



自动车床用

# 3坐标锋利刀尖断屑槽系列

**3D Sharp Edge Chipbreaker Series for Automatic Lathe**

解决切屑处理烦恼的丰富产品系列与MEGACOAT系列组合  
实现长寿命加工！

Extensive product lineup to resolve chip control troubles. Long tool life in combination with MEGACOAT series

## 正角类型 Positive

重视切削阻力(低阻力型)  
Cutting force oriented (Low cutting force)

NEW



低阻力型(精加工用)

**SK断屑槽**

For low cutting force (Finishing)



低阻力型(通用)

**CK断屑槽**

For low cutting force (General use)

重视切屑处理  
Chip control oriented



对应小~大切深

**GQ断屑槽**

For small to large ap



精加工用

**GF断屑槽**

For finishing



对应微小切深

**CF断屑槽**

For minute ap

## 负角类型 Double sided

NEW

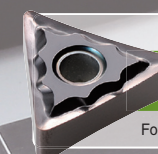


精加工~半精加工用

**SK断屑槽**

For Finishing-Medium

VNCG16型产品系列追加  
VNCG16 type is new available



半精加工~粗加工

**TK断屑槽**

For Medium-Roughing

ADVANCING PRODUCTIVITY

致力于生产效率提高的京瓷

自动车床用  
For Automatic Lathe

负角类型  
Positive

# 3坐标锋利刀尖断屑槽系列

## 3D Sharp Edge Chipbreaker Series for Automatic Lathe

### 解决切屑处理烦恼！配合加工可选 5 种类型

5 types of chipbreakers as solutions for chip evacuation problems

POINT  
01

新开发 3 坐标断屑槽系列的完成，可以在广泛的加工领域发挥良好的切屑处理性能  
New chipbreaker series delivers excellent chip control in a wide range of cutting.

POINT  
02

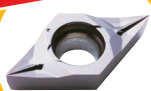
精密外圆研削以及锋利刀尖规格保证锋利效果，可对应高精密切削  
Sharp cutting with ground edge periphery in high precision.

POINT  
03

采用镜面规格保证耐熔着性、完成面效果提高  
The mirror polished insert provides improved adhesion resistance and surface finish.

### 重视切削阻力(低阻力型) Cutting force oriented (Low cutting force)

NEW



低阻力型  
(精加工用)

SK  
断屑槽

For low cutting force  
(Finishing)

兼顾锋利度与切屑处理的 3 维断屑槽切深  
可对应  $ap=0.5\text{mm} \sim 3.0\text{mm}$

3D chipbreaker with sharpness and good chip control  
Applicable  $ap$  range from 0.5 to 3.0mm

延伸至刀尖前端的凸点，保证小切深时的切屑处理得以实现

Large dot to the corner edge  
Improved chip control at small  $ap$  machining

大前角保证大切深时能稳定排出长切屑

Large rake angle generates  
stable long chips at high  $ap$  machining

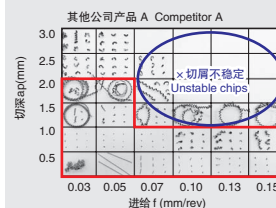
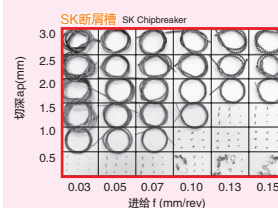
面向中央部刀刃下陷，大幅度降低切削阻力

Slant cutting edge design reduces  
cutting force greatly

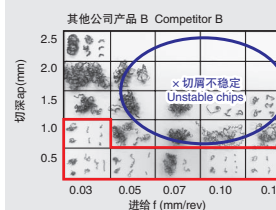
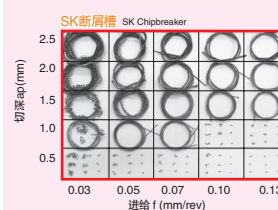
切屑处理比较 Chip Evacuation Comparison

切屑适用范围  
Application range

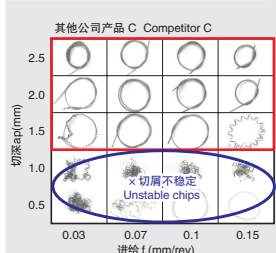
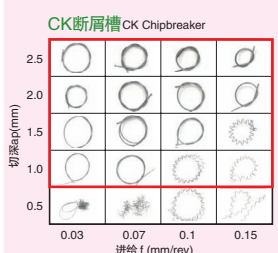
[ S45C  $V_c=100\text{m/min}$  湿式 Wet DCGT11T302型 type ]



