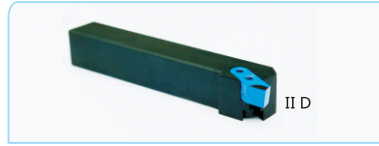
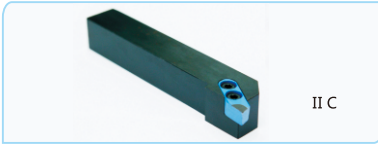
### 1-1.2 PCBN机夹结构外圆车刀 (II型) PCBN clamping system external turning tools (Type II)



机夹结构IIA型车刀 Clamping external turning tool (Type IIA)	订货代号 Order code	刀头 tool bit (R)					刀杆尺寸 (mm) Shank dimension			备注 Remark
		2.0	5.5	6.0	6.5	20	H	B	L	
 PCBN IIA型刀头R= 刀杆 IIA型H×B×L  PCBN tool bit Type IIA: R= Type IIA shank H×B×L	★	★	★	★	★	16	16	110	材质分进口与国产, 备有左结构刀	
	★	★	★	★	★	20	25	125		
	★	★	★	★	★	25	25	150	PCBN blank made in China or imported. Providing left style.	
	★	★	★	★	★	32	32	170		

机夹结构IIB型车刀 Clamping external turning tool (Type IIB)	订货代号 Order code	IIB型刀头 R					刀杆尺寸 (mm) Shank dimension			备注 Remark
		2.0	5.5	6.0	6.5	20	H	B	L	
 PCBN IIB型刀头R= 刀杆 IIB型H×B×L  PCBN tool bit Type IIB: R= Type IIB shank H×B×L	★	★	★	★	★	16	16	110	材质分进口与国产, 备有左结构刀	
	★	★	★	★	★	20	25	125		
	★	★	★	★	★	25	25	150	PCBN blank made in China or imported. Providing left style.	
	★	★	★	★	★	32	32	170		

▲ 订货举例: PCBN II B型刀头R=2进口坯10个, 机夹刀杆II B型25×25×150 1套  
Example: PCBN tool bit Type IIB R=2 imported blank 10 PCS, Type IIB shank 25×25×150 1PC



机夹结构 IIC 型车刀 Clamping external turning tool (Type IIC)	订货代号 Order code	主偏角 Entering angle (Kr°)			刀杆尺寸 (mm) Shank dimension			备注 Remark
		90	92	95	H	B	L	
 刀杆 Shank 刀头 Bit	PCBN刀头 IIC 型 Kr° (s=) 刀杆 IIC 型 H×B×L	★	★	★	16	16	110	材质分进口与国产, 备有左结构刀  PCBN blank made in China or imported. Providing left style.
		★	★	★	20	25	125	
	PCBN tool bit Type IIC : Kr° (s=) Type IIC Shank: H×B×L	★	★	★	25	25	150	
		★	★	★	32	32	170	

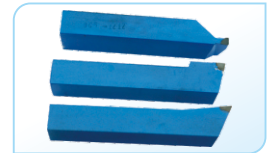
机夹结构 IID 型车刀 Clamping external turning tool (Type IID)	订货代号 Order code	主偏角 Entering angle (Kr°)			刀杆尺寸 (mm) Shank dimension			备注 Remark
		90	92	95	H	B	L	
 刀杆 Shank 刀头 Bit	PCBN刀头 IID型 Kr° (s=) 刀杆 IID 型 H×B×L	★	★	★	16	16	110	材质分进口与国产, 备有左结构刀  PCBN blank made in China or imported. Providing left style.
		★	★	★	20	25	125	
	PCBN tool bit Type IID : Kr° (s=) Type IID Shank H×B×L	★	★	★	25	25	150	
		★	★	★	32	32	170	

机夹结构 IIE 型车刀 Clamping external turning tool (Type IIE)	订货代号 Order code	主偏角 Entering angle (Kr°)			刀杆尺寸 (mm) Shank dimension			备注 Remark
		90	92	95	H	B	L	
 刀杆 Shank 刀头 Bit	PCBN刀头 IIE 型 Kr° (s=) 刀杆 IIE 型 H×B×L	★	★	★	16	16	110	材质分进口与国产, 备有左结构刀  PCBN blank made in China or imported. Providing left style.
		★	★	★	20	25	125	
	PCBN tool bit Type IIE: Kr° (s=) Type IIE shank: H×B×L	★	★	★	25	25	150	
		★	★	★	32	32	170	

▲ 订货举例: PCBN刀头 IID 型 95° (S=9) 10个, 机夹刀杆 IID 型 25×25×150 1套  
 Example: PCBN tool bit Type IID 95° (S=9) 10 PCS, Type IID shank 25×25×150 1PC

### 1-2 PCBN焊接式车刀 PCBN brazed system tools

#### 1-2.1 PCBN焊接式外圆车刀 PCBN brazed system external turning tools



 刀杆 Shank 刀头 Bit	订货代号 Order code	主偏角 Entering angle (Kr°)					刀杆尺寸 (mm) Shank dimension				备注 Remark
		90	75	60	45	切槽 Groove	H	B	L	E	
PCBN刀具 Kr° (s=) H×B×L  PCBN tool : Kr° (s=) H×B×L		★	★	★	★	★	10	10	80	2	材质分进口与国产, 备有左结构刀  PCBN blank made in China or imported. Providing left style.
		★	★	★	★	★	12	12	80	3	
		★	★	★	★	★	16	16	100	3	
		★	★	★	★	★	20	20	125	4	
		★	★	★	★	★	25	25	150	4	

▲ 订货举例: PCBN刀具 90° 20×20×125 (S=5) 进口坯 10把  
 Example: PCBN tool 90° 20×20×125 (S=5) (imported blank) 10 PCS

# PCBN车刀

## 1-2.2 PCBN焊接式内孔镗刀 PCBN brazed system boring tools

### ① 焊接式镗刀 Brazed boring tools



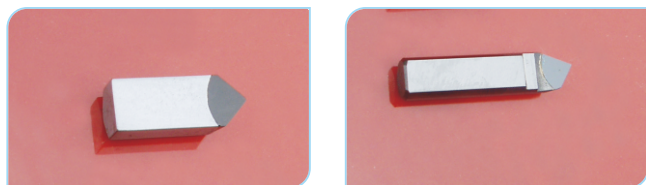
焊接式圆镗刀 Brazed round body boring tool	订货代号 Order code	主偏角 Entering angle (Kr°)				刀杆尺寸 (mm) Shank dimension					备注 Remark
		95	90	75	60	DM	L1	L2	B	H	
	PCBN镗刀 T Kr° φDm×L2	★	★	★	★	10	125	20	18	14	材质分进口与国产， 备有左结构刀 PCBN blank made in China or imported. Providing left style.
	PCBN boring tool T Kr° φDm×L2	★	★	★	★	15	125	30	20	14	
	PCBN boring tool T Kr° φDm×L2	★	★	★	★	20	125	30	20	15	

▲ 订货举例: PCBN镗刀 T75°20×30 (s=5) 10把  
Example: PCBN boring tools T75° φ20\*30 (S=5) 10 PC

焊接式方镗刀 Brazed square body boring tool	订货代号 Order code	主偏角 Entering angle (Kr°)				刀杆尺寸 (mm) Shank dimension					备注 Remark
		95	90	75	60	DM	L1	L2	B	H	
	PCBN镗刀 T Kr° H×B×L1	★	★	★	★	30	140	40	20	20	材质分进口与国产， 备有左结构刀 PCBN blank made in China or imported. Providing left style.
	PCBN boring tool T Kr° H×B×L1	★	★	★	★	40	170	40	25	25	

▲ 订货举例: PCBN镗刀 T75°20×20×140 (s=5) 10把  
Example: PCBN boring tools T75°20\*20\*140 (S=5) 10 PC

### ② 镗刀头 Boring bits

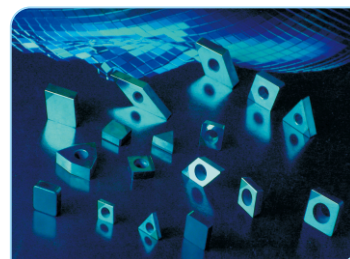


镗刀头 Boring bits	订货代号 Order code	主偏角 Entering angle (Kr°)					刀杆尺寸 (mm) Shank dimension				备注 Remark
		95	90	75	60	45	H	B	L	φ	
PCBN圆镗刀头 CBN round boring bit  	PCBN镗刀头 TKr° φ×L	★	★	★	★	★			25	6	材质分进口与国产， 备有左结构刀 PCBN blank made in China or imported. Providing left style.
	PCBN Boring bit T Kr° φ×L	★	★	★	★	★			35	8	
	PCBN Boring bit T Kr° φ×L	★	★	★	★	★			50	10	
	PCBN Boring bit T Kr° φ×L	★	★	★	★	★			60	12	
	PCBN Boring bit T Kr° φ×L	★	★	★	★	★			70	14	
	PCBN Boring bit T Kr° φ×L	★	★	★	★	★			80	16	
PCBN方镗刀头 CBN square boring bit  	PCBN镗刀头 TKr° H×B×L	★	★	★	★	★	6	6	25		材质分进口与国产， 备有左结构刀 PCBN blank made in China or imported. Providing left style.
	PCBN Boring bit T Kr° H×B×L	★	★	★	★	★	8	8	35		
	PCBN Boring bit T Kr° H×B×L	★	★	★	★	★	10	10	50		
	PCBN Boring bit T Kr° H×B×L	★	★	★	★	★	12	12	60		
	PCBN Boring bit T Kr° H×B×L	★	★	★	★	★	14	14	70		
	PCBN Boring bit T Kr° H×B×L	★	★	★	★	★	16	16	80		

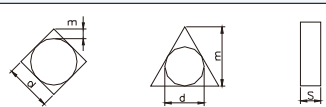
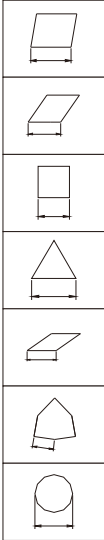
▲ 订货举例: PCBN镗刀 T45° φ8×35进口坯 10个  
Example: PCBN boring bits T45° φ8\*35 (Imported blank) 10 PC



### 1-3.PCBN可转位结构车刀 PCBN indexable system tools



PCBN/PCD 刀片型号编制说明(参照ISO 1832-85) Code key for indexable insert(ISO 1832-85)

<b>3. 精度 Precision</b> 				<b>5. 切削刃长度</b> Cutting edge length 		<b>6. 刀片厚度</b> Thickness <table border="1"> <tr><td>01</td><td>1.59</td></tr> <tr><td>02</td><td>2.38</td></tr> <tr><td>03</td><td>3.18</td></tr> <tr><td>T3</td><td>3.97</td></tr> <tr><td>04</td><td>4.76</td></tr> <tr><td>06</td><td>6.35</td></tr> <tr><td>07</td><td>7.94</td></tr> <tr><td>09</td><td>9.52</td></tr> </table>		01	1.59	02	2.38	03	3.18	T3	3.97	04	4.76	06	6.35	07	7.94	09	9.52	<b>7. 刀片圆弧半径</b> Insert nose radius <table border="1"> <tr><td>00</td><td>0</td></tr> <tr><td>02</td><td>0.2</td></tr> <tr><td>04</td><td>0.4</td></tr> <tr><td>08</td><td>0.8</td></tr> <tr><td>12</td><td>1.2</td></tr> <tr><td>16</td><td>1.6</td></tr> <tr><td>20</td><td>2.0</td></tr> <tr><td>MO</td><td>圆形刀片 Round insert</td></tr> </table>		00	0	02	0.2	04	0.4	08	0.8	12	1.2	16	1.6	20	2.0	MO	圆形刀片 Round insert	<b>10. 修光刃 Wiper land</b> W-有; 无代号-没有 W-Have; No code-None <table border="1"> <tr> <th>主偏角 Entering angle (Kr°)</th> <th>切削方向 Direction</th> </tr> <tr><td>D</td><td>45°</td></tr> <tr><td>E</td><td>60°</td></tr> <tr><td>B</td><td>75°</td></tr> <tr><td>G</td><td>90°</td></tr> <tr><td>J</td><td>93°</td></tr> <tr><td>L</td><td>95°</td></tr> <tr><td>Z</td><td>其它 others</td></tr> <tr><td></td><td>R-Right hand</td></tr> <tr><td></td><td>L-Left hand</td></tr> <tr><td></td><td>N-R&amp;L</td></tr> </table>		主偏角 Entering angle (Kr°)	切削方向 Direction	D	45°	E	60°	B	75°	G	90°	J	93°	L	95°	Z	其它 others		R-Right hand		L-Left hand		N-R&L	<b>12. 刀尖数</b> Cutting edges <table border="1"> <tr><td>S</td><td>整体 Solid</td></tr> <tr><td>F</td><td>1个面 Full face</td></tr> <tr><td>B</td><td>1条边 Entire edge</td></tr> <tr><td>H</td><td>半条边 Semi-edge</td></tr> <tr><td>Cn</td><td>n个角 n Comer</td></tr> </table>		S	整体 Solid	F	1个面 Full face	B	1条边 Entire edge	H	半条边 Semi-edge	Cn	n个角 n Comer				
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L	95°																																																																																
Z	其它 others																																																																																
	R-Right hand																																																																																
	L-Left hand																																																																																
	N-R&L																																																																																
S	整体 Solid																																																																																
F	1个面 Full face																																																																																
B	1条边 Entire edge																																																																																
H	半条边 Semi-edge																																																																																
Cn	n个角 n Comer																																																																																
<table border="1"> <tr> <th>代号 code</th> <th colspan="3">公差 Tolerance (mm)</th> </tr> <tr> <td></td> <th>m</th> <th>d</th> <th>s</th> </tr> <tr><td>A</td><td>±0.005</td><td>±0.025</td><td>±0.025</td></tr> <tr><td>C</td><td>±0.013</td><td>±0.025</td><td>±0.025</td></tr> <tr><td>G</td><td>±0.025</td><td>±0.025</td><td>±0.13</td></tr> <tr><td>M</td><td>±0.08-</td><td>±0.05-</td><td rowspan="2">±0.13</td></tr> <tr><td></td><td>±0.18</td><td>±0.13</td></tr> <tr><td>N</td><td>±0.08-</td><td>±0.05-</td><td rowspan="2">±0.025</td></tr> <tr><td></td><td>±0.18</td><td>±0.13</td></tr> <tr><td>U</td><td>±0.13-</td><td>±0.08-</td><td rowspan="2">±0.13</td></tr> <tr><td></td><td>±0.38</td><td>±0.25</td></tr> </table>				代号 code	公差 Tolerance (mm)				m	d	s	A	±0.005	±0.025	±0.025	C	±0.013	±0.025	±0.025	G	±0.025	±0.025	±0.13	M	±0.08-	±0.05-	±0.13		±0.18	±0.13	N	±0.08-	±0.05-	±0.025		±0.18	±0.13	U	±0.13-	±0.08-	±0.13		±0.38	±0.25	<table border="1"> <tr> <td>T</td><td>N</td><td>M</td><td>A</td><td>16</td><td>04</td><td>08</td><td>T02020</td><td>C</td><td>(WDR)</td><td>N</td><td>C</td> </tr> <tr> <td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td><td>11</td><td>12</td> </tr> </table>										T	N	M	A	16	04	08	T02020	C	(WDR)	N	C	1	2	3	4	5	6	7	8	9	10	11	12			
代号 code	公差 Tolerance (mm)																																																																																
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1	2	3	4	5	6	7	8	9	10	11	12																																																																						
<b>1. 刀片形状</b> Insert shape <table border="1"> <tr><td>C</td><td>D</td></tr> <tr><td>R</td><td>S</td></tr> <tr><td>T</td><td>V</td></tr> <tr><td>W</td><td>其他形状X Other shapeX</td></tr> </table>		C	D	R	S	T	V	W	其他形状X Other shapeX	<b>2. 刀片后角</b> Insert clearance angle <table border="1"> <tr><td>B</td><td>C</td></tr> <tr><td>D</td><td>E</td></tr> <tr><td>P</td><td>N</td></tr> <tr><td>其他° Other°</td><td></td></tr> </table>		B	C	D	E	P	N	其他° Other°		<b>4. 刀片有无断屑槽及中心固定孔</b> Chip breaker and fixing type <table border="1"> <tr><td>A</td><td>M</td></tr> <tr><td>G</td><td>R</td></tr> <tr><td>N</td><td>W</td></tr> <tr><td>T</td><td>特殊X special X</td></tr> </table>		A	M	G	R	N	W	T	特殊X special X	<b>8. 刀口状态</b> Cutting edge condition <table border="1"> <tr> <th>形状 shape</th> <th>宽度 wide</th> <th>角度 angle</th> </tr> <tr><td>F</td><td>—</td><td>—</td></tr> <tr><td>E</td><td>—</td><td>—</td></tr> <tr><td>T</td><td>008-0.08</td><td>05-5°</td></tr> <tr><td></td><td>010-0.10</td><td>10-10°</td></tr> <tr><td></td><td>015-0.15</td><td>15-15°</td></tr> <tr><td></td><td>020-0.20</td><td>20-20°</td></tr> <tr><td></td><td>025-0.25</td><td>25-25°</td></tr> <tr><td></td><td>030-0.30</td><td>30-30°</td></tr> <tr><td></td><td>035-0.35</td><td></td></tr> </table>		形状 shape	宽度 wide	角度 angle	F	—	—	E	—	—	T	008-0.08	05-5°		010-0.10	10-10°		015-0.15	15-15°		020-0.20	20-20°		025-0.25	25-25°		030-0.30	30-30°		035-0.35		<b>9. 前角</b> Rake angle <table border="1"> <tr><td>无 No code</td><td>0°</td></tr> <tr><td>A</td><td>3°</td></tr> <tr><td>B</td><td>5°</td></tr> <tr><td>C</td><td>10°</td></tr> <tr><td>D</td><td>15°</td></tr> <tr><td>X</td><td>其他 Others</td></tr> </table>		无 No code	0°	A	3°	B	5°	C	10°	D	15°	X	其他 Others	<b>11. 材质</b> Material <table border="1"> <tr><td>N</td><td>PCBN</td></tr> <tr><td>D</td><td>PCD</td></tr> </table>		N	PCBN	D	PCD
C	D																																																																																
R	S																																																																																
T	V																																																																																
W	其他形状X Other shapeX																																																																																
B	C																																																																																
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# PCBN车刀

