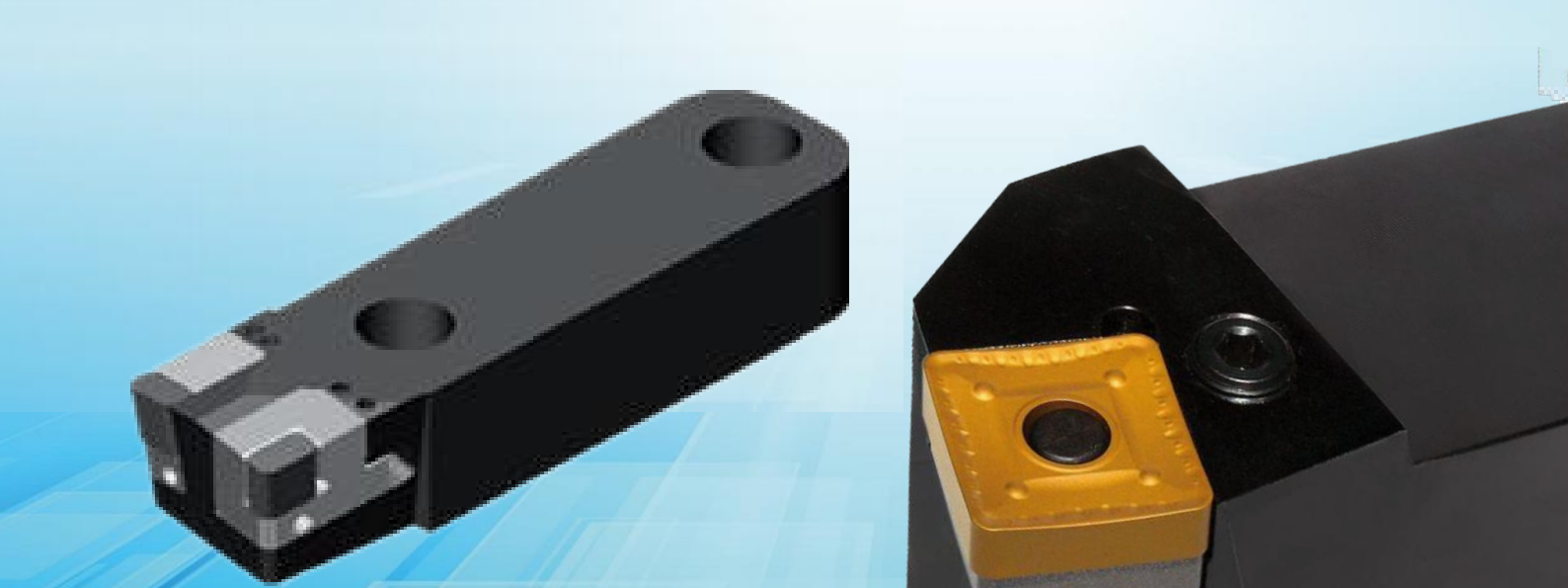
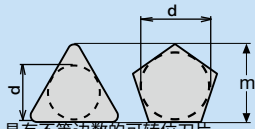
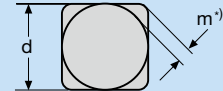
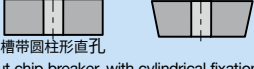
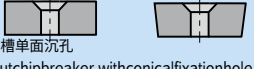
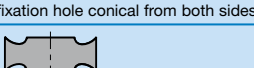
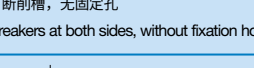
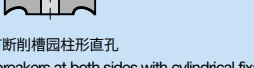
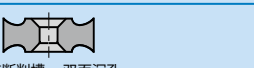
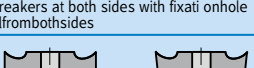
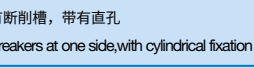
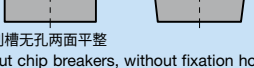
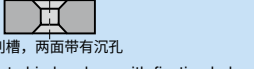
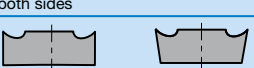
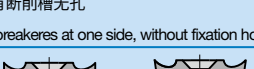
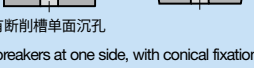


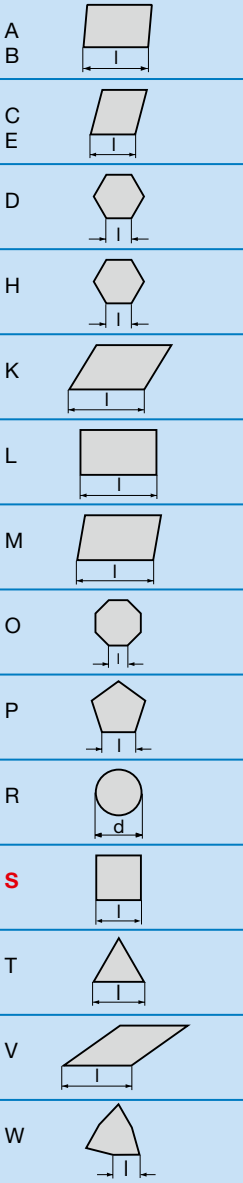
重型机械加工刀片
Heavy machinery
processing
insertion



