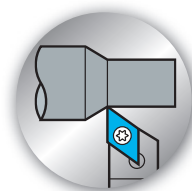


THE NEW VALUE FRONTIER



用于自动车床（梳形刃型刀具台） For Swiss tool automatic lathe (Gang edge tool post)

空间刀杆

Goose-neck Holder

- 粗加工时变细的部分无需回到导套即可加工

Available for machining after roughing without returning workpiece into guide bush

- 自动车床上实现多次走刀

Multiple passes can be possible at Swiss automatic lathe

- DC11型用外径刀杆

VP11型用外径刀杆

KTKF型车螺纹刀杆

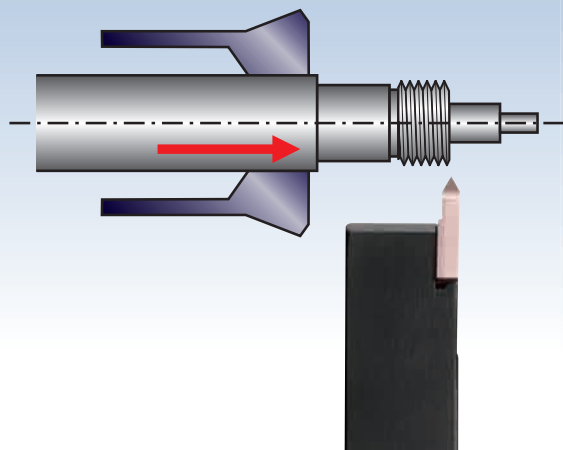
3类产品，阵容强大

3 types of toolholders available:

For DC11 type (external),

VP11 type (external) and

KTKF type (threading)



助您实现更高精度的加工

For higher precision machining

ADVANCING PRODUCTIVITY

致力于生产效率提高的京瓷

空间刀杆

Goose-neck Holder

■小型自动车床（导套方式）的加工方法

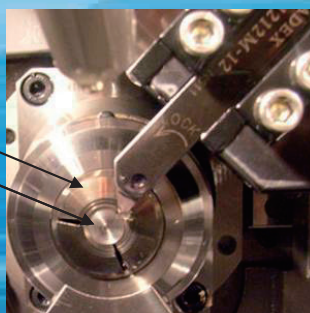
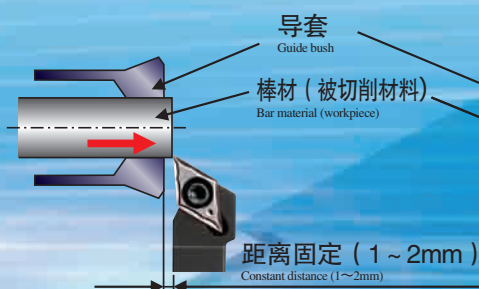
Swiss tool automatic lathe (guide bush system)

以工具无法纵向（Z轴方向）动作的自动车床为对象。

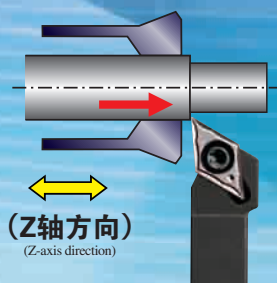
Goose-neck Holder is applicable to automatic lathe that toolholder does not move to longitudinal direction (Z-axis direction)

●使用以往刀杆时 In case of machining with the conventional toolholder

加工前 Before machining



加工中 During machining

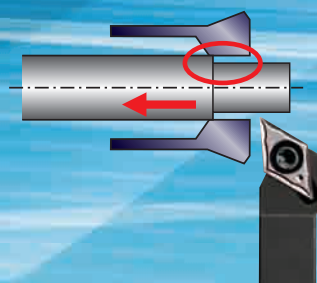


(X轴方向)
(X-axis direction)

刀杆的动作
Toolholder motion

工具的位置不变，依靠棒材（被切削材料）的移动进行加工

Tool position is fixed and bar material (workpiece) moves longitudinally



进行段加工等多次走刀的加工时，已加工的部分退入导套，发生各种问题。

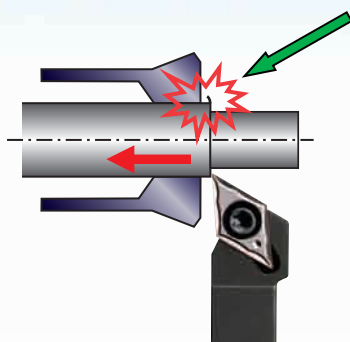
At step turning with multiple passes, machined part return into guide bush and causes various problems

