

住友CBN **BN1000/BN2000**

SUMIBORON BN1000 / BN2000 第7版



BN1000

CONTINUOUS CUTTING

CUTTING SPEED : 80 - 250 m/min
FEED RATE : 0.03 - 0.15 mm/rev
DEPTH OF CUT : 0.03 - 0.20 mm

兼具耐崩损性与耐磨损性，实现稳定的寿命

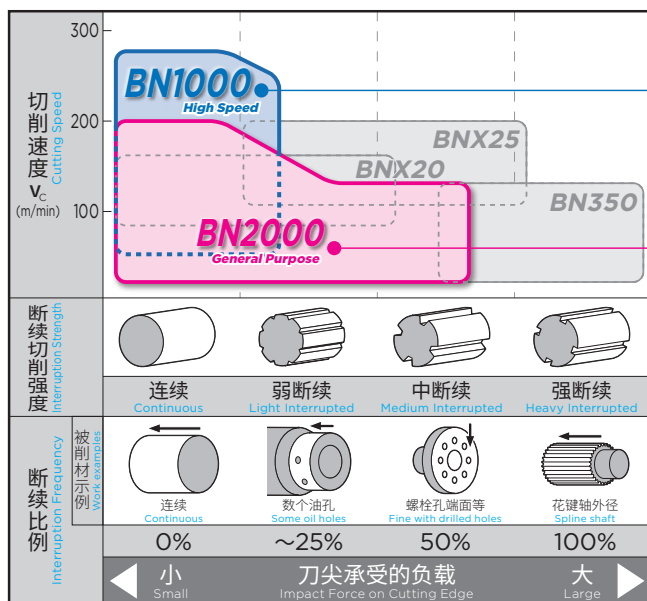
Realizes steady tool life with excellent breakage and wear resistance.

BN2000

GENERAL PURPOSE

CUTTING SPEED : 50 - 200 m/min
FEED RATE : 0.03 - 0.25 mm/rev
DEPTH OF CUT : 0.03 - 0.30 mm

适用领域 Application Range



BN1000

Un Coated

最适合连续~弱断续加工
并重视耐磨损性的无涂层SUMIBORON

Uncoated SUMIBORON with excellent wear resistance is perfect for continuous to light interrupted machining.

BN2000

Un Coated

适用于淬火钢各种加工, 从通用材料
连续~中断续切削, 均可获得稳定的刀具寿命
而且, 实现了高层次的耐崩损性和耐磨损性,
不仅备有不重磨刀片, 还新增了刀片断屑槽
及修光刃刀片

General-purpose CBN series for machining all kinds of hardened steel. Excellent tool life in continuous to middle interrupted cut. Realizes high-level breakage and wear resistance. The product lineup offers chip breakers and wiper inserts in addition to one-use inserts.

BN1000 / BN2000 的特点

Feature of BN1000 / BN2000

- 采用高纯度陶瓷粘结剂
- 兼具耐崩损性与耐磨损性, 实现稳定的寿命
- 价格优惠的不重磨刀片(单切削刃型)备有库存
 - Adopts the high-purity ceramic binder.
 - Realizes steady tool life with excellent breakage and wear resistance.
 - Affordable one-use inserts (one corner type) are in stock.

新开发的高纯度陶瓷粘结剂 Newly Developed High-Purity Ceramic Binder

以往材质 Conventional Grade

以往材质的陶瓷粘结剂中含有的不纯物导致烧结体强度和耐热性降低, 是引起龟裂(崩损)和磨损的主要原因。

The impurities contained in the ceramic binder for conventional grades brings about a strengthening in the sintered body and a decrease in heat resistance, which becomes the cause of cracks (chipping) and wear.

陶瓷粘结剂 Ceramic Binder

产生龟裂 Cracks

磨损加剧 / 刃口切削性变差 Increased Wear / Reduced Sharpness

CBN

不纯物 Impurities

BN1000 / BN2000

BN1000 / BN2000 采用“高纯度陶瓷粘结剂”, 将不纯物减少至最低限度, 提高了耐热性, 并获得了强韧性!

With the high-purity ceramic binder, the BN2000 achieve toughness and improved heat resistance by decreasing impurities to an extreme!

高纯度陶瓷粘结剂 High-purity Ceramic Binder

CBN

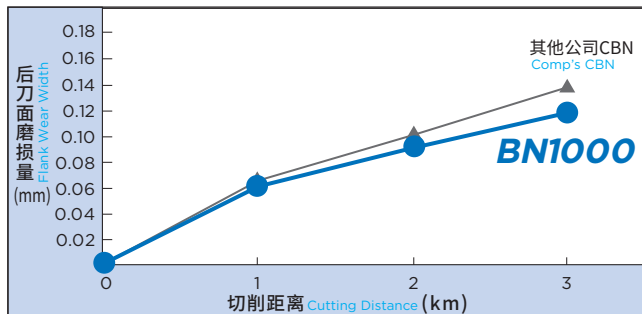
推荐切削条件 Recommended Cutting Conditions

用途 Application	材质 Grade	切削速度 Cutting speed v_c (m/min)						f (mm/rev)	a_p (mm)	切削液 Coolant
		50	(80)	100	(120)	150	200			
高速切削 High speed cutting	BN1000							0.03 ~ 0.15	0.03 ~ 0.20	连续切削: Dry/Wet Continuous Cut: Dry / Wet
通用切削 General purpose	BN2000							0.03 ~ 0.20	0.03 ~ 0.30	断续切削: Dry Interrupted Cut: Dry

BN1000 / BN2000 的切削性能 Cutting performance

● BN1000 的耐磨损性(连续切削)

Wear Resistance (Continuous Cut)

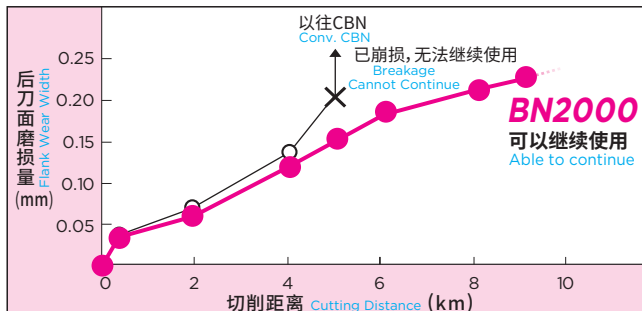


被削材 Work Material: SUJ2 圆棒 Round Bar (58-62HRC)
切削条件 Cutting Conditions: $v_c=150\text{m/min}$, $f=0.1\text{mm/rev}$, $a_p=0.2\text{mm}$, Dry

BN1000 与其他公司的CBN相比, 耐磨损性更优异
Realizes exceptionally high wear resistance compared to competitors' CBN

● BN2000 的耐磨损性(连续切削)

Wear Resistance (Continuous Cutting)