ISO标准命名体系 ISO designation system for indexable inserts

S 基本形状角度 Basic shape angle A  85° B  82° C  80° D  55° E  75° H  120° K  55° L  90° M  86° O  135° P  108° R  - S  90° T  60° V  35° W  80°	N 后角设计 Clearance angle A  3° B  5° C  7° D  15° E  20° F  25° G  30° N  0° P  11° O  11° 特别要求设计的后角处理 Clearance angle requiring special indication	M 公差等级 Tolerance classes 允许公差 Limits of tolerance <table border="1"> <thead> <tr> <th></th><th>m</th><th>s</th><th>d</th></tr> </thead> <tbody> <tr> <td>A</td><td>±0,005¹⁾</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>E</td><td>±0,025</td><td>±0,025</td><td>±0,025</td></tr> <tr> <td>F</td><td>±0,005¹⁾</td><td>±0,025</td><td>±0,013</td></tr> <tr> <td>G</td><td>±0,025</td><td>±0,13</td><td>±0,025</td></tr> <tr> <td>H</td><td>±0,013</td><td>±0,025</td><td>±0,013</td></tr> <tr> <td>J</td><td>±0,005¹⁾</td><td>±0,025</td><td>±0,05 – ±0,15</td></tr> <tr> <td>K</td><td>±0,013¹⁾</td><td>±0,025</td><td>±0,05 – ±0,15</td></tr> <tr> <td>L</td><td>±0,025</td><td>±0,025</td><td>±0,05 – ±0,15</td></tr> <tr> <td>M</td><td>±0,08 – ±0,20</td><td>±0,13</td><td>±0,05 – ±0,15</td></tr> <tr> <td>U</td><td>±0,13 – ±0,38</td><td>±0,13</td><td>±0,08 – ±0,25</td></tr> </tbody> </table> <table border="1"> <thead> <tr> <th></th><th>d</th><th>m</th><th>d</th></tr> </thead> <tbody> <tr> <td>M</td><td>6,35</td><td>±0,08</td><td>±0,05</td></tr> <tr> <td></td><td>9,52</td><td>±0,08</td><td>±0,05</td></tr> <tr> <td></td><td>12,7</td><td>±0,13</td><td>±0,08</td></tr> <tr> <td></td><td>15,88</td><td>±0,15</td><td>±0,10</td></tr> <tr> <td></td><td>19,05</td><td>±0,15</td><td>±0,10</td></tr> <tr> <td></td><td>25,4</td><td>±0,18</td><td>±0,13</td></tr> <tr> <td>U</td><td>6,35</td><td>±0,13</td><td>±0,08</td></tr> <tr> <td></td><td>9,52</td><td>±0,13</td><td>±0,08</td></tr> <tr> <td></td><td>12,7</td><td>±0,20</td><td>±0,13</td></tr> <tr> <td></td><td>15,88</td><td>±0,27</td><td>±0,18</td></tr> <tr> <td></td><td>19,05</td><td>±0,27</td><td>±0,18</td></tr> <tr> <td></td><td>≥25,4</td><td>±0,38</td><td>±0,25</td></tr> </tbody> </table> m = 切削角 Corner radius s = 厚度 Thickness d = 内切圆 Incircle  具有不等边数的可转位刀片 Indexable insert with unequal number of sides  具有相等边数的可转位插入件 Indexable insert with equal number of sides		m	s	d	A	±0,005 ¹⁾	±0,025	±0,025	C	±0,013	±0,025	±0,025	E	±0,025	±0,025	±0,025	F	±0,005 ¹⁾	±0,025	±0,013	G	±0,025	±0,13	±0,025	H	±0,013	±0,025	±0,013	J	±0,005 ¹⁾	±0,025	±0,05 – ±0,15	K	±0,013 ¹⁾	±0,025	±0,05 – ±0,15	L	±0,025	±0,025	±0,05 – ±0,15	M	±0,08 – ±0,20	±0,13	±0,05 – ±0,15	U	±0,13 – ±0,38	±0,13	±0,08 – ±0,25		d	m	d	M	6,35	±0,08	±0,05		9,52	±0,08	±0,05		12,7	±0,13	±0,08		15,88	±0,15	±0,10		19,05	±0,15	±0,10		25,4	±0,18	±0,13	U	6,35	±0,13	±0,08		9,52	±0,13	±0,08		12,7	±0,20	±0,13		15,88	±0,27	±0,18		19,05	±0,27	±0,18		≥25,4	±0,38	±0,25	M 刀片形状 Type of insert A  无断屑槽带圆柱形直孔 without chip breaker, with cylindrical fixation hole B  无断屑槽单面沉孔 without chip breaker, with conical fixation hole C  无断屑槽，两侧有锥形孔 without chip breakers, with fixation hole conical from both sides F  两面有断屑槽，无固定孔 Chip breakers at both sides, without fixation hole G  两面有断屑槽圆柱形直孔 Chip breakers at both sides, with cylindrical fixation hole H  单面有断屑槽单面沉孔 Chip breakers at one side, with conical fixation hole J  两面有断屑槽，双面沉孔 Chip breakers at both sides with fixation hole conical from both sides M  单面有断屑槽，带有直孔 Chip breakers at one side, with cylindrical fixation hole N  无断屑槽无孔两面平整 without chip breakers, without fixation hole Q  无断屑槽，两面带有沉孔 without chip breakers, with fixation hole conical from both sides R  单面有断屑槽无孔 Chip breakers at one side, without fixation hole T  单面有断屑槽单面沉孔 Chip breakers at one side, with conical fixation hole U  两面有断屑槽，双面沉孔 Chip breakers at both sides, with fixation hole conical from both sides W  无断屑槽，带锥形固定孔 without chip breaker, with conical fixation hole X  具有绘图的特殊功能 with special features to drawing
	m	s	d																																																																																																				
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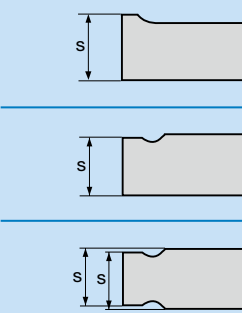
19
切削刃长度
Length of cutting edge



内切圆示例
Examples:

06	l = 6,350 mm
09	l = 9,525 mm
11	l = 11,000 mm
12	l = 12,700 mm
15	l = 15,880 mm
16	l = 16,500 mm
19	l = 19,050 mm
22	l = 22,000 mm
25	l = 25,400 mm
27	l = 27,500 mm
32	l = 31,750 mm

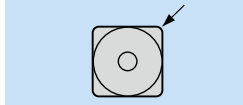
06
厚度
Thickness



厚度示例
Examples:

01	s = 1,59 mm
T1	s = 1,98 mm
02	s = 2,38 mm
03	s = 3,18 mm
T3	s = 3,97 mm
04	s = 4,76 mm
05	s = 5,56 mm
06	s = 6,35 mm
07	s = 7,94 mm
09	s = 9,52 mm
12	s = 12,70 mm

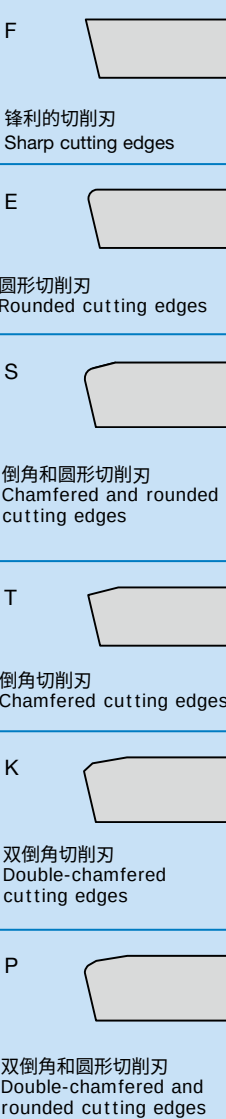
24
圆角半径
Corner radius



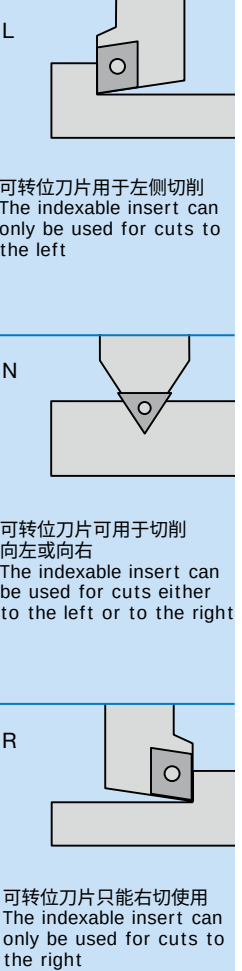
R角示例
Examples:

00	r = max 0,2 mm
04	r = 0,4 mm $\pm 0,1$
08	r = 0,8 mm $\pm 0,1$
12	r = 1,2 mm $\pm 0,1$
16	r = 1,6 mm $\pm 0,1$
20	r = 2,0 mm $\pm 0,1$
24	r = 2,4 mm $\pm 0,1$
25	r = 2,5 mm $\pm 0,1$
32	r = 3,2 mm $\pm 0,1$

切削刃设计
Modernstes Design

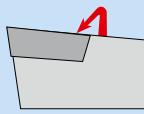
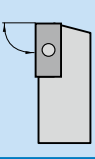
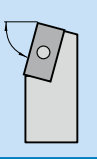
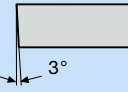
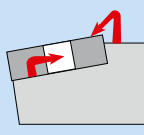
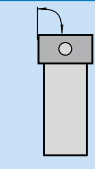
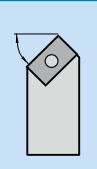
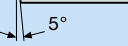
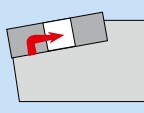
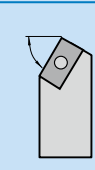
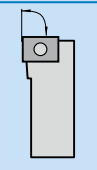
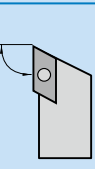
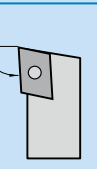
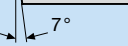
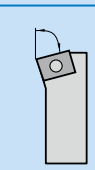
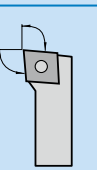
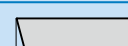
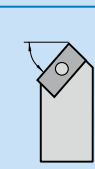
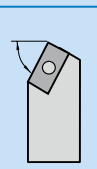
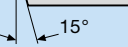
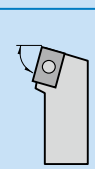
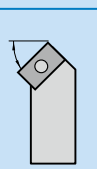
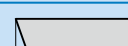
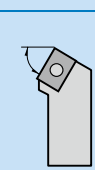
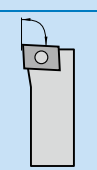
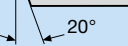
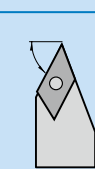
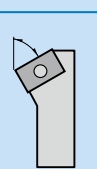
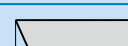
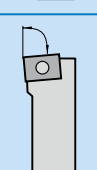
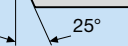