转位结构刀具编号规则 (参照ISO 5680-1989) Indexable tool code key (ISO 5680-1989)

3. 刀具形状 Tool shape								
代号 Code	形状 Shape	偏差 Tolerance	代号 Code	形状 Shape	偏差 Tolerance	代号 Code	形状 Shape	偏差 Tolerance
A		无 No	G		有 Have	P		有 Have
B		无 No			有 Have	Q		有 Have
C		无 No	J		有 Have	S		有 Have
D		无 No	K		有 Have	V		无 No
E		无 No	L		有 Have	X		有 Have
F		有 Have	M		无 No	Y		有 Have

刀柄尺寸 (mm) Shank dimension (mm)	
6. 高度 Height H(mm)	7. 宽度 Width B(mm)








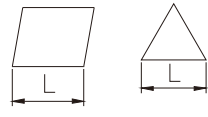

10. 自定义位  
Manufacturer's option

外圆用 external turning	P	C	L	N	R	32	25	P	12	X
	1	2	3	4	5	6	7	8	9	10

1. 夹紧方式 Clamping system		2. 刀片形状 Insert shape		4. 刀片后角 Clearance angle		6. 刀头方向 Feed direction		8. 刀杆长度(mm) Shank length		9. 刃口有效长度 Cutting edge length	
C	单向式 Clamp	C		N	0°	R	右 Right	F	80	代号 Code	mm
D	单动双夹式 Double clamp	D						B	5°	L	左 Left
E	偏心轴式 Eccentric bolt	K		C	7°	N	常规 Normal	K	125		
M	多向式 Multi clamp	R		P	11°			S	150	M	170
P	轴向式 Pole direction Clamp	S						P	180	15	15.875
S	螺栓紧固式 Screw clamp	T						R	200	19	19.05
T	锥度紧固式 Taper clamp	V						S	250		
W	楔式 Wedge clamp	W						T	300		
								U	350		

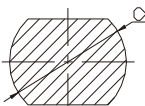
# PCBN金属切削车刀

PCBN cutting tools for metal materials

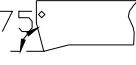


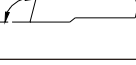

1.刀杆材料 Shank material		3.刀杆长度 (mm) Shank length		5.刀片形状 Insert shape		8.刀头方向 Feed direction		9.刃口有效长度 Cutting edge length		
S	C	F	80	C		菱形80° Rhomb 80°	R	右 Right	代号 Code	mm
Steel	硬质合金 (带钢头) Carbide (with steel head)	H	100	D		菱形55° Rhomb 55°			06	6.35
		K	125	K		四边形55° Quadrangle 55°			09	9.525
		M	150	R		圆形 Round	12	12.7		
		P	170	S		正方形 Square	15	15.875		
		Q	180	T		三角形 Triangular	19	19.05		
		R	200	V		菱形35° Rhomb 35°				
		S	250	W		异六边形 Trigon 80°				
		T	300							
		U	350							

内孔用  
internal boring

S	25	R	-	M	S	K	N	R	12
1	2	3		4	5	6	7	8	9

2.刀杆直径 Shank diameter


4.夹紧方式 Clamping system	
C	单向式 Clamp
D	单动双夹式 Double clamp
E	偏心轴式 Eccentric bolt
M	多向式 Multi clamp
P	轴向式 Pole direction
S	螺栓紧固式 Screw clamp
T	锥度紧固式 Taper clamp
W	楔式 Wedge clamp

6.刀头形状 Tool bit shape	
代号 Code	形状 Shape
K	
F	
U	
L	
Q	

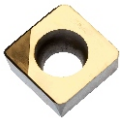
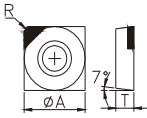
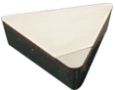
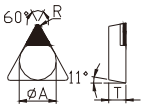

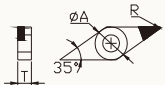
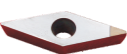
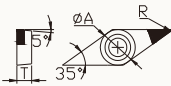
7.刀片后角 Clearance angle of insert	
N	0°
B	5°
C	7°
P	11°

## 1-3.1 PCBN可转位结构刀片 PCBN indexable inserts

刀片形状 Insert shape		订货代号 Order code	尺寸 Dimension ( mm )			
			内接圆A Inscribed circle	厚度T Insert thickness	刀尖圆弧R Nose radius	孔径 D Diameter
		RNGN09T3MOT02020-NF	9.525	3.97		
		RNGN10T3MOT02020-NF	10.0			
		RNGN12T3MOT02020-NF	12.7			
		RNGN13T3MOT02020-NF	13.0			
		RNGN1504MOT02020-NF	15.875	4.76		
		RNGN1906MOT02020-NF	19.05	6.35		
		SNGN09T304T02020-NF	9.525	3.97	0.4	
		SNGN09T308T02020-NF			0.8	
		SNGN09T312T02020-NF			1.2	
		SNGN120408T02020-NF	12.7	4.76	0.8	
		TPGN11T302T02020-NF	6.35	3.97	0.2	
		TPGN11T304T02020-NF			0.4	
		TPGN11T308T02020-NF			0.8	
		TPGN160408T02020-NF	9.525	4.76	0.8	
		CCGW060202T01020-NB	6.35	2.38	0.2	2.8
		CCGW060204T01020-NB			0.4	
		CCGW09T304T02020-NB	9.525	3.97	0.4	4.4
		SCGW090308T02020-NB	9.525	3.18	0.8	4.4
		SCGW09T304T02020-NB			0.4	
		SCGW09T308T02020-NB			0.8	
		DNGA150404T01020-NC2	12.7	4.76	0.4	5.16
		DNGA150408T01020-NC2			0.8	
		DNGA150412T02020-NC2			1.2	
		DNGA150604T01020-NC2			0.4	
		DNGA150608T01020-NC2			0.8	
		DNGA150612T02020-NC2			1.2	
		DCGW070202T01020-NC2	6.35	2.38	0.2	2.8
		DCGW070204T01020-NC2	6.35	2.38	0.4	2.8
		DCGW11T302T01020-NC2	9.525	3.97	0.2	4.4
		DCGW11T304T01020-NC2	9.525	3.97	0.4	4.4
		DCGW11T308T02020-NC2	9.525	3.97	0.8	4.4
		CNGA09T304T02020-NC2	9.525	3.97	0.4	3.81
		CNGA120408T02020-NC2	12.7	4.76	0.8	5.16
		CNGA120412T02020-NC2			1.2	
		VBGW110304T01020-NC2	6.35	3.18	0.4	2.8
		VBGW110308T01020-NC2	6.35	3.18	0.8	4.4
		VBGW160404T01020-NC2	9.525	4.76	0.4	2.8
		VBGW160408T01020-NC2	9.525	4.76	0.8	4.4
		SNGN090304T01020-NC	9.525	3.18	0.4	
		SNGN090308T02020-NC			0.8	
		SNGN120408T02020-NC	12.7	4.76	0.8	
		SNGN120412T02020-NC			1.2	

刀片形状 Insert shape		订货代号 Order code	尺寸 Dimension ( mm )			
			内接圆A Inscribed circle	厚度T Insert thickness	刀尖圆弧R Nose radius	孔径 D Diameter
		TNGA160404T02020-NC	9.525	4.76	0.4	3.81
		TNGA160408T02020-NC			0.8	
		TNGA160412T02020-NC			1.2	
		TNGA220408T02020-NC	12.7	4.76	0.8	5.16
		TNGA220412T02020-NC			1.2	
		TCGW110202T01020-NC	6.35	2.38	0.2	2.8
		TCGW110204T01020-NC			0.4	
		TCGW110208T01020-NC			0.8	
		TCGW110304T02020-NC	6.35	3.18	0.4	3.3
		TCGW110308T02020-NC			0.8	
		CNGN090304T01020-NC	9.525	3.18	0.4	
		CNGN120404T02020-NC	12.7	4.76	0.4	
		CNGN120408T02020-NC			0.8	
		CCGW050202T01020-NC	5.56	2.38	0.2	2.8
		CCGW050204T01020-NC			0.4	
		CCGW060202T01020-NC	6.35		0.2	
		CCGW060204T01020-NC			0.4	
		CCGW060208T01020-NC			0.8	
		CCGW09T302T01020-NC	9.525	3.97	0.2	4.4
		CCGW09T304T02020-NC			0.4	
		CCGW09T308T02020-NC			0.8	
		CCGW120404T02020-NC	12.7	4.76	0.4	5.16
CCGW120408T02020-NC			0.8			
		DNGA150404T02020-NC	12.7	4.76	0.4	5.16
		DNGA150408T02020-NC			0.8	
		DNGA150412T02020-NC			1.2	
		DNGA150604T02020-NC		6.35	0.4	6.35
		DNGA150608T02020-NC			0.8	
		DCGW070202T01020-NC	6.35	2.38	0.2	2.8
		DCGW070204T01020-NC			0.4	
		DCGW070208T01020-NC			0.8	
		DCGW110302T01020-NC	9.525	3.18	0.2	4.4
		DCGW110304T02020-NC			0.4	
		DCGW110308T02020-NC			0.8	
		DCGW11T304T02020-NC		3.97	0.4	
		DCGW11T308T02020-NC			0.8	
		SNGA120404T01020-NC	12.7	4.76	0.4	5.16
		SNGA120408T02020-NC			0.8	
		SNGA120412T02020-NC			1.2	
		SNGA150404T01020-NC	15.875	6.35	0.4	6.35
		SNGA150604T02020-NC			0.8	
		SNGA150608T02020-NC			1.2	

# PCBN车刀

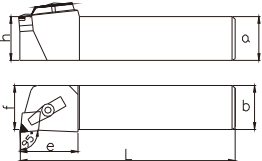
刀片形状 Insert shape	订货代号 Order code	尺寸 Dimension ( mm )			
		内接圆A Inscribed circle	厚度T Insert thickness	刀尖圆弧R Nose radius	孔径 D Diameter
 	SCGW090304T01020-NC	9.525	3.18	0.4	4.4
	SCGW090308T02020-NC			0.8	
	SCGW090312T02020-NC			1.2	
	SCGW09T304T02020-NC	9.525	3.97	0.4	4.4
	SCGW09T308T02020-NC			0.8	
	SCGW09T312T02020-NC			1.2	
 	TPGN090204T01020-NC	5.56	2.38	0.4	
	TPGN110304T01020-NC	6.35	3.18	0.4	
	TPGN110308T02020-NC			0.8	
	TPGN16T304T02020-NC	9.525	3.97	0.4	
	TPGN16T308T02020-NC		3.97	0.8	
 	VNGA160404T01020-NC	9.525	4.76	0.4	3.81
	VNGA160408T01020-NC			0.8	
	VNGA220408T01020-NC	12.7	4.76	0.8	5.16
 	VBGW160404T01020-NC	9.525	4.76	0.4	4.4
	VBGW160408T01020-NC			0.8	

▲ 订货举例: PCBN刀片SCGW09T308T02020-NC 50片  
Example: PCBN insert SCGW09T308T02020-NC 50 PCS

## 1-3.2 PCBN可转位结构外圆车刀 PCBN indexable external turning tools

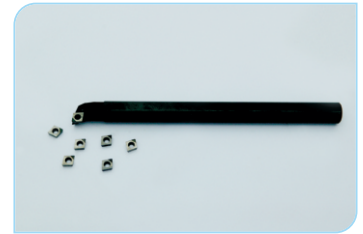


95°转位结构外圆车刀 95° External turning tool

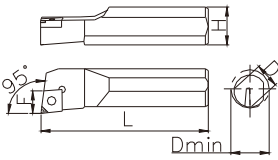
结构图 Structure	订货代号 Order code	尺寸 Dimension ( mm )						PCBN刀片 PCBN inserts
		a	h	b	l	f	e	
	MCLNR/L1616H09	16	16	16	100	13	32	CNMA09T308T02020-NC
	MCLNR/L2020K12	20	20	20	125	17	33	CNMA120408T02020-NC
	MCLNR/L2525M12	25	25	25	150	22	38	CNMA120408T02020-NC
	MCLNR/L3225P12	32	32	25	170	27	38	CNMA120408T02020-NC
	MCLNR/L3232P12	32	32	32	170	27	38	CNMA120408T02020-NC

▲ 订货举例: PCBN刀片 CNMA120408T02020-NC 10片 刀杆 MCLNR2525M12 1套  
Example: PCBN insert CNMA120408T02020-NC 10PCS Shank MCLNR2525M12 1PC

### 1-3.3 PCBN可转位结构内孔镗刀 PCBN indexable boring tools



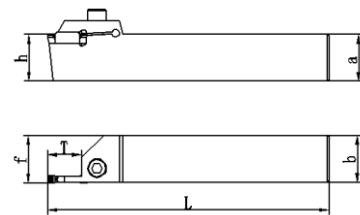
95°转位结构内孔镗刀 95° Indexable boring tools

结构图 Structure	订货代号 Order code	尺寸 Dimension (mm)				最小镗孔径 min. Boring dia. φDmin(mm)	PCBN刀片 PCBN inserts
		F	H	D	L		
	S10K-SCLPR/L06	7	9	10	125	13	CPGW060204T02020-NC
	S12M-SCLPR/L06	9	11	12	150	16	CPGW060204T02020-NC
	S16R-SCLPR/L09	11	15	16	200	20	CPGW09T308T02020-NC
	S20S-SCLPR/L09	13	18	20	250	25	CPGW09T308T02020-NC
	S25T-SCLCR/L12	17	23	25	300	32	CPGW120408T02020-NC
	S32U-SCLCR/L12	22	30	32	350	40	CPGW120408T02020-NC

▲ 订货举例: PCBN刀片 CPGW09T308T02020-NC 10片 刀杆 S20S-SCLPR09 1套  
Example: PCBN insert CPGW09T308T02020-NC 10PCS Shank S20S-SCLPR09 1PC

### 1-3.4 PCBN可转位结构切槽刀 PCBN indexable grooving tools

#### 1-3.4.1 PCBN可转位结构切槽刀(I型) PCBN indexable grooving tools (Type I)



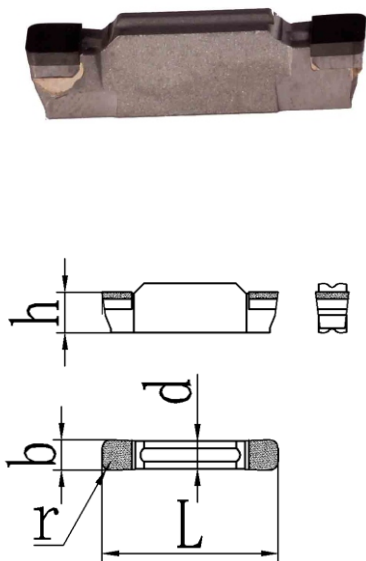
订货代号 Order code	尺寸 Dimension (mm)						PCBN刀片 PCBN inserts
	a	h	b	l	f	T	
MGEHR/L1616-2	16	16	16	100	16.5	14.5	MGMN200R□□
MGEHR/L2020-2	20	20	20	125	20.25	14.5	
MGEHR/L2525-2	25	25	25	150	25.25	14.5	
MGEHR/L1616-2.5	16	16	16	100	16.3	16.5	MGMN250R□□
MGEHR/L2020-2.5	20	20	20	125	20.3	16.5	
MGEHR/L2525-2.5	25	25	25	150	25.3	16.5	
MGEHR/L1616-3	16	16	16	100	16.4	18	MGMN300R□□ MRMN300
MGEHR/L2020-3	20	20	20	125	20.4	18	
MGEHR/L2020-3-T10	20	20	20	125	20.4	10	
MGEHR/L2525-3	25	25	25	150	25.4	18	
MGEHR/L2525-3-T10	25	25	25	150	25.4	10	
MGEHR/L3232-3	32	32	32	170	32.4	18	
MGEHR/L3232-3-T10	32	32	32	170	32.4	10	

订货代号 Order code	尺寸 Dimension ( mm )						PCBN刀片 PCBN inserts
	a	h	b	l	f	T	
MGEHR/L2020-4	20	20	20	125	20.4	18	MGMN400R□□ MRMN400
MGEHR/L2020-4-T10	20	20	20	125	20.4	10	
MGEHR/L2525-4	25	25	25	150	25.4	18	
MGEHR/L2525-4-T10	25	25	25	150	25.4	10	
MGEHR/L3232-4	32	32	32	170	32.4	18	
MGEHR/L3232-4-T10	32	32	32	170	32.4	10	
MGEHR/L2020-5	20	20	20	125	20.5	23	MGMN500R□□
MGEHR/L2020-5-T15	20	20	20	125	20.5	15	
MGEHR/L2525-5	25	25	25	150	25.5	23	
MGEHR/L2525-5-T15	25	25	25	150	25.5	15	
MGEHR/L3232-5	32	32	32	170	32.5	23	
MGEHR/L3232-5-T15	32	32	32	170	32.5	15	
MGEHR/L2020-6	20	20	20	125	20.6	23	MGMN600R□□
MGEHR/L2020-6-T15	20	20	20	125	20.6	15	
MGEHR/L2525-6	25	25	25	150	25.6	23	
MGEHR/L2525-6-T15	25	25	25	150	25.6	15	
MGEHR/L3232-6	32	32	32	170	32.6	23	