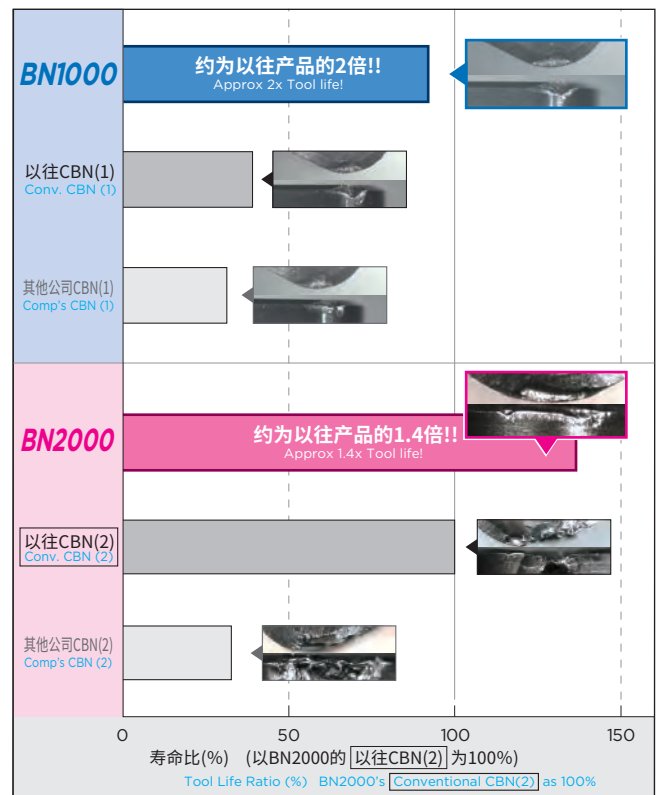


被削材 Work Material: SCM415H 圆棒 Round Bar (58-62HRC)
切削条件 Cutting Conditions: $v_c=100\text{m/min}$, $f=0.1\text{mm/rev}$, $a_p=0.2\text{mm}$, Dry

BN2000 提高耐磨损性, 凭借特别优良的耐月牙洼磨损性延长崩损寿命
Improved wear resistance, crater wear resistance in particular, improves tool life.

● BN1000 / BN2000 的耐小崩口性(断续切削)

Chipping Resistance (Interrupted Cut)



被削材 Work Material: SCM415H 8条V形槽材料 8V Grooved (58-62HRC)
刀具型号 Insert: 2NU-CNGA120408
切削条件 Cutting Conditions: $v_c=150\text{m/min}$, $f=0.1\text{mm/rev}$, $a_p=0.2\text{mm}$, Dry

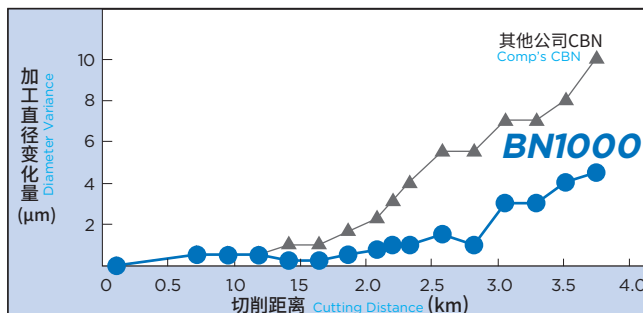
BN1000 既重视耐磨损性, 也大幅改善了耐崩损性
Significantly improves breakage resistance while maintaining wear resistance.

BN2000 与以往产品相比, 耐崩损性更优异
Realizes higher breakage resistance compared to conventional products.

BN1000 / BN2000 的加工精度 Cutting Precision

● BN1000 的尺寸精度比较(连续切削)

Size Accuracy Comparison (Continuous Cut)

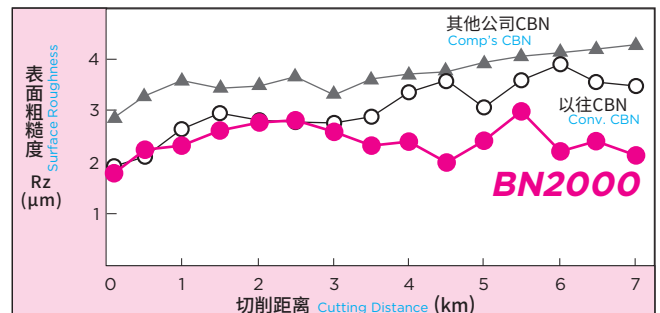


被削材 Work Material: SCM415H $\phi 130$ 外径(58-62HRC)
刀具型号 Insert: 2NU-CNGA120408
切削条件 Cutting Conditions: $v_c=200\text{m/min}$, $f=0.1\text{mm/rev}$, $a_p=0.1\text{mm}$, Wet

BN1000 与其他公司的CBN相比, 尺寸精度更稳定
Stable size accuracy compared to competitors' CBN.

● BN2000 的表面粗糙度比较(连续切削)

Surface Roughness Comparison (Continuous Cut)



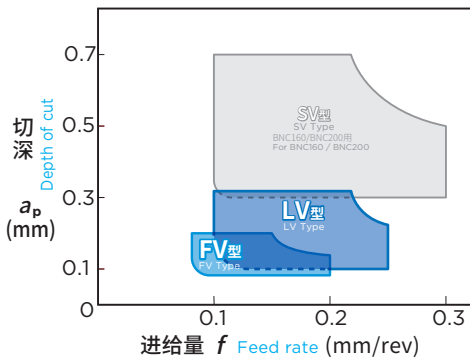
被削材 Work Material: SCM415H 圆棒 Round Bar (58-62HRC)
刀具型号 Insert: 2NU-CNGA120408
切削条件 Cutting Conditions: $v_c=100\text{m/min}$, $f=0.08\text{mm/rev}$, $a_p=0.2\text{mm}$, Dry

BN2000 刀尖切削性得以提高, 表面粗糙度从切削开始时就保持稳定
Improved sharp cutting edges stabilize surface roughness from the start of cutting.

Break Master FV型/LV型 BREAK MASTER FV Type / LV Type **BN2000**

- 最适合淬火钢精加工的切屑处理的刀片断屑槽
- 采用独特设计的断屑槽形状，从淬火部分到未淬火部分均可进行切屑处理
 - Chip breaker perfect for chip removal in hardened metal finishing.
 - Original breaker shape design enables chip removal for both hardened and unhardened parts.

●适用范围 Application Range



LV型 轻切削用 LV type for Light cut
切深量小于0.3mm时，发挥优良的切屑处理性能
Realizes excellent chip removal performance under a depth of cut (a_p) of 0.3 mm or less.

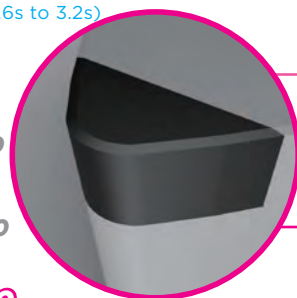
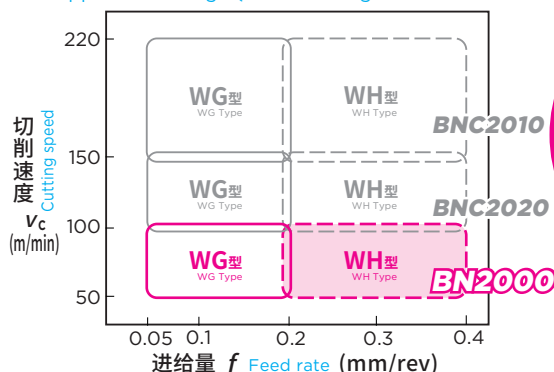
FV型 精切削用 FV type for Finishing
切深量小于0.2mm时，发挥优良的切屑处理性能
Realizes excellent chip removal performance under a depth of cut (a_p) of 0.2 mm or less.

一次性修光刃刀片WG型/WH型 One-Use Wiper insert WG type / WH type **BN2000**

- 采用淬火钢加工用修光刃刀片，实现堪比磨削加工的优异表面粗糙度
- 备有低进给加工用 WG型、高进给加工用 WH型
 - Wiper insert for hardened steel enabling excellent surface roughness equal to grinding processing.
 - Lineup offers WG type for low-feed and WH type for high-feed.

