

刀片
增加

铸铁车削用CVD涂层材料
超级涂层硬质合金

UC5105/UC5115

新型平滑涂层技术确保最稳定的切削。

耐磨损性、耐破损性优异的性能卓越的铸铁车削用材料登场

●可加工钢的UC5115

带断屑槽刀片登场



车削铸铁用CVD涂层材料

超级涂层硬质合金

UC5105/UC5115

UC5105/UC5115 的特点

在加工铸铁方面极为有效

新开发的“全黑超平滑涂层”

提高耐磨损性能

与以往的材料相比，厚而精细的Al₂O₃层和微粒纤维状TiCN涂层，显著提高了耐磨损性能。

提高耐崩刃性能

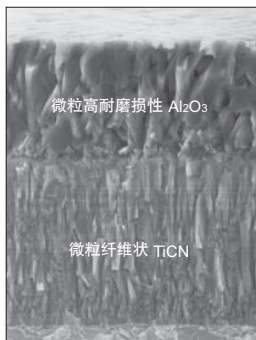
比其他公司涂层表面平滑，大幅度提高了耐粘结性能。不易发生粘结崩刃等异常损伤，能够长时间进行稳定的切削。

UC5105

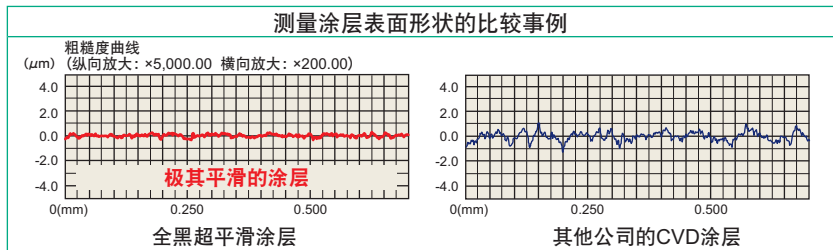
该材料由高硬度硬质合金基体和全黑超平滑涂层组成。对高速车削铸铁和球墨铸铁极为有效。

UC5115

该材料由强韧的硬质合金基体和全黑超平滑涂层组成。是车削铸铁和球墨铸铁的第一推荐材料。



UC5105/UC5115 涂层结构



适用范围和推荐切削条件

TOOL NAVI系统

UC5105是注重耐磨损性能的车削铸铁用材料。

UC5115是兼顾耐磨损和耐破损性能的车削铸铁用材料。并且在钢的高速连续加工中也能发挥出优异的耐磨损性能。

K系列(铸铁)用M级负角刀片的最佳材料、断屑槽



加工状态

● 稳定切削

连续切削
加工余量固定的切削
非黑皮切削
工件夹紧刚性高的切削

● 普通切削

⊕ 不稳定切削

激烈的断续切削
加工余量变化大的切削
工件夹紧刚性低的切削

切削范围

S 轻切削领域

(ap=0.5—1.5mm)

G 准重切削领域 (ap=4.0—7.0mm)

M 中切削领域

(ap=1.5—4.0mm)

适用范围


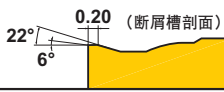

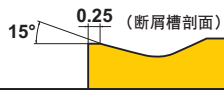

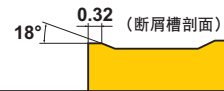
ISO 使用分类代号	适用范围
K01	UC5105
K10	UC5105
K20	UC5105
K30	UC5105







推荐切削条件

工件材料	抗拉强度	切削速度 (m/min)	
		UC5105	UC5115
K 灰口铸铁	≤300MPa	300 (200—400)	250 (150—300)
	≤450MPa	300 (200—400)	250 (150—300)
P 球墨铸铁	500—800MPa	230 (180—300)	200 (150—250)
	硬度 HB180—280	—	300 (220—370)


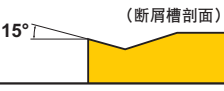

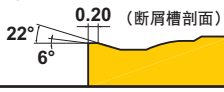
UC5115 断屑槽种类


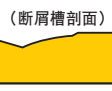

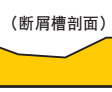
铸铁车削用断屑槽

用途	断屑槽	特点
轻切削用	MA 	正棱边刃形, 切削锋利性高。  (断屑槽剖面) 22° 6°
中切削用	全周 	扁平棱边刃形, 切削刃强度高。  (断屑槽剖面) 15°
准重切削用	GH 	适于断续切削、黑皮切削。 宽棱边与大容量屑槽组合, 实现高进给量加工。  (断屑槽剖面) 18°

用途	断屑槽	特点
准重切削用	平顶 	刀刃强度高、刀片落位稳定, 最适于断续切削等不稳定切削。  (断屑槽剖面) 0°
高效率轻切削用	SW 	带修光刃, 可在轻切削领域内进行高进给加工。  (断屑槽剖面) 18° 7°
高效率中切削用	MW 	带修光刃, 可在通用切削领域内进行高进给加工。  (断屑槽剖面) 19°

钢车削用断屑槽

用途	断屑槽	特点
轻切削用	SH 	正棱边刃形, 切削锋利性高。 在轻切削领域内, 切屑处理性良好。  (断屑槽剖面) 15°
中切削用	MA 	正棱边刃形, 切削锋利性高。 在通用切削领域内, 切屑处理性良好。  (断屑槽剖面) 22° 6°

用途	断屑槽	特点
中切削用	MH 	扁平棱边刃形, 切削刃强度高。 在通用切削领域内, 切屑处理性良好。  (断屑槽剖面) 16°
中切削用	MV 	正棱边刃形, 切削锋利性高。 适合仿形、提拉加工的断屑槽形状。 在通用切削领域内, 切屑处理性良好。  (断屑槽剖面) 30° 11°

UC5105/UC5115的切削性能

耐磨损性能

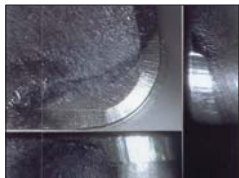
高速连续车削灰口铸铁 (FC300)
(vc = 600m/min)

UC5105 显示了超群的耐磨损性能, 能够与陶瓷材料媲美!!