▲ 订货举例：PCBN切槽刀片 MGMN300R08 10片 刀杆MGEHR/L2020-3-T10 1把  
 Example: PCBN grooving insert MGMN300R08 10 PCS, Shank MGEHR/L2020-3-T10 1 PC

### 1-3.4.2 PCBN可转位切槽刀片 (I型) PCBN indexable grooving inserts (TypeI)

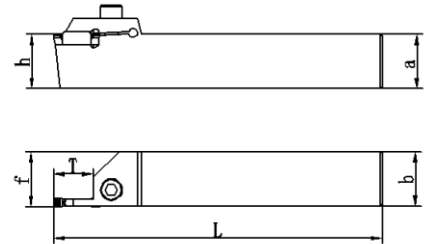
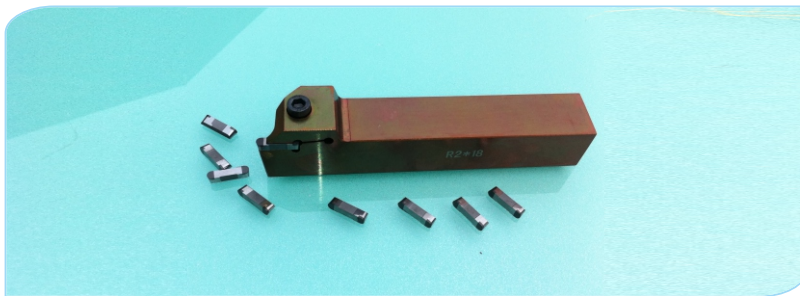
订货代号 Order code	尺寸 Dimension ( mm )				
	b	r	L	d	h
MGMN200R02	2.0	0.2	16	1.6	3.5
MGMN250R02	2.5	0.2	18.5	2.0	3.85
MGMN300R02	3.0	0.2	21	2.35	4.8
MGMN300R04	3.0	0.4	21	2.35	4.8
MGMN300R08	3.0	0.8	21	2.35	4.8
MGMN400R02	4.0	0.2	21	3.3	4.8
MGMN400R04	4.0	0.4	21	3.3	4.8
MGMN400R08	4.0	0.8	21	3.3	4.8
MGMN500R02	5.0	0.2	26	4.1	5.8
MGMN500R04	5.0	0.4	26	4.1	5.8
MGMN500R08	5.0	0.8	26	4.1	5.8
MGMN600R02	6.0	0.2	26	5.0	5.8
MGMN600R04	6.0	0.4	26	5.0	5.8
MGMN600R08	6.0	0.8	26	5.0	5.8





	订货代号 Order code	尺寸 Dimension (mm)				
		b	r	L	d	h
	MRMN200	2.0	1.0	16	1.6	3.5
	MRMN300	3.0	1.5	21	2.35	4.8
	MRMN400	4.0	2.0	21	3.3	4.8
	MRMN500	5.0	2.5	26	4.1	5.8
	MRMN600	6.0	3.0	26	5.0	5.8
	MRMN800	8.0	4.0	31	6.0	6.5

### 1-3.4.3 PCBN可转位结构切槽刀 (II型) PCBN indexable grooving tools (Type II)



订货代号 Order code	尺寸 Dimension (mm)						PCBN刀片 PCBN inserts
	a	h	b	l	f	T	
MNEHR/L1616-3-T8	16	16	16	100	16.3	8	NGMN300R□□ NRMN300
MNEHR/L2020-3-T8	20	20	20	125	20.3	8	
MNEHR/L2020-3-T15	20	20	20	125	20.3	15	
MNEHR/L2525-3-T8	25	25	25	150	25.3	8	
MNEHR/L2525-3-T15	25	25	25	150	25.3	15	
MNEHR/L3232-3-T8	32	32	32	170	32.3	8	
MNEHR/L3232-3-T15	32	32	32	170	32.3	15	NGMN400R□□ NRMN400
MNEHR/L2020-4-T8	20	20	20	125	20.3	8	
MNEHR/L2020-4-T15	20	20	20	125	20.3	15	
MNEHR/L2525-4-T8	25	25	25	150	25.3	8	
MNEHR/L2525-4-T15	25	25	25	150	25.3	15	
MNEHR/L3232-4-T8	32	32	32	170	32.3	8	
MNEHR/L3232-4-T15	32	32	32	170	32.3	15	NGMN500R□□ NRMN500
MNEHR/L2020-5-T10	20	20	20	125	20.4	10	
MNEHR/L2020-5-T15	20	20	20	125	20.4	15	
MNEHR/L2525-5-T10	25	25	25	150	25.4	10	NGMN500R□□ NRMN500
MNEHR/L2525-5-T15	25	25	25	150	25.4	15	
MNEHR/L3232-5-T10	32	32	32	170	32.4	10	
MNEHR/L3232-5-T15	32	32	32	170	32.4	15	

订货代号 Order code	尺寸 Dimension ( mm )						PCBN刀片 PCBN inserts
	a	h	b	l	f	T	
MNEHR/L2020-6-T10	20	20	20	125	20.5	10	NGMN600R□□ NRMN600
MNEHR/L2020-6-T15	20	20	20	125	20.5	15	
MNEHR/L2525-6-T10	25	25	25	150	25.5	10	
MNEHR/L2525-6-T15	25	25	25	150	25.5	15	
MNEHR/L3232-6-T10	32	32	32	170	32.5	10	
MNEHR/L3232-6-T15	32	32	32	170	32.5	15	

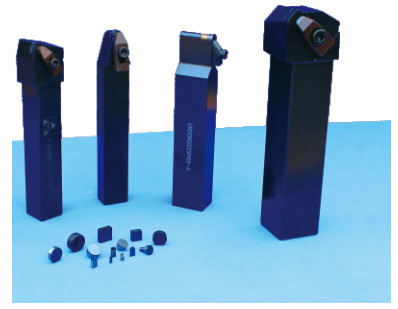
### 1-3.4.4 PCBN可转位切槽刀片 ( II 型 ) PCBN indexable grooving inserts (Type II)

订货代号 Order code	尺寸 Dimension ( mm )				
	B	R	L	D	H
NGMN300R02	3.0	0.2	18	2.35	4
NGMN300R04	3.0	0.4	18	2.35	4
NGMN300R08	3.0	0.8	18	2.35	4
NGMN400R02	4.0	0.2	18	3.3	5
NGMN400R04	4.0	0.4	18	3.3	5
NGMN400R08	4.0	0.8	18	3.3	5
NGMN500R02	5.0	0.2	22	4.1	6
NGMN500R04	5.0	0.4	22	4.1	6
NGMN500R08	5.0	0.8	22	4.1	6
NGMN600R02	6.0	0.2	22	5.0	6
NGMN600R04	6.0	0.4	22	5.0	6
NGMN600R08	6.0	0.8	22	5.0	6
NRMN300	3.0	1.5	18	2.35	4.8
NRMN400	4.0	2.0	18	3.3	4.8
NRMN500	5.0	2.5	22	4.1	5.8
NRMN600	6.0	3.0	22	5.0	5.8
★★★★★	★	★	★	★	★
★★★★★	★	★	★	★	★
★★★★★	★	★	★	★	★
★★★★★	★	★	★	★	★
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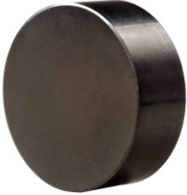

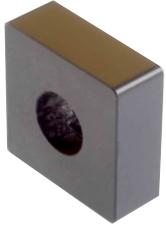
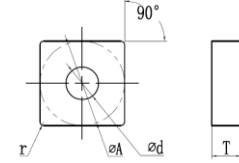
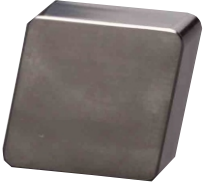
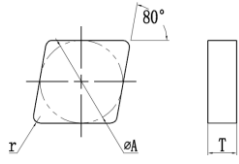
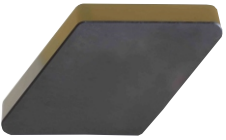
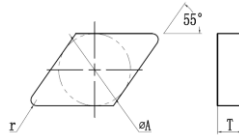
▲ 订货举例: PCBN切槽刀片 II 型 NGMN300R08 10片刀杆MNEHR2525-3-T8 1把  
 Example: PCBN grooving insert (Type II) NGMN300R08 10 PCS, Shank MNEHR2525-3-T8 1 PC

### 1-4. 整体PCBN可转位结构车刀 Indexable solid PCBN cutting tools


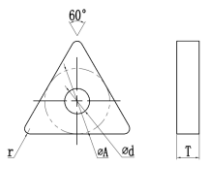
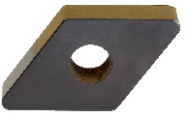
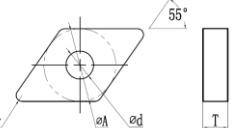

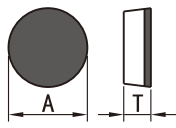
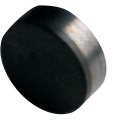

该刀具适合重型工业的断续切削及粗加工  
They are suitable for interrupted and rough machining in heavy industry



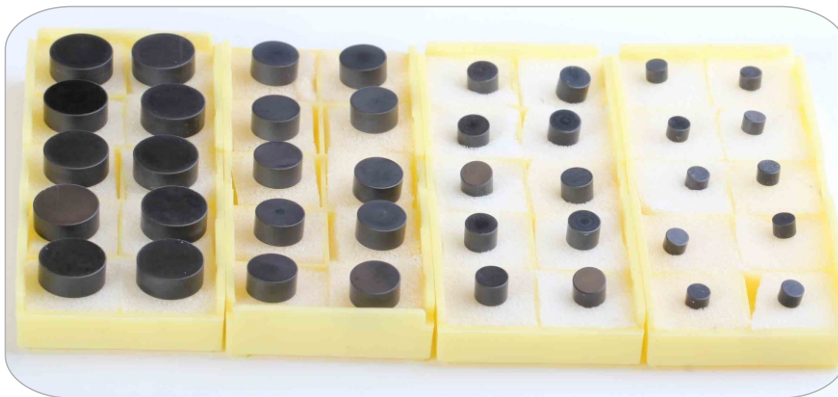
#### 1-4.1 整体PCBN可转位刀片 Indexable solid PCBN cutting inserts

刀片形状 Insert shape		订货代号 Order code	尺寸 dimension			
			ΦA	T	r	Φd
 	RNMN0904Mo-NS	9.525	4.76	0	0	
	RNMN1204Mo-NS	12.7	4.76	0	0	
	RNMN1206Mo-NS	12.7	6.35	0	0	
	RNMN1507Mo-NS	15.875	7.94	0	0	
	RNMN1907Mo-NS	19.05	7.94	0	0	
	RNMN2008Mo-NS	20	8.0	0	0	
 	SNMN090408-NS	9.525	4.76	0.8	5.16	
	SNMN120408-NS	12.7	4.76	0.8	5.16	
	SNMN120412-NS	12.7	4.76	1.2	5.16	
	SNMN120612-NS	12.7	6.35	1.2	5.16	
	SNMN150720-NS	15.875	7.94	2.0	5.16	
	SNMN201020-NS	20	10	2.0	5.16	
 	CNMN090404-NS	9.525	4.76	0.4	0	
	CNMN120408-NS	12.7	4.76	0.8	0	
	CNMN120412-NS	12.7	4.76	1.2	0	
	CNMN120708-NS	12.7	7.94	0.8	0	
	CNMN160412-NS	15.875	4.76	1.2	0	
	CNMN160716-NS	15.875	7.94	1.6	0	
 	DNMN110404-NS	9.525	4.76	0.4	0	
	DNMN110408-NS	9.525	4.76	0.8	0	
	DNMN11T608-NS	9.525	6.75	0.8	0	
	DNMN150408-NS	12.7	4.76	0.8	0	
	DNMN150612-NS	12.7	6.35	1.2	0	
	DNMN150616-NS	12.7	6.35	1.6	0	

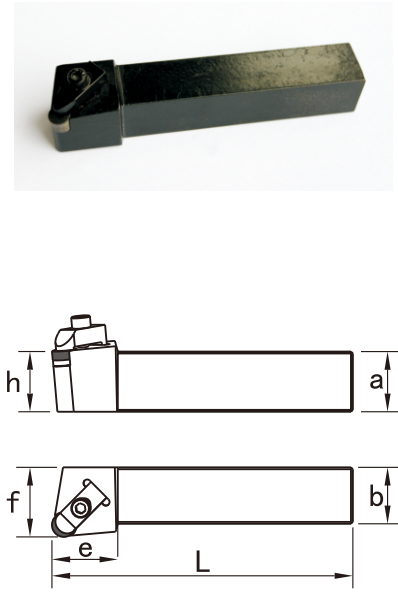
刀片形状 Insert shape		订货代号 Order code	尺寸 dimension			
			$\Phi A$	T	r	$\Phi d$
		RCMN0904Mo-NS	9.525	4.76	0	0
		RCMN1204Mo-NS	12.7	4.76	0	0
		RCMN12T6Mo-NS	12.7	6.75	0	0
		RCMN1507Mo-NS	15.875	7.94	0	0
		RCMN1907Mo-NS	19.05	7.94	0	0
		RCMV0907Mo-NS	9.525	7.94	0	0
		RCMV1207Mo-NS	12.7	7.94	0	0
		RCMV1507Mo-NS	15.875	7.94	0	0
		RCMV1910Mo-NS	19.05		0	0
		RCMV2012Mo-NS	20	12.7	0	0
		RCMV2512Mo-NS	25	12.7	0	0
		RCMX0907Mo-NS	9.525	7.94	0	0
		RCMX1207Mo-NS	12.7	7.94	0	0
		RCMX1507Mo-NS	15.875	7.94	0	0
		RCMX1907Mo-NS	19.05	7.94	0	0
		RCMX2007Mo-NS	20	7.94	0	0
		WNMN060404-NS	9.525	4.76	0.4	0
		WNMN080408-NS	12.7	4.76	0.8	0
		WNMN080412-NS	12.7	4.76	1.2	0
		WNMN100408-NS	15.875	4.76	0.8	0
		WNMN100412-NS	15.875	4.76	1.2	0
		TNMN110308-NS	6.35	3.18	0.8	0
		TNMN160408-NS	9.525	4.76	0.8	0
		TNMN160412-NS	9.525	4.76	1.2	0
		TNMN160416-NS	9.525	4.76	1.6	0
		SNMA120404-NS	12.7	4.76	0.4	5.16
		SNMA120408-NS	12.7	4.76	0.8	5.16
		SNMA120412-NS	12.7	4.76	1.2	5.16
		CNMA120404-NS	12.7	4.76	0.4	5.16
		CNMA120408-NS	12.7	4.76	0.8	5.16
		CNMA120412-NS	12.7	4.76	1.2	5.16
		WNMA080404-NS	12.7	4.76	0.4	5.16
		WNMA080408-NS	12.7	4.76	0.8	5.16
		WNMA080412-NS	12.7	4.76	1.2	5.16

刀片形状 Insert shape		订货代号 Order code	尺寸 dimension			
			ΦA	T	r	Φd
		TNMA160404-NS	9.525	4.76	0.4	3.81
		TNMA160408-NS	9.525	4.76	0.8	3.81
		TNMA160412-NS	9.525	4.76	1.2	3.81
		DNMA150404-NS	12.7	4.76	0.4	5.16
		DNMA150408-NS	12.7	4.76	0.8	5.16
		DNMA150412-NS	12.7	4.76	1.2	5.16
		RCMN09T3Mo-NF	9.525	3.97	0	0
		RCMN10T3Mo-NF	10	3.97	0	0
		RCMN12T3Mo-NF	12.7	3.97	0	0
		RCMN13T3Mo-NF	13	3.97	0	0
		RNMN09T3Mo-NF	9.525	3.97	0	0
		RNMN10T3Mo-NF	10	3.97	0	0
		RNMN12T3Mo-NF	12.7	3.97	0	0
		RNMN13T3Mo-NF	13	3.97	0	0

订货举例：整体PCBN刀片：RNMN1206M0-NS 10片 Order example:Solid PCBN insert:RNMN1206M0-NS 10pcs  
注：表示“NS”表示刀片是整体PCBN，“NF”表示刀片PCBN层是一个面。Remark：“NS”----Solid PCBN,“NF”----Full face PCBN;



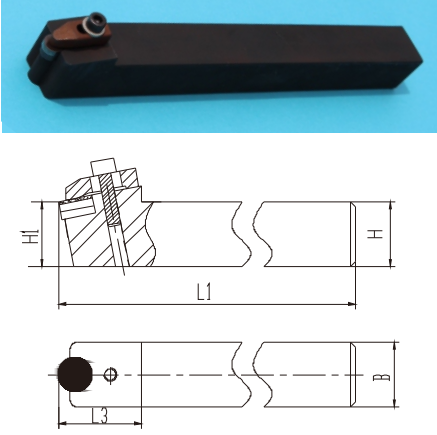
## 1-4.2 可转位整体PCBN圆片车刀(A) Solid PCBN indexable round insert turning tools(A)