●适用范围(表面粗糙度规格1.6s~3.2s)

Application Range (Surface Roughness Standard: 1.6s to 3.2s)



WG型 低进给用 WG type for low-feed
推荐进给量(f) 0.2mm/rev以下
Feed rate (f) = 0.2 mm/rev or less recommended.

WH型 高进给用 WH type for high-feed
推荐进给量(f) 0.2mm/rev以上
Feed rate (f) = 0.2 mm/rev or more recommended.

- 为最大限度发挥修光刃的效果，推荐用于连续切削。
- 可能会发生起伏或振刀，因此请用于高刚性的机械和被削材。
- To maximize the advantage of wiper cutting edges, we recommend using this series in continuous cut.
- Use this series with high-rigid machinery and work material, or waving or chattering may occur.

特殊刀尖处理规格 Special Cutting Edge Preparation **BN2000**

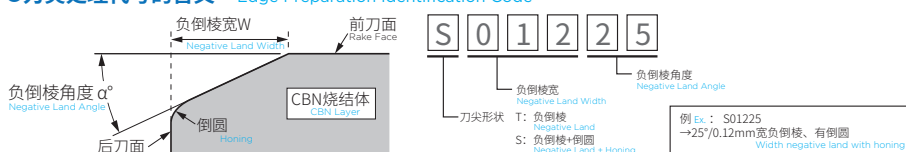
- SUMIBORON BN2000除标准刀尖规格外，最适合特定加工领域的特殊刀尖规格也已经形成系列。请先使用标准刀尖规格的刀具，根据加工结果，再试用特殊刀尖规格产品。

In addition to the standard cutting-edge version, the special cutting-edge version of SUMIBORON BN2000 is also available, optimized for specific machining purposes. We recommend first machining with the standard cutting edge; then, depending on the results, try the special cutting edge.

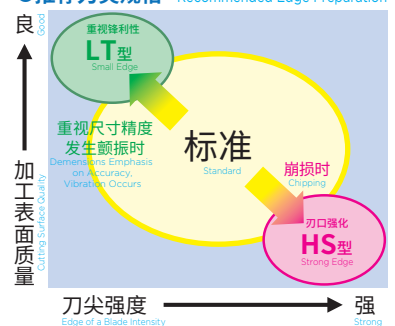
●BN2000的刀尖规格 Edge Preparation of BN2000

	重视锋利型: LT型 Small Edge Type: LT				通用型: 标准型 General Purpose: Standard				刀尖强化型: HS型 Strong Edge Type: HS			
	刀尖处理代号 Edge Preparation Code	α	W	倒圆 Honing	刀尖处理代号 Edge Preparation Code	α	W	倒圆 Honing	刀尖处理代号 Edge Preparation Code	α	W	倒圆 Honing
负型 Negative	T01215	15°	0.12	无 No	S01225	25°	0.12	有 Yes	S01235	35°	0.12	有 Yes
正型 Positive	T01215	15°	0.12	无 No	S01225	25°	0.12	有 Yes	S01235	35°	0.12	有 Yes

●刀尖处理代号的含义 Edge Preparation Identification Code



●推荐刀尖规格 Recommended Edge Preparation



※致使用以往材质“BN250”的各位用户 For users of conventional grade BN250:

以往材质“BN250”的正型刀片的标准刀尖规格是“S01235”，“BN2000”已改为“S01225”。
随着材质变更为“BN2000”，而刀尖规格不想变更时，请选用“刀尖强化的HS型”。
The BN2000 standard cutting edge is S01225, while that of conventional grade BN250 positive inserts is S01235.
When shifting to BN2000, if you wish to continue using the same cutting-edge version, select HS with a tough cutting edge.

	BN250标准 BN250 Standard			
	刀尖处理代号 Identification Code	α	W	倒圆 Honing
负型 Negative	S01225	25°	0.12	有 Yes
正型 Positive	S01235	35°	0.12	有 Yes



BN1000/BN2000的库存型号

BN1000 / BN2000 Stock Items

■多角型一次性刀片/负型(带孔)

Multi-cornered,One-use Type/Negative (With Hole)

外观 Shape	型号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺寸 Dimensions (mm)				
		BN1000	BN2000		烧结合切 削长度 Grinding edge length	内切圆 Island circle	厚度 Thickness	孔径 Hole	刀尖 半径 Nose radius
	2NU-CNGA120404	●	●	2	2.5	12.7	4.76	5.16	0.4
	120408	●	●	2	2.4	12.7	4.76	5.16	0.8
	120412	●	●	2	2.3	12.7	4.76	5.16	1.2
	2NU-CNGA120404WG	—	●	2	2.4	12.7	4.76	5.16	0.4
	120408WG	—	●	2	2.4	12.7	4.76	5.16	0.8
	120412WG	—	●	2	2.3	12.7	4.76	5.16	1.2
	2NU-CNGA120404WH	—	●	2	2.4	12.7	4.76	5.16	0.4
	120408WH	—	●	2	2.3	12.7	4.76	5.16	0.8
	120412WH	—	●	2	2.2	12.7	4.76	5.16	1.2
	2NU-DNGA150404	●	●	2	2.5	12.7	4.76	5.16	0.4
	150408	●	●	2	2.1	12.7	4.76	5.16	0.8
	150412	●	●	2	2.0	12.7	4.76	5.16	1.2
	2NU-DNGA150404WG	—	●	2	2.3	12.7	4.76	5.16	0.4
	150408WG	—	●	2	2.0	12.7	4.76	5.16	0.8
	2NU-DNGA150404WH	—	●	2	2.1	12.7	4.76	5.16	0.4
	150408WH	—	●	2	1.8	12.7	4.76	5.16	0.8
	2NU-SNGA120404	●	●	2	2.5	12.7	4.76	5.16	0.4
	120408	●	●	2	2.3	12.7	4.76	5.16	0.8
	120412	●	●	2	2.1	12.7	4.76	5.16	1.2
	3NU-TNGA160404	●	●	3	2.3	9.525	4.76	3.81	0.4
	160408	●	●	3	2.0	9.525	4.76	3.81	0.8
	160412	●	●	3	2.0	9.525	4.76	3.81	1.2
	2NU-VNGA160404	●	●	2	2.8	9.525	4.76	3.81	0.4
	160408	●	●	2	2.0	9.525	4.76	3.81	0.8

※型号末尾 WG: 低进给用一次性修光刀刀片 WH: 高进给用一次性修光刀刀片
WG: One-Use Wiper insert for Low-feed type WH: One-Use Wiper insert for High-feed type

■多角型一次性刀片/负型(带孔)

Multi-cornered,One-use Type/Negative (With Hole)

