三韩刀具
SANDHOG

宁波三韩合金材料有限公司
NINGBO SANDHOG ALLOY MATERIAL CO.,LTD.
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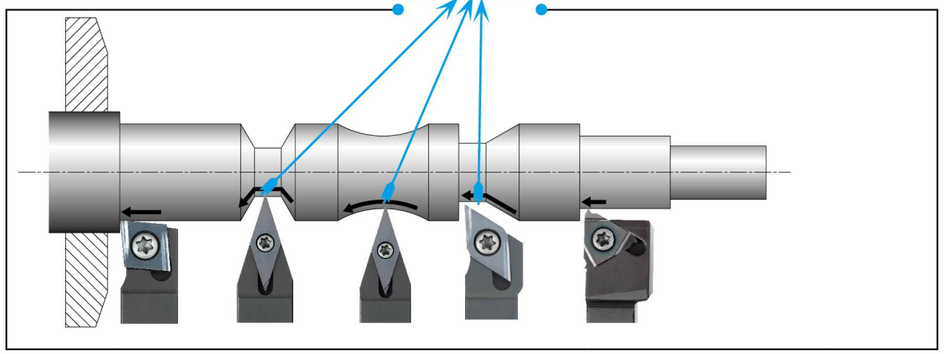


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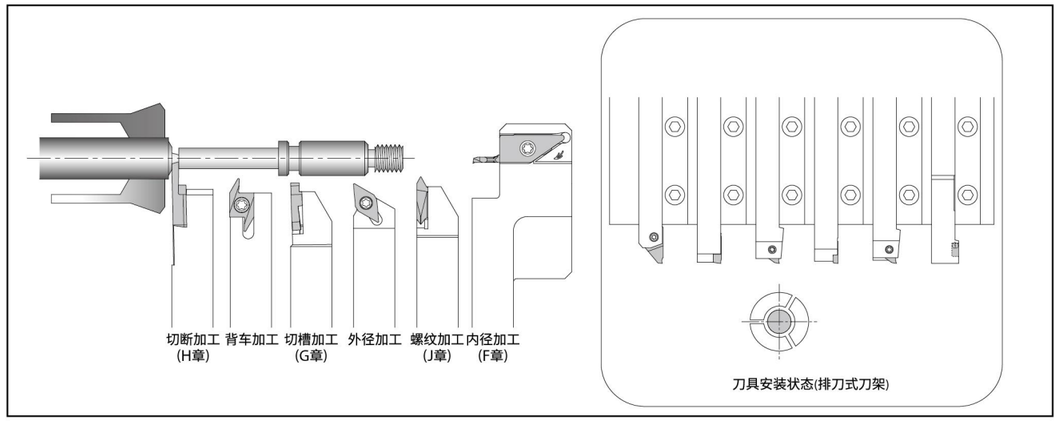
外径加工概要

外径/仿形加工

SCLC- FF	SDJC-FF	SVJB-FF	SDNC	SVVC
螺钉紧固 无偏头	螺钉紧固 无偏头	螺钉紧固 无偏头	螺钉紧固 无偏头	螺钉紧固 无偏头



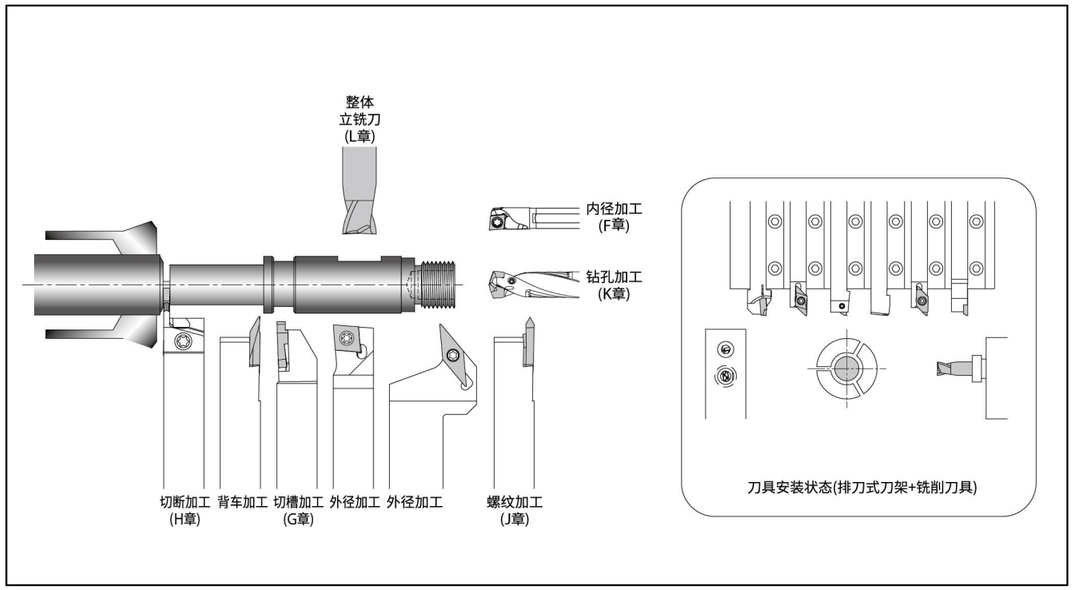
配刀示例① 小型CNC自动车床(排刀式)



背车加工用

KTKF	KTGF	SABS-40F	SABW-40F	TTER	MGEHR	KTTXF
螺钉紧固	螺钉紧固	螺钉紧固	螺钉紧固	螺钉紧固	螺钉紧固	螺钉紧固

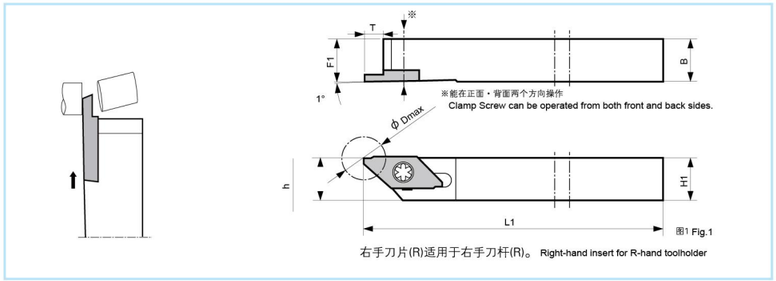
配刀示例② 小型CNC自动车床(排刀式)



KTKF型

For Small Part Cutting KTKF type



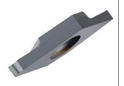
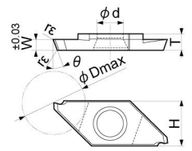
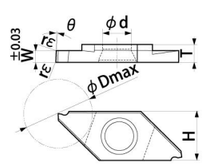


右手刀片(R)适用于右手刀杆(R)。 Right-hand insert for R-hand toolholder

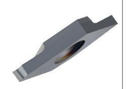
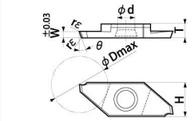
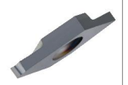
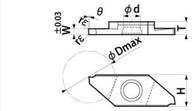
刀杆尺寸 Toolholder Dimensions

型号 Designation		库存 Stock R	库存 Stock L	尺寸(mm) Dimensions(mm) H1=h	B	L1	L2	F1	T	形状 shape	零件 Spare parts 紧固螺丝 screw	零件 Spare parts 扳手 Wrench	适用刀片 Applicable Inserts
KTKFR/L	1010JX-12	●	●	10	10	120	15	10	6	图1 Fig.1	M4.0*9	T15	TKF12R/L ...
	1212JX-12	●	●	12	12	120	-	12	6				
	1616JX-12	●	●	16	16	120	-	16	6				
	2020JX-12	●	●	20	20	120	-	20	6				
KTKFR/L	1010JX-16	●	●	10	10	120	20	10	8	图1 Fig.1	M4.0*9	T15	TKF16R/L ...
	1212JX-16	●	●	12	12	120	-	12	8				
	1616JX-16	●	●	16	16	120	-	16	8				
	2020JX-16	●	●	20	20	120	-	20	8				