< 切削条件 >

刀片: CNMA120408
刀具: PCLNL2525M12
切削速度: 600m/min
每转进给量: 0.3mm/rev
切削深度: 1.5mm
切削液: 干式
连续车削外圆

切削时间=2 min



A公司陶瓷材料

切削时间=5 min

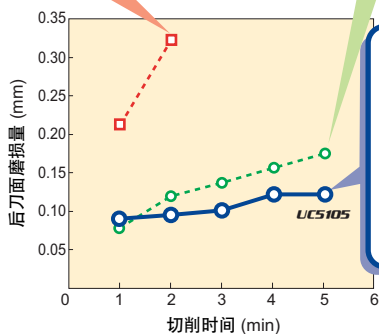


B公司陶瓷材料

切削时间=5 min



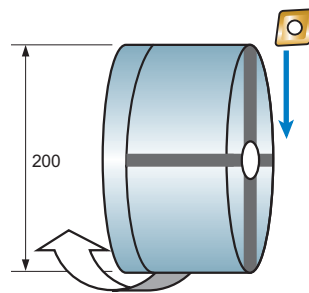
UC5105



耐破损性能

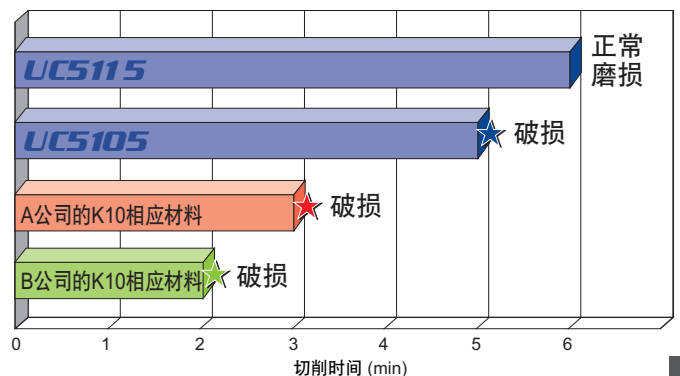
球墨铸铁的断续端面车削 (FCD450)

UC5115 显示了超群的耐崩刃性, 实现极为稳定的切削刃可靠性!!



< 切削条件 >


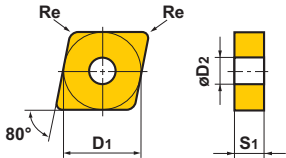

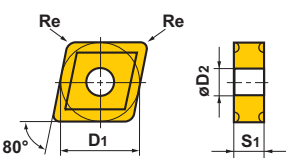

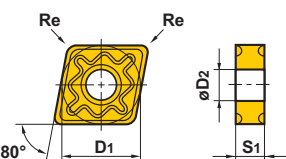

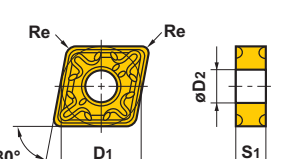

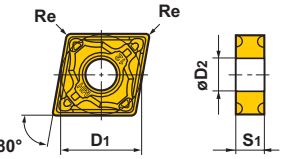

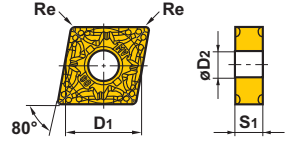
刀片: CNMA120408
刀具: PCLNL2525M12
切削速度: 120m/min
每转进给量: 0.3mm/rev
切削深度: 1.5mm
切削液: 湿式


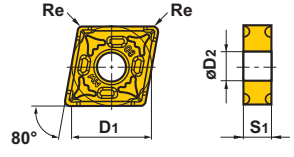

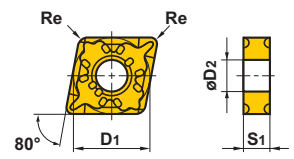

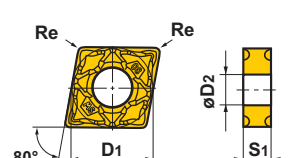

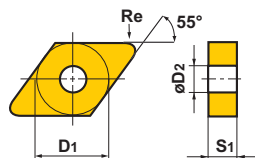

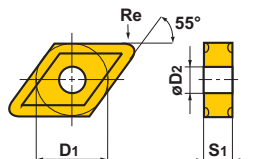

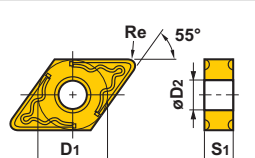

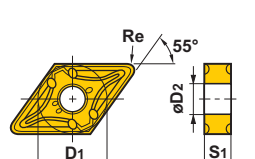

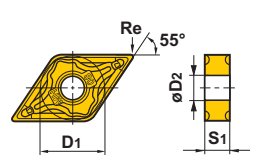


超级涂层硬质合金 UC5105/UC5115

刀片规格

●负角刀片(带孔)