●用以往刀杆进行多次走刀的加工时的问题点 Problems of machining with the conventional toolholder

<问题点 1> <Case 1>

进行多次走刀中，棒材退回导套方向时，毛刺与导套相碰，出现破损

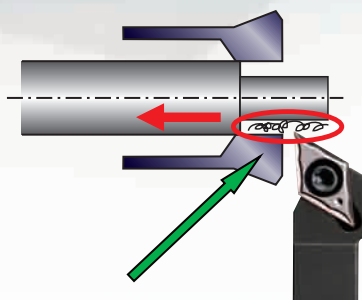
At multiple passes, when bar material returns into guide bush, burr contacts and breaks guide bush.



<问题点 2> <Case 2>

导套与材料的毛刺相互影响，出现尺寸参差不齐

Workpiece burr contacts guide bush and causes dimensional variation.



<问题点 3> <Case 3>
粗加工时的切屑进入导套之中

When roughing, chips come into guide bush.

■空间刀杆的优点 Advantages of Goose-neck Holder

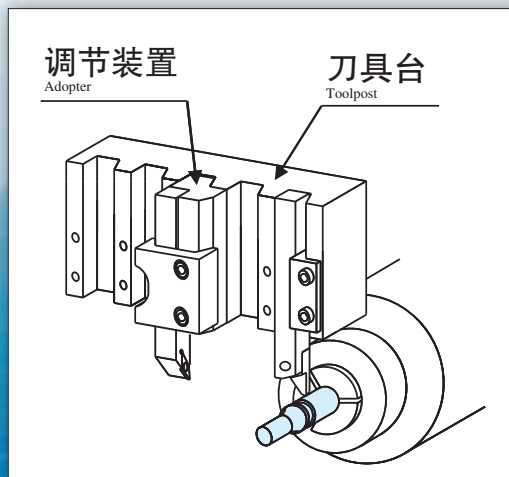
●安装时的优点 Advantages of Toolholder installation

使用调节装置时 With Adopter

要使用以往刀杆

When using the conventional toolholder,

- 1) 需要调节装置的安装空间
Additional space is required for adopter
- 2) 造成调节装置周围刀杆的操作性下降
Toolholder's handling is difficult due to limited space
- 3) 也需要另外购买调节装置
Necessary to buy adopter
- 4) 由于调节装置废除，还要注意与周围刀具台的相互影响
Adopter may interfere with the next toolpost

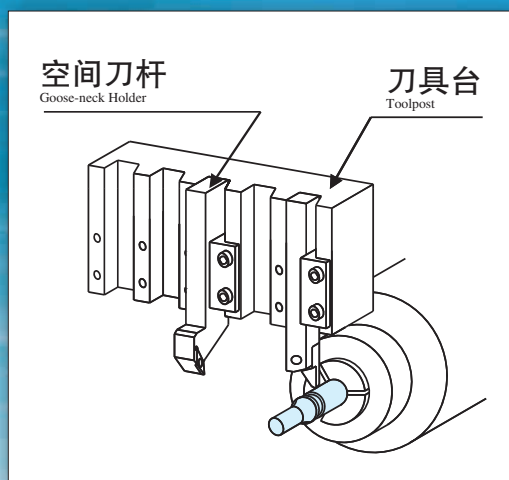


使用空间刀杆时 In case of Goose-neck Holder

如果是空间刀杆

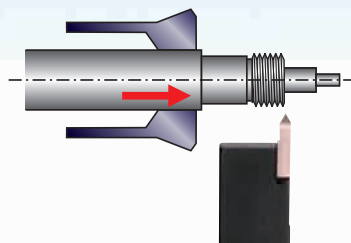
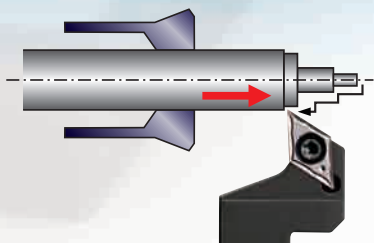
When using Goose-neck Holder

- 1) 不需要改变刀杆安装数量
Maximum number of toolholders can be attached
- 2) 不会与周围刀具台相互影响
No interference with next toolpost