重视锋利的LT型

Small Edge Type LT

外观 Shape	型号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺寸 Dimensions (mm)				
		BN1000	BN2000		烧结合切 削长度 Grinding edge length	内切圆 Island circle	厚度 Thickness	孔径 Hole	刀尖 半径 Nose radius
	2NU-CNGA120404LT	—	●	2	2.5	12.7	4.76	5.16	0.4
	120408LT	—	●	2	2.5	12.7	4.76	5.16	0.8
	120412LT	—	●	2	2.5	12.7	4.76	5.16	1.2
	2NU-DNGA150404LT	—	●	2	2.5	12.7	4.76	5.16	0.4
	150408LT	—	●	2	2.1	12.7	4.76	5.16	0.8
	150412LT	—	●	2	2.0	12.7	4.76	5.16	1.2
	2NU-SNGA120404LT	—	●	2	2.5	12.7	4.76	5.16	0.4
	120408LT	—	●	2	2.3	12.7	4.76	5.16	0.8
	120412LT	—	●	2	2.1	12.7	4.76	5.16	1.2
	3NU-TNGA160404LT	—	●	3	2.3	9.525	4.76	3.81	0.4
	160408LT	—	●	3	2.0	9.525	4.76	3.81	0.8
	160412LT	—	●	3	2.0	9.525	4.76	3.81	1.2
	2NU-VNGA160404LT	—	●	2	2.8	9.525	4.76	3.81	0.4
	160408LT	—	●	2	2.8	9.525	4.76	3.81	0.8

■多角型一次性刀片/负型(带孔)

Multi-cornered,One-use Type/Negative (With Hole)

刀尖强化的HS型

Strong Edge Type HS

外观 Shape	型号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺寸 Dimensions (mm)				
		BN1000	BN2000		烧结合切 削长度 Grinding edge length	内切圆 Island circle	厚度 Thickness	孔径 Hole	刀尖 半径 Nose radius
	2NU-CNGA120404HS	—	●	2	2.5	12.7	4.76	5.16	0.4
	120408HS	—	●	2	2.4	12.7	4.76	5.16	0.8
	120412HS	—	●	2	2.3	12.7	4.76	5.16	1.2
	2NU-DNGA150404HS	—	●	2	2.5	12.7	4.76	5.16	0.4
	150408HS	—	●	2	2.1	12.7	4.76	5.16	0.8
	150412HS	—	●	2	2.0	12.7	4.76	5.16	1.2
	2NU-SNGA120404HS	—	●	2	2.5	12.7	4.76	5.16	0.4
	120408HS	—	●	2	2.3	12.7	4.76	5.16	0.8
	120412HS	—	●	2	2.1	12.7	4.76	5.16	1.2
	3NU-TNGA160404HS	—	●	3	2.3	9.525	4.76	3.81	0.4
	160408HS	—	●	3	2.0	9.525	4.76	3.81	0.8
	160412HS	—	●	3	2.0	9.525	4.76	3.81	1.2
	2NU-VNGA160404HS	—	●	2	2.8	9.525	4.76	3.81	0.4
	160408HS	—	●	2	2.0	9.525	4.76	3.81	0.8

■多角型一次性刀片/负型(带孔)

Multi-cornered,One-use Type/Negative (With Hole)

Break Master LV型

Breakmaster Type LV

外观 Shape	型号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺寸 Dimensions (mm)				
		BN1000	BN2000		烧结合切 削长度 Grinding edge length	内切圆 Island circle	厚度 Thickness	孔径 Hole	刀尖 半径 Nose radius
	2NU-CNGM120404N-LV	—	●	2	2.5	12.7	4.76	5.16	0.4
	120408N-LV	—	●	2	2.1	12.7	4.76	5.16	0.8
	120412N-LV	—	●	2	2.0	12.7	4.76	5.16	1.2
	2NU-DNGM150404N-LV	—	●	2	2.5	12.7	4.76	5.16	0.4
	150408N-LV	—	●	2	2.1	12.7	4.76	5.16	0.8
	150412N-LV	—	●	2	2.0	12.7	4.76	5.16	1.2
	3NU-TNGM160404N-LV	—	●	3	2.3	9.525	4.76	3.81	0.4
	160408N-LV	—	●	3	2.0	9.525	4.76	3.81	0.8
	160412N-LV	—	●	3	2.0	9.525	4.76	3.81	1.2
	2NU-VNGM160404N-LV	—	●	2	2.8	9.525	4.76	3.81	0.4
	160408N-LV	—	●	2	2.0	9.525	4.76	3.81	0.8

※型号末尾 LV: 轻切削用断屑槽
LV: Chipbreaker for Light cut type

■一次性刀片/负型(带孔)

One-use Type/Negative (With Hole)

外观 Shape	型号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺寸 Dimensions (mm)				
		BN1000	BN2000		烧结合切 削长度 Grinding edge length	内切圆 Island circle	厚度 Thickness	孔径 Hole	刀尖 半径 Nose radius
	NU-CNMA120402	●	●	1	2.5	12.7	4.76	5.16	0.2
	120404	●	●	1	2.5	12.7	4.76	5.16	0.4
	120408	●	●	1	2.4	12.7	4.76	5.16	0.8
	NU-DNMA150401	●	●	1	2.7	12.7	4.76	5.16	0.1
	150402	●	●	1	2.5	12.7	4.76	5.16	0.2
	150404	●	●	1	2.5	12.7	4.76	5.16	0.4
	NU-DNMA150604	●	●	1	2.1	12.7	6.35	5.16	0.8
	150608	●	●	1	2.0	12.7	6.35	5.16	1.2
	150612	●	●	1	2.0	12.7	6.35	5.16	1.2
	NU-SNMA120404	●	●	1	2.5	12.7	4.76	5.16	0.4
	120408	●	●	1	2.3	12.7	4.76	5.16	0.8
	120412	●	●	1	2.1	12.7	4.76	5.16	1.2
	NU-TNMA160401	●	●	1	2.5	9.525	4.76	3.81	0.1
	160402	●	●	1	2.4	9.525	4.76	3.81	0.2
	160404	●	●	1	2.3	9.525	4.76	3.81	0.4
	NU-VNMA160401	●	●	1	3.5	9.525	4.76	3.81	0.1
	160402	●	●	1	3.3	9.525	4.76	3.81	0.2
	160404	●	●	1	2.8	9.525	4.76	3.81	0.4
	NU-WNMA080404	●	●	1	1.7	12.7	4.76	5.16	1.2
	080408	●	●	1	3.3	12.7	4.76	5.16	0.4
	080412	●	●	1	2.8	12.7	4.76	5.16	0.8

■重磨型/负型(带孔)

Regrindable Type/Negative (With Hole)

外 观 Shape	型 号 Cat. No.	库存 Stock		刀尖 数 No. of Cutting edges	尺寸 Dimensions (mm)				
		BN1000	BN2000		烧结体切 削刃长度 Grinding edge length	内切圆 Island circle	厚度 Thickness	孔径 Hole	刀尖 半径 Nose radius
	CNMA120404		●	1	4.6	12.7	4.76	5.16	0.4
	120408	●	4.5		0.8				
	120412	●	4.4		1.2				
	DNMA150404		●	1	5.0	12.7	4.76	5.16	0.4
	150408	●	4.7		0.8				
	150412	●	4.3		1.2				
	SNMA120408		●	1	4.8	12.7	4.76	5.16	0.8
	120412	●	4.8		1.2				
	TNMA160402		●	1	3.6	9.525	4.76	3.81	0.2
	160404	●	3.5		0.4				
	160408	●	3.2		0.8				
	160412	●	2.9	1.2					
	TNMA220408		●	1	3.2	12.7	4.76	5.16	0.8
220412	●	2.9	1.2						
	VNMA160404		●	1	5.0	9.525	4.76	3.81	0.4
	160408	●	4.1		0.8				

BN1000/BN2000的库存型号

BN1000 / BN2000 Stock Items

多角型一次性刀片/正型(带孔) Multi-cornered, One-use Type/Positive (With Hole)