结构图 Structure	订货号 Order NO	尺寸 Dimension (mm)						刀片 Insert
		a	h	b	L	e	θ	
	CRGNR/L2525M09	25	25	25	150	35	-	RNGN09T3Mo RNGN0904Mo
	CRGNR/L3225P09	32	32	25	170	35	-	
	CRGNR/L2525M10	25	25	25	150	35	-	RNGN10T3Mo
	CRGNR/L3225P10	32	32	25	170	35	-	
	CRGNR/L3232P10	32	32	32	170	40	-	
	CRGNR/L2525M12	25	25	25	150	35	-	RNGN12T3Mo RNGN1204Mo
	CRGNR/L3225P12	32	32	25	170	35	-	
	CRGNR/L3232P12	32	32	32	170	40	-	
	CRGNR/L2525M13	25	25	25	150	35	-	RNGN13T3Mo
	CRGNR/L3225P13	32	32	25	170	35	-	
	CRGNR/L3232P13	32	32	32	170	40	-	
	CRGNR/L4040R13	40	40	40	200	45	-	RNGN1507Mo RNGN1907Mo
	CRGNR/L4040R15	40	40	40	200	45	-	
CRGNR/L4040R19	40	40	40	200	45	-		

▲订货举例:PCBN刀片RNGN13T3MO-NS 10片,刀杆CRDNR3232P13 1套

Example: PCBN inserts RNGN13T3MO-NS 10 PCS, Tool holder CRDNR3232P13 1PC

## 1-4.3 可转位PCBN圆片车刀(B) PCBN indexable round insert turning tools(B)

	刀杆订货代号 Shank order code	尺寸 Dimension (mm)					CBN刀片 CBN inserts
		H	H1	B	L1	L3	
	CRDNN2520K09□	25	20	20	125	33	RNGN09T3MO -T02020-NF
	CRDNN2525M09□	25	25	25	150	35	
	CRDNN3232P09□	32	32	32	170	40	
	CRDNN2520K10□	25	20	20	125	33	RNGN10T3MO -T02020-NF
	CRDNN2525M10□	25	25	25	150	35	
	CRDNN3232P10□	32	32	32	170	40	
	CRDNN2520K13□	25	20	20	125	33	RNGN13T3MO -T02020-NF
	CRDNN2525M13□	25	25	25	150	35	
	CRDNN3232P13□	32	32	32	170	40	

▲订货举例:PCBN刀片RNGN13T3MO-NF 10片,刀杆CRDNN3232P13 1套

Example: PCBN inserts RNGN13T3MO-NF 10 PCS, Tool holder CRDNN3232P13 1PC

### 1-4.4 可转位整体PCBN圆片车刀(C) Solid PCBN indexable round insert turning tools(C)

结构图 Structure	订货号 Order NO	尺寸 Dimension (mm)						刀片 Insert
		a	h	b	L	e	$\theta$	
	CRDNN3232P09	32	32	32	170	50	20°	RNMN09T3MO RNMN0904MO
	CRDNN3232P10	32	32	32	170	50	20°	RNMN10T3MO
	CRDNN3232P12	32	32	32	170	50	20°	RNMN12T3MO RNMN1206MO
	CRDNN4040S15	40	40	40	250	55	20°	RNMN1507MO
	CRDNN5050T19	50	50	50	300	60	20°	RNMN1907MO
	CRDNN3232P12	32	32	32	170	50	30°	RNMN12T3MO RNMN1206MO
	CRDNN4040S15	40	40	40	250	55	30°	RNMN1507MO
	CRDNN5050T19	50	50	50	300	60	30°	RNMN1907MO

### 1-4.5 可转位整体PCBN圆片车刀(D) Solid PCBN indexable round insert turning tools(D)

结构图 Structure	订货号 Order NO	尺寸 Dimension (mm)						刀片 Insert
		a	h	b	L	e	$\theta$	
	CRDCN3232P09	32	32	32	170	33	-	RCMN09T3MO
	CRDCN3232P10	32	32	32	170	33	-	RCMN10T3MO
	CRDCN3232P12	32	32	32	170	33	-	RCMN12T3MO RCMN1206MO
	CRDCN4040S15	40	40	40	250	38	-	RCMN1507MO
	CRDCN5050T15	50	50	50	300	45	-	RCMN1507MO


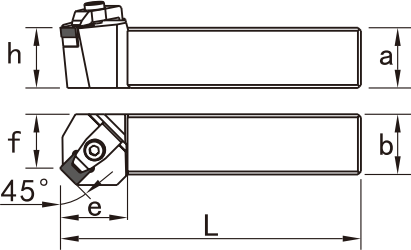
### 1-4.6 75°可转位整体PCBN外圆车刀 75°Solid PCBN indexable insert external turning tool

结构图 Structure	订货号 Order NO	尺寸 Dimension (mm)						刀片 Insert	
		a	h	b	L	f	e		
	CSRNR3232P12	32	32	32	170	35	36	SNMN1204.. SNMN1206..	
	CSRNR3540R15	35	35	40	200	47	38	SNMN1507..	
	CSRNR4040R15	40	40	40	200	47	45	SNMN1507..	
	CSRNR4040R19	40	40	40	200	47	45	SNMN1907..	

▲ 订货举例: PCBN整体刀片 SNMN150712-NS 10片, 刀杆 CSRNR4040R15 1套  
Example: Solid PCBN insert SNMN150712-NS 10 PCS, Tool holder CSRNR4040R15 1PC

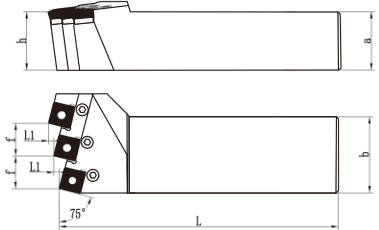
# PCBN车刀

## 1-4.7 45°可转位整体PCBN 外圆车刀 45°Solid PCBN indexable insert external turning tool

结构图 Structure	订货号 Order No.	尺寸 Dimension(mm)						刀片 Insert
		a	h	b	L	f	e	
	CSSNR/L 3232P12	32	32	32	170	30	36	SNMN1204.. SNMN1206..
	CSSNR/L 3540R15	35	35	40	200	36	45	SNMN1507..
	CSSNR/L 4040R15	40	40	40	200	36	45	SNMN1507..
	CSSNR/L 4040R19	40	40	40	200	36	50	SNMN1907..
								

▲ 订货举例:PCBN整体刀片 SNMN120412-NS 10片,刀杆CSSNR3232P12 1套  
Example: Solid PCBN insert SNMN120412-NS 10 PCS, Tool holder CSSNR3232P12 1PC

## 1-4.8 可转位结构整体PCBN排刀 Solid PCBN Indexable insert step structure turning tools

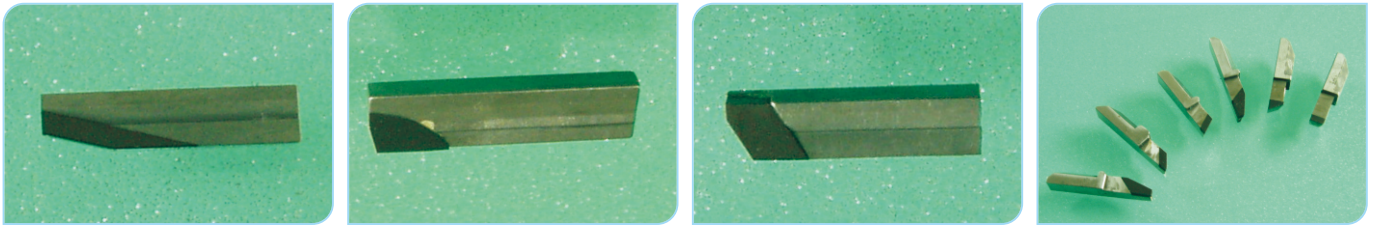
结构图 Structure	订货号 Order No.	尺寸 Dimension(mm)						刀片 Insert
		a	h	b	L	f	L1	
	JT75H50-12	50	50	65	300	20	3	SN..1204..
	JT75H50-15	50	50	65	300	25	4	SN..1504..
	JT75H50-19	50	50	65	300	28	4	SN..1906..


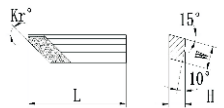

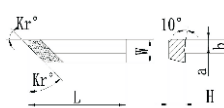

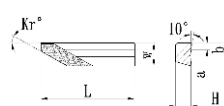

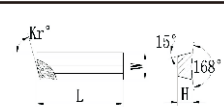
▲ 订货举例:PCBN整体刀片 SNMN190616-NS 10片,刀杆JT75H50-19 1套  
Example: Solid PCBN insert SNMN190616-NS 10 PCS, Tool holder JT75H50-19 1PC





### 1-5 PCBN 铰刀片 PCBN reamers



刀片形状 Insert shape	订货代号 Order code	主偏角 Entering angle (Kr°)					尺寸 Dimension (mm)				
		30	45	60	70	90	W	H	L	a	b
 	MP-11-kr°	★	★	★	★	★	3.5	15	2.5		
		★	★	★	★	★					
		★	★	★	★	★					
 	MP-21-Kr°	★	★	★	★	★	3.6	15	2.5	0.8	2.1
	MP-22-Kr°	★	★	★	★	★	4.1	15	2.5	0.8	2.1
	MP-23-Kr°	★	★	★	★	★	4.4	15	2.5	1.5	2.6
 	MP-31-Kr°	★	★	★	★	★	3.6	15	2.5	0.8	2.1
	MP-32-kr°	★	★	★	★	★	4.1	15	2.5	0.8	2.1
	MP-33-Kr°	★	★	★	★	★	4.4	15	2.5	1.5	2.6
 	MP-41-Kr°	★	★	★	★	★	3.6	15	2		
	MP-42-Kr°	★	★	★	★	★	4.4	16.5	2		
	MP-43-Kr°	★	★	★	★	★	6.6	22	3		

▲ 订货举例: PCBN铰刀片MP-22-45° 10片  
Example: PCBN reamer insert MP-22-45° 10 PCS

刀片形状 Insert shape	订货代号 Order code	主偏角 Entering angle (Kr°)					尺寸 Dimension (mm)					
		30	45	60	70	90	W	L	H	h	B	L1
 	G25-11-kr°	★	★	★	★	★	6	33	6	5	4.5	18.5
		★	★	★	★	★						
		★	★	★	★	★						

▲ 订货举例: PCBN铰刀片 G25-11-45° 10片  
Example: PCBN reamer insert G25-11-45° 10 PCS

# PCD车刀

## 2-1.PCD可转位结构车刀 PCD indexable turning tools

### 2-1.1 PCD可转位刀片 PCD indexable inserts

刀片形状 Insert shape	订货代号 Order code	Dimension ( mm )				
		$\Phi A$	T	r	$\Phi d$	$\theta$
 	CCGW060202-DC	6.35	2.38	0.2	2.8	0
	CCGW060204-DC	6.35	2.38	0.4	2.8	0
	CCGW09T302-DC	9.525	3.97	0.2	4.4	0
	CCGW09T304-DC	9.525	3.97	0.4	4.4	0
	CCGW09T308-DC	9.525	3.97	0.8	4.4	0
	CCGW120402-DC	12.7	4.76	0.2	5.5	0
	CCGW120404-DC	12.7	4.76	0.4	5.5	0
 	CCGT060202FB-DC	6.35	2.38	0.2	2.8	5°
	CCGT060204FB-DC	6.35	2.38	0.4	2.8	5°
	CCGT09T302FC-DC	9.525	3.97	0.2	4.4	10°
	CCGT09T304FC-DC	9.525	3.97	0.4	4.4	10°
	CCGT09T308FC-DC	9.525	3.97	0.8	4.4	10°
	CCGT120402FC-DC	12.7	4.76	0.2	5.5	10°
	CCGT120404FC-DC	12.7	4.76	0.4	5.5	10°
 	DCGW070202-DC	6.35	2.38	0.2	2.8	0
	DCGW070204-DC	6.35	2.38	0.4	2.8	0
	DCGW11T302-DC	9.525	3.97	0.2	4.4	0
	DCGW11T304-DC	9.525	3.97	0.4	4.4	0
	DCGW11T308-DC	9.525	3.97	0.8	4.4	0
 	DCGT070202FC-DC	6.35	2.38	0.2	2.8	10°
	DCGT070204FC-DC	6.35	2.38	0.4	2.8	10°
	DCGT11T302FC-DC	9.525	3.97	0.2	4.4	10°
	DCGT11T304FC-DC	9.525	3.97	0.4	4.4	10°
	DCGT11T308FC-DC	9.525	3.97	0.8	4.4	10°
 	SCGW060202-DC	7.94	2.38	0.2	3.4	0
	SCGW060204-DC	7.94	2.38	0.4	3.4	0
	SCGW09T302-DC	9.525	3.97	0.2	4.4	0
	SCGW09T304-DC	9.525	3.97	0.4	4.4	0
	SCMW09T308-DC	9.525	3.97	0.8	4.4	0

刀片形状 Insert shape		订货代号 Order code	Dimension ( mm )				
			$\Phi A$	T	r	$\Phi d$	$\theta$
		SCGT060202FB-DC	7.94	2.38	0.2	3.4	5°
		SCGT060204FB-DC	7.94	2.38	0.4	3.4	5°
		SCGT09T302FC-DC	9.525	3.97	0.2	4.4	10°
		SCGT09T304FC-DC	9.525	3.97	0.4	4.4	10°
		SCGT09T308FC-DC	9.525	3.97	0.8	4.4	10°
		TCGW090202-DC	5.56	2.38	0.2	2.5	0
		TCGW090204-DC	5.56	2.38	0.4	2.5	0
		TCGW110202-DC	6.35	2.38	0.2	2.8	0
		TCGW110204-DC	6.35	2.38	0.4	2.8	0
		TCGW16T302-DC	9.525	3.97	0.2	4.4	0
		TCGW16T304-DC	9.525	3.97	0.4	4.4	0
		TCGW090202FB-DC	5.56	2.38	0.2	2.5	5°
		TCGW090204FB-DC	5.56	2.38	0.4	2.5	5°
		TCGW110202FC-DC	6.35	2.38	0.2	2.8	10°
		TCGW110204FC-DC	6.35	2.38	0.4	2.8	10°
		TCGW16T302FC-DC	9.525	3.97	0.2	4.4	10°
		TCGW16T304FC-DC	9.525	3.97	0.4	4.4	10°
		TCGW16T308FC-DC	9.525	3.97	0.8	4.4	10°
		TPGN090202-DC	5.56	2.38	0.2	2.5	0
		TPGN090204-DC	5.56	2.38	0.4	2.5	0
		TPGN110202-DC	6.35	2.38	0.2	2.8	0
		TPGN110204-DC	6.35	2.38	0.4	2.8	0
		TPGN110208-DC	6.35	2.38	0.8	2.8	0
		TCGW110202-DB	6.35	2.38	0.2	2.8	0
		TCGW110204-DB	6.35	2.38	0.4	2.8	0
		TCGW16T302-DB	9.525	3.97	0.2	4.4	0
		TCGW16T304-DB	9.525	3.97	0.4	4.4	0
		TCGW16T308-DB	9.525	3.97	0.8	4.4	0
		VCGW110302-DC	6.35	3.18	0.2	2.8	0
		VCGW110304-DC	6.35	3.18	0.4	2.8	0
		VCGW160402-DC	9.525	4.76	0.2	4.4	0
		VCGW160404-DC	9.525	4.76	0.4	4.4	0

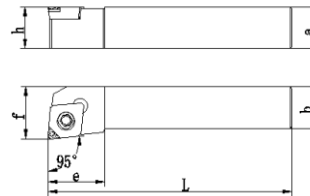
刀片形状 Insert shape		订货代号 Order code	Dimension ( mm )				
			ΦA	T	r	Φd	θ
		VCGT110302FC-DC	6.35	3.18	2.8	0.2	10°
		VCGT110304FC-DC	6.35	3.18	2.8	0.4	10°
		VCGT160402FC-DC	9.525	4.76	4.4	0.2	10°
		VCGT160404FC-DC	9.525	4.76	4.4	0.4	10°
		TPGN060102-DF	3.97	1.59	0.2		
		TPGN060104-DF			0.4		
		TPGN060108-DF			0.8		
		TPGN090204-DF	5.56	2.38	0.4		
		TPGN110304-DF	6.35	3.18	0.4		
		SPGN090304-DF	9.525	3.18	0.4		
		SPGN090308-DF			0.8		
		SPGN09T304-DF			0.4		
		SPGN09T308-DF		3.97	0.8		
		SPGN090304-DC	9.525	3.18	0.4		
		SPGN090308-DC			0.8		
		SPGN090312-DC			1.2		
		SPGN120308-DC	12.7	3.97	0.8		
		SPGN120312-DC			1.2		
		TPGN090204-DC	5.56	2.38	0.4		
		TPGN110304-DC	6.35	3.18	0.4		
		TPGN110308-DC			0.8		
		TPGN16T304-DC	9.525	3.97	0.4		
		TPGN16T308-DC			0.8		
		TPGN220408-DC	12.7	4.76	0.8		
		CPGN090304-DC	9.525	3.18	0.4		
		CPGN090308-DC			0.8		
		CPGN120404-DC	12.7	4.76	0.4		
		TEHW1103PER-DC	6.35	3.18			
		TEHW16T3PER-DC	9.525	3.97			
		SPGN1203EDR-DC	12.7	3.18			
		SPGN1203EDL-DC	12.7	3.18			

刀片形状 Insert shape		订货代号 Order code	Dimension ( mm )				
			ΦA	T	r	Φd	θ
		SECN1203EDR-DC	12.7	3.18			
		SECN1203EDL-DC	12.7	3.18			
		SEGN150412-DC	15.875	4.76	12		