●使用时的优点 Advantages of using Goose-neck Holder

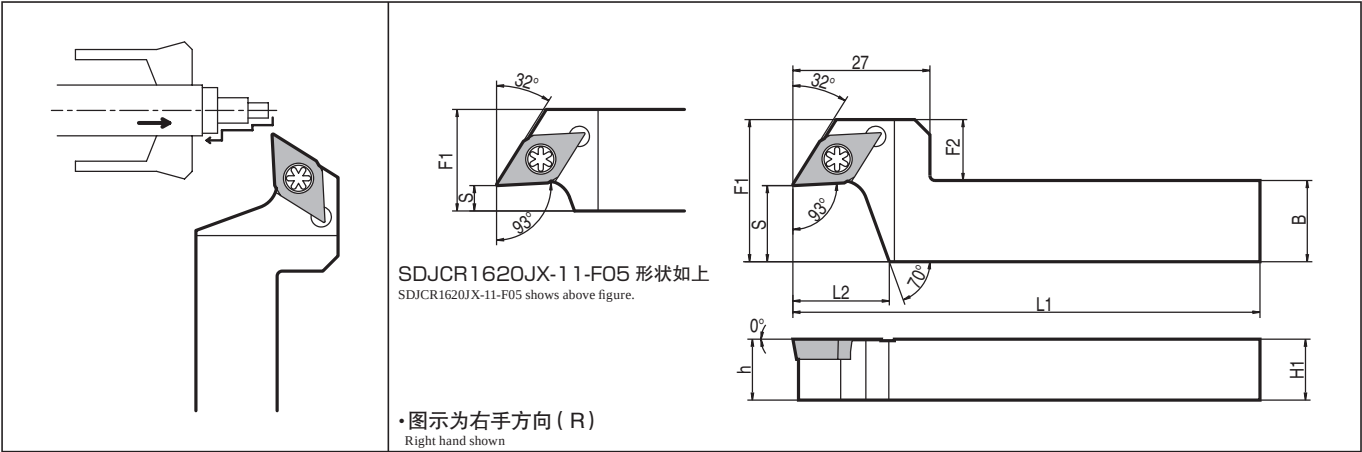
使用空间刀杆时 With Goose-neck Holder



- 1) 精加工走刀增加，零件精度提高! Machining precision improves by additional finishing process
- 2) 切屑不会进入“导套”之中 Chips do not come into guide bush
- 3) 保证大切屑排出“空间”! 切屑处理也轻松无比
Better chip control due to large chip evacuation space.