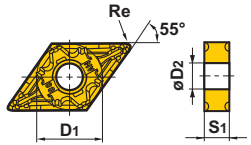

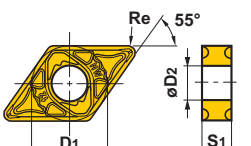

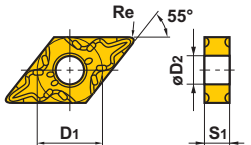

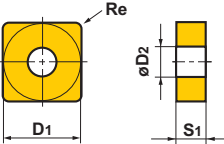

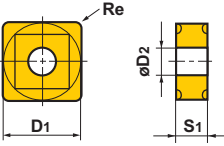

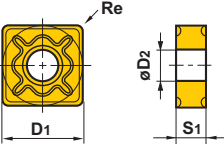

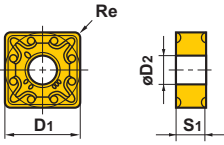

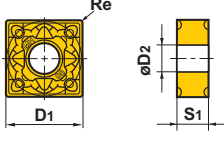
刀片外形	型号	库存		尺寸(mm)				形状
		UC5105	UC5115	D1	S1	Re	D2	
 无断屑槽	CNMA 120404	●	●	12.7	4.76	0.4	5.16	
	120408	●	●	12.7	4.76	0.8	5.16	
	120412	●	●	12.7	4.76	1.2	5.16	
	120416	●	●	12.7	4.76	1.6	5.16	
	160612	●	●	15.875	6.35	1.2	6.35	
	160616	●	●	15.875	6.35	1.6	6.35	
	190612	●	●	19.05	6.35	1.2	7.93	
	190616	●	●	19.05	6.35	1.6	7.93	
 全周断屑槽	CNMG 120404	●	●	12.7	4.76	0.4	5.16	
	120408	●	●	12.7	4.76	0.8	5.16	
	120412	●	●	12.7	4.76	1.2	5.16	
	120416	●	●	12.7	4.76	1.6	5.16	
	160612	●	●	15.875	6.35	1.2	6.35	
	160616	●	●	15.875	6.35	1.6	6.35	
	190612	●	●	19.05	6.35	1.2	7.93	
	190616	●	●	19.05	6.35	1.6	7.93	
 GH断屑槽	CNMG 120408-GH	●	●	12.7	4.76	0.8	5.16	
	120412-GH	●	●	12.7	4.76	1.2	5.16	
	120416-GH	●	●	12.7	4.76	1.6	5.16	
	160612-GH	●	●	15.875	6.35	1.2	6.35	
	160616-GH	●	●	15.875	6.35	1.6	6.35	
	190612-GH	●	●	19.05	6.35	1.2	7.93	
准重切削	190616-GH	●	●	19.05	6.35	1.6	7.93	
 MA断屑槽	CNMG 120404-MA	●	●	12.7	4.76	0.4	5.16	
	120408-MA	●	●	12.7	4.76	0.8	5.16	
	120412-MA	●	●	12.7	4.76	1.2	5.16	
	120416-MA	●	●	12.7	4.76	1.6	5.16	
	160608-MA		□	15.875	6.35	0.8	6.35	
	160612-MA	●	●	15.875	6.35	1.2	6.35	
	160616-MA	●	●	15.875	6.35	1.6	6.35	
	190612-MA	●	●	19.05	6.35	1.2	7.93	
中切削	190616-MA	●	●	19.05	6.35	1.6	7.93	
 MH断屑槽	NEW CNMG120404-MH		●	12.7	4.76	0.4	5.16	
	NEW 120408-MH		●	12.7	4.76	0.8	5.16	
	NEW 120412-MH		●	12.7	4.76	1.2	5.16	
	NEW 120416-MH		●	12.7	4.76	1.6	5.16	
	NEW 160608-MH		●	15.875	6.35	0.8	6.35	
	NEW 160612-MH		●	15.875	6.35	1.2	6.35	
	NEW 160616-MH		●	15.875	6.35	1.6	6.35	
	NEW 190612-MH		●	19.05	6.35	1.2	7.93	
	中切削	NEW 190616-MH		●	19.05	6.35	1.6	
 MV断屑槽	NEW CNMG120404-MV		□	12.7	4.76	0.4	5.16	
	NEW 120408-MV		□	12.7	4.76	0.8	5.16	
	NEW 120412-MV		□	12.7	4.76	1.2	5.16	
	NEW 120416-MV		□	12.7	4.76	1.6	5.16	
	中切削							

刀片外形	型 号	库存		尺寸(mm)				形 状
		UC5105	UC5115	D1	S1	Re	D2	
MW 断屑槽  中切削 (修光刃)	CNMG120408-MW	●	●	12.7	4.76	0.8	5.16	
	120412-MW	●	●	12.7	4.76	1.2	5.16	
SH 断屑槽  轻切削	CNMG120404-SH		□	12.7	4.76	0.4	5.16	
	120408-SH		□	12.7	4.76	0.8	5.16	
	120412-SH		□	12.7	4.76	1.2	5.16	
SW 断屑槽  轻切削 (修光刃)	CNMG120404-SW		●	12.7	4.76	0.4	5.16	
	120408-SW		●	12.7	4.76	0.8	5.16	
无断屑槽 	DNMA150404	●	●	12.7	4.76	0.4	5.16	
	150408	●	●	12.7	4.76	0.8	5.16	
	150412	●	●	12.7	4.76	1.2	5.16	
	150416	□	□	12.7	4.76	1.6	5.16	
	150608	●	●	12.7	6.35	0.8	5.16	
	150612	●	●	12.7	6.35	1.2	5.16	
全周 断屑槽  中切削	DNMG150404	●	●	12.7	4.76	0.4	5.16	
	150408	●	●	12.7	4.76	0.8	5.16	
	150412	●	●	12.7	4.76	1.2	5.16	
	150604	□	□	12.7	6.35	0.4	5.16	
	150608	●	●	12.7	6.35	0.8	5.16	
	150612	●	●	12.7	6.35	1.2	5.16	
GH 断屑槽  准重切削	DNMG150408-GH	●	●	12.7	4.76	0.8	5.16	
	150412-GH	●	●	12.7	4.76	1.2	5.16	
	150608-GH	●	●	12.7	6.35	0.8	5.16	
	150612-GH	●	●	12.7	6.35	1.2	5.16	
MA 断屑槽  中切削	DNMG150404-MA	●	●	12.7	4.76	0.4	5.16	
	150408-MA	●	●	12.7	4.76	0.8	5.16	
	150412-MA	●	●	12.7	4.76	1.2	5.16	
	150608-MA	●	●	12.7	6.35	0.8	5.16	
	150612-MA	●	●	12.7	6.35	1.2	5.16	
MH 断屑槽  中切削	DNMG150404-MH		●	12.7	4.76	0.4	5.16	
	150408-MH		●	12.7	4.76	0.8	5.16	
	150412-MH		●	12.7	4.76	1.2	5.16	
	150604-MH		●	12.7	6.35	0.4	5.16	
	150608-MH		●	12.7	6.35	0.8	5.16	
	150612-MH		●	12.7	6.35	1.2	5.16	