▲ 订货举例：PCD刀片CCGW09T308-DC 10片  
Example：PCD insert CCGW09T308-DC 10 PCS

### 2-1.2 PCD可转位结构外圆车刀 PCD indexable external turning tools

95°SCLCR/L转位结构外圆车刀 95°SCLCR/L External turning tools

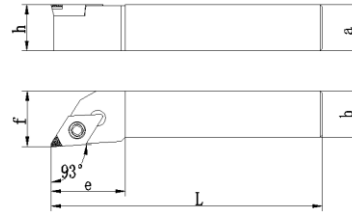


订货代号 Order code	刀杆尺寸 ( mm ) Shank dimension						刀片 insert
	a	h	b	L	f	e	
SCLCR/L1010E06	10	10	10	70	12	11	CC..0602..
SCLCR/L1212F06	12	12	12	80	16	11	
SCLCR/L1212F09	12	12	12	80	16	16	CC..09T3..
SCLCR/L1616H09	16	16	16	100	20	22	
SCLCR/L2020K09	20	20	20	125	25	22	
SCLCR/L2525M09	25	25	25	150	32	22	
SCLCR/L2020K12	20	20	20	125	25	25	CC..1204..
SCLCR/L2525M12	25	25	25	150	32	25	

▲ 订货举例：PCD刀片CCMW09T304 10片 刀杆SCLCR2020K09 1套  
Example: PCD insert CCMW09T304 10 PCS, Shank SCLCR2020K09 1 PC

# PCD车刀

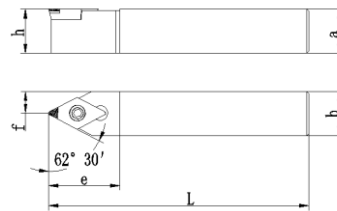
## 93°SDJCR/L转位结构外圆车刀 93°SDJCR/L External turning tools



订货代号 Order code	刀杆尺寸 (mm) Shank dimension						刀片 insert
	a	h	b	L	f	e	
SDJCR/L1010E07	10	10	10	70	12	17	DC..0702..
SDJCR/L1212F07	12	12	12	80	16	19	
SDJCR/L1616H07	16	16	16	100	20	19	
SDJCR/L2020K07	20	20	20	125	25	22	
SDJCR/L2525M07	25	25	25	150	32	22	
SDJCR/L1616H11	16	16	16	100	20	26	DC..11T3..
SDJCR/L2020K11	20	20	20	125	25	26	
SDJCR/L2525M11	25	25	25	150	25	26	

▲订货举例: PCD刀片DCMW070204 10片,刀杆SDJCR/2020K07 1套  
Example: PCD insert DCMW070204 10 PCS, Shank SDJCR/2020K07 1 PC

## 62.5°SDNCN转位结构外圆车刀 62.5°SDNCN External turning tools

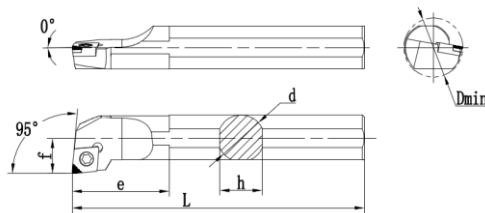


订货代号 Order code	刀杆尺寸 (mm) Shank dimension						刀片 insert
	a	h	b	L	f	e	
SDNCN1010E07	10	10	10	70	5	15	DC..0702..
SDNCN1212F07	12	12	12	80	6	15	
SDNCN1616H07	16	16	16	100	8	15	
SDNCN2020K07	20	20	20	125	10	20	
SDNCN2525M07	25	25	25	150	12.5	20	
SDNCN1616H11	16	16	16	100	8	25	DC..11T3..
SDNCN2020K11	20	20	20	125	10	25	
SDNCN2525M11	25	25	25	150	12.5	25	

▲订货举例: PCD刀片DCMW070204 10片,刀杆SDNCN2020K07 1套  
Example: PCD insert DCMW070204 10 PCS, Shank SDNCN2020K07 1 PC

### 2-1.3 PCD可转位结构内孔镗刀 PCD indexable boring tools

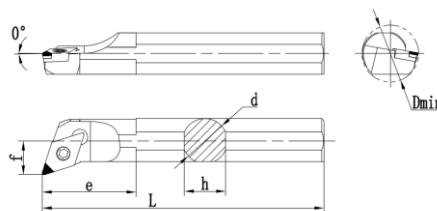
#### 95°SCLCR/L转位结构内孔车刀 95°SCLCR/L Internal boring tools



订货代号 Order code	刀杆尺寸 ( mm ) Shank dimension						刀片 insert
	d	f	L	e	h	Dmin	
S10K-SCLCR/L06	10	7	125	21	9	13	CC..0602..
S12M-SCLCR/L06	12	9	150	25	11	16	
S16R-SCLCR/L09	16	11	200	28	15	20	CC..09T3..
S20S-SCLCR/L09	20	13	250	32	18	25	
S25T-SCLCR/L12	25	17	300	42	23	32	CC..1204..
S32U-SCLCR/L12	32	22	350	50	30	40	

▲ 订货举例：PCD刀片 CCMW09T304 10片,刀杆S20S-SCLCR/L09 1套  
Example: PCD insert CCMW09T304 10 PCS, Shank S20S-SCLCR/L09 1 PC

#### 107.5°SDQCR/L转位结构内孔车刀 107.5°SDQCR/L Internal boring tools

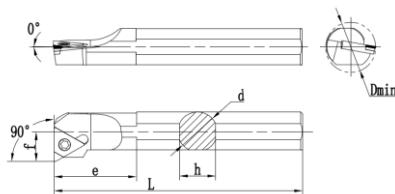


订货代号 Order code	刀杆尺寸 ( mm ) Shank dimension						刀片 insert
	d	f	L	e	h	Dmin	
S10K-SDQCR/L07	10	7	125	21	9	13	DC..0702..
S12M-SDQCR/L07	12	9	150	25	11	16	
S16R-SDQCR/L07	16	11	200	28	15	20	
S20S-SDQCR/L11	20	13	250	32	18	25	DC..11T3..
S25T-SDQCR/L11	25	17	300	40	23	32	
S32U-SDQCR/L11	32	22	350	50	30	40	

▲ 订货举例：PCD刀片 DCMW11T304 10片,刀杆S20S-SDQCR/L11 1套  
Example: PCD insert DCMW11T304 10 PCS, Shank S20S-SDQCR/L11 1 PC

# PCD车刀

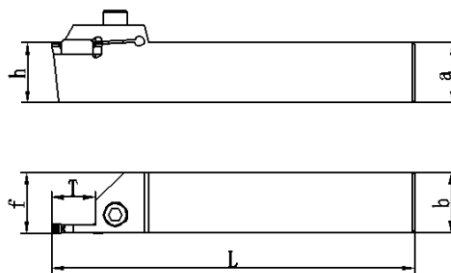
## 90°STFCR/L转位结构内孔车刀 90°STFCR/L Internal boring tools



订货代号 Order code	刀杆尺寸 ( mm ) Shank dimension						刀片 insert
	d	f	L	e	h	Dmin	
S10K-STFCR/L11	10	7	125	21	9	13	TC..1102..
S12M-STFCR/L11	12	9	150	25	11	16	
S16R-STFCR/L11	16	11	200	28	15	20	
S20S-STFCR/L16	20	13	250	32	18	25	TC..16T3..
S25T-STFCR/L16	25	17	300	40	23	32	
S32U-STFCR/L16	32	22	350	50	30	40	

▲ 订货举例：PCD刀片TCMW110204 10片, 刀杆S16R-STFCR/L11 1套  
Example: PCD insert TCMW110204 10 PCS, Shank S16R-STFCR/L11 1 PC

## 2-1.4 PCD可转位结构切槽刀 PCD indexable grooving tools



订货代号 Order code	尺寸 Dimension ( mm )						PCD刀片 PCD inserts
	a	h	b	l	f	T	
MGEHR/L1616-2	16	16	16	100	16.5	14.5	MGMN200R□□
MGEHR/L2020-2	20	20	20	125	20.25	14.5	
MGEHR/L2525-2	25	25	25	150	25.25	14.5	
MGEHR/L1616-2.5	16	16	16	100	16.3	16.5	MGMN250R□□
MGEHR/L2020-2.5	20	20	20	125	20.3	16.5	
MGEHR/L2525-2.5	25	25	25	150	25.3	16.5	
MGEHR/L1616-3	16	16	16	100	16.4	18	MGMN300R□□ MRMN300
MGEHR/L2020-3	20	20	20	125	20.4	18	
MGEHR/L2020-3-T10	20	20	20	125	20.4	10	
MGEHR/L2525-3	25	25	25	150	25.4	18	
MGEHR/L2525-3-T10	25	25	25	150	25.4	10	
MGEHR/L3232-3	32	32	32	170	32.4	18	
MGEHR/L3232-3-T10	32	32	32	170	32.4	10	

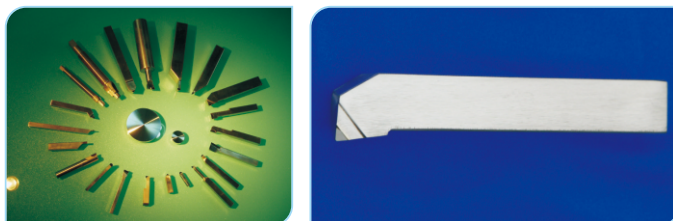


订货代号 Order code	尺寸 Dimension ( mm )						PCD刀片 PCD inserts
	a	h	b	l	f	T	
MGEHR/L2020-4	20	20	20	125	20.4	18	MGMN400R□□ MRMN400
MGEHR/L2020-4-T10	20	20	20	125	20.4	10	
MGEHR/L2525-4	25	25	25	150	25.4	18	
MGEHR/L2525-4-T10	25	25	25	150	25.4	10	
MGEHR/L3232-4	32	32	32	170	32.4	18	
MGEHR/L3232-4-T10	32	32	32	170	32.4	10	
MGEHR/L2020-5	20	20	20	125	20.5	23	MGMN500R□□
MGEHR/L2020-5-T15	20	20	20	125	20.5	15	
MGEHR/L2525-5	25	25	25	150	25.5	23	
MGEHR/L2525-5-T15	25	25	25	150	25.5	15	
MGEHR/L3232-5	32	32	32	170	32.5	23	
MGEHR/L3232-5-T15	32	32	32	170	32.5	15	
MGEHR/L2020-6	20	20	20	125	20.6	23	MGMN600R□□
MGEHR/L2020-6-T15	20	20	20	125	20.6	15	
MGEHR/L2525-6	25	25	25	150	25.6	23	
MGEHR/L2525-6-T15	25	25	25	150	25.6	15	
MGEHR/L3232-6	32	32	32	170	32.6	23	
MGEHR/L3232-6-T15	32	32	32	170	32.6	15	

▲ 订货举例：PCD切槽刀头 MGMT300R04 10个，刀杆MGEHR2525-3-T10 1套  
Example: PCD grooving insert MGMT300R04 10 PCS, Shank MGEHR2525-3-T10 1 PC

## 2-2 PCD焊接式车刀 PCD brazed cutting tools

### 2-2.1 焊接式外圆车刀 PCD brazed external turning tools

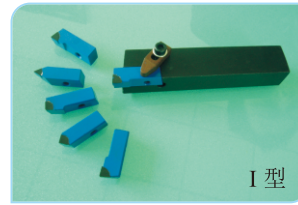


#### ① 焊接式外圆车刀 Brazed external turning tools

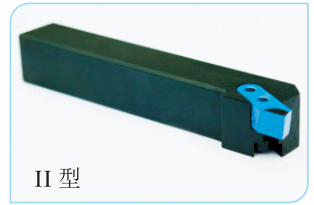
结构图 structure	订货代号 Order code	主偏角 Entering angle ( Kr° )					尺寸 Dimension ( mm )				备注 Remark
		95	90	60	45	切槽 Groove	H	B	L	E	
	PCD刀具 Kr° (S=) H×B×L	★	★	★	★	★	10	10	80	2	材质分进口与国产， 备有左结构刀  PCD blank made-in -China or imported. Providing left style.
		★	★	★	★	★	12	12	80	2	
	PCD tool Kr° (S=) H×B×L	★	★	★	★	★	16	16	100	3	
		★	★	★	★	★	20	20	125	3	
		★	★	★	★	★	25	25	150	4	

▲ 订货举例：PCD刀具90° 20×20×125 ( S=5 ) 10把进口坯  
Example: PCD brazed tools 90° 20\*20\*125 ( S=5 ) 10PCS (Imported blank)

# PCD车刀



I 型



II 型

## ②机夹式外圆车刀 Clamping external turning tools

机夹结构I型外圆车刀 Clamping external turning tool ( Type I )	订货代号 Order code	主偏角 Entering angle ( $Kr^\circ$ )					刀杆尺寸 ( mm ) Shank dimension			备注 Remark
		90	75	60	45	切槽 Groove	H	B	L	
	PCD I 型刀头 $Kr^\circ$ (S=)	★	★	★	★	★	16	16	110	材质分进口与国产, 备有左结构刀  PCD blank made-in -China or imported. Providing left style.
	I 型刀杆H×B×L	★	★	★	★	★	20	25	125	
	PCD Type I tool bit $Kr^\circ$ (S=)	★	★	★	★	★	25	25	150	
	Type I shank H×B×L	★	★	★	★	★	32	32	170	

机夹结构II型外圆车刀 Clamping external turning tool ( Type II )	订货代号 Order code	主偏角 Entering angle ( $Kr^\circ$ )					刀杆尺寸 ( mm ) Shank dimension			备注 Remark
		90	75	60	45	切槽 Groove	H	B	L	
	PCD II 型刀头 $Kr^\circ$ (S=)	★	★	★	★	★	16	16	110	材质分进口与国产, 备有左结构刀  PCD blank made-in -China or imported. Providing left style.
	II 型刀杆H×B×L	★	★	★	★	★	20	25	125	
	PCD Type II tool bit $Kr^\circ$ (S=)	★	★	★	★	★	25	25	150	
	Type II shank H×B×L	★	★	★	★	★	32	32	170	

▲ 订货举例: PCD II 型刀头 $90^\circ$  (S=10) 10个 机夹刀杆 II 型 $20 \times 25 \times 150$  1套  
 Example: PCD Type II tool bit  $90^\circ$  (S=10) 10 PCS, Type II shank  $25 \times 25 \times 150$  1 PC

## 2-2.2 PCD焊接式内孔镗刀 PCD brazed boring tools



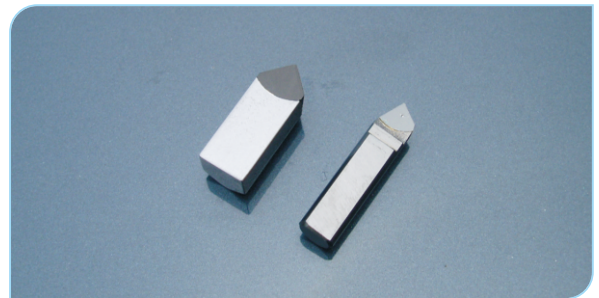
焊接式圆镗刀 Brazed round bar boring tool	订货代号 Order code	主偏角 Entering angle ( $Kr^\circ$ )				尺寸 Dimension ( mm )					备注 Remark
		95	90	75	60	Dm	L1	L2	B	H	
	PCD镗刀 Tkr $\phi$ Dm×L2	★	★	★	★	10	125	20	18	14	材质分进口与国产, 备有左结构刀  PCD blank made-in -China or imported. Providing left style.
	PCD boring tool Tkr $\phi$ Dm×L2	★	★	★	★	15	125	30	20	14	
	PCD boring tool Tkr $\phi$ Dm×L2	★	★	★	★	20	130	30	20	15	

▲ 订货举例: PCD镗刀  $T75^\circ$   $\phi 12 \times 20$  10支  
 Example: PCD boring tool  $T75^\circ$   $\phi 12 \times 20$  10pcs

注: 刀杆直径小于 $\phi 10$ 的镗刀, 建议采用硬质合金刀杆  
 Note: Boring bar diameter less than  $\phi 10$  should be made up of carbide

焊接式方镗刀 Brazed square rod boring tool	订货代号 Order code	主偏角 Entering angle ( Kr° )				尺寸 Dimension ( mm )					备注 Remark
		95	90	75	60	Dm	L1	L2	B	H	
	PCD镗刀 TKr $\phi$ Dm $\times$ L2	★	★	★	★	10	125	20	18	14	材质分进口与国产， 备有左结构刀  PCD blank made-in- China or imported. Providing left style.
	PCD boring tool TKr $\phi$ Dm $\times$ L2	★	★	★	★	15	125	30	20	14	

### 2-2.3 PCD焊接式镗刀头 PCD braze boring bits

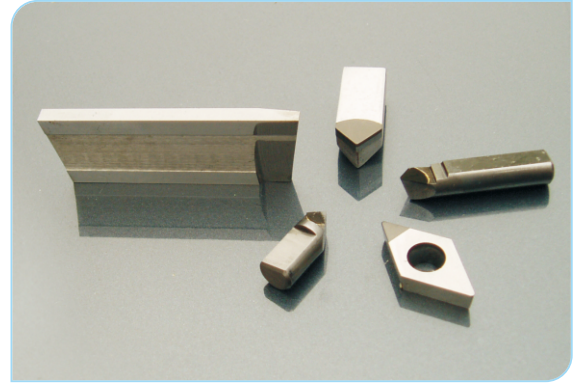
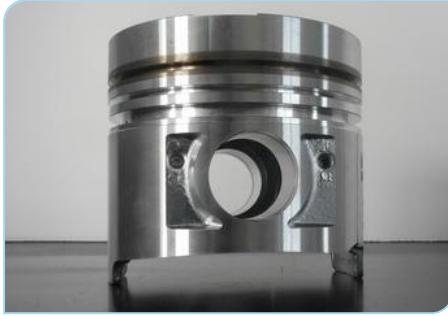


