

不锈钢车削用涂层材质

Coated Grades for Stainless Steel

AC6020M/AC6030M/AC6135M/AC6145M

AC6020M / AC6030M / AC6135M / AC6145M

实现绝对稳定加工的不锈钢车削材料系列



New

一般断续・黑皮加工 强断续加工

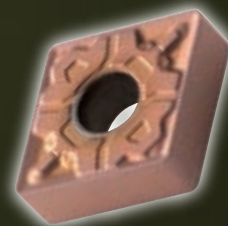
AC6135M/AC6145M 新上市

New

半精~粗加工用
负型M级刀片断屑槽

EH型 产品阵容

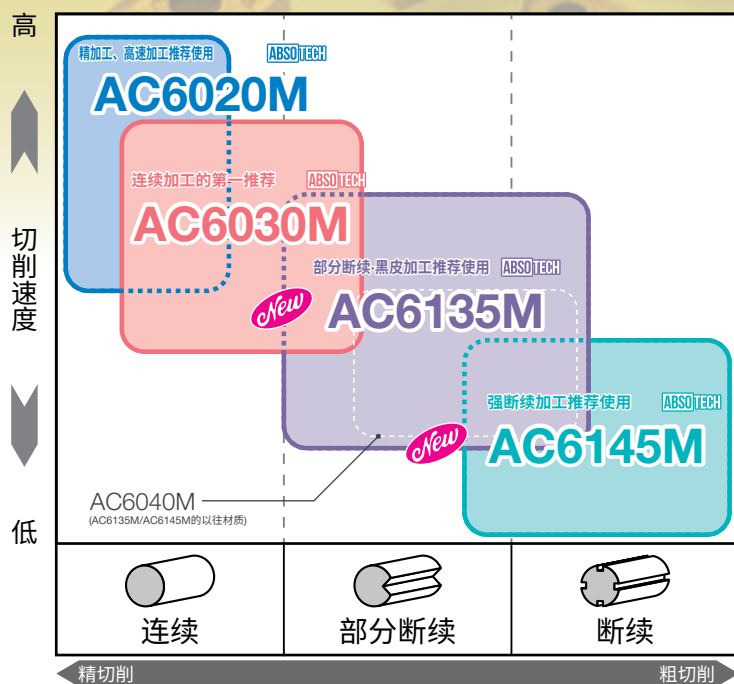
库存材质：AC6135M / AC6145M





AC6020M/AC6030M/AC6135M/AC6145M

■ 适用领域



○ AC6020M CVD ABSO TECH

通过配合使用CVD涂层和高硬度硬质合金母材，在**精加工、高速加工**中实现稳定长寿命

○ AC6030M CVD ABSO TECH

通过采用CVD涂层，大幅降低不锈钢加工中异常损伤，实现稳定长寿命，是**连续加工**的首选材质

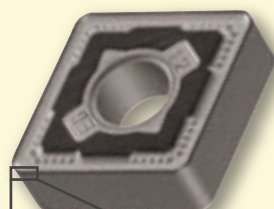
○ AC6135M New PVD ABSO TECH

通过采用PVD新涂层，在**部分断续·黑皮加工**中，兼顾优良的耐磨损性和耐崩损性。

○ AC6145M New PVD ABSO TECH

通过配合使用PVD新涂层和高韧性硬质合金母材，在**强断续加工**中实现绝对的稳定性。

■ AC6020M / AC6030M的特点



AC6020M / AC6030M

CVD ABSO TECH

采用本公司独特的表面平滑处理，大幅提高耐小崩口性和耐溶着性的不锈钢加工用材质

Al_2O_3

表面平滑处理

通过表面平滑化提高耐溶着性，大幅抑制粘屑及其导致的崩口

TiCN

高韧性氧化铝层

采用韧性优异的氧化铝层，实现稳定长寿命

高硬度微粒TiCN层

通过晶体组织的精细、均匀化，大幅提高涂膜硬度

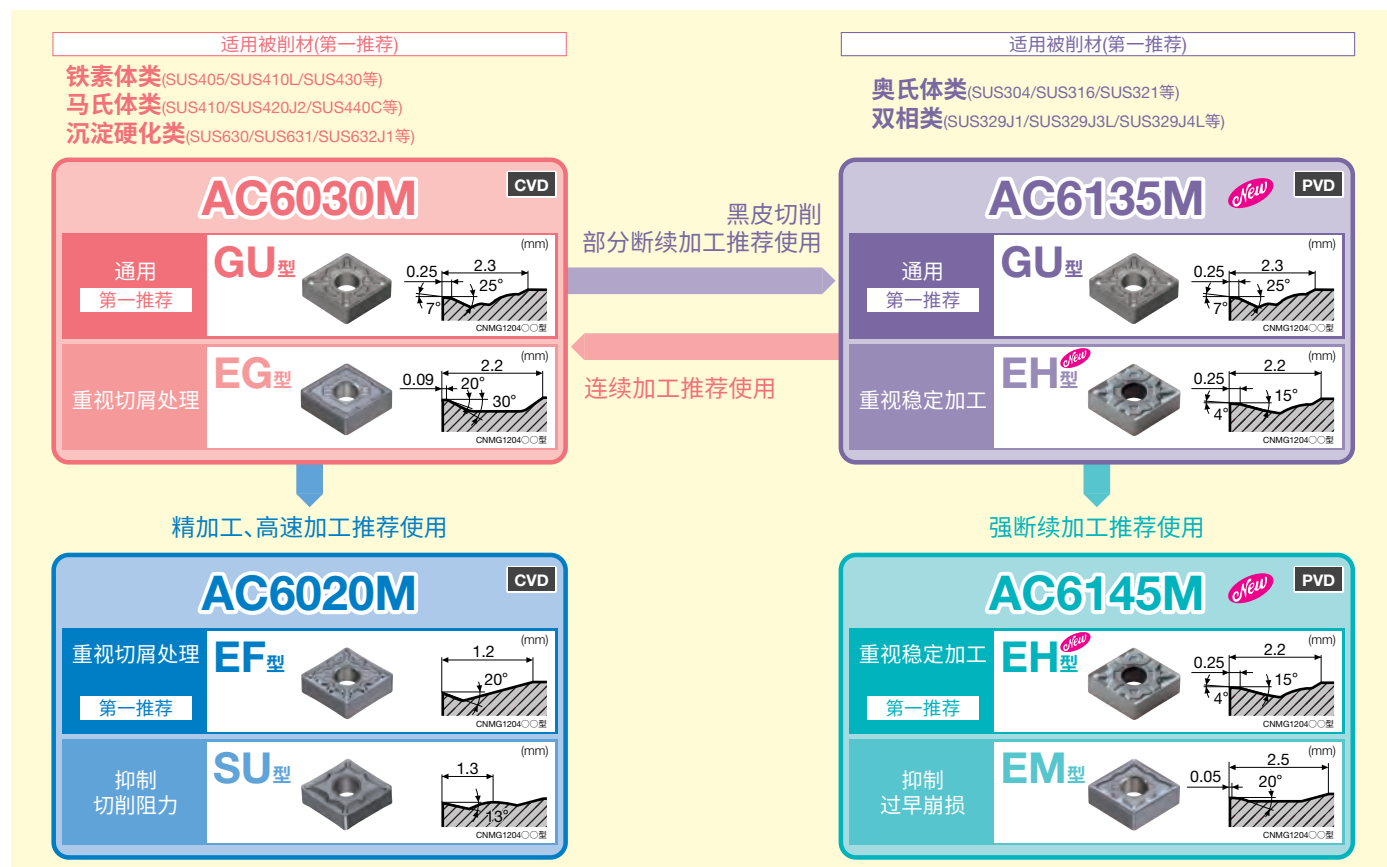
硬质合金母材

高粘合技术

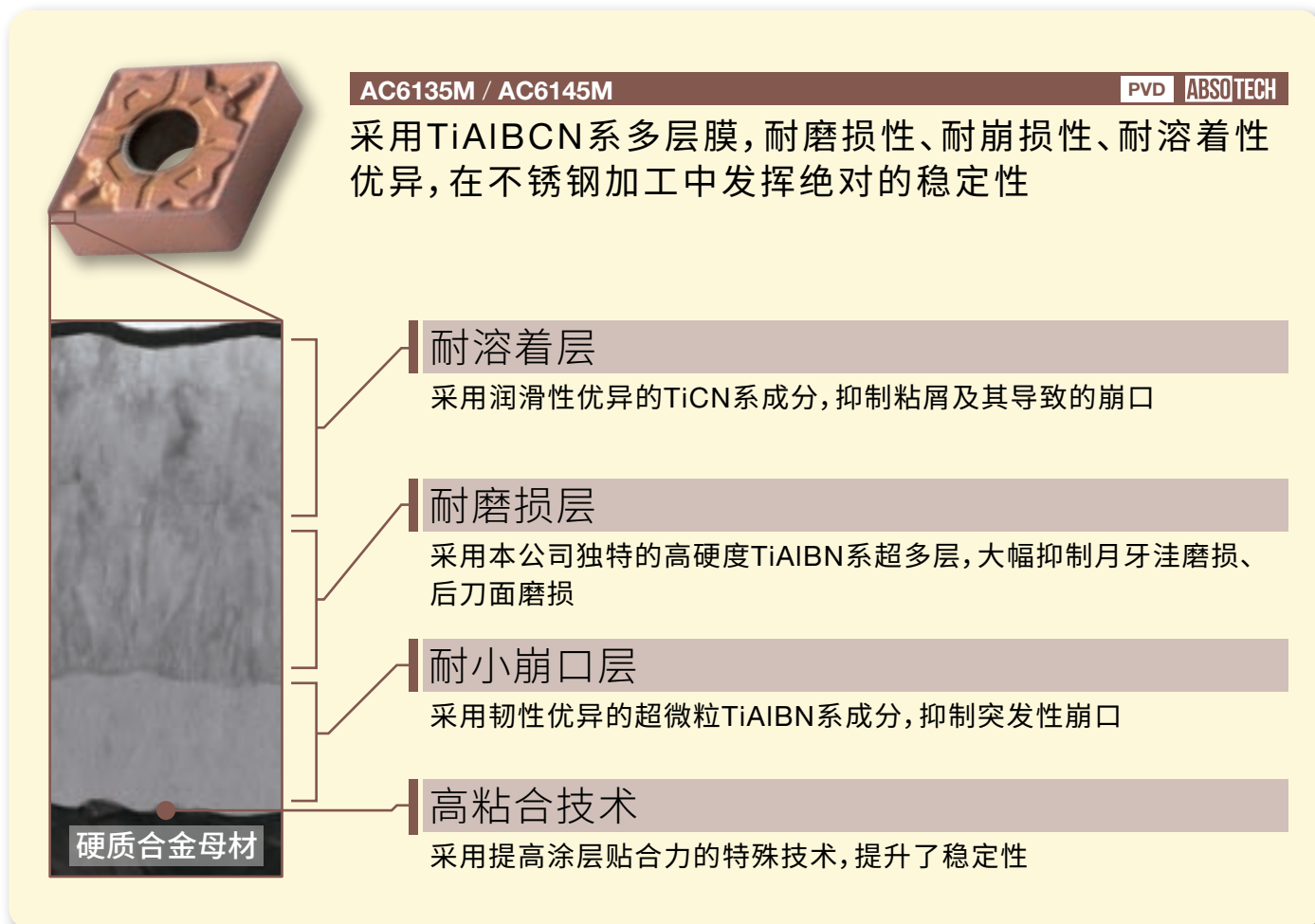
通过硬质合金母材、涂膜界面的平滑化，大幅提高膜的粘合强度

AC6020M/AC6030M/AC6135M/AC6145M

