

THE NEW VALUE FRONTIER

京瓷 创造新价值



CBN工具
CBN insert

KBN475

铸铁加工用 CBN工具

KBN475

CBN Insert for Cast Iron

对应灰口铸铁 (FC) 的高速加工

Suitable for high speed machining of gray cast iron

**耐磨损性良好保证
实现长寿命加工**

Long tool life with high wear resistance

ADVANCING PRODUCTIVITY

致力于生产效率提高的京瓷

KBN475

CBN Insert for Cast Iron

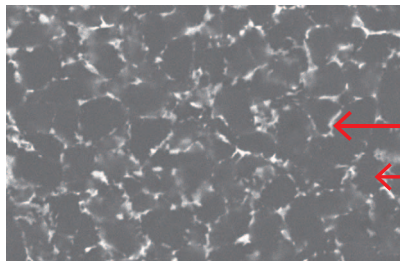


特点 Advantages

- 高CBN含量可抑制摩擦磨损，实现铸铁的稳定加工
High CBN content realized the abrasive wear reduction and stable machining of cast iron
- 特殊粘合剂，提高耐热性，抑制凹坑磨损
Special binder improves the heat resistance and prevents the crater wear
- 丰富的刃口规格实现系列化
Wide selection of edge preparation

高CBN含量提高耐磨损性

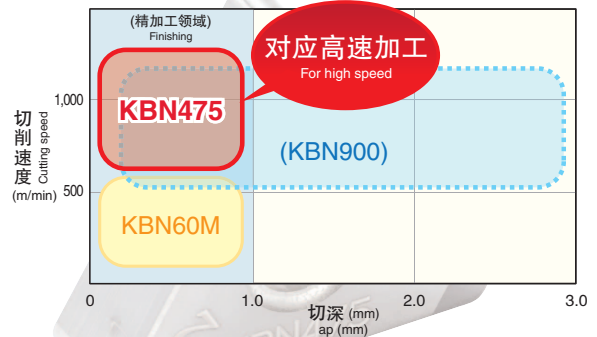
High CBN content improved the wear resistance



特殊粘合剂
Special binder
CBN粒径2 μ m
CBN grain dia.

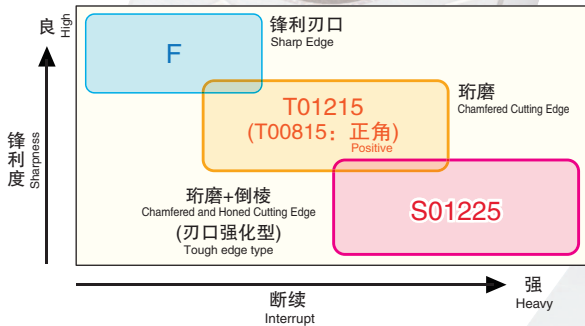
对应高速加工，实现高效率加工

High efficiency machining at high cutting speed



丰富的刃口规格对应多种加工

Wide selection of edge preparation for various applications

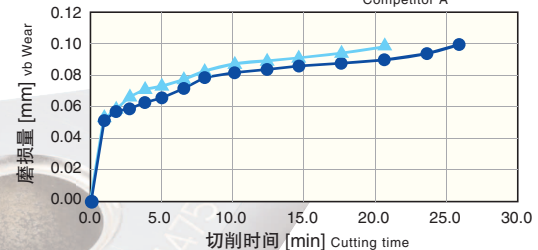


耐磨损性比较

Wear resistance comparison

● Vc=700m/min

—●— KBN475 —▲— 其他公司产品A(CBN) Competitor A



切削条件: FC250 ap=0.2mm f=0.2mm/rev Wet 端面加工(ϕ 196 \rightarrow ϕ 110) Facing
Cutting Conditions

加工案例 Case Studies

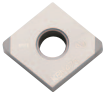

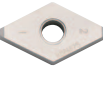




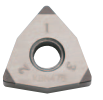
FC200		
<ul style="list-style-type: none"> 壳体 Housing Vc=270m/min ap=0.2mm f=0.05~0.1mm/rev 湿式 Wet DCMW11T304MEF(KBN475) 		
KBN475	70个/刀尖 pcs/c	
其他公司产品 B Competitor B	30个/刀尖 pcs/c	
<ul style="list-style-type: none"> KBN475与其他公司产品B相比，加工数量提高至2倍以上。 KBN475 shows 2 times longer tool life compared to Competitor B. 		
(根据用户评价) Evaluation by the user		