镗刀头 Boring bits	订货代号 Order code	主偏角 Entering angle ( Kr° )					尺寸 Dimension ( mm )				备注 Remark
		95	90	75	60	45	H	B	L	$\phi$	
PCD圆镗刀头 PCD boring bit (roundness)	PCD镗刀头T Kr $\phi$ D $\times$ L  PCD Boring bit TKr° $\phi$ $\times$ L	★	★	★	★	★			25	6	材质分进口与国产， 备有左结构刀  PCD blank made-in-China or imported. Providing left style.
		★	★	★	★	★			35	8	
		★	★	★	★	★			50	10	
		★	★	★	★	★			60	12	
		★	★	★	★	★			70	14	
		★	★	★	★	★			80	16	
PCD方镗刀头 PCD boring bit (square)	PCD镗刀头T KrH $\times$ B $\times$ L  PCD Boring bit TKr° $\phi$ $\times$ L	★	★	★	★	★	6	6	25		材质分进口与国产， 备有左结构刀  PCD blank made-in-China or imported. Providing left style.
		★	★	★	★	★	8	8	35		
		★	★	★	★	★	10	10	50		
		★	★	★	★	★	12	12	60		
		★	★	★	★	★	14	14	70		
		★	★	★	★	★	16	16	80		

▲ 订货举例：10个PCD镗刀头 T 45°  $\phi$  8 $\times$ 35 进口坯 10把  
Example: PCD boring bit T 45°  $\phi$  8 $\times$ 35 (Import blank) 10 PCS

# PCD车刀

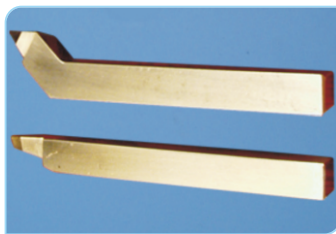
## 2-3. PCD活塞刀具 PCD piston cutters



类型 Type	刀具简图 Tool picture	订货代号 Order code
外圆车刀 External tool		PCD活塞外圆车刀45°8×8×L PCD piston external tool45° 8×8×L
镗孔刀 Boring tool		PCD活塞镗孔刀45°φ8×L PCD piston boring tool T45° φ8×L
矩形切槽刀 Rectangle grooving tool		PCD活塞矩形切槽刀B×H×L PCD piston rectangle grooving tool B×H×L
楔形切槽刀 Wedge grooving tool		PCD活塞楔形切槽刀α°B×H×L PCD piston wedge grooving tool α°B×H×L

▲ 订货举例：PCD活塞矩形切槽刀3×12×70 5把  
 Example: PCD piston rectangle grooving tools 3×12×70 5 PCS

### 2-4 PCD整流子刀具 PCD motor commutator cutters

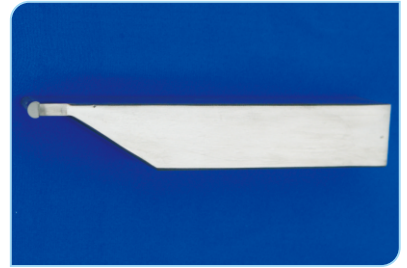
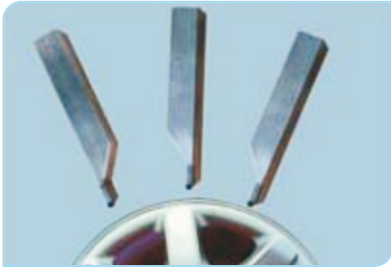


类型 Type	刀具简图 Tool picture	订货代号 Order code
<p>PCD精刮刀 PCD finishing shaving cutter</p>		<p>PCD精刮刀(S=7)B×H×L PCD finishing tool (S=7)B×H×L</p>
<p>PCD电机整流子105°左刀 105° PCD motor commutator left hand cutter</p>		<p>PCD电机整流子105°左刀 (S=7)B×H×L 105° PCD motor commutator left hand cutter(R=)B×H×L</p>
<p>PCD电机整流子刀 PCD motor commutator cutter</p>		<p>PCD电机整流子刀(S=4)B×H×L PCD motor commutator cutter(S=4)B×H×L</p>
<p>PCD电机整流子宽刃刀 PCD motor commutator cutter with wide edge</p>		<p>PCD电机整流子宽刃刀 (S=9)B×H×L PCD motor commutator cutter with wide edge (S=9)B×H×L</p>

▲ 订货举例：PCD电机整流子刀 (S=4) 9×9×90 5把  
Example: PCD motor commutator cutter (S=4) 9×9×90 5 PCS

# PCD车刀

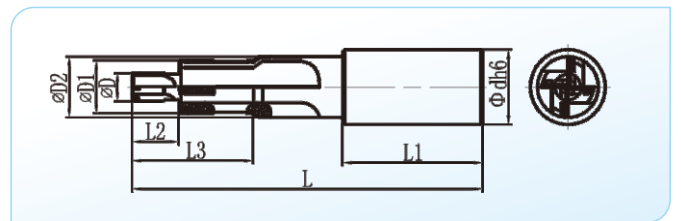
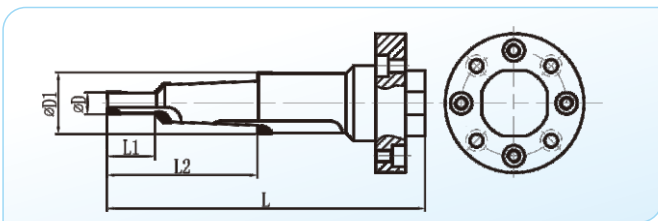
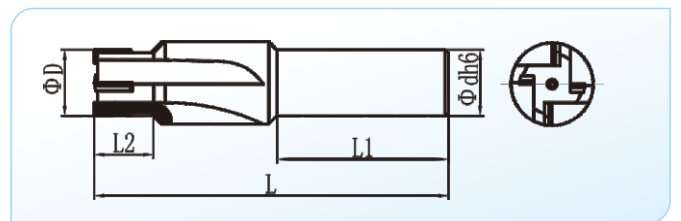
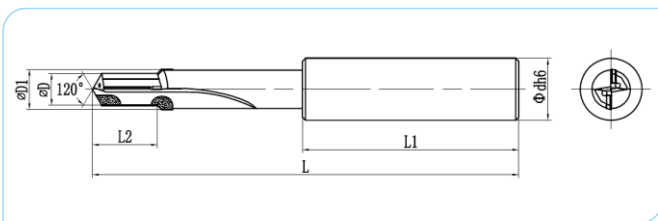
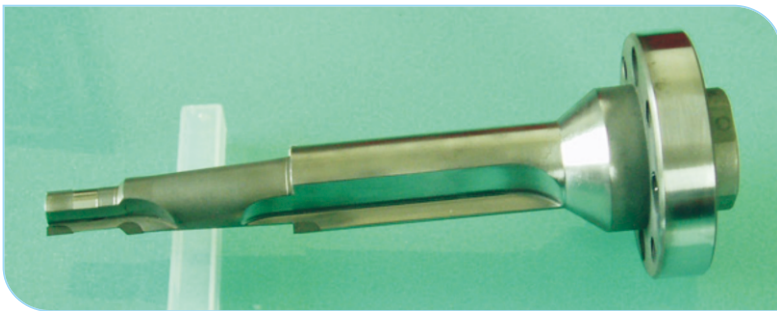
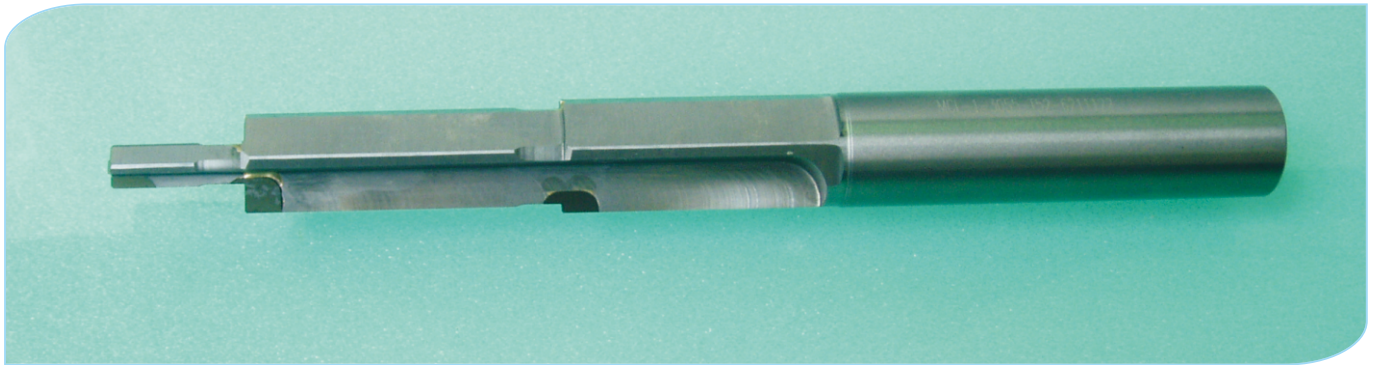
## 2-5.PCD轮毂刀具 PCD wheel hub cutters



类型 Type	刀具简图 Tool picture	订货代号 Order code
R3轮毂刀 R3 wheel hub cutter		PCD R3轮毂刀左25×25×150 备有右结构刀  PCD R3 wheel hub cutter Left 25×25×150 providing right style
R3机夹结构轮毂刀 R3 clamping wheel hub cutter		R3机夹结构轮毂刀B×H×L R3 clamping wheel hub cutter B×H×L
95° 轮毂外圆刀 95° wheel hub external cutter		PCD 95° 轮毂刀具 (R=0.4) B×H×L  PCD 95° (R=0.4) wheel hub external cutter B×H×L
R1.2转位刀片 R1.2 indexable insert		PCD (S=3) 刀片VCMW160412-DC PCD(S=3) insert VCMW160412-DC

▲ 订货举例: PCD R3轮毂刀 左25×25×150 5把  
Order: PCD R3 hub cutter left 25×25×150 5 PCS

## 2-6 PCD阶梯铰刀 PCD reamers with shank



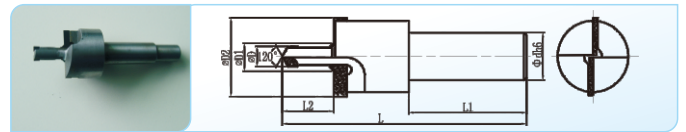
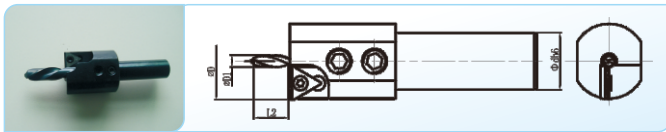
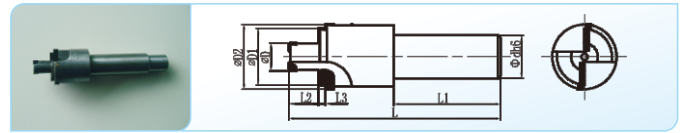
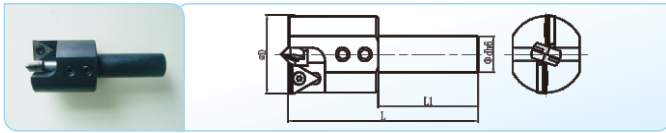
注：可根据用户要求进行设计和生产。  
Note: We can design and produce the reamer according to your concrete requirement.

# PCD车刀

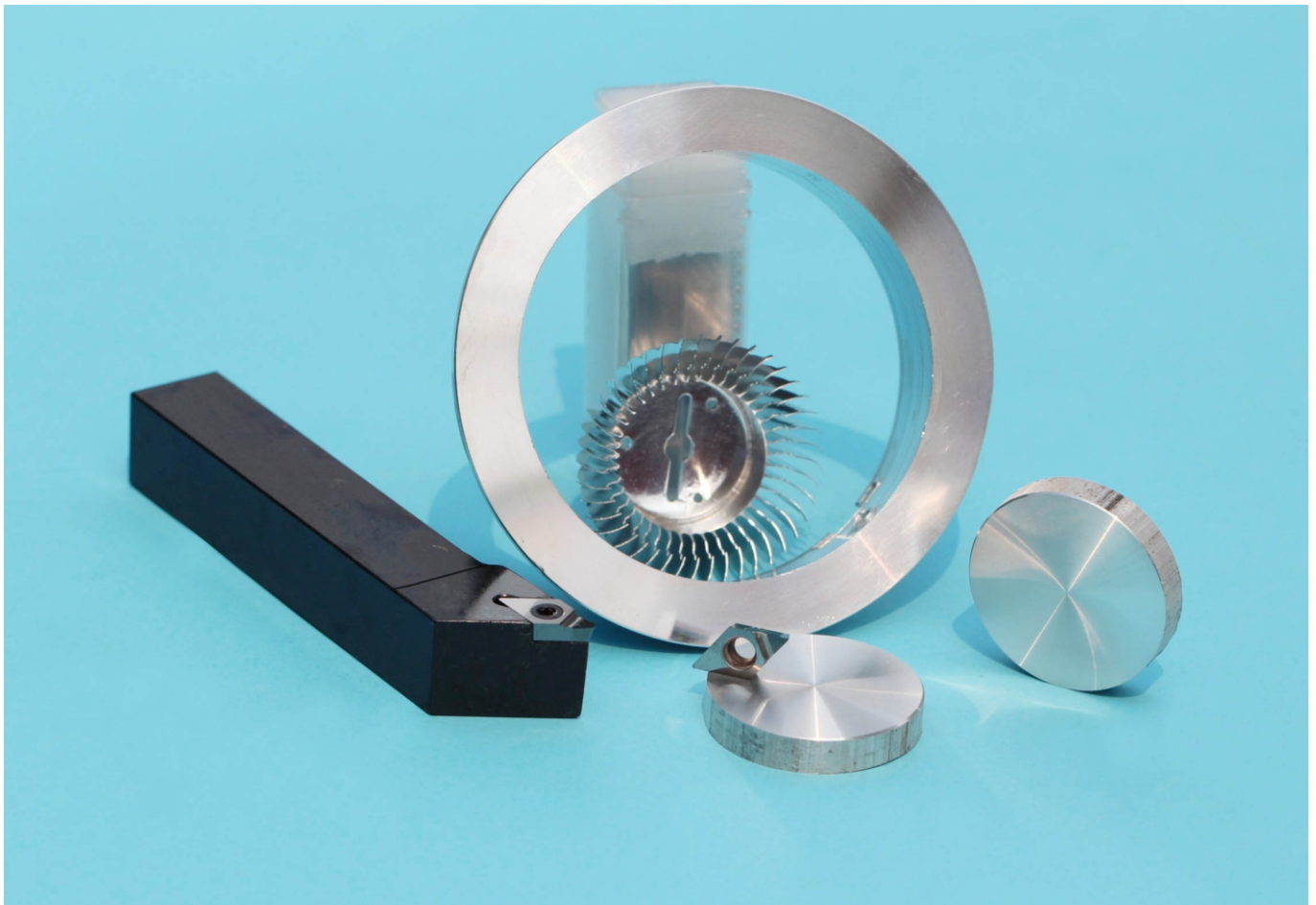
## 2-7.PCD铰刀 PCD countersink cutters

注：可根据用户要求进行设计和生产。

Note : We can design and produce the reamer according to your concrete requirement.