[ SUS304  $V_c=100\text{m/min}$  湿式 Wet DCGT11T302型 type ]



[ S45C  $V_c=100\text{m/min}$  湿式 Wet CCGT09T302型 type ]



大前角保证顺畅排出切屑  
对应切深  $1.0 \sim 2.5\text{mm}$

Smooth chip evacuation with large rake angle  
Applicable  $ap$  range from 1.0 to 2.5mm

面向中央部刀刃下陷，大幅度降低切削阻力

Slant cutting edge design reduces  
cutting force greatly

大前角降低切削阻力。可稳定排出长切屑

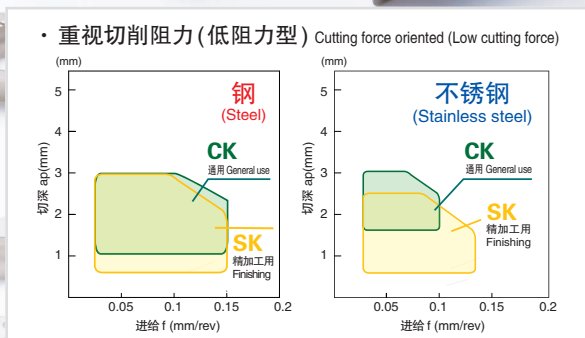
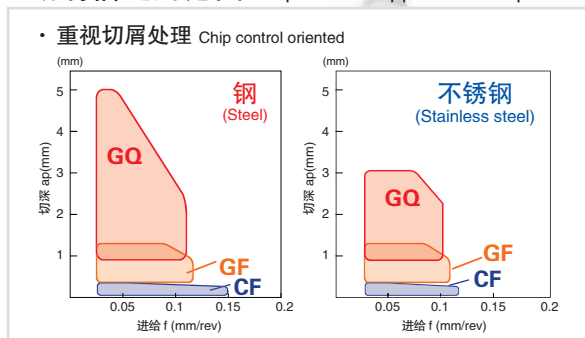
Large rake angle reduces cutting force.  
Long chips in stable conditions.

低阻力型  
(通用)

CK  
断屑槽

For low cutting force  
(General use)

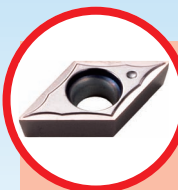
## 断屑槽适用范围 Chipbreaker Application Map



## 重视切屑处理 Chip control oriented

### 切屑处理比较 Chip Evacuation Comparison

切屑适用范围 Application range

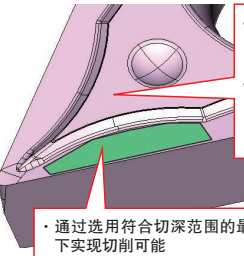


对应小~大切深

**GQ**  
断屑槽

Applicable to both small and large  $a_p$

对应切深  $a_p=0.8 \sim 5\text{mm}$ (钢)、  
 $a_p=0.8 \sim 3\text{mm}$ (不锈钢)的广泛领域  
Available in wide range of application:  $a_p=0.8 \sim 5\text{mm}$ (steel),  
 $a_p=0.8 \sim 3\text{mm}$ (stainless steel)

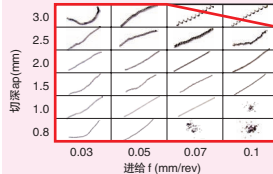


- 低断屑槽段差的低阻力设计  
Low cutting force design with small chipbreaker gap
- 延伸到前端的凸起设计保证小切深时的切屑处理  
Achieves chip control at low  $a_p$  with a dot that overhangs to the edge

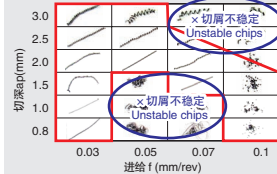
- 通过选用符合切深范围的最适宜断屑槽宽，可以在广泛的条件下实现切削可能  
Enables cutting over a wide range of conditions by using the optimum chipbreaker width according to the cutting depth

[ S45C  $V_c=100\text{m/min}$  湿式 Wet DCGT11T302型 type ]

GQ 断屑槽 GQ Chipbreaker

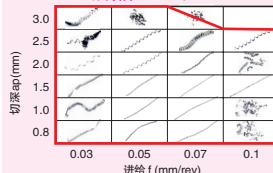


其他公司产品D Competitor D

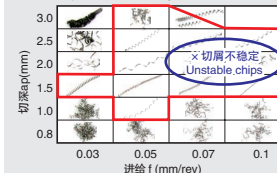


[ SUS304  $V_c=80\text{m/min}$  湿式 Wet DCGT11T302型 type ]