FC250		
<ul style="list-style-type: none"> 刹车盘 Brake disk Vc=230m/min ap=0.3mm f=0.2mm/rev 湿式 Wet CNGA120408T01215ME (KBN475) 		
KBN475	300个/刀尖 pcs/c	
其他公司产品 C Competitor C	300个/刀尖 pcs/c	
<ul style="list-style-type: none"> KBN475与其他公司产品C相比，刀尖状态良好。 KBN475 showed better edge condition against Competitor C. 		
KBN475	其他公司产品 C Competitor C	(根据用户评价) Evaluation by the user

刃口规格 Edge Prep.			
记号 Symbol	刃口状态 Cutting Edge Spec	记入例 Example	
F	锋利刃口 Sharp Edge	F	锋利刃口 Sharp Edge
T	珩磨 Chamfered Cutting Edge	T01215	0.12mm × 15°珩磨 Chamfered Cutting Edge
S	珩磨 + 倒棱 Chamfered and Honed Cutting Edge	S01225	0.12mm × 25°珩磨 + 倒棱 Chamfered and Honed Cutting Edge

(mm)				(mm)			
型号 Description	A	T	φd	型号 Description	A	T	φd
CNGA1204_	12.70	4.76	5.16	TNGA1604_	9.525	4.76	3.81
DNGA1504_	12.70	4.76	5.16	VNGA1604_	9.525	4.76	3.81
SNGA1204_	12.70	4.76	5.16	WNGA0804_	12.70	4.76	5.16

标准库存型号(负角) Stock Items (Negative)

形状 Shape	型号 Description	刃口规格 Edge Prep.	尺寸(mm) Dimension		使用刀尖数 No. of Edges	KBN475	形状 Shape	型号 Description	刃口规格 Edge Prep.	尺寸(mm) Dimension		使用刀尖数 No. of Edges	KBN475
			刀尖 圆弧R (rc) Corner-R (rc)	S						刀尖 圆弧R (rc) Corner-R (rc)	S		
 多锋利刀尖 Multi Edge / Sharp Edge	CNGA 120404MEF 120408MEF 120412MEF	F	0.4 0.8 1.2	2.6 2.6 2.5	2	● ● ●	 多锋利刀尖 Multi Edge / Sharp Edge	TNGA 160404MEF 160408MEF 160412MEF	F	0.4 0.8 1.2	2.7 2.4 2.1	3	● ● ●
	CNGA 120404S01225ME 120408S01225ME 120412S01225ME	S01225	0.4 0.8 1.2	2.6 2.6 2.5	2	● ● ●		TNGA 160404S01225ME 160408S01225ME 160412S01225ME	S01225	0.4 0.8 1.2	2.7 2.4 2.1	3	● ● ●
	CNGA 120404T01215ME 120408T01215ME 120412T01215ME	T01215	0.4 0.8 1.2	2.6 2.6 2.5	2	● ● ●		TNGA 160404T01215ME 160408T01215ME 160412T01215ME	T01215	0.4 0.8 1.2	2.7 2.4 2.1	3	● ● ●
 多锋利刀尖 Multi Edge / Sharp Edge	DNGA 150404MEF 150408MEF 150412MEF	F	0.4 0.8 1.2	2.6 2.2 1.9	2	● ● ●	 多锋利刀尖 Multi Edge / Sharp Edge	VNGA 160404MEF 160408MEF	F	0.4 0.8	2.0 1.8	2	● ●
	DNGA 150404S01225ME 150408S01225ME 150412S01225ME	S01225	0.4 0.8 1.2	2.6 2.2 1.9	2	● ● ●		VNGA 160404S01225ME 160408S01225ME	S01225	0.4 0.8	2.0 1.8	2	● ●
	DNGA 150404T01215ME 150408T01215ME 150412T01215ME	T01215	0.4 0.8 1.2	2.6 2.2 1.9	2	● ● ●		VNGA 160404T01215ME 160408T01215ME	T01215	0.4 0.8	2.0 1.8	2	● ●
 多锋利刀尖 Multi Edge / Sharp Edge	SNGA 120408MEF 120412MEF	F	0.8 1.2	1.8 2.2	2	● ●	 多锋利刀尖 Multi Edge / Sharp Edge	WNGA 080404MEF 080408MEF	F	0.4 0.8	2.0 2.6	3	● ●
	SNGA 120408S01225ME 120412S01225ME	S01225	0.8 1.2	1.8 1.8	2	● ●		WNGA 080404S01225ME 080408S01225ME	S01225	0.4 0.8	2.0 2.6	3	● ●
 多刀尖 Multi Edge	SNGA 120408T01215ME 120412T01215ME	T01215	0.8 1.2	1.8 1.8	2	● ●	 多刀尖 Multi Edge	WNGA 080404T01215ME 080408T01215ME	T01215	0.4 0.8	2.0 2.6	3	● ●