外观 Shape	后角 Relief Angle	型号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺寸 Dimensions (mm)				
			BN1000	BN2000		焊接体切削长度 Welding body cutting length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	7°	2NU-CCGW09T304WG	—	●	2	2.4	9.525	3.97	4.4	0.4
		09T308WG	—	●	2	2.4	9.525	3.97	4.4	0.8
	7°	2NU-CCGW09T304WH	—	●	2	2.4	9.525	3.97	4.4	0.4
		09T308WH	—	●	2	2.3	9.525	3.97	4.4	0.8
	7°	2NU-DCGW11T304WG	—	●	2	2.3	9.525	3.97	4.4	0.4
		11T308WG	—	●	2	2.1	9.525	3.97	4.4	0.8
	7°	2NU-DCGW11T304WH	—	●	2	2.1	9.525	3.97	4.4	0.4
		11T308WH	—	●	2	1.8	9.525	3.97	4.4	0.8

※型号末尾 WG: 低进给用一次性修光刃刀片 WH: 高进给用一次性修光刃刀片
WG: One-Use Wiper insert for Low-feed type WH: One-Use Wiper insert for High-feed type

多角型一次性刀片/正型(带孔) Multi-cornered, One-use Type/Positive (With Hole)

Break Master FV型/LV型
Breakmaster Type FV / LV

外观 Shape	后角 Angle	型 号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺寸 Dimension (mm)				
			BN1000	BN2000		焊接体切削长度 Welded body cutting length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	7°	2NU-CCGT060204N-FV	—	●	2	2.3	6.35	2.38	2.8	0.4
		09T304N-FV	—	●		2.4	9.525	3.97	4.4	0.4
		09T308N-FV	—	●		2.3	9.525	3.97	4.4	0.8
	7°	2NU-CCGT09T304N-LV	—	●	2	2.4	9.525	3.97	4.4	0.4
		09T308N-LV	—	●		2.3	9.525	3.97	4.4	0.8
	7°	2NU-DCGT070204N-FV	—	●	2	2.4	6.35	2.38	2.8	0.4
		11T304N-FV	—	●		2.4	9.525	3.97	4.4	0.4
		11T308N-FV	—	●		2.0	9.525	3.97	4.4	0.8
	7°	2NU-DCGT11T304N-LV	—	●	2	2.4	9.525	3.97	4.4	0.4
		11T308N-LV	—	●		2.0	9.525	3.97	4.4	0.8
	11°	3NU-TPGT110304N-FV	—	●	3	2.2	6.35	3.18	3.4	0.4
		110308N-FV	—	●		1.9	6.35	3.18	3.4	0.8

※型号末尾 FV: 精切削用新屑槽 LV: 轻切削用新屑槽
FV: Chipbreaker for Finishing type LV: Chipbreaker for Light cut type

一次性刀片/正型(带孔) One-use Type/Positive (With Hole)

外观 Shape	后角 Relief Angle	型号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺寸 Dimensions (mm)				
			BN1000	BN2000		焊接体切削长度 Welding body cutting length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	7°	NU-CCGW060202	●	●	1	2.5				0.2
		060204	●	●	1	2.5	6.35	2.38	2.8	0.4
		060208	●	●	1	2.4				0.8
		NU-CCGW09T302	●	●	1	2.5				0.2
		09T304	●	●	1	2.5	9.525	3.97	4.4	0.4
	11°	09T308	●	●	1	2.4				0.8
		NU-CPGW080202	●	●	1	2.5				0.2
		080204	●	●	1	2.5	7.94	2.38	3.4	0.4
		080208	●	●	1	2.4				0.8
		NU-CPGW090302	●	●	1	2.5				0.2
	7°	090304	●	●	1	2.5	9.525	3.18	4.4	0.4
		090308	●	●	1	2.4				0.8
		NU-DCGW070202	●	●	1	2.7				0.2
		070204	●	●	1	2.5	6.35	2.38	2.8	0.4
		070208	●	●	1	2.1				0.8
	11°	NU-DCGW11T302	●	●	1	2.7				0.2
		11T304	●	●	1	2.5	9.525	3.97	4.4	0.4
		11T308	●	●	1	2.1				0.8
		11T312	●	●	1	2.0				1.2
	11°	NU-TPGW080202	●	●	1	2.6				0.2
		080204	●	●	1	2.5	4.76	2.38	2.3	0.4
		080208	●	●	1	2.2				0.8
		NU-TPGW090202	●	●	1	2.6				0.2
		090204	●	●	1	2.5	5.56	2.38	2.8	0.4
		090208	●	●	1	2.2				0.8
		NU-TPGW110202	●	●	1	2.5				0.2
		110204	●	●	1	2.3	6.35	2.38	2.8	0.4
		110208	●	●	1	2.2				0.8
		NU-TPGW110302	●	●	1	2.6				0.2
		110304	●	●	1	2.5	6.35	3.18	3.4	0.4
		110308	●	●	1	2.2				0.8
		110308	●	●	1	2.2				0.8
		NU-TPGW160302	●	●	1	2.4				0.2
		160304	●	●	1	2.3	9.525	3.18	4.4	0.4
	5°	160308	●	●	1	2.0				0.8
		NU-TPGW160404	●	●	1	2.5				0.4
		160408	●	●	1	2.2	9.525	4.76	4.4	0.8
		NU-VBGW110302	●	●	1	3.2				0.2
		110304	●	●	1	2.8	6.35	3.18	2.8	0.4
	7°	110308	●	●	1	2.0				0.8
		NU-VBGW160402	●	●	1	3.8				0.2
		160404	●	●	1	3.8	9.525	4.76	4.4	0.4
		160408	●	●	1	3.8				0.8
		NU-VCGW080202	●	●	1	3.3				0.2
	7°	080204	●	●	1	3.3	4.76	2.38	2.3	0.4
		080208	●	●	1	3.3				0.8
		NU-VCGW110302	●	●	1	3.3				0.2
		110304	●	●	1	2.8	6.35	3.18	2.8	0.4

●印: 1个装、10个装均有库存 ●印: 仅1个装有库存

无印: 接单生产 一印: 不生产

●Mark: 1piece pack and 10piece pack both stock ●Mark: 1piece pack stocked

Blank: Made to order item —Mark: Not to be manufactured

一次性刀片/正型(带孔) One-use Type/Positive (With Hole)