GQ 断屑槽 GQ Chipbreaker



其他公司产品E Competitor E



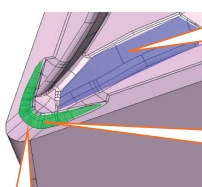
精加工用

**GF**  
断屑槽

For finishing

可对应切深  $a_p=0.25 \sim 1.25\text{mm}$

Applicable  $a_p$  range from 0.25 to 1.25mm



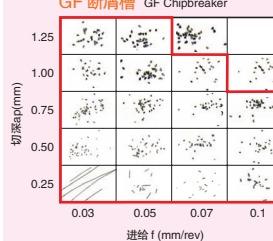
- 远离切刃棱线的高凸点  
⇒减轻大切深条件下切屑阻塞、烧灼  
High breaker dot apart from ridge line of cutting edge Good heat resistance and chip control in cutting of high  $a_p$

- 大前角，切削锋利度up  
Increased sharpness through the use of a large rake angle

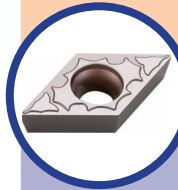
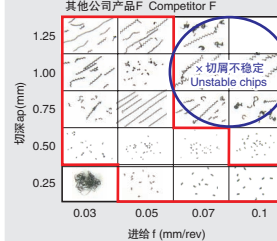
- 延伸到刀尖部、切刃棱线附近的凸点⇒小切深条件下细碎切断切屑  
Dot located close to ridge line of cutting edge on corner Chips fragmented in small pieces in cutting of small  $a_p$

[ S45C  $V_c=100\text{m/min}$  湿式 Wet DCGT11T302型 type ]

GF 断屑槽 GF Chipbreaker



其他公司产品F Competitor F



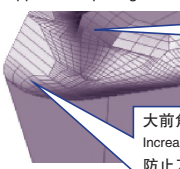
对应微小切深

**CF**  
断屑槽

Applicable to minute  $a_p$

可对应切深  $a_p=0.02 \sim 0.2\text{mm}$

Applicable  $a_p$  range from 0.02 to 0.2mm

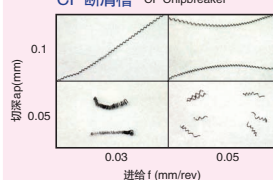


- 特殊凸点保证稳定的卷曲切屑  
Consistent curled chips through the use of special dots

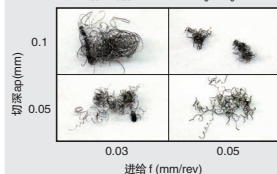
- 大前角，切削锋利度up  
Increase sharpness by large rake angle
- 防止刀片熔着、抑制工件毛刺、白浊面  
Prevents workpiece adhesion and reduces burrs

[ SUS304  $V_c=100\text{m/min}$  湿式 Wet CCGT030102型 type ]

CF 断屑槽 CF Chipbreaker



以往研磨断屑槽 G Conventional grinding breakerG



# 镜面锋利刀尖

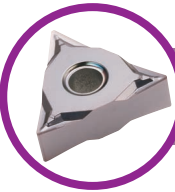
Polished face and sharp edge

负角型  
Double sided

# 自动车床用负角系列

最适合Φ16以上工件  
For workpiece diameter over 16mm

## Double Sided Tooling for Automatic Lathes



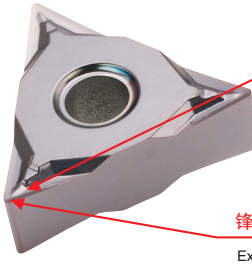
精加工 ~ 半精加工

### SK 断屑槽

For Finishing-Medium

兼顾锋利度与切屑处理的常用断屑槽  
SK chipbreaker for sharpness and better chip control

VNGG16型产品系列追加  
VNGG16 type is new available

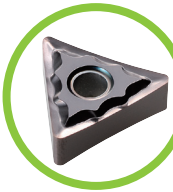


自动车床用断屑槽设计保证在广泛范围内切屑处理良好

Smooth chip control in wide application range due to special chipbreaker design for automatic lathe