刀杆阵容 Tool Holder Lineup

SDJC型 SDJC

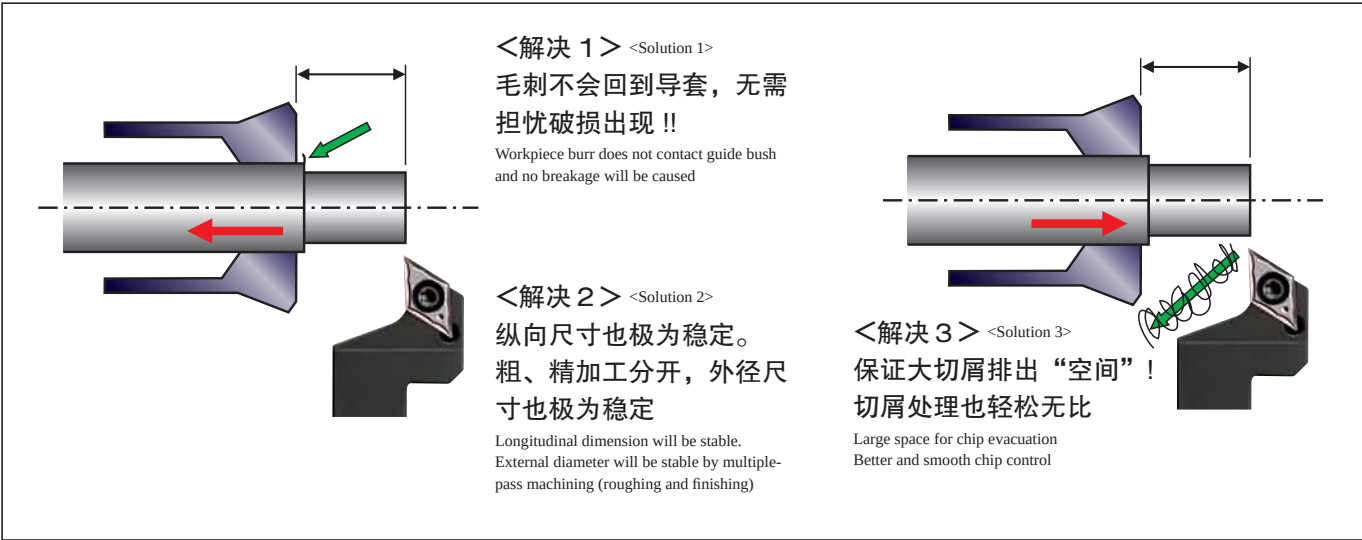


刀杆尺寸 Toolholder Dimensions

型号 Description	库存 Stock	尺寸(mm) Dimension (mm)							标准 刀尖角R (rε)	Std. Corner-R(rε)	零件 Spare Parts		适用刀片 Applicable Inserts
		H1=h	B	L1	L2	F1	F2	S			紧固螺钉 Clamp Screw	扳手 Wrench	
SDJCR 1216JX-11-F05	●	12	16	120	15.4	18	2	5	0.2	SB-4085TR	FT-15	DC..11..	
1216JX-11-F15	●				19	28	12	15					
1620JX-11-F05	●	16	20		15.4	20	-	5					
1620JX-11-F15	●				19	28	8	15					

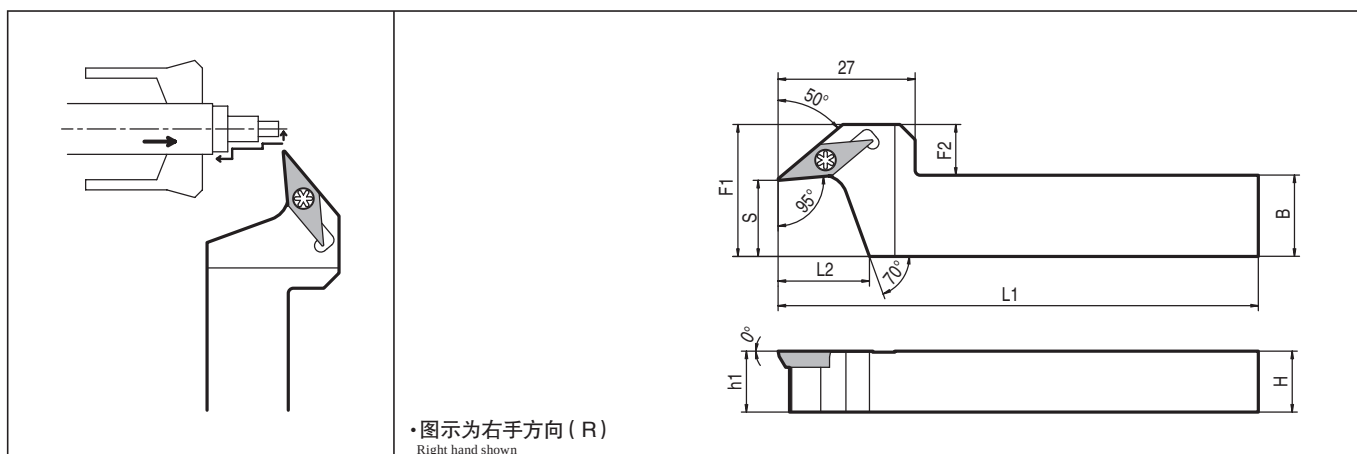
●:标准库存 ●:Standard Stock

空间刀杆可进行粗、精加工的多次走刀加工!!
Goose-neck Holder is available for multiple passes at roughing and finishing