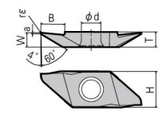
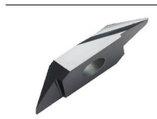
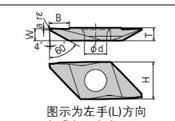
切断加工 Cut-Off

形状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型号 Description		尺寸(mm) Dimension (mm) W	ϕD max	R(rε)	T	H	ϕd	角度(°) Angle θ	PVD涂层 PVD Coating CCG20E	适用刀杆 Related holder
		**TKF12R/L**	050-S-16DR	0.50	5	0.03	3	8.7	5	16°	●	KTKFR/L ...12
			070-S-16DR	0.70	8	0.03	3	8.7	5	16°	●	
			100-S-16DR	1.00	12	0.03	3	8.7	5	16°	●	
			125-S-16DR	1.25	12	0.03	3	8.7	5	16°	●	
			150-S-16DR	1.50	12	0.03	3	8.7	5	16°	●	
			200-S-16DR	2.00	12	0.03	3	8.7	5	16°	●	
		**TKF12R/L**	050-S	0.50	5	0.03	3	8.7	5	0°	●	KTKFR/L ...12
			070-S	0.70	8	0.03	3	8.7	5	0°	●	
			100-S	1.00	12	0.03	3	8.7	5	0°	●	
			125-S	1.25	12	0.03	3	8.7	5	0°	●	
			150-S	1.50	12	0.03	3	8.7	5	0°	●	
			200-S	2.00	12	0.03	3	8.7	5	0°	●	

切断加工 Cut-Off

形状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型号 Description		尺寸(mm) Dimension (mm) W	ϕD max	R(rε)	T	H	ϕd	角度(°) Angle θ	PVD涂层 PVD Coating CCG20E	适用刀杆 Related holder
		**TKF16R/L**	150-S-16DR	1.5	16	0.05	4	9.5	5	16°	●	KTKFR/L ...16
			200-S-16DR	2.0	16	0.05	4	9.5	5	16°	●	
		**TKF16R/L**	150-S	1.5	16	0.05	4	9.5	5	0°	●	KTKFR/L ...16
			200-S	2.0	16	0.05	4	9.5	5	0°	●	

外径 (背车加工) Turning (Back Turning)

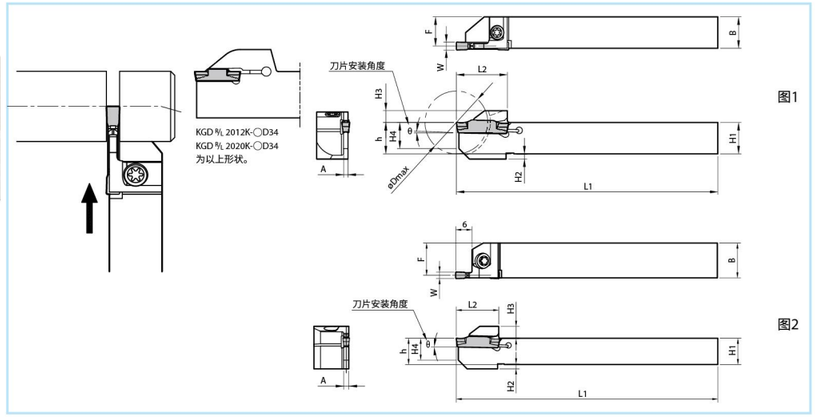
形状 Shape 图片表示为右手方向(R) The photograph shows R-hand.		型号 Description		尺寸(mm) Dimension (mm) W	a	B	R(rε)	T	H	ϕd	角度(°) Angle θ	PVD涂层 PVD Coating CCG20E	适用刀杆 Related holder
	 图示为右手(R)方向 Right-hand shown.	**TKFB**	12R15005M	1.5	0.25	2.6	<0.05	3.0	8.7	5.2		●	KTKFR ...12
			12R28005M	2.8	0.30	4.6	<0.05	3.0	8.7	5.2		●	
			12R28010M	2.8	0.30	4.6	<0.10	3.0	8.7	5.2		●	
		TKFB	16R38005M	3.8	0.30	6.3	<0.05	4.0	9..5	5.2		●	KTKFR ...16
			16R38010M	3.8	0.30	6.3	<0.10	4.0	9.5	5.2		●	
	 图示为左手(L)方向 Left-hand shown.	**TKFB**	12L28005MR	2.8	0.30	4.6	<0.05	3.0	8.7	5.2		●	KTKFL ...12
			12L28010MR	2.8	0.30	4.6	<0.10	3..0	8..7	5.2		●	
		TKFB	16L38005MR	3.8	0.30	6.3	<0.05	4.0	9.5	5.2		●	KTKFL ...16
			16L38010MR	3..8	0.30	6.3	<0.10	4.0	9.5	5.2		●	

TKF12/16推荐加工参数
Recommended Cutting Conditions (TKF12/16)

被切削材 Workpiece Material	推荐刀片材质Recommended Insert Grade (切削速度Vc m/min) PVD涂层 PVD Coating CCG20E	TKF12 刃宽Width W(mm) 0.5 进给Feed Rate(mm/rev)	0.7	1.0	1.25	1.5	2.0	TKF16 刃宽Width W(mm) 1.5 进给Feed Rate(mm/rev)	2.0	备注 Remarks
碳钢(SxxC等) Carbon Steel (SxxC etc	☆ 60-130	0.01~0.02	0.01~0.03	0.01~0.04 (0.01~0.05)	0.01~0.04	0.01~0.04 (0.02~0.1)	0.01~0.04 (0.02~0.1)	0.02~0.07 (0.02~0.1)	0.02~0.07 (0.02~0.1)	湿式 Wet
合金钢(SCM等) Alloy Steel (SCM etc)	☆ 60-130	0.01~0.02	0.01~0.03	0.01~0.04 (0.01~0.05)	0.01~0.04	0.01~0.04 (0.02~0.1)	0.01~0.04 (0.02~0.1)	0.02~0.07 (0.02~0.1)	0.02~0.07 (0.02~0.1)	
不锈钢(SUS304等) Stainless Steel (SUS304 etc)	☆ 50-100	0.005~ 0.015	0.01~0.02	0.01~0.02 (0.01~0.03)	0.01~0.02	0.01~0.02 (0.01~0.05)	0.01~0.02 (0.01~0.05)	0.01~0.04 (0.01~0.05)	0.01~0.04 (0.01~0.05)	