锋利刀尖保证良好的锋利度

Excellent sharpness. Available from nose R 0.1



半精加工 ~ 粗加工用

### TK 断屑槽

For Medium-Roughing

低阻力设计的断屑槽可对应广泛加工条件  
Applicable to wide range of cutting conditions by low cutting force chipbreaker



镜面规格实现卓越的耐熔着性

Superior adhesion resistant polished surface

锋利刀尖保证良好的锋利度

Smooth cutting with sharp edge

无凸点断屑槽构造实现低阻力，可对应 1 ~ 5mm 的广泛切深

Low cutting resistant structure without dots on chipbreaker Available in a wide range of ap:1~5mm

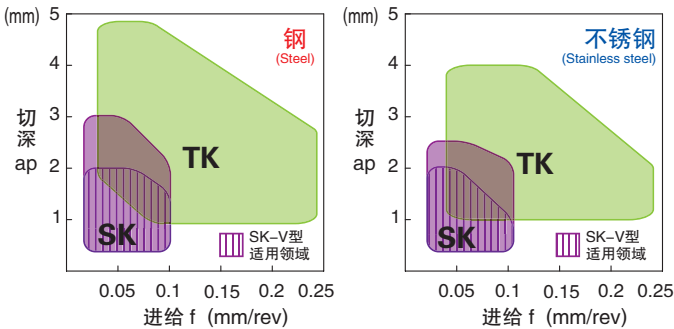
### 无偏头刀杆系列化 Without offset Holder



刀方  
16×20基础上  
20×20系列化

In addition to 16x20mm, 20x20mm square shanks are added to the lineup

### 断屑槽适用范围 Chipbreaker Application Map



### 适合材质图 Application range

• 钢 Steel

| 高速<br>High speed<br>[Vc=200m/min]   | PR1425                                                                              |                                                                                     |                                                                                     |
|-------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
| 中速<br>Medium speed<br>[Vc=150m/min] |                                                                                     |                                                                                     |                                                                                     |
| 低速<br>Low speed<br>[Vc=50m/min]     | PR930                                                                               |                                                                                     | PR1225                                                                              |
|                                     | 连续 Continuous                                                                       | 轻断续 Light interruption                                                              | 强断续 Heavy interruption                                                              |
|                                     |  |  |  |

第一推荐材质: PR1425 1st recommended grade

- 断续加工中实现高可靠性: PR1225 High reliability in interrupted cutting
- 低~中速领域的稳定加工: PR1225 Stable cutting at low to middle speed
- 低速领域的稳定加工: PR930 Stable cutting at low speed

• 不锈钢 Stainless steel

| 高速<br>High speed<br>[Vc=150m/min]   | PR1425                                                                              |                                                                                       |                                                                                       |
|-------------------------------------|-------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| 中速<br>Medium speed<br>[Vc=100m/min] |                                                                                     |                                                                                       |                                                                                       |
| 低速<br>Low speed<br>[Vc=50m/min]     | PR930                                                                               |                                                                                       | PR1225                                                                                |
|                                     | 连续 Continuous                                                                       | 轻断续 Light interruption                                                                | 强断续 Heavy interruption                                                                |
|                                     |  |  |  |

第一推荐材质: PR1225 1st recommended grade

- 高速领域的长寿命化: PR1425 Extended tool life in high speed cutting
- 低速领域的长寿命化: PR930 Extended tool life in low speed cutting

标准库存型号(正角)  
Stock Items(Positive)