■ AC6000M系列 / AC6100M系列的使用区分(例：不锈钢)

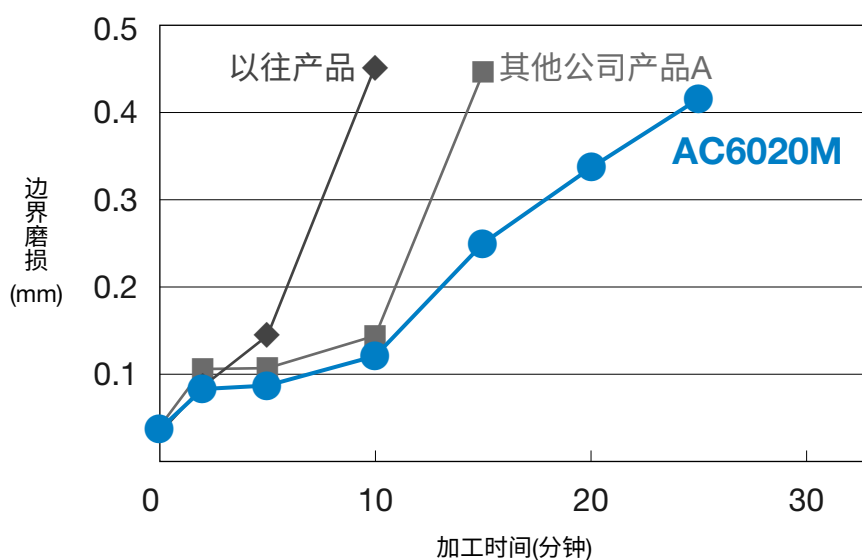


■ AC6135M / AC6145M的特点 *New*

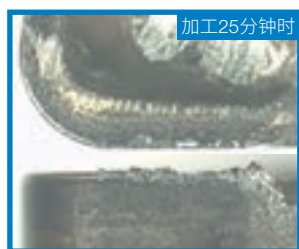
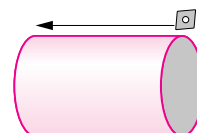


AC6020M/AC6030M/AC6135M/AC6145M

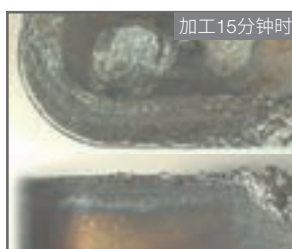
■ AC6020M 的耐磨损性能(不锈钢 连续切削)



被 削 材: SUS316L
连续切削
刀 片: CNMG120408
切削条件: $vc=150\text{m/min}$
 $f=0.3\text{mm/rev}$
 $ap=2.0\text{mm}$
Wet

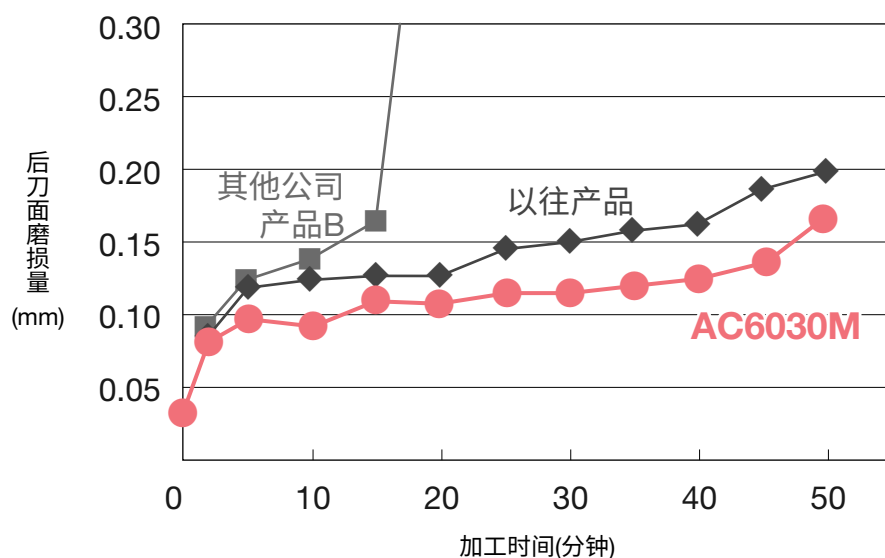


AC6020M

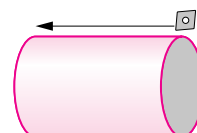


其他公司产品A

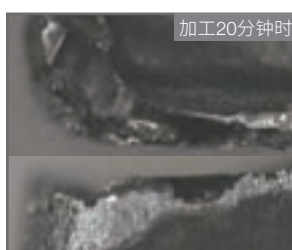
■ AC6030M 的耐磨损性能(不锈钢 连续切削)



被 削 材: SUS316
连续切削
刀 片: CNMG120408
切削条件: $vc=200\text{m/min}$
 $f=0.2\text{mm/rev}$
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Wet



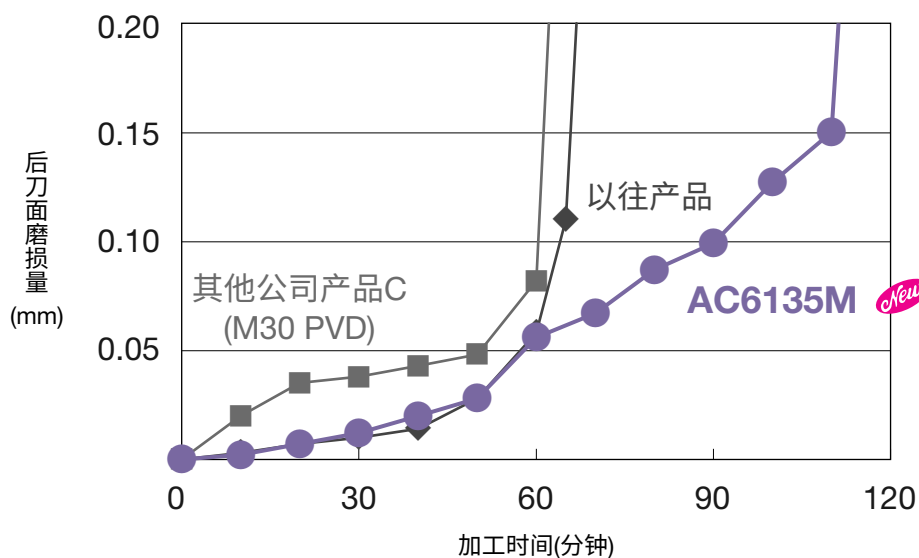
AC6030M



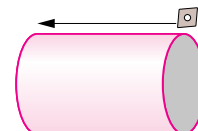
其他公司产品B

AC6020M/AC6030M/AC6135M/AC6145M

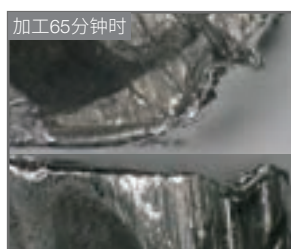
■ AC6135M 的耐磨损性能(不锈钢 连续切削)



被削材: SUS316
连续切削
刀片: CNMG120408
切削条件: $vc=150\text{m/min}$
 $f=0.2\text{mm/rev}$
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Wet