切割方向
Direction of cut



ISO命名
ISO designation system

用于工件外沿加工
for tool holders, external machining

P 紧固类型固定类型 Fixation type	C 可转位刀片形状 Indexable insert shape	L 刀架形状 Tool holder shape		N 刀片后角 Insert clearance angle
C  从上方夹紧 从上方固定 Clamp from above Fix from above	A  85° B  82°	A  90°	B  75°	A  3°
M 	C  80° D  55° E  75° H  120°	C  90°	D  45°	B  5°
P  通过孔夹紧 通过孔固定一个孔 Clamped through a hole Fixation through a hole	K  55° L  90°	E  60°	F  90°	C  7°
S  贯通钻孔拧紧 通过螺丝固定圆锥形的孔 Durch Bohrung geschraubt Fixation by screw through a conical hole	M  86° O  135° P  108° R  -	G  90°	J  93°	D  15°
	S  90° T  60° V  35° W  80°	K  75°	L  95°	E  20°
		M  50°	N  63°	F  25°
		R  75°	S  45°	G  30°
		T  60°	U  93°	N  0°
		V  72,5°	W  60°	P  11°
			Y  85°	O 

需要特殊设计的间隙角
Clearance angle
requiring special
indication

R

切削方向
 Direction of cut

L

刀架只能用于向左切削
 The tool holder can only be used for cuts to the left

N

刀架可用于向左或向右切削
 The tool holder can be used for cuts either to the left or to the right

R

刀架只能用于向右切削
 The tool holder can only be used for cuts to the right

50

切削高度
 Cutting height

对于夹紧刀具，切削高度 (h₁) 通常与轴高度 (h₂) 相对应。例外情况包括卡式刀架和用于内圆车削的夹紧刀具
 For clamped tools, the cutting height (h₁) generally corresponds to the shaft height (h₂). The exceptions to this include cartridge toolholders and clamped tools for internal turning.

50

刀柄宽度
 Shank width

T

刀具长度
 Tool length

长度 l1 的代码字母

Code letters for the length l₁

A	32 mm
B	40 mm
C	50 mm
D	60 mm
E	70 mm
F	80 mm
G	90 mm
H	100 mm
J	110 mm
K	125 mm
L	140 mm
M	150 mm
N	160 mm
P	170 mm
Q	180 mm
R	200 mm
S	250 mm
T	300 mm
U	350 mm
V	400 mm
W	450 mm
X	特殊长度 special length
Y	500 mm

25

切削刃长度
 Cutting edge length

A

B

C

E

D

H

K

L

M

O

P

R

S

T

V

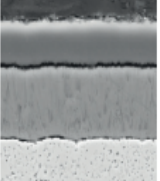
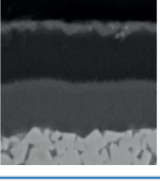
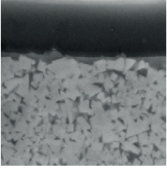
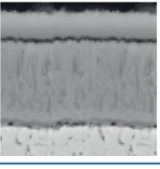
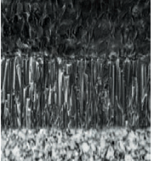
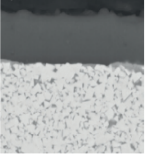
W

示例

Examples:

06	l = 6,350 mm
09	l = 9,525 mm
11	l = 11,000 mm
12	l = 12,700 mm
15	l = 15,880 mm
16	l = 16,500 mm
19	l = 19,050 mm
22	l = 22,000 mm
25	l = 25,400 mm
27	l = 27,500 mm
32	l = 32,000 mm

重力切削刀片涂层牌号说明 Coating Insertion Grade Overview

牌号Grad	国际标准 Iso	显微镜组织结构 Microscopic tissue structure	牌号说明 Grade description
AKC203	P15-P25		PVD多层涂层P10 - P30/M20 - M40/S15 - S25硬质合金基材，用于精加工不锈钢、超合金和钢的中等加工（铣削）最佳应用中的电阻和热稳定性。 PVD multilayer coated P10 - P30/M20 - M40/S15 - S25 carbide substrate for finishing to medium machining of stainless steel, super alloys and steel (milling). Excellent wear resistance and thermal stability in a wide range of applications.
APC252	P20-P35		CVD涂层P20 - P35碳化物等级，适用于钢和铸件的中粗加工钢。耐磨性和韧性的最佳性能，适用于广泛的应用领域。 CVD coated P20 - P35 carbide grade for medium operation to roughing of steel and casting steel. Optimal performance of wear resistance and toughness for a wide application field.
APC352	P20-P40		CVD涂层P20 - P40碳化物等级，用于钢和铸钢的粗加工操作，磨性和韧性的有最佳性能，适用于广泛的应用领域。 CVD coated P20 - P40 carbide grade for roughing operation of steel and casting steel. Optimal performance of wear resistance and toughness for a wide application field.
ABM9320	P10-P30 M10-M25		PVD多层涂层P10 - P30/M10 - M25硬质合金基材，适用于中等精加工不锈钢、超合金和钢的加工（开槽/铣削）。优化的涂层稳定性，在广泛的应用中具有更高的耐磨性和热稳定性。 PVD multilayer coated P10 - P30/M10 - M25 carbide substrate for finishing to medium machining of stainless steel, superalloys and steel (grooving/milling). Optimised coating stability for higher wear resistance and thermal stability in a wide range of applications.
PM253	M15-M35		CVD涂层M15 - M35碳化物级，适用于不锈钢中粗加工，操作具有广泛的应用领域。高磨性和抗塑性在较高切削速度下不变形。 CVD coated M15 - M35 carbide grade for medium to roughing operation stainless steel with wide application field. High wear resistance and capability against plastic deformation at higher cutting speed.
BD152	K10-K25		CVD涂层K10 - K25碳化物基材。针对中粗加工操作进行了优化。在较高切削速度下具有良好的耐磨性和韧性。 CVD coated K10 - K25 carbide substrate. Optimized for medium to roughing operation of cast iron. Good wear resistance and toughness at higher cutting speed.
ABG205	P10-P30 M20-M40 S15-S25		PVD多层涂层P10 - P30/M20 - M40/S15 - S25硬质合金基材，用于精加工不锈钢、超合金和钢的中等加工（铣削）最佳应用中的电阻和热稳定性。 PVD multilayer coated P10 - P30/M20 - M40/S15 - S25 carbide substrate for finishing to medium machining of stainless steel, super alloys and steel (milling). Excellent wear resistance and thermal stability in a wide range of applications.