KGD型



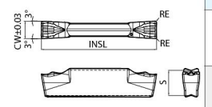


刀杆尺寸　Toolholder Dimensions

型号 Designation		库存 Stock		加工径	尺寸(mm) Dimensions(mm)									角度	刀宽 W(mm)	形状 shape	零件 Spare parts	
		R	L	øDmax	H1=h	H2	H3	H4	B	L1	L2	F	A	θ			紧固螺丝 screw	扳手 Wrench
KGDR/L	1010JX-1.3D16	●	●	16	10	2	4.5	8	10	120	18	9.9	1.0	5°	1.3	图1 Fig.1	M4.0*14	T15
	1010JX-1.3	●	●	20	10	2	4.5	8	10	120	18	9.5	1.0	5°	1.3		M4.0*14	T15
	1212F-1.3D16	●	●	16	12	2	4.5	10	12	85	19.5	11.9	1.0	5°	1.3		M4.0*16	T20
	1212JX-1.3D16	●	●	16	12	2	4.5	10	12	120	19.5	11.9	1.0	5°	1.3		M4.0*16	T20
	1212F-1.3	●	●	24	12	2	4.5	10	12	85	19.5	11.5	1.0	5°	1.3		M4.0*16	T20
	1212JX-1.3	●	●	24	12	2	4.5	10	12	120	19.5	11.5	1.0	5°	1.3		M4.0*16	T20
KGDR/L	1010JX-1.5D16	●	●	16	10	2	4.5	8	10	120	18	9.7	1.2	5°	1.5	图1 Fig.1	M4.0*14	T15
	1010JX-1.5	●	●	20	10	2	4.5	8	10	120	18	9.4	1.2	5°	1.5		M4.0*14	T15
	1212F-1.5D16	●	●	16	12	2	4.5	10	12	85	19.5	11.7	1.2	5°	1.5		M4.0*16	T20
	1212JX-1.5D16	●	●	16	12	2	4.5	10	12	120	19.5	11.7	1.2	5°	1.5		M4.0*16	T20
	1212F-1.5	●	●	24	12	2	4.5	10	12	85	19.5	11.4	1.2	5°	1.5		M4.0*16	T20
	1212JX-1.5	●	●	24	12	2	4.5	10	12	120	19.5	11.4	1.2	5°	1.5		M4.0*16	T20
KGDR/L	1010JX-2	●	●	20	10	2	4.5	8	10	120	18	9.15	1.7	1°	2.0	图1 Fig.1	M4.0*14	T15
	1212F-2	●	●	24	12	2	4.5	10	12	85	19.5	11.15	1.7	1°	2.0		M4.0*16	T20
	1212JX-2	●	●	24	12	2	4.5	10	12	120	19.5	11.15	1.7	1°	2.0		M4.0*16	T20
	1616JX-2	●	●	32	16	-	4.5	10	16	120	24.5	15.15	1.7	1°	2.0		M4.0*16	T20
	2012K-2D34	●	●	34	20	-	9.5	20	12	125	32.5	11.2	1.6	0°	2.0		M4.0*16	T20
	2020K-2D34	●	●	34	20	-	9.5	20	20	125	32.5	19.2	1.6	0°	2.0		M4.0*16	T20
KGDR/L	1010JX-2.4	●	●	20	10	2	4.5	8	10	120	18	9	2.0	1°	2.4	图1 Fig.1	M4.0*14	T15
	1212F-2.4	●	●	24	12	2	4.5	10	12	85	19.5	11	2.0	1°	2.4		M4.0*16	T20
	1212JX-2.4	●	●	24	12	2	4.5	10	12	120	19.5	11	2.0	1°	2.4		M4.0*16	T20
	1616JX-2.4	●	●	32	16	-	4.5	10	16	120	24.5	15	2.0	1°	2.4		M4.0*16	T20
	2012K-2.4D34	●	●	34	20	-	9.5	20	12	125	32.5	11	2.0	0°	2.4		M4.0*16	T20
	2020K-2.4D34	●	●	34	20	-	9.5	20	20	125	32.5	19	2.0	0°	2.4		M4.0*16	T20
KGDR/L	1212JX-3	●	●	24	12	2	4.5	10	12	120	19.5	10.8	2.4	1°	3.0	图1 Fig.1	M4.0*16	T20
	1616JX-3	●	●	32	16	-	4.5	10	16	120	24.5	14.8	2.4	1°	3.0		M4.0*16	T20
	1616JX-3D38	●	●	38	16	-	6	10	16	120	29	14.8	2.4	1°	3.0		M4.0*16	T20
	1913JX-3D38	●	●	38	19	-	6	13	13	125	29	11.8	2.4	1°	3.0		M4.0*16	T20
	2012JX-3D42	●	●	42	20	-	6	14	12	120	31	10.8	2.4	1°	3.0		M4.0*16	T20
	2012JX-3D51	●	●	51	20	-	7.5	14	12	120	36	10.8	2.4	1°	3.0		M4.0*16	T20
	2020JX-3D42	●	●	42	20	-	6	14	20	120	31	18.8	2.4	1°	3.0		M4.0*16	T20
	2020JX-3D51	●	●	51	20	-	7.5	14	20	120	36	18.8	2.4	1°	3.0		M4.0*16	T20
	1216JX-3T06	●	●	-	12	2	5.5	10	16	120	19.5	14.8	2.4	-	3.0	图2 Fig.2	M4.0*16	T20

三韩刀具 SANDHOG

切断加工 Cut-Off

形状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型号 Description		刃宽(CW)		尺寸(mm) Dimension (mm)			角度(°) Angle	PVD涂层 PVD Coating	适用刀杆 Related holder
					公差	RE	INSL	S	θ	CCG20E	
		GDM	2020N-020PM	2.0	±0.03	0.2	20	4.3	-	●	H18~ H23
			2520N-020PM	2.5		0.25				●	
			3020N-025PM	3.0		0.3				●	H18~ H25
			4020N-030PM	4.0		0.4				●	H18 H21~ H25

推荐切削参数(PM/PH断屑槽)

被切削材 Workpiece Material	推荐刀片材质Recommended Insert Grade (切削速度Vc m/min)	进给Feed Rate(mm/rev)			备注 Remarks
		PM	PH		
	PVD涂层 PVD Coating	刃宽Width CW(mm)	刃宽Width CW(mm)		
	CCG20E	2~4	2	3~4	
碳钢(SxxC等) Carbon Steel (SxxC etc	☆ 100~200	0.08~0.18	0.10~0.25	0.15~0.28	湿式 Wet
合金钢(SCM等) Alloy Steel (SCM etc)	☆ 80~180	0.08~0.18	0.10~0.25	0.15~0.28	
不锈钢(SUS304等) Stainless Steel (SUS304 etc)	☆ 60~150	0.06~0.12	0.05~0.12	0.08~0.15	
铸铁(FC · FCD等) Cast Iron (FC/FCD etc)	★ 100~200	0.08~0.18	0.10~0.25	0.15~0.28	

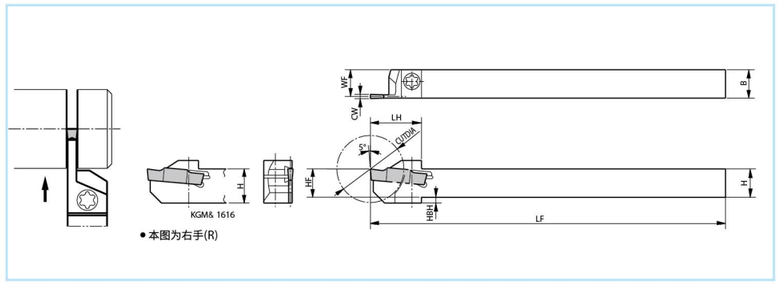
★：第1推荐 1st Recommendation　☆：第2推荐 2nd Recommendation

推荐切削参数

被切削材 Workpiece Material	(切削速度Vc m/min)	进给Feed Rate(mm/rev)
碳钢(SxxC等) Carbon Steel (SxxC etc	60~200	0.08~0.18
合金钢(SCM等) Alloy Steel (SCM etc)	60~150	0.08~0.18
不锈钢(SUS304等) Stainless Steel (SUS304 etc)	50~140	0.08~0.18

KGM(自动车床用)