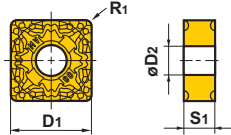

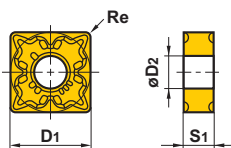

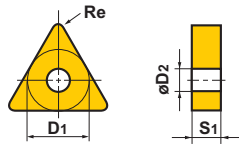

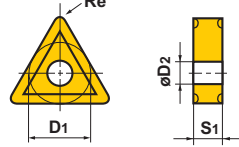

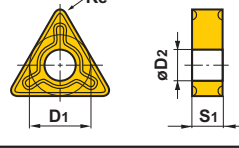

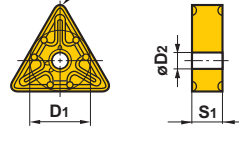

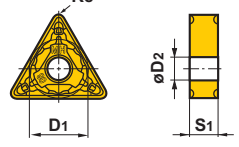

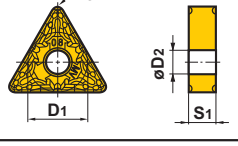
超级涂层硬质合金 UC5105/UC5115

刀片规格

●负角刀片(带孔)

刀片外形	型号	库存		尺寸(mm)				形状
		UC5105	UC5115	D1	S1	Re	D2	
MV 断屑槽  中切削	NEW DNMG150404-MV		□	12.7	4.76	0.4	5.16	
	NEW 150408-MV		□	12.7	4.76	0.8	5.16	
	NEW 150412-MV		□	12.7	4.76	1.2	5.16	
	NEW 150416-MV		□	12.7	4.76	1.6	5.16	
	NEW 150604-MV		□	12.7	6.35	0.4	5.16	
	NEW 150608-MV		□	12.7	6.35	0.8	5.16	
	NEW 150612-MV		□	12.7	6.35	1.2	5.16	
	NEW 150616-MV		□	12.7	6.35	1.6	5.16	
MW 断屑槽  中切削 (修光刃)	DNMX150408-MW	□	□	12.7	4.76	0.8	5.16	
	150412-MW	□	□	12.7	4.76	1.2	5.16	
	150608-MW	□	□	12.7	6.35	0.8	5.16	
	150612-MW	□	□	12.7	6.35	1.2	5.16	
SH 断屑槽  轻切削	NEW DNMG150404-SH		□	12.7	4.76	0.4	5.16	
	NEW 150408-SH		□	12.7	4.76	0.8	5.16	
	NEW 150412-SH		□	12.7	4.76	1.2	5.16	
	NEW 150604-SH		□	12.7	6.35	0.4	5.16	
	NEW 150608-SH		□	12.7	6.35	0.8	5.16	
	NEW 150612-SH		□	12.7	6.35	1.2	5.16	
无断屑槽 	SNMA090308	●	●	9.525	3.18	0.8	3.81	
	120408	●	●	12.7	4.76	0.8	5.16	
	120412	●	●	12.7	4.76	1.2	5.16	
	120416	●	●	12.7	4.76	1.6	5.16	
	190612	●	●	19.05	6.35	1.2	7.93	
	190616	●	●	19.05	6.35	1.6	7.93	
全周 断屑槽  中切削	SNMG120408	●	●	12.7	4.76	0.8	5.16	
	120412	●	●	12.7	4.76	1.2	5.16	
	120416	●	●	12.7	4.76	1.6	5.16	
	150612	□	□	15.875	6.35	1.2	6.35	
	190612	●	●	19.05	6.35	1.2	7.93	
	190616	●	●	19.05	6.35	1.6	7.93	
GH 断屑槽  准重切削	SNMG120408-GH	●	●	12.7	4.76	0.8	5.16	
	120412-GH	●	●	12.7	4.76	1.2	5.16	
MA 断屑槽  中切削	NEW SNMG120404-MA		□	12.7	4.76	0.4	5.16	
	120408-MA	●	●	12.7	4.76	0.8	5.16	
	120412-MA	●	●	12.7	4.76	1.2	5.16	
	120416-MA	●	●	12.7	4.76	1.6	5.16	
	150612-MA	□	□	15.875	6.35	1.2	6.35	
	190612-MA	●	●	19.05	6.35	1.2	7.93	
MH 断屑槽  中切削	NEW SNMG120404-MH		●	12.7	4.76	0.4	5.16	
	NEW 120408-MH		●	12.7	4.76	0.8	5.16	
	NEW 120412-MH		●	12.7	4.76	1.2	5.16	
	NEW 190612-MH		●	19.05	6.35	1.2	7.93	
	NEW 190616-MH		●	19.05	6.35	1.6	7.93	