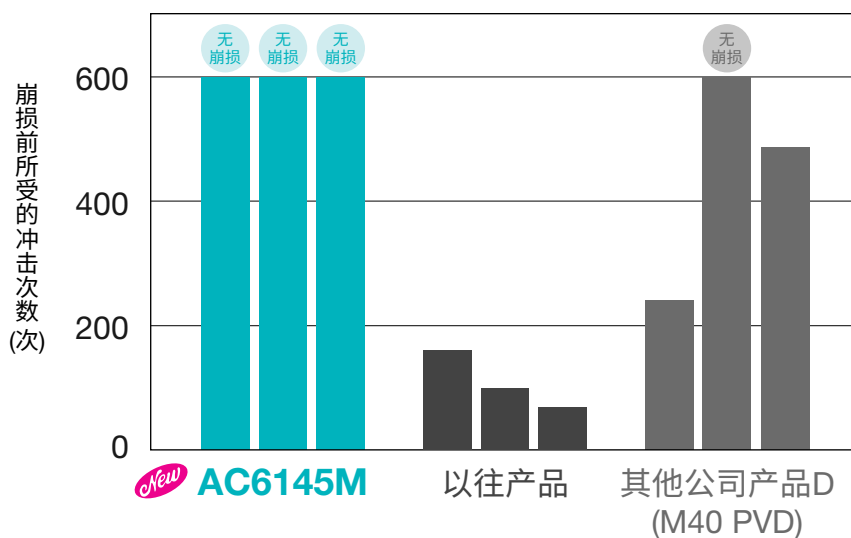


New AC6135M

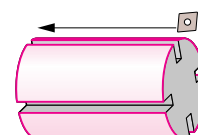


其他公司产品C (M30 PVD)

■ AC6145M 的耐崩损性能(不锈钢 断续切削)

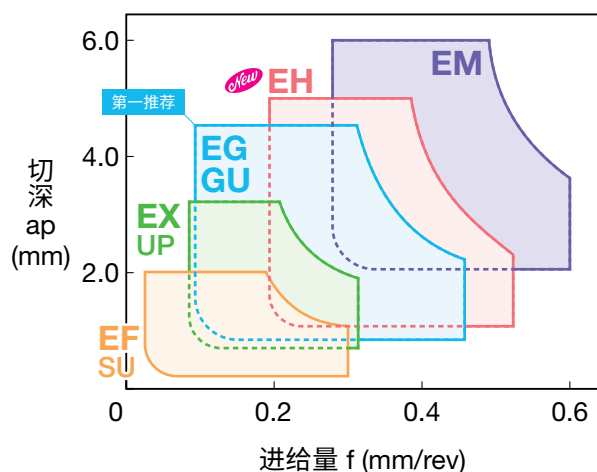


被削材: SUS316
断续切削
刀片: CNMG120408
切削条件: $vc=70\text{m/min}$
 $f=0.25\text{mm/rev}$
 $ap=1.0\text{mm}$
Wet



AC6020M/AC6030M/AC6135M/AC6145M

■ 刀片断屑槽适用领域



不锈钢加工用断屑槽系列

精切削用 EF型

精加工~半精切削用 EX型

半精切削用 EG型 / GU型

粗切削用 EM型之外,

还备有半精~粗切削用且断续用途的EH型

整个系列的切屑处理性能、耐磨损性能、耐崩损性能等可满足多种需求,在不锈钢的车削加工中实现稳定加工

■ 刀片断屑槽的特点

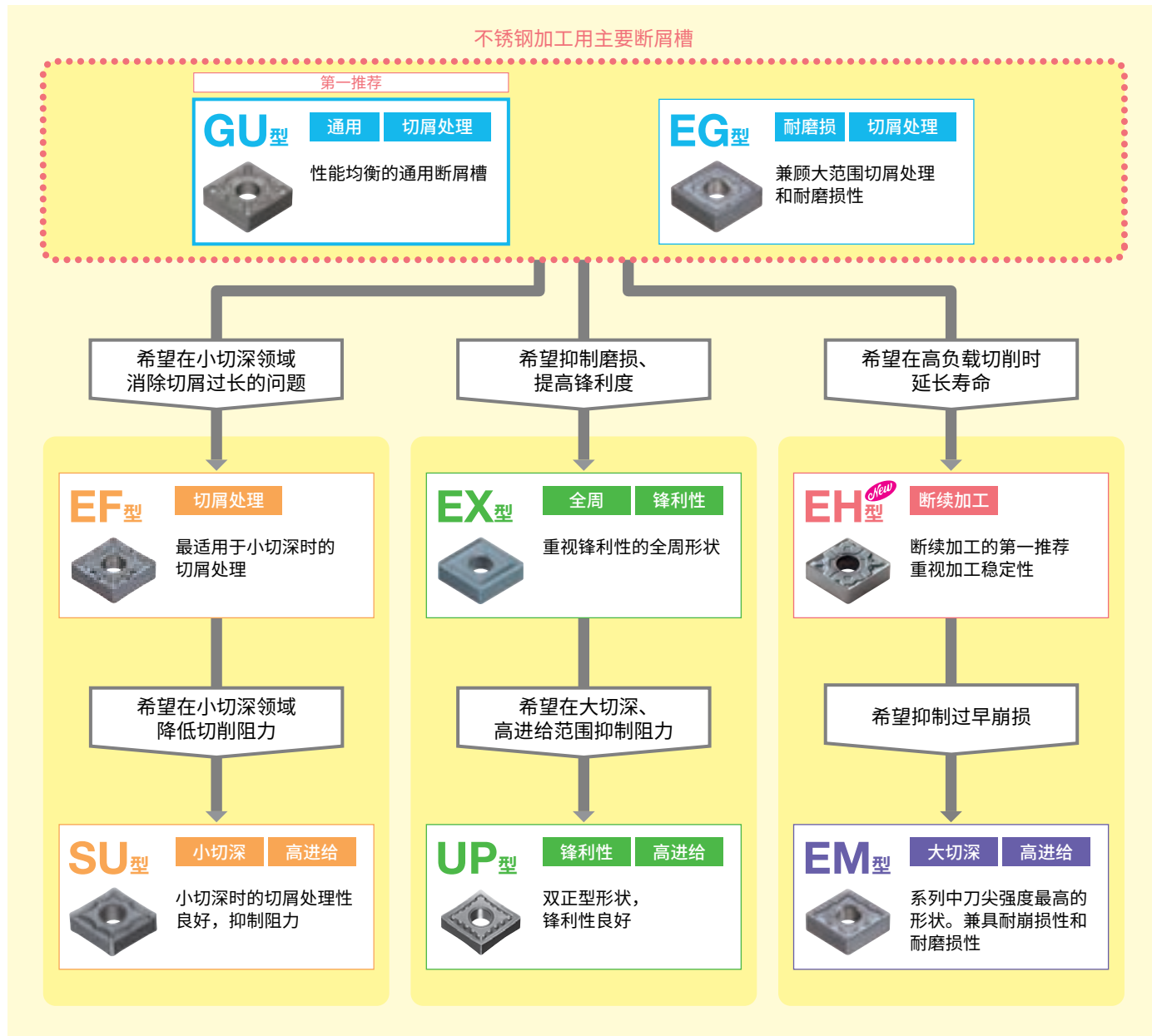
EF型 精切削用 刀片断屑槽截面图 (CNMG1204○○型) 对于小切深也可发挥良好切屑处理性的主要断屑槽 抑制磨损、注重锋利性 (前刀角 20°) 的刀尖设计 减少发热和不均匀接触的前刀面槽形 刀尖部 (mm): 1.2, 20° 边部 (mm): 20°	EX型 轻~半精切削用 刀片断屑槽截面图 (CNMG1204○○型) 采用曲面断屑槽, 与切屑的接触少, 减小发热和切削负载 采用直线切削刃和大前角 (16°), 锋利性良好且提高了边界耐损伤性能 边部(全周) (mm): 2.0, 16°
EG型 半精切削用 刀片断屑槽截面图 (CNMG1204○○型) 在广泛条件下发挥良好的切屑处理性能的球形突起部分 发生磨损后也会保持强度的刀尖形状 刀尖部 (mm): 0.09, 2.2, 20°, 30° 边部 (mm): 0.09, 20°, 30°	GU型 半精切削用 刀片断屑槽截面图 (CNMG1204○○型) 带槽球状突起设计, 宽广的切屑处理范围 抑制磨损加剧的 2 段前刀面形状 刀尖部 (mm): 0.25, 2.3, 25°, 7° 边部 (mm): 0.3, 25°
EH型 半精~粗切削用 刀片断屑槽截面图 (CNMG1204○○型) 抑制阻力, 处理切屑的球状突起 提高耐崩损性的 2 段前刀面形状 刀尖部 (mm): 0.25, 2.2, 15°, 4° 边部 (mm): 0.25, 15°, 4°	EM型 粗切削用 刀片断屑槽截面图 (CNMG1204○○型) 在保持刀尖强度的同时, 抑制月牙洼磨损的大圆弧前刀面形状 无抑制沟槽磨损的过渡点的切刃棱线 刀尖部 (mm): 0.05, 2.5, 20° 边部 (mm): 0.30, 25°