刀杆尺寸　Toolholder Dimensions

型号 Designation		库存 Stock R	库存 Stock L	尺寸(mm) Dimensions(mm) CUTDIA	H	HF	HBH	B	LF	LH	WF	刃宽 CW(mm) MIN.	MAX.	零件 Spare parts 紧固螺丝 screw	扳手 Wrench
KGMR/L	1010JX-1.5	●	●	18	10	10	2	10	120	18	9.4	1.5	2..0	M4.0*16	T20
	1212JX-1.5	●	●	23	12	12	2	12	120	19	11.4	1.5	2.0	M4.0*16	T20
KGMR/L	1010JX-2	●	●	18	10	10	2	10	120	18	9.15	2.0	3.0	M4.0*16	T20
	1212JX-2	●	●	23	12	12	2	12	120	19	11.15	2.0	3.0	M4.0*16	T20
	1616JX-2	●	●	30	16	16	-	16	120	24.5	15.15	2.0	3.0	M5.0*12	T20
KGMR/L	1212JX-2.5	●	●	23	12	12	2	12	120	19	11	2.4	3.0	M4.0*16	T20
	1616JX-2.5	●	●	30	16	16	-	16	120	24.5	15	2.4	3.0	M5.0*12	T20
KGMR/L	1616JX-3	●	●	30	16	16	-	16	120	24.5	14.8	3.0	4.0	M5.0*12	T20
KGMRR/L	1212F-1.5-85	●	●	23	12	12	2	12	85	19	11.4	1.5	2.0	M4.0*16	T20
KGMR/L	1212F-2-85	●	●	23	12	12	2	12	85	19	11.15	2.0	3.0	M4.0*16	T20
KGMR	1212F-2.5-85	●	●	23	12	12	2	12	85	19	11	2.4	3.0	M4.0*16	T20

CDX:表示加工可对应的槽深。
KGMR/L 121 2H-3上也可安装刃宽4.0mm的刀片，但是由于刚性不足不推荐。

切断加工 Cut-Off

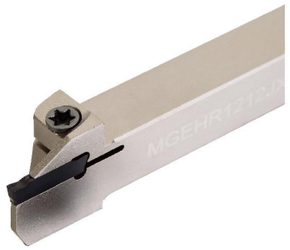
形状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型号 Description	尺寸(mm) Dimension (mm) CW	RE	INSL	S	角度(°) Angle PSIR R/L	PVD涂层 PVD Coating CCG20E	适用刀杆 Related holder
重视锋利度型 2刀尖规格		**GMMR/L** 1520R/L-MT-15D	1.5	0 0.05	20	4.3	15°	○	KGMR/L
		2020R/L-MT-15D	2.0	0 0.05	20	4.3	15°	○	
		2520R/L-MT-15D	2.5	0 0.05	20	4.3	15°	○	
		3020R/L-MT-15D	3.0	0 0.05	20	4.3	15°	○	

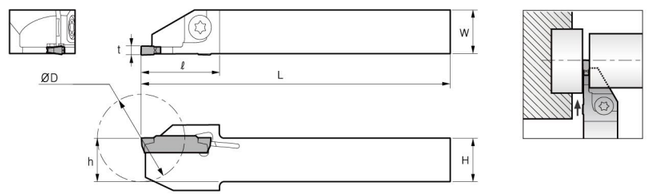
多功能刀具(GMM-MT使用时)

被切削材 Workpiece Material	推荐刀片材质Recommended Insert Grade (切削速度Vc m/min) PVD涂层 PVD Coating CCG20E	刃宽Width CW(mm) 1.5	2.0/2.5	3.0	4.0	备注 Remarks
		进给Feed Rate(mm/rev)				
碳钢(SxxC等) Carbon Steel (SxxC etc	★ 60～150	0.01～0.04	0.02～0.15	0.03～0.20	0.08～0.30	湿式 Wet
合金钢(SCM等) Alloy Steel (SCM etc)	★ 60～150	0.01～0.04	0.02～0.15	0.03～0.20	0.08～0.30	
不锈钢(SUS304等) Stainless Steel (SUS304 etc)	★ 60～140	0.01～0.03	0.02～0.10	0.03～0.15	0.08～0.25	

※(　　)内是刃口强化型(TKF..T..)的切削参数。(　　): Cutting condition of tough edge type inserts (TKF..T..)
★：第1推荐 1st Recommendation　☆：第2推荐 2nd Recommendation

Available tool holders (MGT)

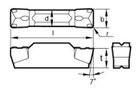
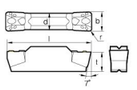




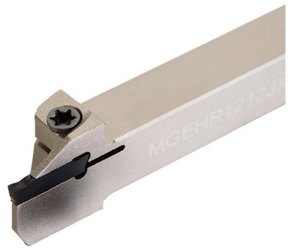
刀杆尺寸　Toolholder Dimensions

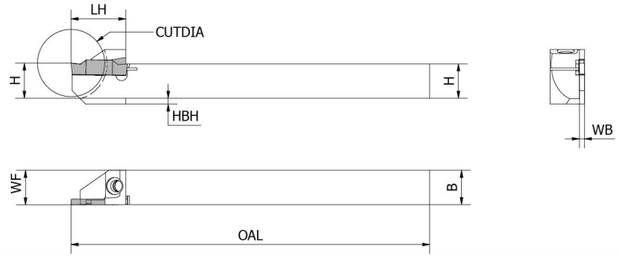
型 号 Designation	库 存 Stock		尺寸(mm) Dimensions(mm)						Insert	零件 Spare parts	
	R	L	H=h	w	L	ℓ	t	ϕD		紧固螺丝 screw	扳手 Wrench
MGEHL1010JX-1.5	●	●	10	10	120	18.0	1.5	20	MGMN150	M5.0*16N	L4.0
MGEHL1010JX-2.5	●	●	10	10	120	18.0	1.5	20	MGMN250	M5.0*16N	L4.0
MGEHL1010JX-2	●	●	10	10	120	18.0	1.5	20	MGMN200	M5.0*16N	L4.0
MGEHL1212JX-1.5	●	●	12	12	120	19.5	2.0	25	MGMN150	M5.0*16N	L4.0
MGEHL1212JX-2	●	●	12	12	120	19.5	2.0	25	MGMN200	M5.0*16N	L4.0
MGEHL1616JX-1.5	●	●	16	16	120	25.0	2.0	32	MGMN150	M5.0*16N	L4.0
MGEHL1616JX-2	●	●	16	16	120	25.0	2.0	32	MGMN200	M5.0*16N	L4.0
MGEHR1010JX-1.5	●	●	10	10	120	20.0	2.5	20	MGMN150	M5.0*16N	L4.0
MGEHR1212JX-1.5	●	●	12	12	120	20.0	2.5	25	MGMN150	M5.0*16N	L4.0
MGEHR1212JX-2	●	●	12	12	120	20.0	2.5	25	MGMN200	M5.0*16N	L4.0
MGEHR1616JX-1.5	●	●	16	16	120	25.0	2.5	32	MGMN150	M5.0*16N	L4.0
MGEHR1616JX-2	●	●	16	16	120	25.0	2.5	32	MGMN200	M5.0*16N	L4.0

Applicable inserts (MGT)

形 状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型 号 Description		尺 寸(mm) Dimension (mm)					PVD涂层 PVD Coating
				b	r	I	d	t	CCG20E
		MGMN	150-G	1.5	0.15	16.0	1.2	3.50	●
			200-G	2.0	0.20	16.0	1.2	3.50	●
			250-G	2.5	0.20	18.5	2.0	3.50	●
		MGMN	200-M	2.0	0.20	16.0	1.2	3.50	●
			250-M	2.5	0.20	18.5	2.0	3.85	●