| 形 状<br>Shape                      |                                                                                     | 型 号<br>Description                                | 尺寸(mm)<br>Dimension (mm) |                 |            |                                  |                       | 材质<br>Grades |        |
|-----------------------------------|-------------------------------------------------------------------------------------|---------------------------------------------------|--------------------------|-----------------|------------|----------------------------------|-----------------------|--------------|--------|
|                                   |                                                                                     |                                                   | 内接<br>圆径<br>I.C.         | 厚度<br>Thickness | 孔径<br>Hole | 刀尖角<br>R(r°)<br>Corner-<br>R(r°) | 后角<br>Relief<br>Angle |              |        |
| 无方向刀片显示为左手刀(L)<br>Left-hand shown |                                                                                     |                                                   |                          |                 |            |                                  |                       | PR1425       | PR1225 |
| 微小切深<br>Minute ap                 |    | CCGT 030101MP-CF<br>030102MP-CF                   | 3.5                      | 1.4             | 1.9        | <0.1<br><0.2                     | 7°                    | ●            | ●      |
|                                   |                                                                                     | CCGT 040101MP-CF<br>040102MP-CF                   | 4.3                      | 1.8             | 2.3        | <0.1<br><0.2                     |                       | ●            | ●      |
| 精加工<br>Finishing                  |    | CCGT 060201MFP-GF<br>060202MFP-GF<br>060204MFP-GF | 6.35                     | 2.38            | 2.8        | <0.1<br><0.2<br><0.4             | 7°                    | ●            | ●      |
|                                   |                                                                                     | CCGT 09T301MFP-GF<br>09T302MFP-GF<br>09T304MFP-GF | 9.525                    | 3.97            | 4.4        | <0.1<br><0.2<br><0.4             |                       | ●            | ●      |
| 精加工<br>Finishing                  |    | CCGT 060201MFP-SK<br>060202MFP-SK<br>060204MFP-SK | 6.35                     | 2.38            | 2.8        | <0.1<br><0.2<br><0.4             | 7°                    | ●            | ●      |
|                                   |                                                                                     | CCGT 09T301MFP-SK<br>09T302MFP-SK<br>09T304MFP-SK | 9.525                    | 3.97            | 4.4        | <0.1<br><0.2<br><0.4             |                       | ●            | ●      |
| 通用<br>General use                 |    | CCGT 060201MP-CK<br>060202MP-CK                   | 6.35                     | 2.38            | 2.8        | <0.1<br><0.2                     | 7°                    | ●            | ●      |
|                                   |                                                                                     | CCGT 09T301MP-CK<br>09T302MP-CK                   | 9.525                    | 3.97            | 4.4        | <0.1<br><0.2                     |                       | ●            | ●      |
| 精加工、半精加工<br>Finishing-Medium      |    | CCGT 060201MFP-GQ<br>060202MFP-GQ<br>060204MFP-GQ | 6.35                     | 2.38            | 2.8        | <0.1<br><0.2<br><0.4             | 7°                    | ●            | ●      |
|                                   |                                                                                     | CCGT 09T301MFP-GQ<br>09T302MFP-GQ<br>09T304MFP-GQ | 9.525                    | 3.97            | 4.4        | <0.1<br><0.2<br><0.4             |                       | ●            | ●      |
| 微小切深<br>Minute ap                 |    | DCGT 070201MP-CF<br>070202MP-CF                   | 6.35                     | 2.38            | 2.8        | <0.1<br><0.2                     | 7°                    | ●            | ●      |
|                                   |                                                                                     | DCGT 11T301MP-CF<br>11T302MP-CF                   | 9.525                    | 3.97            | 4.4        | <0.1<br><0.2                     |                       | ●            | ●      |
| 精加工<br>Finishing                  |  | DCGT 070201MFP-GF<br>070202MFP-GF<br>070204MFP-GF | 6.35                     | 2.38            | 2.8        | <0.1<br><0.2<br><0.4             | 7°                    | ●            | ●      |
|                                   |                                                                                     | DCGT 11T301MFP-GF<br>11T302MFP-GF<br>11T304MFP-GF | 9.525                    | 3.97            | 4.4        | <0.1<br><0.2<br><0.4             |                       | ●            | ●      |
| 精加工<br>Finishing                  |  | DCGT 070201MFP-SK<br>070202MFP-SK<br>070204MFP-SK | 6.35                     | 2.38            | 2.8        | <0.1<br><0.2<br><0.4             | 7°                    | ●            | ●      |
|                                   |                                                                                     | DCGT 11T301MFP-SK<br>11T302MFP-SK<br>11T304MFP-SK | 9.525                    | 3.97            | 4.4        | <0.1<br><0.2<br><0.4             |                       | ●            | ●      |