AC6020M/AC6030M/AC6135M/AC6145M

■ 刀片断屑槽的使用区分(负型刀片) 切削状态



■ 刀片断屑槽的使用区分(负型刀片) 故障诊断



AC6020M/AC6030M/AC6135M/AC6145M

◇ 负型 80°菱形

形状	型号	库存				尺寸 (mm)			
		AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	CNMG 090304N-FE	●	●	●	●	9.525	3.18	3.81	0.4
	090308N-FE	●	●	●	●	9.525	3.18	3.81	0.8
	CNMG 090404N-FE	●	●	●	●	9.525	4.76	3.81	0.4
	090408N-FE	●	●	●	●	9.525	4.76	3.81	0.8
	CNMG 120402N-FE	●	●	●	●	12.7	4.76	5.16	0.2
	120404N-FE	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-FE	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-FE	●	●	●	●	12.7	4.76	5.16	1.2
	CNMG 090304N-LU	●	●	●	●	9.525	3.18	3.81	0.4
	090308N-LU	●	●	●	●	9.525	3.18	3.81	0.8
	CNMG 120402N-LU	●	●	●	●	12.7	4.76	5.16	0.2
	120404N-LU	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-LU	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-LU	●	●	●	●	12.7	4.76	5.16	1.2
	CNMG 120404N-LUW	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-LUW	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-LUW	●	●	●	●	12.7	4.76	5.16	1.2
	CNMG 120402N-SU	●	●	●	●	12.7	4.76	5.16	0.2
	120404N-SU	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-SU	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-SU	●	●	●	●	12.7	4.76	5.16	1.2
	CNMG 090404N-EF	●	●	●	●	9.525	4.76	3.81	0.4
	090408N-EF	●	●	●	●	9.525	4.76	3.81	0.8
	CNMG 120404N-EF	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-EF	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-EF	●	●	●	●	12.7	4.76	5.16	1.2
	CNMG 120404N-EX	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-EX	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-EX	●	●	●	●	12.7	4.76	5.16	1.2
	120416N-EX	●	●	●	●	12.7	4.76	5.16	1.6
	CNMG 160612N-EX	●	●	●	●	15.875	6.35	6.35	1.2
	CNMG 190612N-EX	●	●	●	●	19.05	6.35	7.94	1.2
	CNMG 120404N-UP	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-UP	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-UP	●	●	●	●	12.7	4.76	5.16	1.2
	CNMG 120404N-GU	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-GU	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-GU	●	●	●	●	12.7	4.76	5.16	1.2
	120416N-GU	●	●	●	●	12.7	4.76	5.16	1.6
	CNMG 160608N-GU	●	●	●	●	15.875	6.35	6.35	0.8
	160612N-GU	●	●	●	●	15.875	6.35	6.35	1.2
	160616N-GU	●	●	●	●	15.875	6.35	6.35	1.6
	CNMG 090408N-EG	●	●	●	●	9.525	4.76	3.81	0.8
	090412N-EG	●	●	●	●	9.525	4.76	3.81	1.2
	CNMG 120404N-EG	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-EG	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-EG	●	●	●	●	12.7	4.76	5.16	1.2
	CNMG 160608N-EG	●	●	●	●	15.875	6.35	6.35	0.8
	160612N-EG	●	●	●	●	15.875	6.35	6.35	1.2
	160616N-EG	●	●	●	●	15.875	6.35	6.35	1.6
	CNMG 190612N-EG	●	●	●	●	19.05	6.35	7.94	1.2
	190616N-EG	●	●	●	●	19.05	6.35	7.94	1.6
	CNMG 120408N-MU	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-MU	●	●	●	●	12.7	4.76	5.16	1.2
	CNMG 160612N-MU	●	●	●	●	15.875	6.35	6.35	1.2
	160616N-MU	●	●	●	●	15.875	6.35	6.35	1.6
	CNMG 190612N-MU	●	●	●	●	19.05	6.35	7.94	1.2
	190616N-MU	●	●	●	●	19.05	6.35	7.94	1.6
	CNMG 120404N-EH	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-EH	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-EH	●	●	●	●	12.7	4.76	5.16	1.2
	120416N-EH	●	●	●	●	12.7	4.76	5.16	1.6
	CNMG 190612N-EH	●	●	●	●	19.05	6.35	7.94	1.2
	190616N-EH	●	●	●	●	19.05	6.35	7.94	1.6
	CNMG 120408N-EM	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-EM	●	●	●	●	12.7	4.76	5.16	1.2
	120416N-EM	●	●	●	●	12.7	4.76	5.16	1.6
	CNMG 160608N-EM	●	●	●	●	15.875	6.35	6.35	0.8
	160612N-EM	●	●	●	●	15.875	6.35	6.35	1.2
	160616N-EM	●	●	●	●	15.875	6.35	6.35	1.6
	CNMG 190612N-EM	●	●	●	●	19.05	6.35	7.94	1.2
	190616N-EM	●	●	●	●	19.05	6.35	7.94	1.6
	190624N-EM	●	●	●	●	19.05	6.35	7.94	2.4
	CNMG 250924N-EM	●	●	●	●	25.4	9.52	9.12	2.4

◇ 负型 80°菱形

形状	型号	库存				尺寸 (mm)			
		AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	CNMM 120408N-MP	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-MP	●	●	●	●	12.7	4.76	5.16	1.2
	120416N-MP	●	●	●	●	12.7	4.76	5.16	1.6
	CNMM 160608N-MP	●	●	●	●	15.875	6.35	6.35	0.8
	160612N-MP	●	●	●	●	15.875	6.35	6.35	1.2
	160616N-MP	●	●	●	●	15.875	6.35	6.35	1.6
	CNMM 190608N-MP	●	●	●	●	19.05	6.35	7.94	0.8
	190612N-MP	●	●	●	●	19.05	6.35	7.94	1.2
	190616N-MP	●	●	●	●	19.05	6.35	7.94	1.6
	190624N-MP	●	●	●	●	19.05	6.35	7.94	2.4

AC6020M/AC6030M/AC6135M/AC6145M

◇ 负型 55°菱形

形状	型号	库存				尺寸 (mm)			
		AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	DNMG 110404N-FE	●	●	●	●	9.525	4.76	3.81	0.4
	110408N-FE	●	●	●	●				0.8
	110412N-FE	●	●	●	●				1.2
	DNMG 150402N-FE	●	●	●	●	12.7	4.76	5.16	0.2
	150404N-FE	●	●	●	●				0.4
	150408N-FE	●	●	●	●				0.8
	150412N-FE	●	●	●	●				1.2
	DNMG 150602N-FE	●	●	●	●	12.7	6.35	5.16	0.2
	150604N-FE	●	●	●	●				0.4
	150608N-FE	●	●	●	●				0.8
	DNMG 110404N-LU	●	●	●	●	9.525	4.76	3.81	0.4
	110408N-LU	●	●	●	●				0.8
	110412N-LU	●	●	●	●				1.2
	DNMG 150402N-LU	●	●	●	●	12.7	4.76	5.16	0.2
	150404N-LU	●	●	●	●				0.4
	150408N-LU	●	●	●	●				0.8
	150412N-LU	●	●	●	●				1.2
	DNMG 110404N-SU	●	●	●	●	9.525	4.76	3.81	0.4
	110408N-SU	●	●	●	●				0.8
	110412N-SU	●	●	●	●				1.2
	DNMG 150402N-SU	●	●	●	●	12.7	4.76	5.16	0.2
	150404N-SU	●	●	●	●				0.4
	150408N-SU	●	●	●	●				0.8
	150412N-SU	●	●	●	●				1.2
	DNMG 110404N-EF	●	●	●	●	9.525	4.76	3.81	0.4
	110408N-EF	●	●	●	●				0.8
	110412N-EF	●	●	●	●				1.2
	DNMG 150404N-EF	●	●	●	●	12.7	4.76	5.16	0.4
	150408N-EF	●	●	●	●				0.8
	150412N-EF	●	●	●	●				1.2
	DNMG 150604N-EF	●	●	●	●	12.7	6.35	5.16	0.4
	150608N-EF	●	●	●	●				0.8
	150612N-EF	●	●	●	●				1.2
	DNMG 150404N-EX	●	●	●	●	12.7	4.76	5.16	0.4
	150408N-EX	●	●	●	●				0.8
	150412N-EX	●	●	●	●				1.2
	DNMG 150604N-EX	●	●	●	●	12.7	6.35	5.16	0.4
	150608N-EX	●	●	●	●				0.8
	150612N-EX	●	●	●	●				1.2
	DNMG 150404N-UP	●	●	●	●	12.7	4.76	5.16	0.4
	150408N-UP	●	●	●	●				0.8
	150412N-UP	●	●	●	●				1.2
	DNMG 110404N-GU	●	●	●	●	9.525	4.76	3.81	0.4
	110408N-GU	●	●	●	●				0.8
	110412N-GU	●	●	●	●				1.2
	DNMG 150404N-GU	●	●	●	●	12.7	4.76	5.16	0.4
	150408N-GU	●	●	●	●				0.8
	150412N-GU	●	●	●	●				1.2
	DNMG 150608N-GU	●	●	●	●	12.7	6.35	5.16	0.8
	150612N-GU	●	●	●	●				1.2
	DNMG 110408N-EG	●	●	●	●	9.525	4.76	3.81	0.8
	110412N-EG	●	●	●	●				1.2
	DNMG 150404N-EG	●	●	●	●	12.7	4.76	5.16	0.4
	150408N-EG	●	●	●	●				0.8
	150412N-EG	●	●	●	●				1.2
	DNMG 150604N-EG	●	●	●	●	12.7	6.35	5.16	0.4
	150608N-EG	●	●	●	●				0.8
	150612N-EG	●	●	●	●				1.2
	DNMG 150408N-MU	●	●	●	●	12.7	4.76	5.16	0.8
	150412N-MU	●	●	●	●				1.2
	DNMG 150608N-MU	●	●	●	●	12.7	6.35	5.16	0.8
	150612N-MU	●	●	●	●				1.2
	DNMG 150404N-EH	●	●	●	●	12.7	4.76	5.16	0.4
	150408N-EH	●	●	●	●				0.8
	150412N-EH	●	●	●	●				1.2
	DNMG 150608N-EH	●	●	●	●	12.7	6.35	5.16	0.8
	150612N-EH	●	●	●	●				1.2
	DNMG 150408N-EM	●	●	●	●	12.7	4.76	5.16	0.8
	150412N-EM	●	●	●	●				1.2
	150416N-EM	●	●	●	●				1.6
	DNMG 150608N-EM	●	●	●	●	12.7	6.35	5.16	0.8
	150612N-EM	●	●	●	●				1.2
	DNMG 150404R-HM	●	●	●	●	12.7	4.76	5.16	0.4
	150404L-HM	●	●	●	●				0.4
	150408R-HM	●	●	●	●				0.8
	150408L-HM	●	●	●	●				0.8