刀杆阵容 Tool Holder Lineup

SVLP型 SVLP

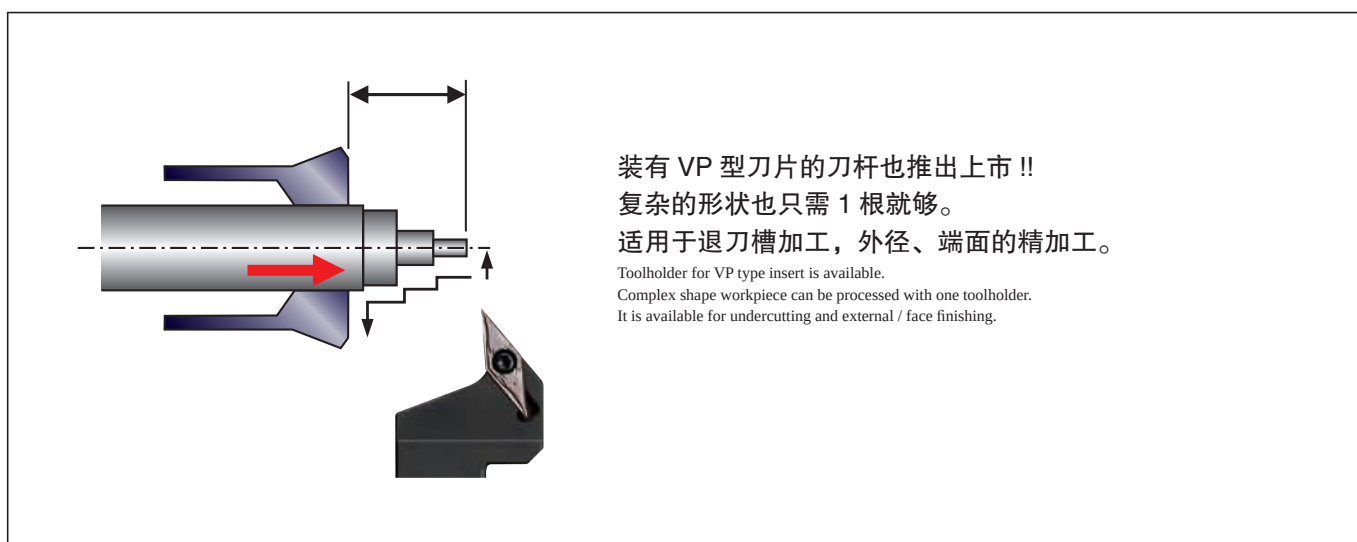


刀杆尺寸 Toolholder Dimensions

型号 Description	库存 Stock	尺寸 (mm) Dimension (mm)							标准 刀尖角 R (rε) Std. Corner-R (rε)	零件 Spare Parts		适用刀片 Applicable Inserts ➡ P5
		H1=h	B	L1	L2	F1	F2	S		紧固螺钉 Clamp Screw	扳手 Wrench	
SVLPR 1216JX-11-F15	●	12	16	120	18	26	10	15	0.2	SB-2570TR	FT-8	VP..11..
1620JX-11-F15	●	16	20				6					

●:标准库存 ●:Standard Stock

复杂形状的精加工也只需1根就够 One toolholder for complex shape workpiece



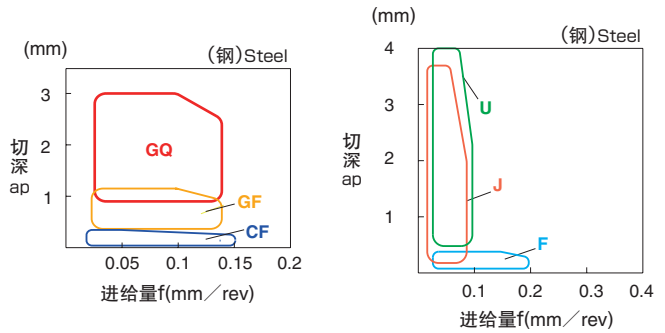
标准库存型号 (正角) Stock Items(Ptems(Ptems(Positive)