| 形 状<br>Shape                      |                                                                                     | 型 号<br>Description                                                  | 尺寸(mm)<br>Dimension (mm) |                 |            |                                  |                       | 材质<br>Grades |        |
|-----------------------------------|-------------------------------------------------------------------------------------|---------------------------------------------------------------------|--------------------------|-----------------|------------|----------------------------------|-----------------------|--------------|--------|
|                                   |                                                                                     |                                                                     | 内接<br>圆径<br>I.C.         | 厚度<br>Thickness | 孔径<br>Hole | 刀尖角<br>R(r°)<br>Corner-<br>R(r°) | 后角<br>Relief<br>Angle |              |        |
| 无方向刀片显示为左手刀(L)<br>Left-hand shown |                                                                                     |                                                                     |                          |                 |            |                                  |                       | PR1425       | PR1225 |
| 通用<br>General use                 |    | DCGT 070201MP-CK<br>070202MP-CK                                     | 6.35                     | 2.38            | 2.8        | <0.1<br><0.2                     | 7°                    | ●            | ●      |
|                                   |                                                                                     | DCGT 11T301MP-CK<br>11T302MP-CK                                     | 9.525                    | 3.97            | 4.4        | <0.1<br><0.2                     |                       | ●            | ●      |
| 精加工、半精加工<br>Finishing-Medium      |    | DCGT 070201MFP-GQ<br>070202MFP-GQ<br>070204MFP-GQ                   | 6.35                     | 2.38            | 2.8        | <0.1<br><0.2<br><0.4             | 7°                    | ●            | ●      |
|                                   |                                                                                     | DCGT 11T301MFP-GQ<br>11T302MFP-GQ<br>11T304MFP-GQ                   | 9.525                    | 3.97            | 4.4        | <0.1<br><0.2<br><0.4             |                       | ●            | ●      |
| 微小切深<br>Minute ap                 |    | TBGT 060101MP-CF<br><br>060102MP-CF                                 | 3.97                     | 1.59            | 2.3        | <0.1<br><0.2                     | 5°                    | ●            | ●      |
|                                   |                                                                                     |                                                                     |                          |                 |            |                                  |                       | ●            | ●      |
| 微小切深<br>Minute ap                 |    | TPGT 080201MP-CF<br>080202MP-CF                                     | 4.76                     | 2.38            | 2.3        | <0.1<br><0.2                     | 11°                   | ●            | ●      |
|                                   |                                                                                     | TPGT 090201MP-CF<br>090202MP-CF                                     | 5.56                     | 2.38            | 3.0        | <0.1<br><0.2                     |                       | ●            | ●      |
| 微小切深<br>Minute ap                 |    | VPGT 110301MP-CF<br><br>110302MP-CF                                 | 6.35                     | 3.18            | 2.8        | <0.1<br><0.2                     | 11°                   | ●            | ●      |
|                                   |                                                                                     |                                                                     |                          |                 |            |                                  |                       | ●            | ●      |
| 精加工<br>Finishing                  |    | VPGT 110301MFP-GF<br><br>110302MFP-GF                               | 6.35                     | 3.18            | 2.8        | <0.1<br><0.2                     | 11°                   | ●            | ●      |
|                                   |                                                                                     |                                                                     |                          |                 |            |                                  |                       | ●            | ●      |
| 通用<br>General use                 |  | VPGT 080201MP-CK<br>080202MP-CK                                     | 4.76                     | 2.38            | 2.3        | <0.1<br><0.2                     | 11°                   | ●            | ●      |
|                                   |                                                                                     | VPGT 110301MP-CK<br>110302MP-CK                                     | 6.35                     | 3.18            | 2.8        | <0.1<br><0.2                     |                       | ●            | ●      |
| 微小切深<br>Minute ap                 |  | WBGT 060101MP <sup>®</sup> /L-CF<br><br>060102MP <sup>®</sup> /L-CF | 3.97                     | 1.59            | 2.3        | <0.1<br><0.2                     | 5°                    | ●            | ●      |
|                                   |                                                                                     |                                                                     |                          |                 |            |                                  |                       | ●            | ●      |

· 刀尖角 R(r°) 用不等号(例: <0.05, <0.1, <0.2等)表示的刀片, 显示为负公差产品。  
An insert which corner R(r°) dimension is shown with inequality sign (Ex<0.05,<0.1,<0.2) indicates minus tolerance of corner R(r°).  
●: 标准库存 ●: Standard Stock  
R: 仅右手刀(R)库存 R: R-hand Only L: 仅左手刀(L)库存 L: L-hand Only

标准库存型号(负角)  
Stock Items(Double sided)