A

Turning

B

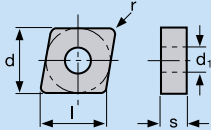
Milling

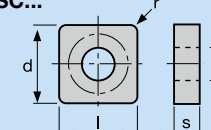
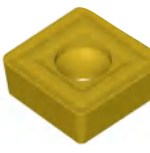
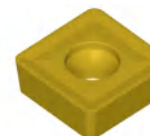
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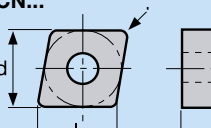
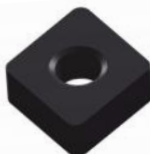
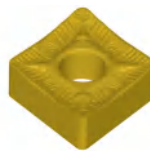
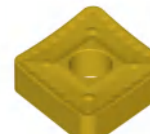
Drilling

用于重型加工的正负可转位刀片

Positive and negative reversible inserts for heavy-duty machining

	刀片型号 Insert model							牌号Grade			
		l	d	s	d1	r	ap max.	ACP15T	ACP25T	AC240F	AC620H
CCMT...-BSMR 	CCMT 250924-BSMR	25,80	25,40	9,52	8,60	2,4	20	●	●		●

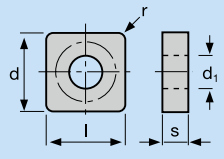
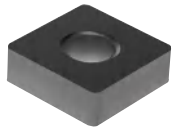
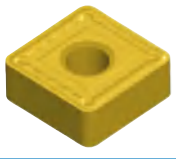
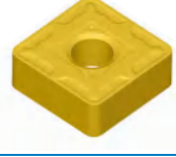
	刀片型号 Insert mode							牌号Grade			
		l	d	s	d1	r	ap max.	LCP15T	LCP25T	LC240F	LC620H
SCMT...-BSMR 	SCMT 250924-BSMR	25,40	25,40	9,52	8,60	2,4	20	●	●	●	
	SCMT 380932-BSMR	38,10	38,10	9,52	8,60	3,2	35	●	●	●	
SCMT...-BSR 	SCMT 250916-BSR	25,40	25,40	9,52	8,60	1,6	20	●	●	●	●
	SCMT 250924-BSR	25,40	25,40	9,52	8,60	2,4	20	●	●	●	●
	SCMT 380932-BSR	38,10	38,10	9,52	8,60	3,2	35	●	●	●	

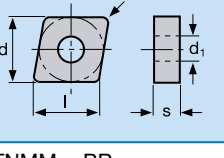
	刀片型号 Insert mode							牌号Grade			
		l	d	s	d1	r	ap max.	ACP15T	ACP25T	AC240F	AC620H
CNMA.... 	CNMA 190616	19,30	19,05	6,35	7,93	1,6	17				●
CNMM...-RP 	CNMM 190612-RP	19,30	19,05	6,35	7,93	1,2	17	●	●	●	
	CNMM 190616-RP	19,30	19,05	6,35	7,93	1,6	17	●	●	●	
	CNMM 190624-RP	19,30	19,05	6,35	7,93	2,4	17	●	●	●	
CNMM...-BRP 	CNMM 250724-BRP	25,80	25,40	7,94	9,12	2,4	20	●	●	●	
	CNMM 250924-BRP	25,80	25,40	9,52	9,12	2,4	20	●	●	●	

切削数据指南参见第 18 页

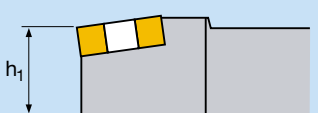
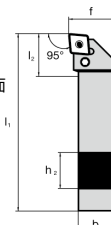
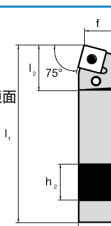
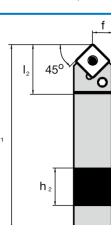
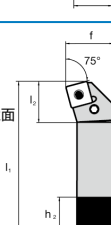
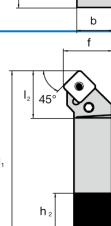
For cutting data standard values see pages 18

用于火车件重型加工的负角刀片
Negative angle blade for heavy-duty machining of train components

	刀片型号 Insert mode	l	d	s	d1	r	ap max.	牌号 Grade			
								ACP15T	ACP25T	AC240F	AC620H
SNMA... 	SNMA 190616	19,05	19,05	6,35	7,93	1,6	17				●
	SNMA 250724	25,40	25,40	7,94	9,12	2,4	22				●
SNMG...-BMR 	SNMG 250924-BMR	25,40	25,40	9,52	9,12	2,4	16		●		
SNMG...-BRW 	SNMG 250724-BRW	25,40	25,40	7,94	9,12	2,4	9	●	●	●	
	SNMG 250924-BRW	25,40	25,40	9,52	9,12	2,4	12	●	●	●	
SNMM...-BRP 	SNMM 250724-BRP	25,40	25,40	7,94	9,12	2,4	20	●	●	●	●
	SNMM 250732-BRP	25,40	25,40	7,94	9,12	3,2	20	●	●	●	
	SNMM 250924-BRP	25,40	25,40	9,52	9,12	2,4	20	●	●	●	●
	SNMM 250932-BRP	25,40	25,40	9,52	9,12	3,2	20	●	●	●	
SNMM...-BR 	SNMM 250724-BR	25,40	25,40	7,94	9,12	2,4	20		●	●	
	SNMM 250924-BR	25,40	25,40	9,52	9,12	2,4	20		●	●	
SNMM...-RP 	SNMM 190612-RP	19,05	19,05	6,35	7,93	1,2	17	●	●	●	
	SNMM 190616-RP	19,05	19,05	6,35	7,93	1,6	17	●	●	●	
	SNMM 190624-RP	19,05	19,05	6,35	7,93	2,4	17	●	●	●	
	SNMM 190632-RP	19,05	19,05	6,35	7,93	3,2	17	●	●	●	
	SNMM 250724-RP	25,40	25,40	7,94	9,12	2,4	20		●		

TN... 	刀片型号 Insert mode	l	d	s	d1	r	ap max.	Sorte Grade			
								ACP15T	ACP25T	AC240F	AC620H
TNMM...-BR 	TNMM 270612-BR	27,50	15,87	6,35	6,35	1,2	20			●	

切削数据指南参见第 17页
For cutting data standard values see pages 18

	编码Ordering code						刀架配置刀片 型号 Tool holder configuration insertion model
		h = h	b	l ₁	l ₂	f	
PCLNR/L 95° 右手版如图所示，左手版如镜面 Righthand version as shown, left hand version mirrorlike 	PCLNR/L 2525M19	25	25	150	38	32	CNM. 19....
	PCLNR/L 3232P19	32	32	170	38	40	
	PCLNR/L 4040S19	40	40	250	38	50	CNM. 2509..
	PCLNR/L 4040S25	40	40	250	45	50	
	PCLNR/L 5050T25	50	50	300	45	60	
PSBN-R/L 75° 右侧版本如图所示，左侧手持版镜面 Righthand version as shown, left hand version mirrorlike 	PSBNR/L 3232P19	32	32	170	39,2	27	SNM. 19....
	PSBNR/L 4040S19	40	40	250	38,5	35	SNM. 2507..
	PSBNR/L 4040S25	40	40	250	47,5	35	
	PSBNR/L 5050T25	50	50	300	49	43	SNM. 2509..
	PSBNR/L 4040S25-09	40	40	250	47,5	35	
	PSBNR/L 5050T25-09	50	50	300	49	43	
PSDNN-N 45° 	PSDNN 3225 P19	32	25	170	40,4	13	SNM. 19....
	PSDNN 3232 P19	32	32	170	40,4	12,5	SNM. 2507..
	PSDNN 4040S25	40	40	250	45	20	
	PSDNN 5050T25	50	50	300	45	25	SNM. 2509..
	PSDNN 4040S25-09	40	40	250	45	20	
	PSDNN 5050T25-09	50	50	300	45	25	
PSKNR-R/L 75° 右侧版本如图所示，左侧手持版镜面 Righthand version as shown, left hand version mirrorlike 	PSKNR/L 3232P19	32	32	170	33,7	40	SNM. 19....
	PSKNR/L 4040S19	40	40	250	37,6	50	SNM. 2507..
	PSKNR/L 4040S25	40	40	250	45	50	
	PSKNR/L 5050T25	50	50	300	45	60	SNM. 2509..
	PSKNR/L 4040S25-09	40	40	250	45	50	
	PSKNR/L 5050T25-09	50	50	300	45	60	
PSSNR/L 45° 右执行如图所示，左执行镜像 Righthand version as shown, left hand version mirrorlike 	PSSNR/L 3232P19	25	25	150	28	32	SNM. 19....
	PSSNR/L 4040S19	32	32	170	32,6	40	SNM. 2507..
	PSSNR/L 4040S25	25	25	150	38	32	
	PSSNR/L 5050T25	32	32	170	38	40	SNM. 2509..
	PSSNR/L 4040S25-09	40	40	250	38	50	
	PSSNR/L 5050T25-09	40	40	250	45	50	