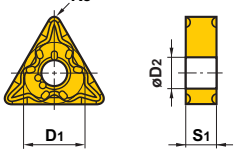

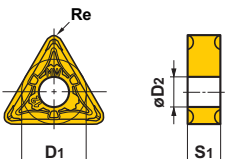

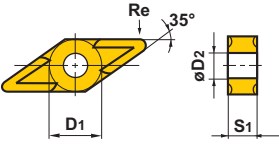

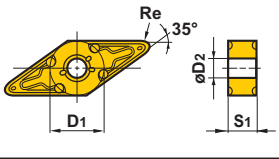

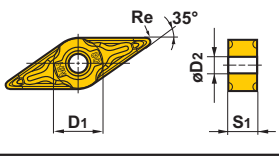

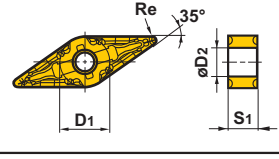

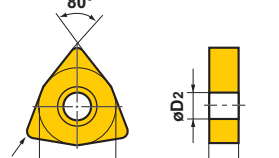

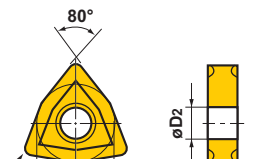

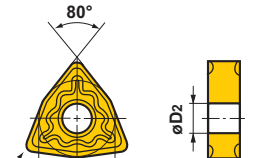
●：标准库存品 □：预订生产品

刀片外形	型 号	库存		尺寸(mm)				形 状
		UC5105	UC5115	D1	S1	Re	D2	
MV 断屑槽  中切削	NEW SNMG120404-MV		□	12.7	4.76	0.4	5.16	
	NEW 120408-MV		□	12.7	4.76	0.8	5.16	
	NEW 120412-MV		□	12.7	4.76	1.2	5.16	
SH 断屑槽  轻切削	NEW SNMG120404-SH		□	12.7	4.76	0.4	5.16	
	NEW 120408-SH		□	12.7	4.76	0.8	5.16	
	NEW 120412-SH		□	12.7	4.76	1.2	5.16	
无断屑槽 	TNMA 160404	●	●	9.525	4.76	0.4	3.81	
	160408	●	●	9.525	4.76	0.8	3.81	
	160412	●	●	9.525	4.76	1.2	3.81	
	160416	●	●	9.525	4.76	1.6	3.81	
	160420	●	●	9.525	4.76	2.0	3.81	
	220408	●	●	12.7	4.76	0.8	5.16	
	220412	●	●	12.7	4.76	1.2	5.16	
220416	●	●	12.7	4.76	1.6	5.16		
全周 断屑槽  中切削	TNMG 160404	●	●	9.525	4.76	0.4	3.81	
	160408	●	●	9.525	4.76	0.8	3.81	
	160412	●	●	9.525	4.76	1.2	3.81	
	160416	●	●	9.525	4.76	1.6	3.81	
	160420	●	●	9.525	4.76	2.0	3.81	
	220408	●	●	12.7	4.76	0.8	5.16	
	220412	●	●	12.7	4.76	1.2	5.16	
220416	●	●	12.7	4.76	1.6	5.16		
GH 断屑槽  准重切削	TNMG 160408-GH	●	●	9.525	4.76	0.8	3.81	
	160412-GH	●	●	9.525	4.76	1.2	3.81	
	220408-GH	●	●	12.7	4.76	0.8	5.16	
	220412-GH	●	●	12.7	4.76	1.2	5.16	
MA 断屑槽  中切削	TNMG 160404-MA	●	●	9.525	4.76	0.4	3.81	
	160408-MA	●	●	9.525	4.76	0.8	3.81	
	160412-MA	●	●	9.525	4.76	1.2	3.81	
	160416-MA	●	●	9.525	4.76	1.6	3.81	
	220408-MA	●	●	12.7	4.76	0.8	5.16	
	220412-MA	●	●	12.7	4.76	1.2	5.16	
220416-MA	●	●	12.7	4.76	1.6	5.16		
MH 断屑槽  中切削	NEW TNMG 160404-MH		●	9.525	4.76	0.4	3.81	
	NEW 160408-MH		●	9.525	4.76	0.8	3.81	
	NEW 160412-MH		●	9.525	4.76	1.2	3.81	
	NEW 220408-MH		●	12.7	4.76	0.8	5.16	
	NEW 220412-MH		●	12.7	4.76	1.2	5.16	
MV 断屑槽  中切削	NEW TNMG 160404-MV		□	9.525	4.76	0.4	3.81	
	NEW 160408-MV		□	9.525	4.76	0.8	3.81	
	NEW 160412-MV		□	9.525	4.76	1.2	3.81	

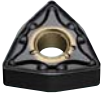
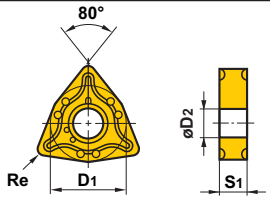

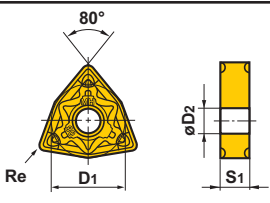
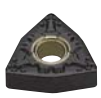
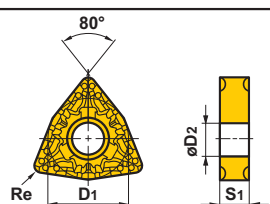

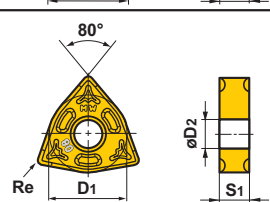

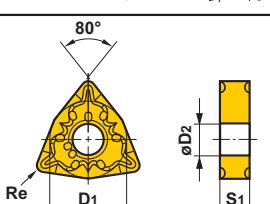
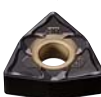
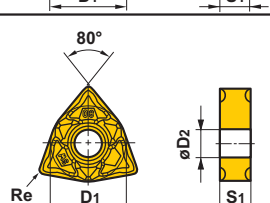
超级涂层硬质合金 UC5105/UC5115