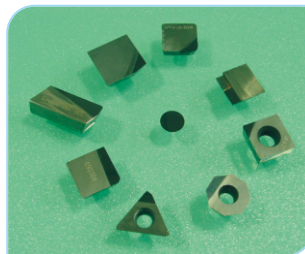


## 2-8.PCD光亮加工刀具 PCD tools for aluminum high-brightness machining





### 3-1.PCD可转位铣刀片 PCD indexable milling inserts



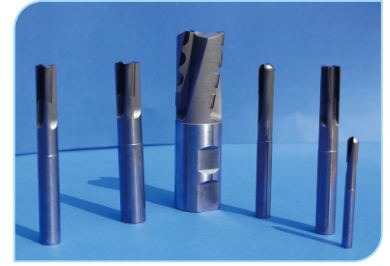
铣刀片规格 Milling insert specification

刀片形状 Insert shape		订货代号 Order code	尺寸 Dimension (mm)							
			D	S	Z	X	$\alpha$	$\beta$	$\gamma$	R
		TEEN1603PEFR	9.525	3.18	1.4	0.6	20°	20°	30°	
		TECN2204PEFR	12.7	4.76	1.4	1	20°	20°	30°	
		TEEW16T3PEFR	9.525	3.97	1.4	0.6	20°	20°	30°	
		TECW2204PEFR	12.7	4.76	1.4	1	20°	20°	30°	
		SECN1203EFR	12.7	3.18	1.4		20°	25°	15°	1.0
		SEEN1203AFFN	12.7	3.18	1.4		20°	25°	45°	
		SEEW1203AFFN	12.7	3.18	1.4		20°	25°	45°	
		ADEW1503PEFR	15	9.525	1	1.5	15°	20°	5°	
		REEN1203MO	12.7	3.18			20°			
		SDEN1203ZEFR	12.7	3.18	5	0.5	15°	20°	3°	
		ODEW0504ZDFR	12.7	4.76			15°	1°	2°	
		XEEN0902ZEFR	12.86	2	9.8		20°			1
		EDR-100-031	26.75	6.35	5.75	0.7				0.8
		SDR-100-31	26.75	9.525	6.35	1.8				0.8

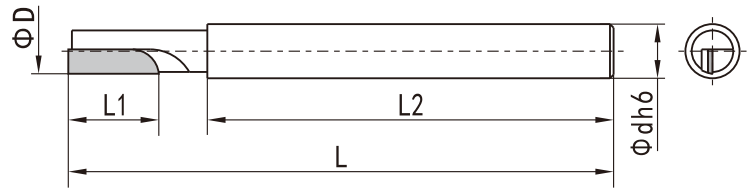
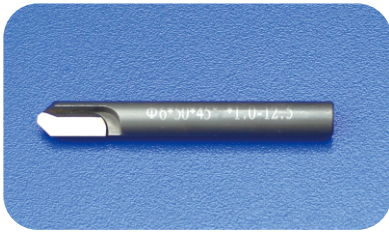
▲ 订货举例：PCD铣刀片TEEW16T3PEFR 10片  
Example : PCD milling insert TEEW16T3PEFR 10 PCS

# PCD铣刀

## 3-2.PCD立铣刀 PCD end milling tools



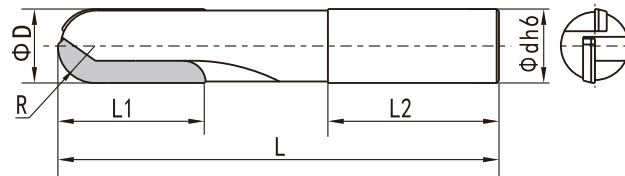
### 3-2.1 PCD 单刃立铣刀 PCD single tip end mill



订货号 Order No.	尺寸 Dimension(mm)					
	刃数 tip	D	d	L	L1	L2
DID04L10	1	4.0	6.0	60	10	45
DID05L10	1	5.0	6.0	60	10	45
DID06L10	1	6.0	6.0	60	10	45

订货举例: PCD 立铣刀 DID04L10 1把 Order example: PCD end mill DID04L10 1PC

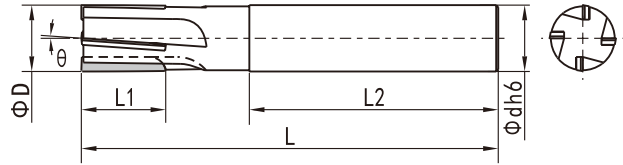
### 3-2.2 PCD 球头立铣刀 PCD ball nose end mill



订货号 Order No.	尺寸 Dimension(mm)						
	刃数 tip	D	d	R	L	L1	L2
DQD04L10	1	4.0	6.0	2	60	10	45
DQD06L10	1	6.0	6.0	3	60	10	45
DQD08L10	2	8.0	8.0	4	80	10	60
DQD08L20	2	8.0	8.0	4	80	20	50
DQD10L10	2	10.0	10.0	5	80	10	60
DQD10L20	2	10.0	10.0	5	80	20	50
DQD12L10	2	12.0	12.0	6	100	10	70
DQD12L20	2	12.0	12.0	6	100	20	60
DQD16L10	2	16.0	16.0	8	100	10	70
DQD16L20	2	16.0	16.0	8	100	20	60

订货举例: PCD 球头立铣刀 DQD08L10 1把 Order example: PCD ball nose end mill DQD08L10 1PC

### 3-2.3 PCD 螺旋立铣刀 PCD helical end mill



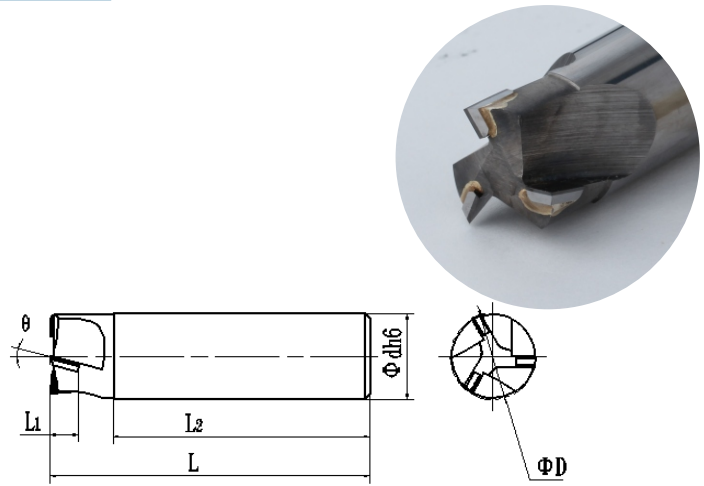
订货号 Order No.	尺寸 Dimension(mm)						
	刃数 tip	D	d	L	L1	L2	θ
DKD06L10-2Z	2	6.0	6.0	60	10	45	2°
DKD06L15-2Z	2	6.0	6.0	60	15	40	2°
DKD08L15-2Z	2	8.0	8.0	80	15	60	3°
DKD08L15-3Z	3	8.0	8.0	80	15	50	2°
DKD10L15-2Z	2	10.0	10.0	80	15	50	4°
DKD10L15-3Z	3	10.0	10.0	80	15	50	3°
DKD12L10-2Z	2	12.0	12.0	85	10	60	6°
DKD12L20-2Z	2	12.0	12.0	100	20	70	6°
DKD12L20-3Z	3	12.0	12.0	100	20	70	4°
DKD12L20-4Z	4	12.0	12.0	100	20	70	3°
DKD16L10-4Z	4	16.0	16.0	85	10	60	6°
DKD16L20-4Z	4	16.0	16.0	100	20	70	6°
DKD20L10-4Z	4	20.0	20.0	100	10	70	6°
DKD20L20-4Z	4	20.0	20.0	100	20	70	6°



订货举例：PCD 螺旋立铣刀 DKD12L20-4Z-L 1把 Order example: PCD helical end mill DKD12L20-4Z-L 1PC

# PCD铣刀

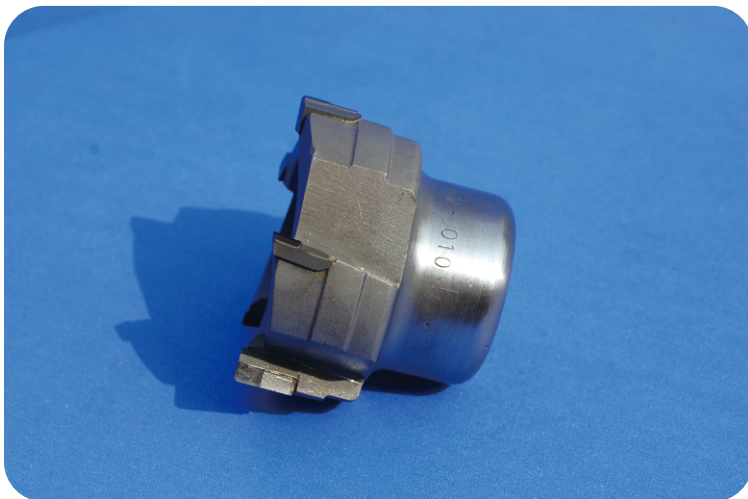
## 3-2.4 PCD 3刃螺旋立铣刀 PCD helical end mill with three flutes



订货号 Order No.	尺寸 Dimension(mm)						
	刃数 tip	D	d	L	L1	L2	$\theta$
DKD06L5L50-2Z	2	6.0	6.0	50	5	40	5°
DKD08L5L50-2Z	2	8.0	8.0	50	5	40	6°
DKD10L5L50-2Z	2	10.0	10.0	50	5	40	10°
DKD12L5L50-2Z	2	12.0	12.0	50	5	40	12°
DKD16L5L50-3Z	3	16.0	16.0	50	5	38	15°
DKD20L10L50-3Z	3	20.0	20.0	50	10	38	15°

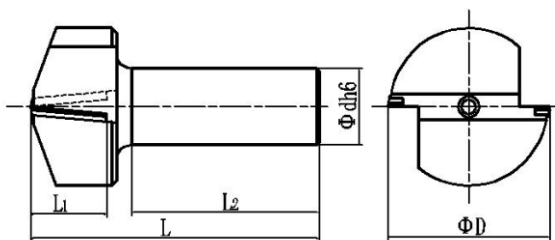
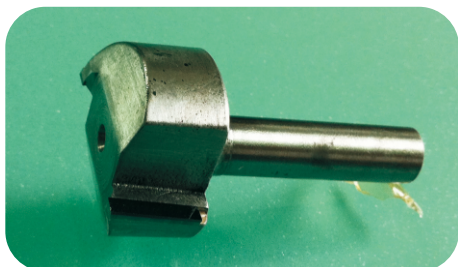
订货举例：PCD 3刃螺旋立铣刀 DKD16L5L50-3Z 10把 Order example: PCD helical end mill with 3 flutes DKD16L5L50-3Z 10PC

## 3-2.5 PCD多刃铣刀 PCD end mill with multi flutes



▲ 订货举例：PCD 5刃铣刀 1把 Order example: PCD 5 edges milling cutter 1PC

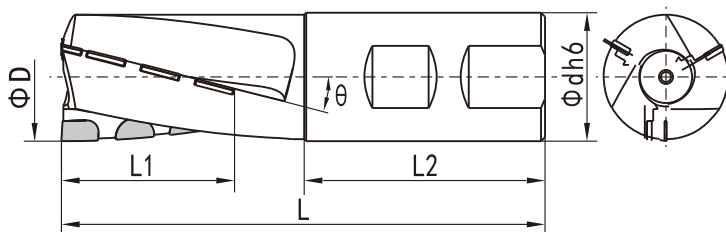
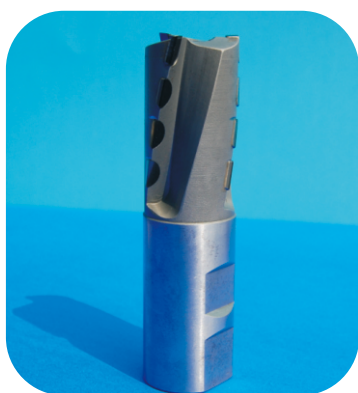
### 3-2.5 PCD 双刃立铣刀 PCD end mil with 2 edges



订货号 Order No.	尺寸 Dimension(mm)						
	刃数 tip	D	d	L	L1	L2	轴向前角 (θ)
DKD20L15D16L80-2Z	2	20	16	80	15	50	6°
DKD20L15D20L80-2Z	2	20	16	80	15	50	6°
DKD25L15D20L80-2Z	2	25	20	80	15	50	6°
DKD25L15D25L80-2Z	2	25	25	80	15	50	6°
DKD32L15D20L80-2Z	2	32	20	80	15	50	6°
DKD32L15D25L80-2Z	2	32	25	80	15	50	6°
DKD32L15D32L80-2Z	2	32	32	80	15	50	6°

订货举例: PCD 2刃立铣刀 DKD20L15D20L80-2Z 10把 Order example: PCD end mil with 2 edges DKD20L15D20L80-2Z 10PC

### 3-3.PCD玉米粒铣刀 PCD corn end milling cutters

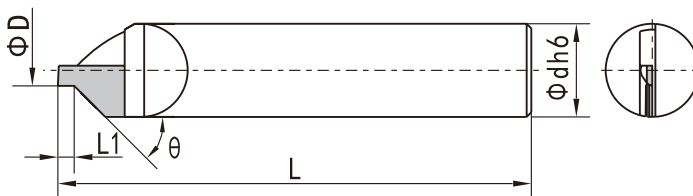


订货号 Order No.	尺寸 Dimension(mm)						
	刃数 tip	D	d	L	L1	L2	θ
DKD16L30-2Z	2	16	16	100	30	50	15°
DKD20L30-2Z	2	20	20	100	30	50	15°
DKD25L30-3Z	3	25	25	100	30	50	15°
DKD32L30-3Z	3	32	32	100	30	50	15°
DKD32L50-3Z	3	32	32	120	50	60	15°

订货举例: PCD玉米粒铣刀 DKD32L50-3Z 10把 Order example: PCD corn end milling cutters DKD32L50-3Z 10PC

## 3-4.PCD电子行业刀具 PCD milling tools for electronic industry

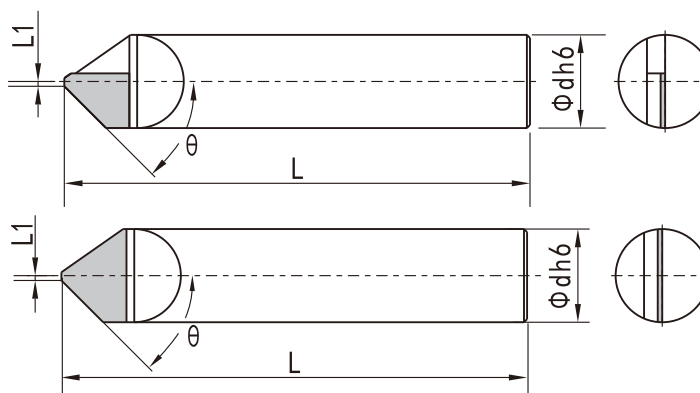
### 3-4.1 PCD 亚克力雕刻刀 PCD acrylic carving cutters



订货号 Order No.	尺寸 Dimension(mm)					
	刃数 tip	ΦD	L1	d	L	θ
Φ0.8×0.5×Φ6×40×30°	1	0.8	0.5	6.0	40	30°
Φ1.2×0.8×Φ6×40×45°	1	1.2	0.8	6.0	40	45°
Φ2×1.05×Φ6×40×45°	1	2	1.05	6.0	40	45°

订货举例：PCD 亚克力雕刻刀 Φ1.2×0.8×Φ6×40×45° 10把 Order example: PCD acrylic carving cutters Φ1.2×0.8×Φ6×40×45° 10PC

### 3-4.2 PCD 亚克力倒角刀 PCD acrylic chamfering cutters

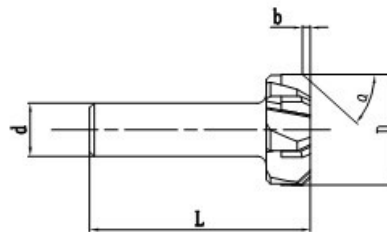


订货号 Order No.	尺寸 Dimension(mm)				
	刃数 tip	d	L	L1	θ
Φ6×40×45°	1	6.0	40	0.2	45°
Φ6×40×60°	1	6.0	40	0.2	60°
Φ6×40×78°	1	6.0	40	0.2	78°

订货举例：PCD 亚克力倒角刀 Φ6×40×45° 10把 Order example: PCD acrylic chamfering cutters Φ6×40×45° 10PC

### 3-4.3 PCD多刃倒角刀 PCD multi tips chamfering cutter

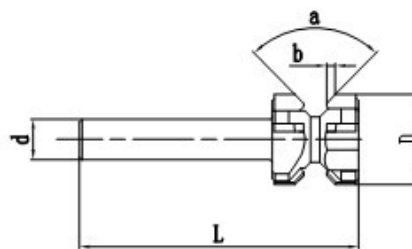
PCD 单面倒角刀 PCD multi tips chamfering cutter



d	L	b	a	D	Z
Φ6-Φ25	50-100	0.5-10	0-90	Φ10-Φ40	2-10

注：倒角刀位置可按客户要求订制(special requirements)

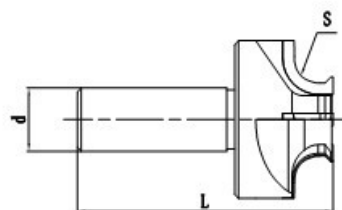
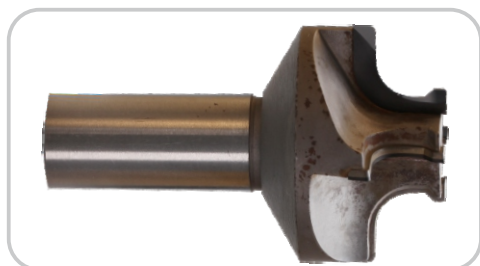
### PCD 双面倒角刀 PCD double tips chamfering cutter



d	L	b	a	D	Z
Φ6-Φ25	50-100	0.5-10	45-180	Φ10-Φ40	2-4

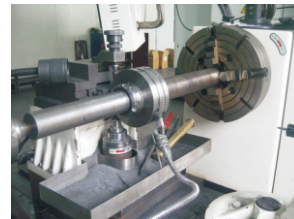
注：上下倒角刀的宽度和角度可分别按客户要求订制(special requirements)

### 3-4.4 PCD成型铣刀 PCD forming end mill



d	L	s	Z
Φ6-Φ25	定制 special requirements	定制 special requirements	2-4

## 4-1.PCBN/PCD硬质合金轧辊肋旋刻刀 PCBN/PCD cutters for the rib of carbide roller pass



## 4-2.PCD/PCBN一个面旋刻刀头 Full face PCD/PCBN/ cutters for the rib of carbide roller pass

结构图 Structure	订货号 Order No.	尺寸 Dimension(mm)				
		ΦD	b	H	L	θ°
	Φ2×0.4×4.06×80°	2.0	0.4	1.4	4.06	80
	Φ2.5×0.5×5.2×80°	2.5	0.5	1.6	5.2	80
	Φ3×0.6×5.5×80°	3	0.6	1.8	5.5	80
	Φ3.2×0.6×6.2×85°	3.2	0.6	1.9	6.2	85
	Φ4×0.6×7.53×80°	4	0.6	2.3	7.53	80
	Φ4×0.7×7.83×70°	4	0.7	2.3	7.83	70
	Φ4×0.8×9.55×80°	4	0.8	2.4	9.55	80
	Φ4.5×0.9×10.7×80°	4.5	0.9	2.75	10.7	80