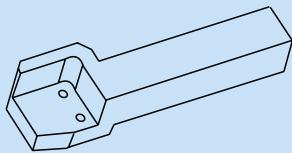
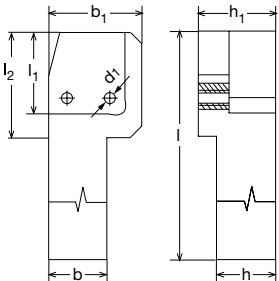
备件Spare parts		编码Ordering Code						
切削刃长度 Cutting edge length	刀柄部尺寸 Knife handle size	 垫片形状C Shim shape C	 垫片形状S Shim shape S	 压杆 Lever	 固定螺钉 Fixation screw	 垫片销 Shim pin	 装配冲头 Assembly punch	 扳手 wrench
19	2525 - 4040	B01-C1847	B01-S1847	D02-19210	A03-10270	E01-11011	V10-30000	V01-A0040
25	4040 - 5050	B01-C2463	B01-S2463	D02-23250	A03-12360	E01-15212	V10-50000	V01-A0050

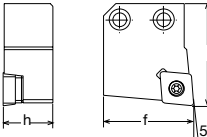
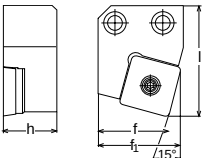
重型加工刀架刀片架系统：刀片架

Tool holders for heavy duty machining

Cartridge system: Cartridge

刀片架尺寸 Blade holder size

 刀架Tool holder	编码 Ordering Code	h = b	h ₁	b ₁	l	l ₁	l ₂	d ₁
	D-82-026 L	50	65	80	300	70	90	10
	D-82-027 R	50	65	80	300	70	90	10
	D-82-030 L	60	65	80	300	70	90	10
	D-82-031 R	60	65	80	300	70	90	10

	编码 Ordering Code									适用可转 位刀片 Suitable indexable inserts
		h = b	h ₁	b ₁	l	l ₁	l ₂	f	f ₁	
CCMT刀片 卡夹Insert the CCMT card holder 	D-80-002 L	40			83			73		CCMT 2509..
	D-80-001 R	40			83			73		CCMT 2509..
SCMT刀片 卡夹Insert the CCMT card holder 	BM46411 L	40			83			53,00	58,9	SCMT 2509..
	BM46412 R	40			83			53,00	58,9	SCMT 2509..
	BM46233 L	40			83			53,25	62,2	SCMT 3809..
	BM46247 R	40			83			53,25	62,2	SCMT 3809..

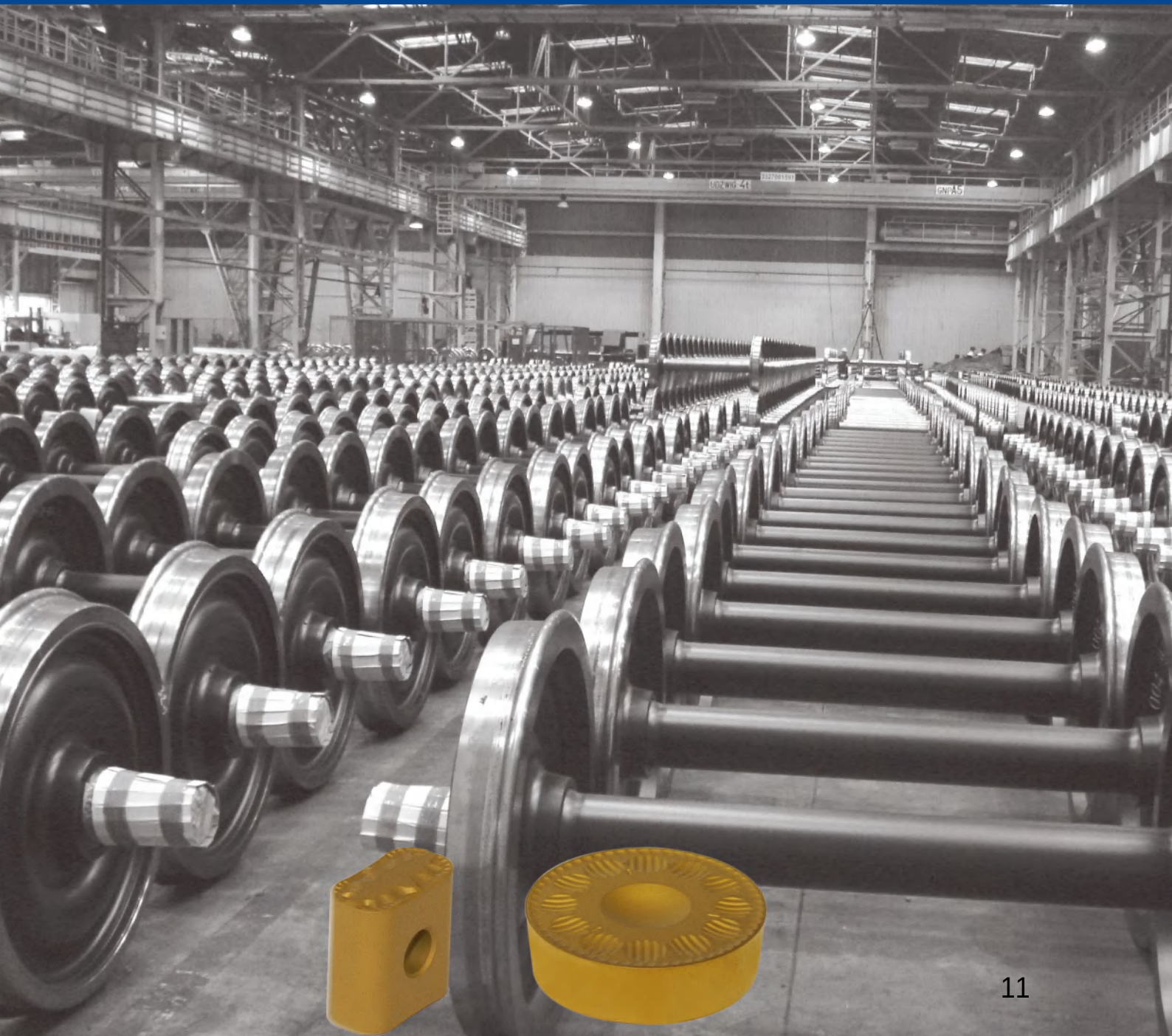
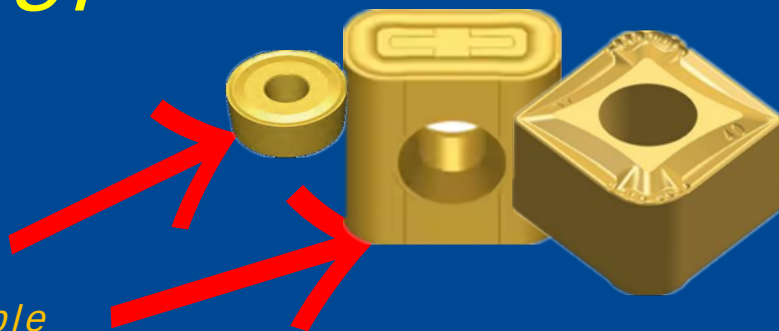
右手版如图所示，左手版如镜面所示 Rechtsausführung wie gezeichnet, Linksausführung spiegelbildlich