重视锋利的LT型
Small Edge Type LT

外 观 Shape	后角 Angle	型 号 Cat. No.	库存 Stock		刀尖 数 No. of Cutting edges	尺 寸 Dimension (mm)				
			BN1000	BN2000		烧结体切削 长度 Sintered body cutting length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖 半径 Nose radius
	7°	NU-CCGW060202LT	—	●	1	2.5				0.2
		060204LT	—	●	1	2.5	6.35	2.38	2.8	0.4
		060208LT	—	●	1	2.5				0.8
		NU-CCGW09T302LT	—	●	1	2.5				0.2
		09T304LT	—	●	1	2.5	9.525	3.97	4.4	0.4
		09T308LT	—	●	1	2.4				0.8
	11°	NU-CPGW080204LT	—	●	1	2.5	7.94	2.38	3.4	0.4
		NU-CPGW090302LT	—	●	1	2.5				0.2
		090304LT	—	●	1	2.5	9.525	3.18	4.4	0.4
		090308LT	—	●	1	2.4				0.8
	7°	NU-DCGW070202LT	—	●	1	2.7				0.2
		070204LT	—	●	1	2.5	6.35	2.38	2.8	0.4
		070208LT	—	●	1	2.1				0.8
		NU-DCGW11T302LT	—	●	1	2.7				0.2
		11T304LT	—	●	1	2.5	9.525	3.97	4.4	0.4
		11T308LT	—	●	1	2.1				0.8
		11T312LT	—	●	1	2.0				1.2
	11°	NU-TPGW080202LT	—	●	1	2.6				0.2
		080204LT	—	●	1	2.5	4.76	2.38	2.3	0.4
		NU-TPGW090202LT	—	●	1	2.6				0.2
		090204LT	—	●	1	2.5	5.56	2.38	2.8	0.4
		NU-TPGW110202LT	—	●	1	2.5				0.2
		110204LT	—	●	1	2.3	6.35	2.38	2.8	0.4
		NU-TPGW110302LT	—	●	1	2.6				0.2
		110304LT	—	●	1	2.5	6.35	3.18	3.4	0.4
		110308LT	—	●	1	2.2				0.8
	5°	NU-TPGW160404LT	—	●	1	2.5				0.4
		160408LT	—	●	1	2.2	9.525	4.76	4.4	0.8
		NU-VBGW110302LT	—	●	1	3.2				0.2
		110304LT	—	●	1	3.2	6.35	3.18	2.8	0.4
		110308LT	—	●	1	3.2				0.8
	5°	NU-VBGW160402LT	—	●	1	3.8				0.2
		160404LT	—	●	1	3.8	9.525	4.76	4.4	0.4
		160408LT	—	●	1	3.8				0.8
		NU-VCGW080202LT	—	●	1	3.3				0.2
		080204LT	—	●	1	3.3	4.76	2.38	2.3	0.4
		080208LT	—	●	1	3.3				0.8

■一次性刀片/正型(无孔)
One-use Type/Positive (Without Hole)

外观 Shape	后角 Relief Angle	型 号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺 寸 Dimensions (mm)				
			BN1000	BN2000		烧结体切削刃长度 Sintered edge length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	7°	NU-CCGN040104	—	●	1	2.5	4.76	1.59	—	0.4
		040108	—	●		2.4				
	11°	NU-SPGN090304	—	●	1	2.5	9.525	3.18	—	0.4
		090308	—	●		2.5				
	11°	NU-TPGN110302	—	●	1	2.4	6.35	3.18	—	0.2
		110304	—	●		2.3				
	11°	110308	—	●	1	2.0				0.8
		110308	—	●		2.0				
	11°	NU-TPGN160302	—	●	1	2.4	9.525	3.18	—	0.2
		160304	—	●		2.3				
	11°	160308	—	●	1	2.0				0.8
		160308	—	●		2.0				

■一次性刀片/正型(无孔)
One-use Type/Positive (Without Hole)

重视锋利的LT型
Small Edge Type LT

外观 Shape	后角 Relief Angle	型 号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺 寸 Dimensions (mm)				
			BN1000	BN2000		烧结体切削刃长度 Sintered edge length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	7°	NU-SPGN090304LT	—	●	1	2.5	9.525	3.18	—	0.4
		090308LT	—	●		2.5				
	11°	NU-TPGN110302LT	—	●	1	2.4	6.35	3.18	—	0.2
		110304LT	—	●		2.3				
	11°	110308LT	—	●	1	2.0				0.8
		110308LT	—	●		2.0				
	11°	NU-TPGN160304LT	—	●	1	2.3	9.525	3.18	—	0.4
		160308LT	—	●		2.0				

■一次性刀片/正型(无孔)
One-use Type/Positive (Without Hole)

刀尖强化的HS型
Strong Edge Type HS

外观 Shape	后角 Relief Angle	型 号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺 寸 Dimensions (mm)				
			BN1000	BN2000		烧结体切削刃长度 Sintered edge length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	7°	NU-CCGN040104HS	—	●	1	2.5	4.76	3.18	—	0.4
		040108HS	—	●		2.5				
	11°	NU-SPGN090304HS	—	●	1	2.5	9.525	3.18	—	0.4
		090308HS	—	●		2.5				
	11°	NU-TPGN110304HS	—	●	1	2.3	6.35	3.18	—	0.4
		110308HS	—	●		2.0				
	11°	110308HS	—	●	1	2.3	9.525	3.18	—	0.4
		160308HS	—	●		2.0				

■重磨型/正型(带孔)
Regrindable Type/Positive (With Hole)

外观 Shape	后角 Relief Angle	型 号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺 寸 Dimensions (mm)				
			BN1000	BN2000		烧结体切削刃长度 Sintered edge length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	7°	TPGW110304	—	●	1	3.5	6.35	3.18	3.4	0.4
		110308	—	●		3.2				
	7°	TPGW160404	—	●	1	3.5	9.525	4.76	4.4	0.4
		160408	—	●		3.2				

■重磨型/正型(带孔)
Regrindable Type/Positive (With Hole)

刀尖强化的HS型
Strong Edge Type HS

外观 Shape	后角 Relief Angle	型 号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺 寸 Dimensions (mm)				
			BN1000	BN2000		烧结体切削刃长度 Sintered edge length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	7°	TPGW110304HS	—	●	1	3.5	6.35	3.18	3.4	0.4
		110308HS	—	●		3.5				
	7°	TPGW160404HS	—	●	1	3.5	9.525	4.76	4.4	0.4
		160408HS	—	●		3.5				

■重磨型/正型(无孔)
Regrindable Type/Positive (Without Hole)

外观 Shape	后角 Relief Angle	型 号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺 寸 Dimensions (mm)				
			BN1000	BN2000		烧结体切削刃长度 Sintered edge length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	7°	TPGN090204	—	●	1	3.5	5.56	2.38	—	0.4
		TPGN110304	—	●		3.5				
	7°	110308	—	●	1	3.2	6.35	3.18	—	0.8
		110308	—	●		3.2				
	7°	TPGN160304	—	●	1	3.5	9.525	3.18	—	0.4
		160308	—	●		3.2				
	7°	TPGN220408	—	●	1	3.2	12.7	4.76	—	0.8
		TPGN220408	—	●		3.2				

■重磨型/正型(无孔)
Regrindable Type/Positive (Without Hole)

刀尖强化的HS型
Strong Edge Type HS

外观 Shape	后角 Relief Angle	型 号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺 寸 Dimensions (mm)				
			BN1000	BN2000		烧结体切削刃长度 Sintered edge length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	7°	TPGN090204HS	—	●	1	3.5	5.56	2.38	—	0.4
		TPGN110304HS	—	●		3.5				
	7°	110308HS	—	●	1	3.5	6.35	3.18	—	0.8
		110308HS	—	●		3.5				
	7°	TPGN160304HS	—	●	1	3.5	9.525	3.18	—	0.4
		160308HS	—	●		3.5				
	7°	TPGN220408HS	—	●	1	3.2	12.7	4.76	—	0.8
		TPGN220408HS	—	●		3.2				

■前刀面整面CBN型/正型(无孔)
Full-Top CBN Insert/Positive (Without Hole)

外观 Shape	后角 Relief Angle	型 号 Cat. No.	库存 Stock		刀尖数 No. of Cutting edges	尺 寸 Dimensions (mm)				
			BN1000	BN2000		烧结体切削刃长度 Sintered edge length	内切圆 Inscribed circle	厚度 Thickness	孔径 Hole	刀尖半径 Nose radius
	5°	TBGN060102B	—	●	3	6.5	3.97	1.59	—	0.2
		060104B	—	●		6.3				
	5°	060108B	—	●	3	5.7				0.8
		060108B	—	●		5.7				

适用车刀的详情请参见综合产品目录“住友CBN牌”。
Details for the applicable tools can be found in our General Catalogue, at "SUMIBORON" section.