| 形 状<br>Shape                     |                                                                                     | 型 号<br>Description                    | 尺寸(mm)<br>Dimension (mm) |                 |            |                                  |  | 材质<br>Grades |        |
|----------------------------------|-------------------------------------------------------------------------------------|---------------------------------------|--------------------------|-----------------|------------|----------------------------------|--|--------------|--------|
|                                  |                                                                                     |                                       | 内接<br>圆径<br>I.C.         | 厚度<br>Thickness | 孔径<br>Hole | 刀尖角<br>R(r°)<br>Corner-<br>R(r°) |  |              |        |
| 带方向刀片为右手刀(R)<br>Right-hand shown |                                                                                     |                                       |                          |                 |            |                                  |  | PR1425       | PR1225 |
| 半精加工、粗加工<br>Medium-Roughing      |  | CNGG 120404FP-TK<br><br>120408FP-TK   | 12.70                    | 4.76            | 5.16       | 0.4<br>0.8                       |  | ●            | ●      |
|                                  |                                                                                     |                                       |                          |                 |            |                                  |  | ●            | ●      |
| 精加工、半精加工<br>Finishing-Medium     |  | DNGG 150404FP-TK<br><br>150408FP-TK   | 12.70                    | 4.76            | 5.16       | 0.4<br>0.8                       |  | ●            | ●      |
|                                  |                                                                                     |                                       |                          |                 |            |                                  |  | ●            | ●      |
| 精加工、半精加工<br>Finishing-Medium     |  | TNGG 160404FP-TK<br><br>160408FP-TK   | 9.525                    | 4.76            | 3.81       | 0.4<br>0.8                       |  | ●            | ●      |
|                                  |                                                                                     |                                       |                          |                 |            |                                  |  | ●            | ●      |
| 精加工、半精加工<br>Finishing-Medium     |  | CNGG 120402MFP-SK<br><br>120404MFP-SK | 12.70                    | 4.76            | 5.16       | <0.2<br><0.4                     |  | ●            | ●      |
|                                  |                                                                                     | DNGG 150402MFP-SK<br><br>150404MFP-SK | 12.70                    | 4.76            | 5.16       | <0.2<br><0.4                     |  | ●            | ●      |

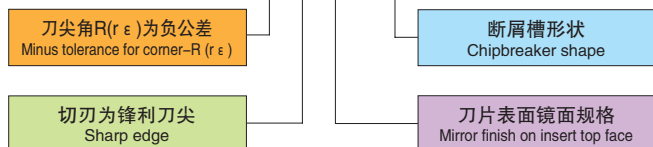
| 形 状<br>Shape                     |                                                                                     | 型 号<br>Description                                            | 尺寸(mm)<br>Dimension (mm) |                 |            |                                  |  | 材质<br>Grades |       |        |        |
|----------------------------------|-------------------------------------------------------------------------------------|---------------------------------------------------------------|--------------------------|-----------------|------------|----------------------------------|--|--------------|-------|--------|--------|
|                                  |                                                                                     |                                                               | 内接<br>圆径<br>I.C.         | 厚度<br>Thickness | 孔径<br>Hole | 刀尖角<br>R(r°)<br>Corner-<br>R(r°) |  |              |       |        |        |
| 带方向刀片为右手刀(R)<br>Right-hand shown |                                                                                     |                                                               |                          |                 |            |                                  |  | TN620        | PV720 | TN6010 | PV7010 |
| 精加工、半精加工<br>Finishing-Medium     |  | TNGG 160401MFP-SK<br><br>160402MFP-SK<br>160404MFP-SK         | 9.525                    | 4.76            | 3.81       | <0.1<br><0.2<br><0.4             |  | ●            | ●     | ●      | ●      |
|                                  |                                                                                     |                                                               |                          |                 |            |                                  |  | ●            | ●     | ●      | ●      |
| 精加工、半精加工<br>Finishing-Medium     |  | VNGG 160402MFP-SK<br><br>160404MFP-SK                         | 9.525                    | 4.76            | 3.81       | 0.2<br>0.4                       |  | ●            | ●     | ●      | ●      |
|                                  |                                                                                     |                                                               |                          |                 |            |                                  |  | ●            | ●     | ●      | ●      |
| 精加工、半精加工<br>Finishing-Medium     |  | VNGG 160402M-SK<br><br>160404M-SK                             | 9.525                    | 4.76            | 3.81       | 0.2<br>0.4                       |  | ●            | ●     | ●      | ●      |
|                                  |                                                                                     |                                                               |                          |                 |            |                                  |  | ●            | ●     | ●      | ●      |
| 精加工<br>Finishing                 |  | TNGG 160402 <sup>®</sup> /L-S<br><br>160404 <sup>®</sup> /L-S | 9.525                    | 4.76            | 3.81       | 0.2<br>0.4                       |  | ●            | ●     | ●      | ●      |
|                                  |                                                                                     | 160408 <sup>®</sup> /L-S                                      | 9.525                    | 4.76            | 3.81       | 0.8                              |  | ●            | ●     | ●      | ●      |

※ 金属陶瓷材质、TN620/PV720无锋利刀尖规格。(R珩磨规格)  
For cermet grades TN620/PV720, edge preparation is not sharp edge type. (R-honing type)

## 正角刀片表示例

Positive Insert Identification System

### CCGT060201 MF P-GF



## 刀尖角R(rε)为负公差的使用方法

Use of minus tolerance for corner-R(rε)

加工图纸中如图1所示

The actual corner-R of the workpiece may become larger than R0.2mm when machined by the insert whose corner-R(rε) is 0.2. In such case, insert with minus tolerance for corner-R(rε) is recommended.