备件 Spare parts	编码 Ordering Code					
刀架代码 Knife holder code	 垫片 Shim	 固定螺钉 Fixation screw	 螺纹衬套 Threaded bushing	 锥形弹簧垫圈 Conical spring washer	 断屑器 Chip breaker	 扳手 Key
D-80-003R, D-80-005L	D-20-061	M6x16 DIN 7991		D04-0F276	D-61-008	V01-A0040
D-80-001 R, D-80-002 L	D-20-058	A02-80250	E02-F12080			V04-T3000
BM46412 R, BM46411 L	B02-S2563	A02-80250	E02-F12080			V04-T3000
BM46247 R, BM46233 L	B02-S3863	A02-80250	E02-F12080			V04-T3000

火车轮加工

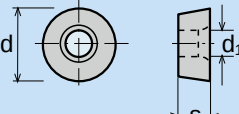
Train wheel processing

CNMX
两面都可用
CNMX
both sides useable

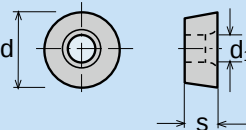


铁路车轮加工用可转位刀片

Indexable inserts for railway wheel machining

RC...		编码 Ordering Code	刀片尺寸Insert size					牌号 Grades	
			l	d	s	d ₁	r	LCP15T	LCP25T
精加工 fine application									
	RCMX...R25	RCMX 2507M0-R25	-	25,00	7,90	7,20	-	●	●
		RCMX 3209M0-R25	-	32,00	9,52	9,50	-	●	●
粗加工 rough application									
	RCMX...	RCMX 2006M0	-	20,00	6,35	6,50	-	●	●
		RCMX 2507M0	-	25,00	7,90	7,20	-	●	●
		RCMX 3209M0	-	32,00	9,52	9,50	-	●	●
	RCMX...R40	RCMX 2507M0-R40	-	25,00	7,90	7,20	-	●	●
		RCMX 3209M0-R40	-	32,00	9,52	9,50	-	●	●
特殊槽型 special fixation									
	RCMH...R40	RCMH 3209M0-R40	-	32,00	9,52	9,50	-	●	●

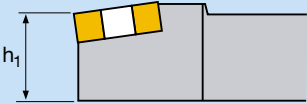
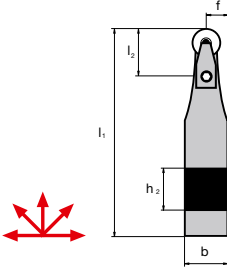
Sonderlösung: System Vollhartmetall / Special Solution: System full carbide

RC...		备件 Ordering Code						牌号 Grades		
			l	d	s	d ₁	r	LCP15T	LCP25T	
精加工 fine application										
RCMR...R25 	RCMR 3209M0-R25	-	32,00	9,52	12,00	-	●	●		
粗加工 rough application										
RCMR...R40 	RCMR 3209M0-R40	-	32,00	9,52	12,00	-	●	●		

切割数据指南参见第 17 页

For cutting data standard values see pages 18

铁路车轮加工用刀架
 Tool holders for railway wheel machining

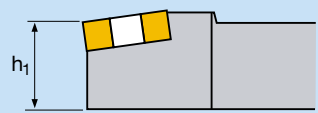
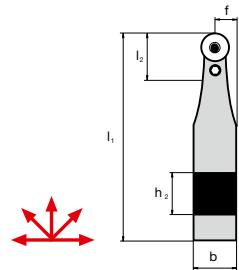
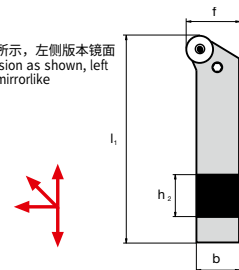
	刀架编码Knife holder code	刀架尺寸Knife holder size						合适的可转位刀片 Suitable indexable inserts
		h ₁ = h ₂	b	l ₁	l ₂	f		
	CRCCN 5050V32	50	50	400	42	25		RCMR 3209M0-R25
								RCMR 3209M0-R40



备件Spare parts

备件Spare parts		编码 Ordering Code					
切削刃长度 Cutting edge length	刀柄尺寸 Shank size	 垫片 Shim	 压板 Clamp	 内六角螺钉 Fixation screw	 垫片螺钉 Shimscrew	 装配冲头 Assembly punch	 扳手 Key
32	5050	Bm46416	Bm46417	M8x20 DIN912	M6x16 DIN7991	0,5x5x30 DIN2098	V01-A0060 SW6 V01-A0040 SW4

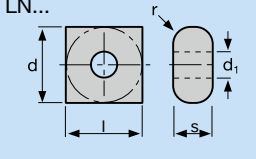
ISO标准刀具架 Tool holders for ISO - Standard

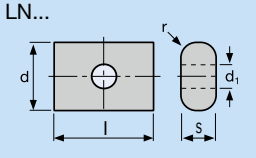
	刀架编码Ordering Code	刀架尺寸Knife holder size						合适的可转位刀片 Suitable indexable inserts
		$h_1 = h_2$	b	l_1	l_2	f		
PRDC-N 	PRDCN 3232P20	32	32	170	32	16		RCMX 20...
	PRDCN 4040S25	40	40	250	42	20		RCMX 25...
	PRDCN 5050V32	50	50	400	52	25		RCMX 32...
PRGCR-L 右侧版本如图所示，左侧版本镜面 Righthand version as shown, left hand version mirrorlike 	PRGCR/L 3232P20	32	32	170	-	40		RCMX 20...
	PRGCR/L 4040S25	40	40	250	-	50		RCMX 25...
	PRGCR/L 5050S32	50	50	250	-	50		RCMX 32...

备件Spare parts		编码Ordering Code					
切削刃长度 Cutting edge length	刀柄尺寸 Shank size	 刀垫 Shim	 压杆 Lever	 固定螺丝 Fixation screw	 垫片销 Shim pin	 装配冲头 Assembly punch	 扳手 Key
20	3232	B05-R1747	D05-19189	A03-08235	E01-09008	V10-40000	V01-A0030
25	4040	B05-R2263	D05-23235	A03-10305	E01-11011	V10-30000	V01-A0040
32	5050	3832	8132	1612	4125	0025	5005

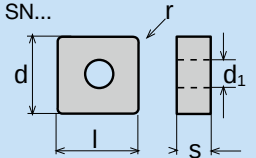
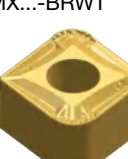


用于加工和修理火车车轮的可转位刀片
Indexable blade for processing and repairing train wheels

LN... 	编码 Ordering Code	刀片尺寸 Insert size						牌号 Grades	
		l	d	s	d ₁	r	a _p max.	LCP15T	LCP25T
LNUX...-BRWT 	LNUX 191940SN-RWT	19,05	19,05	10,00	6,35	4,0	7	•	•
LNUX...-BRW 	LNUX 191940SN-RWM	19,05	19,05	10,00	6,35	4,0	10	•	•

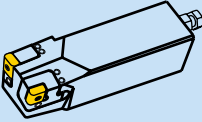
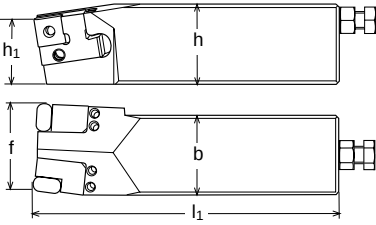
LN... 	编码 Ordering Code	刀片尺寸 Insert size						牌号 Grades	
		l	d	s	d ₁	r	a _p max.	LCP15T	LCP25T
LNUX...-BRW 	LNUX 301940SN-RWM	30,00	19,05	12,00	6,35	4,0	14	•	•
LNUX...-BRWF 	LNUX 301940SN-RWF	30,00	19,05	12,00	6,35	4,0	17	•	•
LNUX...-BRWR 	LNUX 301940SN-RWR	30,00	19,05	12,00	6,35	4,0	20	•	•