形状 Shape	型号 Description	尺寸(mm) Dimension(mm)					库存材料种类 Stock Grades
		内接圆径 I.C.	厚度 Thickness	孔径 Hole	刀尖角(rε) Corner-R(re)	后角 Relief Angle	
有方向的刀片图示为左手方向 (L) Left-hand shown							PR1225
微小切深 Minute ap	 DCGT 11T301MP-CF	9.525	3.97	4.4	<0.1	7°	●
	 11T302MP-CF				<0.2		
精加工 Finishing	 DCGT 11T301MFP-GF	9.525	3.97	4.4	<0.1	7°	●
	 11T302MFP-GF				<0.2		
	 11T304MFP-GF				<0.4		
精加工 Finishing	 DCGT 11T301MP-CK	9.525	3.97	4.4	<0.1	7°	●
	 11T302MP-CK				<0.2		
精加工-半精加工 Finishing-Medium	 DCGT 11T301MFP-GQ	9.525	3.97	4.4	<0.1	7°	●
	 11T302MFP-GQ				<0.2		
	 11T304MFP-GQ				<0.4		
半精切削 Medium cutting	 DCGT 11T3005MF	9.525	3.97	4.4	<0.05	7°	●
	 11T301MF				<0.1		
	 11T302MF				<0.2		
	 11T304MF				<0.4		
精加工 Finishing	 DCET 11T3005MF/L-FSF	9.525	3.97	4.4	<0.05	7°	●
	 11T301MF/L-FSF				<0.1		
	 11T302MF/L-FSF				<0.2		
	 11T304MF/L-FSF				<0.4		
精加工 Finishing	 DCGT 11T3005MF/L-F	9.525	3.97	4.4	<0.05	7°	●
	 11T301MF/L-F				<0.1		
	 11T302MF/L-F				<0.2		
	 11T304MF/L-F				<0.4		
小进给量 Low Feed	 DCET 11T3005MF/L-USF	9.525	3.97	4.4	<0.05	7°	●
	 11T301MF/L-USF				<0.1		
	 11T302MF/L-USF				<0.2		
小进给量 Low Feed	 DCGT 11T3005MF/L-U	9.525	3.97	4.4	<0.05	7°	●
	 11T301MF/L-U				<0.1		
	 11T302MF/L-U				<0.2		
	 11T304MF/L-U				<0.4		
小进给量 Low Feed	 DCET 11T3005MF/L-JSF	9.525	3.97	4.4	<0.05	7°	●
	 11T301MF/L-JSF				<0.1		
小进给量 Low Feed	 DCGT 11T3005MF/L-J	9.525	3.97	4.4	<0.05	7°	●
	 11T301MF/L-J				<0.1		
	 11T302MF/L-J				<0.2		
微小切深 Minute ap	 VPGT 110301MP-CF	6.35	3.18	2.8	<0.1	11°	●
	 110302MP-CF				<0.2		
精加工 Finishing	 VPGT 110301MFP-GF	6.35	3.18	2.8	<0.1	11°	●
	 110302MFP-GF				<0.2		
精加工 Finishing	 VPGT 110301MP-CK	6.35	3.18	2.8	<0.1	11°	●
	110302MP-CK				<0.2		

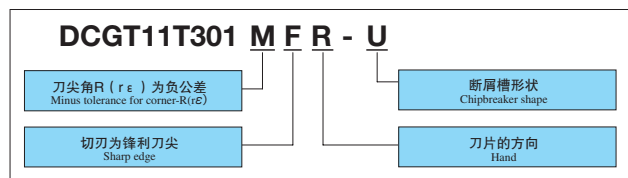
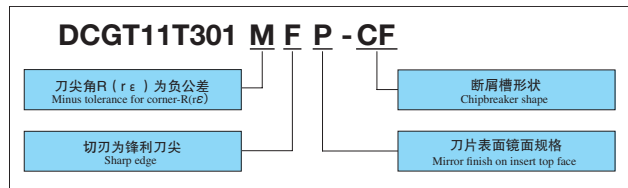
形状 Shape	型号 Description	尺寸(mm) Dimension(mm)					库存材料种类 Stock Grades
		内接圆径 I.C.	厚度 Thickness	孔径 Hole	刀尖角(rε) Corner-R(re)	后角 Relief Angle	
有方向的刀片图示为左手方向 (L) Left-hand shown							PR1225
精加工 Finishing	 VPET 1103005M/L-FSF	6.35	3.18	2.8	<0.05	11°	●
	 110301M/L-FSF				<0.1		
	 110302M/L-FSF				<0.2		
小进给量 Low Feed	 VPET 1103005M/L-USF	6.35	3.18	2.8	<0.05	11°	●
	 110301M/L-USF				<0.1		
	 110302M/L-USF				<0.2		

·刀尖角R(rε)用不等号(例: <0.05,<0.1,<0.2等)表示的刀片说明其刀尖角R(rε)为负公差。
An insert which corner R(re) dimension is shown with inequality sign (Ex:<0.05,<0.1,<0.2) indicates minus tolerance of corner R(re).

●: 标准库存 ●:Standard Stock



正角刀片示例 Positive Insert Identification System



◆刀尖角R(rε)为负公差的使用方法

Use of minus tolerance for corner-R(re)

加工图纸中,如图1所示,角部R已指示时如使用刀尖角R(rε)0.2mm的刀片,角部R有可能变大。
这种情况请使用刀尖角R(rε)为负公差的刀片。

The actual corner-R of the workpiece may become larger than R0.2mm when machined by the insert whose corner-R(re) is 0.2.

In such case, insert with minus tolerance for corner-R(re) is recommended.