□ 负型 正方形

形状	型号	库存				内切圆	尺寸 (mm)		
		AC6020M	AC6030M	AC6135M 外圆	AC6145M 外圆		厚度	孔径	刀尖半径
	SNMG 120404N-FE		●	●	●	12.7	4.76	5.16	0.4
	120408N-FE		●	●	●				0.8
	120412N-FE		●	●	●				1.2
	SNMG 120408N-LU		●			12.7	4.76	5.16	0.8
	120412N-LU		●						1.2
	SNMG 120408N-SU	●	●	●	●	12.7	4.76	5.16	0.8
	SNMG 120404N-EF	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-EF	●	●	●	●				0.8
	SNMG 120404N-EX	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-EX	●	●	●	●				0.8
	120412N-EX	●	●	●	●				1.2
	SNMG 150612N-EX			●	●	15.875	6.35	6.35	1.2
	SNMG 190612N-EX			●	●	19.05	6.35	7.94	1.2
	SNMG 120404N-UP	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-UP	●	●	●	●				0.8
	120412N-UP	●	●	●	●				1.2
	SNMG 120404N-GU	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-GU	●	●	●	●				0.8
	120412N-GU	●	●	●	●				1.2
	SNMG 150608N-GU								0.8
	150612N-GU		●	●	●	15.875	6.35	6.35	1.2
	150616N-GU		●	●	●				1.6
	SNMG 120404N-EG	●	●	●	●	12.7	4.76	5.16	0.4
	120408N-EG	●	●	●	●				0.8
	120412N-EG	●	●	●	●				1.2
	SNMG 150608N-EG	●	●	●	●	15.875	6.35	6.35	0.8
	150612N-EG	●	●	●	●				1.2
	150616N-EG	●	●	●	●				1.6
	SNMG 190612N-EG	●	●	●	●	19.05	6.35	7.94	1.2
190616N-EG	●	●	●	●	1.6				
	SNMG 120408N-MU		●			12.7	4.76	5.16	0.8
	120412N-MU		●						1.2
	SNMG 150612N-MU		●			15.875	6.35	6.35	1.2
	150616N-MU		●						1.6
	SNMG 190612N-MU		●			19.05	6.35	7.94	1.2
190616N-MU		●			1.6				
	SNMG 120404N-EH			●	●	12.7	4.76	5.16	0.4
	120408N-EH			●	●				0.8
	120412N-EH			●	●				1.2
	SNMG 190612N-EH			●	●	19.05	6.35	7.94	1.2
	190616N-EH			●	●				1.6
	SNMG 120408N-EM	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-EM	●	●	●	●				1.2
	SNMG 150608N-EM	●	●	●	●				
	150612N-EM	●	●	●	●	15.875	6.35	6.35	1.2
	150616N-EM	●	●	●	●				1.6
	SNMG 190612N-EM	●	●	●	●	19.05	6.35	7.94	1.2
	190616N-EM	●	●	●	●				1.6
	190624N-EM	●	●	●	●				2.4
	SNMG 250924N-EM	●	●	●	●	25.4	9.52	9.12	2.4
	SNMG 120408R-HM	●	●			12.7	4.76	5.16	0.8
	120408L-HM	●	●						0.8
	SNMG 150608R-HM	●	●			15.875	6.35	6.35	0.8
	150608L-HM	●	●						0.8
	SNMM 120408N-MP	●	●	●	●	12.7	4.76	5.16	0.8
	120412N-MP	●	●	●	●				1.2
	120416N-MP	●	●						1.6
	SNMM 150612N-MP		●			15.875	6.35	6.35	1.2
	150616N-MP	●	●						1.6
	SNMM 190612N-MP	●	●	●	●	19.05	6.35	7.94	1.2
	190616N-MP	●	●	●	●				1.6
	SNMM 250724N-MP	●	●			25.4	7.94	9.12	2.4
SNMM 250924N-MP	●	●			25.4	9.52	9.12	2.4	
SNMM 310924N-MP	●	●			31.75	9.52	8.8	2.4	

AC6020M/AC6030M/AC6135M/AC6145M

△ 负型 三角形

形状	型号	库存				尺寸 (mm)			
		AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	TNMG 160402N-FE	●	●	●	●	9.525	4.76	3.81	0.2
	160404N-FE	●	●	●	●				0.4
	160408N-FE	●	●	●	●				0.8
	160412N-FE	●	●	●	●				1.2
	TNMG 160402N-LU	●	●	●	●	9.525	4.76	3.81	0.2
	160404N-LU	●	●	●	●				0.4
	160408N-LU	●	●	●	●				0.8
	160412N-LU	●	●	●	●				1.2
	TNMG 160402N-SU	●	●	●	●	9.525	4.76	3.81	0.2
	160404N-SU	●	●	●	●				0.4
	160408N-SU	●	●	●	●				0.8
	160412N-SU	●	●	●	●				1.2
	TNMG 160404N-EF	●	●	●	●	9.525	4.76	3.81	0.4
	160408N-EF	●	●	●	●				0.8
	TNMG 160404N-EX	●	●	●	●	9.525	4.76	3.81	0.4
	160408N-EX	●	●	●	●				0.8
	160412N-EX	●	●	●	●				1.2
	TNMG 160404N-UP	●	●	●	●	9.525	4.76	3.81	0.4
	160408N-UP	●	●	●	●				0.8
	160412N-UP	●	●	●	●				1.2
	TNMG 220408N-UP	●	●	●	●	12.7	4.76	5.16	0.8
	220412N-UP	●	●	●	●				1.2
	TNMG 160404N-GU	●	●	●	●	9.525	4.76	3.81	0.4
	160408N-GU	●	●	●	●				0.8
	160412N-GU	●	●	●	●				1.2
	TNMG 220408N-GU	●	●	●	●	12.7	4.76	5.16	0.8
	220412N-GU	●	●	●	●				1.2
	TNMG 160404N-EG	●	●	●	●	9.525	4.76	3.81	0.4
	160408N-EG	●	●	●	●				0.8
	160412N-EG	●	●	●	●				1.2
	TNMG 160408N-MU	●	●	●	●	9.525	4.76	3.81	0.8
	160412N-MU	●	●	●	●				1.2
	TNMG 220408N-MU	●	●	●	●	12.7	4.76	5.16	0.8
	220412N-MU	●	●	●	●				1.2
	TNMG 160404N-EH	●	●	●	●	9.525	4.76	3.81	0.4
	160408N-EH	●	●	●	●				0.8
	160412N-EH	●	●	●	●				1.2
	TNMG 160408N-EM	●	●	●	●	9.525	4.76	3.81	0.8
	160412N-EM	●	●	●	●				1.2
	TNMG 330924N-EM	●	●	●	●				2.4
	TNMG 160404R-HM	●	●	●	●	9.525	4.76	3.81	0.4
	160404L-HM	●	●	●	●				0.4
	160408R-HM	●	●	●	●				0.8
	160408L-HM	●	●	●	●				0.8

◇ 负型 35°菱形

形状	型号	库存				尺寸 (mm)			
		AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	VNMG 160402N-FE	●	●	●	●	9.525	4.76	3.81	0.2
	160404N-FE	●	●	●	●				0.4
	160408N-FE	●	●	●	●				0.8
	160412N-FE	●	●	●	●				1.2
	VNMG 160402N-LU	●	●	●	●	9.525	4.76	3.81	0.2
	160404N-LU	●	●	●	●				0.4
	160408N-LU	●	●	●	●				0.8
	VNMG 160402N-SU	●	●	●	●	9.525	4.76	3.81	0.2
	160404N-SU	●	●	●	●				0.4
	160408N-SU	●	●	●	●				0.8
	VNMG 160402N-EF	●	●	●	●	9.525	4.76	3.81	0.2
	160404N-EF	●	●	●	●				0.4
	160408N-EF	●	●	●	●				0.8
	VNMG 160404N-EX	●	●	●	●	9.525	4.76	3.81	0.4
	160408N-EX	●	●	●	●				0.8
	VNMG 160404N-UP	●	●	●	●	9.525	4.76	3.81	0.4
	160408N-UP	●	●	●	●				0.8
	VNMG 160404N-GU	●	●	●	●	9.525	4.76	3.81	0.4
	160408N-GU	●	●	●	●				0.8
	160412N-GU	●	●	●	●				1.2
	VNMG 160404N-EG	●	●	●	●	9.525	4.76	3.81	0.4
	160408N-EG	●	●	●	●				0.8
	160412N-EG	●	●	●	●				1.2