T-CLAMP

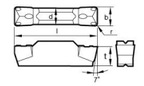
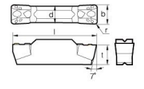




刀杆尺寸　Toolholder Dimensions

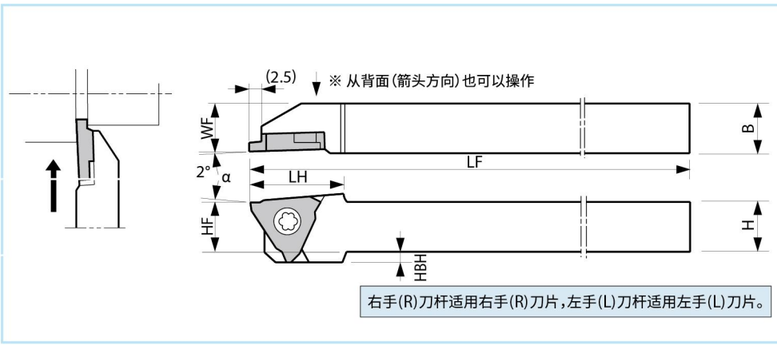
型 号 Designation	库 存 Stock		尺寸(mm) Dimensions(mm)										零件 Spare parts	
	R	L	CW	SSC	H	B	OAL	LH	WF	WB	H2		紧固螺丝 screw	扳手 Wrench
TTEL12-24-2	●	●	1.4	1	12	12	125	19.5	11.5	1	15.7		M4.0*16	T20
TTEL12-24-3	●	●	1.4	1	12	12	125	19.5	11.5	1	15.7		M4.0*16	T20
TTEL16-32-2	●	●	1.4	1	16	16	125	24	15.5	1	19.7		M4.0*16	T20
TTEL16-32-3	●	●	1.4	1	16	16	125	24	15.5	1	19.7		M4.0*16	T20
TTER12-24-2	●	●	2.0	2	12	12	125	19	11.1	1.72	19		M4.0*16	T20
TTER12-24-3	●	●	2.0	2	12	12	125	19	11.1	1.72	19		M4.0*16	T20
TTER16-32-2	●	●	2.0	2	16	16	125	24	15.1	1.72	21		M4.0*16	T20
TTER16-32-3	●	●	2.0	2	16	16	125	24	15.1	1.72	21		M4.0*16	T20

Applicable inserts (MGT)

形 状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型 号 Description		尺 寸(mm) Dimension (mm)				PVD涂层 PVD Coating
				d	t	r	D	CCG20E
		TDC	200	2.0	4.7	0.2	1.70	●
			300	3.0	4.7	0.2	2.40	●
			400	4.0	4.7	0.3	3.00	●
			500	5.0	5.2	0.3	4.00	●
		TDJ	200	2.0	4.7	0.2	1.70	●
			300	3.0	4.7	0.2	2.40	●
			400	4.0	4.7	0.3	3.00	●
			500	5.0	5.2	0.3	4.00	●

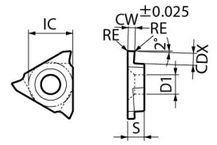
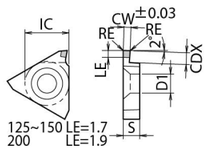
KTGF–F





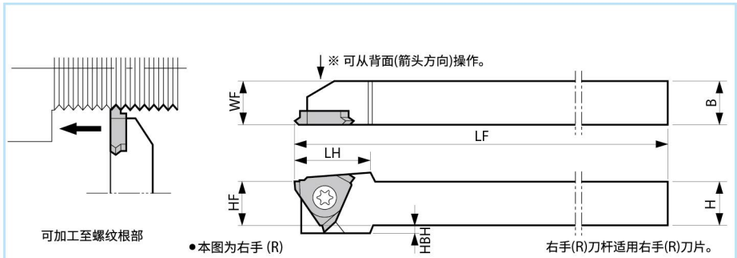
刀杆尺寸　Toolholder Dimensions

型号 Designation		库存 Stock		尺寸(mm) Dimensions(mm)							零件 Spare parts	
		R	L	H	HBH	HF	B	LF	LH	WF	紧固螺丝 screw	扳手 Wrench
KTGFR/L	1010JX-16F	●	●	10	2	10	10	120	18.5	10	M3.5*9	FT-8
	1212JX-16F	●	●	12	-	12	12	120	18.5	12	M3.5*9	FT-8
	1616JX-16F	●	●	16	-	16	16	120	18.5	16	M3.5*9	FT-8
KTGFR/L	1212F-16F	●	●	12	-	12	12	85	18.5	12	M3.5*9	FT-8
KTGFR/L	1010F-16	●	●	10	4	10	10	80	18.5	12	M3.5*9	FT-10
	1212H-16	●	●	12	2	12	12	100	18.5	16	M3.5*9	FT-10
	1616H-16	●	●	16	-	16	16	100	18.5	20	M3.5*9	FT-10
	2020K-16	●	●	20	-	20	20	125	20	25	M3.5*9	FT-10
	2525M-16	●	●	25	-	25	25	150	20	32	M3.5*9	FT-10

形状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型号 Description		尺寸(mm) Dimension (mm) CW	CDX	RE	PVD涂层 PVD Coating CCG20E	适用刀杆 Related holder
		**TGF32R/L**	033-005	0.33	0.8	0.05	●	KTGF R/L---16F KTGF R/L---16 S---KTGF L/-16
			050-005	0.50	1.2	0.05	●	
			075-010	0.75	2.0	0.1	●	
			095-010	0.95	2.0	0.1	●	
			100-010	1.00	2.0	0.1	●	
			120-010	1.20	2.0	0.1	●	
			125-010	1.25	2.0	0.1	●	
			140-010	1.40	2.0	0.1	●	
			145-010	1.45	2.0	0.1	●	
			150-010	1.50	2.0	0.1	●	
			175-010	1.75	2.0	0.1	●	
			200-010	2.00	2.5	0.1	●	
			250-010	2.50	2.5	0.1	●	
		**TGF32R/L**	125-010	1.25	2.0	0.1	●	
			150-010	1.50	2.0	0.1	●	
			200-010	2.00	2.5	0.1	●	

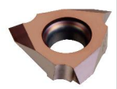
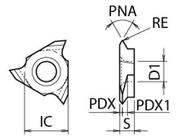
KTTX





刀杆尺寸　Toolholder Dimensions

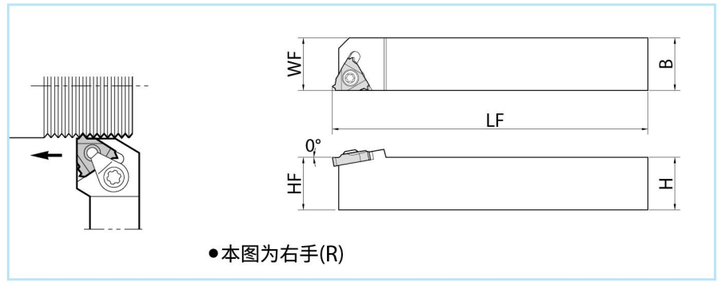
型 号 Designation		库 存 Stock	尺寸(mm) Dimensions(mm) H	HF	HBH	B	LF	LH	WF	零件 Spare parts 紧固螺丝 screw	扳手 Wrench
KTTXR	1010JX-16	●	10	10	2	10	120	17.6	10	M4.0*9	T15
	1212JX-16F	●	12	12	-	12	120	17.6	12	M4.0*9	T15
	1616JX-16F	●	16	16	-	16	120	17.6	16	M4.0*9	T15
	1212F-16F	●	12	12	-	12	85	17.6	12	M4.0*9	T15
	2020K-16F	●	20	20	-	20	125	17.6	20	M4.0*9	T15