●: 标准库存
●: Standard Stock

刃口规格 Edge Prep.		
记号 Symbol	刃口状态 Cutting Edge Spec	记入例 Example
F	锋利刃口 Sharp Edge	F 锋利刃口 Sharp Edge
T	珩磨 Chamfered Cutting Edge	T00815 0.08mm × 15°珩磨 Chamfered Cutting Edge
S	珩磨 + 倒棱 Chamfered and Honed Cutting Edge	S01225 0.12mm × 25°珩磨 + 倒棱 Chamfered and Honed Cutting Edge

(mm)					(mm)				
型号 Description	A	T	φd	α	型号 Description	A	T	φd	α
CCMW0602_	6.35	2.38	2.8	7°	TPGB1103_	6.35	3.18	3.5	11°
CCMW09T3_	9.525	3.97	4.4	7°	TPGB1603_	9.525	3.18	4.5	11°
CPGB0802_	7.94	2.38	3.5	11°	VBGW1103_	6.35	3.18	2.8	5°
CPGB0903_	9.525	3.18	4.5	11°	VBGW1604_	9.525	4.76	4.4	5°
DCMW0702_	6.35	2.38	2.8	7°	VCGW0802_	4.76	2.38	2.3	7°
DCMW11T3_	9.525	3.97	4.4	7°					

标准库存型号(正角) Stock Items (Positive)

形状 Shape	型号 Description	刃口规格 Edge Prep.	尺寸(mm) Dimension		使用刀尖数 No. of Edges	KBN475
			刀尖圆弧半径 (r) Corner-R (r)	S		
多锋利刀尖 Multi Edge / Sharp Edge	CCMW 09T304MEF 09T308MEF	F	0.4 0.8	1.9 1.8	2	● ●
	CCMW 060204T00815ME 060208T00815ME	T00815	0.4 0.8	1.9 1.8	2	● ●
多刀尖 Multi Edge	CCMW 09T304T00815ME 09T308T00815ME	T00815	0.4 0.8	1.9 1.8	2	● ●
	CCMW 09T304S01225MES 09T308S01225MES	S01225	0.4 0.8	1.9 1.8	2	● ●
多刀尖 Multi Edge	CPGB 080204T00815ME 090308T00815ME	T00815	0.4 0.8	1.9 2.5	2	● ●
	DCMW 11T304MEF 11T308MEF	F	0.4 0.8	1.7 1.9	2	● ●
多刀尖 Multi Edge	DCMW 070202T00815ME 070204T00815ME	T00815	0.2 0.4	1.9 1.7	2	● ●
	DCMW 11T304T00815ME 11T308T00815ME	T00815	0.4 0.8	1.7 1.9	2	● ●
多刀尖·通用 Multi Edge / General purpose	DCMW 11T304S01225MES 11T308S01225MES	S01225	0.4 0.8	1.7 1.9	2	● ●

形状 Shape	型号 Description	刃口规格 Edge Prep.	尺寸(mm) Dimension		使用刀尖数 No. of Edges	KBN475
			刀尖圆弧半径 (r) Corner-R (r)	S		
多锋利刀尖 Multi Edge / Sharp Edge	TPGB 110304MEF 110308MEF	F	0.4 0.8	2.1 1.8	3	● ●
	TPGB 110302T00815ME 110304T00815ME 110308T00815ME	T00815	0.2 0.4 0.8	2.3 2.1 1.8	3	● ● ●
多刀尖 Multi Edge	TPGB 160304T00815ME 160308T00815ME	T00815	0.4 0.8	1.8 1.5	3	● ●
	TPGB 110304S01225MES 110308S01225MES	S01225	0.4 0.8	2.1 1.8	3	● ●
多锋利刀尖 Multi Edge / Sharp Edge	VBGW 110304MEF 110308MEF	F	0.4 0.8	2.0 1.7	2	● ●
	VBGW 160404MEF 160408MEF	F	0.4 0.8	2.0 1.7	2	● ●
多刀尖 Multi Edge	VBGW 110302T00815ME 110304T00815ME 110308T00815ME	T00815	0.2 0.4 0.8	2.4 2.0 1.7	2	● ● ●
	VBGW 160404T00815ME 160408T00815ME	T00815	0.4 0.8	2.0 1.7	2	● ●
多刀尖·通用 Multi Edge / General purpose	VBGW 110304S01225MES 110308S01225MES	S01225	0.4 0.8	2.0 1.7	2	● ●
	VBGW 160404S01225MES 160408S01225MES	S01225	0.4 0.8	2.0 1.7	2	● ●
多刀尖 Multi Edge	VCGW 080202T00815ME 080204T00815ME 080208T00815ME	T00815	0.2 0.4 0.8	2.0 2.0 1.7	2	● ● ●

●: 标准库存
●: Standard Stock

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