△ 负型 六角形

形状	型号	库存				尺寸 (mm)			
		AC6020M	AC6030M	AC6135M 新到	AC6145M 新到	内切圆	厚度	孔径	刀尖半径
 FE	WNMG 060404N-FE	●	●	●	●	9.525	4.76	3.81	0.4
	060408N-FE	●	●	●	●				0.8
	WNMG 080402N-FE	●	●	●	●	12.7	4.76	5.16	0.2
	080404N-FE	●	●	●	●				0.4
	080408N-FE	●	●	●	●				0.8
080412N-FE	●	●	●	●	1.2				
 LU	WNMG 080404N-LU	●	●			12.7	4.76	5.16	0.4
	080408N-LU	●	●						0.8
	080412N-LU	●	●						1.2
 LUW	WNMG 060404N-LUW	●	●			9.525	4.76	3.81	0.4
	060408N-LUW	●	●						0.8
 LUW	WNMG 080404N-LUW	●	●			12.7	4.76	5.16	0.4
	080408N-LUW	●	●						0.8
	080412N-LUW	●	●						1.2
 SU	WNMG 060404N-SU	●	●	●	●	9.525	4.76	3.81	0.4
	060408N-SU	●	●	●	●				0.8
	060412N-SU	●	●	●	●				1.2
	WNMG 080404N-SU	●	●	●	●	12.7	4.76	5.16	0.4
080408N-SU	●	●	●	●	0.8				
080412N-SU	●	●	●	●	1.2				
 EF	WNMG 060404N-EF	●	●	●	●	9.525	4.76	3.81	0.4
	060408N-EF	●	●	●	●				0.8
	WNMG 080404N-EF	●	●	●	●	12.7	4.76	5.16	0.4
080408N-EF	●	●	●	●	0.8				
 EX	WNMG 080404N-EX	●	●	●	●	12.7	4.76	5.16	0.4
	080408N-EX	●	●	●	●				0.8
	080412N-EX	●	●	●	●				1.2
 UP	WNMG 080408N-UP	●	●	●	●	12.7	4.76	5.16	0.8
	080412N-UP	●	●	●	●				1.2
 GU	WNMG 060404N-GU	●	●	●	●	9.525	4.76	3.81	0.4
	060408N-GU	●	●	●	●				0.8
	060412N-GU	●	●	●	●				1.2
	WNMG 080404N-GU	●	●	●	●	12.7	4.76	5.16	0.4
	080408N-GU	●	●	●	●				0.8
080412N-GU	●	●	●	●	1.2				
 EG	WNMG 060408N-EG	●	●	●	●	9.525	4.76	3.81	0.8
	060412N-EG	●	●	●	●				1.2
	WNMG 080404N-EG	●	●	●	●	12.7	4.76	5.16	0.4
	080408N-EG	●	●	●	●				0.8
080412N-EG	●	●	●	●	1.2				
 MU	WNMG 080408N-MU	●	●			12.7	4.76	5.16	0.8
	080412N-MU	●	●						1.2
 EH	WNMG 080404N-EH			●	●	12.7	4.76	5.16	0.4
	080408N-EH			●	●				0.8
	080412N-EH			●	●				1.2
	080416N-EH			●	●				1.6
 EM	WNMG 080408N-EM	●	●	●	●	12.7	4.76	5.16	0.8
	080412N-EM	●	●	●	●				1.2

AC6020M/AC6030M/AC6135M/AC6145M

正型 80°菱形

形状	后角	型号	库存				尺寸 (mm)			
			AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	7	CCMT 060202N-LU	●	●	●	●	6.35	2.38	2.8	0.2
		060204N-LU	●	●	●	●				0.4
		CCMT 09T304N-LU	●	●	●	●	9.525	3.97	4.4	0.4
	7	CCMT 060202N-LB	●	●	●	●				0.2
		060204N-LB	●	●	●	●	6.35	2.38	2.8	0.4
		CCMT 09T302N-LB	●	●	●	●				0.2
	7	09T304N-LB	●	●	●	●	9.525	3.97	4.4	0.4
		09T308N-LB	●	●	●	●				0.8
		CCMT 060202N-SU	●	●	●	●	6.35	2.38	2.8	0.2
	7	060204N-SU	●	●	●	●				0.4
		060208N-SU	●	●	●	●				0.8
		CCMT 09T302N-SU	●	●	●	●				0.2
	7	09T304N-SU	●	●	●	●	9.525	3.97	4.4	0.4
		09T308N-SU	●	●	●	●				0.8
		CCMT 060204N-GU	●	●	●	●	6.35	2.38	2.8	0.4
	11	060208N-GU	●	●	●	●				0.8
		CCMT 09T304N-GU	●	●	●	●	9.525	3.97	4.4	0.4
		09T308N-GU	●	●	●	●				0.8
	11	CCMT 09T304N-MU	●	●	●	●	9.525	3.97	4.4	0.4
		09T308N-MU	●	●	●	●				0.8
		CPMT 090304N-LU	●	●	●	●	9.525	3.18	4.4	0.4
	11	090308N-LU	●	●	●	●				0.8
		CPMT 080204N-LB	●	●	●	●	7.94	2.38	3.4	0.4
		CPMT 090304N-LB	●	●	●	●	9.525	3.18	4.4	0.4
	11	090308N-LB	●	●	●	●				0.8
		CPMT 090304N-SU	●	●	●	●	9.525	3.18	4.4	0.4
		090308N-SU	●	●	●	●				0.8
	11	CPMT 090304N-GU	●	●	●	●	9.525	3.18	4.4	0.4
		090308N-GU	●	●	●	●				0.8
		CPMT 090304N-MU	●	●	●	●	9.525	3.18	4.4	0.4
	11	090308N-MU	●	●	●	●				0.8

正型 55°菱形

形状	后角	型号	库存				尺寸 (mm)			
			AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	7	DCMT 070202N-LU	●	●	●	●	6.35	2.38	2.8	0.2
		070204N-LU	●	●	●	●				0.4
		DCMT 11T302N-LU	●	●	●	●				0.2
	7	11T304N-LU	●	●	●	●	9.525	3.97	4.4	0.4
		11T308N-LU	●	●	●	●				0.8
		DCMT 070202N-LB	●	●	●	●				0.2
	7	070204N-LB	●	●	●	●	6.35	2.38	2.8	0.4
		070208N-LB	●	●	●	●				0.8
		DCMT 11T302N-LB	●	●	●	●				0.2
	7	11T304N-LB	●	●	●	●	9.525	3.97	4.4	0.4
		11T308N-LB	●	●	●	●				0.8
		DCMT 070202N-SU	●	●	●	●	6.35	2.38	2.8	0.2
	7	070204N-SU	●	●	●	●				0.4
		070208N-SU	●	●	●	●				0.8
		DCMT 11T302N-SU	●	●	●	●				0.2
	7	11T304N-SU	●	●	●	●	9.525	3.97	4.4	0.4
		11T308N-SU	●	●	●	●				0.8
		DCMT 070204N-GU	●	●	●	●	6.35	2.38	2.8	0.4
	7	070208N-GU	●	●	●	●				0.8
		DCMT 11T302N-GU	●	●	●	●				0.2
		11T304N-GU	●	●	●	●	9.525	3.97	4.4	0.4
	7	11T308N-GU	●	●	●	●				0.8
		11T312N-GU	●	●	●	●				1.2
		DCMT 11T304N-MU	●	●	●	●	9.525	3.97	4.4	0.4
	7	11T308N-MU	●	●	●	●				0.8

正型 正方形

形状	后角	型号	库存				尺寸 (mm)			
			AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	7	SCMT 09T304N-LU	●	●	●	●	9.525	3.97	4.4	0.4
		09T308N-LU	●	●	●	●				0.8
	7	SCMT 09T304N-LB	●	●	●	●	9.525	3.97	4.4	0.4
		09T308N-LB	●	●	●	●				0.8
	7	SCMT 09T304N-SU	●	●	●	●	9.525	3.97	4.4	0.4
		09T308N-SU	●	●	●	●				0.8
	7	SCMT 09T304N-GU	●	●	●	●	9.525	3.97	4.4	0.4
		09T308N-GU	●	●	●	●				0.8
	7	SCMT 09T308N-MU	●	●	●	●	9.525	3.97	4.4	0.8
	11	SPMT 090304N-LU	●	●	●	●	9.525	3.18	3.4	0.4
		090308N-LU	●	●	●	●				0.8
	11	SPMT 090304N-LB	●	●	●	●	9.525	3.18	3.4	0.4
		090308N-LB	●	●	●	●				0.8