形 状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型 号 Description		适用螺纹	螺距 mm	螺距 牙/英寸	尺寸(mm) Dimension (mm) RE	PDX	PDX1	角度(°) Angle PNA	PVD涂层 PVD Coating CCG20E	适用刀杆 Related holder
		**TTX32R**	6000	M UN	0.5～1.0 -	- 56～32	0.00	0.6	1.12	60°	●	KTTXR...-16 S...KTTXL16
			60005	M UN	0.5～1.0 -	- 48～32	0.05	0.6	1.12	60°	●	
			6001	M UN	1.0～2.0 -	- 28～14	0.10	1.1	1.62	60°	●	
		TTX32R	600S	M UN	0.5 -	- 56～48	0.00	0.3	1.12	60°	●	
			60005S	M UN	0.5 -	- 48	0.05	0.3	1.12	60°	●	
		TTX32R	5501	G R W	-	28～19 24～20	0.10	0.75	1.01	55°	●	
			55015	G R W	-	19～11 20～11	0.15	1.20	1.46	55°	●	

适用螺纹		
	M:公制螺纹	R (PT)(BSPT):管用锥度螺纹
	UN:英制螺纹	W:惠氏螺纹
	UNF :英制细牙螺纹	NPT:美式管用锥度螺纹
	G(PF):管用平行螺纹	

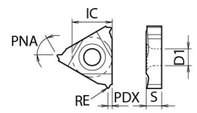
SER/L





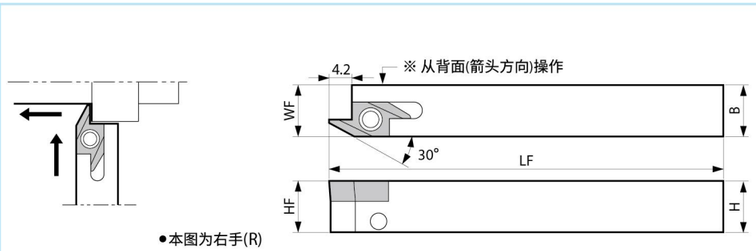
刀杆尺寸　Toolholder Dimensions

型 号 Designation		库存 Stock R	L	尺寸(mm) Dimensions(mm) H	HF	B	LF	LH	WF	形状 shape	零件 Spare parts 紧固螺丝 screw	扳手 Wrench	垫片 Shim	垫片紧固螺钉 Screw	适用刀片 Applicable Inserts
SER/L	1216JX-16F	●	●	12	12	16	120	-	16	Fig.1	M3.5*9	T15	-	-	16E R/L ...
	1616H-16	●	●	16	16	16	100	25	20	Fig.2	M3.5*12	T15	TN-32	SP3X8	
	1616JX-16F	●	●	16	16	16	120	-	16	Fig.1	M3.5*12	T15	-	-	
	2020H-16*	●	●	20	20	20	100	25	25	Fig.2	M3.5*12	T15	TN-32	SP3X8	
	2020JX-16F	●	●	20	20	20	120	-	20	Fig.1	M3.5*12	T15	-	-	

形 状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型 号 Description		适用螺纹 M 螺距 mm	尺寸(mm) Dimension (mm) RE	PDX	角度(°) Angle PNA	PVD涂层 PVD Coating CCG20E
		**16ER/L**	050ISO	0.5	0.06	0.40	60°	●
			075ISO	0.8	0.09	0.53	60°	●
			100ISO	1.0	0.12	0.80	60°	●
			125ISO	1.25	0.15	0.90	60°	●
			150ISO	1.5	0.19	1.00	60°	●
			175ISO	1.75	0.22	1.50	60°	●
			200ISO	2.0	0.25	1.50	60°	●
			250ISO	2.5	0.32	1.60	60°	●
			300ISO	3.0	0.41	2.10	60°	●
			350ISO	3.5	0.48	2.10	60°	●
			400ISO	4.0	0.55	2.80	60°	●
			450ISO	4.5	0.62	2.80	60°	●
			500ISO	5.0	0.70	2.80	60°	●

背车(外径)加工用刀杆(ABS15刀片用)

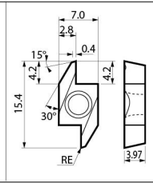




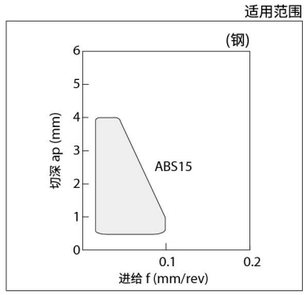
刀杆尺寸　Toolholder Dimensions

型号 Designation		库存 Stock	尺寸(mm) Dimensions(mm) H	HF	B	LF	WF	标准尖R (RE)	零件 Spare parts 紧固螺丝 screw	扳手 Wrench
SABSR	1010JX-40F	●	10	10	10	120	10.2	0.15	M3.0*8	T8
	1212JX-40F	●	12	12	12	120	12.2	0.15	M3.0*8	T8
	1616JX-40F	●	16	16	16	120	16.2	0.15	M3.0*8	T8
SABSR	1212F-40F	●	12	12	12	85	12.2	0.15	M3.0*8	T8
	2020K-40F	●	20	20	20	125	20.2	0.15	M3.0*8	T8

适用刀片

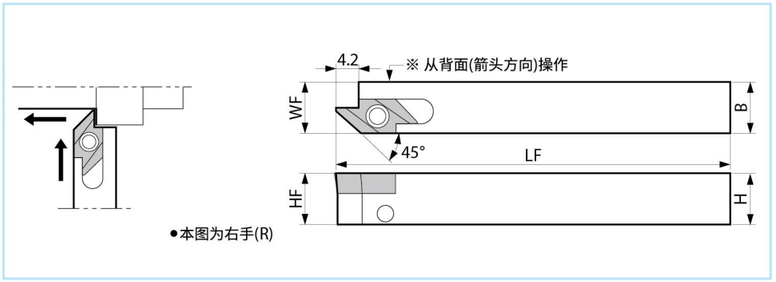
形状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.	型号 Description	刀尖R(RE) (mm)	参考页
 	ABS15R4005	0.05	B102
	15R4015	0.15	B102
	ABS15R4005M	<0.05	B102
	15R4015M	<0.15	B102

适用范围



背车(外径)加工用刀杆[ABW15刀片用]

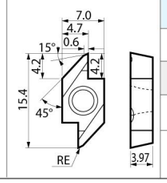




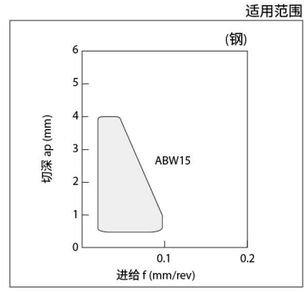
刀杆尺寸　Toolholder Dimensions

型号 Designation		库存 Stock	尺寸(mm) Dimensions(mm) H	HF	B	LF	WF	标准尖R (RE)	零件 Spare parts 紧固螺丝 screw	扳手 Wrench
SABWR	1010JX-40F	●	10	10	10	120	10.2	0.15	M3.0*8	T8
	1212JX-40F	●	12	12	12	120	12.2	0.15	M3.0*8	T8
	1616JX-40F	●	16	16	16	120	16.2	0.15	M3.0*8	T8