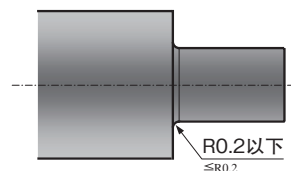
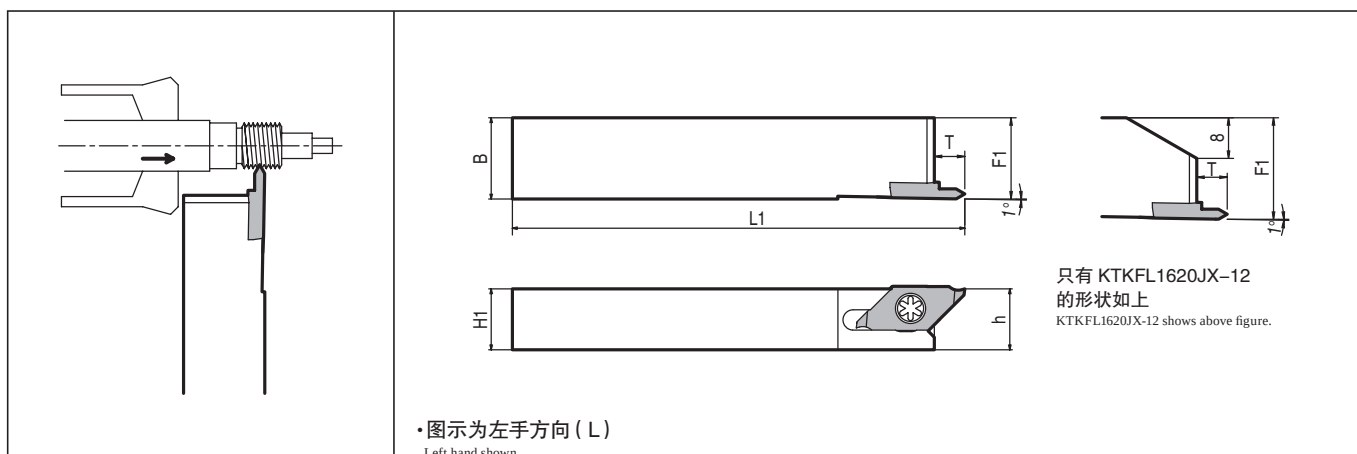


图1 加工图面中的角部R范例
Fig. 1 Corner-R on the drawing

刀杆阵容 Tool Holder Lineup

●KTKF型 KTKF



●刀杆尺寸 Toolholder Dimensions

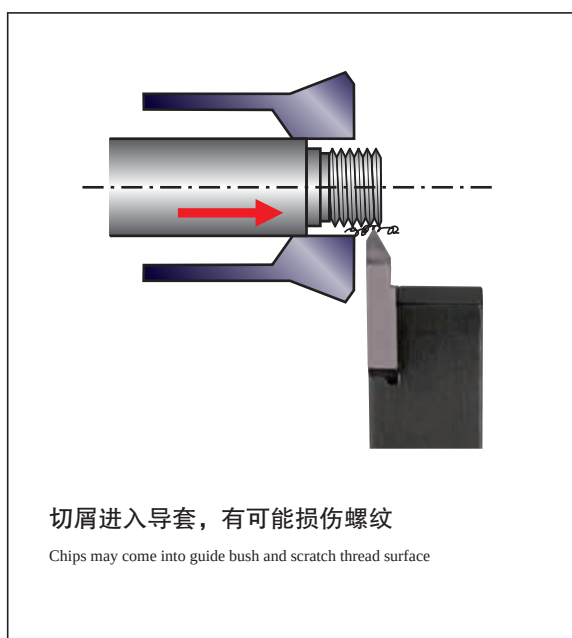
型号 Description	库存 Stock	尺寸 (mm) Dimension (mm)					零件 Spare Parts		适用刀片 Applicable Inserts ➡ P7
		H1=h	B	L1	F1	T	紧固螺钉 Clamp Screw	扳手 Wrench	
KTKFL 1216JX-12	●	12	16	120	16	6	SB-4590TRWN	LTW-10S	TKFT12L..
1620JX-12	●	16	20		20				