正型 三角形

形状	后角	型号	库存				尺寸 (mm)			
			AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	7	TCMT 110204N-LU	●	●	●	●	6.35	2.38	2.8	0.4
		110208N-LU	●	●	●	●				0.8
	7	TCMT 110204N-LB	●	●	●	●	6.35	2.38	2.8	0.4
		110208N-LB	●	●	●	●				0.8
	7	TCMT 110204N-SU	●	●	●	●	6.35	2.38	2.8	0.4
		110208N-SU	●	●	●	●				0.8
	7	TCMT 16T304N-SU	●	●	●	●	9.525	3.97	4.3	0.4
		16T308N-SU	●	●	●	●				0.8
	11	TPMT 080202N-LU	●	●	●	●	4.76	2.38	2.4	0.2
		080204N-LU	●	●	●	●				0.4
	11	TPMT 110302N-LU	●	●	●	●	6.35	3.18	3.4	0.4
		110304N-LU	●	●	●	●				0.8
	11	110308N-LU	●	●	●	●				0.8
		TPMT 080202N-LB	●	●	●	●	4.76	2.38	2.4	0.2
	11	080204N-LB	●	●	●	●				0.4
		TPMT 090202N-LB	●	●	●	●	5.56	2.38	2.8	0.2
	11	090204N-LB	●	●	●	●				0.4
		TPMT 110302N-LB	●	●	●	●	6.35	3.18	3.4	0.4
	11	110304N-LB	●	●	●	●				0.8
		110308N-LB	●	●	●	●				0.8
	11	TPMT 160304N-LB	●	●	●	●	9.525	3.18	4.4	0.4
		160308N-LB	●	●	●	●				0.8
	11	TPMT 160404N-LB	●	●	●	●	9.525	4.76	4.4	0.4
		160408N-LB	●	●	●	●				0.8
	11	TPMT 080202N-SU	●	●	●	●	4.76	2.38	2.4	0.2
		080204N-SU	●	●	●	●				0.4
	11	TPMT 110302N-SU	●	●	●	●	6.35	3.18	3.4	0.4
		110304N-SU	●	●	●	●				0.8
	11	110308N-SU	●	●	●	●				0.8
		TPMT 160404N-SU	●	●	●	●	9.525	4.76	4.4	0.4
	11	160408N-SU	●	●	●	●				0.8
		TPMT 110304N-GU	●	●	●	●	6.35	3.18	3.4	0.4
	11	110308N-GU	●	●	●	●				0.8
		TPMT 160404N-GU	●	●	●	●	9.525	4.76	4.4	0.4</

AC6020M/AC6030M/AC6135M/AC6145M

正型 35°菱形

形状	后角	型号	库存				尺寸 (mm)			
			AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	5	VBMT 110304N-LU	●	●	●	●	6.35	3.18	2.8	0.4
		110308N-LU	●	●	●	●	6.35	3.18	2.8	0.8
		VBMT 160404N-LU	●	●	●	●	9.525	4.76	4.4	0.4
		160408N-LU	●	●	●	●	9.525	4.76	4.4	0.8
	5	VBMT 110302N-LB	●	●	●	●	6.35	3.18	2.8	0.2
		110304N-LB	●	●	●	●	6.35	3.18	2.8	0.4
		110308N-LB	●	●	●	●	6.35	3.18	2.8	0.8
		VBMT 160404N-LB	●	●	●	●	9.525	4.76	4.4	0.4
	5	160408N-LB	●	●	●	●	9.525	4.76	4.4	0.8
		160412N-LB	●	●	●	●	9.525	4.76	4.4	1.2
	5	VBMT 110302N-SU	●	●	●	●	6.35	3.18	2.8	0.2
		110304N-SU	●	●	●	●	6.35	3.18	2.8	0.4
		110308N-SU	●	●	●	●	6.35	3.18	2.8	0.8
		VBMT 160404N-SU	●	●	●	●	9.525	4.76	4.4	0.4
	5	160408N-SU	●	●	●	●	9.525	4.76	4.4	0.8
		VBMT 110304N-GU	●	●	●	●	6.35	3.18	2.8	0.4
		110308N-GU	●	●	●	●	6.35	3.18	2.8	0.8
		VBMT 160404N-GU	●	●	●	●	9.525	4.76	4.4	0.4
	7	160408N-GU	●	●	●	●	9.525	4.76	4.4	0.8
		VCMT 160404N-LU	●	●	●	●	9.525	4.76	4.4	0.4
		160408N-LU	●	●	●	●	9.525	4.76	4.4	0.8
		VCMT 080202N-LB	●	●	●	●	4.76	2.38	2.3	0.2
	7	080204N-LB	●	●	●	●	4.76	2.38	2.3	0.4
		VCMT 160404N-LB	●	●	●	●	9.525	4.76	4.4	0.4
		160408N-LB	●	●	●	●	9.525	4.76	4.4	0.8
		VCMT 080204N-SU	●	●	●	●	4.76	2.38	2.3	0.4
	7	VCMT 110302N-SU	●	●	●	●	6.35	3.18	2.8	0.2
		110304N-SU	●	●	●	●	6.35	3.18	2.8	0.4
		110308N-SU	●	●	●	●	6.35	3.18	2.8	0.8
		VCMT 160404N-SU	●	●	●	●	9.525	4.76	4.4	0.4
	7	160408N-SU	●	●	●	●	9.525	4.76	4.4	0.8
		VCMT 160404N-GU	●	●	●	●	9.525	4.76	4.4	0.4
		160408N-GU	●	●	●	●	9.525	4.76	4.4	0.8
		VCMT 160404N-GU	●	●	●	●	9.525	4.76	4.4	0.8

正型 六角形

形状	后角	型号	库存				尺寸 (mm)			
			AC6020M	AC6030M	AC6135M	AC6145M	内切圆	厚度	孔径	刀尖半径
	11	WPMT 110204N-LB	●	●	●	●	6.35	2.38	2.8	0.4
		WPMT 160308N-LB	●	●	●	●	9.525	3.18	4.4	0.8

AC6020M/AC6030M/AC6135M/AC6145M

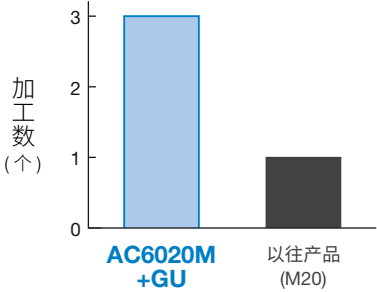
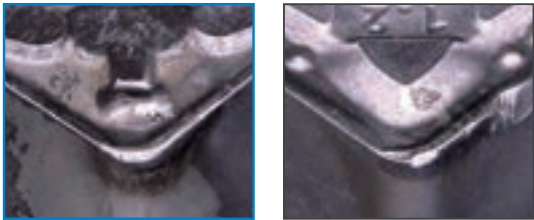
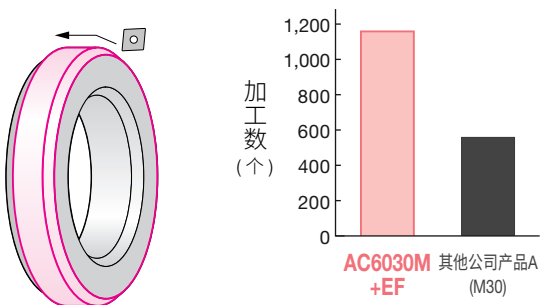
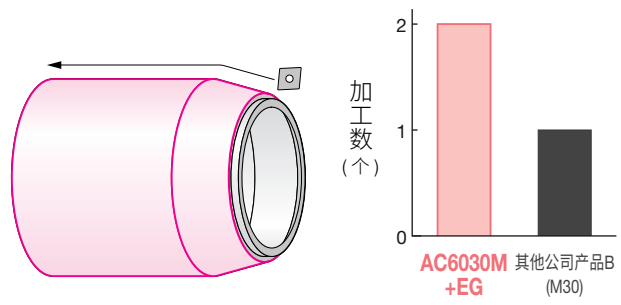
■ 推荐切削条件

(红字表示第1推荐)

被削材	切削状态	断屑槽	材质	切削条件		
				切深 ap(mm)	进给量 f(mm/rev)	切削速度 vc(m/min)
铁素体类 SUS405 SUS410L SUS430等	精加工	EF(SU)	AC6020M	0.5 - 1.5 - 2.0	0.05 - 0.15 - 0.25	170 - 230 - 300
	连续	EG·GU·EX	AC6030M	1.0 - 2.5 - 4.0	0.10 - 0.25 - 0.40	140 - 170 - 250
	部分断续	GU·EH	AC6135M	1.0 - 3.0 - 5.0	0.20 - 0.35 - 0.50	140 - 170 - 200
	断续	EH·EM	AC6145M	1.5 - 3.5 - 6.0	0.25 - 0.40 - 0.60	100 - 130 - 160
马氏体类 SUS410 SUS420J2 SUS440C等	精加工	EF(SU)	AC6020M	0.5 - 1.5 - 2.0	0.05 - 0.15 - 0.25	120 - 180 - 240
	连续	EG·GU·EX	AC6030M	1.0 - 2.5 - 4.0	0.10 - 0.25 - 0.40	100 - 150 - 200
	部分断续	GU·EH	AC6135M	1.0 - 3.0 - 5.0	0.20 - 0.35 - 0.50	80 - 130 - 180
	断续	EH·EM	AC6145M	1.5 - 3.5 - 6.0	0.25 - 0.40 - 0.60	60 - 100 - 140
奥氏体类 SUS304 SUS316 SUS321等	精加工	EF(SU)·EX	AC6030M	0.5 - 1.5 - 2.0	0.05 - 0.15 - 0.25	120 - 180 - 240
	连续	EG·GU	AC6135M	1.0 - 2.5 - 4.0	0.10 - 0.25 - 0.40	100 - 150 - 200
	部分断续	GU·EH	AC6135M	1.0 - 3.0 - 5.0	0.20 - 0.35 - 0.50	80 - 130 - 180
	断续	EH·EM	AC6145M	1.5 - 3.5 - 6.0	0.25 - 0.40 - 0.60	60 - 100 - 140
双相类 SUS329J1 SUS329J3L SUS329J4L等	精加工	EF(SU)·EX	AC6030M	0.5 - 1.5 - 2.0	0.05 - 0.15 - 0.25	100 - 140 - 180
	连续	EG·GU	AC6135M	1.0 - 2.5 - 4.0	0.10 - 0.25 - 0.40	80 - 120 - 160
	部分断续	GU·EH	AC6135M	1.0 - 3.0 - 5.0	0.20 - 0.35 - 0.50	70 - 100 - 140
	断续	EH·EM	AC6145M	1.5 - 3.5 - 6.0	0.25 - 0.40 - 0.60	50 - 80 - 120
沉淀硬化类 SUS630 SUS631 SUS632J1等	精加工	EF(SU)	AC6020M	0.5 - 1.5 - 2.0	0.05 - 0.15 - 0.25	90 - 115 - 140
	连续	EG·GU·EX	AC6030M	1.0 - 2.5 - 4.0	0.10 - 0.25 - 0.40	70 - 90 - 130
	部分断续	GU·EH	AC6135M	1.0 - 3.0 - 5.0	0.20 - 0.35 - 0.50	50 - 80 - 120
	断续	EH·EM	AC6145M	1.5 - 3.5 - 6.0	0.25 - 0.40 - 0.60	40 - 70 - 100