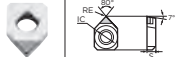
●印：1个装、10个装均有库存 ●印：仅1个装有库存

无印：接单生产产品 一印：不生产

●Mark : 1piece pack and 10piece pack both stock ●Mark : 1piece pack stocked

Blank : Made to order item 一Mark : Not to be manufactured

住友CBN小直径镗刀 BNZ型用刀片
Insert for Sumiboron Small Hole Boring Bars BNZ Type

形状 Shape	型号 Cat. No.	库存 Stock		尺寸 Dimensions (mm)			
		BN1000	BN2000	内切圆 IC Inscribed circle	厚度 S Thickness	孔径 D1 Hole	刀尖半径 RE Nose radius
	NU-ZNEX040102	●	●	4.76	1.59	2.3	0.2
	040104	●	●				0.4

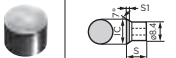
BNZ型的详情请参见综合产品目录“内径镗刀章”。
Details for BNZ series can be found in our General Catalogue, at “Boring Tools” section.

住友CBN圆刀片车刀 PRGN型用刀片
Insert for Sumiboron Tool Holders with Small Round Inserts

形状 Shape	型号 Cat. No.	库存 Stock		尺寸 Dimensions (mm)			
		BN1000	BN2000	内切圆 IC Inscribed circle	厚度 S Thickness	孔径 D1 Hole	CBN层厚度 S1 Thickness of CBN
	RNGA0906M0	●	●	9.00	6.35	—	0.80

PRGN型的详情请参见综合产品目录“住友CBN章”。
Details for PRGN series can be found in our General Catalogue, at “SUMIBORON” section.

住友CBN圆刀片车刀 PRGC型/PRDC型用刀片
Insert for Sumiboron Tool Holders with Small Round Inserts

形状 Shape	型号 Cat. No.	库存 Stock		尺寸 Dimensions (mm)			
		BN1000	BN2000	内切圆 IC Inscribed circle	厚度 S Thickness	孔径 D1 Hole	CBN层厚度 S1 Thickness of CBN
	RCGA0906M0	●	●	9.00	6.35	—	0.80

PRGC型/PRDC型的详情请参见综合产品目录“住友CBN章”。
Details for PRGC/PRDC series can be found in our General Catalogue, at “SUMIBORON” section.

住友CBN小直径镗刀 SEXC型用刀片
Insert for Sumiboron Small Hole Boring Bars SEXC Type

形状 Shape	型号 Cat. No.	库存 Stock		尺寸 Dimensions (mm)			
		BN1000	BN2000	内切圆 IC Inscribed circle	厚度 S Thickness	孔径 D1 Hole	刀尖半径 RE Nose radius
	2NU-ECXA 030X02LE	●	●	3.31	1.15	0.2	
	2NU-ECXA 030X02LF	●	●	3.31	1.15	0.2	

※型号末尾 LE：有倒圆 LF：锋利刃
LE : Hornig , LF : Sharp Edge

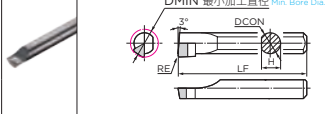
SEXC型的详情请参见综合产品目录“内径镗刀章”。
Details for SEXC series can be found in our General Catalogue, at “Boring Tools” section.

住友CBN小直径镗刀 BSME型
SUMIBORON Small Hole Boring Bars BSME Type

形 状 Shape		型 号 Cat. No.	库存 Stock		最小加工直径 DMIN Min Bore Dia.	尺 寸 Dimensions (mm)							Fig
			BN2000			直 径 DCON Diameter	刀头直径 DN Diameter	全 长 LF Overall Length	刀尖距离 WF Position	加工深度 CDX Depth	刀尖半径 RE Nose radius		
			R	L									

BSME型需要另售的套筒HBSM6020。BSME型的详情请参见综合产品目录“内径镗刀章”。
BSME needs adapter sleeve HBSM6020(sold separately). Details for BSME series can be found in our General Catalogue, at “Boring Tools” section.

住友CBN小直径镗刀 BNBX型
SUMIBORON Small Hole Boring Bars BNBX Type

形 状 Shape		型 号 Cat. No.	库存 Stock	最小加工直径 DMIN Min. Bore Dia.	尺 寸Dimensions (mm)			
			BN2000		直 径 DCON Diameter	高 度 H Height	全 长 LF Overall Length	刀尖半径 RE Nose Radius
	BNBX 020R	●	2.5	2.0	1.8	40	0.2	
	025R	●	3.0	2.5	2.2	40	0.2	
	030R	●	3.5	3.0	2.7	40	0.2	
	035R	●	4.0	3.5	3.2	40	0.2	
	040R	●	4.5	4.0	3.7	40	0.2	
	045R	●	5.0	4.5	4.2	40	0.2	
	050R	●	5.5	5.0	4.7	60	0.2	
	055R	●	6.0	5.5	5.2	60	0.2	
	060R	●	6.5	6.0	5.7	60	0.2	
	065R	●	7.0	6.5	6.2	60	0.2	
	070R	●	7.5	7.0	6.7	80	0.2	
	075R	●	8.0	7.5	7.2	80	0.2	
	080R	●	8.5	8.0	7.7	80	0.2	

●印：1个装、10个装均有库存 ●印：仅1个装有库存

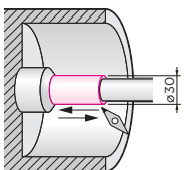
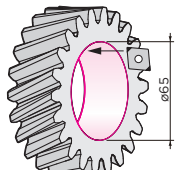
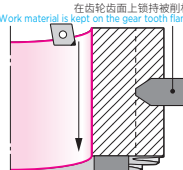
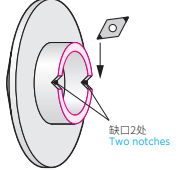
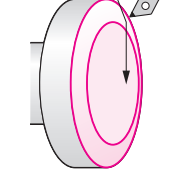
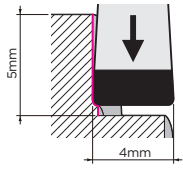
无印：接单生产 一印：不生产

●Mark : 1piece pack and 10piece pack both stock ●Mark : 1piece pack stocked
Blank : Made to order item —Mark : Not to be manufactured