适用刀片

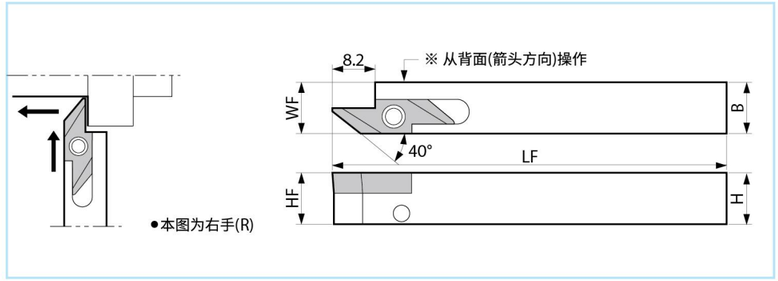
形状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.	型号 Description	刀尖R(RE) (mm)	参考页
 	ABW15R4005	0.05	B102
	15R4015	0.15	B102
	ABW15R4005M	<0.05	B102
	15R4015M	<0.15	B102

适用范围



背车(外径)加工用刀杆[ABW23刀片用]

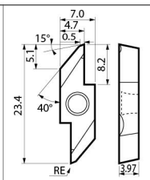




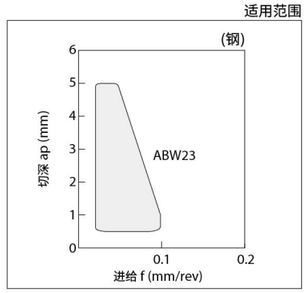
刀杆尺寸　Toolholder Dimensions

型 号 Designation		库存 Stock	尺寸(mm) Dimensions(mm) H	HF	B	LF	WF	标准尖R (RE)	零件 Spare parts 紧固螺丝 screw	扳手 Wrench
SABWR	1010JX-50F	●	10	10	10	120	10.2	0.15	M3.0*8	T8
	1212JX-50F	●	12	12	12	120	12.2	0.15	M3.0*8	T8
	1616JX-50F	●	16	16	16	120	16.2	0.15	M3.0*8	T8

适用刀片

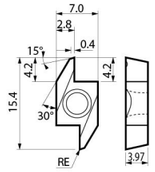
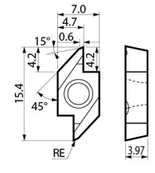
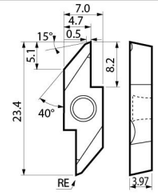
形 状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型 号 Description	刀尖R(RE) (mm)	参考页
		ABW23R5005	0.05	B102
		23R5015	0.15	B102
		ABW23R5005M	<0.05	B102
		23R5015M	<0.15	B102

适用范围



推荐切削参数

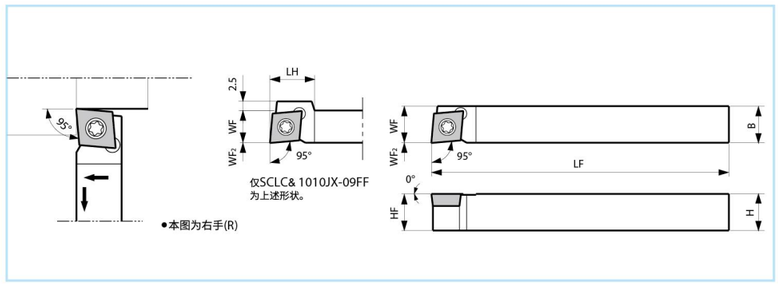
被切削材 Workpiece Material		PVD涂层 PVD Coating CCG20E	
碳钢(SxxC等) Carbon Steel (SxxC etc	切削速度Vc m/min	★ 60~180	
	进给Feed Rate(mm/rev)	0.02	0.02~0.07
合金钢(SCM等) Alloy Steel (SCM etc)	切削速度Vc m/min	★ 60~180	
	进给Feed Rate(mm/rev)	0.02	0.02~0.07
不锈钢(SUS304等) Stainless Steel (SUS304 etc)	切削速度Vc m/min	☆ 30~130	
	进给Feed Rate(mm/rev)	0.02	0.02~0.05
铝合金 Aluminum alloy	切削速度Vc m/min	★ 60~180	
	进给Feed Rate(mm/rev)	0.02	0.02~0.07
黄铜 Brass	切削速度Vc m/min	☆ 30~130	
	进给Feed Rate(mm/rev)	0.02	0.02~0.05

形 状 Shape 带刀片方向的表示为右手方向(R) Handed Insert shows Right-hand.		型 号 Description		尺寸(mm) Dimension (mm) RE	PVD涂层 PVD Coating CCG20E
		**ABS**	15R4005	0.05	●
			15R4015	0.15	●
		ABS	15R4005M	<0.05	●
			15R4015M	<0.15	●
		**ABW**	15R4005	0.05	●
			15R4015	0.15	●
		ABW	15R4005M	<0.05	●
			15R4015M	<0.15	●
		**ABW**	23R5005	0.05	●
			23R5015	0.15	●
		ABW	223R5005M	<0.05	●
			23R5015M	<0.15	●

刀尖R(RE)尺寸用不等号(例: <0.05, <0.1, <0.2等)所示的刀片是指刀尖R(RE)为负公差产品。

小零件加工用刀杆(外径) [CC□□刀片用]



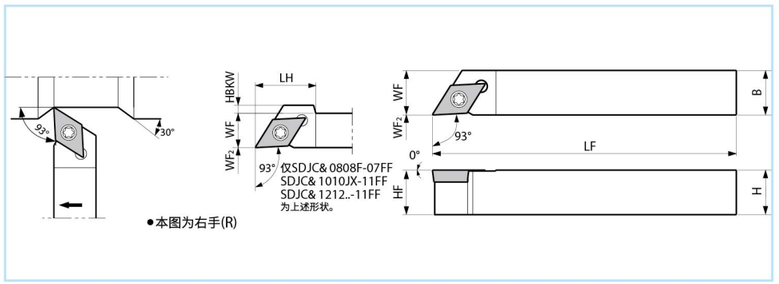


刀杆尺寸　Toolholder Dimensions

型号 Designation		库存 Stock		尺寸(mm) Dimensions(mm)							标准尖R (RE)	零件 Spare parts	
		R	L	H	HF	B	LF	LH	WF	WF2		紧固螺丝 screw	扳手 Wrench
SCLC R/L	1010JX-06FF	●	●	10	10	10	120	-	10	0	0.2	M3.5*9	T15
	1010JX-09FF	●	●	10	10	10	120	15	10	0	0.2	M3.5*9	T15
	1212JX-09FF	●	●	12	12	12	120	-	12	0	0.2	M3.5*9	T15
	1616JX-09FF	●	●	16	16	16	120	-	16	0	0.2	M3.5*9	T15

小零件加工用刀杆(外径) [DC□□刀片用]



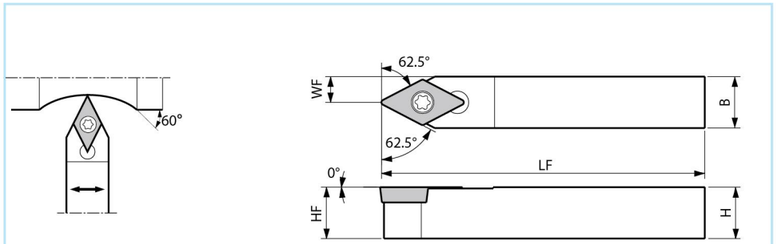


刀杆尺寸　Toolholder Dimensions

型号 Designation		库存 Stock		尺寸(mm) Dimensions(mm)								标准尖R (RE)	零件 Spare parts	
		R	L	H	HF	B	LF	LH	WF	HBKW	WF2		紧固螺丝 screw	扳手 Wrench
SDJC R/L	1010JX-06FF	●	●	10	10	10	120	-	10	-	0	0.2	M3.5*9	T15
	1010JX-09FF	●	●	10	10	10	120	20	10	3	0	0.2	M3.5*9	T15
	1212JX-09FF	●	●	12	12	12	120	-	12	1	0	0.2	M3.5*9	T15
	1616JX-09FF	●	●	16	16	16	120	-	16	-	0	0.2	M3.5*9	T15