刀片两面有车削槽
Insert with turning grooves on both sides

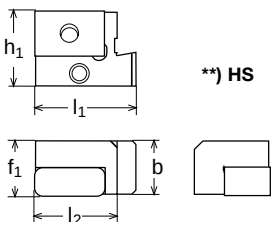
SN... 	编码 Ordering Code	刀片尺寸 Insert size						牌号 Grade
		l	d	s	d ₁	r	a _p max.	LCP25T
CNMX...-BRWT 	CNMX 190740-RWT	19,05	19,05	7,93	7,80	4,0	7	•
	CNMX 191140-RWT	19,05	19,05	10,40	7,80	4,0	7	•

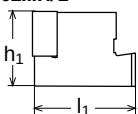
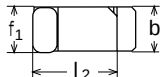
切割数据指南参见第 17 页
For cutting data standard values see pages 18

铁路火车轮加工用刀架
Tool holders for railway wheel machining

	插入专用刀架 Insert special tool holder	刀架尺寸 Knife holder size						配套合适的刀架 Matching suitable tool bar
	编码 Ordering Code	b	h	l ₁	h ₁	f		
BRWT01...R/L *) 	RWT01-32 5555R	55	55	210	44	60		BRWC01...R BRWC02...L
	RWT01-32 5555L	55	55	210	44	60		BRWC01...L BRWC02...R

Ersatzteile Spare parts	配件 Ordering Code					
	 螺纹螺丝 threaded screw	 扳手 Key	 6-kt螺丝 6-kt-screw	 六角螺母 6-kt-nut		
BRWT01-32 5555 R/L	M6x16 ISO 4028	V01-A0030	M12x50 ISO 4017	M12 (Typ1) ISO 4032		

	刀片座尺寸 Insert seat size						合适的可转位刀片 Suitable indexable insert
	编码 Ordering Code	b	l ₁	l ₂	h ₁	f ₁	
BRWC01...R/L *) 	RWC01-LN19 3223R/L	22,5	42,4	35	32	23	LNIX 191940
	RWC01-LN30 3223R/L	22,5	42,4	35	32	23	LNIX 301940

刀片座尺寸 Insert seat size								
								
BRWC02...R/L *)	**) NS	RWC02-LN19 3219R/L	18,5	42,4	35	32	19,1	LNIX 191940
								
								

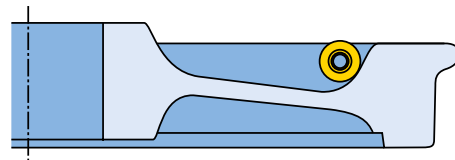


切削数据建议 Cutting data recommendations

刀片类型 nsert Type	ACP15T	A CP25T	进给量 Feed f mm/U mm/rev	切削深度 ap Depth of cut ap mm	
	切割速度 Cutting speed m/min				
LINUX 19....	30 - 90	30 - 70	0,25 - 1 0,4 - 1,4	BRWT: 0,4 - 7 BRW: 1 - 10	
LINUX 30....	40 - 100	40 - 80	0,5 - 1,8	BRW: 2 - 14 BRWF: 2 - 17 BRWR: 4 - 20	

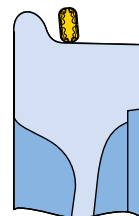
刀片切削指导数据 Insert cutting guidance data

工件	Work piece:	火车轮 Railway wheel R9 湿车削 <i>nass wet</i>
材料:	Material:	PRCCN 5050V32
切削条件:	Condition of cut:	RCMX 3209M0
刀具:	Tool:	AKC203
可转位刀片:	Indexable insert:	$v_c = 100 - 160$ m/min
涂层牌号: 切削参数	Boehlerit grade:	$a_p = 4 - 10$ mm
	Parameters of cut:	$f_n = 1,0 - 1,6$ mm/U mm/rev

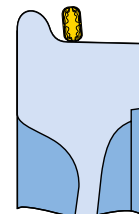


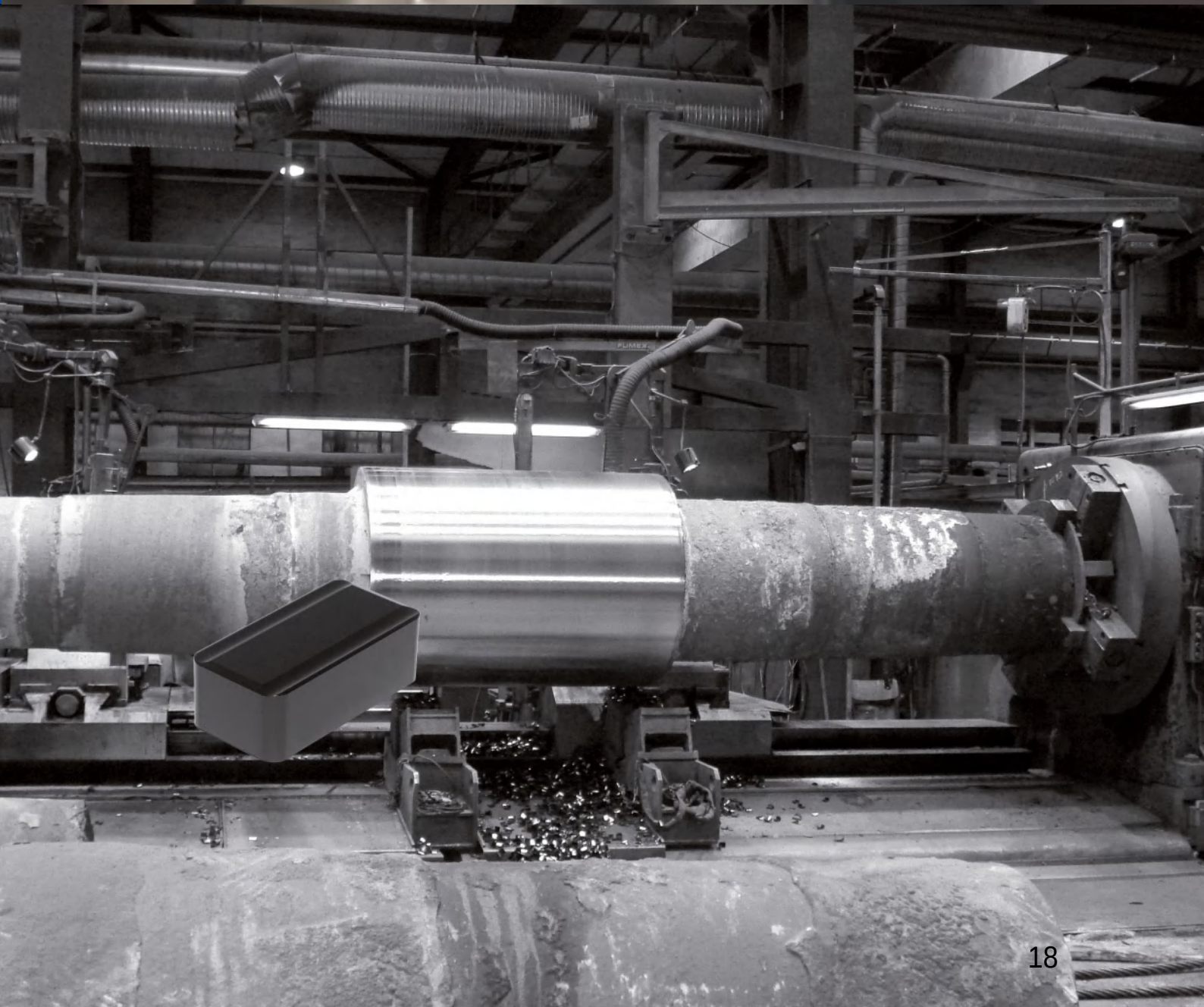
APC352

工件	Work piece:	Radprofil 火车轮 Railway wheel profile
材料:	Material:	干车 <i>dry-</i>
切削条件:	Condition of cut:	BRWT01-325555R
刀具:	Tool:	-
可转位刀片:	Indexable insert:	APC352
涂层牌号: 切削参数	Boehlerit grade:	$v_c = 70$ m/min
	Parameters of cut:	$a_p = 0,4 - 2$ mm
		$f_n = 1,0$ mm/U mm/rev