刀片规格


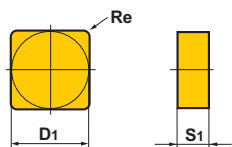

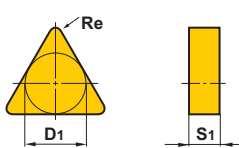
●负角刀片(带孔)

刀片外形	型号	库存		尺寸(mm)				形状
		UC5105	UC5115	D1	S1	Re	D2	
SH 断屑槽  轻切削	NEW TNMG160404-SH		☐	9.525	4.76	0.4	3.81	
	NEW 160408-SH		☐	9.525	4.76	0.8	3.81	
MW 断屑槽  中切削 (修光刃)	TNMX160408-MW	☐	☐	9.525	4.76	0.8	3.81	
	160412-MW	☐	☐	9.525	4.76	1.2	3.81	
全周 断屑槽  中切削	VNMG160404	●	●	9.525	4.76	0.4	3.81	
	160408	●	●	9.525	4.76	0.8	3.81	
	160412	●	●	9.525	4.76	1.2	3.81	
MA 断屑槽  中切削	VNMG160404-MA	●	●	9.525	4.76	0.4	3.81	
	160408-MA	●	●	9.525	4.76	0.8	3.81	
MH 断屑槽  中切削	NEW VNMG160404-MH		●	9.525	4.76	0.4	3.81	
	NEW 160408-MH		●	9.525	4.76	0.8	3.81	
MV 断屑槽  中切削	NEW VNMG160404-MV		☐	9.525	4.76	0.4	3.81	
	NEW 160408-MV		☐	9.525	4.76	0.8	3.81	
无断屑槽  	WNMA080404	●	●	12.7	4.76	0.4	5.16	
	080408	●	●	12.7	4.76	0.8	5.16	
	080412	●	●	12.7	4.76	1.2	5.16	
	080416	●	●	12.7	4.76	1.6	5.16	
全周 断屑槽  中切削	WNMG080404	●	●	12.7	4.76	0.4	5.16	
	080408	●	●	12.7	4.76	0.8	5.16	
	080412	●	●	12.7	4.76	1.2	5.16	
	080416	●	●	12.7	4.76	1.6	5.16	
GH 断屑槽  准重切削	WNMG080408-GH	●	●	12.7	4.76	0.8	5.16	
	080412-GH	●	●	12.7	4.76	1.2	5.16	

●：标准库存品 ☐：预订生产品

刀片外形	型 号	库存		尺寸(mm)				形 状
		UC5105	UC5115	D1	S1	Re	D2	
MA 断屑槽  中切削	WNMG080404-MA	●	●	12.7	4.76	0.4	5.16	
	080408-MA	●	●	12.7	4.76	0.8	5.16	
	080412-MA	●	●	12.7	4.76	1.2	5.16	
	080416-MA	●	●	12.7	4.76	1.6	5.16	
MH 断屑槽  中切削	NEW WNMG080404-MH		●	12.7	4.76	0.4	5.16	
	NEW 080408-MH		●	12.7	4.76	0.8	5.16	
	NEW 080412-MH		●	12.7	4.76	1.2	5.16	
MV 断屑槽  中切削	NEW WNMG080404-MV		□	12.7	4.76	0.4	5.16	
	NEW 080408-MV		□	12.7	4.76	0.8	5.16	
	NEW 080412-MV		□	12.7	4.76	1.2	5.16	
MW 断屑槽  中切削 (修光刃)	WNMG060408-MW	□	□	9.525	4.76	0.8	3.81	
	060412-MW	□	□	9.525	4.76	1.2	3.81	
	080408-MW	●	●	12.7	4.76	0.8	5.16	
	080412-MW	●	●	12.7	4.76	1.2	5.16	
SH 断屑槽  轻切削	NEW WNMG080404-SH		□	12.7	4.76	0.4	5.16	
	NEW 080408-SH		□	12.7	4.76	0.8	5.16	
	NEW 080412-SH		□	12.7	4.76	1.2	5.16	
SW 断屑槽  轻切削 (修光刃)	NEW WNMG080404-SW		●	12.7	4.76	0.4	5.16	
	NEW 080408-SW		●	12.7	4.76	0.8	5.16	


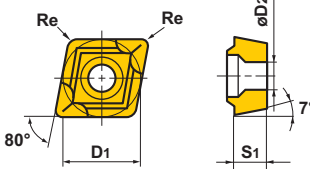

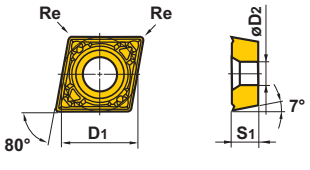

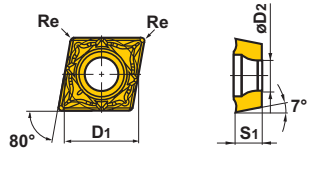

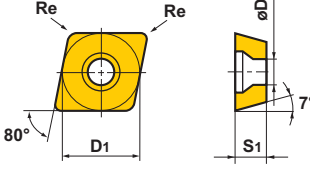

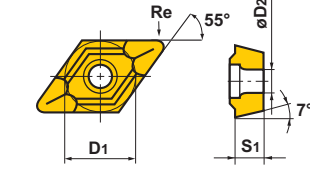

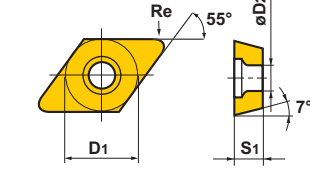

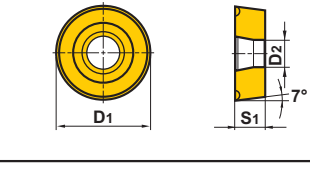

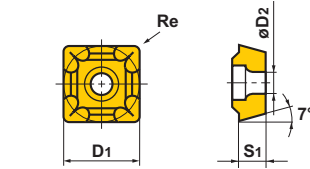
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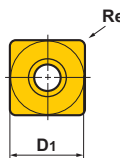
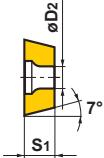