小零件加工用刀杆(外径) [DC□□刀片用]



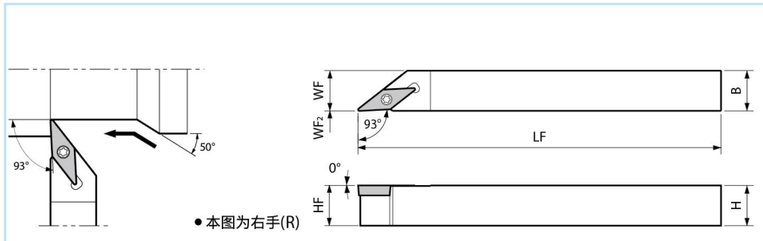


刀杆尺寸　Toolholder Dimensions

型号 Designation		库存 Stock			尺寸(mm) Dimensions(mm)					标准尖R (RE)	零件 Spare parts	
		R	N	L	H	HF	B	LF	WF		紧固螺丝 screw	扳手 Wrench
SDNCN	1010JX-07		●		10	10	10	120	5	0.2	M2.5*6	T8
	1212JX-07		●		12	12	12	120	6	0.2	M2.5*6	T8
	1010JX-11		●		10	10	10	120	5	0.2	M3.5*9	T15
	1212JX-11		●		12	12	12	120	6	0.2	M3.5*9	T15
	1616JX-11		●		16	16	16	120	8	0.2	M3.5*9	T15

小零件加工用刀杆(外径) [VB□□刀片用]





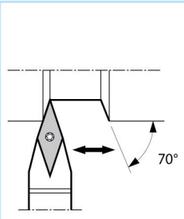
● 本图为右手(R)

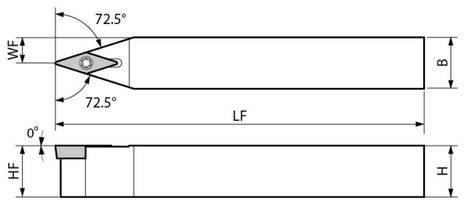
刀杆尺寸　Toolholder Dimensions

型号 Designation		库存 Stock		尺寸(mm) Dimensions(mm)						标准尖R (RE)	零件 Spare parts	
		R	L	H	HF	B	LF	WF	WF2		紧固螺丝 screw	扳手 Wrench
SVJB R/L	1010JX-11FF	●	●	10	10	10	120	10	0	0.4	M2.5*6	T8
	1212JX-11FF	●	●	12	12	12	120	12	0	0.4	M2.5*6	T8
	1616JX-11FF	●	●	16	16	16	120	16	0	0.4	M2.5*6	T8

小零件加工用刀杆(外径) [VB□□刀片用]





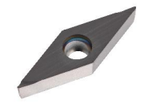
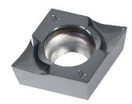


刀杆尺寸　Toolholder Dimensions

型号 Designation		库存 Stock			尺寸(mm) Dimensions(mm)					标准尖R (RE)	零件 Spare parts	
		R	N	L	H	HF	B	LF	WF		紧固螺丝 screw	扳手 Wrench
SVVBN	1010JX-11		●		10	10	10	120	5	0.4	M2.5*6	T8
	1212JX-11		●		12	12	12	120	6	0.4	M2.5*6	T8
	1616JX-11		●		16	16	16	120	8	0.4	M2.5*6	T8

刀片

被加工件 Material	钢 Steel	P	不锈钢 Stainless Steel	M	铸铁 Cast Iron	K	有色金属钢 Nonferrous Metals	N
加工类型 Cut Type	连续加工 Continuous Cut		普通加工 General Cut		断续加工 Interrupted Cut			

刀片形状 Shape	型号 Designation	规格尺寸 Size d	t	r	D	PVD Coating CCG20E	No Coating CCG10A	可配刀杆 Holders
	CCGT09T301FL-U CCG20E	9.525	3.97	0.1	4.4	●	○	SCLCR/L
	CCGT09T301FR-U CCG20E	9.525	3.97	0.1	4.4	●	○	SCLCR/L
	CCGT09T302FL-U CCG20E	9.525	3.97	0.2	4.4	●	○	SCLCR/L
	CCGT09T302FR-U CCG20E	9.525	3.97	0.2	4.4	○	○	SCLCR/L
	DCGT070201EL-U CCG20E	6.35	2.38	0.1	2.8	○	○	SDJCR/L SDNCN
	DCGT070201ER-U CCG20E	6.35	2.38	0.1	2.8	○	○	SDJCR/L SDNCN
	DCGT070202EL-U CCG20E	6.35	2.38	0.2	2.8	○	○	SDJCR/L SDNCN
	DCGT070202ER-U CCG20E	6.35	2.38	0.2	2.8	●	○	SDJCR/L SDNCN
	DCGT11T301EL-U CCG20E	9.525	3.97	0.1	4.4	●	○	SDJCR/L SDNCN
	DCGT11T301ER-U CCG20E	9.525	3.97	0.1	4.4	●	○	SDJCR/L SDNCN
	DCGT11T302EL-U CCG20E	9.525	3.97	0.2	4.4	●	○	SDJCR/L SDNCN
	DCGT11T302ER-U CCG20E	9.525	3.97	0.2	4.4	●	○	SDJCR/L SDNCN
	VBGT110301L-F CCG20E	6.35	3.18	0.1	2.8	●	○	SVJBR/L SVVBN
	VBGT110301R-F CCG20E	6.35	3.18	0.1	2.8	●	○	SVJBR/L SVVBN
	VBGT110302L-F CCG20E	6.35	3.18	0.2	2.8	●	○	SVJBR/L SVVBN
	VBGT110302R-F CCG20E	6.35	3.18	0.2	2.8	●	○	SVJBR/L SVVBN
	XCCGT09T301E-NB CCG20E	9.525	3.97	0.1	4.4		○	SCLCR/L
	XCCGT09T302E-NB CCG20E	9.525	3.97	0.2	4.4	●	○	SCLCR/L
	XCCGT09T304E-NB CCG20E	9.525	3.97	0.4	4.4	●	○	SCLCR/L
	XDCGT11T301E-NB CCG20E	9.525	3.97	0.1	4.4		○	SDJCR/L SDNCN
	XDCGT11T302E-NB CCG20E	9.525	3.97	0.2	4.4	●	○	SDJCR/L SDNCN
	XDCGT11T304E-NB CCG20E	9.525	3.97	0.4	4.4	●	○	SDJCR/L SDNCN
	XVCGT110301E-NB CCG20E	6.35	3.18	0.1	2.8		○	SVJCR/L SVVCN
	XVCGT110302E-NB CCG20E	6.35	3.18	0.2	2.8	●	○	SVJCR/L SVVCN
	XVCGT110304E-NB CCG20E	6.35	3.18	0.4	2.8	●	○	SVJCR/L SVVCN

刀片


KTGFR1212JX-16F
SABSR1212JX-40F
SVVBN1212JX-11FF
SCLCR1212JX-09FF
CTPAR1010
SVJBR1212JX-11FF
KTKFR1212JX-12F
SDNCN121
SABWR1212JX-40F