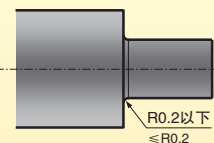


图1 加工图纸中的R角指示例  
Fig. 1 Corner-R on the drawing

## 与MEGACOAT组合实现长寿命

Long tool life in combination with MEGACOAT series

### 钢加工的第一推荐

First Choice for Steel Cutting

### MEGACOAT NANO PR1425

采用特殊纳米多涂层「MEGACOAT NANO」的采用保证钢加工在广泛领域实现出色的切削性能

Superior performance in various applications of steel cutting by Special Multilayer Nano Coating "MEGACOAT NANO"

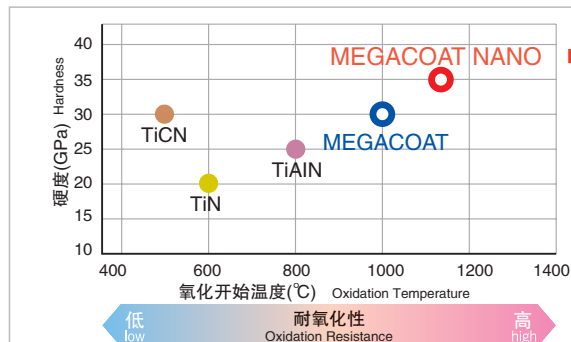
### 不锈钢加工的第一推荐

First Choice for Stainless Steel Cutting

### MEGACOAT PR1225

涂层密着性提高、独特的薄膜技术以及高表面平滑性，在不锈钢加工中发挥威力

Kyocera's unique Coating Technology for improved bonding force and surface smoothness enables excellent performance in stainless steel cutting.



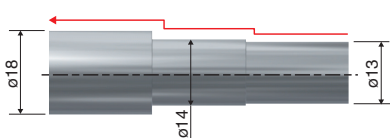
MEGACOAT NANO的高硬度(35GPa)、出色的耐氧化性(氧化开始温度: 1,150°C)可抑制磨损、提高抗崩刀性。  
MEGACOAT NANO prevents wear and fracture with high hardness (35GPa) and superior oxidation resistance (oxidation temperature: 1,150°C)

## 加工实例

Case studies

### SUJ2

- Vc=165 ~ 250m/min
- ap=0.3 ~ 1.3mm
- f=0.07mm/rev
- 湿式 Wet
- DCGT11T302MFP-SK



#### SK断屑槽 PR1425

200个/刀尖  
200pcs/edge

其他公司产品G  
(3维断屑槽、PVD涂层)  
Competitor G  
(Molded Chipbreaker / PVD Coated)

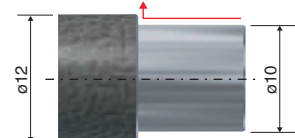
150个/刀尖  
150pcs/edge

即使切深变化也可进行出色的切屑处理。工具寿命提高1.3倍。  
Excellent chip control even at variable ap machining. Tool life extended by 30%.

(根据用户评价) Evaluation by the user

### (3维断屑槽、PVD涂层) Electromagnetic stainless steel

- Vc=180 ~ 210m/min
- ap=0.25 ~ 1.2mm
- f=0.025 ~ 0.05mm/rev
- 湿式 Wet
- DCGT11T302MFP-SK



#### SK断屑槽 PR1225

3,500个/刀尖  
3,500 pcs/edge

其他公司产品H  
(3维断屑槽、PVD涂层)  
Competitor H  
(Molded Chipbreaker / PVD Coated)

2,000个/刀尖  
2,000 pcs/edge

与其他公司相比切屑可有控制的排出。工具寿命提高1.75倍。  
Better chip control compared with the competitor. Tool life extended by 75%.

(根据用户评价) Evaluation by the user

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京瓷(中国)商贸有限公司

机械工具事业部  
上海市闸北区万荣路700号大宁中心广场A3幢140室(200072)  
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