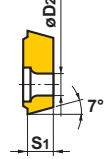

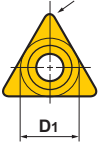
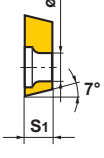

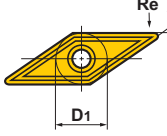
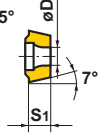

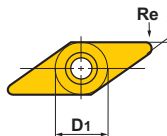
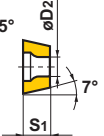
刀片外形	型 号	库存		尺寸(mm)				形 状
		UC5105	UC5115	D1	S1	Re	D2	
	SNMN120408	●	●	12.7	4.76	0.8	—	
	120412	●	●	12.7	4.76	1.2	—	
	120416	●	●	12.7	4.76	1.6	—	
	TNMN160408	●	●	9.525	4.76	0.8	—	
	160412	●	●	9.525	4.76	1.2	—	
	160416	●	●	9.525	4.76	1.6	—	
	160420	●	●	9.525	4.76	2.0	—	

超级涂层硬质合金 UC5105/UC5115

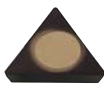
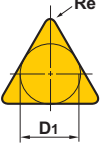
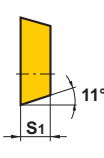
刀片规格

●正角刀片(带孔)

刀片外形	型号	库存		尺寸(mm)				形状
		UC5105	UC5115	D1	S1	Re	D2	
无代号 断屑槽 	CCMT060204	●	●	6.35	2.38	0.4	2.8	
	NEW 060208	□	□	6.35	2.38	0.8	2.8	
	09T304	●	●	9.525	3.97	0.4	4.4	
	09T308	●	●	9.525	3.97	0.8	4.4	
	120404	●	●	12.7	4.76	0.4	5.5	
	120408	●	●	12.7	4.76	0.8	5.5	
中切削	120412	□	□	12.7	4.76	1.2	5.5	
MW 断屑槽 	NEW CCMT120404-MW	□	□	12.7	4.76	0.4	5.5	
	NEW 120408-MW	□	□	12.7	4.76	0.8	5.5	
SW 断屑槽 	NEW CCMT060204-SW	□	□	6.35	2.38	0.4	2.8	
	NEW 09T302-SW	□	□	9.525	3.97	0.2	4.4	
	NEW 09T304-SW	□	□	9.525	3.97	0.4	4.4	
无断屑槽 	CCMW060204	●	●	6.35	2.38	0.4	2.8	
	09T304	●	●	9.525	3.97	0.4	4.4	
	09T308	●	●	9.525	3.97	0.8	4.4	
	120404	●	●	12.7	4.76	0.4	5.5	
	120408	●	●	12.7	4.76	0.8	5.5	
	120412	□	□	12.7	4.76	1.2	5.5	
无代号 断屑槽 	DCMT070204	□	□	6.35	2.38	0.4	2.8	
	NEW 070208	□	□	6.35	2.38	0.8	2.8	
	11T304	●	●	9.525	3.97	0.4	4.4	
	11T308	●	●	9.525	3.97	0.8	4.4	
	150404	□	□	12.7	4.76	0.4	5.5	
	150408	□	□	12.7	4.76	0.8	5.5	
无断屑槽 	DCMW070204	□	□	6.35	2.38	0.4	2.8	
	11T304	●	●	9.525	3.97	0.4	4.4	
	11T308	●	●	9.525	3.97	0.8	4.4	
	150404	□	□	12.7	4.76	0.4	5.5	
	150408	□	□	12.7	4.76	0.8	5.5	
无代号 断屑槽 	RCMX1204M0		●	12	4.76	—	4.2	
无代号 断屑槽 	SCMT09T304	●	●	9.525	3.97	0.4	4.4	
	09T308	●	●	9.525	3.97	0.8	4.4	
	120404	●	●	12.7	4.76	0.4	5.5	
	120408	●	●	12.7	4.76	0.8	5.5	
	120412	□	□	12.7	4.76	1.2	5.5	
中切削								

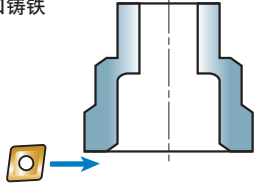
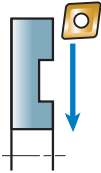
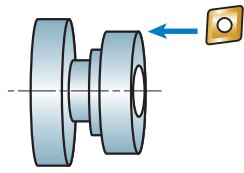
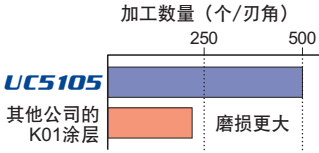
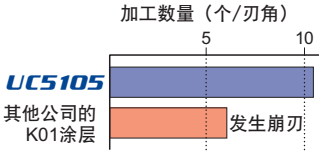
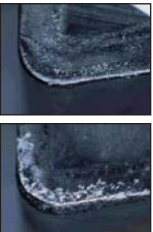
刀片外形	型 号	库存		尺寸(mm)				形 状
		UC5105	UC5115	D1	S1	Re	D2	
无断屑槽 	SCMW09T304	●	●	9.525	3.97	0.4	4.4	 
	09T308	●	●	9.525	3.97	0.8	4.4	
	120404	●	●	12.7	4.76	0.4	5.5	
	120408	●	●	12.7	4.76	0.8	5.5	
	120412		□	12.7	4.76	1.2	5.5	
无代号 断屑槽 	TCMT110204		□	6.35	2.38	0.4	2.8	 
	16T304		●	9.525	3.97	0.4	4.4	
	16T308		●	9.525	3.97	0.8	4.4	
中切削 无断屑槽 	TCMW110204	□	□	6.35	2.38	0.4	2.8	 
	16T304	●	●	9.525	3.97	0.4	4.4	
	16T308	●	●	9.525	3.97	0.8	4.4	
无代号 断屑槽 	VCMT160404		□	9.525	4.76	0.4	4.4	 
	160408		●	9.525	4.76	0.8	4.4	
中切削 无断屑槽 	VCMW160404	□	□	9.525	4.76	0.4	4.4	 
	160408	●	●	9.525	4.76	0.8	4.4	