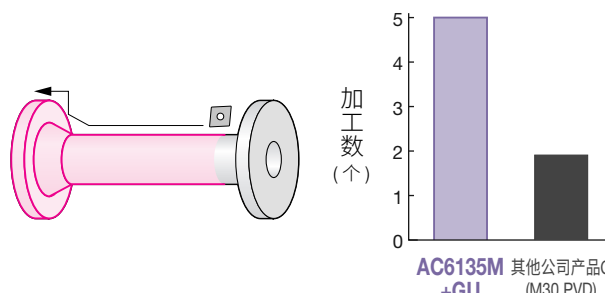
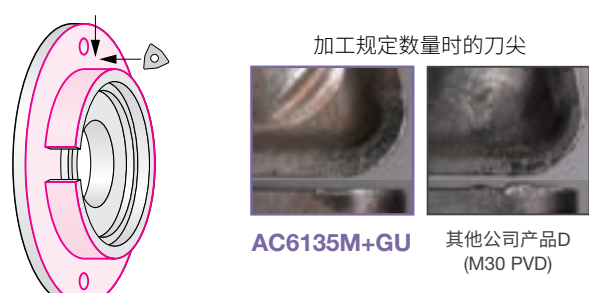
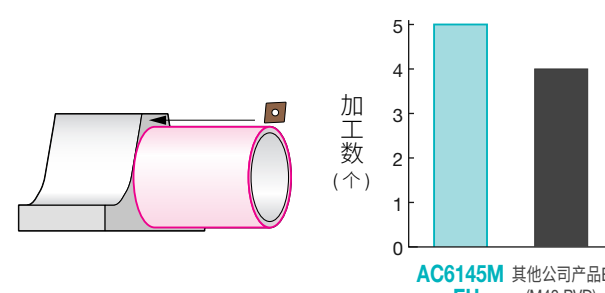
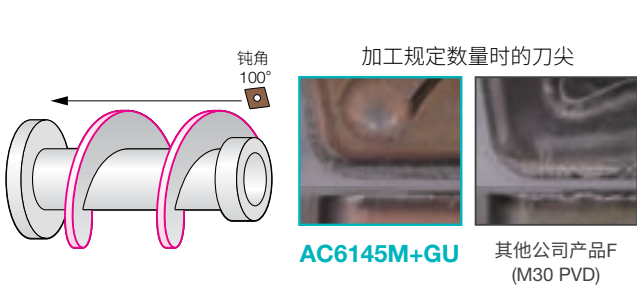
AC6020M/AC6030M/AC6135M/AC6145M

■ AC6020M / AC6030M的使用实例

SUS316 零件 AC6020M M	SUS316L 壳体 AC6020M M
AC6020M耐磨损性优良, 寿命提升至3倍  使用刀具: CNMG120408N-GU(AC6020M)连续加工 切削条件: $vc=180\text{m/min}$ $f=0.25\text{mm/rev}$ $ap=3.0\text{mm}$ Wet	AC6020M耐小崩口性优异, 寿命延长30%  使用刀具: SNMG120412N-GU(AC6020M)连续加工 切削条件: $vc=180\text{m/min}$ $f=0.25\text{mm/rev}$ $ap=2.5\text{mm}$ Wet
SUS430 摩托车零件 AC6030M M	SCS11 泵零件 AC6030M M
AC6030M凭借优良的耐溶着性, 实现了稳定的加工面品质, 寿命达2倍  使用刀具: CNMG120404N-EF(AC6030M)连续加工 切削条件: $vc=120\text{m/min}$ $f=0.1\text{mm/rev}$ $ap=0.8-1.5\text{mm}$ Wet	AC6030M效率提高至2.5倍($vc=60 \rightarrow 100\text{m/min}$, $f=0.2 \rightarrow 0.3\text{mm/rev}$), 寿命达2倍  使用刀具: CNMG120408N-EG(AC6030M)连续加工 切削条件: $vc=100\text{m/min}$ $f=0.3\text{mm/rev}$ $ap=0.5\text{mm}$ Wet

AC6020M/AC6030M/AC6135M/AC6145M

■ AC6135M / AC6145M的使用实例

SUS316L 管	AC6135M M	SUS316L 法兰	AC6135M M
AC6135M抑制月牙洼磨损, 寿命提升至2.5倍  加工数 (个) AC6135M+GU 其他公司产品C (M30 PVD)		AC6135M抑制月牙洼磨损和溶着, 实现稳定加工  加工规定数量时的刀尖 AC6135M+GU 其他公司产品D (M30 PVD)	
使用刀具: CNMG120408N-GU(AC6135M) 切削条件: $vc=150\text{m/min}$ $f=0.25\text{mm/rev}$ $ap=1.5\text{mm}$ Wet		使用刀具: WNMG080408N-GU(AC6135M) 切削条件: $vc=130\text{m/min}$ $f=0.15\text{mm/rev}$ $ap=1.0\text{mm}$ Wet	
SCS16 气门	AC6145M M	SUS316L 螺钉	AC6145M M
AC6145M抑制崩损, 寿命提升至1.3倍  加工数 (个) AC6145M+EH 其他公司产品E (M40 PVD)		AC6145M抑制小崩口和热龟裂, 实现稳定加工  钝角 100° 加工规定数量时的刀尖 AC6145M+GU 其他公司产品F (M30 PVD)	
使用刀具: CNMG120408N-EH(AC6145M)断续加工 切削条件: $vc=110\text{m/min}$ $f=0.15\text{mm/rev}$ $ap=1.0\text{mm}$ Wet		使用刀具: CNMG120412N-GU(AC6145M)断续加工 切削条件: $vc=110\text{m/min}$ $f=0.15\text{mm/rev}$ $ap=1.5\text{mm}$ Wet	



● 加工时会出现高温切屑飞散、排出切屑过长等情况，请使用安全罩壳及防护眼镜等防护具，并务必注意防火、防灾。

● Very hot or lengthy chips may be discharged while the machine is in operation. Therefore, machine guards, safety goggles or other protective covers must be used. Fire safety precautions must also be considered.

● 使用时请务必小心锋利刀尖。
● 使用方法错误、使用条件不当，会造成刀具崩损、飞散，请在推荐的范围内使用。

● Please handle with care as this product has sharp edges.
● Improper cutting conditions or mis-handling of the tool may result in breakages or projectiles. Therefore, please use the tool within its recommended conditions.

● 使用非水溶性切削油的情况下，为防止火灾意外，请配置自动灭火装置。

● When using non-water soluble cutting oil, precautions against fire must be taken and please ensure that a fire extinguisher is placed near the machine.



住友电工硬质合金贸易(上海)有限公司

华东地区

住友电工硬质合金贸易(上海)有限公司总公司

住友电工硬质合金贸易(上海)有限公司宁波分公司

住友电工硬质合金贸易(上海)有限公司南京分公司

住友电工硬质合金贸易(上海)有限公司常州分公司

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华北地区

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住友电工硬质合金贸易(上海)有限公司天津分公司

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电话：022-8494-9495 传真：022-8494-9493

地址：郑州市郑东新区商务外环路14号路劲大厦622室(邮编：450003)

电话：138-1084-8075

东北地区

住友电工硬质合金贸易(上海)有限公司大连分公司

住友电工硬质合金贸易(上海)有限公司长春分公司

住友电工硬质合金贸易(上海)有限公司沈阳事务所

地址：大连市开发区金马路128号天成国际金融中心1911室(邮编：116600)

电话：0411-8792-6266 传真：0411-8792-6277

地址：长春市朝阳区人民大街3299号宏汇国际广场1510室(邮编：130012)

电话：0431-8191-6558 传真：0431-8191-6559

地址：辽宁省沈阳市铁西区建设西路2甲号长峰中心1309A(邮编：110075)

电话：024-8889-1040

西南地区

住友电工硬质合金贸易(上海)有限公司重庆分公司

住友电工硬质合金贸易(上海)有限公司成都分公司

住友电工硬质合金贸易(上海)有限公司武汉分公司

地址：重庆市江北区建新北路一支路6号未来国际大厦9-1(邮编：400020)

电话：023-6785-7656 传真：023-6785-7780

地址：四川省成都市锦江区东大街577号环球贸易广场ICC一期904室(邮编：610016)

电话：028-8445-6626 传真：028-8443-6625

地址：武汉市硚口区京汉大道688号武汉恒隆广场办公楼1304室(邮编：430077)

电话：027-8711-0060 传真：027-8711-0090

华南地区

住友电工硬质合金贸易(上海)有限公司广州分公司

住友电工硬质合金贸易(上海)有限公司厦门分公司

地址：广州市天河区林和西路3-15号耀中广场A座2221室(邮编：510610)

电话：020-3891-0442 传真：020-3891-0449

地址：厦门市思明区莲花北路1号磐基莲华里1805室(邮编：362000)

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