▲ 订货举例：PCD一个面旋刻刀头：Φ2×0.4×4.06×80° 10粒  
Order example:PCD full face roll groove cutter :Φ2×0.4×4.06×80° 10pcs

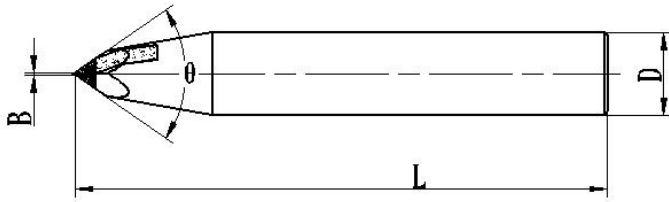
## 4-3.PCD/PCBN焊接式旋刻刀头 PCD/PCBN brazed roll groove bits

结构图 Structure	订货号 Order No.	尺寸 Dimension(mm)					
		D	b	H1	H2	L	θ°
	Φ4×0.7×7.98×80° -H	4	0.7	3.3	3.4	7.98	80
	Φ4×0.8×9.68×80° -H	4	0.8	3.3	3.4	9.68	80
	Φ4.5×0.9×10.8×80° -H	4.5	0.9	3.5	3.9	10.8	80

▲ 订货举例：PCD焊接式旋刻刀头：Φ4×0.7×7.98×80° -H 10粒  
Order example:PCD brazed roller groove bit:Φ4×0.7×7.98×80° -H 10pcs



### 4-4.CVD金刚石刻字刀 CVD Diamond brazed lettering cutters

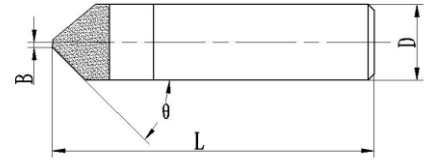
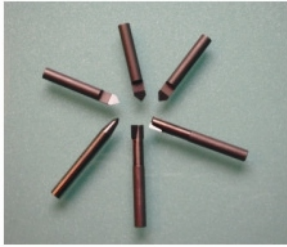


规格	柄径 (D)	总长 (L)	夹角 (θ)	刀尖宽 (B)
DLJΦ6×50×70°×0.3	6	50	70	0.3
DLJΦ6×50×70°×0.4	6	50	70	0.4
DLJΦ6×50×70°×0.5	6	50	70	0.5
DLJΦ6×50×90°×0.3	6	50	90	0.3
DLJΦ6×50×90°×0.4	6	50	90	0.4
DLJΦ6×50×90°×0.5	6	50	90	0.5
DLJΦ8×50×70°×0.3	8	50	70	0.3
DLJΦ8×50×70°×0.4	8	50	70	0.4
DLJΦ8×50×70°×0.5	8	50	70	0.5
DLJΦ8×50×90°×0.3	8	50	90	0.3
DLJΦ8×50×90°×0.4	8	50	90	0.4
DLJΦ8×50×90°×0.5	8	50	90	0.5

▲ 订货举例：CVD金刚石刻字刀 DLJΦ6×50×90°×0.4 10支  
Order example:CVD Diamond lettering cutter DLJΦ6×50×90°×0.4 10PCS



## 5-1.PCD平底角度雕刻刀 PCD bottom flat carving cutters



编号规则 Identification system

DPJ
平底尖刀 bottom flat carving cutters

06
柄径 (D) shank diameter(D)

×

45°
角度 (θ) angle (θ)

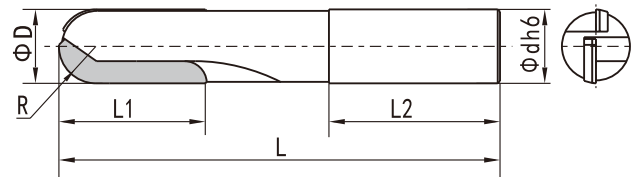
×

04
刀尖宽度 (B) tip width(B)

订货编号 order No	刀尖宽度 (B) tip width (B)	角度(θ°) angle(θ°)	柄径(D) shank diameter(D)	总长(L) overall length(L)
DPJ06×30°×□□	0.2,0.3,0.4,0.5,0.8,1.0,1.5	30	6	40
DPJ06×35°×□□	0.2,0.3,0.4,0.5,0.8,1.0,1.5	35	6	40
DPJ06×45°×□□	0.2,0.3,0.4,0.5,0.8,1.0,1.5	45	6	40
DPJ09×35°×□□	0.3,0.4,0.5,0.8,1.0,1.5	35	9	50
DPJ09×45°×□□	0.3,0.4,0.5,0.8,1.0,1.5	45	9	50

订货举例: PCD平底尖刀 DPJ06×45° ×0.4 10支 Example: PCD bottom flat carving cutter DPJ06×45° ×0.4 10PCS

## 5-2.PCD球头雕刻刀 PCD ball nose carving cutters



编号规则 Identification system

DQX
球头铣刀 ball nose milling cutter

2Z
刃数 tip

×

06
刃径 (2R) diameter (2R)

×

06
刃长 (L1) tip length (L1)

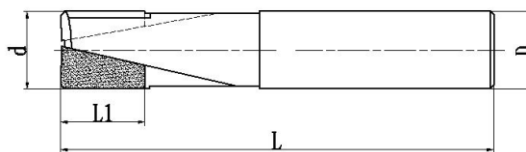
订货编号 order No	刃长 (L1) tip length	刃径(2R) diameter	刃数 tip	柄径 (D) shank diameter	总长 (L) overall length
DQX1Z×06×□□	6,8,10,12	6	1	6	50
DQX2Z×08×□□	6,8,10,12	8	2	8	60
DQX2Z×10×□□	8,10,12,16	10	2	10	65
DQX2Z×12×□□	8,10,12,16	12	2	12	65

订货举例: PCD球头铣刀DQX2Z08×10 10支 Example: PCD ball nose milling cutter DQX2Z08×10 10PCS

# PCD石材雕刻刀具

## PCD carving cutters for stone

### 5-3 PCD双刃雕刻刀 PCD two tips carving cutters



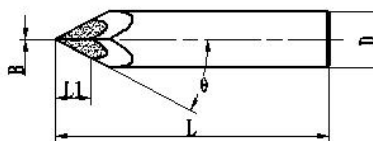
编号规则: Identification system

DZX	2Z	×	06	×	08
球头铣刀 ball nose milling cutter	刃数 tip	×	刃径 (d) diameter (d)	×	刃长 (L1) tip length (L1)

订货编号 order No	刃长 (L1) tip length (L1)	刃径(d) diameter (d)	刃数 tip	柄径 (D) shank diameter (D)	总长 (L) overall length
DZX2Z×06×□□	6,8,10,12,16	6	1	6	50
DZX2Z×08×□□	8,10,12,16,20,25	8	2	8	60
DZX2Z×10×□□	8,10,12,16,20,25	10	2	10	65
DZX2Z×12×□□	8,10,12,16,20,25	12	2	12	65

订货举例: PCD直槽铣刀DZX2Z×06×8 10支 Example: PCD milling cutter DZX2Z×06×8 10PCS

### 5-4 金刚石四棱尖刀 Diamond cutter with 4 edges



编号规则: Identification system

DLJ	4Z	×	06	×	30°	×	0.2
四棱尖刀 four edges cutter	刃数 tip	×	刃径 (D) diameter (D)	×	角度 (θ) Angle	×	刀尖宽度(B) Tip width

订货编号 order No	柄径(ΦD) Shank diameter	角度 (θ°) Angle (θ°)	刀尖宽度(B) Tip width	总长 (L) overall length
DLJ4Z×06×□□×0.2	6	30,35,40,45	0.2	45
DLJ4Z×06×□□×0.2	6	45,50,55	0.2	45

订货举例: 金刚石四棱尖刀DLJ4Z×06×45°×0.2 10支  
Example: Diamond 4 edges cutter DLJ4Z×06×45°×0.2 10PCS



## 6-1.PCBN/PCD刀具的技术资料 Technical specifications for PCBN/PCD cutting tools

刀具材质 Tool material	使用范围 Scope of application	推荐的切削参数 Recommended conditions		
		切削速度Cutting speed V (m/min)	走刀量 Feed rate F (mm/rev)	切削深度 Depth of cutting D (mm)
PCBN	各种淬硬钢: HRC50-67 Hardened steel: HRC50-67	50-150	0.05-0.15	≈0.2
	普通灰铸铁: HB200左右 Gray cast iron: About HB200	500-1000	0.1-0.5	≈3.0
	高硬度铸铁: HRC50-64 High hardness cast iron: HRC50-64	50-100	0.1-0.3	≈2.5
	粉末冶金零件 Powder metallurgy work-piece	80-200	0.03-0.2	≈1.0
	热喷涂焊件零件 Thermal spray coating work-piece	50-150	0.1-1.0	≈2.5
	其他零件 (如Co>15%的硬质合金HRA=80-88) Other (Such as Co>15%wt Carbide HRA=80-88)	5-90	0.05-0.2	≈0.3
PCD	各种铝合金 Al alloy	300-3000	0.1-0.3	≈1.0
	各种铜合金 Cu alloy	300-1200	0.03-0.2	≈0.5
	非金属材料 (如陶瓷、机械用碳、玻璃钢等) Nonmetal material (such as ceramic, mechanical carbon, glass fiber and so on)	100-200	0.1-0.3	≈1.0
	木工材料 (如强化地板、三聚氢胺层压板、MDF等) Woodworking material (such as laminated floor, melamine reinforced plastic, MDF and so on)	≈4000	0.1-6.0	10

### PCBN刀具的修磨

PCBN刀具应在切削性能变差之前 (即工件表面粗糙度变坏时) 进行修磨, 否则容易出现打刀或崩刃现象, CBN刀具修磨最好在磨刀机床上进行, 对磨损量小的刀具可以加大刀尖圆弧, 磨掉磨损亮带, 需要刃磨后刀面的应采用粗磨---精磨两序, 粗磨选用240-120# 粒度的树脂结合剂金刚石砂轮, 进给量0.02-0.05mm/往返一次; 精磨选用W20的金刚石砂轮, 进给量0.005-0.02mm/往返一次。一般采用干磨。

#### The regrinding of PCBN tools

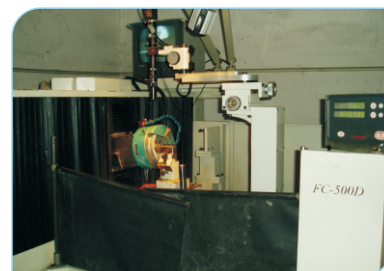
PCBN tool should be regrinded before the surface turns bad, otherwise it will be easy broken-down. The regrinding of PCBN tools should be made on the tool grinding machine. The tool with light wear can be enlarged the nose radius to grind off the wear area. There are two steps when regrinding the tool flank face---rough grinding, finish grinding. Rough grinding should use the diamond resin bond wheel with granularity 240-120#, and the return feed rate is 0.02-0.05mm/each time. Finish grinding should use the W20 diamond grinding wheel, and the return feed rate is 0.005-0.02mm/each time. Dry grinding is the normal way.

### PCD刀具的修磨

PCD刀具要采用专业设备及专业砂轮修磨。一般用户无法解决修磨问题, 应送回刀具生产厂家修磨。

#### The regrinding of PCD tools

The regrinding of PCD tool need special machine and wheel. The user should send the tool back to the manufacturer when the grind problem can't be solved.



# PCBN/PCD使用范围及典型应用

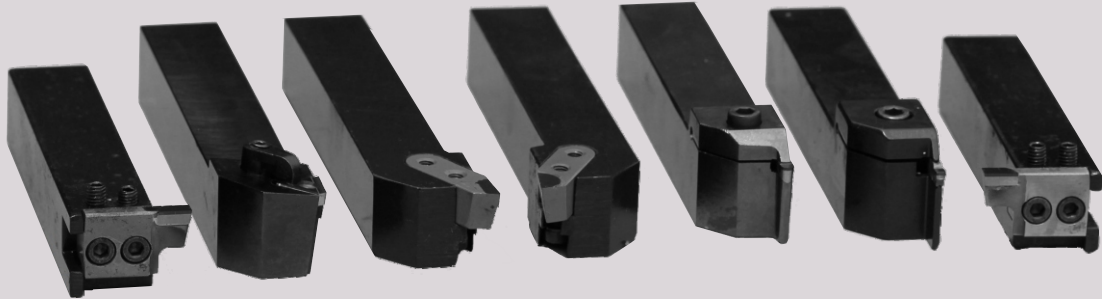
PCBN/PCD technical specifications and typical applications

## 6-2. iPad铝框加工PCD刀具 PCD tools for iPad aluminum frame



6-3.缸套加工PCBN刀具 PCBN cutting tools for Cylinder liner

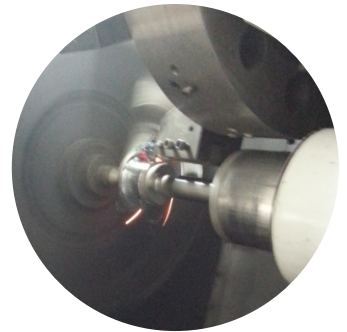
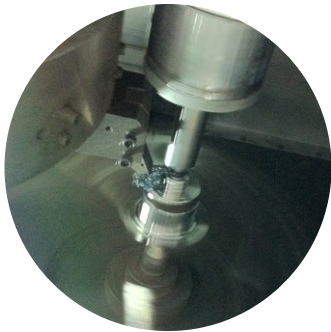
缸套外圆加工PCBN刀具  
PCBN external turning tools for Cylinder liner machining



缸套内孔PCBN铣刀  
PCBN milling cutter for Cylinder liner inner bore machining



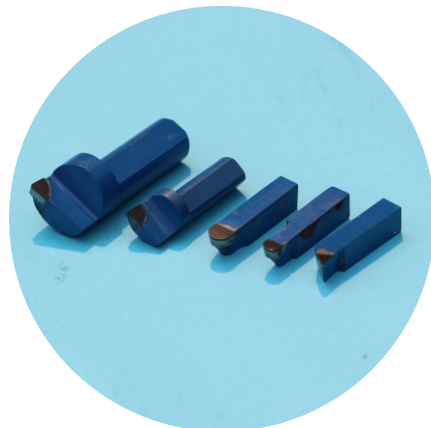
### 6-4. 3牙轮钻头加工PCBN刀具 PCBN tools for tricone bit machining



牙爪外圆车削 PCBN external turning for tricone bit



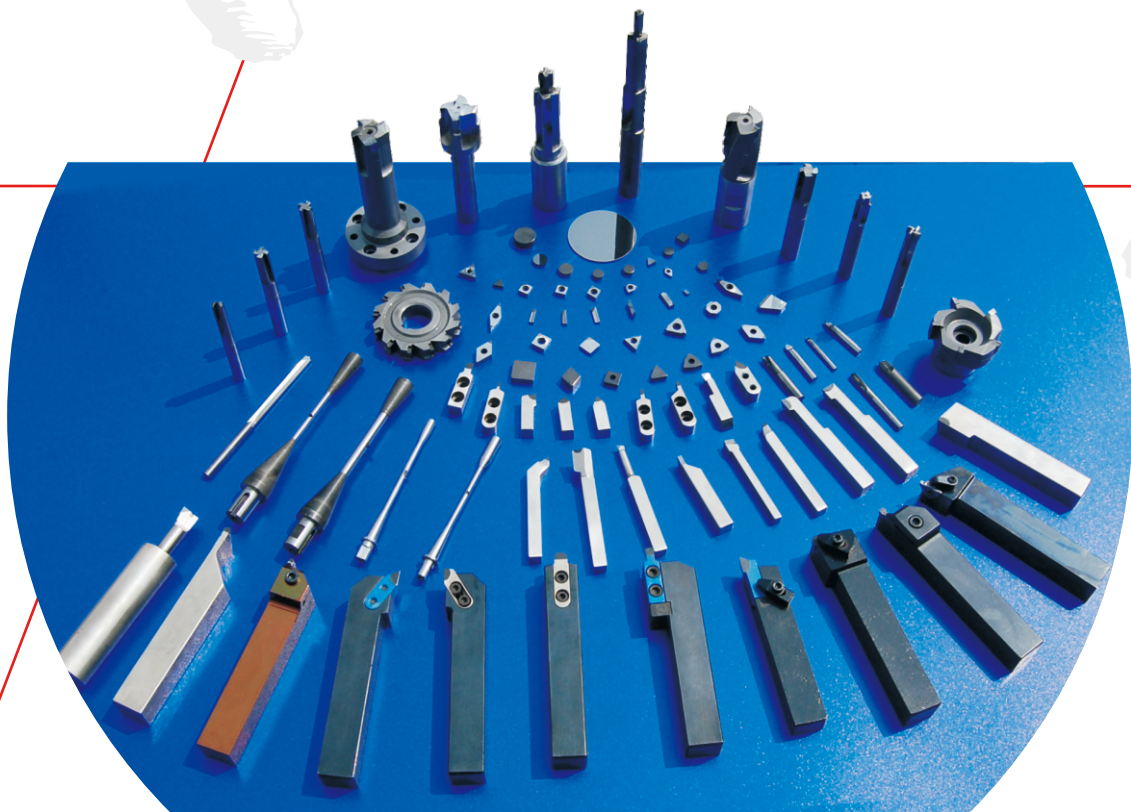
牙爪外圆铣削  
PCBN external milling for tricone bit



牙轮/牙爪PCBN刀具  
PCBN tools for tricone bit machining

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