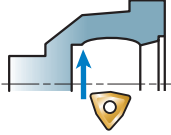
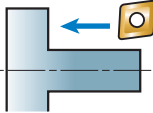
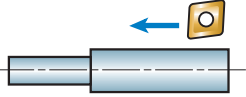
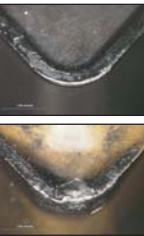
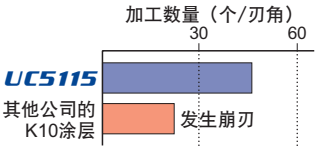
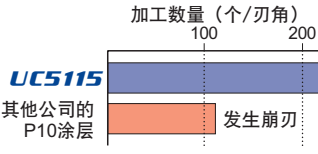
●正角刀片(无孔)

刀片外形	型 号	库存		尺寸(mm)				形 状
		UC5105	UC5115	D1	S1	Re	D2	
	TPMN110304	●	●	6.35	3.18	0.4	—	 
	110308	●	●	6.35	3.18	0.8	—	
	160304	●	●	9.525	3.18	0.4	—	
	160308	●	●	9.525	3.18	0.8	—	
	160312	□	□	9.525	3.18	1.2	—	
	220408	□	□	12.7	4.76	0.8	—	

超级涂层硬质合金 UC5105/UC5115

使用实例

使用刀片 (材料)	CNMA120408(UC5105)	CNMA120412 (UC5105)	CNMA120408 (UC5105)
工件材料	灰口铸铁 	球墨铸铁 	球墨铸铁 
零部件名称	轮毂	挡圈	扣环
切削条件	切削速度 (m/min)	250	230
	每转进给量 (mm/rev)	0.30	0.30
	切削深度 (mm)	2.5	2.0
切削液	湿式切削	湿式切削	湿式切削
结果	 <p>加工数量 (个/刃角) 250 500</p> <p>UC5105 加工数量 70个/刃角</p> <p>其他公司的 K01涂层 磨损更大</p> <p>UC5105 可以达到双倍以上的刀具寿命</p>	 <p>加工数量 (个/刃角) 5 10</p> <p>UC5105 加工数量 70个/刃角</p> <p>其他公司的 K01涂层 发生崩刃</p> <p>UC5105 可以达到1.5倍刀具寿命, 无任何异常损伤现象。</p>	 <p>UC5105 加工数量 70个/刃角</p> <p>其他公司的 K01涂层 加工数量 46个/刃角</p>

使用刀片 (材料)	WNMG080412-GH (UC5115)	CNMG120408 (UC5115)	DNMG150608-MH (UC5115)
工件材料	球墨铸铁 (FCD550) 	球墨铸铁 (FCD600) 	合金钢 (SCM420) 
零部件名称	差速器壳体	曲轴	旋转轴
切削条件	切削速度 (m/min)	160	145-160
	每转进给量 (mm/rev)	0.25	0.20
	切削深度 (mm)	1-2	2.5
切削液	湿式切削	湿式切削	湿式切削
结果	 <p>UC5115 加工数量 100个/刃角</p> <p>其他公司的 K10涂层 加工数量 100个/刃角</p>	 <p>加工数量 (个/刃角) 30 60</p> <p>UC5115 加工数量 100个/刃角</p> <p>其他公司的 K10涂层 发生崩刃</p> <p>UC5115 可以达到1.7倍刀具寿命, 无崩刃现象。</p>	 <p>加工数量 (个/刃角) 100 200</p> <p>UC5115 加工数量 100个/刃角</p> <p>其他公司的 P10涂层 发生崩刃</p> <p>UC5115 可以达到双倍刀具寿命, 无崩刃现象。</p>

关于安全

- 请不要直接用手摸切削刃、切屑。● 请在推荐条件范围内使用, 提早更换刀具。● 有时会有高温的切屑飞出、伸长的切屑排出。请使用安全罩、防护镜等防护用具。● 使用非水溶性切削液时, 务必采取防火措施。
- 安装刀片或零部件时, 请使用附带的扳手稳妥安装。

三菱综合材料株式会社

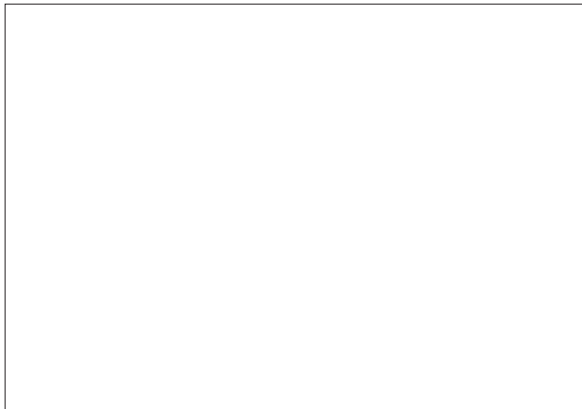
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<http://www.mitsubishicarbide.com>



(规格若有更改, 恕不事先通知)