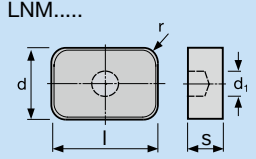
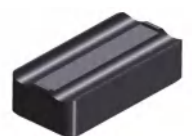


工件	Work piece:	Radprofil 火车轮 Railway wheel profile
材料:	Material:	R7T
切削条件:	Condition of cut:	干车 <i>dry</i>
刀具:	Tool:	BRWT01-325555R
可转位刀片:	Indexable insert:	LNUX 191940-BRW
涂层牌号: 切削参数	Boehlerit grade:	ABC320
	Parameters of cut:	$v_c = 60 - 70$ m/min
		$a_p = 2,5 - 4$ mm
		$f_n = 1,4$ mm/U mm/rev

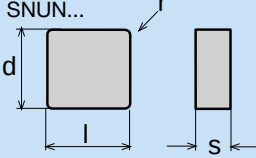
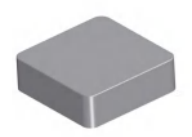




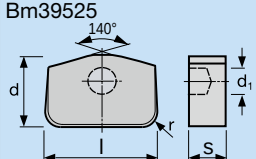
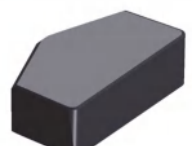
用于铁路轨道车削的可转位刀片
Indexable inserts for roll turning

LNM..... 	编码 Ordering Code	刀片尺寸 Insert size							牌号 Grade		
		l	d	s	d ₁	r			LCP15T	LCP25T	LC228E
LNMR.. 	LNMR 501432	50,8	25,5	14	6,4	3,2			●	●	●
LNMR...-CB 	LNMR 501432-CB	50,8	25,5	14	6,4	3,2			○	○	●

两面可车削刀片 Insert bothsided

SNUN... 	编号 Ordering Code	刀片尺寸 Insert size							牌号 Grade		
		l	d	s	d ₁	r			AB01SA		
SNUN... 	SNUN 250724T	25,40	25,40	7,94		2,4			●		

开槽刀片 Insert for grooving

Bm39525 	编号 Ordering Code	刀片尺寸 Insert size							牌号 Grades		
		l	d	s	d ₁	r			ACP15T	ACP25T	AC228E
Bm39525 	Bm39525	44,4	25,50	14,2	6,4	2,5			○	●	○

牌 号 Grade	标 准 ISO	应用范围 Range of applications	刀片涂层对应加工材料 Insert coating corresponding processing material						刀片应用方式 Insert application method					
			P steel	M 不锈钢 Stainless steel	K 灰铸铁 Grey cast iron	N 金属 metals	S 高温材料 High temperature materials	H 硬质材料 Hard materials	T 车削 Turning	M 铣削 Milling	D 剥皮 Scarfig	S 螺纹 Threa	G 切槽 Grooving	P 切断 Part1
AKC203	P15		■						●					
	P25				□				●					
APC252	P20		■						●					
	P35			□					●					
APC352	P20		■						●					
	P40			■					●					
ABG205	P10-P30 M20-M40 S15-S25		■	■					●					
				■					●					
ABC320	P10- P30 M10- M25				■				●					
			■						●					
ABD152	K10- K25		■		■				●					
			■						●					
应用符合ISO 513全范围 The application complies with the full scope of ISO 513			■ 主要用途 Main application □ 更多用途 Further applications						标准牌号 Standard grade					

加工材料说明 Processing Material Description

应用领域 Fields of a lication

AKC203 P15-P25

高抗拉强度钢材的车削等级以及加工温度。
也适用于铸造车削。

AKC203 P15-P25

Grade for steel materials with tensile strength and
high temperature. Suitable for stainless steel application

APC252 P20-P35

通用车削级) “主要加工级钢材和易加工中等切割速度的
的不锈钢, 包括具有高耐磨性和优异的特性,
适用于广泛的应用领

APC252 P20-P35

(Universal turning grade) “ Main grade for machining
steel materials and easily machina
ble stainless steels at medium cutting speeds, included
inter-the properties of high wear resistance and excellent
characteristics across a wide range of applications.

APC352 P20-P40

CVD涂层P20-P40碳化物等级, 用于钢和铸钢的粗加工
操作, 磨性和韧性的有最佳性能, 适用于广泛的应用领域。

APC352 P20-P40

CVD coated P20 – P40 carbide grade for roughing operation
of steel and casting steel. Optimal performance of wear
resistance and toughness for a wide application field

P10-P30 M20- ABG205 M40 S15-S25

用于在中等切削速度下加工合金和非合金钢的等级。多层
TiN-TiCN涂层被施加到极其坚硬的基材上。因此, 这种切
削材料将硬质材料涂层的耐磨性与基材的切削刃稳定性和
断裂安全性相结合

ABG205 P10-P30 M20-M40 S15-S25

Grade for machining alloyed and unalloyed steels at medium
cutting speeds. The multilayer TiN TiCN coating is on a very
tough base material.
This grade has the wear resistance of the
hard material coating as well as the cutting edge stability an

ABD152 K10-K25

K15地区铸件车削等级。最佳
加工GG和MGG材料并将其用于轧钢

ABD152 K10-K25

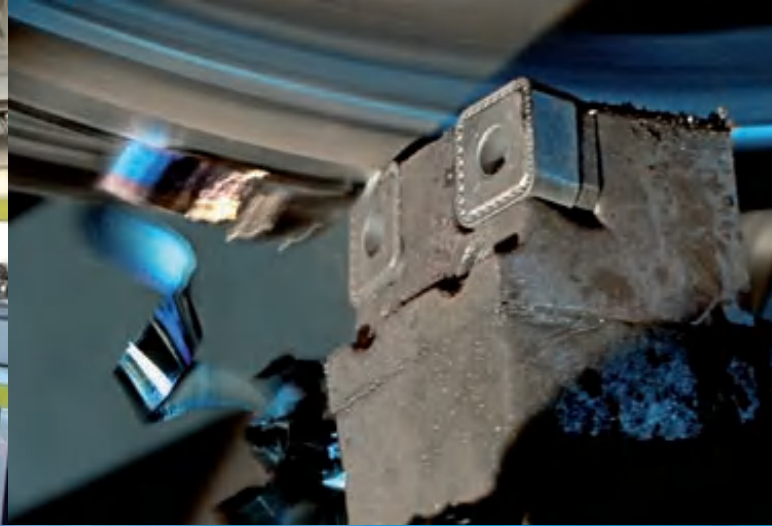
K15 region casting turning grade. the best Processing
GG and MGG materials and using them for steel rolling

ABM 9320 P10-P30 M10-M25

PVD多层涂层P10-P30/M10-M25硬质合金基材, 适用于
中等精加工不锈钢、超合金和钢的加工 (开槽/铣削)
优化的涂层稳定性, 在广泛的应用中具有更高的
耐磨性和热稳定性。

ABM 9320 P10-P30 M10-M25

PVD multilayer coated P10 – P30/M10 – M25 carbide substrate
for finishing to medium machining of stainless steel, super
alloys and steel (grooving/milling). Optimised coating stability
for higher wear resistance and thermal stability in a wide
range of applications.



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