使用实例

Application Examples

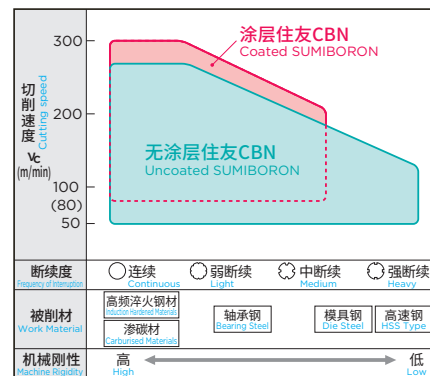
S55C高频淬火 机油泵轴 S55C High-frequency hardening oil pump shaft 低刚性环境 BN1000  刀具悬伸量大、刀具刚性低的切削实例。在表面粗糙度要求 $Rz\ 2.0$ 的高精度加工中，BN1000 的寿命是其他公司产品的2倍 This is an example of cutting with long tool overhang and low tool rigidity. BN1000 enables tool life twice as long as competitors' CBN in high-accuracy machining with a required surface roughness of $Rz\ 2.0$. 规格：表面粗糙度 $Rz=2.0\mu m$ Standard: surface roughness $Rz = 2.0\ \mu m$ 加工数 No. of workpieces BN1000 140个(切削距离11.3km) 140pcs (Cutting Distance 11.3km) 其他公司CBN Comp's CBN 75个(切削距离3.7km) 75pcs (Cutting Distance 3.7km)	SCM420行星齿轮 SCM420 Planetary gear 低速高精度 BN1000  由于设备转速的关系，无法进行高速加工，涂层膜发生异常损伤的实例。其他公司的涂层CBN会因少许的膜剥离而导致表面粗糙度变差，寿命缩短。BN1000的磨损形态平滑，因此寿命是其他公司产品的3倍 This is an example of abnormal damage on the coating film, caused by insufficient machine speed performance which impeded high-speed machining. For competitors' CBN, a minute peeled portion deteriorated the surface roughness, resulting in short tool life. BN1000's smooth wear form enables tool life three times longer than competitors' CBN. 规格：表面粗糙度 $Ra=0.6\mu m$ Standard: surface roughness $Ra = 0.6\ \mu m$ 加工数 No. of workpieces BN1000 285个 285pcs 其他公司的涂层CBN Comp's Coated CBN 90个 90pcs	渗碳材 齿轮 Carburized material gear 低刚性环境 BN2000  在齿轮齿面上维持被削材 Work material is kept on the gear tooth flank. 涂层CBN会因涂层膜的崩损而导致表面粗糙度变差，而使用BN2000后寿命可延长至1.5倍 Coated CBN has had problems with deteriorated surface roughness due to chipping of the coating film. BN2000 enables tool life 1.5 times longer than the coated CBN. 规格：表面粗糙度 $Ra=0.6\mu m$(圆锥面部分) Standard: surface roughness $Ra = 0.6\ \mu m$ (taper portion) 加工数 No. of workpieces BN2000 250个 250pcs 涂层CBN Coated CBN 150个 150pcs
刀片：NU-VBGW160404 Insert 切削条件：$v_c=195m/min, f=0.04mm/rev, a_p=0.18mm$ Dry Cutting Condition	刀片：2NU-CNGA120408W(特种型号) Insert 切削条件：$v_c=90m/min, f=0.17mm/rev, a_p=0.05mm$ Dry Cutting Condition	刀片：NU-CCGW09T308W(特种型号) Insert 切削条件：$v_c=185m/min, f=0.09mm/rev, a_p=0.1mm$ Dry Cutting Condition
SCM415H CVT带轮 SCM415H CVT pulley 中断续加工 BN2000  其他公司的产品会随着月牙洼磨损的严重而导致崩损，使用耐磨损性优良的BN2000后寿命可延长至2倍 Although competitors' CBN has had problems with fracturing due to developed crater wear, BN2000 with higher breakage resistance enables tool life twice as long as competitors' CBN. 规格：表面粗糙度 $Ra=1.0\mu m$ Standard: surface roughness $Ra = 1.0\ \mu m$ 加工数 No. of workpieces BN2000 250个 250pcs 其他公司CBN Comp's CBN 120个 120pcs	SKD11 液压零部件 SKD11 Hydraulic part 低速高精度 BN2000  中心部的切削等切削速度变得极低时，BN2000的表面粗糙度比涂层CBN更稳定，其寿命达到1.6倍 For cutting processes with significantly low cutting speed, such as cutting of the central portion, BN2000 enables more stable surface roughness and tool life as much as 1.6 times longer than the coated CBN. 规格：表面粗糙度 $Rz=0.8\mu m$(圆锥面部分) Standard: surface roughness $Rz = 0.8\ \mu m$ (taper portion) 加工数 No. of workpieces BN2000 200个 200pcs 涂层CBN Coated CBN 120个 120pcs	SCM420H 传动轴 SCM420H Shaft 切槽加工 BN2000  随着磨损的严重会导致尺寸变化和崩损问题的发生，使用耐磨损性优良的BN2000后寿命可延长至约2倍 Although competitors' CBN has had problems with size change and fractures due to developed wear, BN2000 with higher wear resistance enables tool life about twice as long as competitors' CBN. 加工内容：由切槽车刀确定宽度 Machining description: width determination with grooving cut-off tool 加工数 No. of workpieces BN2000 1,800个 1,800pcs 其他公司CBN Comp's CBN 950个 950pcs
刀片：2NU-DNGA150408 Insert 切削条件：$v_c=150m/min, f=0.1mm/rev, a_p=0.2mm$ Dry Cutting Condition	刀片：2NU-DNGA150408 Insert 切削条件：$v_c=0.150m/min, f=0.03-0.25mm/rev, a_p=0.04mm$ Dry Cutting Condition	刀片：特种型号切槽刀片 Insert 切削条件：$v_c=100m/min, f=0.08mm/rev, a_p=0.25mm$ Dry Cutting Condition

■ 无涂层SUMIBORON的用途

Suitable use application of uncoated SUMIBORON

- 无法提高切削速度的小零件加工
- 低刚性刀具的加工
- 加工含较多硬质粒子的模具零件时，往往无法获得涂层膜的应有效果，因此选用无涂层SUMIBORON最为适合。

- Cutting of small parts, where cutting speed cannot be increased.
- Machining low-rigidity material.
- Since the coating film often suffers no effects when mold components containing large amounts of hard particles are machined, uncoated SUMIBORON is the best choice.



MEMO

A large rectangular area filled with a uniform grid of small dots, intended for handwritten notes or a drawing.

MEMO



● 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

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住友电工硬质合金贸易(上海)有限公司常州分公司

住友电工硬质合金贸易(上海)有限公司嘉兴事务所

地址：上海市延安西路728号华敏·翰尊国际大厦6楼J座(邮编：200050)
电话：021-5238-1199 传真：021-6212-9689
地址：宁波市江北区大庆南路99号来福士广场办公楼709室(邮编：315020)
电话：0574-8723-3856 传真：0574-8723-3935
地址：南京市秦淮区汉中路1号国际金融中心12楼D座(邮编：210029)
电话：025-8586-0803 传真：025-8586-0881
地址：常州市武进区技术产业开发区西湖路8号12号厂房(邮编：213164)
电话：0519-8622-0306(分机305)
地址：浙江省嘉兴市秀洲区东升东路2316号杉杉印象1号楼2201室
电话：18067036551

华北地区

住友电工硬质合金贸易(上海)有限公司北京分公司

住友电工硬质合金贸易(上海)有限公司青岛分公司

住友电工硬质合金贸易(上海)有限公司天津分公司

住友电工硬质合金贸易(上海)有限公司郑州事务所

地址：北京市朝阳区东三环北路3号幸福大厦B座1306室(邮编：100027)
电话：010-6468-8500 传真：010-6468-9500
地址：青岛市市北区龙城路31号卓越世纪中心3号楼1801室(邮编：266033)
电话：0532-5578-7866 传真：0532-5578-7865
地址：天津市空港经济区西四道168号融和广场5号楼2门905室(邮编：300300)
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号磐基莲花里1805室(邮编：362000)
电话：0592-5602-190 传真：0592-5602-195

住友电工硬质合金(常州)有限公司

地址：常州市武进区技术产业开发区西湖路8号12号厂房(邮编：213164)
电话：0519-8622-0306 传真：0519-8622-0305
地址：常州市武进区技术产业开发区西湖路8号12号厂房(邮编：213164)
电话：0519-8622-0306(分机305)

中国刀具技术中心

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微信扫一扫



在线样册扫一扫

(2025.07)