•T尺寸：表示从刀杆面到刀尖之间的距离。

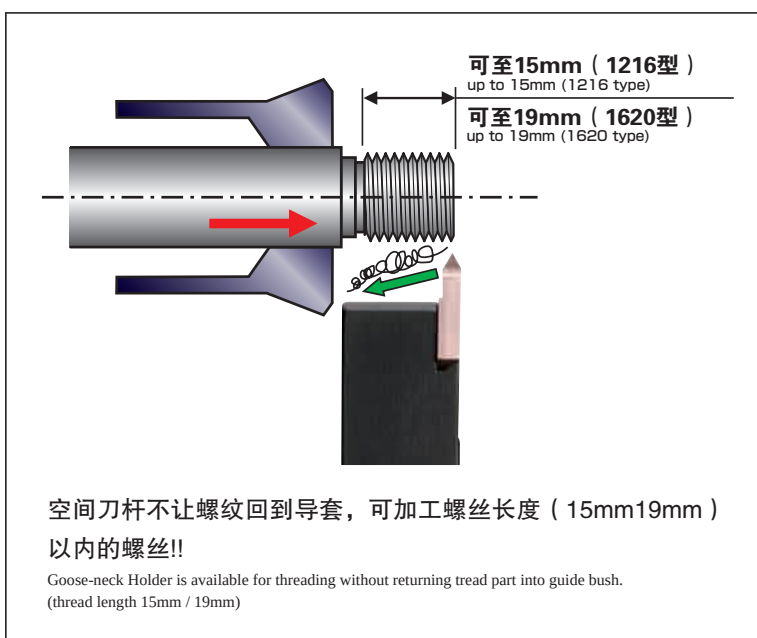
Dimension T shows the distance from the toolholder to the cutting edge.

●:标准库存 ●:Standard Stock

●使用以往车螺纹刀杆时 Conventional Treading Tool



●使用空间刀杆车螺纹刀杆时 Goose-neck Holder (for threading)



● 适用刀片 Applicable Insert

形状 Shape		型号 Description	适用 螺纹 Applicable Thread	间距 Pitch		尺寸 (mm) Dimension (mm)								角度 (°) Angle	库存材料种类 Stock Grades		适用刀杆 Applicable Toolholder
						PVD涂层 PVD Coated	超硬 Carbide										
				mm	螺纹/inch TPI	T	W	H	φd	R(r)	S1	S2	θ	PR1025	KW10		
无修光刃 No wiper edge		TKFT	12LA6000	M UN	0.2 ~ 0.6	64 ~ 48 牙	3.0	2.5	8.7	5.2	Max 0.05 フラット Flat	2.1	0.4	60°	●	●	KTKFL ...12
			12LB6000		0.5 ~ 1.25	48 ~ 24 牙					0.4	2.1	●		●		
			12LA6000S								1.7	0.8	●		●		
			12LB6000S								0.8	1.7	●		●		
		12LB6001	1 ~ 1.5	24 ~ 18 牙	0.1	1.25	1.25	●	●								
		12LA5500S	G,R W	-	40 ~ 16 牙	0.05	1.7	0.8	55°	●	●						
12LB5500S	0.8	1.7					●	●									

■ 刀片型号说明 (参照表- 1)
Insert Description (See Fig. 1)

TKFT 12 L A 60 00

刀片名称 Insert Name	刀片尺寸 Insert Size	刀尖位置 Edge position	刀尖 R (re) Corner-R (re)
刀片方向 Insert Hand		螺纹角度 Thread angle	
R : 右手方向 Right			
L : 左手方向 Left			

表 1 Fig.1
左手方向 (L) 刀片 Left hand (L) insert

A 型 A Type TKFT12LA..	B 型 B Type TKFT12LB..	N 型 N Type TKFT12LN..
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■ 使用空间刀杆的注意点 Precautions for using Goose-neck Holder

空间刀杆
When machining with Goose-neck Holder,

- 1) 比起以往刀杆，偏置尺寸设定得更大，因此比以往刀杆更容易与背面主轴相互影响，敬请注意。
Be careful of interference with back spindle because offset dimension is larger than the conventional toolholder.
- 2) 请注意次主轴前进时的相互影响。
⇒ 安装位置有限制。
Be careful of interference with sub spindle ⇒ Toolholder installation position is limited
- 3) 同时加工时 (平衡切和下道工序工具的方法时) 有可能与其他工具相互影响。
At simultaneous machining (balance cut and tool approach for next process), interference with other toolholder may occur.
- 4) 可能会出现 NC 设备的画面上指定刀杆形状的情况和 CAM 等无法应对的情况。
In some cases, such as specifying toolholder shape on NC display or using CAM, Goose-neck Holder can not be drawn perfectly.

切削工具相关咨询

400-650-6400-5

● 受理时间 8:45~11:45・12:45~17:30
● 周六、日以及法定节假日期间不受理业务。

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